

ZX5 Operator Training Guide

Operator Training Schedule for ZX5

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Comments

[Link to software guide](#)

Walkaround and Identification

Module A - Infeed

Laser measuring
Rear Offcut Array
Infeed Wheel

Module B - Machining Centre

Clamping rollers
Holding clamp
Width measuring
Datum Grip holes
Spindle function and double plunge

Spindle air lock
V notches and Blades
Tooling
Toolbreak sensor

Module C - Outfeed

Function of gripper
Load clear sensors

Module D – Transfer Table

Pop up system - sensor flaps and cylinders
Queue up system
Resetting Transfer table bars
Transfer disable switch
Extraction Entry Doors
Extractor bags
Extractor Filters

Module E – Saw Infeed

Function of gripper
Restarting after blockage
Side access door

Module F – Saw

Opening Door
Zero speed detection
Clamp height adjustment
Printer labels and loading

Control System

Identification of Module Cabinets
Overload Switches on Machining Side
Overload Fuses on Saw side
Stop and Emergency Stop function
Windows 10 Updates - do not switch off during automatic updates
Ensuring connection to a mapped drive

Operation

Switching On / Off

Correct power on procedure
Correct power off procedure

Desktop

Icons
Spanned screen - 2 monitors

Loading Bars

Identification and Orientation
Bar Quantity
Colour identification and picker
Foiled and Coloured bar loading
Piece Counter
Timing Prediction
Width measuring feature

Work Queue

- Load batch onto work queue
- Deleting / Reorder batches in work queue
- Pause / Fastforward Profiles
- Reoptimisation options

Saw Queue

- Function
- Checking transfer table matches
- Recovering bar
- Delete bar

Unloading Work

- Printer Labels
- Changing Printer roll

Safety

- Location of Estops
- Location Of Guard Switches
- Recognition of dangerous areas

Common Faults and Recovery

- Two sides of machine - separate and dual alarms
- Hard reset and Soft reset
- Bars doubled up on infeed
- Bars doubled up on transfer
- Eject not out / home
- Saw Cut not up / home
- Common areas for missing pieces and offcuts
- Restarting machining side after fault - part cut bar
- Restarting saw side after fault - part cut bar
- Broken Tool
- Reporting Faults

Operator Procedures

- Daily Maintenance Checklist
- Weekly Maintenance Checklist
- Identifying need and changing Saw Blade
- Identifying need and changing Spindle Cutters and Spindle Menu
- Changing Extraction Bags
- Changing Extraction Filters
- Create backup to external drive
- Datum Test
- Pos test
- Printer: Loading labels
- Printer: Width Calibration

Quality Checks

- Ensuring Measuring Equipment is fit for purpose
- Measuring Length correctly
- Measuring operation position
- Profile Width measurement - Z profiles
- Arrow head position Measurement
- V notch Depth
- Y notch depth
- Datum Test

Pos Test for x axis position

Advanced Procedures

Manual Cuts

Service Tab - Inputs and Outputs

Service Tab - Drives