LEC Firmware Position for Unloading and Loading

Applies to

☑ Trendsetter 3244 Autoloader

☑ Trendsetter 3230 Autoloader

Background

Plates occasionally get stuck in the leading edge clamps during unload, causing the unload traveller to stall when trying to pull the plate out of the clamps. In many cases, the traveller will succeed in pulling the plate from the clamps, but will have lost steps. It will then have trouble finding the rotate position.

As of version V1.10, the position of the drum during unload can be changed to make pulling the plate from the clamps easier. The "al duoff (drum unload offset)" parameter can be used to over-rotate the drum past the leading edge clamp position. When the actuator comes down, it hits the clamps below the notch, opening the clamps wider than otherwise

Requirements

- newer LE film guide (ECO #C547, stainless steel mounts) or no film guide
- firmware versions 1.10 and above



WARNING: Failure to follow the safety policies and procedures for field engineers may create a dangerous situation that could result in serious injury as well as damage to the output device. For more information, see: http://techplanet.creo.com/output/computer_to_plate/all_ctp/nav/safety.htm

Steps

Load

The first step is to set the LEC position

1. Initialize the autoloader:
   `ale init`
2. Query the drum position:
   `drum`
3. Verify that the drum position for the leading edge (LE) actuator bar to line up with is the same as the drum position just queried:
   `set al lepos`
4. If the two values are different set lepos to the drum position from step 2.
   `set al lepos <drum query>`
5. **`nvs save al`**

Unload

1. Turn the key switch to laser hazards, and open the front door.
2. Start with an "al duoff" value of 90 for the newer enclosed encoder and 125 for the older unenclosed encoder:
   `set al duoff 90 (or 125)`
3. Calculate "al lepos" minus "al duoff" (equal to **<*nn*>*)*** and move the drum to this position:
   `drum move <nn> h`

4. Activate the leading edge backbone:
   `lec on`
5. Go to the machine and block the flyoff beam. This action will idle the drum. If the drum moves so that the leading edge clamp backbone falls into the notch in the clamps, then the “al duoff” parameter used is too small. Increase it until the drum no longer moves when idled.
6. If, when idled, the drum moves so that the leading edge backbone falls off the back of the clamps, the parameter has been increased too far. If the displacement value is too large, the clamp will fall off the backbone and press against the film guide. This last check is not obvious, test for it by trying to push the film guide towards the drum.

Adjusting the film guide

If the film guide contacts the drum roller, adjust the roller cylinder rod ends so that there is 2mm of full diameter shaft protruding out of the cylinder end cap (i.e., 2mm of stroke left in the cylinder) when the roller is on the drum. This should be approximately 6 half turns out from the rod ends fully in position.

The gap between the drum and the film guide should be 2-3mm, adjust by removing the film guide and turning the clevises. (note: 1/2 turn will move the gilm guide by 1.5mm or more). Don’t forget to install the sprint clips after the final adjustment.

Notes

Technical contact Lyle Beck (lbeck@creo.com)

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