Kodak

# Magnus 400 With MCU Plate Loading Sequence and Parameters

Reference Guide
English

731-00835B-EN Rev A

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# Product

- Kodak® Magnus™ 400 platesetter
- Kodak Magnus 400 Quantum platesetter
- Kodak Magnus 400 platesetter with multi-cassette unit (MCU)

# Overview

This guide describes the Magnus 400 MCU plate-loading sequence and parameters for the Kodak Magnus 400 Controller software version 1.02.392.

The loading sequence is a series of steps (movements) performed by the platesetter that removes the plate from the cassette, transports it to the drum, and secures it to the drum. The loading sequence consists of four stages:

- **Cassette entry to punch entry (a)**: The XY bar transports the plate from the cassette into the punch entry.
- **Punch entry to drum entry (b):** The XY bar inserts the plate into the punch and, after punching, removes the plate from the punch and transports the plate to the drum entry.
- **Drum entry to drum (c):** The plate is moved from the drum entry to the drum, secured to the drum, and then the loading system prepares to load another plate.
- **Paper disposal tasks:** If, after the third step of stage a (a3-y), the paper/metal optic detector detects a slip sheet in the cassette, the loading system removes the slip sheet from the cassette and transports it to the disposal system.

Each significant movement that occurs during each stage is described in the following tables.

**Notes:**

- Relative values are enclosed in parenthesis—for example (161).
- The values shown are the default values.
- The values shown relate to cassette number 2.
- The steps for each stage are sequentially numbered and include either a horizontal X-axis movement descriptor (x) or a vertical Y-axis movement descriptor (y)—for example, a3-y (a = stage, 3 = step number, and y = XY bar movement).

**XY bar movement:**

← = horizontal movement toward the cassette

→ = horizontal movement toward the drum

↓ = vertical downward movement

↑ = vertical upward movement

# Cassette Entry to Punch Entry (a)

Table 1 on page 3 describes the relevant actions that occur during the cassette entry to punch entry stage (a).

During stage a, the loading system removes a plate from the cassette and transports it to the punch.

The XY bar plate-picking positions are defined in the Magnus 400 Controller software. On the underside of the plate, mark the plate-picking positions according to the following diagram.

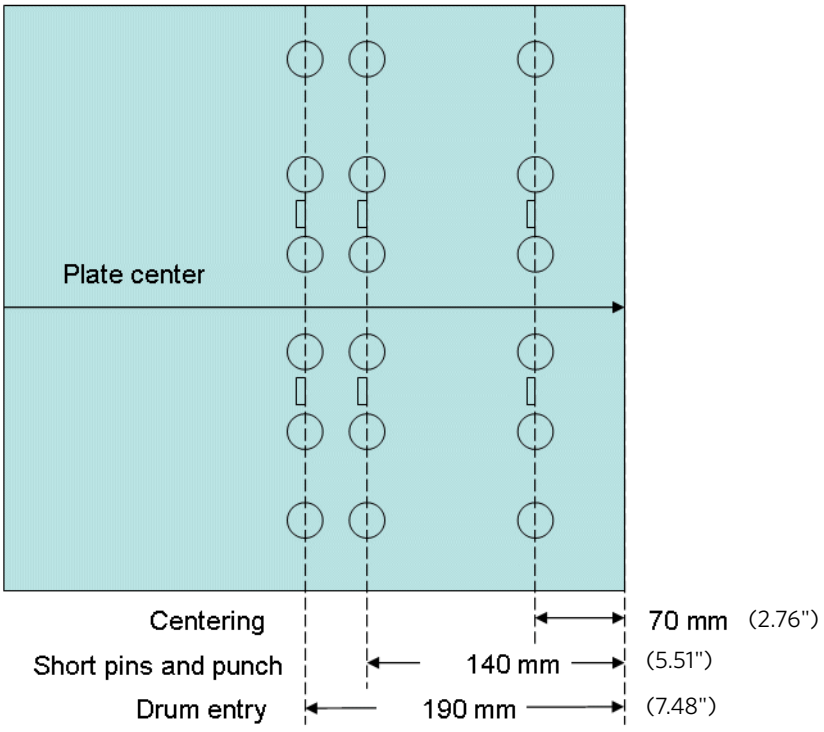
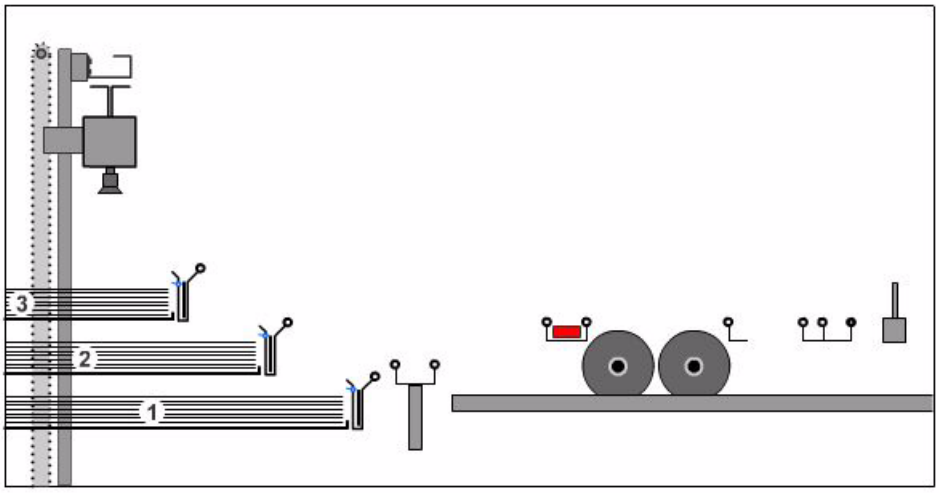
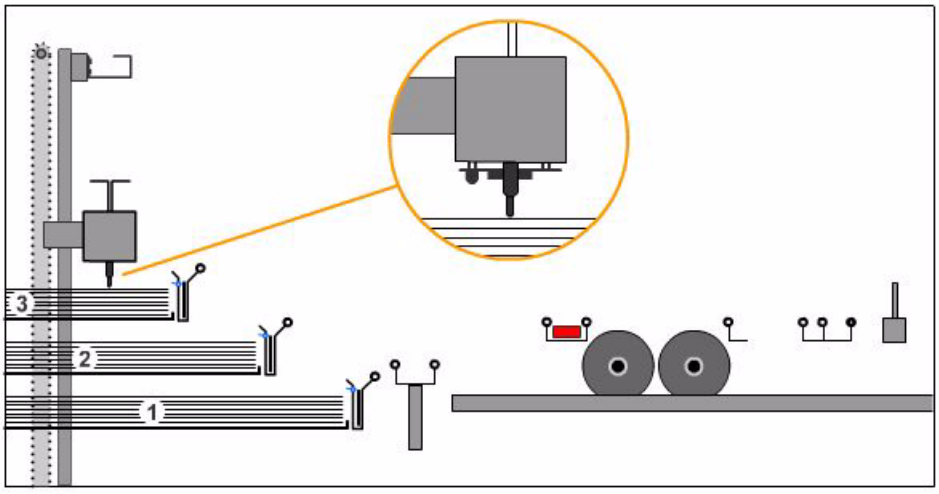


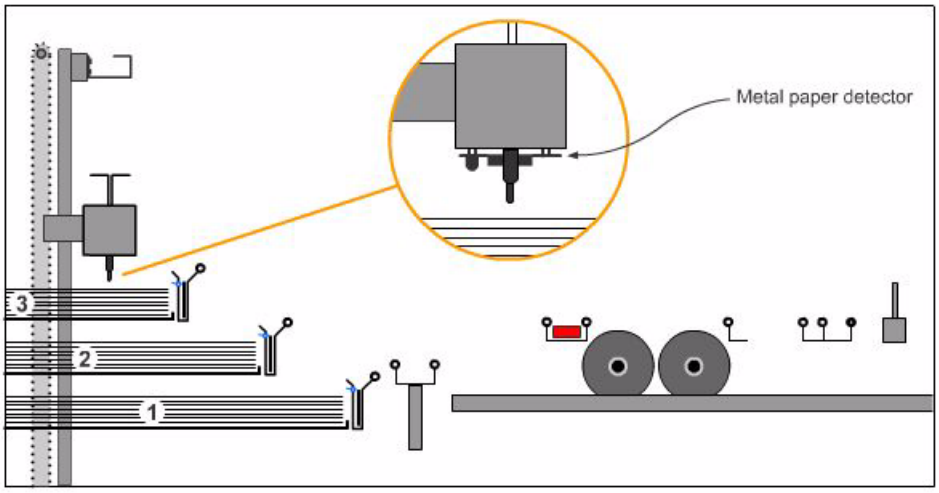

Figure 1: Plate-picking positions

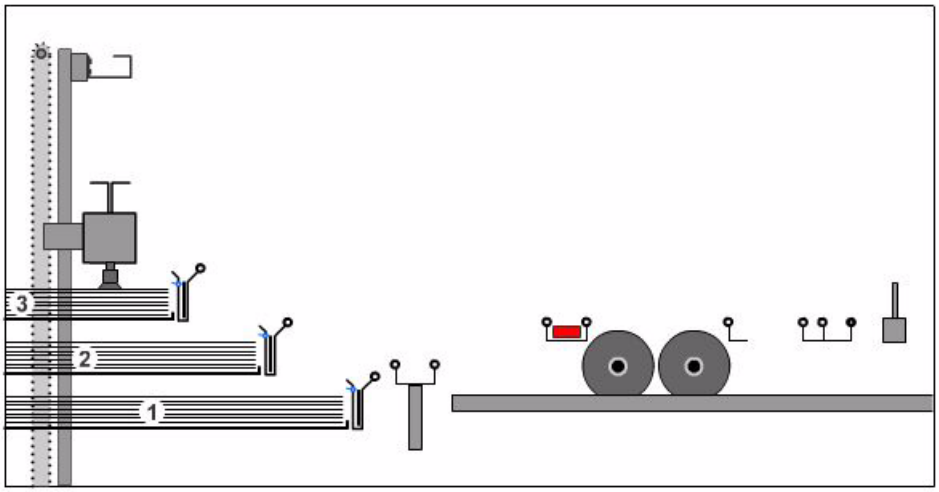
**Note:** During the cassette entry to punch entry stage, the operator must visually verify that the plate is centered correctly and that the XY bar movement and plate-picking positions are synchronized.

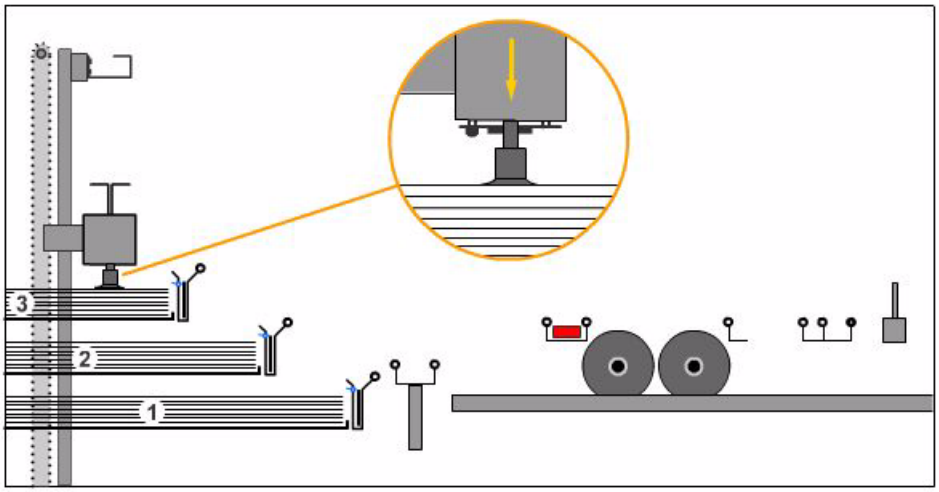
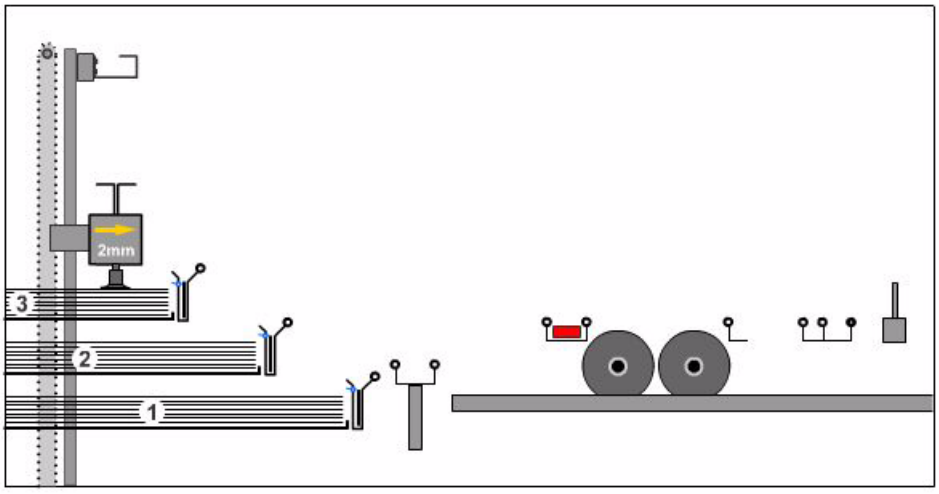
Table 1: Cassette entry to punch entry (a)

| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| a1-x<br>→ | **Cassette to centering sequence**<br>The XY bar moves forward to the selected cassette. | Load Plate > From Cassette to Punch Entry Stage ><br>**X Position in Cassette for Cst 1 (mm)**<br>**X Position in Cassette for Cst 2 (mm)**<br>**X Position in Cassette For Cst 3 (mm)** | <br>315<br>163<br>27 |
| |  | | |
| a2-y<br>↓ | The XY bar descends to the bar flag detector. | Load Plate > From Cassette to Punch Entry Stage ><br>**Y to bar flag det. Speed in Cassette** | <br>13 |
| |  | | |

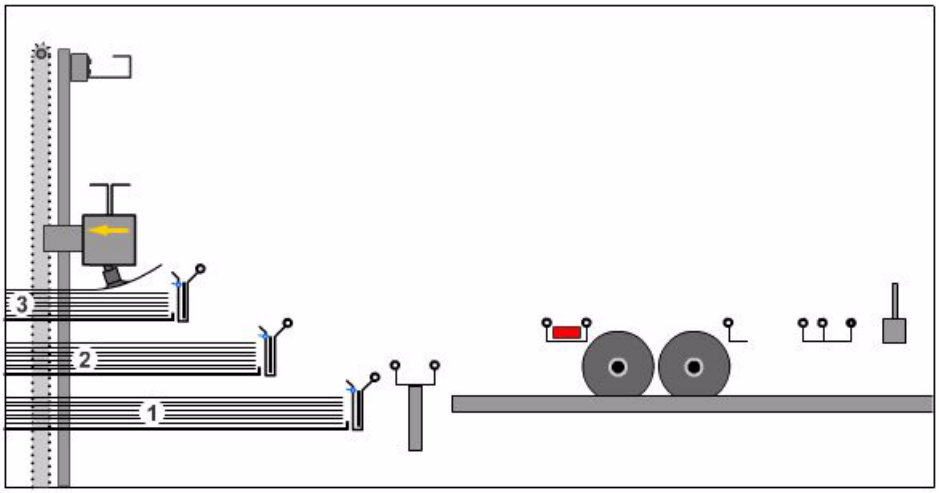
| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| a3-y ↑ | The paper/metal optic detector identifies a plate or slip sheet in the cassette.<br>**Note:** If a slip sheet is detected, the Paper Disposal stage is initiated. See *Paper Disposal* on page 24. | Loading System > Loading System Setup > **Y To Read Paper Metal Det (mm) Rel** | -10 |
| a4-y ↓ | The vacuum activates.<br>The suction cups activate.<br>The XY bar descends to the bar flag. | Load Plate > From Cassette to Punch Entry Stage > **Y to bar flag det. Speed in Cassette** | 13 |

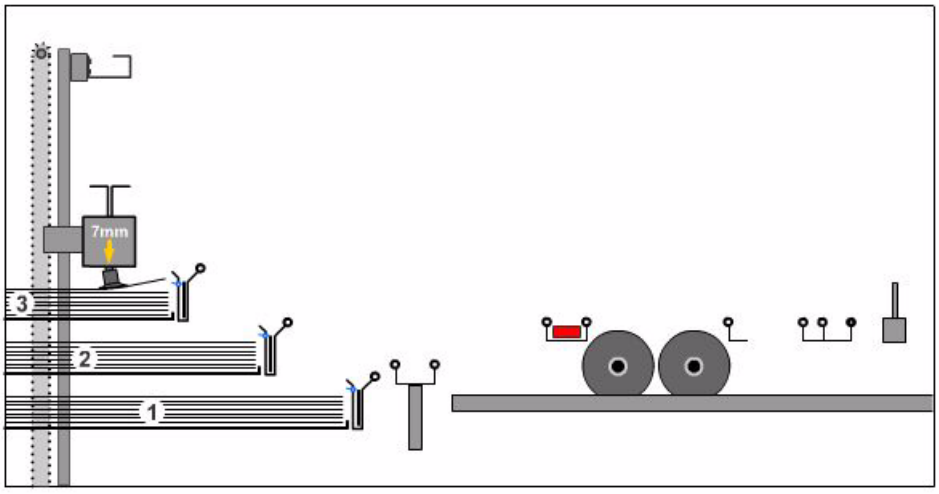


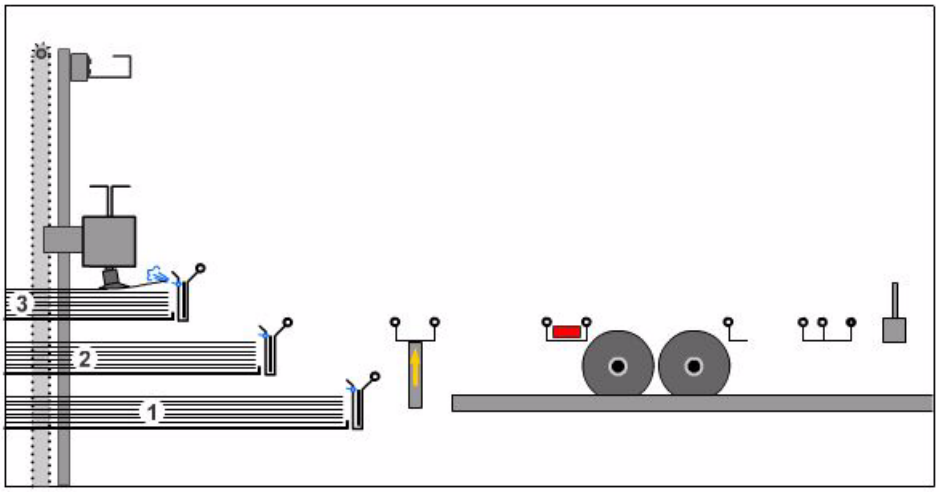
| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| a5-y<br>↓ | The Y-axis is at the Extra to bar flag position.<br><br>At cassette to center position (70 mm from the edge of the plate), all suction cups touch and securely hold the plate. | Loading System > Loading System Setup ><br>**Y Extra to Bar Flag Det For 0.15 (mm) Rel**<br>**Y Extra to Bar Flag Det For 0.3–0.2 (mm) Rel**<br>**Y Extra to Bar Flag Det Speed**<br>**Sleep After Extra to Bar Flag Det [mSec]** | <br>7<br>10<br>5 mm/sec<br>2000 msec |
| |  | | |
| a6-x<br>→ | **Separation of plate from slip sheet sequence**<br><br>The purpose of this motion and the next two movements is to separate the plate from the slip sheet that is underneath it. | Load Plate > From Cassette to Punch Entry Stage ><br>**X Plate Forward In Cassette for 0.15 (mm) Rel**<br>**X Plate Forward In Cassette for 0.2 (mm) Rel**<br>**X Plate Forward In Cassette for 0.3 (mm) Rel** | <br>1<br>2<br>2 |
| |  | | |

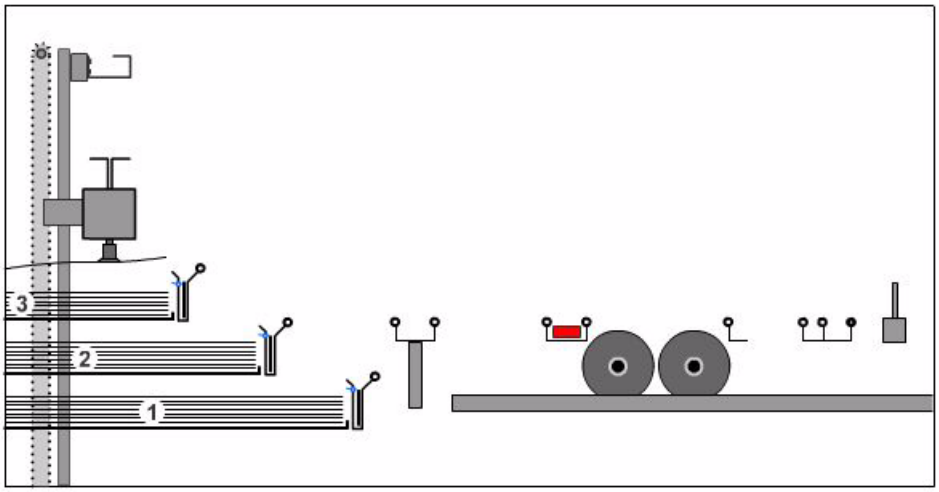
| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| a7-y<br>↑ | These two back-and-forth (default) movements along the X and Y axes repeat several times to help plate and slip sheet separation, and prevent double-loading. | Load Plate > From Cassette to Punch Entry Stage ><br>**Y Plate Up in Cassette_3 (mm)**<br>**Y Plate Up in Cassette_2 (mm)**<br>**Y Plate Up in Cassette_1 (mm)**<br>**Y Plate High Up in Cassette (for all thicknesses)**<br>**Number of Plate BackWard Separations** | <br>25<br>80<br>145<br>0<br>3 |
| a8-x<br>← | The plate bends to separate the slip sheet. | Load Plate > From Cassette to Punch Entry Stage ><br>**X Backward For 0.15 plate [mm] Rel**<br>**X Backward For 0.2 plate [mm] Rel**<br>**X Backward For 0.3 plate [mm] Rel** | <br>16<br>19<br>20 |
| a9-y<br>↓ | The status bar flag detects whether the plate is still attached. | Load Plate > From Cassette to Punch Entry Stage ><br>**Y After Plate Separation [mm] Rel** | <br>7 |

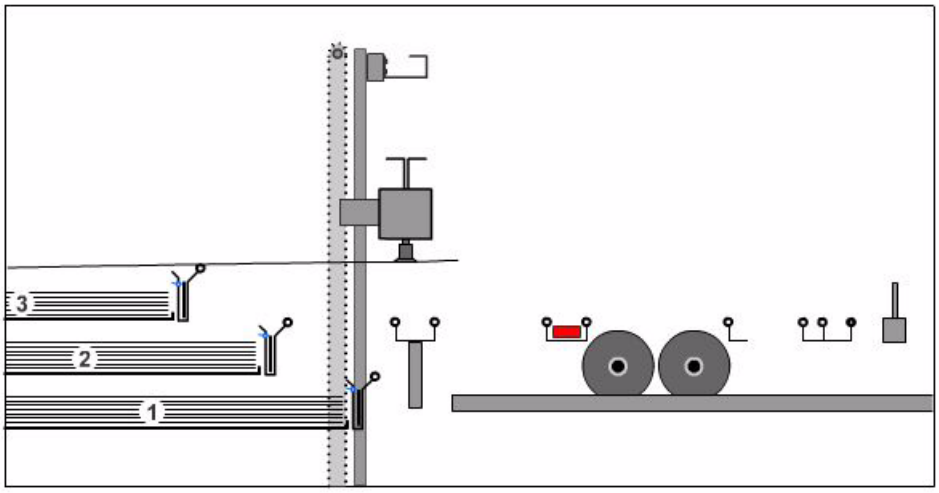
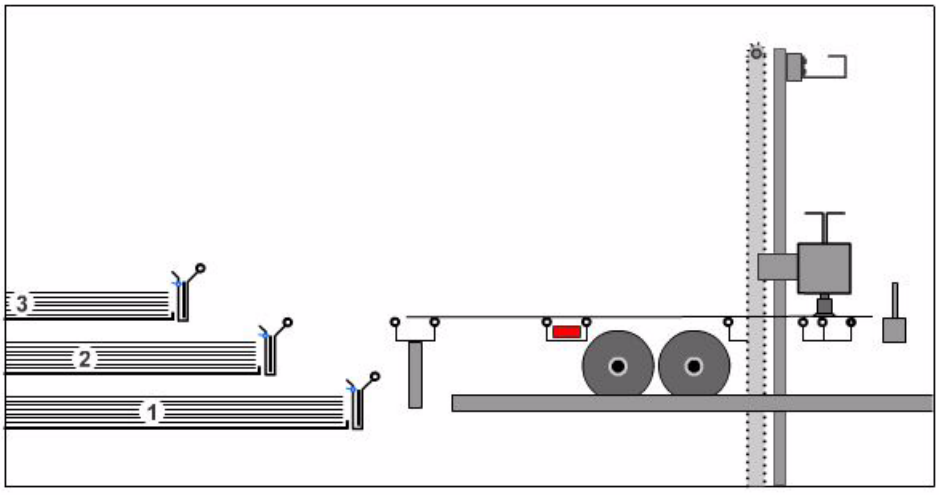


