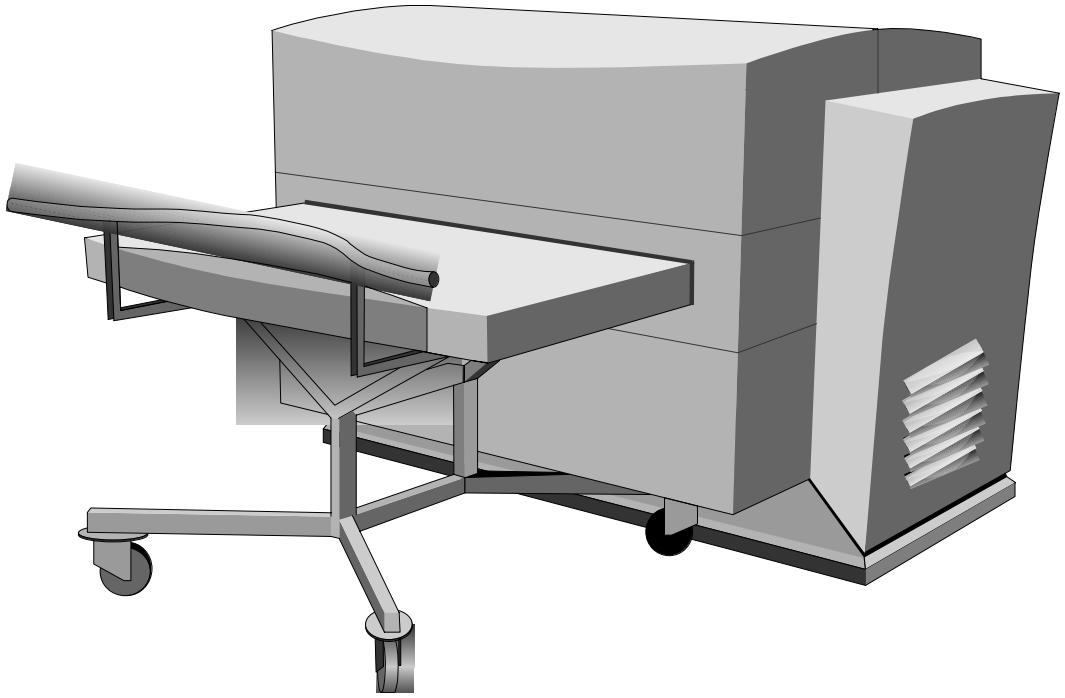
creo™



Lotem 800

Plate Loading Sequence

Version 3.20.01

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RE37376	5247174	5420702	5625766	5854883	6031932	6181362
4456924	5247352	5420722	5636330	5861904	6043865	6181439
4500919	5249067	5459505	5649220	5861992	6060208	6186068
4558302	5283140	5473733	5650076	5864651	6063528	6189452
4743091	5291273	5481379	5652804	5875288	6063546	6191882
4992864	5296935	5488906	5680129	5894342	6072518	6204874
5049901	5313278	5497252	5691823	5900981	6090529	6208369
5079721	5323248	5508828	5691828	5934196	6096461	6214276
5081617	5325217	5509561	5696393	5942137	6098544	6217965
5103407	5331439	5517359	5699174	5946426	6107011	6252522
5111308	5333064	5519852	5699740	5947028	6112663	6260482
5113249	5339176	5526143	5708736	5958647	6115056	6266080
5122871	5343059	5532728	5713287	5966504	6121996	6266134
5124547	5355446	5561691	5739819	5969872	6130702	6267054
5132723	5359451	5568595	5742743	5973801	6134393	6268948
5150225	5359458	5576754	5764374	5986819	6136509	6283589
5153769	5367360	5579115	5764381	5995475	6137580	6295076
5155782	5367388	5592309	5771794	5996499	6147789	
5157516	5384648	5594556	5785309	5998067	6158345	
5177724	5384899	5600448	5802034	6003442	6159659	
5208818	5412491	5608822	5813346	6014471	6164637	
5208888	5412737	5615282	5818498	6016752	6180325	

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Part No. 399Z1R945B

March 2002

Table of Contents

OVERVIEW **9**

LOTEM 800 LOADING PARAMETERS **10**

Accessing Parameters in the Registry **10**
Accessing Parameters Using the Registry Editor ("regedit") 10
Accessing Parameters via the PC Controller 10

Motor Position Factor (Pos Factor) **11**
Verifying Distance Accuracy 11

CASSETTE TO PUNCH ENTRY (A) **12**

Table 1: Stage a: Motions and Parameters **13**

PUNCH ENTRY TO DRUM ENTRY (B) **30**

Table 2: Stage 2: Motions and Parameters **31**

DRUM ENTRY TO DRUM (C) **37**

Table 3: Stage c: Motions and Parameters **38**

PAPER DISPOSAL TASK (D) **41**

Table 4: Stage d: Motions and Parameters **42**

APPENDIX A: PARAMETERS IN REGISTRY **47**

Overview

This document describes the Lotem 800 plate loading sequence and parameters, as pertains to machines using software version **3.20.01**.

The Lotem 800 plate loading sequence is a series of actions (motions) performed by the machine that remove the plate from the **Cassette**, transport it, and secure it, to the **Drum**. The loading sequence is divided into four stages, as follows:

- **Cassette Entry to Punch Entry (a):** In this stage, the **Loading System** moves the plate from the cassette into the **Punch Entry**, as described in Table 1 beginning on page 12. Table 1 includes Figures 1 through 6, which illustrate the motions in stage **a**.
- **Punch Entry to Drum Entry (b):** In this stage, the **Loading System** fully inserts the plate into the **Punch** and, after punching, removes it from the **Punch** and transports it to the **Drum Entry**, as described in Table 2 beginning on page 30. Table 2 includes Figures 7 and 8, which illustrate the motions in stage **b**.
- **Drum Entry to Drum (c):** In this stage, the plate is moved from the **Drum Entry** to the **Drum**, is fully secured to the **Drum**, and the **Loading System** prepares to load another plate, as described in Table 3 beginning on page 37. Table 3 includes Figure 9, which illustrates the motions in stage **c**.
- **Paper Disposal Tasks (d):** This stage only occurs when the **Paper/Metal Detector** detects the presence of paper in the cassette. The first five motions of stage **a** are performed, as described in Table 1 beginning on page 12 and then, if paper is detected, the **Loading System** removes the paper from the cassette and transports it to the **Disposal System**, as described in Table 4 beginning on page 41. Table 4 includes Figures 10 and 11, which illustrate the motions in stage **d**.

Lotem 800 Loading Parameters

Each stage consists of several motions, and each motion is defined by a parameter that is located in the **Registry**. The value entered for each parameter determines the distance moved, either in relative or absolute coordinates. In addition, the distance moved is influenced by the motor position factor (Pos Factor), as described in Motor Position Factor (Pos Factor) on page 11.

Accessing Parameters in the Registry

The parameters listed in the **Location of Parameters in Registry** column of Tables 1 through 4 are accessed using either of the following methods, as described below:

- Using the Registry Editor ("regedit")
- Via the PC Controller

Accessing Parameters Using the Registry Editor ("regedit")

The following is the base (beginning of each) path used to access the parameters listed in the **Location of Parameters in Registry** column of Tables 1 through 4, using the "regedit". To access these parameters in the registry using the "regedit", add this path to the beginning of the paths listed in the **Location of Parameters in Registry** column for each parameter.

"HKEY_LOCAL_MACHINE\SOFTWARE\Scitex\Projects\Lotem800V\IOOBJECTS"

Accessing Parameters via the PC Controller

To access parameters in the Registry via the PC Controller, select **Utilities > Hardware** and in the displayed Hardware tree, double-click **Loading System**, and right-click **Loading System** to display the Registry.

Note: The values entered for each of the parameters listed in Tables 1 through 4 are examples only. Use default values for parameters whenever possible, or enter an appropriate value, as required, for the current job.

Motor Position Factor (Pos Factor)

The Motor Position Factor (Pos Factor) is a value that is used to calculate the distance traveled by the Loading System and XY Bar per X and Y motor rotation (as interpreted by both the X and Y motor encoders). The exact calculation is as follows: Number of rotations x Pos Factor = distance traveled in millimeters. The value entered for the Pos Factor ensures that the distance traveled by the Loading System and XY Bar along both the X-Axis and the Y-Axis is accurate according to the value entered for each parameter. For example, if the value entered for a specific parameter is "6 mm" and the Pos Factor is "0.0056", then the relevant motor would have to rotate 1071.43 times (1071.43 x 0.0056 = 6mm).
Note: These values are examples only.
In cases where the actual distance traveled by the Loading System or XY Bar is not equal to the value entered (in millimeters), the Pos Factor must be modified. Distance accuracy is verified as described below.

Verifying Distance Accuracy

1. In the PC Controller, select **Utilities > Hardware**.
2. In the displayed Hardware tree, double-click **Loading System > Loading Plate To Drum > X System > X Motor**. The X Motor dialog box is displayed.
3. In the **Operation** tab of the X Motor dialog box, select **Home Position (HP)**, and then click **Start**. The Loading System moves to the home position (HP). Place a metal ruler against the base of the Drum, and note the exact distance of the Loading System from the Drum.
4. In the **Operation** tab of the X Motor dialog box, select **Distance**, enter a value in the **Distance** field and then click **Start**. The Loading System moves from the HP along the X-Axis.
   Note: The value entered should be a multiple of 10 to enable easier measurement of the distance traveled, for example, 10, 20, and so on.
5. Measure the actual distance traveled using the metal ruler, as described in step 3. The distance traveled should be equal to the value entered in the **Distance** field within a maximum tolerance of ± 0.5 mm. If it is not, contact the PSS.
6. In the **Operation** tab of the X Motor dialog box, select **Y Motor** from the **Motor** dropdown-menu. The Y Motor dialog box is displayed.
7. Repeat steps 3 through 5 to verify distance accuracy along the Y-Axis (place the end of the metal ruler on the Punch Beam and measure the distance traveled by the XY Bar).

Cassette to Punch Entry (a)

Table 1 describes each motion that occurs during the **Cassette to Punch Entry (a)** stage of the Lotem 800 loading sequence, in which the plate is removed from the **Cassette** and transported to the **Punch**.

The parameters that define the action and direction of each motion are listed in the **Location of Parameters in Registry and Values** column along with their default values. Any relevant comments are listed in the **Comments** column.

Note: When accessing parameters in the **Registry**, remember to add the base path to the beginning of each one, as described in Accessing Parameters in the Registry, on page 10.

The values entered for each of the parameters listed in Table 1 are examples only.

The figures listed below illustrate the motions described in Table 1, as follows:

- Figure 1 on page 13 illustrates motions **a-1** through **a-5**.
- Figure 2 on page 16 illustrates motions **a-6** through **a-12**.
- Figure 3 on page 20 illustrates motions **a-13** through **a-18**.
- Figure 4 on page 23 illustrates motions **a-19** through **a-20**.
- Figure 5 on page 25 illustrates motions **a-21** through **a-25**.
- Figure 6 on page 28 illustrates motions **a-26** through **a-29**.

