

Halving of sheets




How to program the halving of sheets.

Benefits for the customer

- Faster operation of the cutting machine
- Improved production quality

Description

Now and then you have to deal with material which needs to be cut in two before any further processing. If the material meets the demand of the finishing process as far as its squareness and dimensional accuracy is concerned, it can be halved right away. Otherwise, it is necessary to make an angular cut first of all. Make sure to adjust the proper clamping pressure before starting the program. Example of a program for halving the material, with jogging mark and programmable ejector:

1 R:	JOGGING MARK	
2	55.000	
3	99.500	
4	49.750	
5 PE	30.000	

In order to feed the paper more easily, start with the jogging mark (55.000). The paper is cut on the short side. For this purpose, align the paper against the backgauge and one side gauge. In our example this cut is made at a position of 99.5 cm.

After the initial cut has been carried out, the material is halved. The backgauge moves the paper to the programmed position. In our example the second cut is made after a brief alignment at a position of 49.750 cm.

It is recommendable to add the function "Align material" to this position. When this function is used the clamp does not return to its upper home position once the cut is finished, but holds the rear ream according to a preset time period. This allows the operator to align the cut material against the rear ones. The "programmable ejector" function helps to take the material to a position where it can be conveniently unloaded.

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