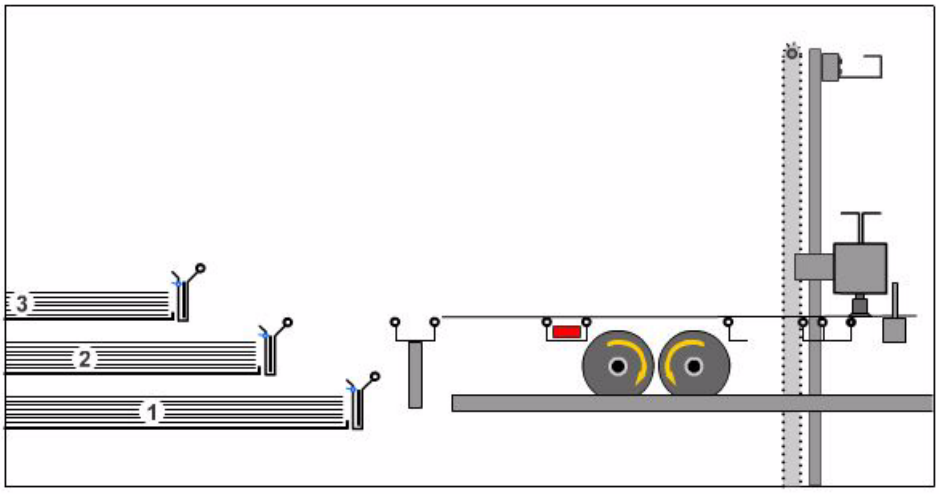
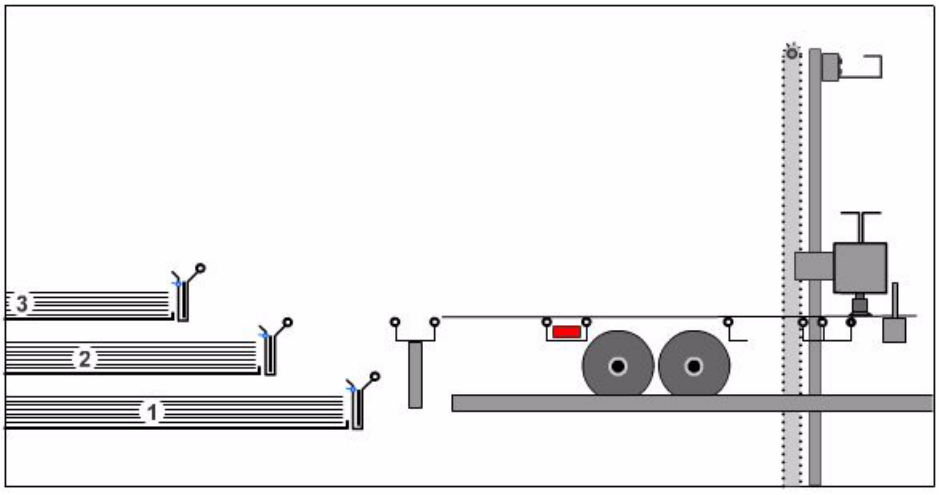



| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| a10-y ↓ | The fufu activates to blow the slip sheet downward.<br>The centering pins activate and move ( 5 mm) to accommodate the plate.<br>The ramp rises according to the plate size.<br>The bar flag detects whether the plate is still attached. | Load Plate > From Cassette to Punch Entry Stage ><br>**Y Above Air Nozzle In Tray 1(mm)**<br>**Y Above Air Nozzle In Tray 2(mm)**<br>**Y Above Air Nozzle In Tray 3(mm)**<br><br>**Centering Wait Dis (mm) Rel** | <br>181<br>110<br>37<br><br>10 |
| a11-y ↑ | The plate rises so that it can be removed from the cassette. | Load Plate > From Cassette to Punch Entry Stage ><br>**Y Prepare to Take Out Plate From Cst 1(mm)**<br>**Y Prepare to Take Out Plate From Cst 2(mm)**<br>**Y Prepare to Take Out Plate From Cst 3(mm)** | <br>160<br>70<br>25 |

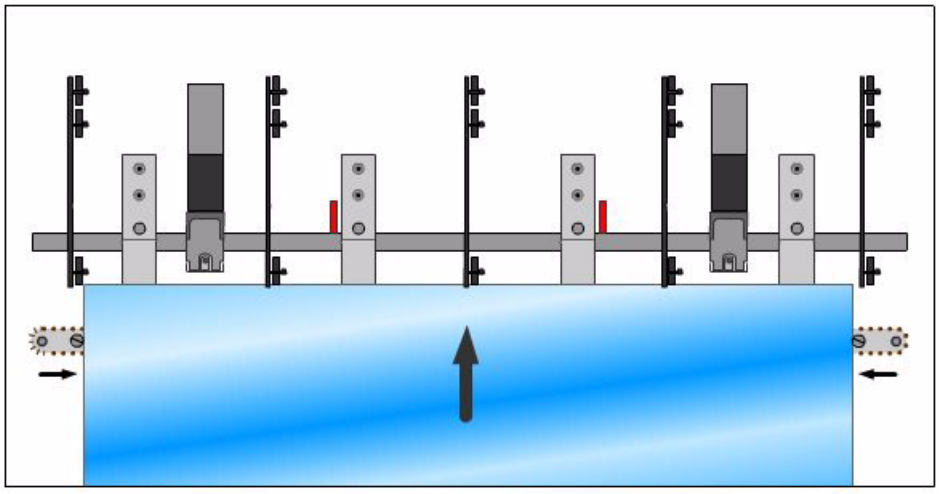


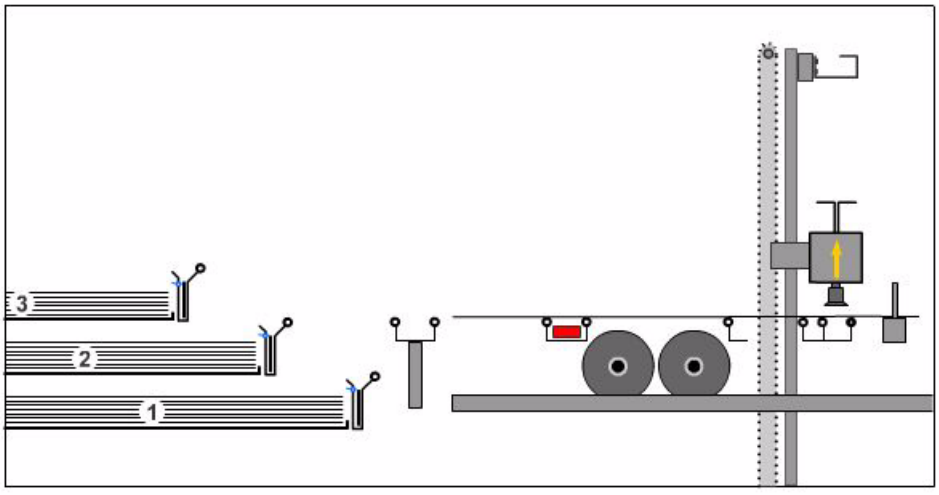



| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| a12-x<br>→ | The plate advances forward and air blows inside the cassette until the X-axis reaches this position. | Load Plate > From Cassette to Punch Entry Stage ><br>**X to Fufu Off Cassette 1 (Rel)**<br>**X to Fufu Off Cassette 3 (Rel)** | <br>110<br>200 |
| |  | | |
| a13-y<br>↑ | Depending on the cassette from which the plate is removed, the plate either rises above the ramp level (cassette 1) or descends down to the ramp level (cassette 3). | Load Plate > From Cassette to Punch Entry Stage ><br>**Y Ramp Position mm** | <br>90 |
| |  | | |

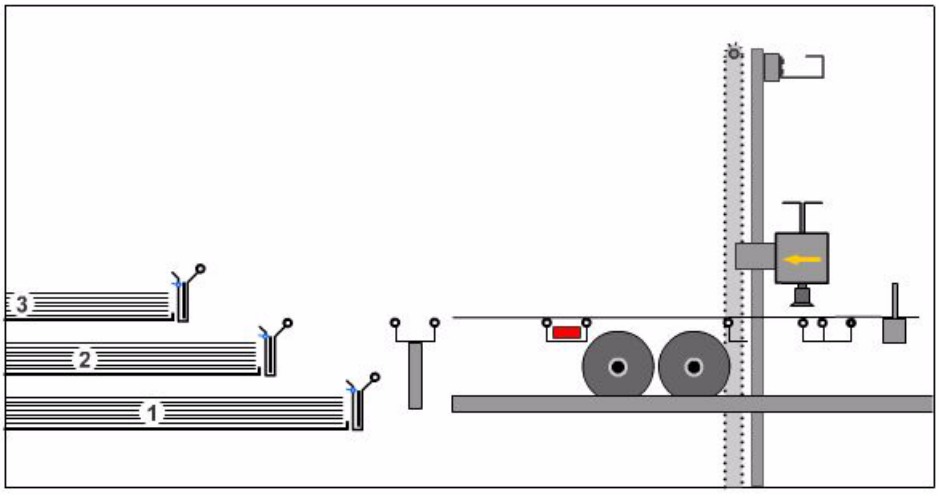
| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| a14-x<br>→ | The XY bar transports the plate to centering.<br>The paper disposal rollers activate to remove any remaining slip sheets. | Load Plate > From Cassette to Punch Entry Stage ><br>**X for Centering (mm)**<br>**X for Centering Speed** | <br>820<br>15 |
| |  | | |
| a15-y<br>↓ | The Y-axis descends for centering and releases the plate. | Load Plate > From Cassette to Punch Entry Stage ><br>**Y for Centering (mm)** | <br>88 |
| |  | | |

| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| a16-x<br>→ | The XY bar transports the plate to the final centering position.<br>The plate size is measured and compared to the media definition of the selected cassette.<br>The paper disposal deactivates. | Load Plate > From Cassette to Punch Entry Stage ><br>**X for Centering Final (mm)**<br>**X for Centering Speed**<br>**Measure Centering Tolerance (mm)** | <br>833<br>1<br>3 |
| a17-y<br>↑ | The XY bar rises and releases the plate. | Load Plate > From Cassette to Punch Entry Stage ><br>**Y Up For Centering (mm) Rel** | <br>–15 |