Table 1: Stage a: Motions and Parameters

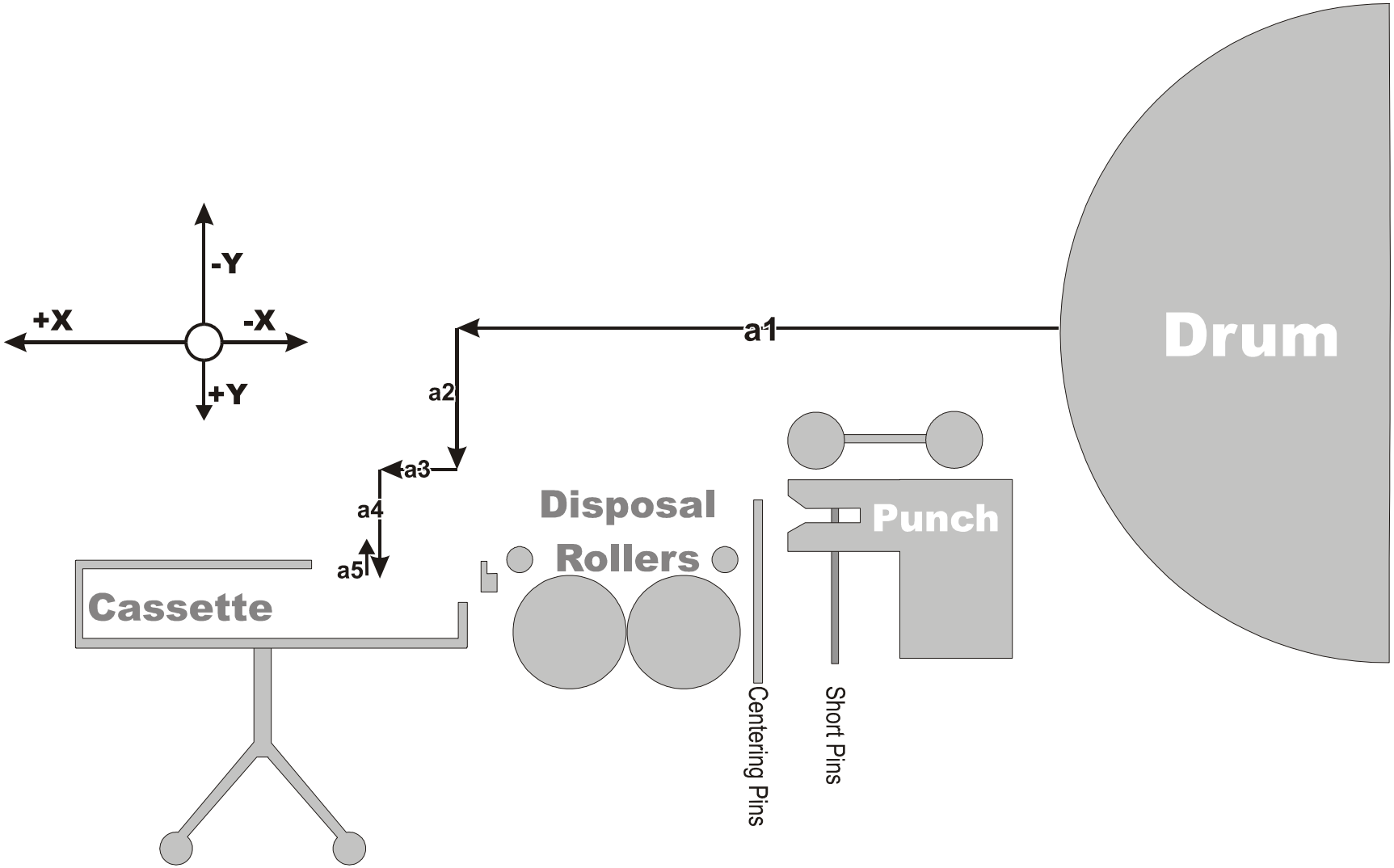


Figure 1: Cassette to Punch Entry (a-1 to a-5)

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
a-1	The **Loading System** moves toward the **Cassette** along the **X-Axis**.	…Loading System\Loading System Setup "X Position In Cassette (mm)"="350"	It is recommended to use the default value for this parameter. Increasing the value for this parameter causes the **Loading System** to travel further along the **X-Axis** toward the **Cassette**. Decreasing the value causes the **Loading System** to travel a shorter distance along the **X-Axis**. If you do increase this value, initiate **a-1** and verify that the **XY Bar** does not hit the **X-Shaft**.
a-2	The **XY Bar** moves down along the **Y-Axis** until it clears the **Front Frame**.	...\Loading System\Loading System Setup "Prepare Y to catch Plate (mm)"="70"	The value of this parameter determines the distance of the downward motion of the **XY Bar**. It is recommended to use the default value for this parameter. Increasing the value for this parameter causes the **XY Bar** to move further downward along the **Y-Axis**. Decreasing the value causes the **XY BAR** to travel a shorter distance along the **Y-Axis**.
a-3	The **Loading System** moves toward the **Cassette** along the **X-Axis**, until it is positioned over the plate, near the **Leading Edge**.	...\Loading System] "X Prepare to Catch Plate (mm)"="365" **For Dual Cassette Main Tray:** …\Loading System] "X Prepare to Catch Plate (In Dual Cassette) For Main Tray (mm)"="370" **For Dual Cassette Upper Tray:** ...\Loading System] "X Prepare to Catch Plate (In Dual Cassette) For Upper Tray (mm)"="367"	This parameter determines the position of the **XY Bar Suction Cups** on the plate in motion **a-4**.

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
a-4	The **XY Bar** moves down along the **Y-Axis** until the **Bar Flag Detector** is activated and the suction cups are touching the plate (or paper).	Speed = ...\Loading System\Loading System Setup "Y to detector Speed"="12.6"	Do not change the default value for this parameter.
a-5	The **XY Bar** moves up along the **Y-Axis** (relative additional up) until the **Paper/Metal Detector** is positioned correctly. The **Paper/Metal Detector** then identifies the presence of either a plate or paper in the cassette.	...\Loading System\Loading System Setup "Tilted Paper Metal Detector Y Relative Position"="-5"	It is recommended to use the default value for this parameter. **Notes:** When adjusting the **Paper/Metal Detector**, use the new TIC procedure. If paper is detected in the **Cassette**, the **Paper Disposal Task** (stage **d**) is initiated, as described on page 41.

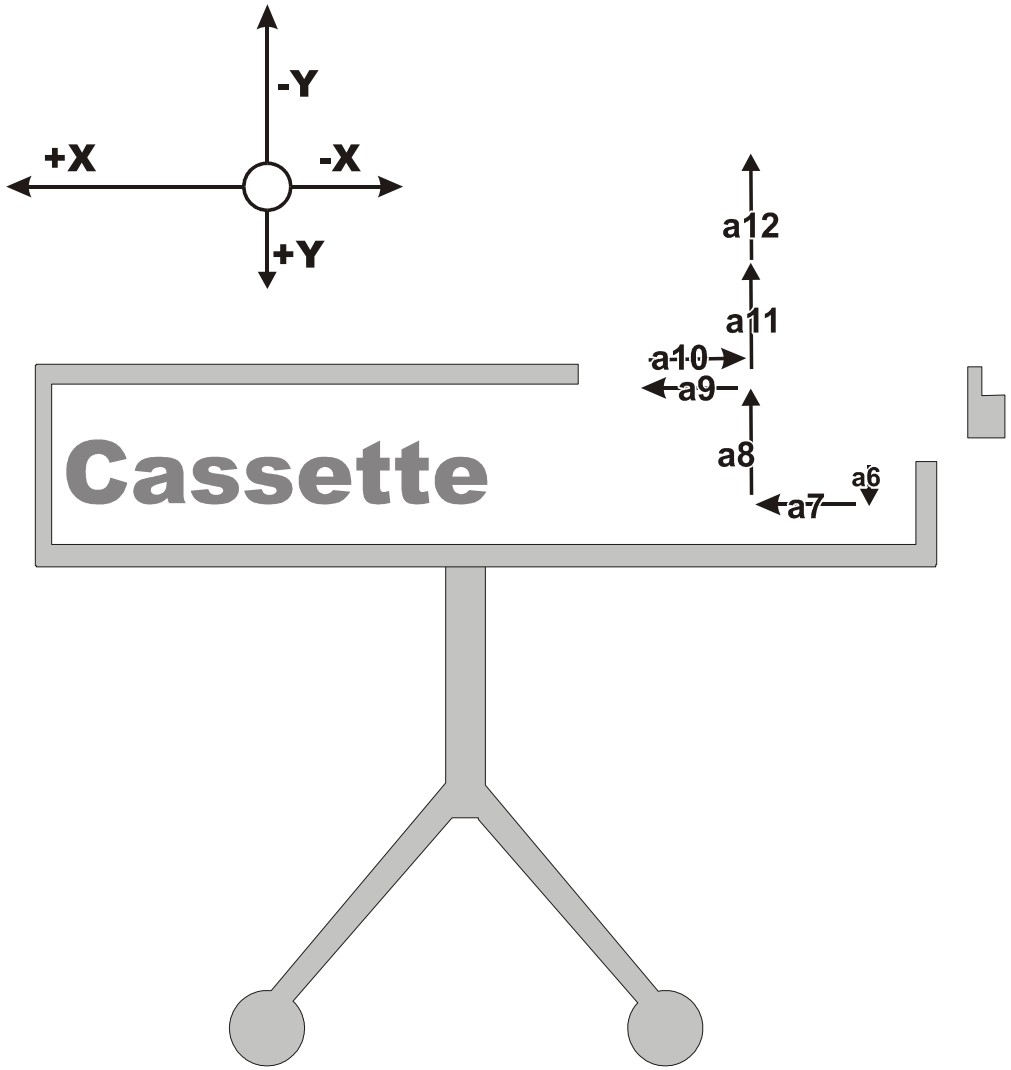


Figure 2: Cassette to Punch Entry (a-6 to a-12)

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
a-6	The **XY Bar** moves down along the **Y-Axis** (relative additional down) until the **Bar Flag Detector** is activated and the suction cups press down on the plate (or paper). **Note:** If paper was detected in the machine, refer to Table 4 on page 42.	...\Loading System\Loading System Setup] "Y Extra to detector (mm)"="14" **For thinner plates:** ...\Loading System\Loading System Setup] "Y Extra to detector For 015 (mm)"="7" Speed = ...\Loading System\Loading System Setup "Y Extra to detector Speed"="5"	This motion firmly places all **XY Bar Suction Cups** on the plate so that, when the **Suction Cup Vacuum** is activated, the plate will be properly secured. Increasing the value for this parameter causes the **XY Bar** to move further downward along the **Y-Axis**. Decreasing the value causes the **XY Bar** to travel a shorter distance along the **Y-Axis**. **Important:** Initiate **a-6** using an almost-empty cassette and verify that ***all* XY Bar Suction Cups** fully contact and press firmly down on the plate. Then, initiate **a-7** and verify that the plate is secured by ***all* XY Bar Suction Cups**. In addition, verify that the machine is leveled and perform leveling, as required. **Tip:** If plates cannot be secured by the suction cups because they are positioned too low in the **Cassette**, you can raise them by placing five or six used plates on the bottom of the **Cassette**, covering them with cardboard and then placing unused plates on top of the cardboard.

