Adjusting plate centering

Applies to

☑ Trendsetter 3244 Autoloader (Only applies to plates large enough to need rotation.)

Background

As of version 1.30, the method for adjusting the side-to-side position of the plate after rotation has been changed. The *alpos pco* parameter is no longer used, and the *alpos ltu* parameter has been returned to its original function: defining the physical distance from the leading edge clamps to the home position of the unload table. If the *alpos ltu* parameter has been adjusted for plate centering, it should be returned to its proper value.

Steps

For Version 1.30 and newer

If the *alpos ltu* and the plate size parameters are set up properly, all plates should be centered on the unload table after being rotated. However, the side-to-side position of plates may need to be adjusted to shift plates relative to a stacker or processor. A new NVS parameter, *alpos ssoe* (side_shift_on_exit) allows the plate to be moved off-center by up to 10cm in either direction. If this parameter is positive, the plate will be shifted to the left after rotation (when viewed from the front of the Trendsetter). A negative value will cause the plate to be shifted to the right.
Do not decrease the *alpos ssoe* parameter more than -40mm for 44" plates, otherwise these large plates may hit the back of the machine during rotation.

For Version older than 1.30

Plates with main scan dimension greater than about 650 mm

Plates with a main scan dimension greater than twice the value stored in *alpos ltu* are grabbed at the center of the plate during unloading. The parameter which controls plate centering for these plates is *alpos lt*u.

1. Enter **`set alpos ltu`** to see the current setting.
2. Enter **`set alpos ltu <nn>`** where **`<nn>`** is the new setting.

- To move the plate further to the left (viewed from the front of theTrendsetter) as it enters the processor, increase the value of **`ltu`**.
- To move the plate further to the right (viewed from the front of theTrendsetter) as it enters the processor, decrease the value of **`ltu`**.

3. Enter **`nvs save al alpos ltu`** to save the new setting.

Plates with main scan dimension smaller than about 650 mm

Plates with a main-scan dimension less than twice the value stored in *alpos ltu* cannot be grabbed at the center and require an extra operation during unloading. The parameter which controls plate centering for these plates is *alpos pc*o.

1. Enter **`set alpos pco`** to see the current setting.
2. Enter **`set alpos pco <nn>`** where **`<nn>`** is the new setting.

- To move the plate further to the left (viewed from the front of the Trendsetter) as it enters the processor, increase the value of **`pco`**.
- To move the plate further to the right (viewed from the front of the Trendsetter) as it enters the processor, decrease the value of **`pco`**.

3. Enter **`nvs save al alpos pco`** to save the new setting.

Notes

Alternate Method for Adjusting Plate Centering

As an alternate method for adjusting plate centering, the "table cal center" command can be used to adjust the side-to-side position of the plate after it has been rotated. After typing table cal center, you will be prompted for the main-scan dimension of the plate and the distance you would like to shift the center position. A negative shift value moves the plate right (when viewed from the front of the recorder) while a positive value moves the plate left.

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