Kodak

Multi-Cassette Unit II for Magnus 400 II and Magnus 400 II Quantum

Platesetters

Version 1.05.394

Plate Loading Sequence and Parameters Guide

English

731-01239A-EN Rev A

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Revised February 2008

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Overview

This guide describes the Kodak® Magnus™ 400 Controller software version 1.05.394 multi-cassette unit II (MCU II) plate-loading sequence and parameters for the Magnus 400 II (with LDA) and Magnus 400 II Quantum platesetters, which are also applicable to the Magnus 400 family platesetters.

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. It begins with the paper disposal task and continues with the three loading sequence stages. If required, during the loading sequence you can also remake a plate using the plate bypass option.

- **Paper disposal task:** Before stage A (cassette entry to punch entry) starts, the loading system removes the slip sheet from the cassette and transports it to the disposal system.

  Note: The paper disposal task is performed when the slip sheet is at the top of the cassette and before the plate is loaded.

- **Stage A: Cassette entry to punch entry**—the XY bar transports the plate from the cassette into the punch entry.
- **Stage B: Punch entry to drum entry**—the XY bar inserts the plate into the punch and, after punching, removes the plate from the punch, and then after the plate is punched, the XY bar removes the plate from the punch and transports it to the drum entry.
- **Stage C: Drum entry to drum**—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.

Plate Bypass Option

During the loading sequence, when a plate remake is required, it can be performed automatically (using the MCU II) or manually, as follows:

- ❒ **Automatically**: Stages A, B, and C.
- ❒ **Manually**: Stages B and C.

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

Notes:

- The values shown are the default values.
- 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

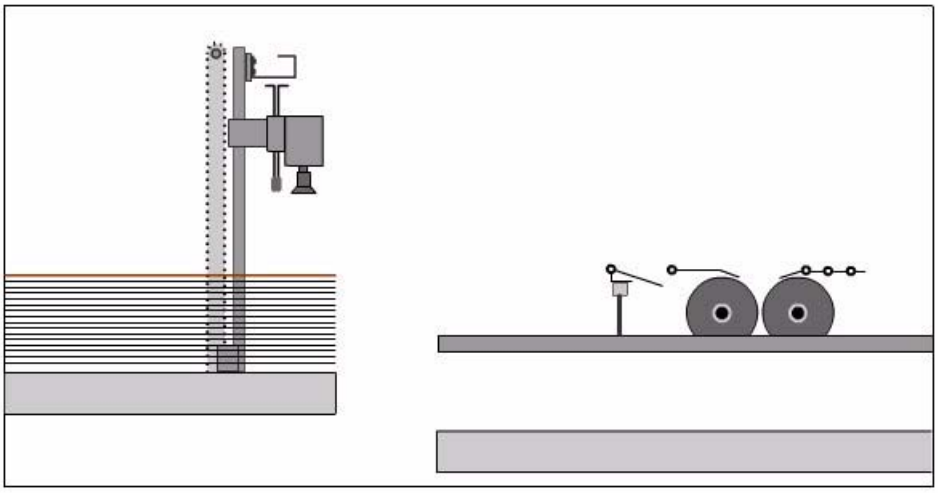
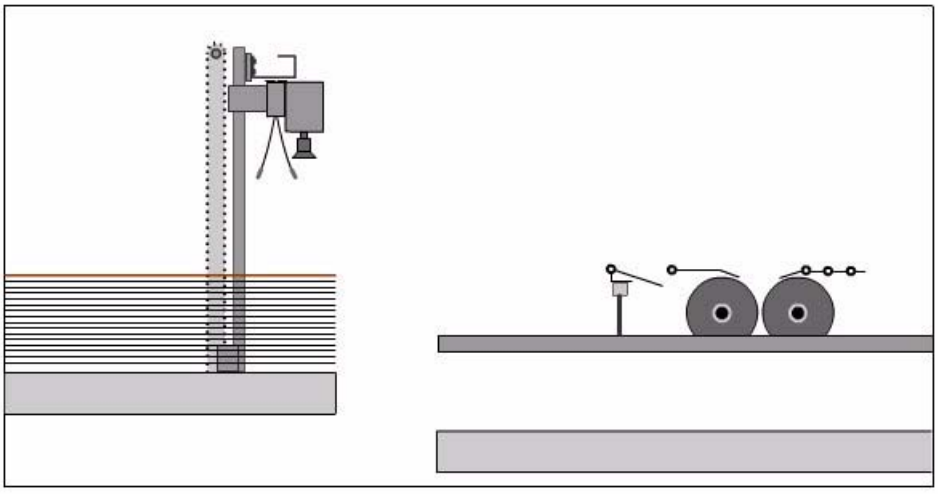
↓ = vertical downward movement

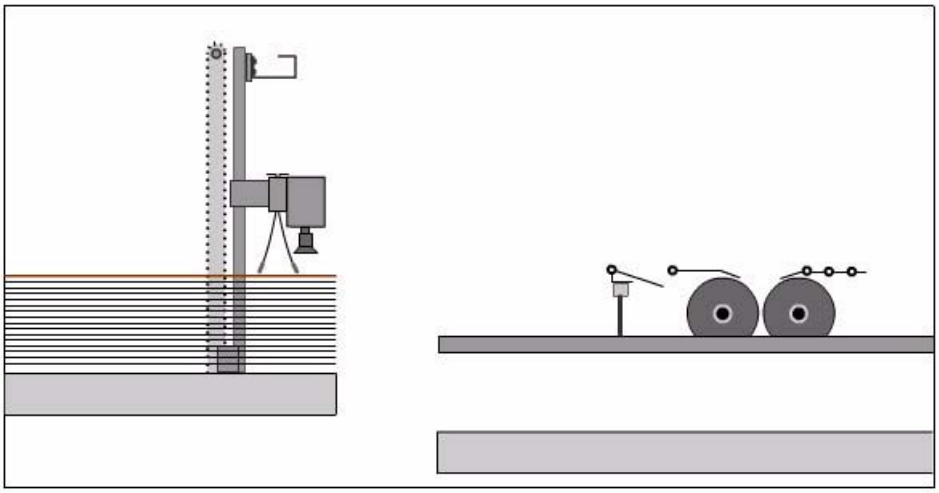
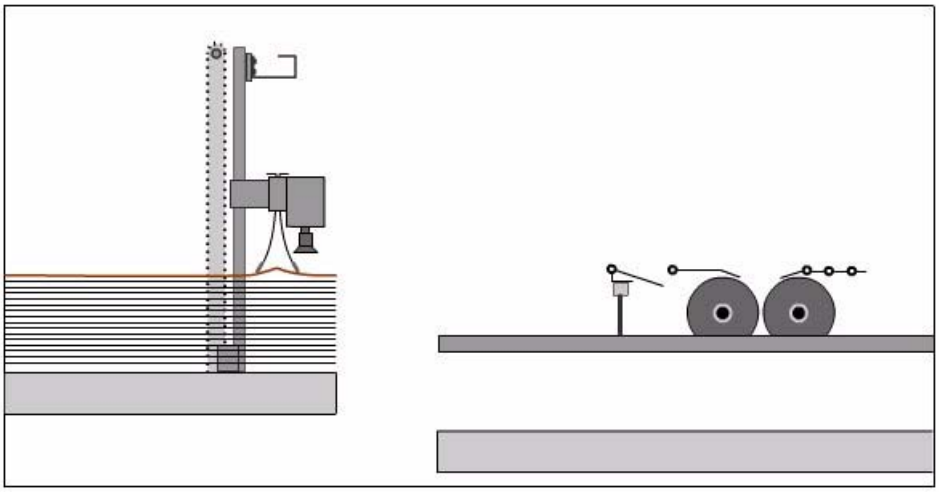
↑ = vertical upward movement

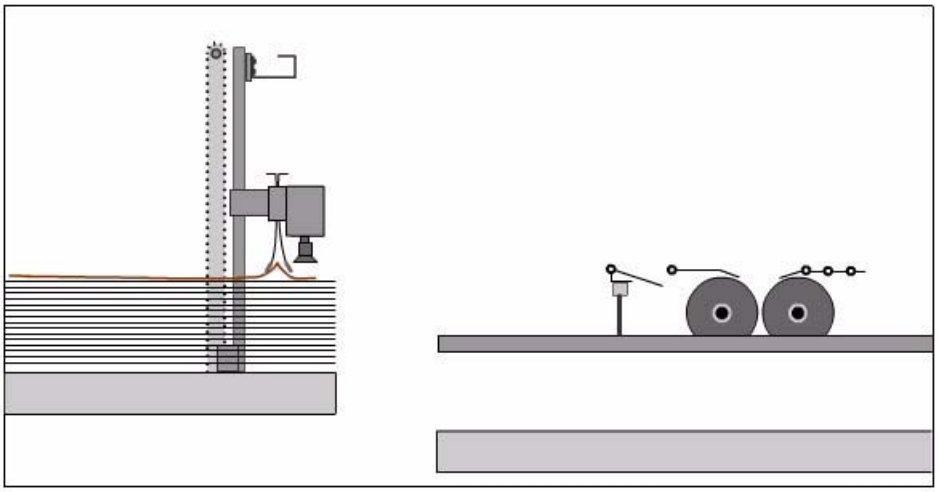
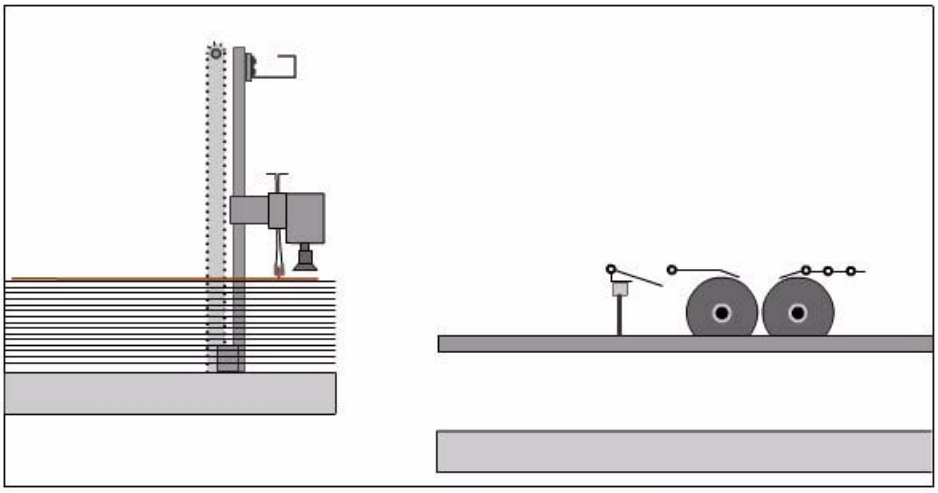
Paper Disposal Task

Table 1 describes the relevant actions that occur during the paper disposal task. During this task, the XY bar transports the slip sheet from the cassette to the disposal system. This stage occurs before loading a plate or when a slip sheet is detected in the cassette.

