

TB0161 Fitting Outfeed Clear Sensor on ZX Machine

The outfeed clear sensor that existed on Mk3 flowlines was not repeated on ZX machines. This leaves the machine vulnerable to crash.

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Technical Bulletin

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Title:	0161 Fitting Outfeed Clear Sensor on ZX Machine

Problem

The outfeed clear sensor that existed on Mk3 flowlines was not repeated on ZX machines. This leaves the machine vulnerable to crash if one of the following situations occurs:

- A bar is not correctly ejected onto the transfer table, and the gripper then returns for the next bar
- A bar is present on the outfeed when the gripper is initialising

Solution

A new outfeed clear sensor has been designed to fit on the third zip gate

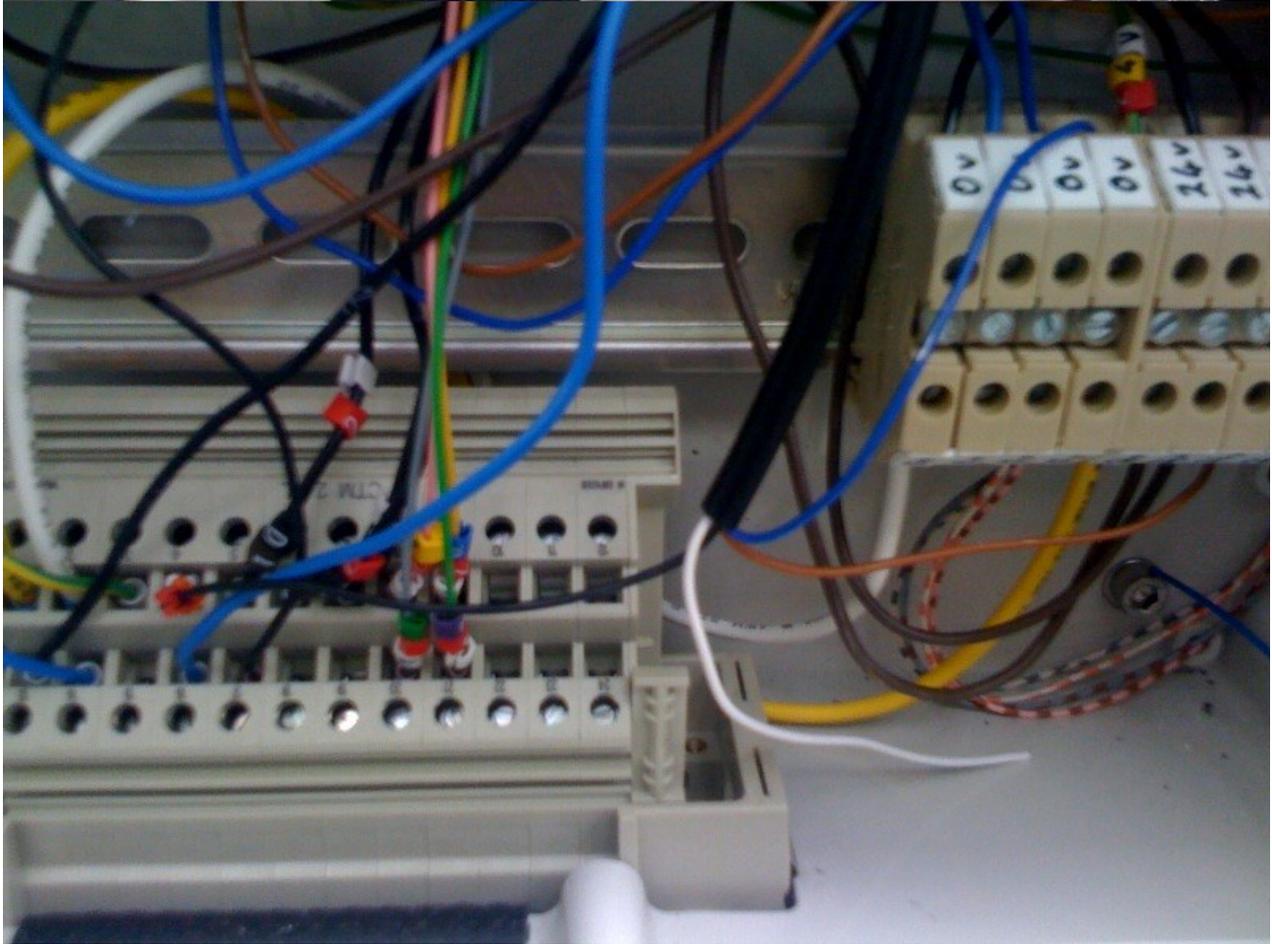
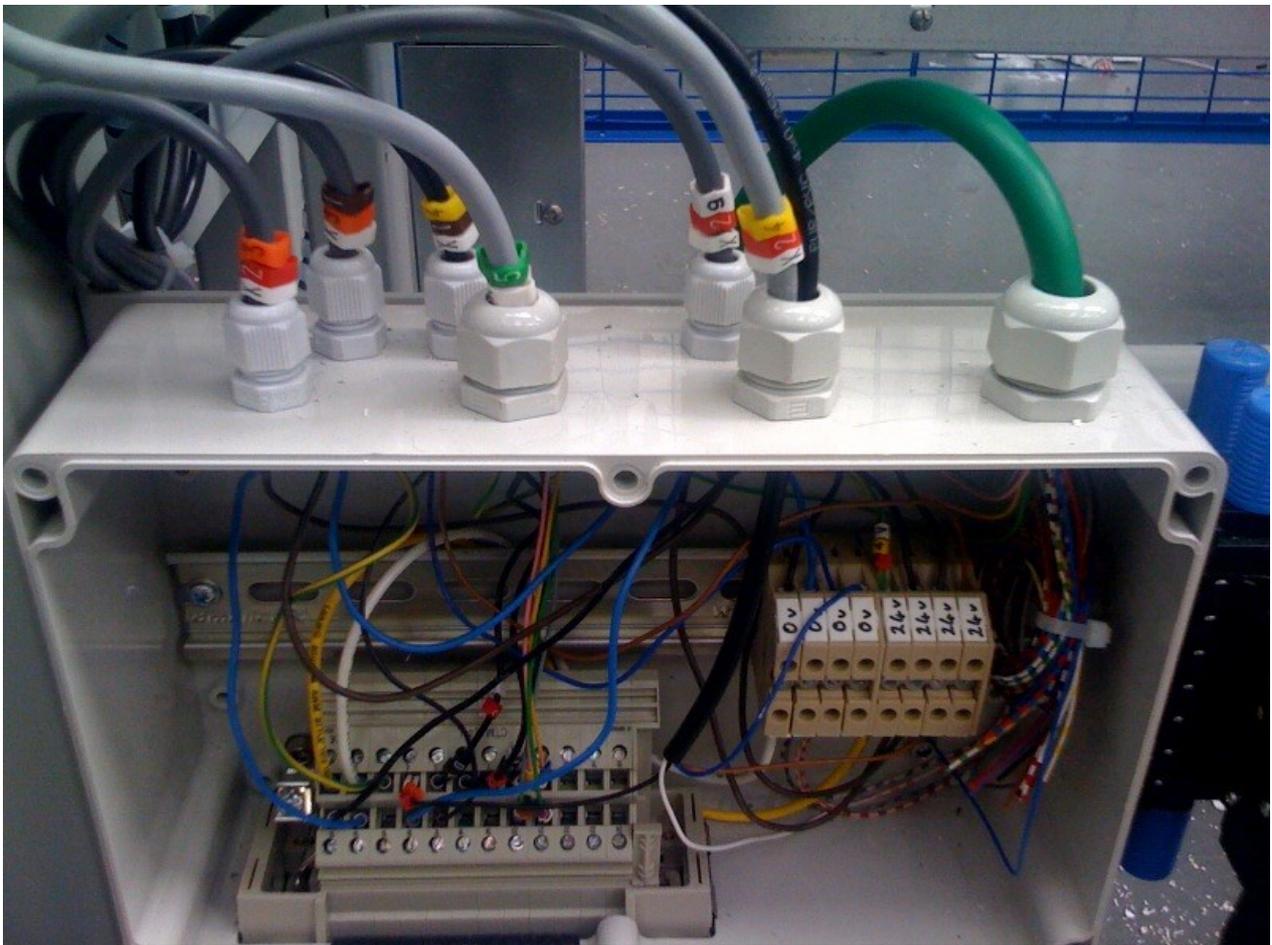
Kit is R0000312 ZX: Outfeed Sensor