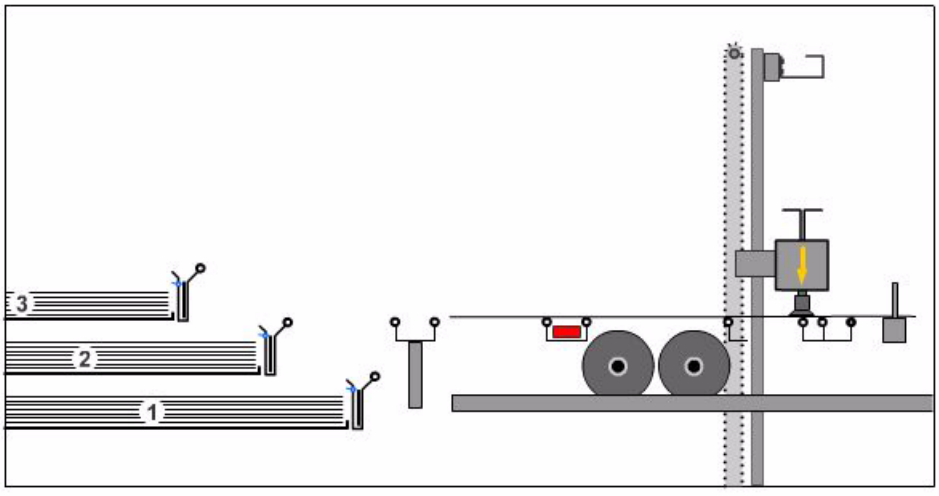


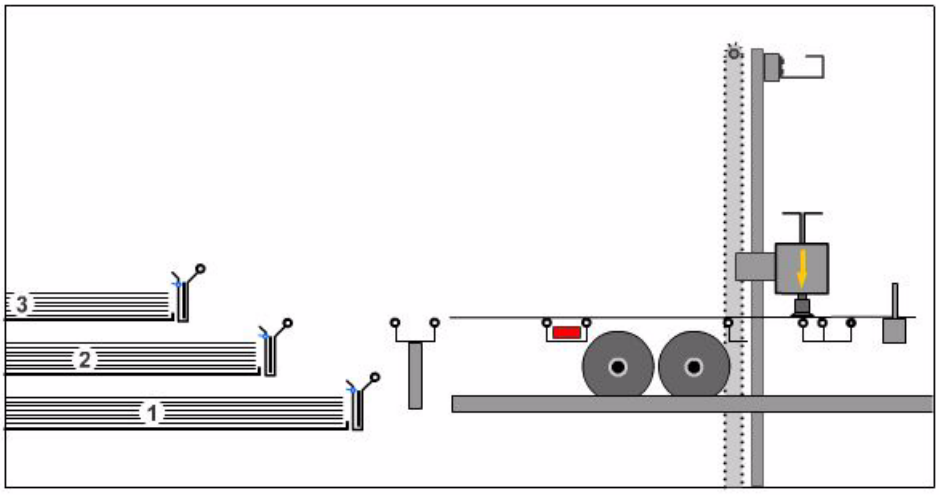
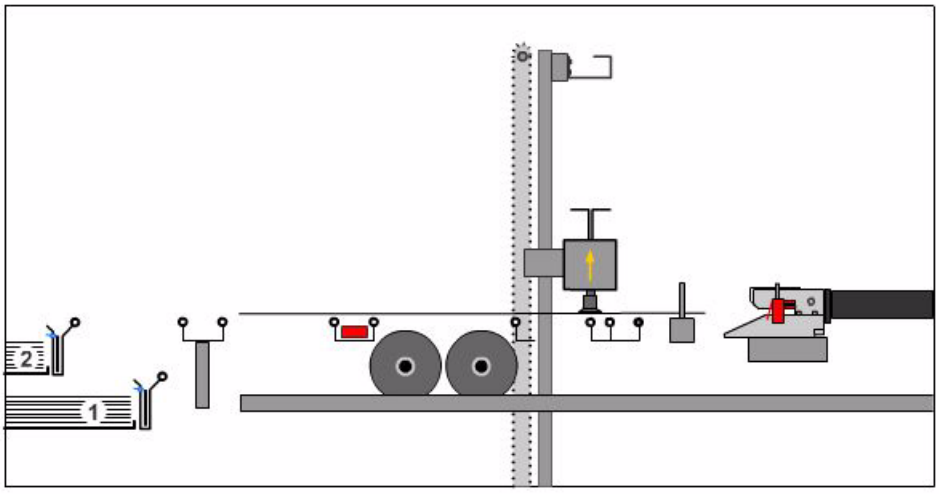
| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| a18-x<br>← | Before punch entry, the XY bar returns to pick up the plate at 140 mm from the edge of the plate. See Figure 1 on page 2. | Load Plate > From Cassette to Punch Entry Stage > **X Pick Up Plate Before In Punch (mm)** | 760 |



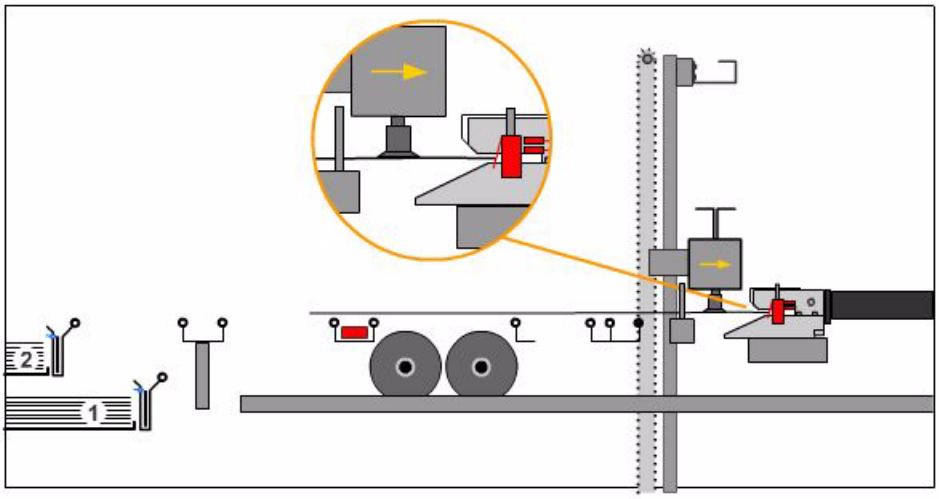

**Note:** If the plate-picking position is not aligned on the 140-mm line, adjust the **X for Centering Final (mm)** parameter.

| | | | |
|---|---|---|---|
| a19-y<br>↓ | The suction cup vacuum activates.<br>The plate is detected and reattaches to the suction cups (**Y to Detector**).<br>The centering pins release the plate and move to wait distance. | | |



| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| a20-y ↓ | The suction cups descend to secure the plate. | Load Plate > From Cassette to Punch Entry Stage > **Y Down After Centering to catch Plate For 0.15 (mm) Rel**<br>**Y Down After Centering to catch Plate For 0.3–0.2 (mm) Rel** | 9<br>9 |
| |  | | |
| a21-y ↑ | The XY bar lifts the plate to punch level. | Load Plate > From Punch to Drum Entry Stage > **Y to short pins (mm)** | 88 |
| |  | | |

| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| a22-x<br>→ | The XY bar transports the plate to the micro switches.<br>Stage (a) finishes when the plate reaches **Pre Extra** position.<br>**Note:** After this stage, if the plate is not 3–5 mm from the short pins, adjust the **X Pre Extra To Short Pins** parameter. | Load Plate > From Cassette to Punch Entry Stage ><br>**X Pre Extra To Short Pins For 0.15 (mm) Rel**<br>**X Pre Extra To Short Pins For 0.2 (mm) Rel**<br>**X Pre Extra To Short Pins For 0.3 (mm) Rel** | <br>48<br>48<br>48 |

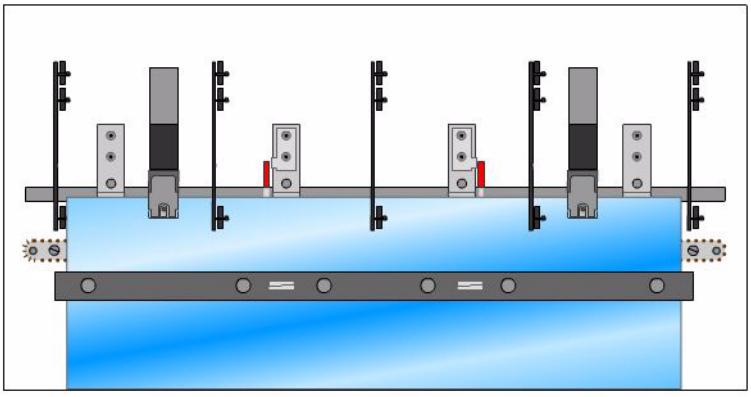


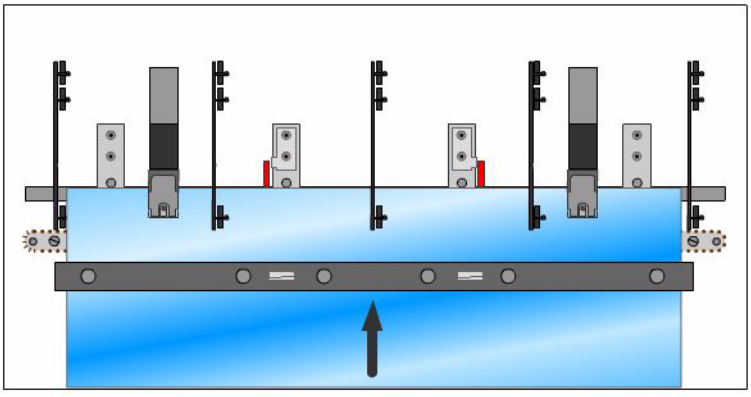
# Punch Entry to Drum Entry (b)

Table 2 describes the relevant actions that occur during the punch entry to drum entry stage. In this stage, the loading system inserts the plate into the punch, and after it is punched, removes the plate from the punch and transports it to the drum entry.

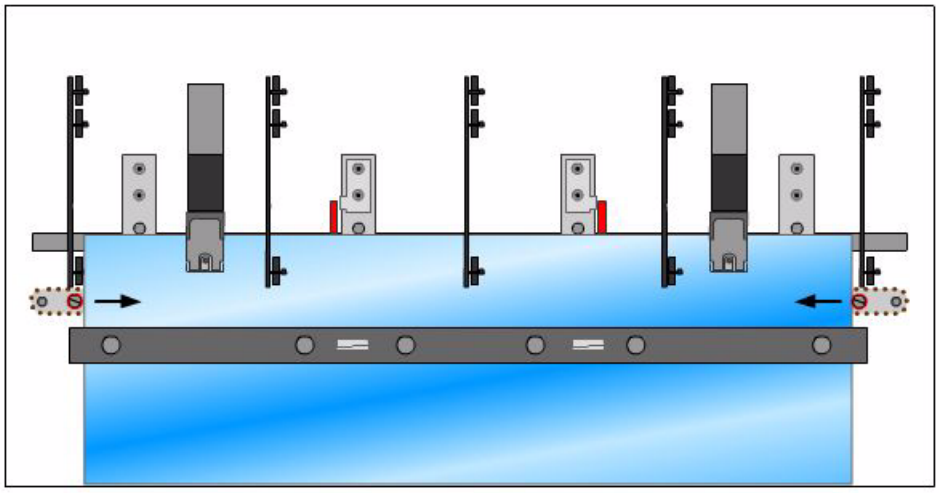
Table 2: Punch entry to drum entry (b)

