

TB0247 Safety Gate Distances on Autoflow

Confusion surrounds the parameter values needed to ensure the end of a bar length does not clash with the safety gate

Contents

Technical Bulletin

Overview

Solution

Comments

Technical Bulletin

TB Number:	247
Originator:	Gareth Green
Machine:	Autoflow
Date:	12/03/14
Circulate to:	Service;
Title:	Safety Gate Distances on Autoflow

Overview

Confusion surrounds the parameter values needed to ensure the end of a bar length does not clash with the safety gate

Solution

Two parameters are used to check if the end of the bar will hit the gate when the Autoflow moves the X axis:-

Parameter	Description	Factory Value
ejectStrokeLength	Distance that eject cylinder pulls profile out of machine	580
outfeedSize	Size of outfeed table from where a square-ended bar is ejected to to the safety gate	2020

As a physical check, you can measure the distance from the saw blade to the safety gate, should be around 2600.

The sum $ejectStrokeLength + outfeedSize$ should be just less than this physical measurement (2600) in order for the system to work properly.