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
a-7	The **Suction Cup Vacuum** is activated, securing the plate to the **XY Bar** suction cups. The **Loading System** moves toward the **Cassette** along the **X-Axis** to separate the plate from the paper underneath.	...\Loading System\Load Plate\From Cassette To Punch Entry Stage "X Plate Rel Backward In Cassette (mm)"="0.1" Speed= ...\Loading System "Normal Speed"="127	This is the first action that is performed to separate the paper and/or the plate below from the plate currently being loaded. **a-8**, **a-9** and **a-10** further aid separation, and prevent double-loading. It is recommended to use the default value for this parameter.
a-8	The **XY Bar** moves up along the **Y-Axis** (relative up). This bends the plate slightly.	...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Plate High Up In Cassette (Rel) (mm)"="-45"+"Y Plate Rel Up In Cassette (mm)"="-16" Speed= ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Plate High Up In Cassette (Rel) Speed"="1"	It is recommended to use the default value for this parameter.
a-9	The **Loading System** moves toward the **Cassette** along the **X-Axis** (relative backward). This further bends the plate.	...\Loading System\Load Plate\From Cassette To Punch Entry Stage "X Rel Backward For 03 (mm)"="25" Speed = 1	**Important:** Setting a high value for this parameter will cause the plate to be released. Where plate separation problems (double-loading) occur, it is preferable to increase the value of the following parameter to 2 or 3: Loading system/Load plate/From Cassette To Punch Entry Stage/"Number Of Plate Backward Separation". **Note:** This action is effective only if the **Backward Stopper Bar** in the cassette is properly positioned and secured.

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
a-10	The **Loading System** moves toward the **Drum** along the **X-Axis** until the plate is straight.	...\Loading System] "X Prepare to Catch Plate (mm)"="365"+"X Plate Rel Backward In Cassette (mm)"="0.1" Speed = 2 **For Dual Cassette Main Tray:** ...\Loading System] "X Prepare to Catch Plate (In Dual Cassette) For Main Tray (mm)"="370"+"X Plate Rel Backward In Cassette (mm)"="0.1" Speed = 2 **For Dual Cassette Upper Tray:** ...\Loading System] "X Prepare to Catch Plate (In Dual Cassette) For Upper Tray (mm)"="367"+"X Plate Rel Backward In Cassette (mm)"="0.1" Speed = 2	It is recommended to use the default value for this parameter.
a-11	The **XY Bar** moves up along the **Y-Axis** (relative up). This enables the system to verify that the plate is still secured by the suction cups based on whether the **Bar Flag Detector** is activated.	...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y After Plate Separation [mm]"="7"	It is recommended to use the default value for this parameter.
a-12	The **XY Bar** moves up along the **Y-Axis** to position the plate at, and slightly above the air nozzles. The air nozzles are activated and the paper, if still on the underside of the plate, is blown off.	...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Above Air Nozzle (mm)"="63"	If the paper is not blown off of the underside of the plate, the value for this parameter can be changed to position the plate just above the air nozzles. Increasing the value for this parameter causes the **XY Bar** to move further along the **Y-Axis** (lower). Decreasing the value causes the **XY Bar** to travel a shorter distance along the **Y-Axis** (the **XY Bar** is higher).

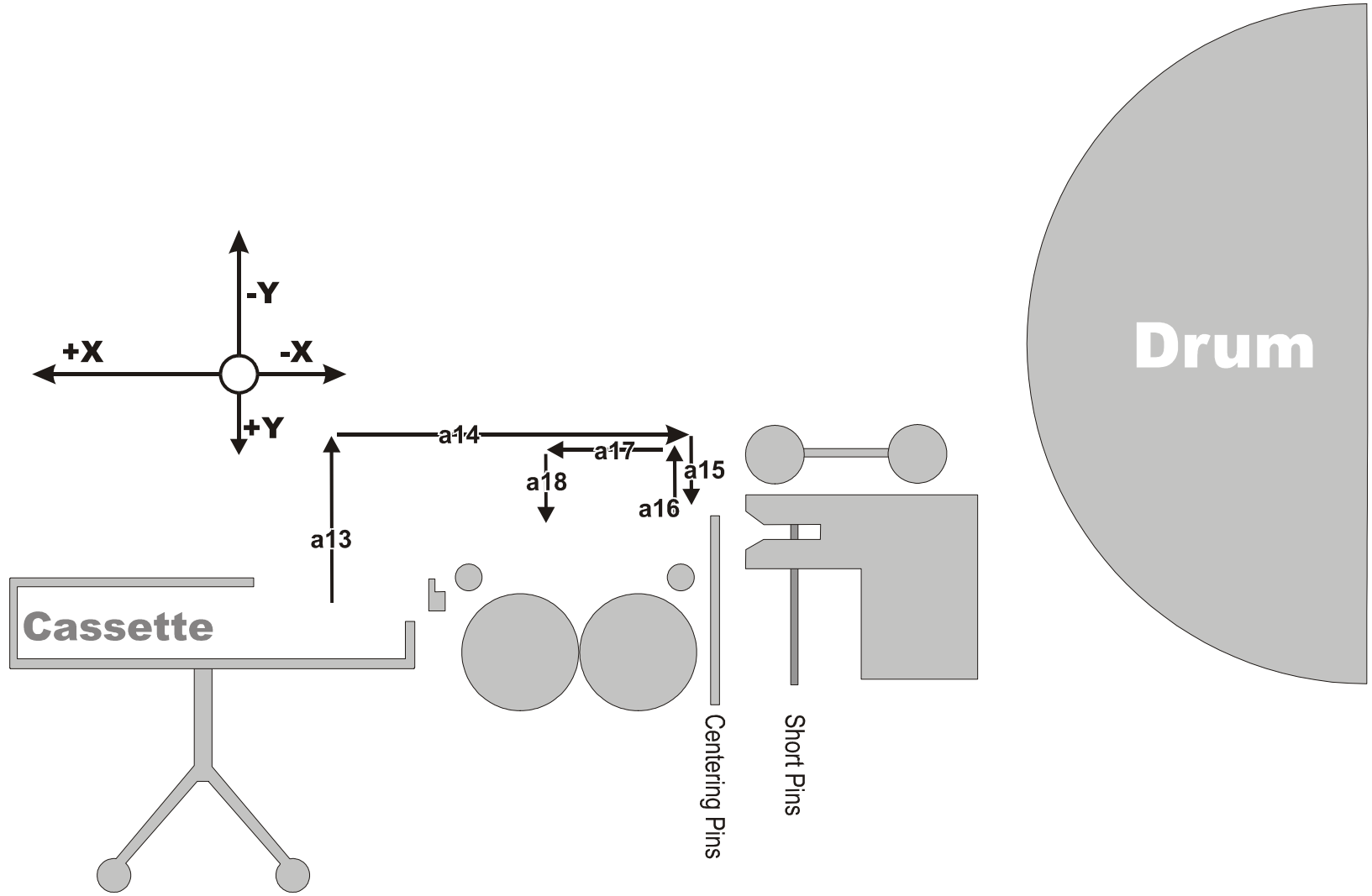


Figure 3: Cassette to Punch Entry (a-13 to a-18)

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
a-13	The **XY Bar** moves up along the **Y-Axis** to position the plate so that, when pulled out of the cassette, it will not be scratched or damaged.	...\Loading System\Loading System Setup "Prepare Y to catch Plate (mm)"="70"	**Important:** Verify that the plates slide easily out of the **Cassette** without hitting the **Cassette** frame. **Note:** The height of the plate must enable it to ride smoothly over the **Cassette Rollers** without resistance. Increasing the value for this parameter causes the **XY Bar** to move further along the **Y-Axis** (higher). Decreasing the value causes the **XY Bar** to travel a shorter distance along the **Y-Axis** (the **XY Bar** is lower).
a-14	The **Loading System** moves toward the **Drum** along the **X-Axis** until the **Leading Edge** of the plate is positioned in the **Centering Unit**.	...\Loading System\Loading System Setup "x In Punch (mm)"="125"	Decreasing the value for this parameter causes the **Loading System** to move further toward the **Drum** along the **X-Axis**. (This positions the plate closer to the **Punch**.) Increasing the value for this parameter causes the **Loading System** to move a shorter distance toward the **Drum**. (This positions the plate farther from the **Punch**.) **Important:** Verify that the **Leading Edge** of the plate is positioned at least 10 mm past the **Centering Pins** (toward the drum). **Note:** The **Disposal Rollers** are now activated. If paper was separated from the plate during motion **a-12**, it is now caught by the **Disposal Rollers** and transported into the **Paper Disposal Bin**.

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
a-15	The **XY Bar** moves down along the **Y-Axis** to further position the plate for entry into the **Punch(es)**. The plate is centered.	...\Loading System\Loading System Setup "y In Punch (mm)"="73" Speed = ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y In Punch Speed"="10" Speed = ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Centering Speed"="2"	This is the first of three times that the plate is centered.
a-16	The **Suction Cup Vacuum** is deactivated, the plate is released and the **XY Bar** moves up along the **Y-Axis** (relative up).	...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Up For Centering (mm)"="-15"+"Y Up After Punch (mm)"="-15"	It is recommended to use the default value for this parameter.
a-17	The **Loading System** moves toward the **Cassette** along the **X-Axis** in preparation for re-securing and lifting the plate.	...\Loading System\Load Plate\From Cassette To Punch Entry Stage "X Extra To Short Pins (mm)"="25" **For thinner plates:** ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "X Extra To Short Pins For 02 (mm)"="25" "X After Centering (mm)"="260"	This parameter defines the location at which the **XY Bar Suction Cups** re-secure the plate – the value represents the distance from the **Leading Edge**. Increasing the value for this parameter causes the **Loading System** to move further toward the **Cassette** along the **X-Axis**. (This positions the plate closer to the **Punch** in motion **a-22**.) Decreasing the value for this parameter causes the **Loading System** to move a shorter distance toward the **Cassette**. (This positions the plate farther from the **Punch** in motion **a-22**.)
a-18	The **XY Bar** moves down along the **Y-Axis**.	...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Down For Second Centering (mm)"="75"	Increasing the value for this parameter causes the **XY Bar** to move further downward along the **Y-Axis**. Decreasing the value causes the **XY Bar** to travel a shorter distance along the **Y-Axis**.