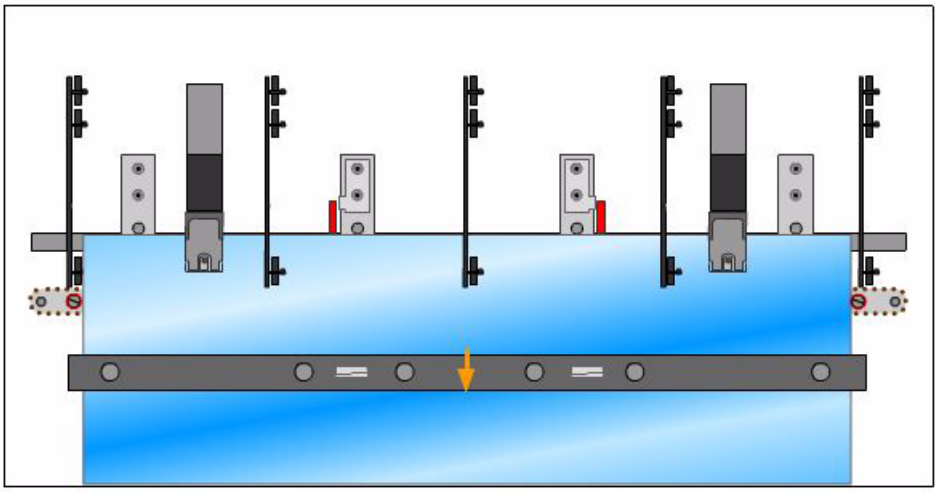
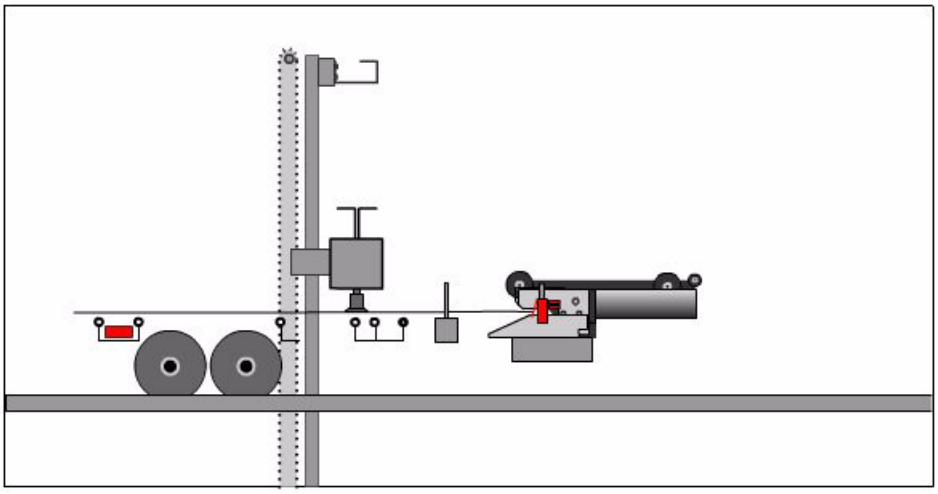
| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| b1-x → | The leading edge of the plate presses against the micro switches. (This movement repeats up to six times.)<br><br>When the micro switches detect the leading edge of the plate, the plate advances one more step (3 mm) toward the short pins.<br><br>The punch activates while the plate is attached to the short pins. | Load Plate > From Punch Entry to Drum Entry Stage ><br>**X Extra To Short Pins For 0.15 (mm) Rel**<br>**X Extra To Short Pins For 0.2 (mm) Rel**<br>**X Extra To Short Pins For 0.3 (mm) Rel** | <br>3<br>3<br>3 |

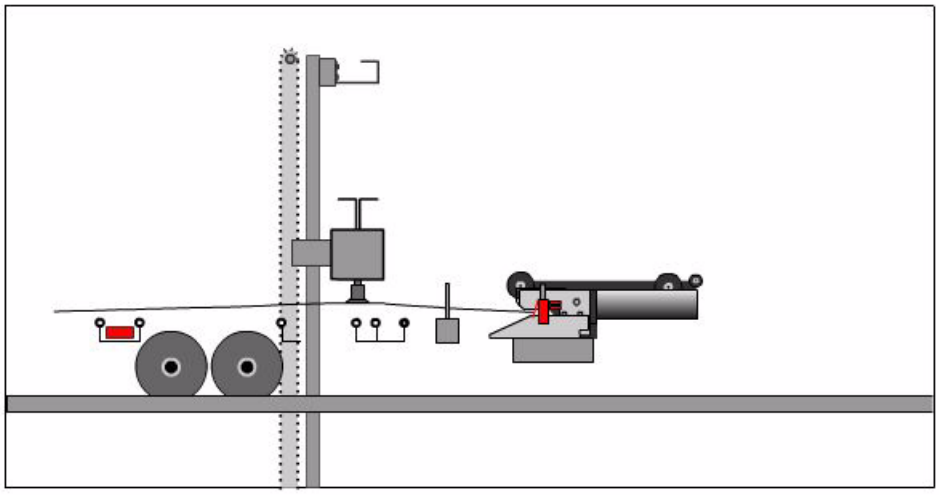
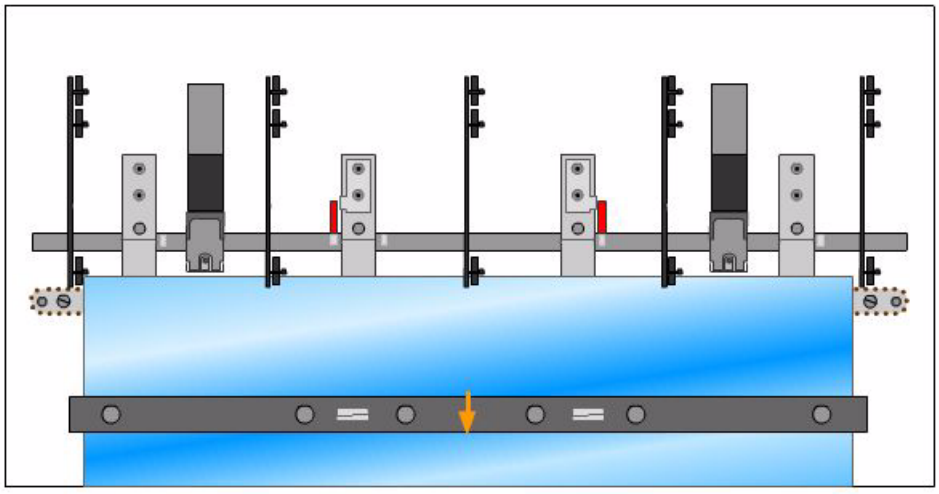


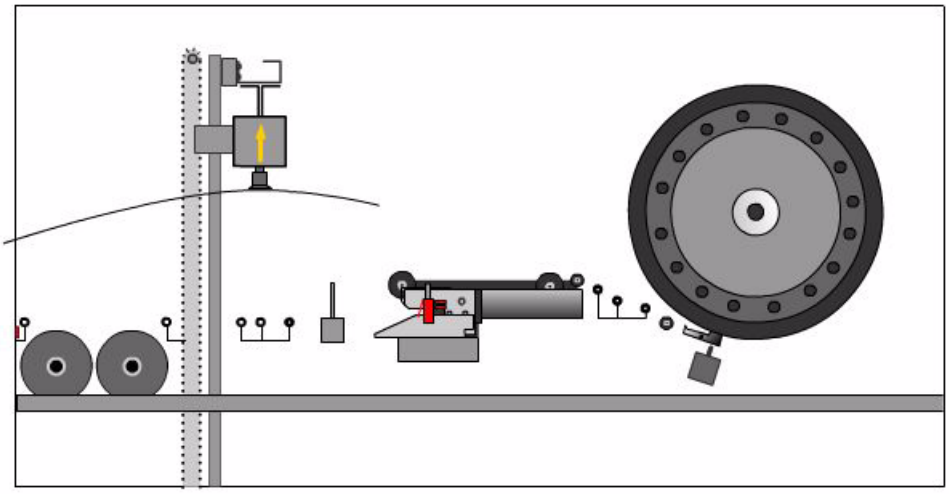
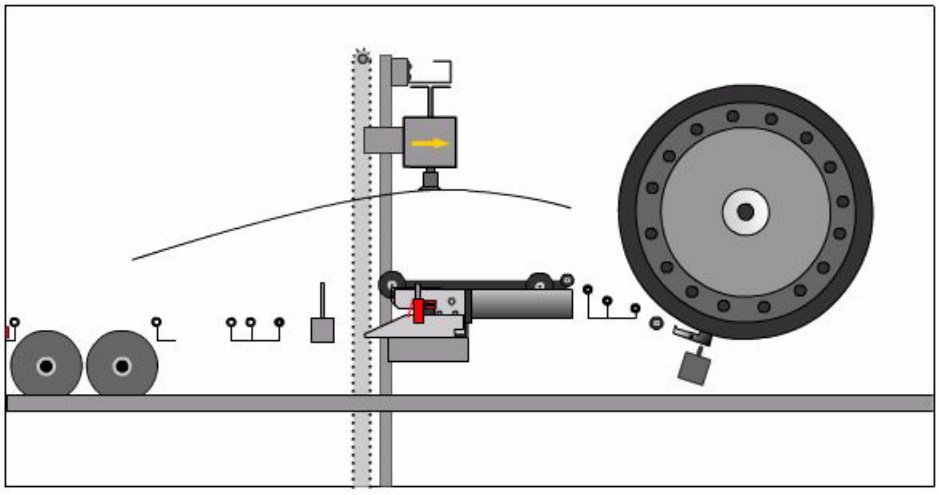


| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| b2-y ↑ | The centering pins center the plate according to the plate size, keeping it center-aligned until releasing it before punch entry.<br>The XY bar rises and releases the plate. | Load Plate > From Punch Entry to Drum Entry Stage ><br>**Y Up For Backward After Centering (mm) Rel** | –15 |

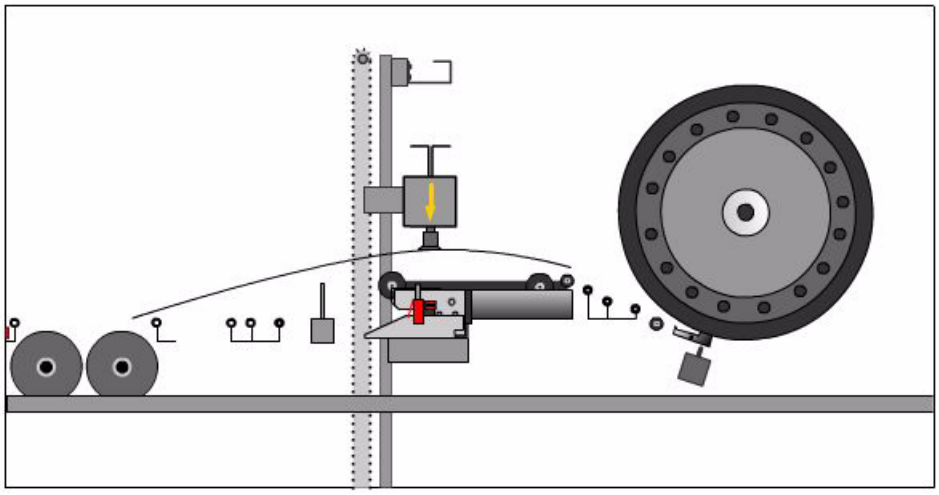


| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| b3-x ← | The XY bar returns to pick up the plate.<br>**Note:** After this stage, the X position is the sum of two parameters—**X Pick Up Plate Before In Drum (mm) + X Move X Upto Wheels (mm)**. | Load Plate > From Punch Entry to Drum Entry Stage ><br>**X Pick Up Plate Before In Drum (mm)**<br>**X Move X Upto Wheels For 0.15 (mm)**<br>**X Move X Upto Wheels For 0.2 (mm)**<br>**X Move X Upto Wheels For 0.3 (mm)** | <br>760<br>0<br>0<br>0 |
| |  | | |
| | **Note:** After this stage, the XY bar is above the 190-mm plate-picking position. | | |
| b4-y ↓ | The suction activates.<br>The XY bar descends to the bar flag.<br>The suction cups attach to the plate.<br>The centering pins release the plate. | Load Plate > From Cassette to Punch Entry Stage ><br>**Y Down After Centering to catch Plate For 0.15 (mm) Rel**<br>**Y Down After Centering to catch Plate For 0.3-0.2 (mm) Rel** | <br>9<br>9 |
| |  | | |

| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| b5-y<br>↑ | The XY bar lifts the plate and removes it from the punch. | Load Plate > From Punch Entry to Drum Entry Stage ><br>**Y Up After DoPunch For 0.15**<br>**Y Up After DoPunch For 0.2**<br>**Y Up After DoPunch For 0.3** | <br>85<br>85<br>85 |
| |  | | |
| b6-x<br>← | The XY bar removes the plate from the punch. | Load Plate > From Punch Entry to Drum Entry Stage ><br>**X After DoPunch For 0.15**<br>**X After DoPunch For 0.2**<br>**X After DoPunch For 0.3** | <br>705<br>705<br>705 |
| |  | | |

| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| b7-y ↑ | The XY bar lifts the plate above the punch and roller guides. | Load Plate > From Punch Entry to Drum Entry Stage > | |
| | | **Y Up Prepare To Drum** | –10 |
| |  | | |
| b8-x → | The XY bar transports the plate toward the drum entry. | Load Plate > From Punch Entry to Drum Entry Stage > | |
| | | **X Near To Drum For 0.15 Seq (mm)** | 900 |
| | | **X Near To Drum For 0.2 Seq (mm)** | 900 |
| | | **X Near To Drum For 0.3 Seq (mm)** | 900 |
| |  | | |

| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| b9-y<br>↓ | The XY bar lowers the plate onto the roller guides in front of the drum entry (Cobra position). | Load Plate > From Punch Entry to Drum Entry Stage<br>><br>**Y In Drum For 0.15 (mm)**<br>**Y In Drum For 0.2 (mm)**<br>**Y In Drum For 0.3 (mm)** | <br><br>10<br>20<br>30 |

