

# VSM Welder After Welding Options

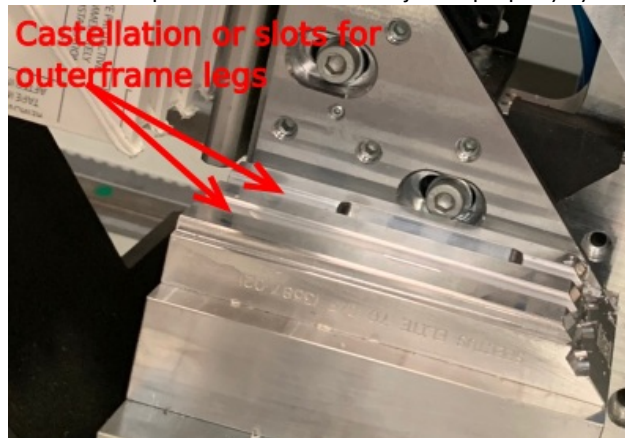
The Sturtz VSM welder has a number of options on how to present the finished frame after welding

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## Problem

If the welder blocks are castellated, the automatic centring system on a VSM-P welder will have a problem unloading the frame after welding. This happens because the castellation holds on to the profile and it cannot be ejected properly by the centralising mechanism.



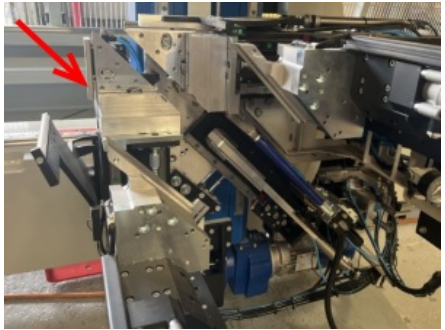
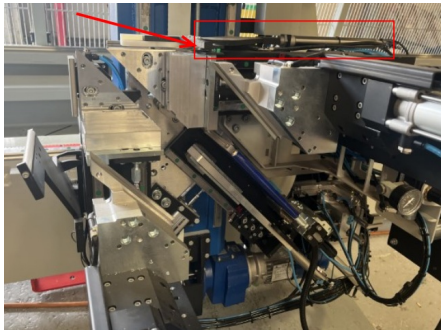
See this video of the issue - note how the profile cannot lift up when the heads retract - the top heads have not given the clearance after welding

To overcome this, the centring needs to be disabled

## After Welding Options

The VSM software allows for the following unloading options

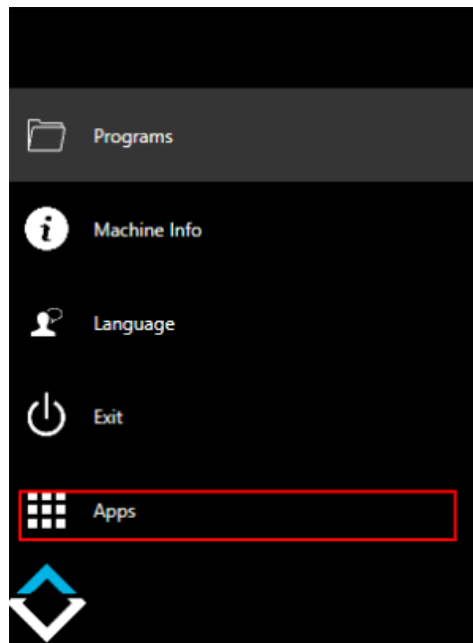
Flag	Option	Description	Photo
1	Loading: Clampingunit 1 Extend		
2	Loading: Clampingunit 2 Extend		
4	Loading: Belts Up	For unloading to a rear corner cleaner	
8	Release: Clamps Retract		

16	Release: Offloading Support Arms	Enables the cylinders for pushing profile forwards from rear	 <p>Push Cylinder</p>
32	Release: Belts Up	For unloading to a rear corner cleaner	
64	Loading: Melting Retracted	For unloading to a rear corner cleaner	
256	disable centering	Disables the centralising unloading cylinders	 <p>Centralising Cylinder</p>