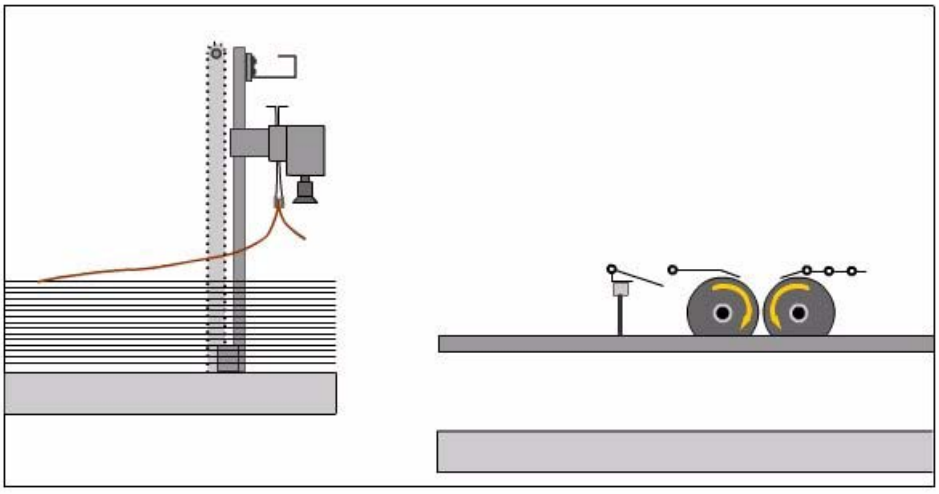
Table 1: Paper disposal

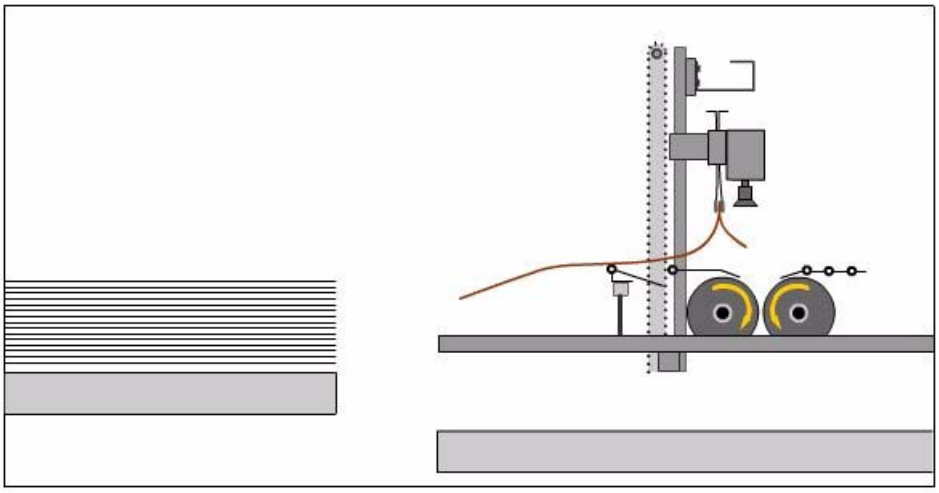
Step	Description	Parameter	Value (mm)
1-x →	The XY bar moves to slip-sheet-picking position.	Load Plate > Paper Disposal Stage > **X Paper Position In Cassette For Cst 1 (mm)** **X Paper Position In Cassette For Cst 2 (mm)** **X Paper Position In Cassette For Cst 3 (mm)**	 322 175 32
			
2-y ↑	The XY bar rises and the tweezers open.	Load Plate > Paper Disposal Stage > **Y Up for Init Catcher (mm) Rel**	 –25
			

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

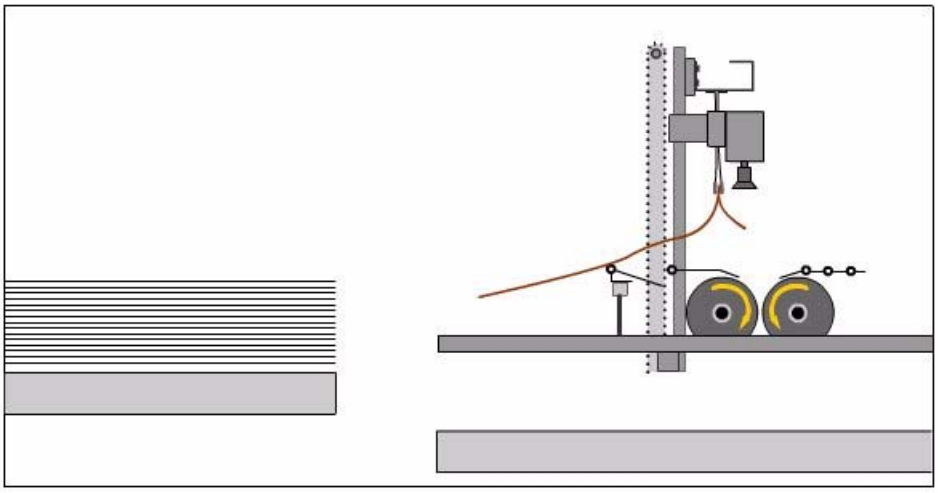
Step	Description	Parameter	Value (mm)
5-y ↑	The XY bar rises, enabling the tweezers to close and catch the slip sheet.	Load Plate >Paper Disposal Stage > **Y Up After Extra To Catch Paper (mm) Rel**	5
			
6-y ↓	The tweezers close while catching the slip sheet.	Load Plate > Paper Disposal Stage > **Y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

Step	Description	Parameter	Value (mm)
7-y ↑	The paper disposal rollers start revolving, and the XY bar lifts the slip sheet.		
8-x →	The XY bar transports the slip sheet above the disposal rollers.	Load Plate > Paper Disposal Stage > **X Paper in disposal (mm)**	625

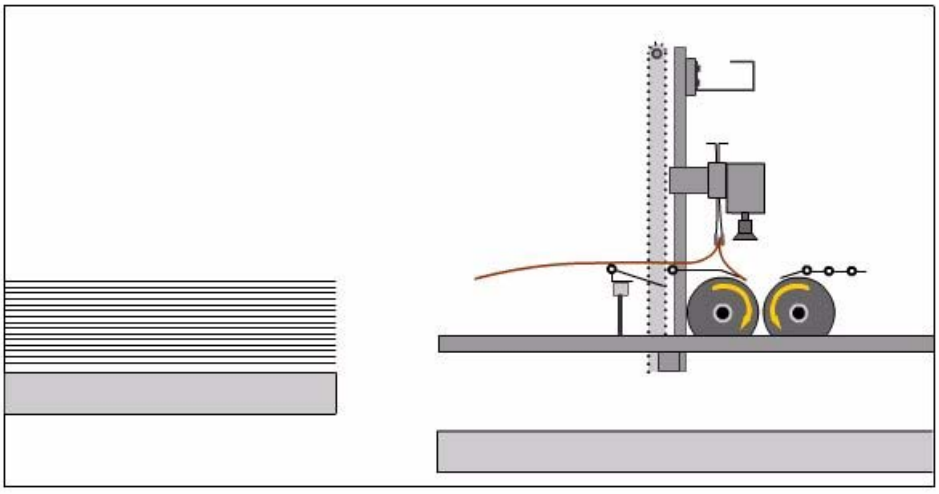


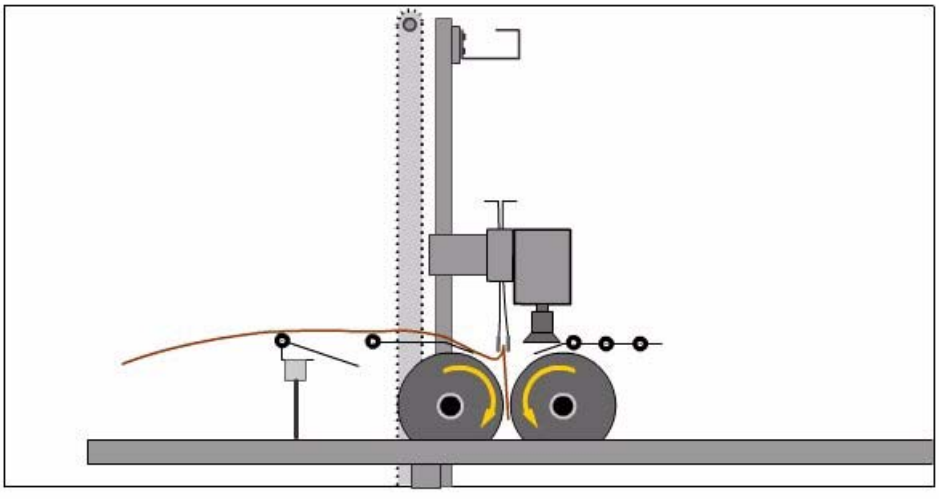


Step	Description	Parameter	Value (mm)
9-y ↑	The XY bar rises and the tweezers slightly descend, enabling the slip sheet to enter smoothly between the paper disposal rollers. The suction cups remain stationary above the disposal rollers (and do not interfere with the entry of the slip sheet between the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



Step	Description	Parameter	Value (mm)
10-y ↓	The XY bar descends with the slip sheet and moves forward until the slip sheet is caught between the rollers and transferred to the paper bin. **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.	Load Plate > Paper Disposal Stage > **Y Prepare To Paper Disposal(mm)** **Y Down To Paper Disposal(mm)** **X Paper Disposal Final(mm)**	 82 102 660





After this step, the process starts again from *Stage A: Cassette Entry to Punch Entry*.

Stage A: Cassette Entry to Punch Entry

Table 2 on page 9 describes the relevant actions that occur during the cassette entry to punch entry stage.

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

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

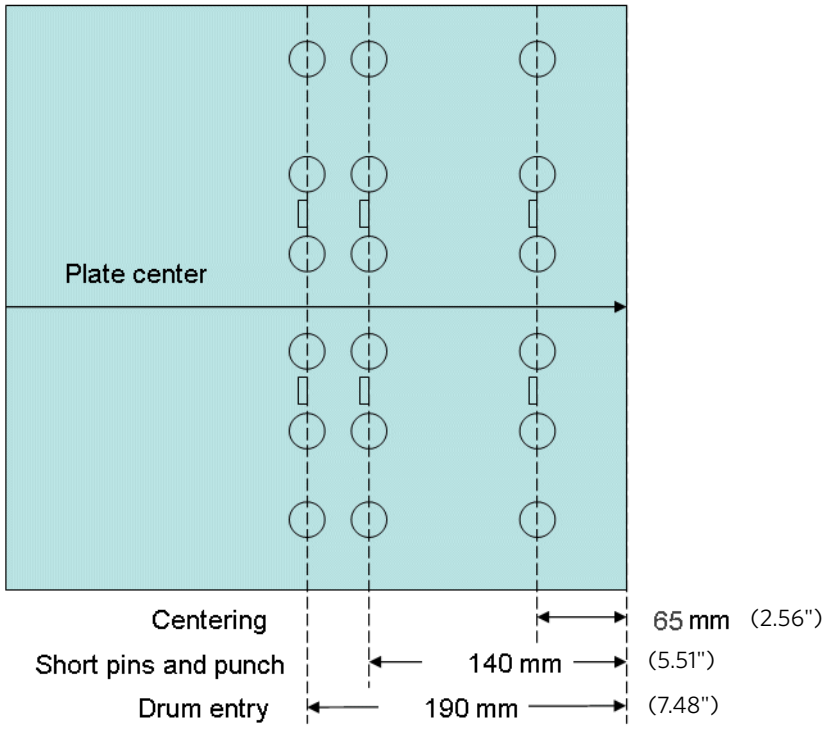
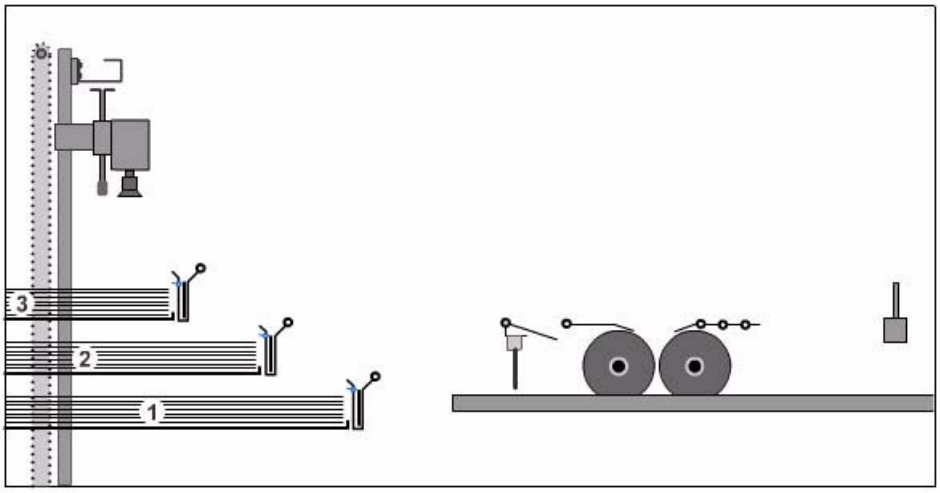
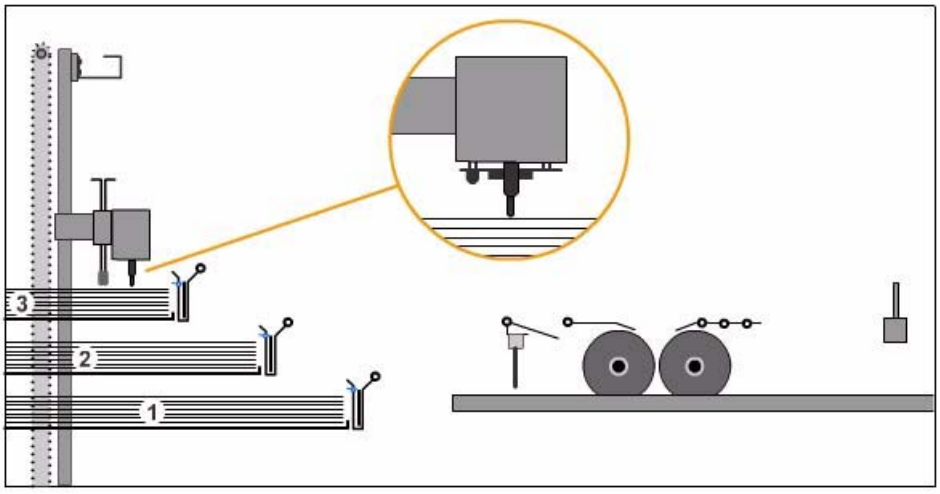