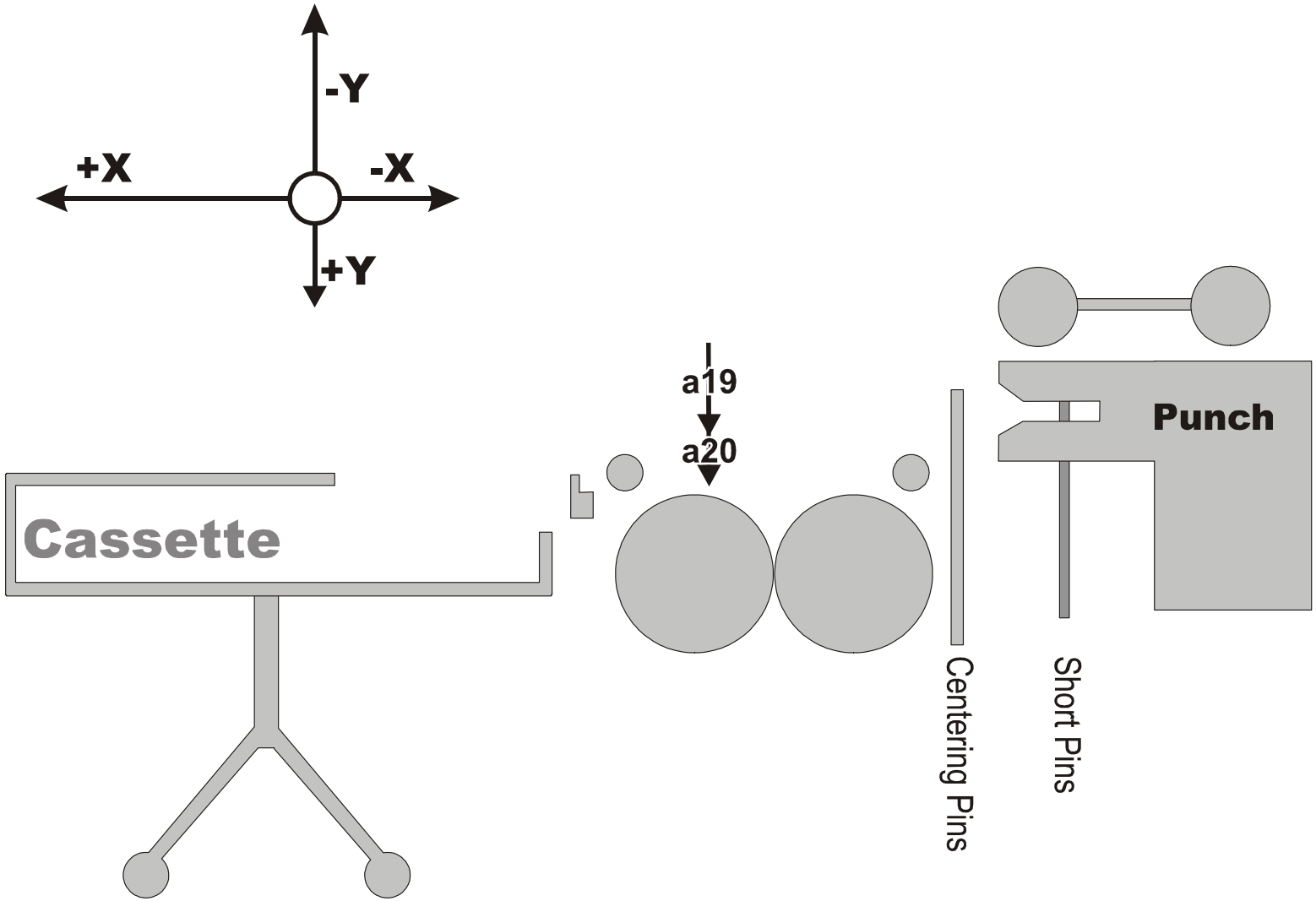


Figure 4: Cassette to Punch Entry (a-19 to a-20)

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
a-19	The **XY Bar** moves further downward along the **Y-Axis** until the **Bar Flag Detector** is activated.	Speed = ...\Loading System\Loading System Setup "Y to detector Speed"="12.6"	It is recommended to use the default value for this parameter.
a-20	The **XY Bar** moves further downward along the **Y-Axis** and the **Suction Cup Vacuum** is activated, securing the plate to the **XY Bar Suction Cups**.	...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Down After Punch (mm)"="11" **For thinner plates**...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Down After Punch For 0.15 (mm)"="5" Speed = ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Down After Punch Speed"="4"	It is recommended to use the default value for this parameter. **Important:** Verify that the **XY Bar Suction Cups** do not exert excessive pressure on the plate: this can cause scratches in the emulsion.

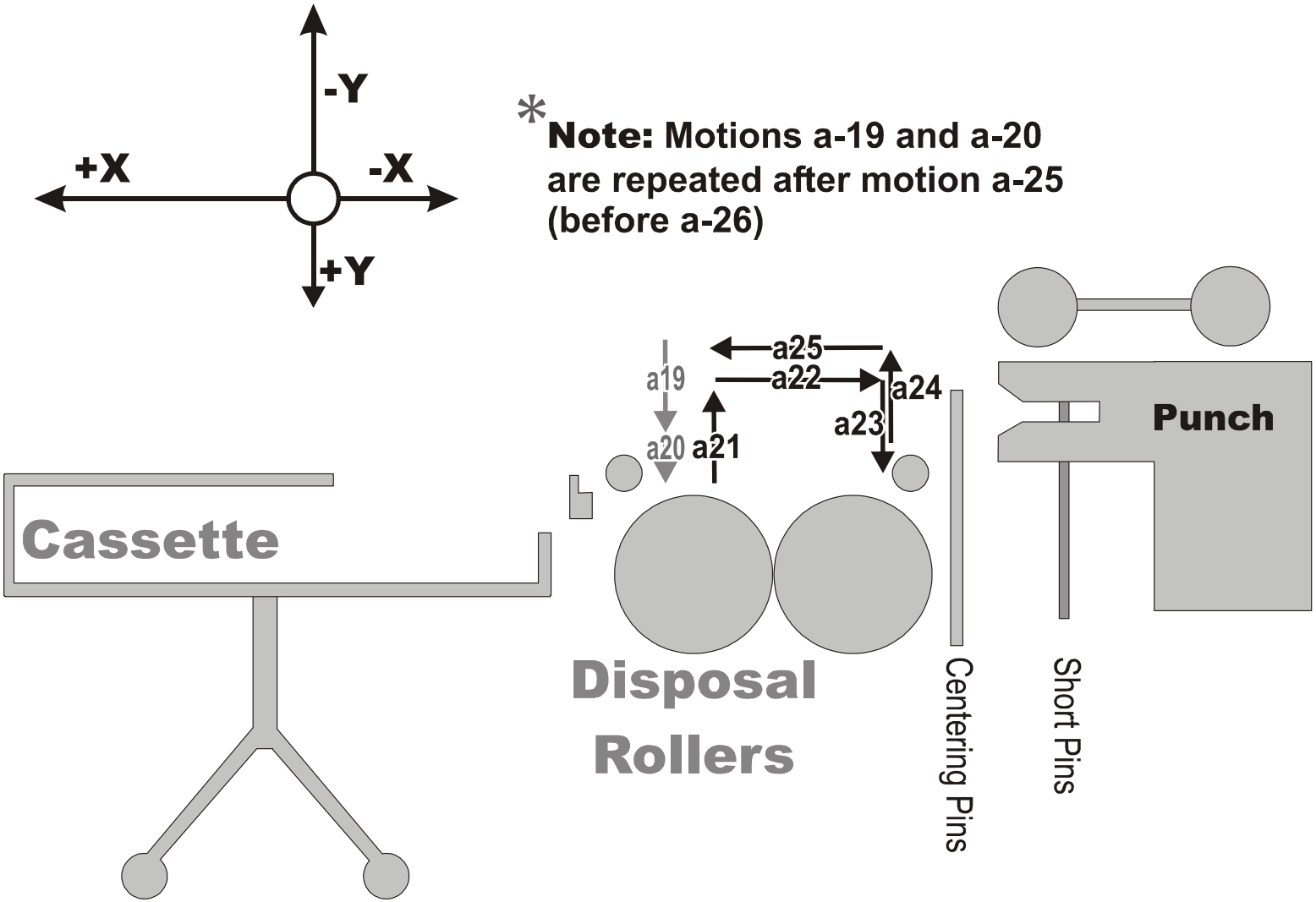


Figure 5: Cassette to Punch Entry (a-21 to a-25, and a-19 to a-20)

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
a-21	The **XY Bar** moves up along the **Y-Axis** to center the **Leading Edge** of the plate in the **Punch Guide(s)**.	Loading System\Loading System Setup "y Enter To Punch (mm)"="74 **For thinner plates:** ...\Loading System\Loading System Setup "y Enter To Punch For 02 (mm)"="75 Speed = ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y In Punch Speed"="10	**Important:** Verify that the leading edge of the plate is positioned between the upper and lower parts of the **Punch Guide(s)**.
a-22	The **Loading System** moves slightly toward the **Drum** along the **X-Axis**, and the **Leading Edge** of the plate is slightly inserted into the **Punch**.	...\Loading System\Load Plate\From Cassette To Punch Entry Stage "X Extra To Short Pins (mm)"="25" **For thin plates:** ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "X Extra To Short Pins For 02 (mm)"="25" Speed = ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "X Half Way Speed"="5" **Note:** These parameters are also applied to motion **a-17**.	Decreasing the value for this parameter causes the **Loading System** to move further toward the **Drum** along the **X-Axis**. (This positions the plate closer to the **Punch**.) Increasing the value for this parameter causes the **Loading System** to move a shorter distance toward the **Drum**. (This positions the plate farther from the **Punch**.)
a-23	The **XY Bar** moves down along the **Y-Axis**.	...\Loading System\Loading System Setup "y In Punch (mm)"="73" Speed = ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y In Punch Speed"="10"	It is recommended to use the default value for this parameter.
a-24	The **Suction Cup Vacuum** is deactivated, the plate is released and centered, and the **XY Bar** moves up along the **Y-Axis** (relative up).	...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Up For Centering (mm)"="-15"+"Y Up After Punch (mm)"="-15" Speed = ...\Loading System "Normal Speed"="127"	It is recommended to use the default value for this parameter.
a-25	The **Loading System** moves toward the **Cassette** along the **X-Axis**, in preparation for re-securing and lifting the plate.	...\Loading System\Load Plate\From Cassette To Punch Entry Stage "X In After Punch (mm)"="282" Speed = ...\Loading System "Normal Speed"="127"	**Important:** The **XY Bar Suction Cups** must be positioned directly over the highest point of either **Disposal Roller**. **Note:** **a-19** and **a-20** are repeated in the next two motions.

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
a-19	The **XY Bar** moves further downward along the **Y-Axis** until the **Bar Flag Detector** is activated.	Speed = ...\Loading System\Loading System Setup "Y to detector Speed"="12.6"	It is recommended to use the default value for this parameter.
a-20	The **XY Bar** moves further downward along the **Y-Axis** and the **Suction Cup Vacuum** is activated, securing the plate to the **XY Bar Suction Cups**.	...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Down After Punch (mm)"="11" **For thinner plates**...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Down After Punch For 0.15 (mm)"="5" Speed = ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Down After Punch Speed"="4"	It is recommended to use the default value for this parameter. **Important:** Verify that the **XY Bar** is not pressing the plate against the **Disposal Rollers**.

