



ZX5 Maintenance Manual

Maintenance Procedures for Stuga ZX5

Common Issues



Common Issue - Mitre Cuts Cutting Short

If the length of pieces with mitred ends are too short from the saw, there are some simple root causes to check



Common Issue - Initialising - Cannot Connect to PLC

Cannot connect to TwinCAT PLC on switch on

TB0410 Common winMulti Startup Problems

Common winMulti Startup Problems



General Accuracy Guidelines - Start Here

This is the launch page for starting an accuracy journey on any Stuga machine. It contains general principles to follow and signpost further procedures and pages to investigate further

Mechanical Procedures



ZX5 V Notch Blade Mechanical Setup

How to mechanically set the V notches on a ZX5.



ZX5 Adjusting V Notch Depth and Position

How to change the depth and position of the V notch on a ZX5 machine



Setting Ultrasonic Sensor - Vertical

How to set ultrasonic sensor to detect profile

TB0447 ZX5 Setup - X Axis Beam Calibration

ZX5 Setup - X Axis Beam Calibration



TB0445 ZX5 Setup - Infeed Measure Sensor Calibration

ZX5 Setup - Infeed Measure Sensor Calibration

Setting Arrow Heads on ZX5 or ZX5-E

How to set arrow heads on Stuga ZX5 and ZX5e machines with the SY axis and Y notching on saw

Gripper Setup - ZX5

How to set up the toothed gripper on the ZX5 machine



Setting Ultrasonic Sensor - Vertical

How to set ultrasonic sensor to detect profile



Commissioning - Off-Cut Laser Sensor

Setting up the laser sensors on the infeed of a Flowline, ZX4 and ZX5.



ZX5 Adjusting V Notch Depth and Position

How to change the depth and position of the V notch on a ZX5 machine



ZX5 V Notch Blade Mechanical Setup

How to mechanically set the V notches on a ZX5.

Commissioning - Z-Block Calibration

Commonly used during sawing on Z transoms, the Z block operation is used to fasten the profile, making sure it does not move during sawing.

Software procedures



Viewing Camera Footage from Hikvision Cameras

How to view the live footage and stored data from a Hikvision camera on a Stuga machine



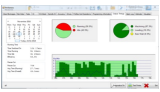
Accessing Zebra Printer Settings Via Web Browser

How to access the settings of a Zebra printer via a web browser



Hikvision Camera Setup

Setting up the Hikvision cameras and recording system

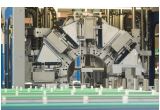


Understanding Output Timings Tab

The winMulti software contains a system to monitor machine performance and a screen to view the details. It is accessed by the service button, then selecting "Output Timings".

TM017 Setting Cut Length on Saw

This module guides the engineer on how to correctly set the cut lengths on Stuga saws



Turning Off and Changing Datum Tool

How to turn off a spindle and change the datum tool.



TB0452 ZD620 Zebra Printer Setup

This document outlines the setup of the new ZD620 printers to replace the older Zebra 420d printers that are obsolete.

Technical Bulletins and Further Information



Consumables List

Stuga Machinery Consumables List

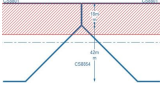
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L,BLR56E
P,12340,V,00,00,BR129A/001
P,12340,V,00,00,BR129A/001
P,20000,V,00,00,BR129A/001
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O,00150,DEF,000,000,000
n,1000m,esp,000,000,000
```

Stuga Batch Cutting List Specification

Full specification of the file format used by the entire range of Stuga machinery for cutting lengths and machining operation



The requirement is for a separate file to directly print labels from the Stuga machinery, driven by the third party software cc maintain backwards compatibility, a third saw link file will be generated – a Zebra print file written in the zebra printer lang allows graphic and font information to be transferred to create a more visually appealing label.



TB0434 Setting Up Deep Y notches on ZX5

The saw “Y drive” on a ZX5 is limited in its depth range to +/- 20mm from the centreline of the profile, and 20mm from the b; This is fine for most normal Y notching, but there are combinations when a particularly deep Y notch is required.



Z Transom Width Measurement

How to measure the width of a Z section profile



Zebra GX420D - Blink Sequence Meanings

How to set up the Printer using the Blinking LED Sequence on Feed Button



Updating Zebra Firmware on ZD620 model

How to use the ZDownloader to update the Firmware on Zebra ZD620 printers.

Parameters Dictionary

Dictionary of parameters in Stuga machines

| Legacy Wire Label | ID Ref | Code |
|-------------------|-------------|----------------|
| 1 | IA_G10MFP | |
| 2 | IA_Measure1 | Output Inverse |
| 3 | IA_Measure2 | |
| 4 | IA_G20MFP | |
| 5 | IA_G20MFP | |
| 6 | IA_G20MFP | |
| 7 | IA_G20MFP | |
| 8 | IA_G20MFP | |

Stuga Machine IO Dictionary - Inputs

List of input references used on Stuga Machines

| ID Ref | Legacy Wire Label | Code |
|--------|-------------------|----------------|
| 1 | IA_G10MFP | Output Inverse |
| 2 | IA_G10MFP | Output Inverse |
| 3 | IA_G10MFP | |
| 4 | IA_G10MFP | |

Stuga Machine IO Dictionary - Outputs

List of output references used on Stuga Machines