Gapper to Switch Calibration on Twin-Trak Conveyors

PROBLEM: Replacement of sensor or recalibration.

This procedure is used to calibrate the distance from a gapper to the first switch on a simple Routing Control used in Motor Control/Routing Control 1911A25451. The system is designed to operate in any of three different ways:

1. Switch when the Photo eye on the switch sees a gap.

2. Switch when a gap is made and a calibrated number of SDWS pules has indicated the distance from gapper to the switch has expired.

3. Switch when the calibrated Distance has been counted and the photo eye sees the gap. When used in this manner the Calibrated Distance is set to slightly less than the position of the photo eye.

When using the photo eye only (1) method: Momentarily jumper PLC input 006 to 24 vdc. This clears any calibrated value from memory. Mount the photo eye so that it sees a gap just as the last newspaper in a batch clears the switch. Note: the photo eye is set to Light Operate so that it turns off when it sees a gap.

When using the calibrated number of SDS pulses (2) method:

Jumper Switch Calibrate input **006 to 24 v** dc.

Place a newspaper on the gapper skid plate so that the tail is just held by the upper clamp arm. Run the conveyor until the newspaper just clears the last Moveable Roller on the switch.

Remove the Jumper from **006**. The calibrated distance is now stored in PLC memory.

When using both the photo and calibrated distance (3):

Mount the photo eye as in Method 1

Calibrate the distance as in Method 2, except calibrate to a point where the newspaper just enters the switch.

- Test the distance by pressing the here/there switch during a Press run and observe when the actual switch occurs in relation to gap.