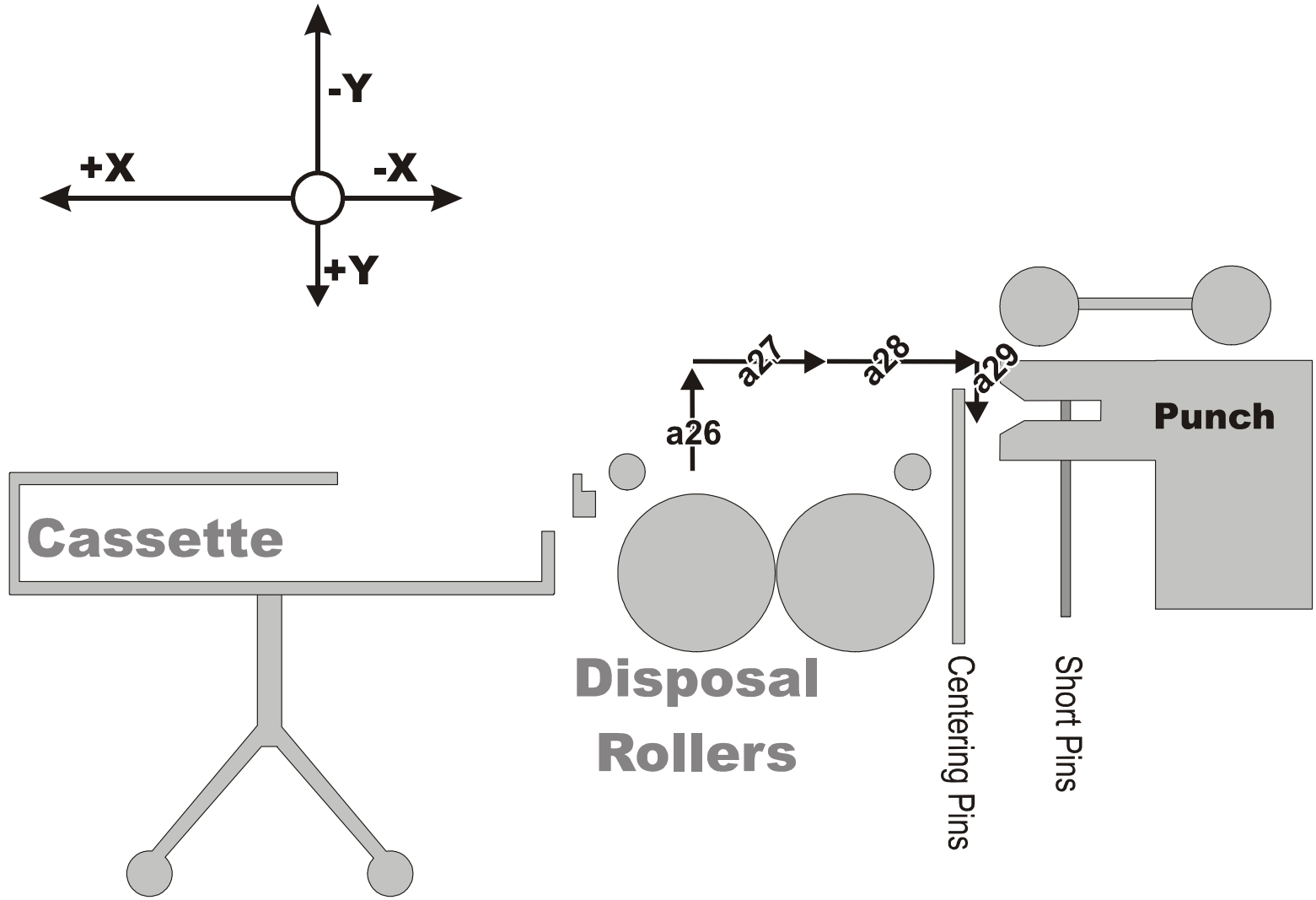


Figure 6: Cassette to Punch Entry (a-26 to a-29)

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
a-26	The **XY Bar** moves up along the **Y-Axis**.	...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "Y Up After Centering (mm)"="76 Speed = ...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "Y Up After Centering Speed"="10"	
a-27	The **Loading System** moves toward the **Drum** along the **X-Axis**, and the **Leading Edge** of the plate is further inserted into the **Punch(es)**.	...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "X After Centering (mm)"="270" Speed = ...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "X After Centering Speed"="5"	
a-28	The **Loading System** moves toward the **Drum**, a little at a time (see comment), along the **X-Axis** until the **Leading Edge** of the plate comes into contact with the **Short Pins**. The **Leading Edge** of the plate is now fully inserted into the **Punch(es)**, the plate is centered again.	...\Loading System\Loading System Setup "x Rep Extra In Punch (mm)"="-4" **For thinner plates:** ...\Loading System\Loading System Setup "x Rep Extra In Punch For 02 (mm)"="-4" Speed = ...\Loading System "Normal Speed"="127"	The **Loading System** moves toward the **Drum** a maximum of eight times (eight small movements). Ideally, the **Leading Edge** of the plate will come into contact with the **Short Pins** after three of these small movements have been completed. It is recommended to use the default value for this parameter.
a-29	The **XY Bar** moves slightly down along the **Y-Axis** to complete proper positioning of the **Leading Edge** in the **Punch(es)** , and the **XY Bar Suction Cup Vacuum** is deactivated.	...\Loading System\Loading System Setup "y In Punch (mm)"="73" Speed = ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y In Punch Speed"="10"	It is recommended to use the default value for this parameter.

Punch Entry to Drum Entry (b)

Table 2 describes each motion that occurs during the **Punch Entry to Drum Entry (b)** stage of the Lotem 800 loading sequence, in which the plate is fully inserted into the **Punch** and, after punching, it is removed from the **Punch** and transported to the **Drum Entry**.

The parameters that define the action and direction of each motion are listed in the **Location of Parameters in Registry and Values** column along with their default values. Any relevant comments are listed in the **Comments** column.

Note: When accessing parameters in the **Registry**, remember to add the base path to the beginning of each one, as described in Accessing Parameters in the Registry, on page 10.

The values entered for each of the parameters listed in Table 2 are examples only.

The figures listed below illustrate the motions described in Table 2, as follows:

- Figure 7 on page 31 illustrates motions **b-1** through **b-3**.
- Figure 8 on page 34 illustrates motions **b-4** through **b-9**.

Table 2: Stage 2: Motions and Parameters

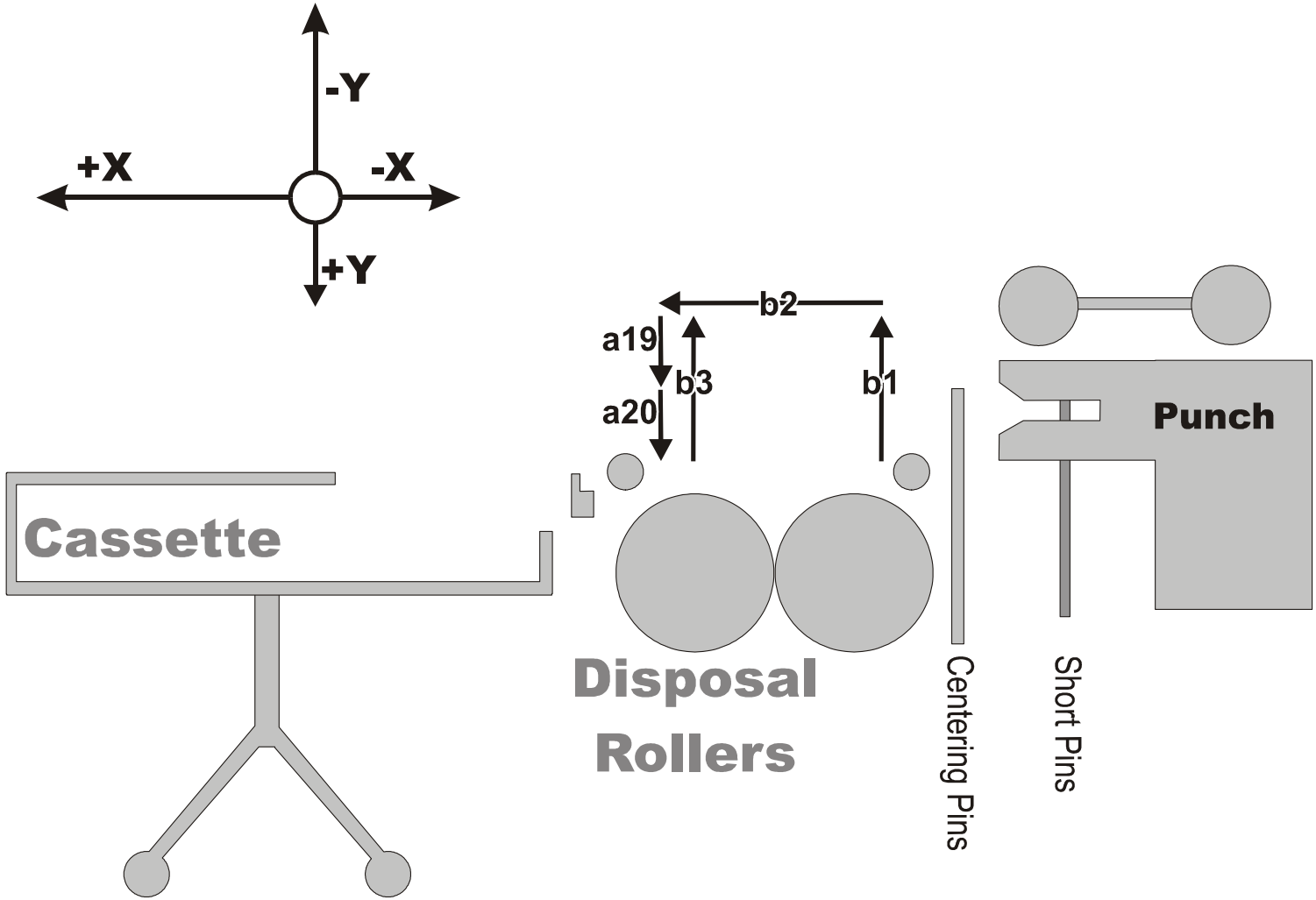


Figure 7: Punch Entry to Drum Entry (b-1 to b-3)

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
b-1	The **XY Bar** moves up along the **Y-Axis** (relative up) to a position that enables safe movement during **b-2**.	...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "Y Up For Re Catch (mm)"="-15" Speed = \Loading System\Load Plate\From Cassette To Punch Entry Stage "Y In Punch Speed"="10"	It is recommended to use the default value for this parameter.
b-2	The **Loading System** moves toward the **Cassette** along the **X-Axis**.	...\Loading System\Load Plate\From Punch Entry To Drum Entry Sage "X After Centering (mm)"="270"+"X Rel After Sec Centering (mm)"="5" Speed = ...\Loading System\Load Plate\From Punch Entry To Drum Entry Sage "X After Centering Speed"="5"	The value of this parameter determines where the **XY Bar Suction Cups** will secure the plate in the next motions. Increasing the value for this parameter will cause the plate to be secured farther from the **Leading Edge**. **Important:** Verify that, in motion **b-3**, the position of the **XY Bar Suction Cups** on the plate does not cause the **Leading Edge** to bend downward (the value is too high), or to curve upward (the value is too low).
a-19	The **XY Bar** moves further downward along the **Y-Axis** until the **Bar Flag Detector** is activated.	Speed = ...\Loading System\Loading System Setup "Y to detector Speed"="12.6"	It is recommended to use the default value for this parameter.
a-20	The **XY Bar** moves further downward along the **Y-Axis** and the **Suction Cup Vacuum** is activated, securing the plate to the **XY Bar Suction Cups**.	...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Down After Punch (mm)"="11" **For thinner plates**...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Down After Punch For 0.15 (mm)"="5" Speed = ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Down After Punch Speed"="4"	It is recommended to use the default value for this parameter.

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
b-3	The **XY Bar** moves up along the **Y-Axis** and the plate is slightly inserted into the **Punch**.	...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "Y Up After Centering (mm)"="76" Speed = ...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "Y Up After Centering Speed"="10"	It is recommended to use the default value for this parameter. **Note:** If the plate bends or folds, or the **Leading Edge** curves upward, refer to motion **b-2**.

