# Technical Note

<table>
<thead>
<tr>
<th>Product</th>
<th>Scitex XLjet</th>
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<tbody>
<tr>
<td>T/N #</td>
<td>16</td>
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<tr>
<td>Subject</td>
<td>ACS Software</td>
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<tr>
<td>Revision</td>
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<td>5</td>
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<td>Refer to T/N #</td>
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Overview

This technical note will show us how to use the ACS software. This may come in handy when diagnosing motion problems.

View Menu

The View menu is used to view useful information about the current status of the drivers. It contains the following options:

Current Position

This option enables you:

- To view the current position in encoder pulses of a specific motor. To do this, select the desired motor from the drop-down menu.
- To reset to Zero (for troubleshooting purposes). This is needed to set the cleaning station point (Zero point) in pulses. To do this:
  1. Place the head carriage at the desired cleaning station point.
  2. Reset to Zero by pressing the 0 button in the Current Position window.
  3. Exit the ACS Adjuster application.
  4. Open the XLjet software.
  5. From the Tools menu, select Calibration.
  6. Click Set Cleaning Station Point.
  7. Move the head carriage 1 meter.
  8. Click Set Meter Point.
Safety Signals

This option displays the current status (safety signals) of each axis: left and right limit switches, emergency stop, and the status of the driver.

Normally, for X and Y both switches and Emergency stop should be OFF. For Z and T, both switches should be ON, and Emergency stop OFF.

To check the ACS proper functioning, activate any limit switch; its status must be changed to the opposite. You can also invert the status by pressing the Invert button.

Communication Terminal

Note: The commands should be written in uppercase letters.

This option lets you communicate with ACS via the terminal window. To write commands, click the Edit icon.
Start/Stop Commands

- **KX** – immediately stops the X axis motion
- **KY** – immediately stops the Y axis motion
- **KZ** – immediately stops the Z axis motion
- **KT** – immediately stops the T axis motion
- **SXMO** – turns off the X drive
- **SYMO** – turns off the Y drive
- **SZMO** – turns off the Z drive
- **STMO** – turns off the T drive
- **SXMO1** – turns on X drive
- **SYMO1** – turns on Y drive
- **SZMO1** – turns on Z drive
- **STMO1** – turns on T drive

Commands to Move X and Y

- **SXMM0RP………BX** – causes the X-axis to move …… pulses.

  For example, approx. 93,000 pulses in the X position move the head carriage 1 meter (type SXMM0RP93000BX and press Enter). To move the head carriage 2 meters, type SXMM0RP186000BX and press Enter.

  To move the head carriage from right to left, you must add a “-” before the number.

- **SYMM0RP………BY** – causes the Y-axis to rotate …… pulses.

  *Note: At least a seven-figure number should be entered when attempting to rotate the Y-axis.*

  For example, to begin rotation of the Y-axis, type SYMM0RP1000000BY and press Enter.

Commands to Move Z and T

- **SZDA…… causes Z-axis to rotate with …… tension.**
- **STDA…… causes T-axis to rotate with …… tension.**

The tension ranges from -511 to +511.

For example, **SZDA120** causes Z-axis to rotate with 120 tension.
Status Commands

- **T** – displays the current status of all drivers.
- **T1** – displays the results of the last begin motion.
- **T2** – displays the results of the last end motion.

ACSPL Menu

Use the **Run** option from the ACSPL menu to run several useful commands such as **INIT**, **HOME**, etc.

For example, to perform INIT, select **INIT** from the list and click **OK**.