

# TB0189 Narrow Profile Next to Wide on Infeed Table

If a very narrow section is followed by a very wide section on the Autoflow infeed, there is a collision point resulting in damage to the infeed measuring sensors.

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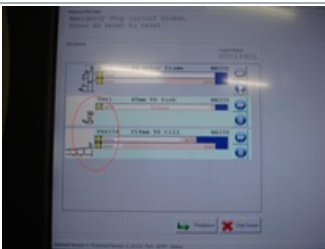


## Technical Bulletin

<b>TB Number:</b>	0189
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<b>Machine:</b>	Autoflow 2
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<b>Title:</b>	Narrow Profile Next to Wide on Infeed Table

## Problem

If a very narrow section is followed by a very wide section on the Autoflow infeed, there is a collision point resulting in damage to the infeed measuring sensors.

This combination of events has only ever happened after the operator has changed the queue order on screen, and has not followed the advice from Stuga personnel to leave a gap on the infeed table belts.

		
<b>Step 1</b> – Narrow followed by wide profile queue alteration	<b>Step 2</b> – After measuring narrow profile, it is advanced to docking position	<b>Step 3</b> – as gripper returns to dock with profile, a collision occurs between infeed sensors and wide section

## Solution

To prevent the situation again, it is necessary to hard code a solution into the front end software. A new version of software (v2.24) has been installed to prevent Step 1 from happening. If the operator attempts to change the order of bars to this combination, then a message is displayed and the narrow bar is placed "on-hold". The bar cannot be removed from "on-hold" until the queue order is allowable. It is the operator's job to do this.

The definition of the "illegal" combination is achieved using two new parameters:

```
illegalComboLeadWidth = 50
```

illegalComboFollowWidth = 140

So if the lead bar width < illegalComboLeadWidth and following bar width > illegalComboFollowWidth, then the queue is deemed "illegal"