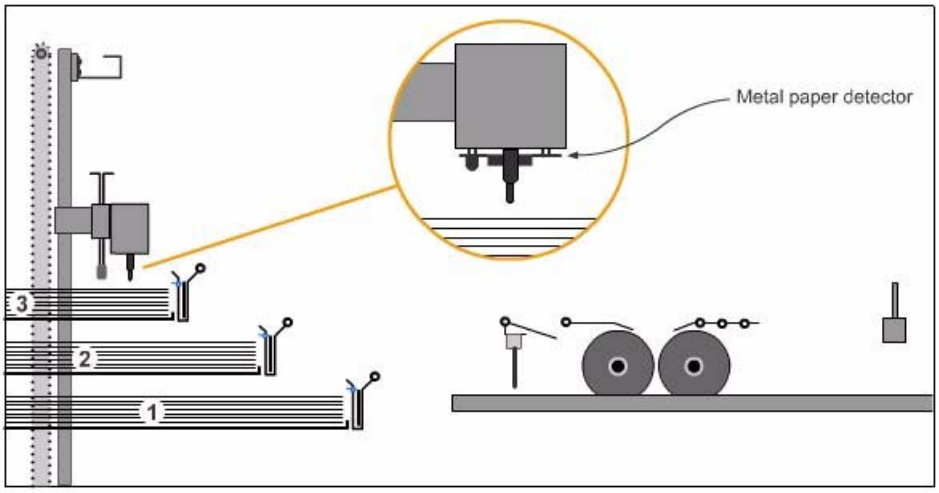
Figure 1: Plate-picking positions

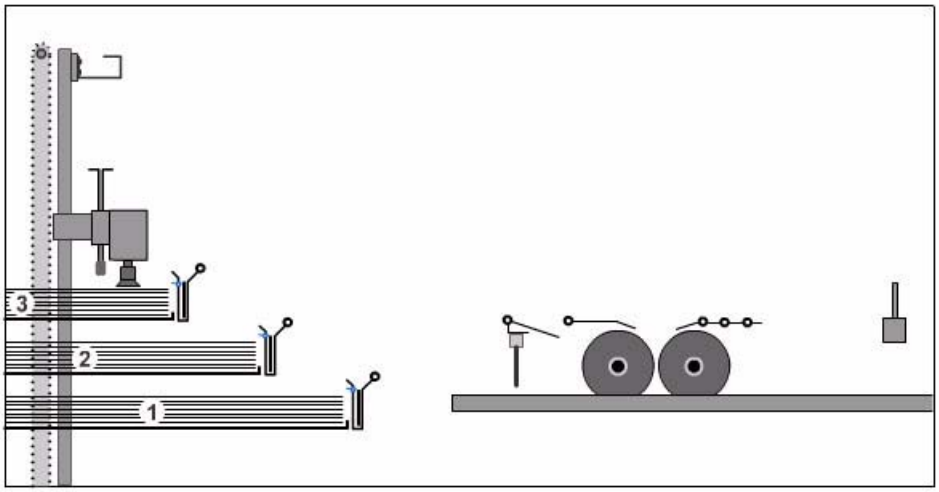
Note: During the cassette entry to punch entry stage, the operator must visually verify that the plate is centered correctly and that the XY bar movement and plate-picking positions are synchronized.

Table 2: Cassette entry to punch entry

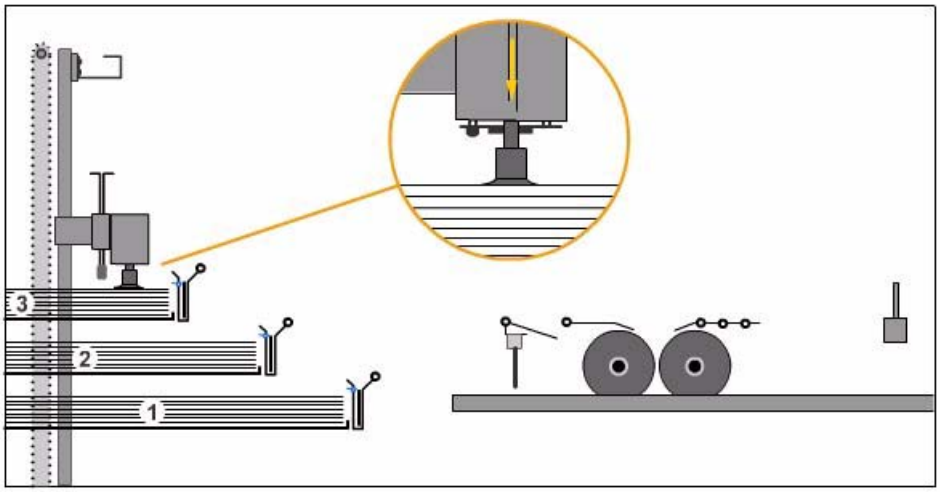
Step	Description	Parameter	Value (mm)
A1-x →	**Cassette to centering sequence** The XY bar moves forward to the selected cassette.	Load Plate > From Cassette to Punch Entry Stage > **X Position in Cassette for Cst 1 (mm)** **X Position in Cassette for Cst 2 (mm)** **X Position in Cassette For Cst 3 (mm)**	 315 175 30
			
A2-y ↓	The XY bar descends to the bar flag detector.	Load Plate > From Cassette to Punch Entry Stage > **Y to bar flag det. Speed in Cassette**	 15
			

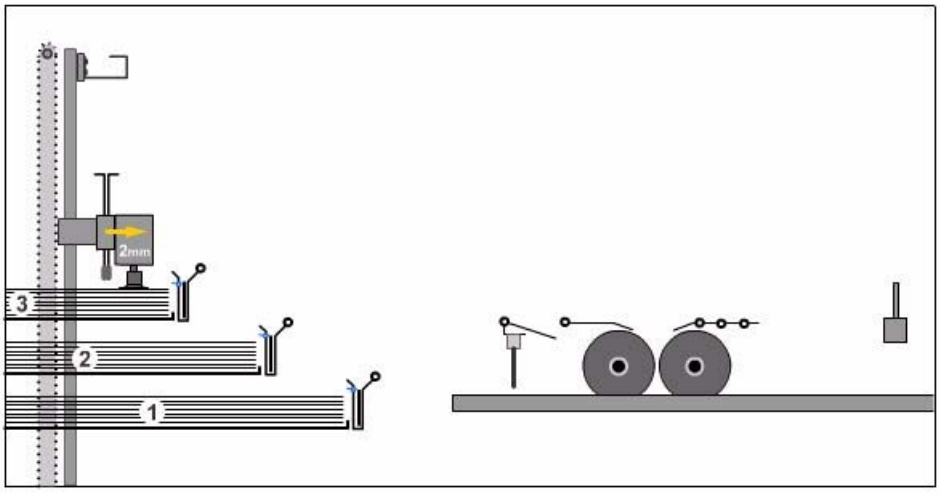
Step	Description	Parameter	Value (mm)
A3-y ↑	The paper/metal optic detector identifies a plate or slip sheet in the cassette. **Note:** If a slip sheet is detected, the Paper Disposal stage is initiated. See *Paper Disposal Task* on page 2.	Loading System > Loading System Setup > **Y To Read Paper Metal Det (mm) Rel**	–15
A4-y ↓	The vacuum activates. The suction cups activate. The XY bar descends to the bar flag.	Load Plate > From Cassette to Punch Entry Stage > **Y to bar flag det. Speed in Cassette**	15

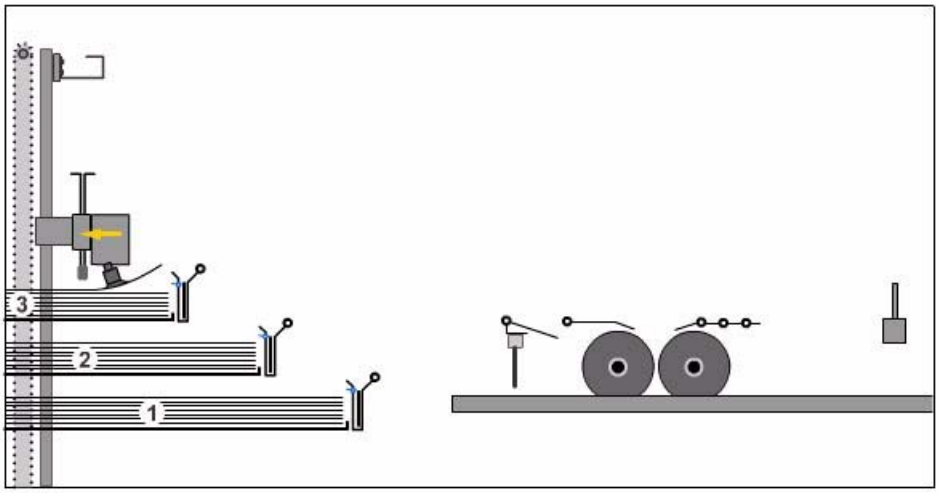
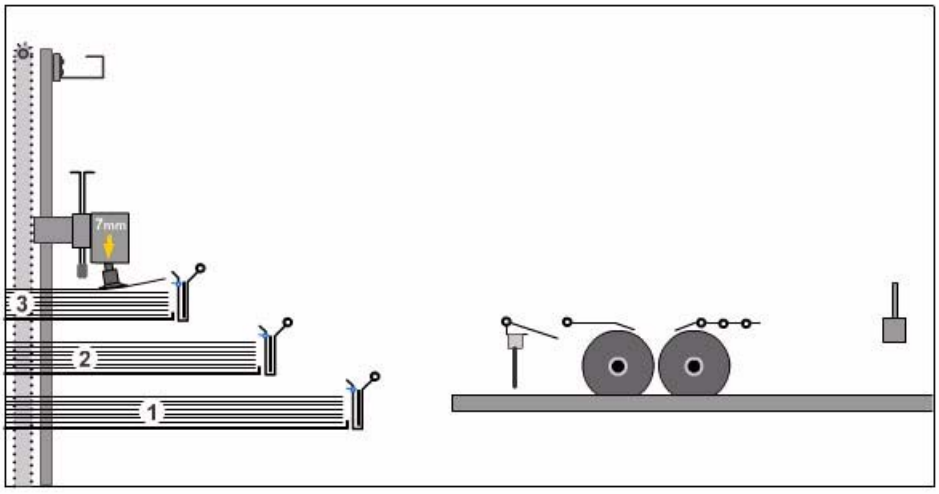




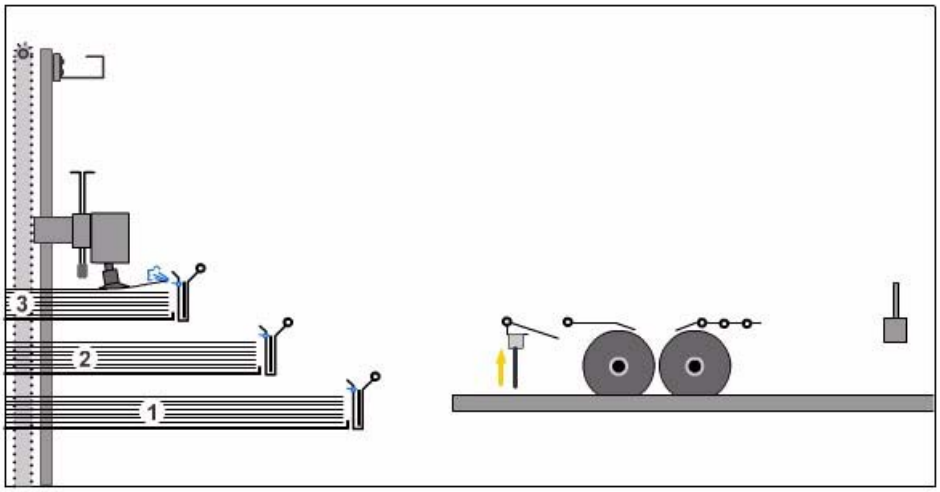
Step	Description	Parameter	Value (mm)
A5-y ↓	The Y-axis is at the Extra to bar flag position. At cassette to center position (65 mm from the edge of the plate), all suction cups touch and securely hold the plate.	Loading System > Loading System Setup > **Y Extra to Bar Flag Det For 0.15 (mm) Rel** **Y Extra to Bar Flag Det For 0.3–0.2 (mm) Rel** **Y Extra to Bar Flag Det Speed** **Sleep After Extra to Bar Flag Det [mSec]**	 7 10 5 mm/sec 500 msec
A6-x →	**Separation of plate from slip sheet sequence** 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 > **X Plate Forward In Cassette for 0.15 (mm) Rel** **X Plate Forward In Cassette for 0.2 (mm) Rel** **X Plate Forward In Cassette for 0.3 (mm) Rel**	 1 2 2