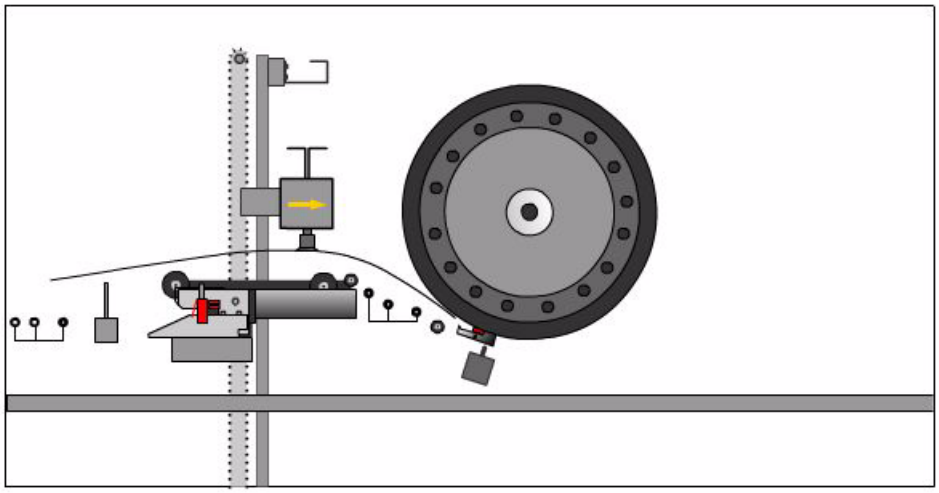


# Drum Entry to Drum (c)

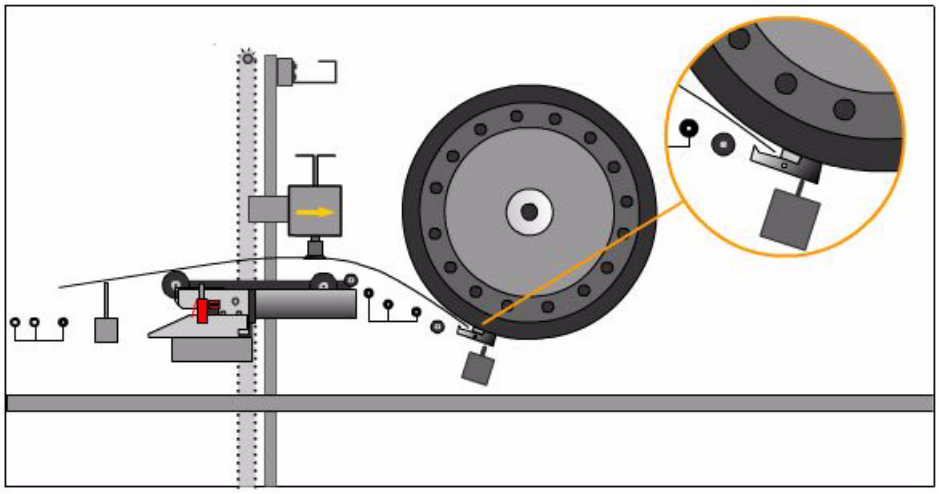
Table 3 describes the relevant actions that occur during the drum entry to drum stage. In this stage, the plate is transported from the drum entry and fully secured to the drum. At the end of this stage, the loading system repositions itself in preparation for loading another plate.

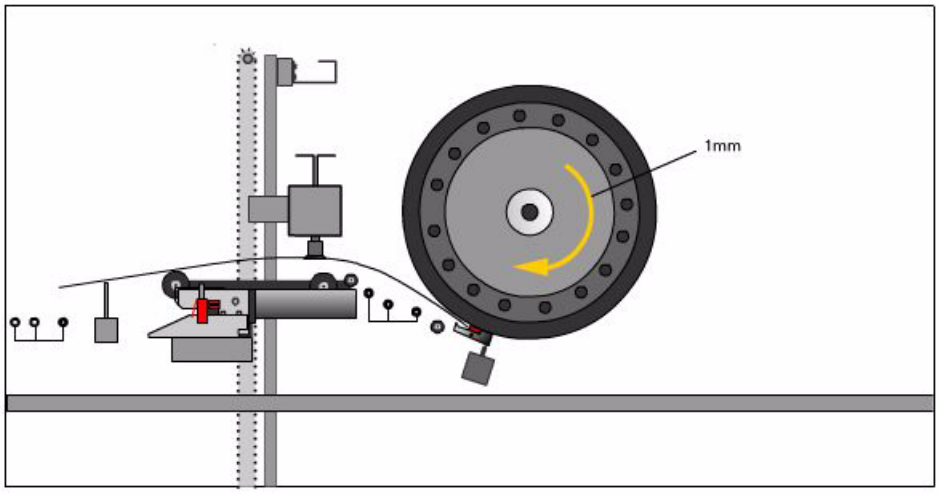
Table 3: Drum entry to drum (c)

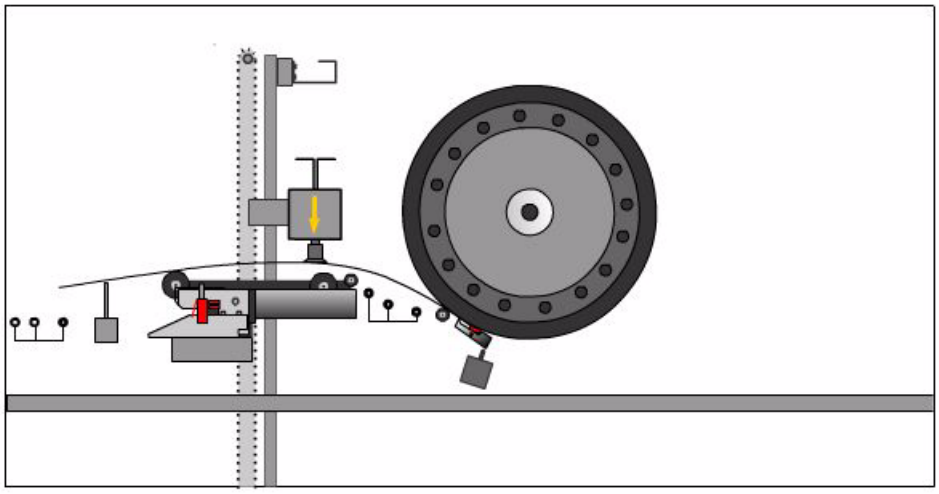
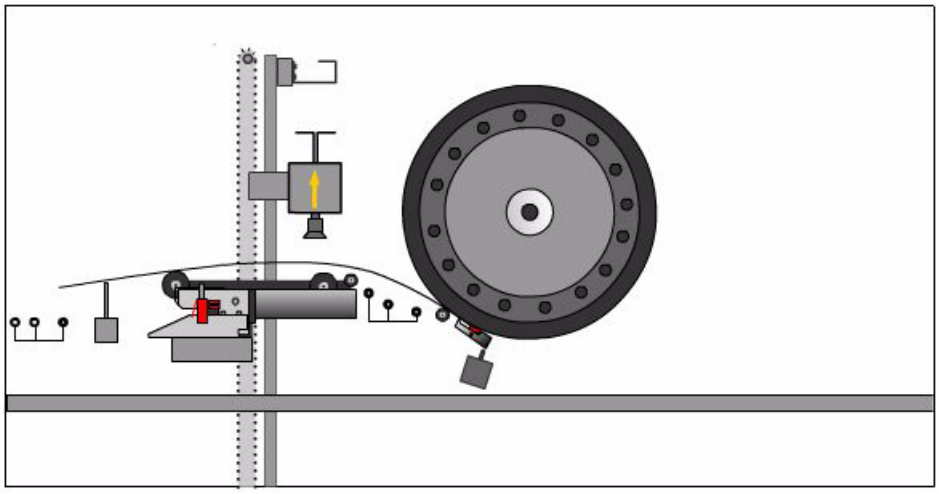
| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| c1-x → | This step occurs after the drum rotates and is positioned to secure the plate, and the head grippers open.<br><br>The plate advances toward the drum. | Load Plate > From Drum Entry to Drum Stage ><br>**X In Drum For 0.15(mm)**<br>**X In Drum For 0.2(mm)**<br>**X In Drum For 0.3(mm)** | <br>1006<br>1006<br>1006 |

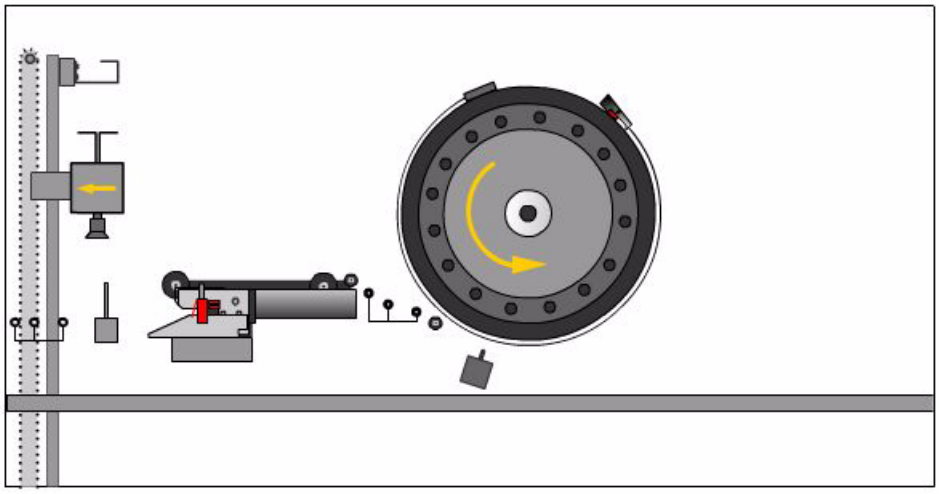
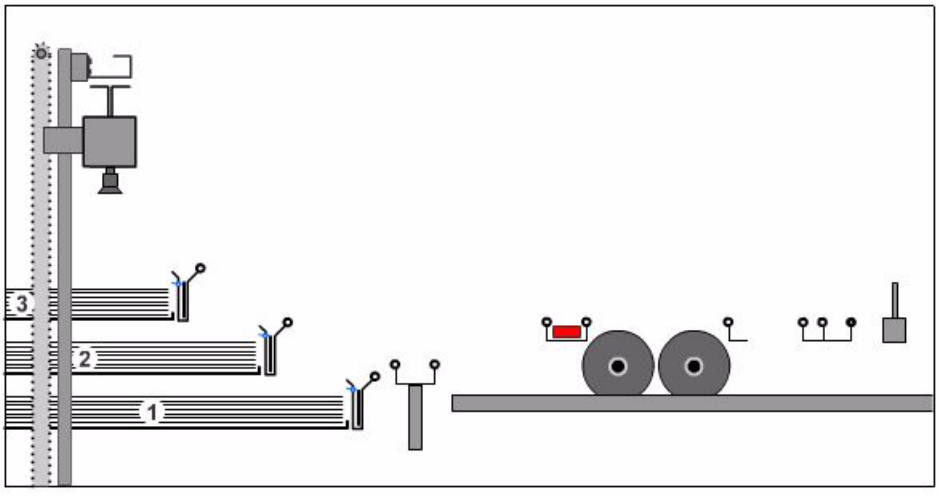


| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| c2-x → | X is in the drum final position.<br>The leading edge of the plate is inserted into the head grippers. | Load Plate > From Drum Entry to Drum Stage ><br>**X In Drum Final For 0.15 Plates (mm) Rel**<br>**X In Drum Final For 0.2 Plates (mm) Rel**<br>**X In Drum Final For 0.3 Plates (mm) Rel** | <br>12<br>12<br>12 |
| c3-Drum | The drum moves toward the plate, the head grippers close on the plate, and the leading edge is secured on the drum. | Load Plate > From Drum Entry to Drum Stage ><br>**Drum To Plate After Extra For 0.15 (mm)**<br>**Drum To Plate After Extra For 0.2 (mm)**<br>**Drum To Plate After Extra For 0.3 (mm)** | <br>1<br>1<br>1 |