Wiring

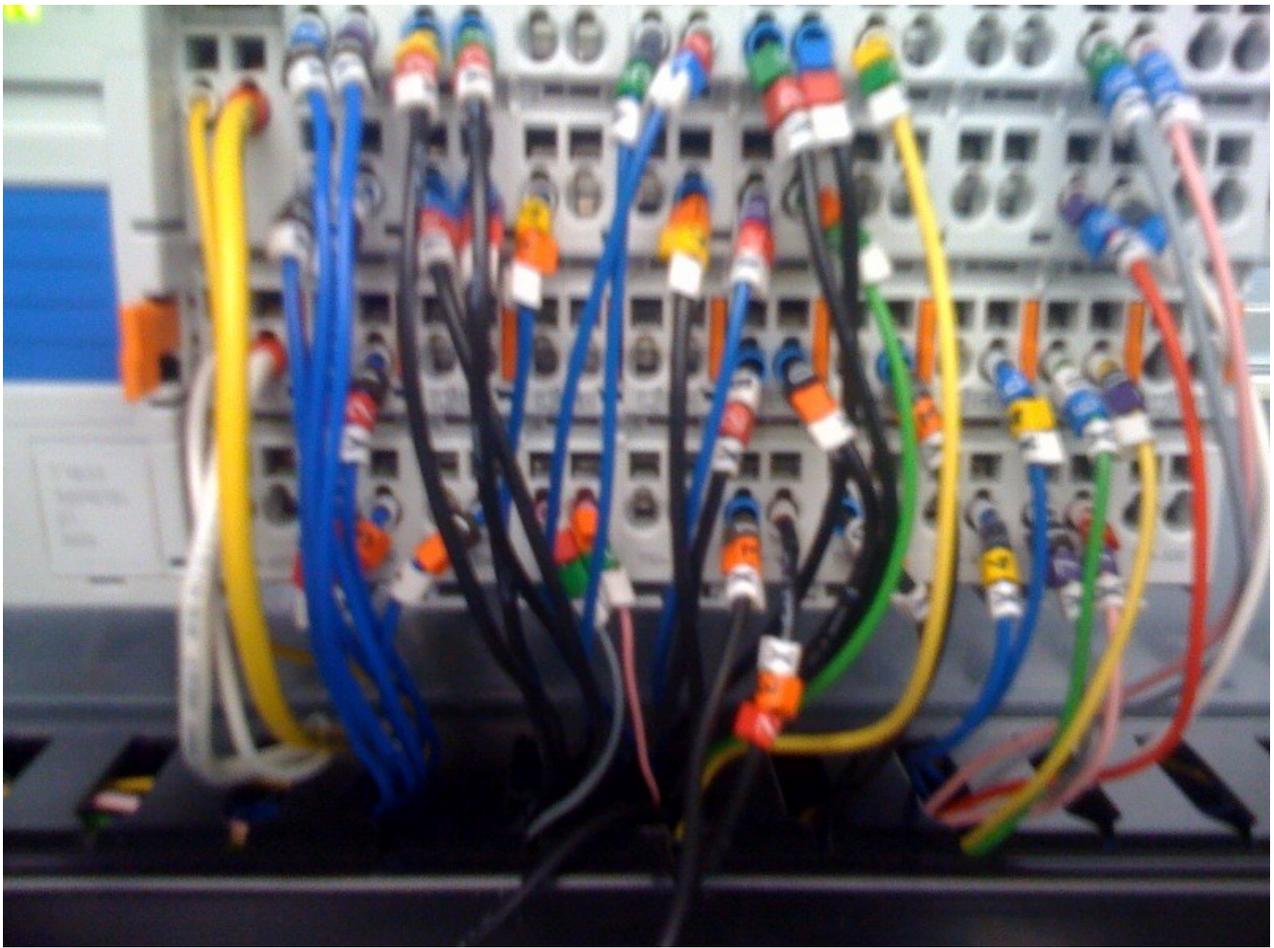
Spare cables can be utilised to route the input from the outfeed connection box to the main cabinet.

Cable number: X32

Outfeed Connection Box Pin: 4



Cabinet



Pick up core number 23 from the same cable as X31 – this will exist in the cable trunking.
Label as X32 and connect to the next hole along from X31

Setting Up

See https://stuga.dokit.app/wiki/Setting_Ultrasonic_Sensor_-_Horizontal to train the ultrasonic sensor