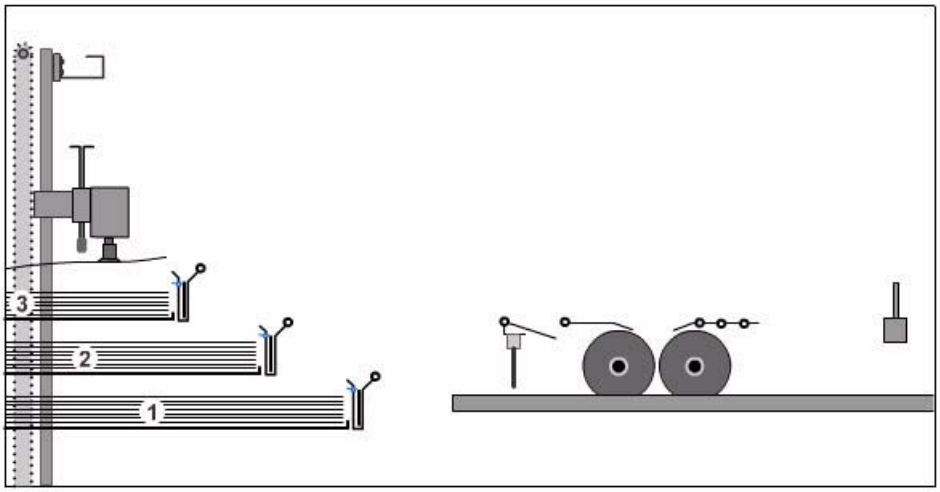


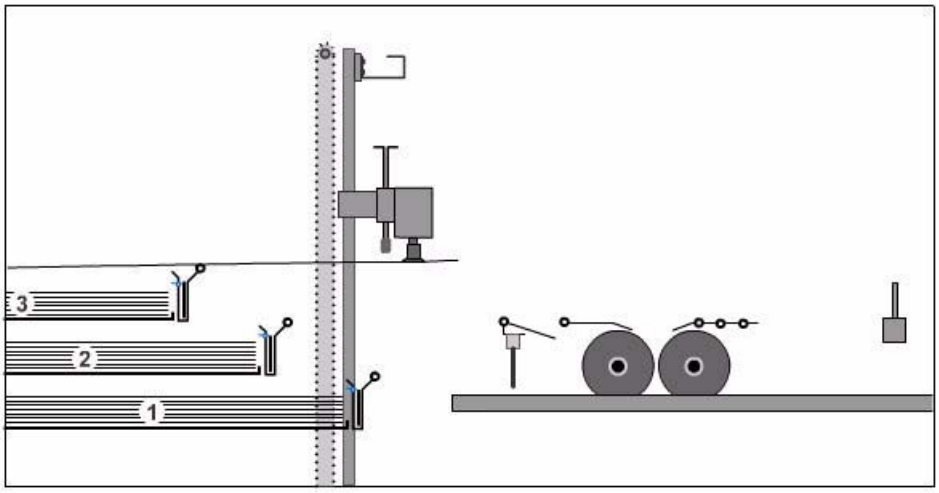
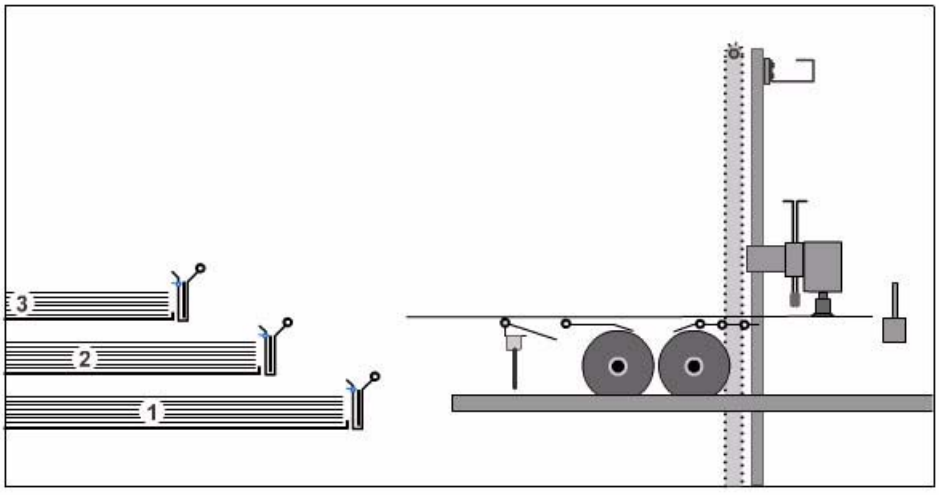


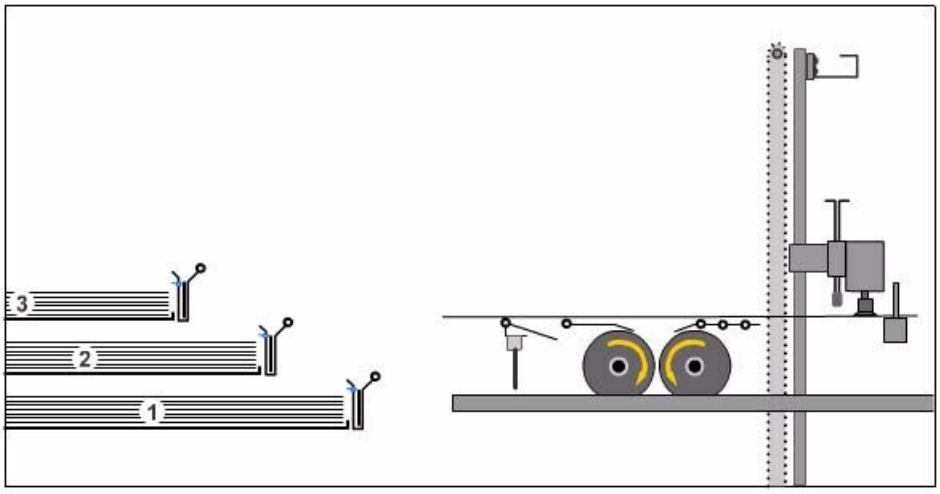
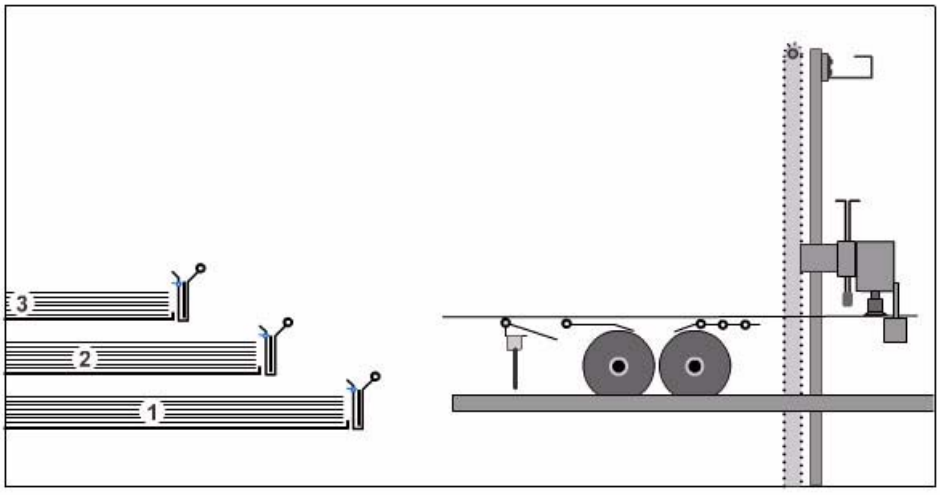
Step	Description	Parameter	Value (mm)
A7-y ↑	These two back-and-forth (default) movements along the X and Y axes repeat several times to help plate and slip sheet separation, and prevent double-loading.	Load Plate > From Cassette to Punch Entry Stage >	
		Y Plate Up in Cassette_3 (mm)	20
		Y Plate Up in Cassette_2 (mm)	85
		Y Plate Up in Cassette_1 (mm)	150
		Y Plate High Up in Cassette (for all thicknesses)	0
		Number of Plate BackWard Separations	4
A8-x ←	The plate bends to separate the slip sheet.	Load Plate > From Cassette to Punch Entry Stage >	
		X Backward For 0.15 plate [mm] Rel	16
		X Backward For 0.2 plate [mm] Rel	16
		X Backward For 0.3 plate [mm] Rel	16
			
A9-y ↓	The status bar flag detects whether the plate is still attached.	Load Plate > From Cassette to Punch Entry Stage >	
		Y After Plate Separation [mm] Rel	3
			

Step	Description	Parameter	Value (mm)
A10-y ↓	The fufu activates to blow the slip sheet downward. The centering pins activate and move (±5 mm) to accommodate the plate. The ramp rises according to the plate size. The bar flag detects whether the plate is still attached.	Load Plate > From Cassette to Punch Entry Stage > **Y Above Air Nozzle In Tray 1(mm)** **Y Above Air Nozzle In Tray 2(mm)** **Y Above Air Nozzle In Tray 3(mm)** **Centering Wait Dis (mm) Rel**	 181 110 37 10
A11-y ↑	The plate rises so that it can be removed from the cassette.	Load Plate > From Cassette to Punch Entry Stage > **Y Prepare to Take Out Plate From Cst 1(mm)** **Y Prepare to Take Out Plate From Cst 2(mm)** **Y Prepare to Take Out Plate From Cst 3(mm)**	 160 70 25

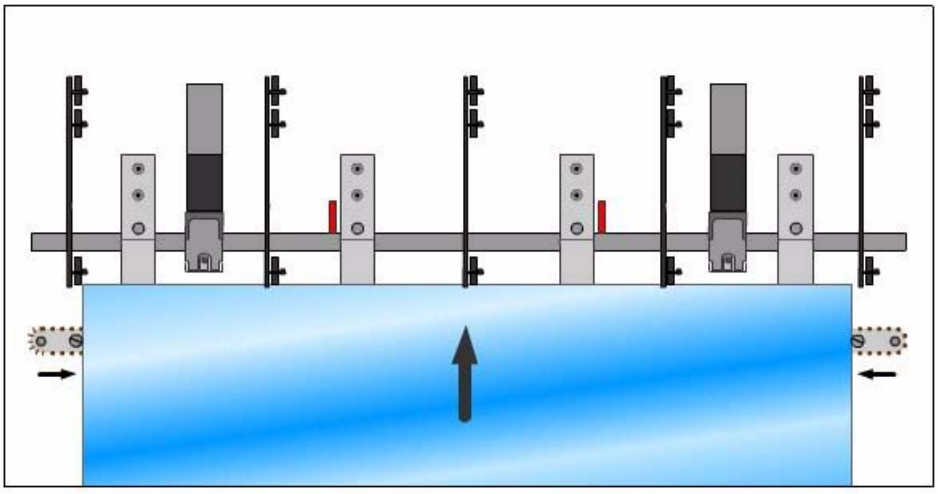


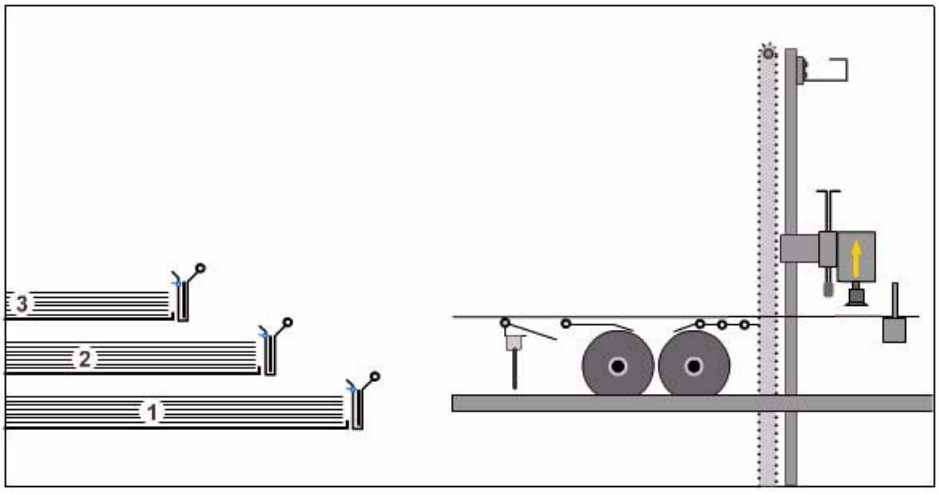


Step	Description	Parameter	Value (mm)
A12-x →	The plate advances forward and air blows inside the cassette until the X-axis reaches this position.	Load Plate > From Cassette to Punch Entry Stage > **X to Fufu Off Cassette 1 (Rel)** **X to Fufu Off Cassette 3 (Rel)**	 110 200
			
A13-y ↑	Depending on 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 > **Y Ramp Position mm**	 90
			

