AUTOPUNCH INSTALLATION PROCEDURE

To support the Ternes AutoPunch, you need firmware version 1.30 or higher. You can download the firmware and release notes from \\intranet\support\firmware\CTP\3244_Trendsetter\al\versions.htm. For detailed information on all the firmware parameters and commands associated with punching, go to the Creo firmware documentation web pages at \\intranet\support\firmware\ctp\index.html and click on NVS Index or Command Index in the sidehead.

Enabling the AutoPunch

To enable the punch use the diagnostic parameters:

set al pi 1	to set **p**unch **i**nstalled to **1** (enables the punch)
nvs save al pi	to save the parameter

Using Media Types to Set up the Punch Configurations

Overview

Ternes has configured the punch for different plate sizes and defined a number between 1 and 19 for each configuration. (A pre-programmed list comes with each Autopunch.) The punch configuration is now part of the media type so that punching can be controlled from the workstation by selecting different media types. A different media type is required for each punch configuration, including a separate media type to disable punching. See the examples that follow.

You must also create new hdm (head dependent media) types to mirror the new media types (give the hdm type the same name as the media type). The media and hdm parameters will be identical for a given media, with the exception of the name and the punch configuration. See the examples that follow.

Saving Existing HDM and Media Parameters

A new command has been created to reduce the manual labor involved in copying media parameters from one media type to another. Use the command **punch media** <**media source**> <**media dest**> to copy all media and hdm parameters. Copy the parameters BEFORE setting the name and punch configurations; otherwise those parameters will be over-written. Since only 8 media types are available, this method of copying will not work well if multiple medias of different sizes need to be punched. If this is a concern, contact Steve Froese for assistance.

Examples of Naming the New Media Types and Plate Types

Give the media types names that reflect the punch configuration or plate size they will be used for. For example, if a 25" wide Kodak IR plate uses punch configuration 5, then the media name could be "Kodak IR p5" or "Kodak IR 25inch punched". Naming the media types based on the plate size helps to hide the arbitrary punch numbers from the operators.

To configure the media types in the firmware:

EXAMPLE 1: A customer only runs Kodak plates, but in two different sizes: 25" wide requiring punch configuration 5, and 40" wide requiring punch configuration 2. Three media types must be configured.

Assuming that Kodak is set up as media type 1, copy these parameters to media types 2 and 3:

punch media 1 2
punch media 1 3

For the 25" plates, set the parameters as follows:

set media <n1> name “Kodak IR 25inch punched”
set hdm <n1> name “Kodak IR 25inch punched”
set media <n1> pcfg 5

For the 40" plates, set the parameters as follows:

set media <n2> name “Kodak IR 40inch punched”
set hdm <n2> name “Kodak IR 40inch punched”
set media <n2> pcfg 2

For Kodak plates that should not be punched, set the parameters as follows:

set media <n3> name “Kodak IR unpunched”
set hdm <n3> name “Kodak IR unpunched”
set media <n3> pcfg 0

EXAMPLE 2: A customer runs Kodak plates 40" wide and Agfa plates 40" wide. Both plates require punch configuration 2. Four media types must be configured.

For the Kodak 40" plates, set the parameters as follows:

set media <n1> name “Kodak IR 40inch punched”
set hdm <n1> name “Kodak IR 40inch punched”
set media <n1> pcfg 2

For Kodak plates that should not be punched, set the parameters as follows:

set media <n2> name “Kodak IR unpunched”
set hdm <n2> name “Kodak IR unpunched”
set media <n2> pcfg 0

For the Agfa 40" plates, set the parameters as follows:

set media <n3> name “Agfa 40inch punched”
set hdm <n3> name “Agfa 40inch punched”
set media <n3> pcfg 2

For Agfa plates that should not be punched, set the parameters as follows:

set media <n4> name “Agfa unpunched”
set hdm <n4> name “Agfa unpunched”

set media <n4> pcfg 0

Saving Media and HTM parameters

Use the following commands to save the confituration:

nvs save media 2	saves the new media parameters for media type 2
nvs save hdm	saves the new hdm parameters for all hdm types

Copy the parameters before the name and punch configurations are set, as those parameters will otherwise be over-written.

Other Punching Parameters

Although most NVS parameters are left at their default values when the punch is installed, you need to change the following parameters:

alpos prd	Distance from the table home position (traveler tabs) to the register stops of the punch. The default value is 1485 mm.
alpos fed	Distance to push the plate before the speed changes from FAST to SLOW. Should be increased by the width of the punch, around 330mm.
aldly vrd	Pause after the vacuum has been turned off before lowering the cups. This pause is not needed in most cases – the value can be reduced to 0.1s or 0s.

Configurıng the workstation

Shut down and restart the workstation.

As a convenience to the customer, redefine the plate types they currently use to include the new media type. For example, if the customer uses plate type "Kodak 25inch", then redefine it to use media type "Kodak IR 25inch punched" instead of "Kodak IR". Similarly, define a new plate type for plates not to be punched. This new plate type could be named "Kodak 25inch unpunched" using media type "Kodak IR unpunched".

For each new media type, the Medium Index must also be set in the Configure Media window. Configure the plate types through the workstation to use the new media types you created. Set this to the same value as the original media type (i.e., Kodak IR).

Submitting a job of plate type "Kodak 25inch" will then cause the plate to be punched with the configuration defined for 25inch plates. Submitting a job of plate type "Kodak 25inch unpunched" will cause the plate to be handled as before, without punching.