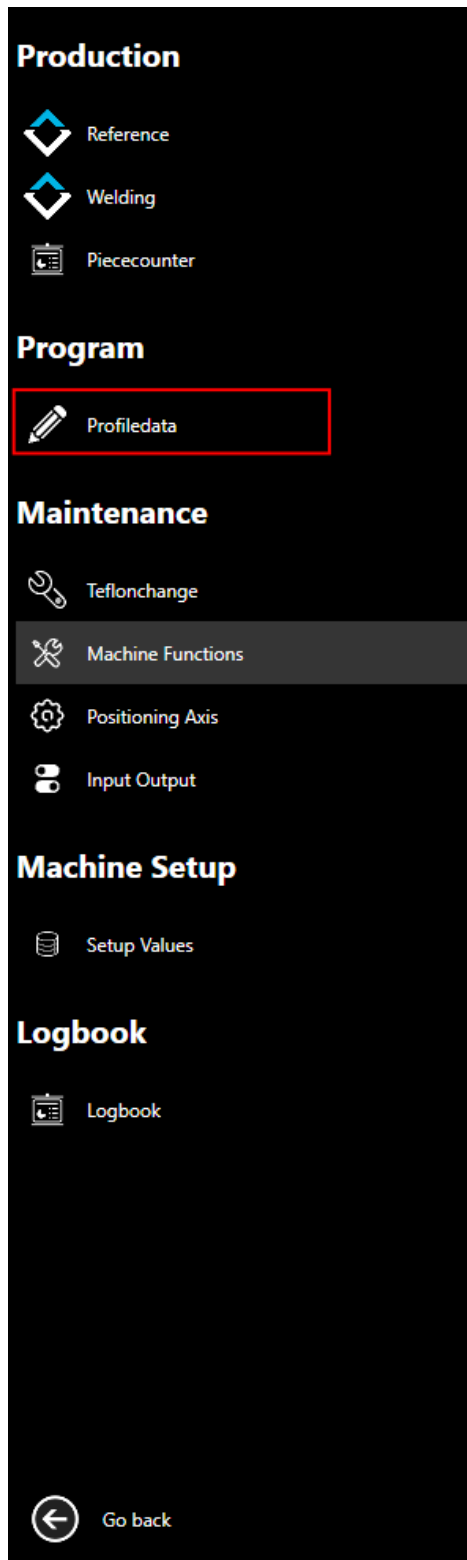
# Instructions

Log in. You will need to log in as Technician to access these options. For the password, please contact service, the passwords are stored in the file g:\IT Department\Sturtz Passwords.txt

Select Apps



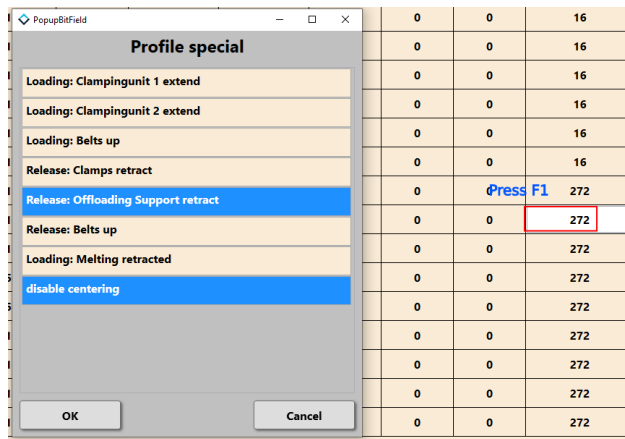
Select Profile Data



Scroll right to special function column

Special 1
16
16

Highlight the profile special 1 parameter and press F1



Select the options as required and press Ok.  
 The numerical value of the options selected will reflect in the number in the column

## Position After Welding Width and Height

The position of the heads after welding can be adjusted in these columns. This is the distance the welder moves to release from the block.

Position After Welding Width (mm)	Position After Welding Height (mm)
0.00	130.00