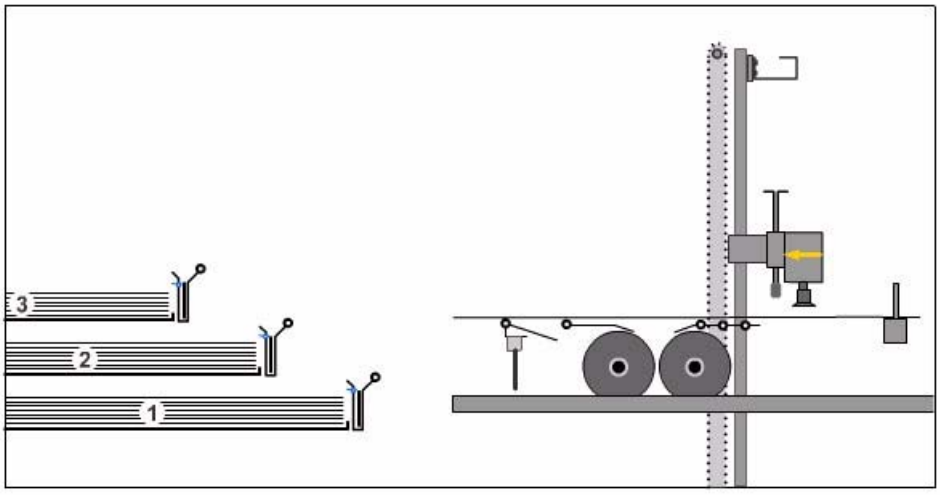
Step	Description	Parameter	Value (mm)
A14-x →	The XY bar transports the plate to centering. The paper disposal rollers activate to remove any remaining slip sheets.	Load Plate > From Cassette to Punch Entry Stage > **X for Centering (mm)** **X for Centering Speed**	 820 40
			
A15-y ↓	The Y-axis descends for centering and releases the plate.	Load Plate > From Cassette to Punch Entry Stage > **Y for Centering (mm)**	 89
			

Step	Description	Parameter	Value (mm)
A16-x →	The XY bar transports the plate to the final centering position. The plate size is measured and compared to the media definition of the selected cassette. The paper disposal deactivates.	Load Plate > From Cassette to Punch Entry Stage > **X for Centering Final (mm)** **X for Centering Speed** **Measure Centering Tolerance (mm)**	 833 40 3
A17-y ↑	The XY bar rises and releases the plate.	Load Plate > From Cassette to Punch Entry Stage > **Y Up For Centering (mm) Rel**	 –15





Step	Description	Parameter	Value (mm)
A18-x ←	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 8.	Load Plate > From Cassette to Punch Entry Stage > **X Pick Up Plate Before In Punch (mm)**	750



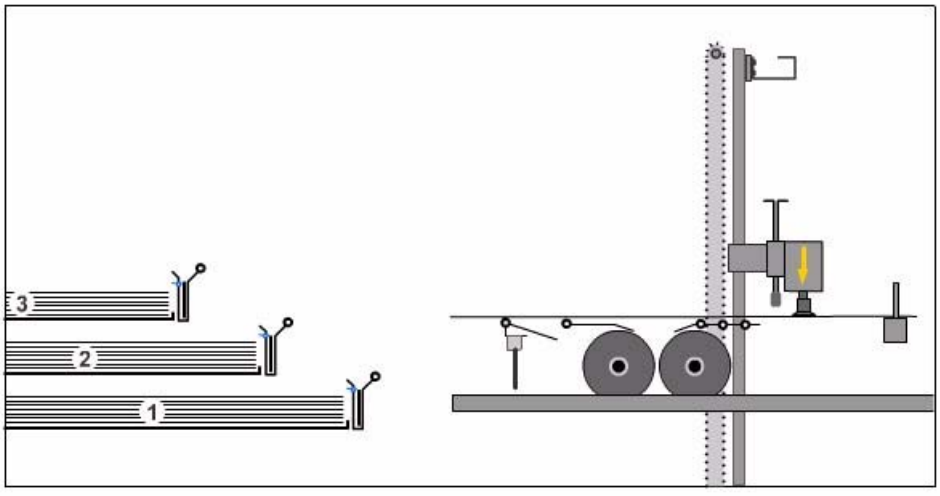
Note: If the plate-picking position is not aligned on the 140-mm line, adjust the **X for Centering Final (mm)** parameter.

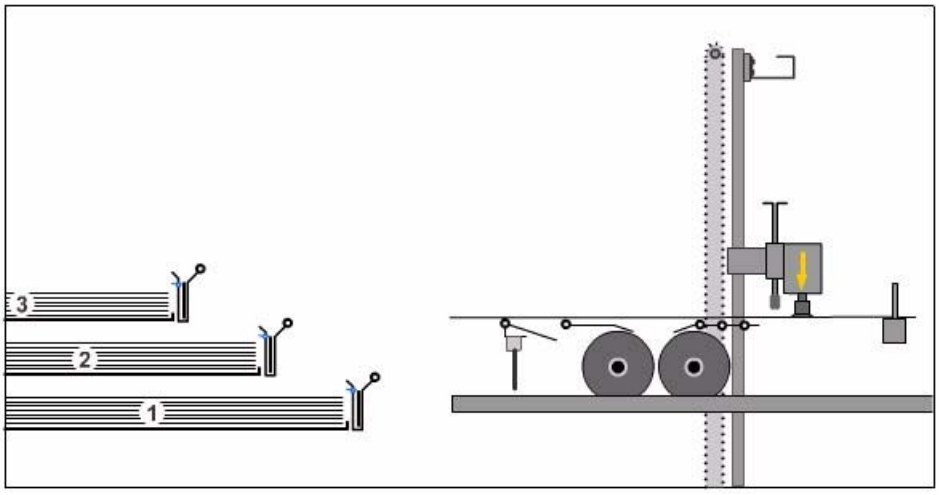
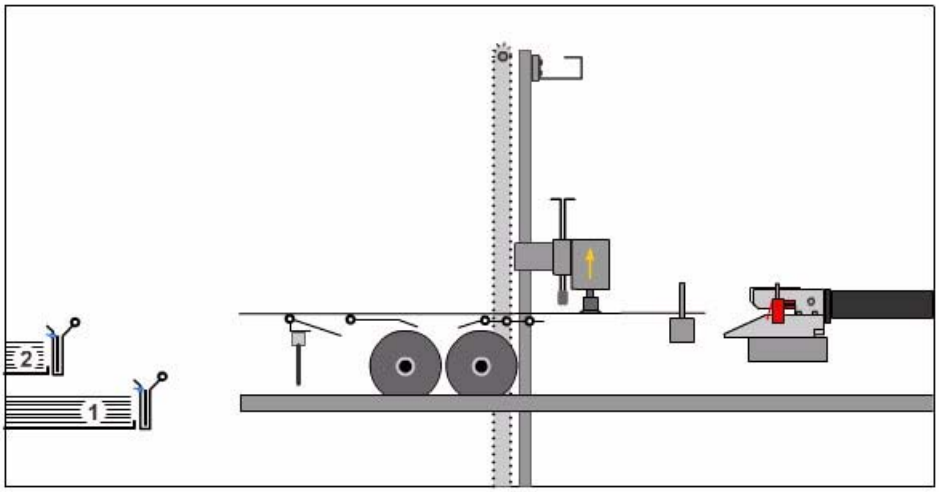
A19-y
↓

The suction cup vacuum activates.

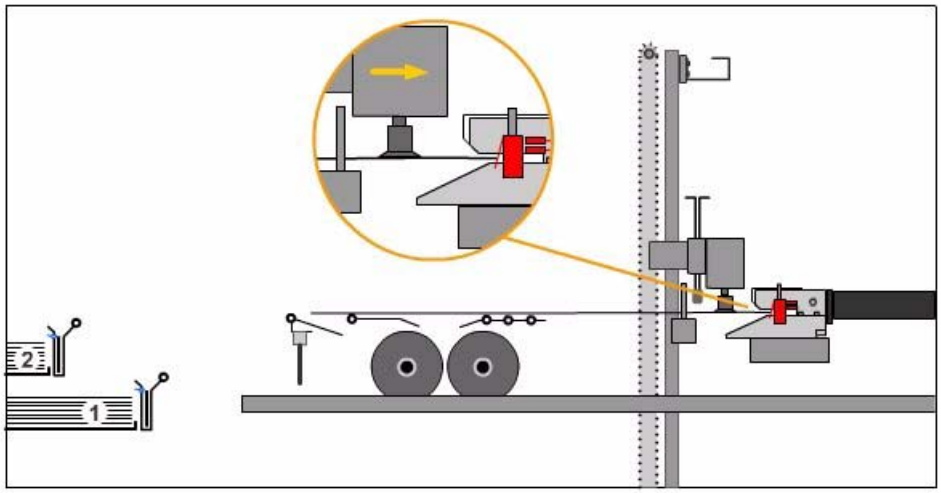
The plate is detected and reattaches to the suction cups (**Y to Detector**).

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** **Y Down After Centering to catch Plate For 0.3–0.2 (mm) Rel**	7 10
			
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 →	The XY bar transports the plate to the microswitches. Stage (a) finishes when the plate reaches **Pre Extra** position. **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 > **X Pre Extra To Short Pins For 0.15 (mm) Rel** **X Pre Extra To Short Pins For 0.2 (mm) Rel** **X Pre Extra To Short Pins For 0.3 (mm) Rel**	 48 48 48

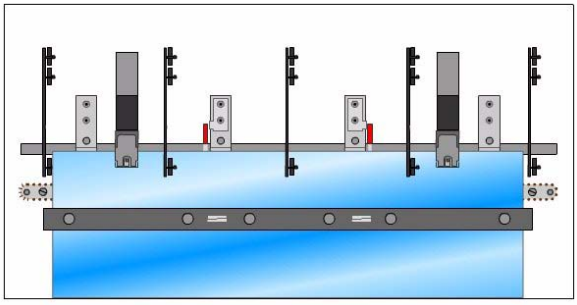


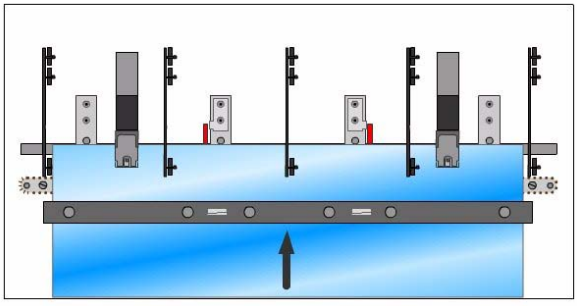
Stage B: Punch Entry to Drum Entry

Table 3 describes the relevant actions that occur during the punch entry to drum entry stage. During 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.

