Setting the Slip Sheet Picker (Wedgemaster) Vacuum Threshold

Applies to

Trendsetter VLF Autoloader

Background

Just before the slip sheet picker attempts to pick a slip sheet, the vacuum is turned on with both cups open and away from the slip sheet. (For example, if the slip sheet is on the top of the lower plate, the icup and ocup will both be turned upwards.)

The system then checks that the open cup vacuum reading is not already above the threshold set in VAL SSVTH.

Steps

To set the slip sheet picker vacuum threshold (SSVTH)

Note: These steps can now also be done using the firmware command cal picker.

1. Initialize the picker
2. Idle the picker, using "picker idle", and then physically drag it to the middle of the table where it is convenient to work.
3. Type "picker" and note the value of the slip sheet picker vacuum level ("Open_vacuum"). It should be less than 100.
4. Type the following commands in the order given:
    a. picker ss icup up
    b. picker ss ocup up
    c. picker ss vac on
    d. picker ss down
5. Type "picker" and write down the slip sheet picker vacuum level ("Open_vacuum").

    Repeat this step to ensure that the reading is consistent.
6. Cover the mouth of the slip sheet picker lightly with a smooth piece of slip sheet. Do not press the slip sheet into the mouth; just let the vacuum pull it in as far as it can on its own.
7. Type "picker" and write down the slip sheet picker vacuum level ("Covered_vacuum").

    Repeat this step to ensure that the reading is consistent.
8. Calculate the slip sheet vacuum threshold (SSVTH) as follows:

$$\frac{(3*\text{Open_vacuum}) + (2*\text{Covered_vacuum})}{5}$$

    Typically, this value will be around 300, but it can vary by +/- 50.

9. Set SSVTH to the value calculated in Step 8.

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