


# Autoflow Power On

How to power on the Autoflow

 Difficulty **Very easy**

 Duration **1 minute(s)**

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Video overview

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Comments

## Step 1 - Ensure the air and electrical supplies are on

(minimum 6 bar to machine)

## Step 2 - Isolators on

Ensure the isolator at the rear of the machining module and the isolator on the door of the saw console are switched on

## Step 3 - Guard Doors Closed

Ensure all guard doors are closed on the Multihead and Saw

## Step 4 - Emergency Stop Buttons pulled out

## Step 5 - Load "winMulti"

## Step 6 - Press Start to Initialise

In order to ensure that the machine axes operate from the same datum position every time it is switched on, the ring and grippers go through an Initialisation process.

During the Initialisation process, the ring moves to the operating position with the top spindle touching the top datum switch. It then moves back slowly to the stop position and then moves back to the top position ready for machining.

The grippers go through a similar process.

## Step 7 - Transfer Table On / Off

Occasionally the transfer table may need to be temporarily disabled (e.g. if the profiles have bunched up) this can be done by pressing the yellow transfer button

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## Step 8 - Extraction System

It is essential that the extraction system running during the machining and cutting cycle to prevent swarf and offcut build up inside the machining units. To ensure this the extraction unit is switched on automatically.

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## Step 9 - Printer

The printer switches on automatically when the Machine is switched on. Ensure there is sufficient length of label roll in the printer for the day's production, if not replace the printer roll.

The printer does have a memory so that even if it runs out of the roll, when you have replaced the new roll, the printer will continue to print out the remaining labels in the correct order.

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