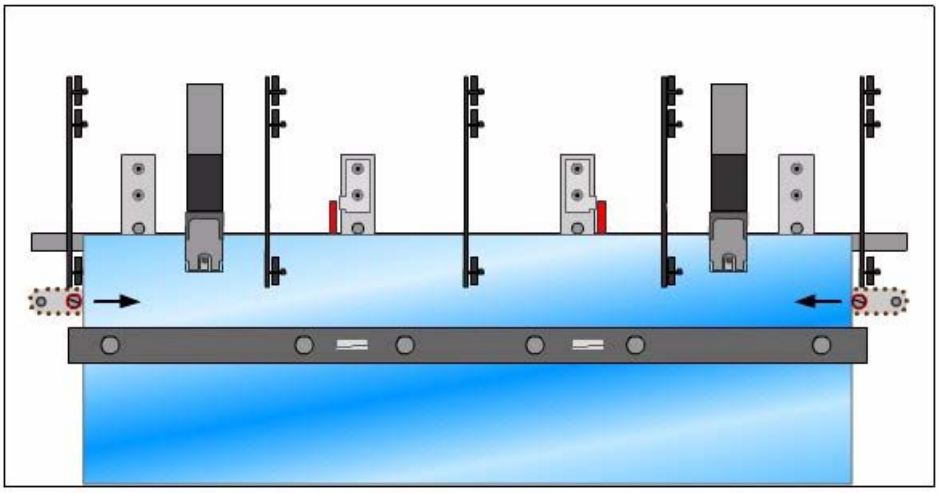
Table 3: Punch entry to drum entry

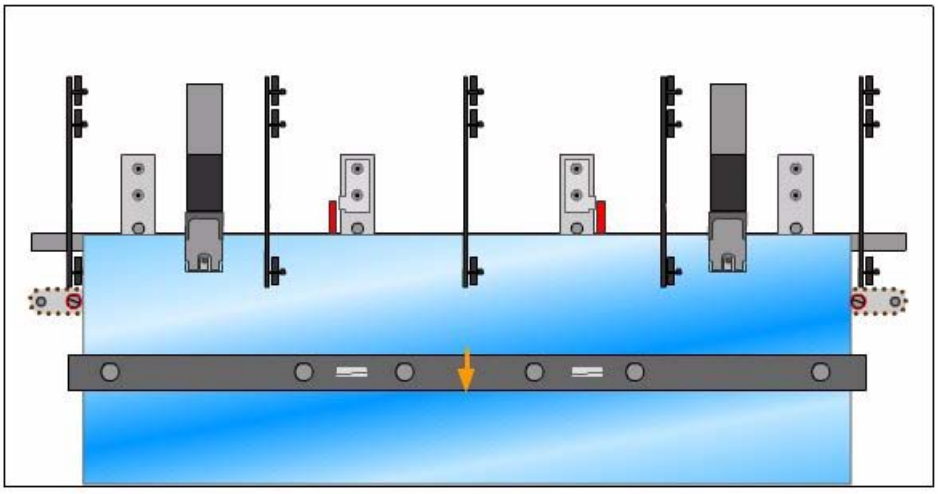
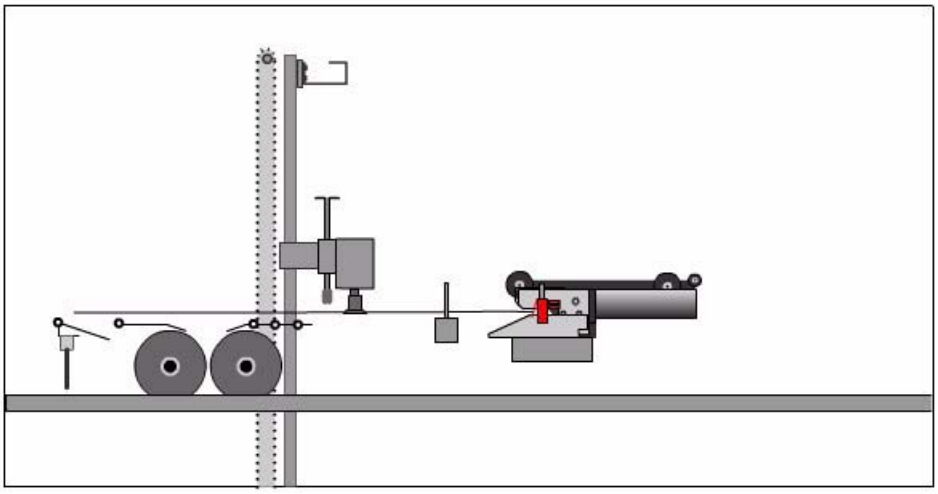
Step	Description	Parameter	Value (mm)
B1-x →	The leading edge of the plate presses against the microswitches. (This movement repeats up to six times.) When the microswitches detect the leading edge of the plate, the plate advances one more step (3 mm) toward the short pins. The XY bar transports the plate backward 6 mm to release the plate from the pressure of the microswitches.	Load Plate > From Punch Entry to Drum Entry Stage > **X Extra To Short Pins For 0.15 (mm) Rel** **X Extra To Short Pins For 0.2 (mm) Rel** **X Extra To Short Pins For 0.3 (mm) Rel**	 3 3 3



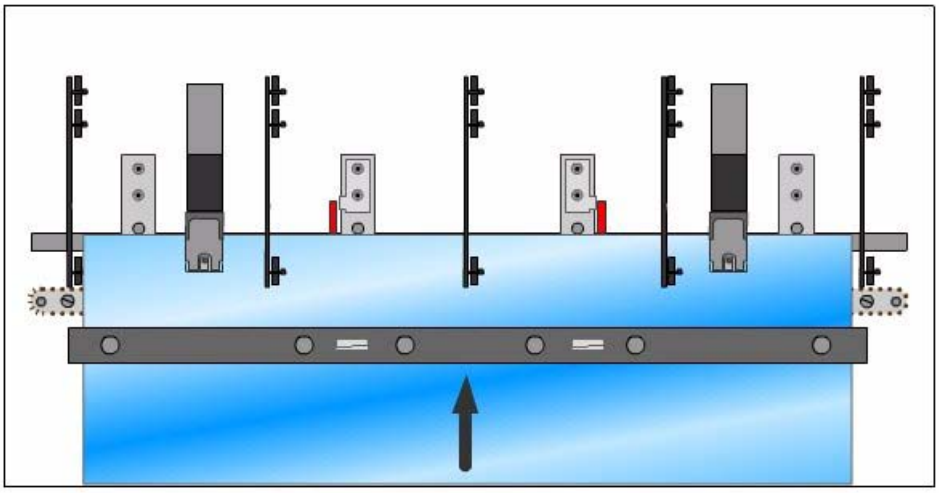


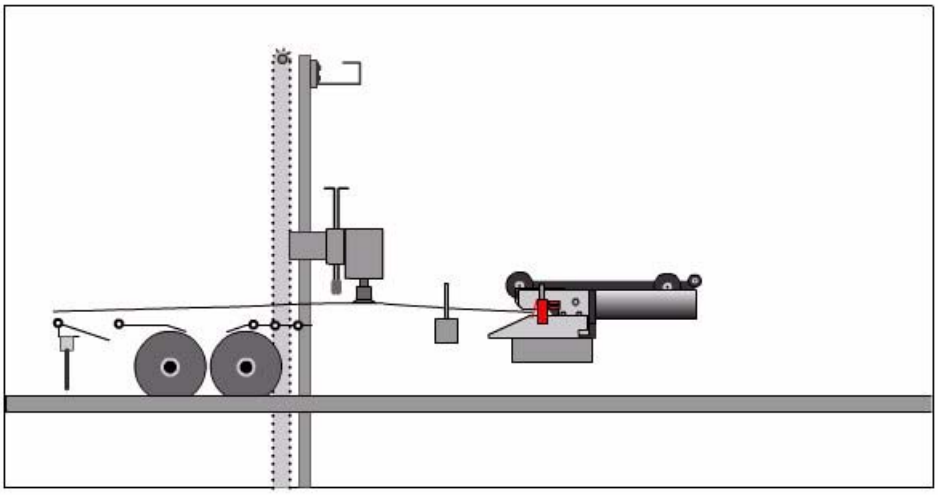
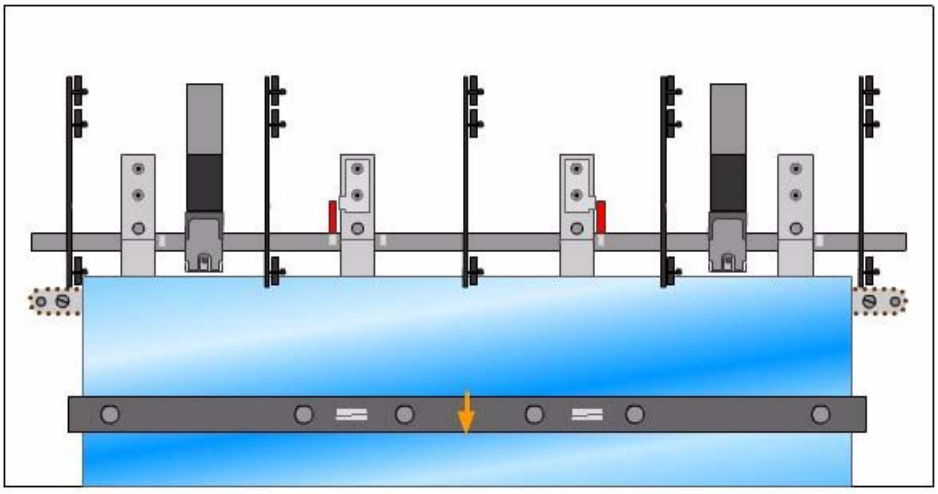
Step	Description	Parameter	Value (mm)
B2-y ↑	The centering pins center the plate according to the plate size, keeping it center-aligned until releasing it before punch entry. The XY bar rises and releases the plate.	Load Plate > From Punch Entry to Drum Entry Stage > **Y Up For Backward After Centering (mm) Rel**	–15

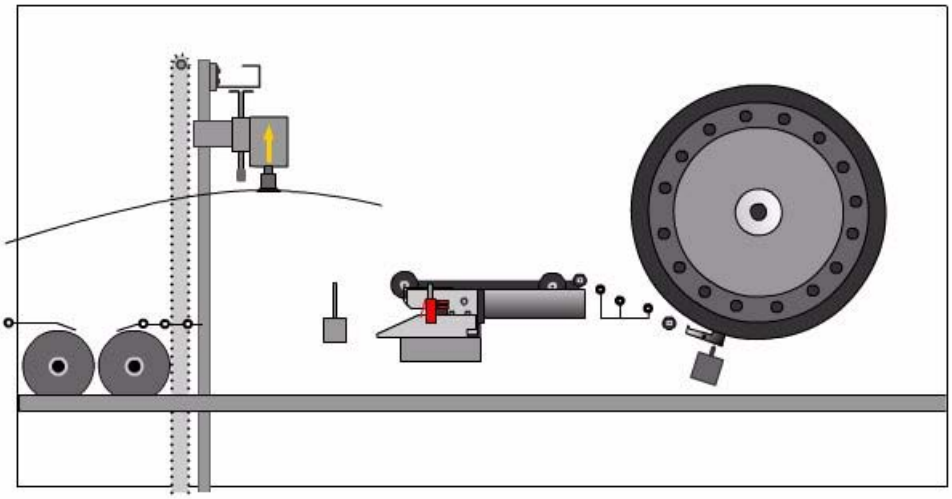
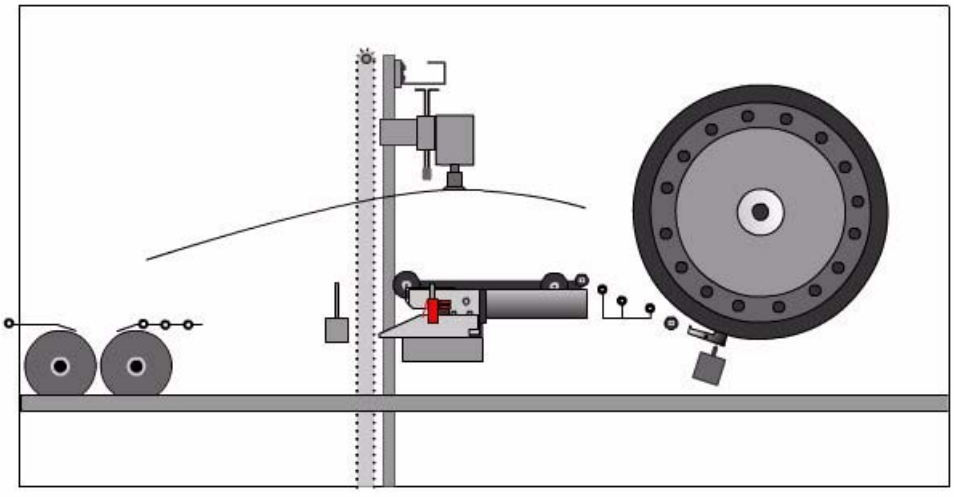


Step	Description	Parameter	Value (mm)
B3-x ←	The XY bar returns to pick up the plate. **Note:** After this stage, the X position is the sum of two parameters—**X Pick Up Plate Before In Drum (mm) + X Move X Upto Wheels (mm)**.	Load Plate > From Punch Entry to Drum Entry Stage > **X Pick Up Plate Before In Drum (mm)** **X Move X Upto Wheels For 0.15 (mm)** **X Move X Upto Wheels For 0.2 (mm)** **X Move X Upto Wheels For 0.3 (mm)**	 750 0 0 0
			
	Note: After this stage, the XY bar is above the 190-mm plate-picking position.		
B4-y ↓	The suction activates. The XY bar descends to the bar flag. The suction cups attach to the plate. The centering pins release the plate.	Load Plate > From Cassette to Punch Entry Stage > **Y Down After Centering to catch Plate For 0.15 (mm) Rel** **Y Down After Centering to catch Plate For 0.3-0.2 (mm) Rel**	 7 10
			