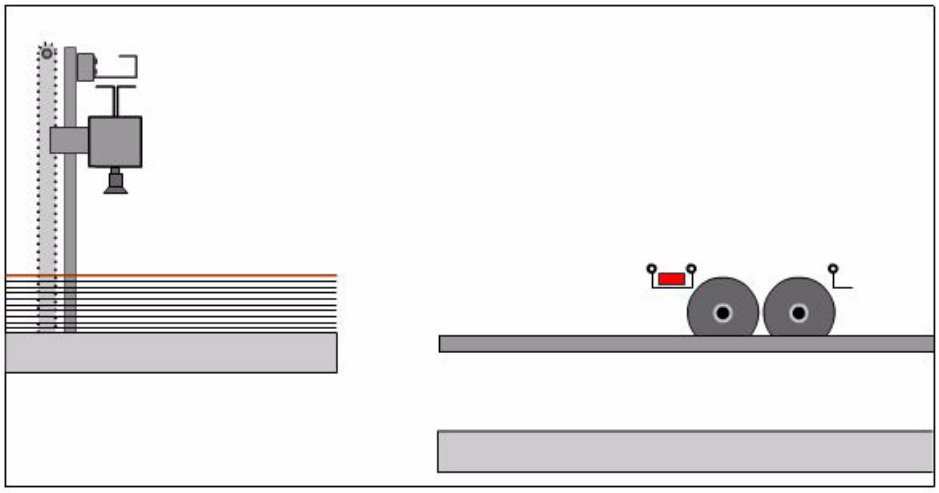
| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| c4-y ↓ | The suction cup vacuum stops, and the plate is released.<br>The drum vacuum is activated. | Load Plate > From Drum Entry to Drum Stage > **Y Down After Plate Drop Abs (mm)** | 25 |
| |  | | |
| c5-y ↑ | The XY bar rises and returns to the cassette. | Load Plate > From Drum Entry to Drum Stage > **Y Up Before Back Abs (mm)** | 14 |
| |  | | |

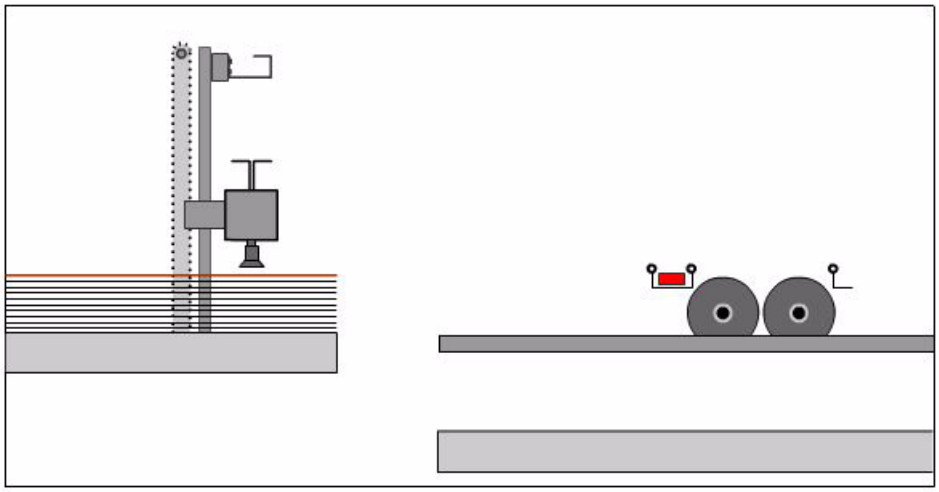
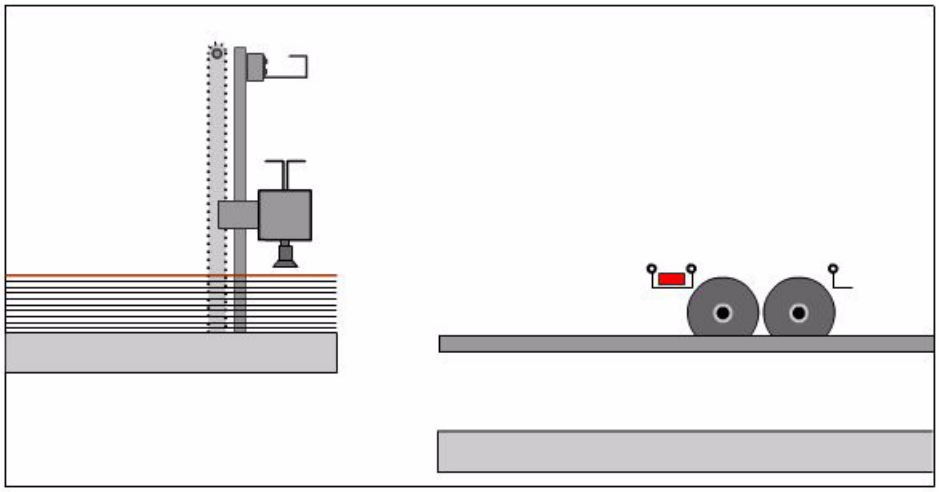
| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| c6-x ← | The drum rotates and the plate is wrapped around the drum, secured to the drum by vacuum, and the tail grippers secure the tail edge of the plate. | Load Plate > From Drum Entry to Drum Stage > **X Run Away From Plate On Drum** | 300 |
| |  | | |
| c7-y ↑ | The XY bar returns to the Y-axis home position (HP). | **Init XY** | HP |
| c8-x ← | The XY bar returns to the X-axis home position. | | |
| |  | | |

# Paper Disposal

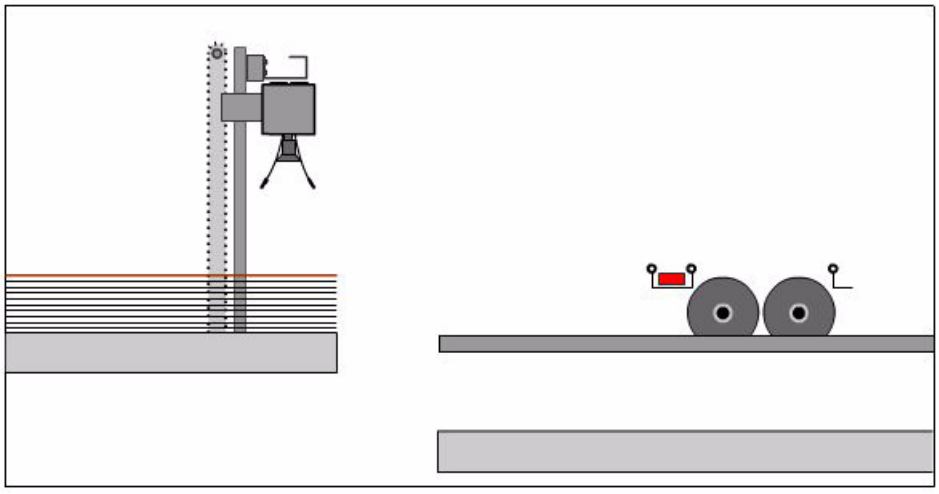
Table 4 describes the relevant actions that occur during the paper disposal stage. In this stage, the XY bar transports the slip sheet from the cassette to the disposal system. This stage occurs only when a slip sheet is detected in the cassette, and begins after step a3.

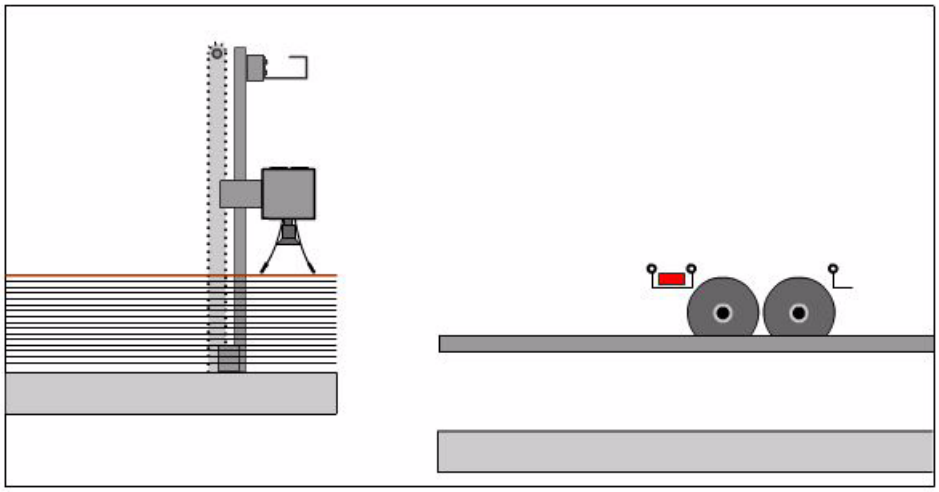
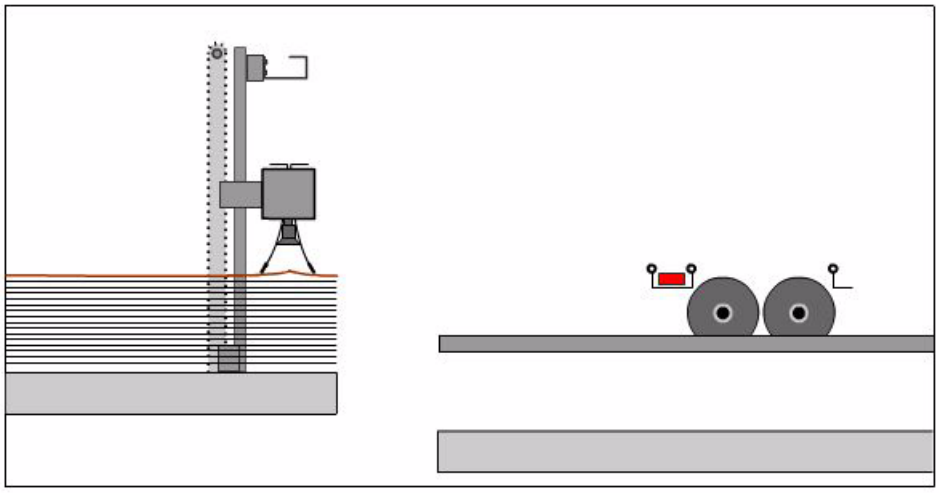
Table 4: Paper disposal