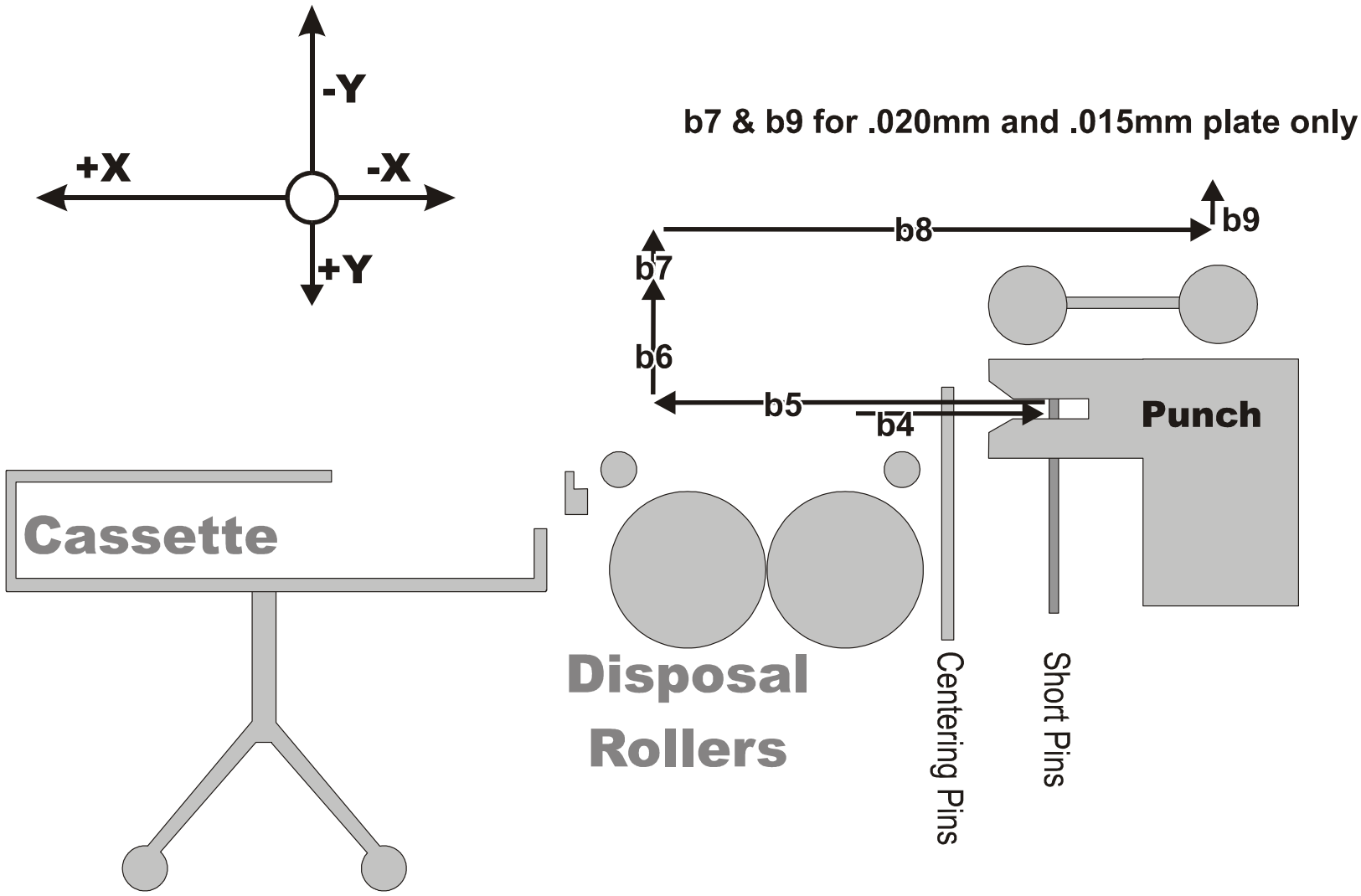


Figure 8: Punch Entry to Drum Entry (b-4 to b-9)

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
b-4	The **Loading System** moves toward the **Drum** along the **X-Axis** until the plate is fully inserted into the **Punch** and the **Leading Edge** comes into contact with the **Short Pins**. The **Punch** is activated.	...\Loading System\Loading System Setup "x Rep Extra In Punch (mm)"="-4" **For thin plates:** ...\Loading System\Loading System Setup "x Rep Extra In Punch For 02 (mm)"="-4" Speed = ...\Loading System "Normal Speed"="127"	It is recommended to use the default value for this parameter.
b-5	The **Loading System** moves toward the **Cassette** along the **X-Axis** to remove the plate from the **Punch**.	...\Loading System\Loading System Setup "X Prepare To Drum (mm)"="324" Speed = ...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "X Prepare To Drum Speed"="20"	**Important:** Verify that the plate is completely removed from the **Punch(s)**, and does not touch the **Punch Guide(s)** and/or **Plate Support**. This is especially important when using thin plates (0.15 mm and 0.2 mm). Increasing the value for this parameter will cause the **Loading System** to move a longer distance toward the **Cassette** (closer to the **Cassette**).
b-6	The **XY Bar** moves up along the **Y-Axis**.	...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "Y To Drum (mm)"="12 Speed = ...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "Y Prepare To Drum Speed"="2	This parameter determines the height of the plate during movement to the drum. Increasing the value for this parameter causes the **XY Bar** to travel a shorter distance upward (the plate is lower). Decreasing the value causes the **XY Bar** to travel further upward (the plate is higher). **Important:** Verify that the plate does not touch the **Plate Support Rollers** during this motion.

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
b-7 **Applies to thin plates only (0.15 to 0.2)**	The **XY Bar** moves further upward along the **Y-Axis**.	Speed = ...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "Y Rel For 0.2 Speed"="2"	It is recommended to use the default value for this parameter.
b-8	The **Loading System** moves toward the **Drum** along the **X-Axis** to just before the **Drum Entry**.	...\Loading System\Load Plate\From Drum Entry to Drum Stage "X Near To Drum (mm)"="140" Speed = ...\Loading System\Load Plate\From Drum Entry to Drum Stage "X In Drum Speed"="5"	The **Drum** rotates until it is positioned to secure the plate and the **Head Grippers** open. It is recommended to use the default value for this parameter.
b-9 **Applies to thin plates only (0.15 to 0.2)**	The **XY Bar** moves up a bit along the **Y-Axis**.	...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "Y To Drum For 02 (mm)"="17" **For thinner plates:** "Y To Drum For 015 (mm)"="16"	It is recommended to use the default value for this parameter.

Drum Entry to Drum (c)

Table 3 describes each motion that occurs during the **Drum Entry to Drum (c)** stage of the Lotem 800 loading sequence, in which the plate is moved 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.

The parameters that define the action and direction of each motion are listed in the **Location of Parameters in Registry and Values** column along with their default values. Any relevant comments are listed in the **Comments** column.

Note: When accessing parameters in the **Registry**, remember to add the base path to the beginning of each one, as described in Accessing Parameters in the Registry, on page 10.

The values entered for each of the parameters listed in Table 3 are examples only.

Figure 9 on page 38 illustrates motions **c-1** through **c-8**, as described in Table 3.

Table 3: Stage c: Motions and Parameters

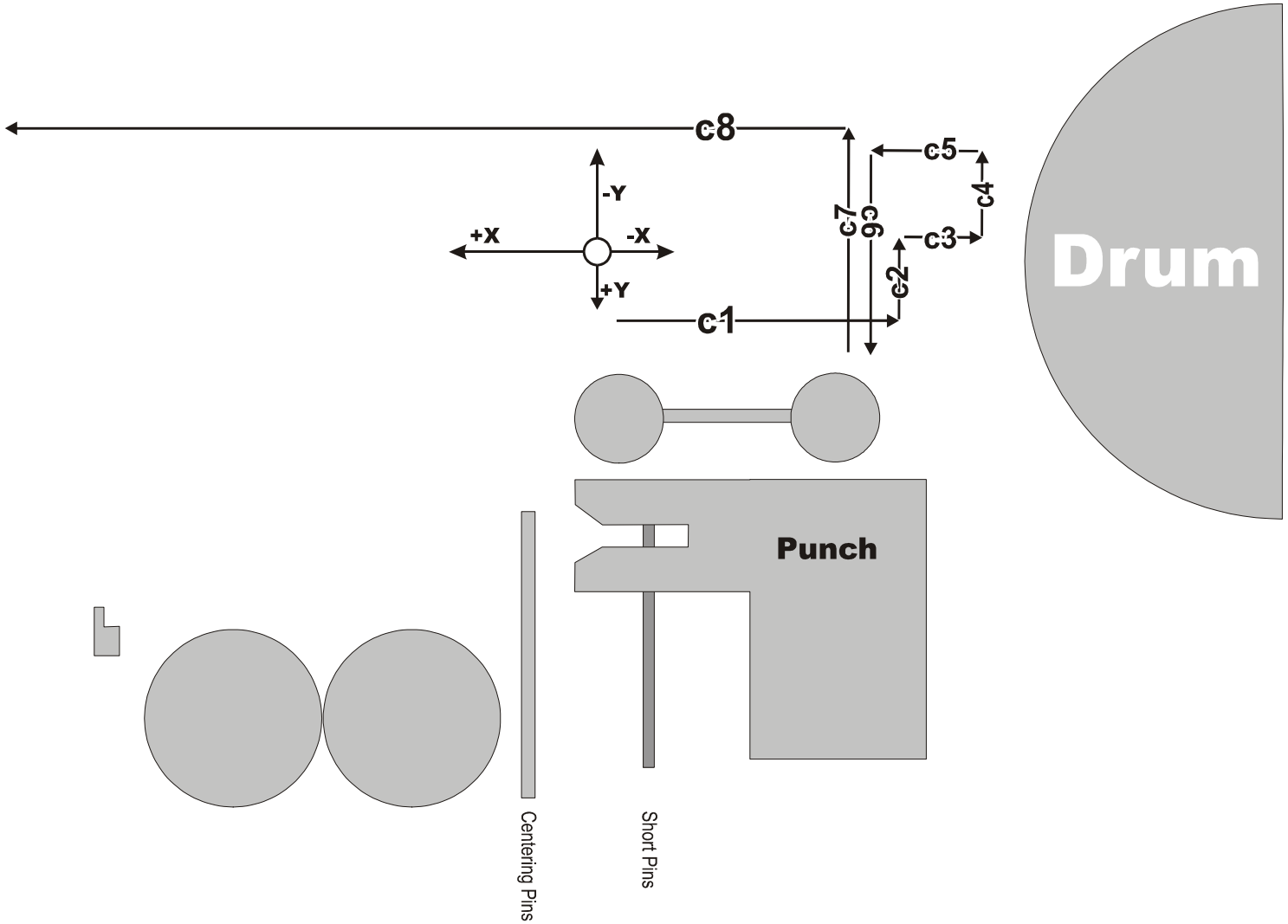


Figure 9: Drum Entry to Drum (c-1 to c-8)

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
c-1	The **Loading System** moves toward the **Drum** along the **X-Axis** to position the plate in front of the **Drum Pin**.	…\Loading System\Loading System Setup "X In Drum (mm)"="15" Speed = ...\Loading System\Load Plate\From Drum Entry to Drum Stage "X In Drum Speed"="5 **For thin plates:** ...\Loading System\Loading System Setup "X In Drum For 0.2(mm)"="20" Speed = ...\Loading System\Load Plate\From Drum Entry to Drum Stage "X In Drum Speed"="5"	Decreasing the value for this parameter moves the **Loading System** further along the **X-Axis** (the plate is moved closer to the **Drum Pin**). **Important:** The plate must be perfectly centered in the **Punch Notch** and positioned close to the **Drum Pin** (from 0.5 mm to 1 mm) before performing **c-3** (X in Drum Final).
c-2	The **XY Bar** moves up along the **Y-Axis** (relative up) to position the plate for insertion into the **Head Grippers**.	...\Loading System\Load Plate\From Drum Entry to Drum Stage "Y Before Extra to Drum (mm)"="-4" Speed = ...\Loading System "Normal Speed"="127"	It is recommended to use the default value for this parameter.
c-3	The **Loading System** moves toward the **Drum** (relative) along the **X-Axis**, until the plate is inserted into the **Head Grippers** and the **Punch Notch** is pressed against the **Drum Pin**.	...\Loading System\Loading System Setup "X In Drum Final (mm)"="-10" Speed = ...\Loading System "Normal Speed"="127" **For 0.2 thin plates:** ...\Loading System\Loading System Setup "X In Drum Final For 0.2 Plates (mm)"="-8" Speed = ...\Loading System "Normal Speed"="127" **For small plates (0.15mm):** ...\Loading System\Loading System Setup "X In Drum Final For Small Plates (mm)"="-8" Speed = ...\Loading System "Normal Speed"="127"	**Important:** Verify that the plate is held firmly against the **Drum Pin**. If it is not, adjust as described in the TIC procedure.
c-4	The **XY Bar** moves up along the **Y-Axis** (relative additional up). The **Leading Edge** of the plate is inserted into the **Head Grippers** and the **Head Grippers** close. The **Leading Edge** is secured on the **Drum**.	...\Loading System\Load Plate\From Drum Entry to Drum Stage "Y After Extra to Drum (mm)"="-2" Speed = ...\Loading System "Normal Speed"="127"	It is recommended to use the default value for this parameter.