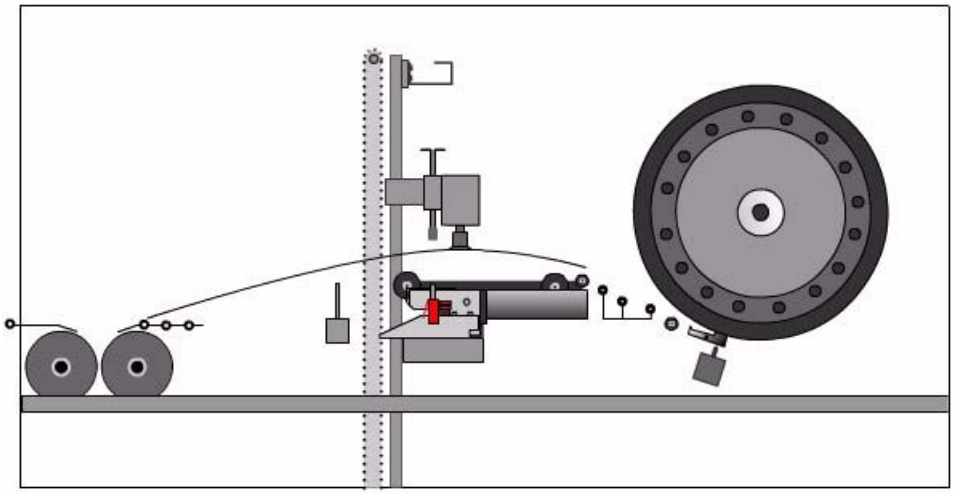
Step	Description	Parameter	Value (mm)
B5-x →	The leading edge of the plate presses against the microswitches. (This movement repeats up to six times.) When the microswitches detect the leading edge of the plate, the plate advances one more step (3 mm) toward the short pins. The punch activates while the plate is attached to the short pins. The XY bar transports the plate backward 6 mm to release the plate from the pressure of the microswitches.	Load Plate > From Punch Entry to Drum Entry Stage > **X Extra To Short Pins For 0.15 (mm) Rel** **X Extra To Short Pins For 0.2 (mm) Rel** **X Extra To Short Pins For 0.3 (mm) Rel**	 3 3 3



Step	Description	Parameter	Value (mm)
B6-y ↑	The XY bar lifts the plate and removes it from the punch.	Load Plate > From Punch Entry to Drum Entry Stage >	
		Y Up After DoPunch For 0.15	85
		Y Up After DoPunch For 0.2	85
		Y Up After DoPunch For 0.3	80
			
B7-x ←	The XY bar removes the plate from the punch.	Load Plate > From Punch Entry to Drum Entry Stage >	
		X After DoPunch For 0.15	705
		X After DoPunch For 0.2	705
		X After DoPunch For 0.3	705
			

Step	Description	Parameter	Value (mm)
B8-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**	 -4
			
B9-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)** **X Near To Drum For 0.2 Seq (mm)** **X Near To Drum For 0.3 Seq (mm)**	 900 900 900
			

Step	Description	Parameter	Value (mm)
B10-y ↓	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 > **Y In Drum For 0.15 (mm)** **Y In Drum For 0.2 (mm)** **Y In Drum For 0.3 (mm)**	 10 30 30

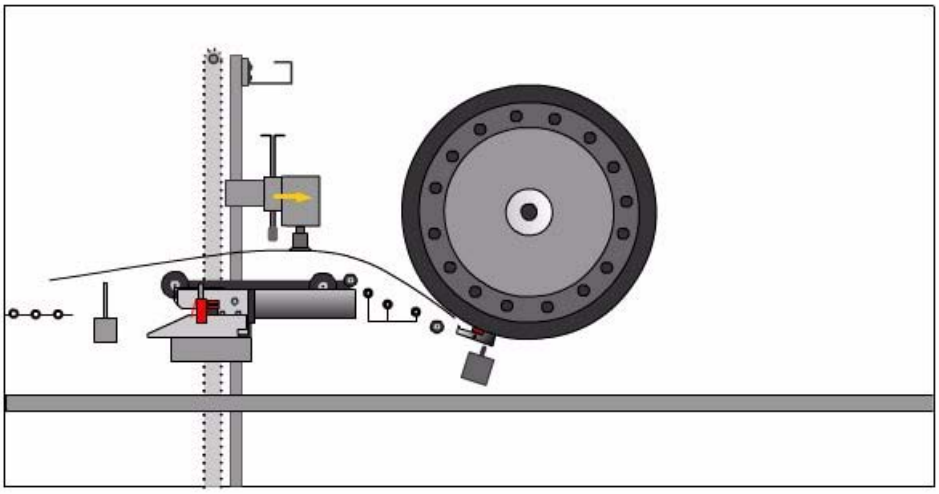


Stage C: Drum Entry to Drum

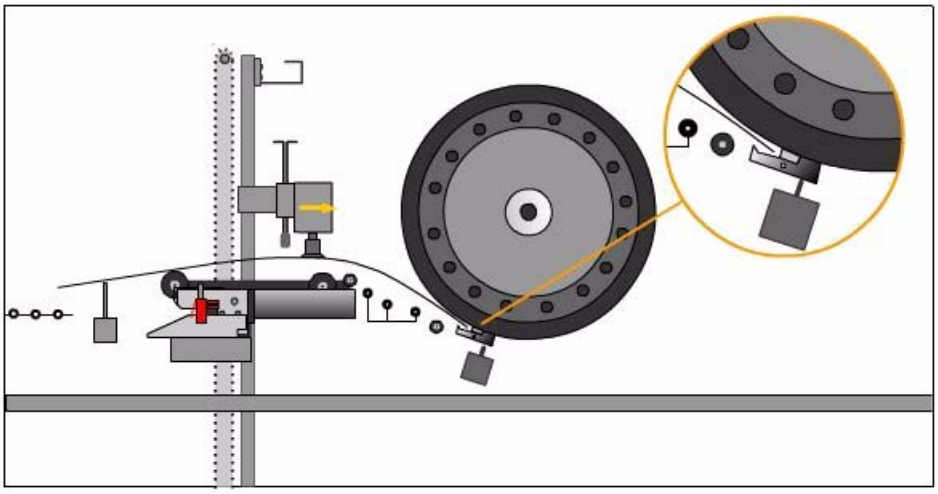
Table 4 describes the relevant actions that occur during the drum entry to drum stage. During this stage, the plate is transported from the drum entry and fully secured to the drum. At the end of this stage, the loading system repositions itself in preparation for loading another plate.

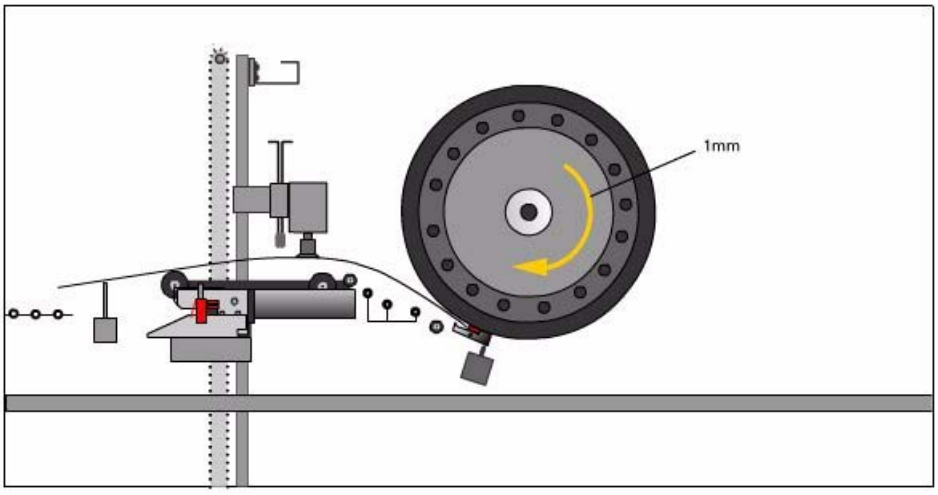
Table 4: Drum entry to drum

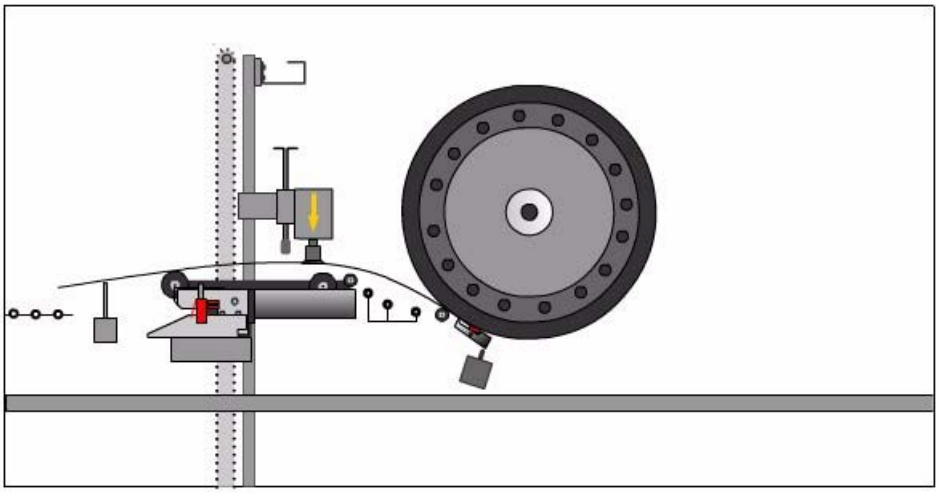
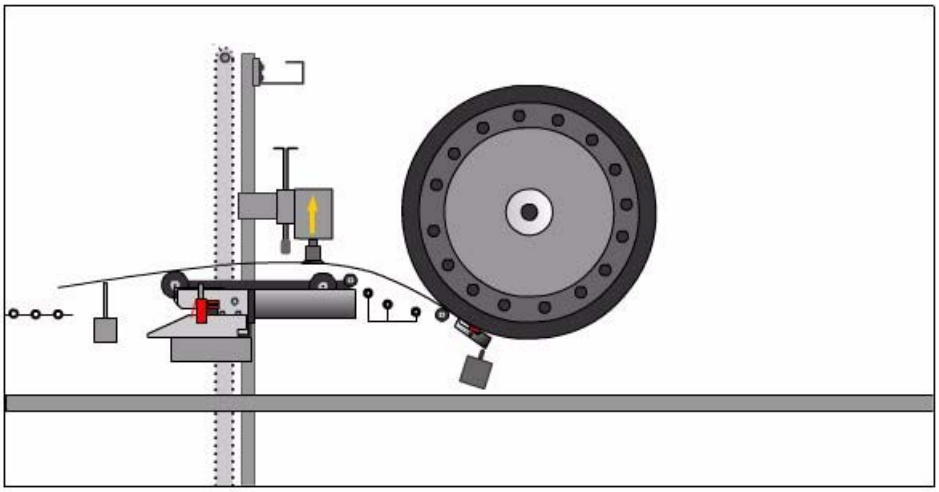
Step	Description	Parameter	Value (mm)
C1-x →	This step occurs after the drum rotates and is positioned to secure the plate, and the head grippers open. The plate advances toward the drum.	Load Plate > From Drum Entry to Drum Stage > **X In Drum For 0.15(mm)** **X In Drum For 0.2(mm)** **X In Drum For 0.3(mm)**	 1006 1006 1006

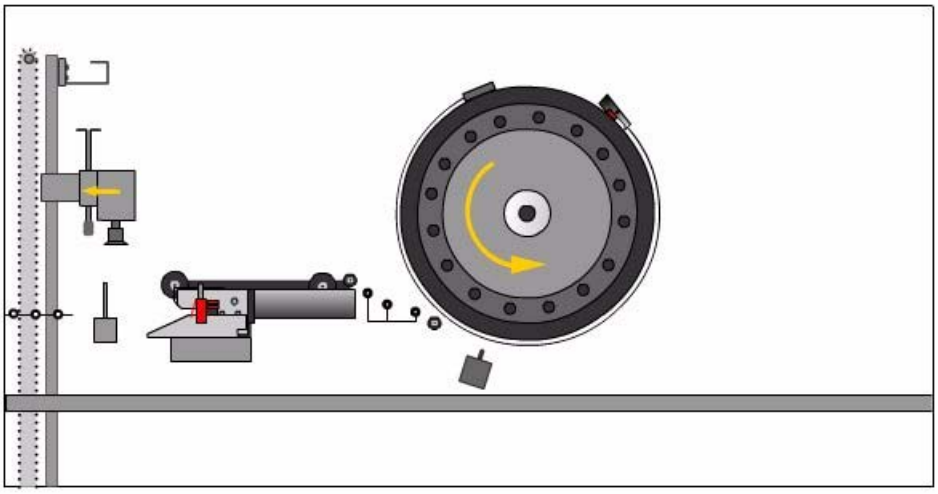
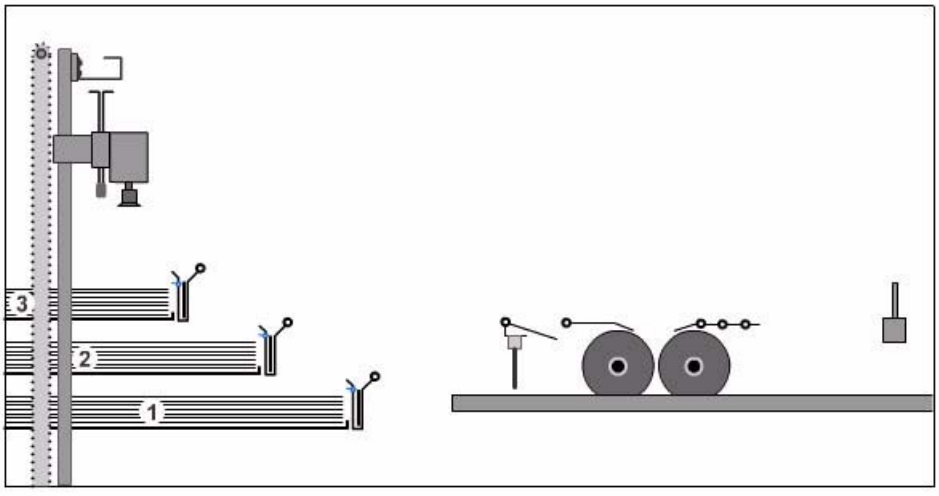


Step	Description	Parameter	Value (mm)
C2-x →	X is in the drum final position. The leading edge of the plate is inserted into the head grippers.	Load Plate > From Drum Entry to Drum Stage > **X In Drum Final For 0.15 Plates (mm) Rel** **X In Drum Final For 0.2 Plates (mm) Rel** **X In Drum Final For 0.3 Plates (mm) Rel**	 6 6 6
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 > **Drum To Plate After Extra For 0.15 (mm)** **Drum To Plate After Extra For 0.2 (mm)** **Drum To Plate After Extra For 0.3 (mm)**	 0 0 0





Step	Description	Parameter	Value (mm)
C4-y ↓	The suction cup vacuum stops, and the plate is released. The drum vacuum is activated.	Load Plate > From Drum Entry to Drum Stage > **Y Down After Plate Drop For 0.15 (mm) Abs** **Y Down After Plate Drop For 0.2 (mm) Abs** **Y Down After Plate Drop For 0.3 (mm) Abs**	 10 30 30
			
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)**	 16
			

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 plate-picking position.		
			