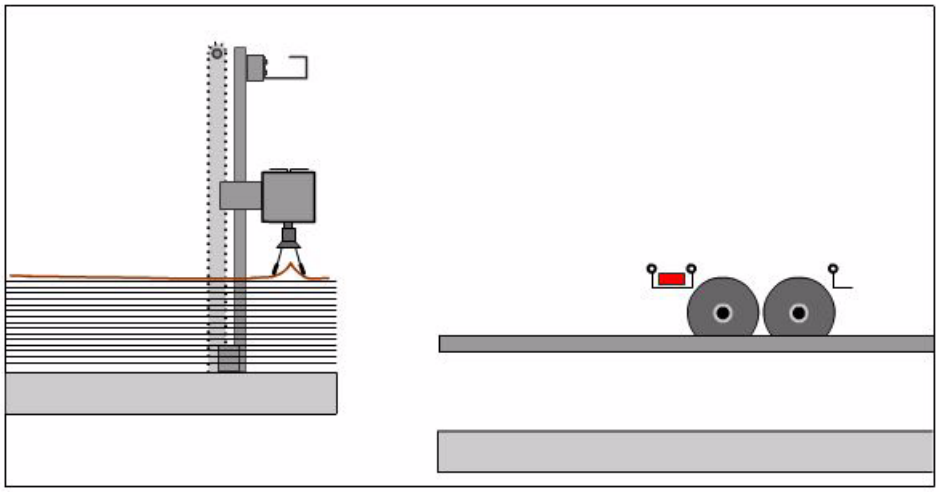
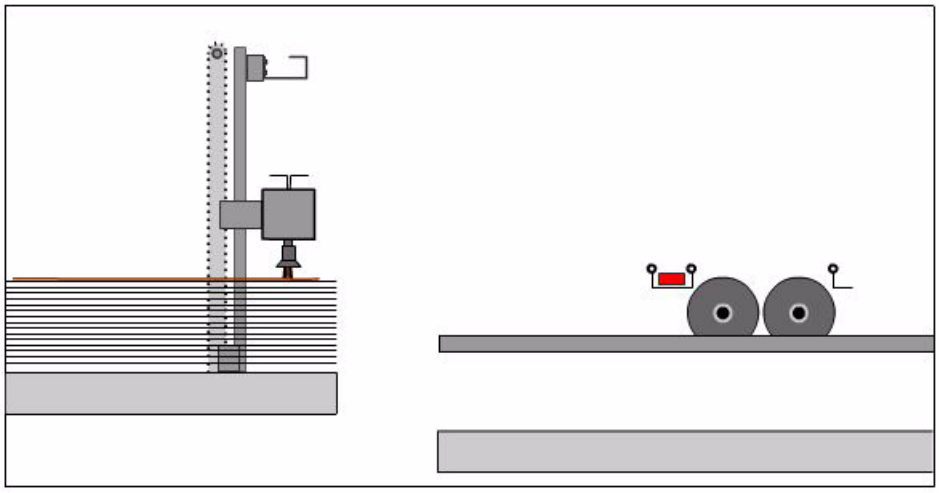
| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| | The XY bar is at the home position. | Init XY | HP |
| |  | | |

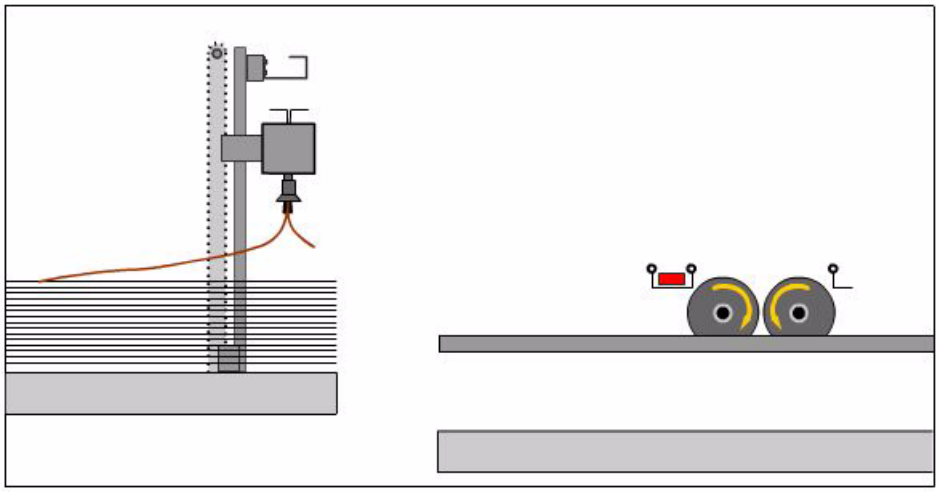
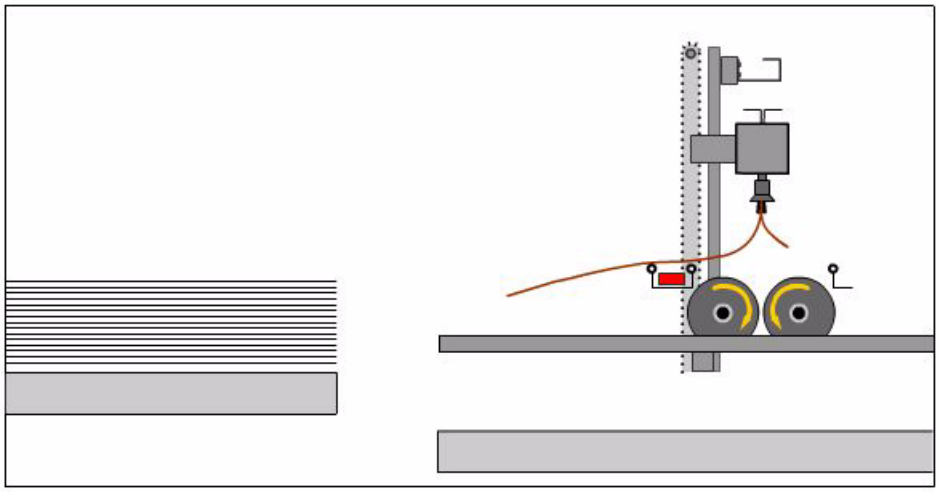
| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| 1-y<br>↑ | A slip sheet is detected by the paper/metal optic detector. | Loading System > Loading System Setup<br>**Y To Read Paper Metal Det [mm] Rel** | <br>-10 |
| |  | | |
| | Turn on the XY vacuum suction and FUFU. | Load Plate > Paper Disposal Stage ><br>**Operate Vacuum During Paper Disposal**<br>**Time to Sleep After Switch On FUFU [mSec]** | <br>1<br>500 |
| 2-x<br>→ | The XY bar moves to slip-sheet-picking position. | Load Plate > Paper Disposal Stage ><br>**X Paper Position In Cassette For Cst 1 (mm)**<br>**X Paper Position In Cassette For Cst 2 (mm)**<br>**X Paper Position In Cassette For Cst 3 (mm)** | <br>322<br>175<br>32 |
| |  | | |
| 3-y<br>↓ | The XY bar descends to the bar flag and the vacuum suction catches the paper. | Load Plate > Paper Disposal Stage ><br>**Time to Sleep Before Catch Paper With Vacuum [mSec]** | <br>1000 |

| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| 4-y<br>↑ | The XY bar rises withthe paper attached to the suction cups. | Load Plate > Paper Disposal Stage ><br>**Y Up With Vacuum To Catch Paper (mm) Rel** | –25 |
| 5-x<br>← | The XY bar moves backward.<br>Turn off the XY vacuum suction and FUFU. | Load Plate > Paper Disposal Stage ><br>**X Paper In Catch With Vacuum(mm)Rel** | –3 |
| 6-y<br>↑ | The XY bar rises and the tweezers open. | Load Plate > Paper Disposal Stage ><br>**Y Up for Init Catcher (mm) Rel** | –25 |

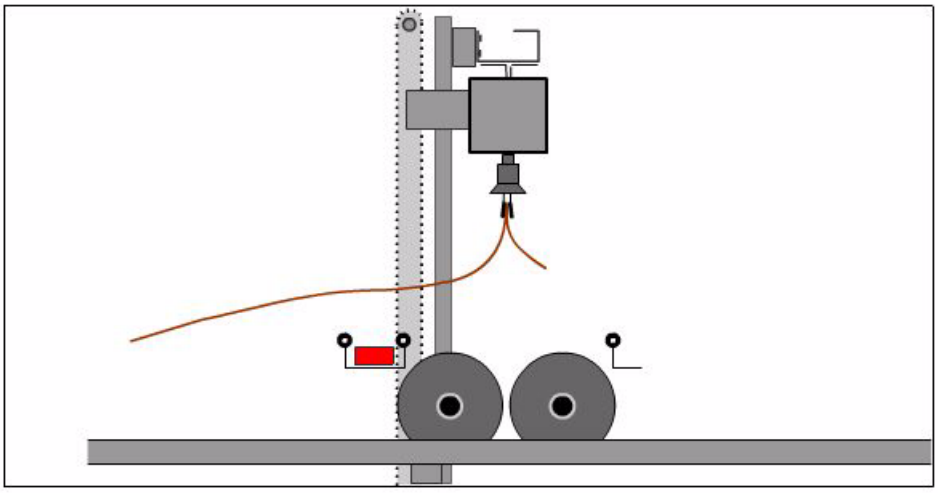


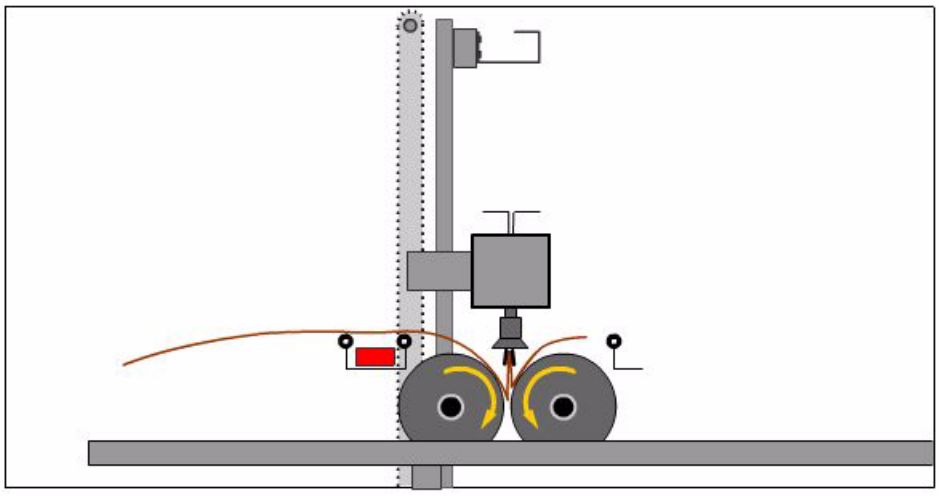
| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| 7-y<br>↓ | The XY bar descends to the bar flag, and the tweezers touch the slip sheet. | Loading System > Loading System Setup ><br>**Y Extra to Bar Flag Det For 0.15 (mm) Rel**<br>**Y Extra to Bar Flag Det For 0.3–0.2 (mm) Rel**<br><br>Load Plate > Paper Disposal Stage ><br>**Y to Bar Flag Det. Speed for paper** | <br>7<br>10<br><br><br>5 |
| |  | | |
| 8-y<br>↓ | The tweezers attach to the slip sheet and start closing. | Load Plate > Paper Disposal Stage ><br>**Y Extra to catch paper (mm) Rel** | <br>4 |
| |  | | |

| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| 9-y ↑ | The XY bar rises, enabling the tweezers to close and catch the slip sheet. | Load Plate >Paper Disposal Stage > **Y Up After Extra To Catch Paper (mm) Rel** | 5 |
| |  | | |
| 10-y ↓ | The tweezers close while catching the slip sheet. | Load Plate > Paper Disposal Stage > **Y Extra to catch paper (mm) Rel** | 4 |
| |  | | |

| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| 11-y<br>↑ | The paper disposal rollers start revolving, and the XY bar lifts the slip sheet. | | |
| |  | | |
| 12-x<br>→ | The XY bar transports the slip sheet above and between the disposal rollers in three stages. | Load Plate > Paper Disposal Stage ><br>**X Prepare To Paper in disposal (mm)**<br>**X Paper in disposal (mm)**<br>**X Paper disposal Final(mm)** | <br>600<br>620<br>660 |
| |  | | |

| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| 13-y<br>↑ | The XY bar rises and the tweezers slightly descend, enabling the slip sheet to enter smoothly between the paper disposal rollers.<br>The suction cups remain stationary above the disposal rollers (and do not interfere with the entry of the slip sheet between the rollers). | Load Plate > Paper Disposal Stage ><br>**Y Up Before Down To Paper Disposal (mm)** | 0 |



| Step | Description | Parameter | Value (mm) |
|---|---|---|---|
| 14-y<br>↓ | The XY bar descends with the slip sheet until the slip sheet is caught between the rollers and transferred to the paper bin.<br><br>**Note:** If the paper-plate disposal detector is covered, the error message `Plate not loaded, paper was not disposed` appears. Remove the slip sheet from the top of the rollers.<br><br><br><br>After this step, the process starts again from *Cassette Entry to Punch Entry (a)*. | Load Plate > Paper Disposal Stage ><br>**Y Prepare To Paper Disposal(mm)**<br>**Y Down To Paper Disposal(mm)** | <br>88<br>108 |

# Technical Contact(s)

Content owner: David Nacash

See the Escalation page for escalation contacts.

# Date Submitted

02 Aug 2006

# Last Updated

05 Jun 2007