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
c-5	The **Loading System** moves toward the **Cassette** along the **X-Axis**.	...\Loading System\Loading System Setup "X In Drum Final "="-10" Speed = ...\Loading System\Load Plate\From Drum Entry to Drum Stage "X In Drum Speed"="5"	The plate is still secured by the **XY Bar Suction Cups**. The **Loading System** moves back to the "X In Drum" (**c-1**) position. The distance that the **Loading System** moves toward the **Cassette** is determined by the value entered for the "X In Drum Final" (**c-3**) parameter
c-6	The **XY Bar** moves down along the **Y-Axis** to prevent the plate from bending as it is wound around the **Drum**. The **Suction Cup Vacuum** is deactivated and the plate is released.	...\Loading System\Load Plate\From Drum Entry to Drum Stage "Y Down Before Plate Drop Abs (mm)"="19" Speed = "2"	**Important:** The value for this parameter should not be set more than 2 or 3 numbers higher than the value for the "Y To Drum" (**b-6**, or for thinner plates, **b-9**) parameter. Increasing the value by too much causes the plate to be pulled out of the **Head Grippers**.
c-7	The **XY Bar** moves up along the **Y-Axis** to the highest possible position.	...\Loading System "Y Max Up (mm)"="0" Speed = ...\Loading System "Normal Speed"="127"	The **Drum** rotates, the plate is wrapped around the **Drum** and the **Tail Grippers** secure the **Tail Edge** of the plate.
c-8	The **Loading System** moves toward the **Cassette** along the **X-Axis** in preparation for loading the next plate.	...\Loading System\Load Plate\From Drum Entry to Drum Stage "X After Gripper (mm)"="352 Speed = ...\Loading System "Normal Speed"="127"	

Paper Disposal Task (d)

Table 4 describes each motion that occurs during the **Paper Disposal Task (d)** stage of the Lotem 800 loading sequence, which only occurs when paper is detected in the **Cassette**. In this stage, the **Loading System** removes the paper from the **Cassette** and transports it to the **Disposal System** which then deposits it into the **Disposal Bin**.

Note: The first five motions of the Lotem 800 Loading Sequence (**a-1** through **a-5**) are the same regardless of whether the next item to be removed from the **Cassette** is paper, or a plate, as described on pages 14 and 15. If paper is detected in the Cassette at the end of motion **a-5**, the Lotem performs the **Paper Disposal Task** (**d-1** through **d-13**), as described in this section.

The parameters that define the action and direction of each motion are listed in the **Location of Parameters in Registry and Values** column along with their default values. Any relevant comments are listed in the **Comments** column.

Note: When accessing parameters in the **Registry**, remember to add the base path to the beginning of each one, as described in Accessing Parameters in the Registry, on page 10.

The values entered for each of the parameters listed in Table 4 are examples only.

The figures listed below illustrate the motions described in Table 4, as follows:

- Figure 10 on page 42 illustrates motions **d-1** through **d-4**.
- Figure 11 on page 44 illustrates motions **d-5** through **d-13**.

Table 4: Stage d: Motions and Parameters

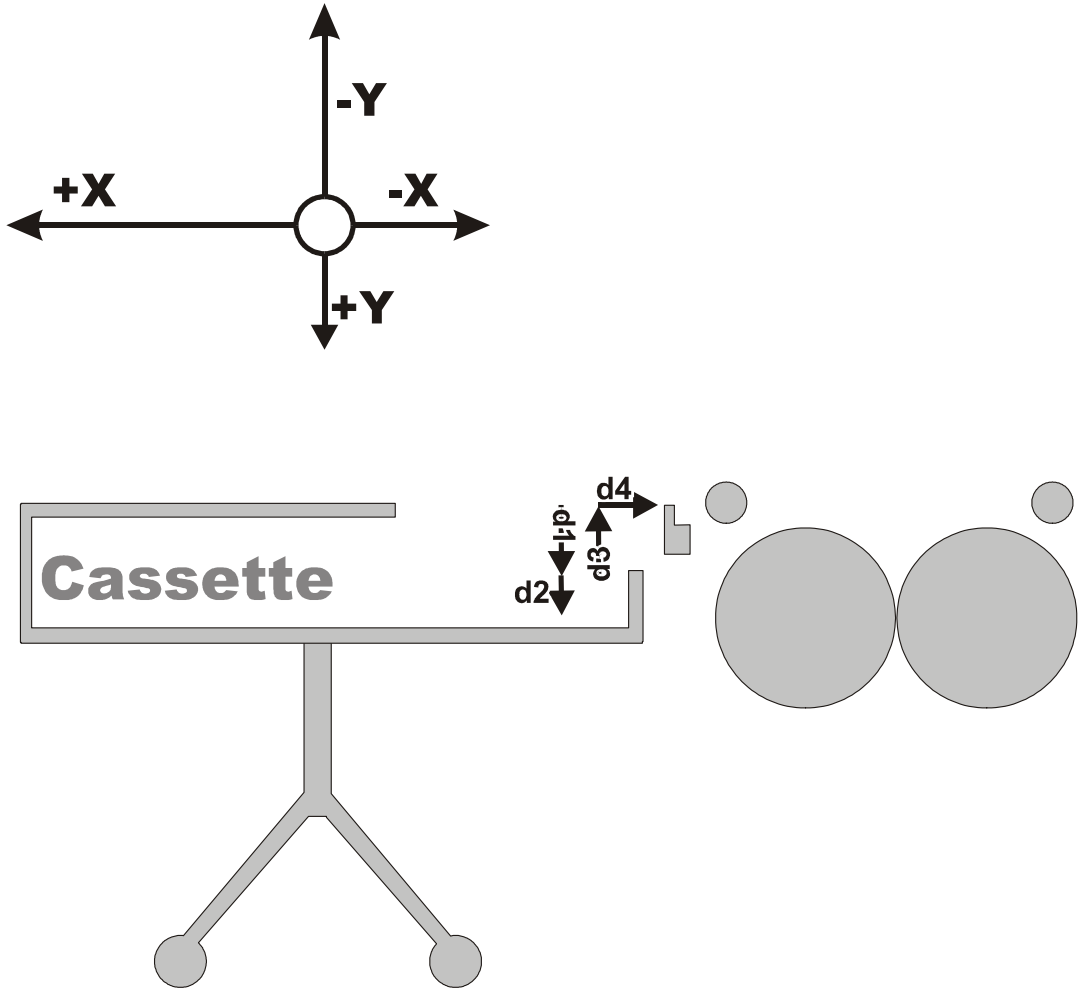


Figure 10: Paper Disposal Task (d-1 to d-4)

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
a-1 to a-5	Refer to pages 14 and 15 for details.	Refer to pages 14 and 15 for details.	The first five motions of the loading sequence are the same regardless of whether the next item to be removed from the **Cassette** is paper, or a plate. Refer to pages 14 and 15 for full details.
d-1	The **XY Bar** moves down along the **Y-Axis** until the **Bar Flag Detector** is activated and the suction cups press down on the paper.	Speed = ...\Loading System\Loading System Setup "Y to detector Speed"="12.6"	
d-2	The **XY Bar** moves further down along the **Y-Axis** (relative additional down).	...\Loading System / Loading System Setup /"Y Extra to Detector (mm)"="11"	
d-3	The **XY Bar** moves up along the **Y-Axis**.	...\Loading System\ Load plate/Paper Disposal "Y Down After Init catcher" ="45"	
d-4	The **Loading System** moves toward the **Cassette** along the **X-Axis** until the **XY Bar** is positioned underneath the **Front Frame** (under the **X-Shaft**) of the **Lotem**.	...\Loading System\Load Plate/Paper Disposal "X For Open paper clips" (mm)"="392"	**Important:** The underside of the **Front Frame** includes two metal pads that are affixed over the **XY Bar Paper Clips**. Verify that the **XY Bar** is directly below the **Front Frame** and perfectly aligned with it so that the metal pads are positioned directly over the **XY Bar Paper Clips**. In addition, verify that the **Loading System** is positioned at least 10 mm from the **Front Door** latch securing screws.

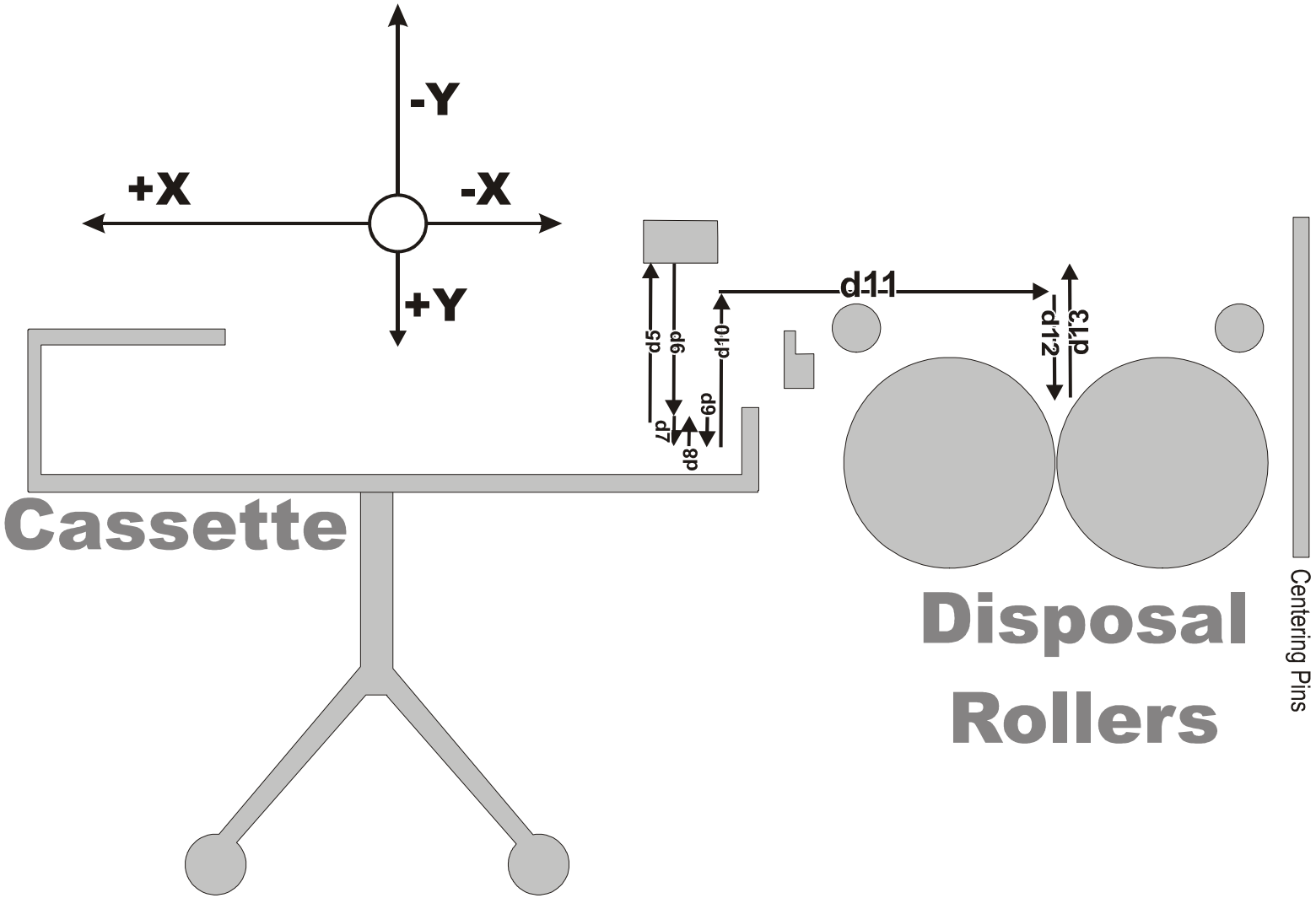


Figure 11: Paper Disposal Task (d-5 to d-13)