Appendix A: MCU/MCU II Loading System Parameters

The multi-cassette unit (MCU)/MCU II loading system parameters for the Magnus 400 Controller 1.05.394 software are listed in tables on the following pages. The parameters, which are grouped according to the series of movements (stages) performed by the platesetter during the loading sequence, are located in the registry at the following locations:

- Table 5: Loading system setup parameters: **\Magnus400\IO OBJECTS\Loading System\Loading System Setup**
- Table 6: Paper disposal parameters: **\Magnus400\IO OBJECTS\Loading System\Load Plate\Paper Disposal Stage**
- Table 7: Cassette entry to punch entry parameters: **\Magnus400\IO OBJECTS\Loading System\Load Plate\From Cassette To Punch Entry Stage**
- Table 8: Punch entry to drum entry parameters: **\Magnus400\IO OBJECTS\Loading System\Load Plate\From Punch Entry To Drum Entry Stage**
- Table 9: Drum entry to drum parameters: **\Magnus400\IO OBJECTS\Loading System\Load Plate\From Drum Entry to Drum Stage**

Loading System Setup

Table 5: Loading system setup parameters

Parameter	Default	Minimum	Maximum
Centering HP Speed	25	20	25
Enable FlyOff Detection(0=No, 1=First Loading, 2=Always)	1	0	2
Enable Pre-Loading Detectors Check [Yes=1,No=0]	1	0	1
High Speed	40	15	40
Is Mask Air Pressure Check No=1/Yes=0	0	0	1
Load Head Gripper Location (mm)	-218	-222	-214
Max Media Height Size For Small Plate	250	220	300
Max Media Width Size For Small Plate	350	300	400
Min Media Height For Operate All Valav (mm)	635	600	700
Min Media Height For Operate Middle Valav (mm)	330	300	400
Normal Speed	20	5	20
Sleep After Extra to Bar Flag Det [mSec]	500	0	3000
X HP Speed	15	10	15
Y Extra to Bar Flag Det For 0.15 (mm) Rel	7	5	12
Y Extra to Bar Flag Det For 0.3 - 0.2 (mm) Rel	10	5	12
Y Extra to Bar Flag Det Speed	5	3	5
Y HP Speed	15	10	15
Y Max Up (mm)	1	0	2
Y to Bar Flag Det Speed	8	3	10
Y To Read Paper Metal Det [mm] Rel	-15	-30	-6
Enable Detecting no Plate	0	0	1

Paper Disposal Stage

Table 6: Paper Disposal parameters

Parameter	Default	Minimum	Maximum
Delay For Y Up (Mili Sec)	0	0	2000
Operate Vacuum During Paper Disposal	0	0	1
Time To Sleep After Extra In cassette [mSec]	500	0	2000
Time To Wait For Clips are Full Open [mSec]	500	0	1000
X Paper Disposal Final(mm)	660	620	680
X Paper in disposal (mm)	625	600	645
X Paper in disposal speed	5	2	10
X Paper Position In Cassette For Cst 1(mm)	322	317	348
X Paper Position In Cassette For Cst 2(mm)	175	160	195
X Paper Position In Cassette For Cst 3(mm)	32	24	60
X Prepare To Paper Disposal (mm)	600	560	620
X Prepare To Paper Disposal Speed (mm)	40	20	40
Y Down To Paper Disposal Speed	12	5	15
Y Down To Paper Disposal(mm)	102	90	135
Y Extra to catch paper (mm) Rel	4	3	8
Y High Up Speed	15	5	15
Y Prepare To Paper Disposal(mm)	82	70	100
Y to Bar Flag Det. Speed For Paper	7	1	10
Y Up After Extra To Catch Paper (mm) Rel	5	2	6
Y Up Before Down To Paper Disposal (mm)	0	-20	0
Y Up for Init Catcher (mm) Rel	-25	-30	-24

Cassette to Punch Entry

Table 7: Cassette to punch entry parameters

Parameter	Default	Minimum	Maximum
Centering Speed	1	1	5
Centering Wait Dis (mm) Rel	10	0	20
Max Media WSize Ramp Up After Punch [mm]	625	600	650
Measure Centering Tolerance (mm)	3	1	4
Min Media Width Size To Operate Paper Disposal During Loading Plate [mm]	450	400	600
Min Media WSize Ramp Up After Punch [mm]	550	500	600
Min Plate High Size For Centtering wait distance[mm]	763	700	770
Number of Plate BackWard Seperations	4	1	5
Prepare Y to catch Plate Speed	5	2	7
Sleep in Punch Short Detctor [Msec]	500	500	2000
Time To Sleep After Plate Seperation [mSec]	0	0	2000
Time To Wait In Punch Before Stop Paper Dis[Msec]	500	0	3000
Wait For Fufu For Tray2 msec	500	0	3000
Wait For Fufu msec	500	0	3000
X Backward For 0.15 plate [mm] Rel	16	5	20
X Backward For 0.2 plate [mm] Rel	16	5	20
X Backward For 0.3 plate [mm] Rel	16	5	20
X Do Plate Sep Speed	5	2	7
X for Centering (mm)	820	800	840
X for Centering Final (mm)	833	810	855
X for Centering Speed	40	10	40
X Pick Up Plate Before in Punch (mm)	750	735	765
X Plate Forward in Cassette For 0.15 (mm) Rel	1	1	3
X Plate Forward in Cassette For 0.2 (mm) Rel	2	1	3
X Plate Forward in Cassette For 0.3 (mm) Rel	2	1	3
X Position in Cassette For Cst 1(mm)	315	310	325
X Position in Cassette for Cst 2(mm)	175	160	180

Parameter	Default	Minimum	Maximum
X Position in Cassette for Cst 3(mm)	30	22	33
X Pre Extra To Short Pins For 0.15 (mm) Rel	48	20	54
X Pre Extra To Short Pins For 0.2 (mm) Rel	48	20	54
X Pre Extra To Short Pins For 0.3 (mm) Rel	48	20	54
X To Fufu Off Cassette 1 (Rel)	110	50	200
X To Fufu Off Cassette 3 (Rel)	200	100	300
Y Above Air Nozzle In Tray 1(mm)	181	178	184
Y Above Air Nozzle In Tray 2(mm)	110	107	113
Y Above Air Nozzle In Tray 3(mm)	37	34	40
Y After Plate Seperation [mm] Rel	3	3	10
Y Down After Centering to catch Plate For 0.15 (mm) Rel	7	3	10
Y Down After Centering to catch Plate For 0.3 - 0.2 (mm) Rel	10	3	13
Y Down After Centering to catch Plate Speed	5	2	6
Y for Centering (mm)	89	85	90
Y In Punch Speed	15	10	16
Y Movement for 0.15 plate [mm] Rel	0	0	4
Y Movement for 0.2 plate [mm] Rel	0	0	4
Y Movement for 0.3 plate [mm] Rel	0	0	4
Y Plate High Up In Cassette For 0.15 (mm)	0	0	5
Y Plate High Up In Cassette For 0.2 (mm)	0	0	5
Y Plate High Up In Cassette For 0.3 (mm)	0	0	5
Y Plate High Up In Cassette Speed	1	1	3
Y Plate Up In Cassette_1 (mm)	150	135	150
Y Plate Up In Cassette_2 (mm)	85	70	85
Y Plate Up In Cassette_3 (mm)	20	15	30
Y Prepare To Take Out Plate From Cst 1(mm)	160	158	162
Y Prepare To Take Out Plate From Cst 2(mm)	70	68	72
Y Prepare To Take Out Plate From Cst 3(mm)	25	23	27
Y Ramp Position mm	90	85	95

Parameter	Default	Minimum	Maximum
Y to bar flag det. Speed In Cassette	15	10	16
Y to short pins (mm)	86	85	90
Y to short pins Speed	10	5	10
Y Up For Centering (mm) Rel	–15	–20	–10

Punch Entry to Drum Entry

Table 8: Punch entry to drum entry

Parameter	Default	Minimum	Maximum
X After DoPunch For 0.15	705	700	710
X After DoPunch For 0.2	705	700	710
X After DoPunch For 0.3	705	700	710
X Extra To Short Pins For 0.15 (mm) Rel	2	2	4
X Extra To Short Pins For 0.2 (mm) Rel	3	2	4
X Extra To Short Pins For 0.3 (mm) Rel	3	2	4
X Move X Upto Wheels For 0.15 (mm)	0	–10	10
X Move X Upto Wheels For 0.2 (mm)	0	–10	10
X Move X Upto Wheels For 0.2 (mm)	0	–10	10
X Near to Drum For 0.15 Seq (mm)	900	880	910
X Near to Drum For 0.2 Seq (mm)	900	880	910
X Near to Drum For 0.3 Seq (mm)	900	880	910
X Pick Up Plate Before In Drum (mm)	750	735	765
X Prepare In Drum Speed	15	10	15
X Speed Extra To Short Pins	3	2	4
Y In Drum For 0.15 (mm)	10	0	35
Y In Drum For 0.2 (mm)	30	0	35
Y In Drum For 0.3 (mm)	30	0	35
Y Min Media WSize to Go Up After Punch [mm]	550	400	700
Y Prepare To Drum Speed	15	10	15
Y Up After DoPunch for 0.15	85	75	90

Parameter	Default	Minimum	Maximum
Y Up After DoPunch for 0.2	85	75	90
Y Up After DoPunch for 0.3	85	75	90
Y Up For Backward After Centering (mm) Rel	–15	–20	–10
Y Up Prepare To Drum	–4	–12	–2

Drum Entry to Drum Stage

Table 9: Drum entry to drum stage parameters

Parameter	Default	Minimum	Maximum
Drum To Plate After Extra For 0.15 (mm)	0	0	2
Drum To Plate After Extra For 0.2 (mm)	0	0	2
Drum To Plate After Extra For 0.3 (mm)	0	0	2
Thickness For 0.15 Seq (mm)	0.15	0.15	0.15
Thickness For 0.2 Seq (mm)	0.2	0.2	0.2
Thickness For 0.3 Seq (mm)	0.3	0.3	0.3
X In Drum Final For 0.15 Plates (mm) Rel	6	0	16
X In Drum Final For 0.2 Plates (mm) Rel	6	0	16
X In Drum Final For 0.3 Plates (mm) Rel	6	0	16
X In Drum Final Speed	1	1	3
X In Drum For 0.15(mm)	1006	1000	1012
X In Drum For 0.2(mm)	1006	1000	1012
X In Drum For 0.3(mm)	1006	1000	1012
X In Drum Speed	10	4	10
X Run Away From Plate On Drum	300	1	700
Y After Extra to Drum (mm)	0	0	10
Y Before Extra to Drum (mm) Rel	0	0	10
Y Down After Plate Drop For 0.15 (mm) Abs	10	0	40
Y Down After Plate Drop For 0.2 (mm) Abs	30	0	40
Y Down After Plate Drop For 0.3 (mm) Abs	30	10	40
Y Up Before Back Abs (mm)	16	10	25