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
d-5	The **XY Bar** moves up along the **Y-Axis** until it presses against the underside of the **Front Frame**.	...\Loading System\"Y Max Up (mm)"=" 0"	When the **XY Bar** presses upward against the **Front Frame**, the top of the **Paper Clips** are pressed against the two metal pads which causes the clips to move downward in the **XY Bar**. As the **Paper Clips** move downward, they open.
d-6	The **XY Bar** moves down along the **Y-Axis** until the **Bar Flag Detector** is activated.	Speed = ...\Loading System\Loading System Setup "Y to detector Speed"="12.6"	As the **XY Bar** moves down, the **Paper Clips** are pressed upward in the **XY Bar**. As they begin to close, the paper is pinched by the **Paper Clips**.
d-7	The **XY Bar** moves further down along the **Y-Axis** (relative additional down).	...\Loading System\Loading System Setup "Paper Y Down In Cassette (mm)"="6" Speed = \Loading System\Loading System Setup "Y Extra to detector Speed"="5"	**Important:** ***Change the default value for this parameter from 35 to 6.***
d-8	The **XY Bar** moves slightly up along the **Y-Axis**.	...\Loading System\Load Plate\Paper Disposal Stage "Y Up After paper down in cassette (mm)"="-5"	
d-9	The **XY Bar** moves further down along the **Y-Axis** (relative additional down).	"Y Up After paper down in cassette (mm)"="-5" + "Paper Y Down In Cassette (mm)"="6"	The **Paper Clips** close and the paper is held securely.
d-10	The **XY Bar** moves up along the **Y-Axis** and the **Disposal Rollers** are activated.	...\Loading System\Load Plate\Paper Disposal Stage "Y High Up “ = “40”	The paper is lifted.
d-11	The **Loading System** moves toward the **Drum** to position the paper over the **Disposal Rollers**.	...\Loading System\Loading System Setup "X paper in motor (mm)"="210.8"	**Important:** Verify that the paper is positioned directly over and in between the two **Disposal Rollers**.

Motion	Description	Location of Parameters in Registry and Values	Comments and Tips
d-12	The **XY Bar** moves down along the **Y-Axis**.	...\Loading System\Loading System Setup "Y Paper Out Cassette (mm)"="98.5"	The paper is inserted into the **Disposal Rollers** and pulled downward into the **Disposal Bin**. As the paper is pulled, the **Paper Clips** are also pulled downward, causing them to open and release the paper. **Important:** Verify that the **XY Bar Suction Cups** do not touch the **Disposal Rollers**.
d-13	The **XY Bar** moves up along the **Y-Axis**.	...\Loading System "Y Max Up (mm)"="0"	

Appendix A

Appendix A lists all Lotem 800 loading sequence parameters in alphabetical order, along with the motion that they govern and the page on which a description of the motion can be found. On each page, you will also find relevant comments and tips.

Parameters in Registry

Paper Y Down In Cassette (mm)"="6
d-9 45
Paper Y Down In Cassette (mm)"="6" Speed = \Loading System\Loading System Setup "Y Extra to detector Speed"="5
d-7 45
Prepare Y to catch Plate (mm)"="70
a-13 21
a-2 14
Speed = ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Centering Speed"="2
a-15 22
Speed = ...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "Y Rel For 0.2 Speed"="2
b-7 36
Speed = ...\Loading System\Loading System Setup "Y to detector Speed"="12.6
a-19 ..... 24, 27
d-1 43
d-6 45
Tilted Paper Metal Detector Y Relative Position"="-5
a-5 15
X After Centering (mm)"="270" Speed = ...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "X After Centering Speed"="5
a-27 29
X After Centering (mm)"="270"+"X Rel After Sec Centering (mm)"="5" Speed = ...\Loading System\Load Plate\From Punch Entry To Drum Entry Sage "X After Centering Speed"="5
b-2 32

X After Gripper (mm)"="352 Speed = ...\Loading System "Normal Speed"="127
c-8 40
X Extra To Short Pins (mm)"="25
a-17 22
a-22 26
X Extra To Short Pins For 02 (mm)"="25" "X After Centering (mm)"="260
a-17 22
X Extra To Short Pins For 02 (mm)"="25" Speed = ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "X Half Way Speed"="5
a-22 26
X For Open paper clips” (mm)"="392
d-4 43
X In After Punch (mm)"="282" Speed = ...\Loading System "Normal Speed"="127
a-25 26
X In Drum (mm)"="15" Speed = ...\Loading System\Load Plate\From Drum Entry to Drum Stage "X In Drum Speed"="5
c-1 39
X In Drum Final "="-10" Speed = ...\Loading System\Load Plate\From Drum Entry to Drum Stage "X In Drum Speed"="5
c-5 40
X In Drum Final (mm)"="-10" Speed = ...\Loading System "Normal Speed"="127
c-3 39
X In Drum Final For 0.2 Plates (mm)"="-8" Speed = ...\Loading System "Normal Speed"="127
c-3 39
X In Drum Final For Small Plates (mm)"="-8" Speed = ...\Loading System "Normal Speed"="127
c-3 39
X In Drum For 0.2(mm)"="20" Speed = ...\Loading System\Load Plate\From Drum Entry to Drum Stage "X In Drum Speed"="5
c-1 39
x In Punch (mm)"="125
a-14 21
X Near To Drum (mm)"="140" Speed = ...\Loading System\Load Plate\From Drum Entry to Drum Stage "X In Drum Speed"="5
b-8 36
X paper in motor (mm)"="210.8
d-11 45

X Plate Rel Backward In Cassette (mm)"="0.1" Speed= ...\Loading System "Normal Speed"="127
a-7 18
X Position In Cassette (mm)"="350
a-1 14
X Prepare to Catch Plate (In Dual Cassette) For Main Tray (mm)"="370
a-3 14
X Prepare to Catch Plate (In Dual Cassette) For Main Tray (mm)"="370"+"X Plate Rel Backward In Cassette (mm)"="0.1" Speed = 2
a-10 19
X Prepare to Catch Plate (In Dual Cassette) For Upper Tray (mm)"="367
a-3 14
X Prepare to Catch Plate (In Dual Cassette) For Upper Tray (mm)"="367"+"X Plate Rel Backward In Cassette (mm)"="0.1" Speed = 2
a-10 19
X Prepare to Catch Plate (mm)"="365
a-3 14
X Prepare to Catch Plate (mm)"="365"+"X Plate Rel Backward In Cassette (mm)"="0.1" Speed = 2
a-10 19
X Prepare To Drum (mm)"="324" Speed = ...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "X Prepare To Drum Speed"="20
b-5 35
X Rel Backward For 03 (mm)"="25" Speed = 1
a-9 18
x Rep Extra In Punch (mm)"="-4
a-28 29
b-4 35
x Rep Extra In Punch For 02 (mm)"="-4" Speed = ...\Loading System "Normal Speed"="127
a-28 29
b-4 35
Y Above Air Nozzle (mm)"="63
a-12 19
Y After Extra to Drum (mm)"="-2" Speed = ...\Loading System "Normal Speed"="127
c-4 39

Y After Plate Separation [mm]"="7
a-11 19
Y Before Extra to Drum (mm)"="-4" Speed = ...\Loading System "Normal Speed"="127
c-2 39
Y Down After Init catcher" ="45
d-3 43
Y Down After Punch (mm)"="11
a-20 ..... 24, 27, 32
Y Down After Punch For 0.15 (mm)"="5" Speed = ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Down After Punch Speed"="4
a-20 ..... 24, 27, 32
Y Down Before Plate Drop Abs (mm)"="19" Speed = "2
c-6 40
Y Down For Second Centering (mm)"="75
a-18 22
y Enter To Punch (mm)"="74
a-21 26
y Enter To Punch For 02 (mm)"="75 Speed = ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y In Punch Speed"="10
a-21 26
Y Extra to Detector (mm)"="11
d-2 43
Y Extra to detector (mm)"="14
a-6 17
Y Extra to detector For 015 (mm)"="7" Speed = ...\Loading System\Loading System Setup "Y Extra to detector Speed"="5"
a-6 17
Y High Up “ = “40
d-10 45
y In Punch (mm)"="73 Speed = ...\Loading System\Load Plate\From Cassette To Punch Entry Stage 29
y In Punch (mm)"="73" Speed = ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y In Punch Speed"="10"
a-15 22
a-23 26

Y Max Up (mm)"=" 0
d-5 45
Y Max Up (mm)"="0
d-13 46
Y Max Up (mm)"="0" Speed = ...\Loading System "Normal Speed"="127
c-7 40
Y Paper Out Cassette (mm)"="98.5
d-12 46
Y Plate High Up In Cassette (Rel) (mm)"="-45"+"Y Plate Rel Up In Cassette (mm)"="-16" Speed= ...\Loading System\Load Plate\From Cassette To Punch Entry Stage "Y Plate High Up In Cassette (Rel) Speed"="1
a-8 18
Y Rel For 0.2 Speed"="2
b-7 36
Y to detector Speed"="12.6
a-19 ..... 24, 27, 32
a-4 15
d-1 43
d-6 45
Y To Drum (mm)"="12 Speed = ...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "Y Prepare To Drum Speed"="2
b-6 35
Y To Drum For 015 (mm)"="16
b-9 36
Y To Drum For 02 (mm)"="17
b-9 36
Y Up After Centering (mm)"="76 Speed = ...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "Y Up After Centering Speed"="10
a-26 29
Y Up After Centering (mm)"="76" Speed = ...\Loading System\Load Plate\From Punch Entry To Drum Entry Stage "Y Up After Centering Speed"="10
b-3 33

Y Up After paper down in cassette (mm)"="-5
d-8 45
Y Up After paper down in cassette (mm)"="-5" +
d-9 45
Y Up For Centering (mm)"="-15"+"Y Up After Punch (mm)"="-15
a-16 22
Y Up For Centering (mm)"="-15"+"Y Up After Punch (mm)"="-15" Speed = ...\Loading System "Normal Speed"="127
a-24 26
Y Up For Re Catch (mm)"="-15\ Speed = \Loading System\Load Plate\From Cassette To Punch Entry Stage
b-1 32

