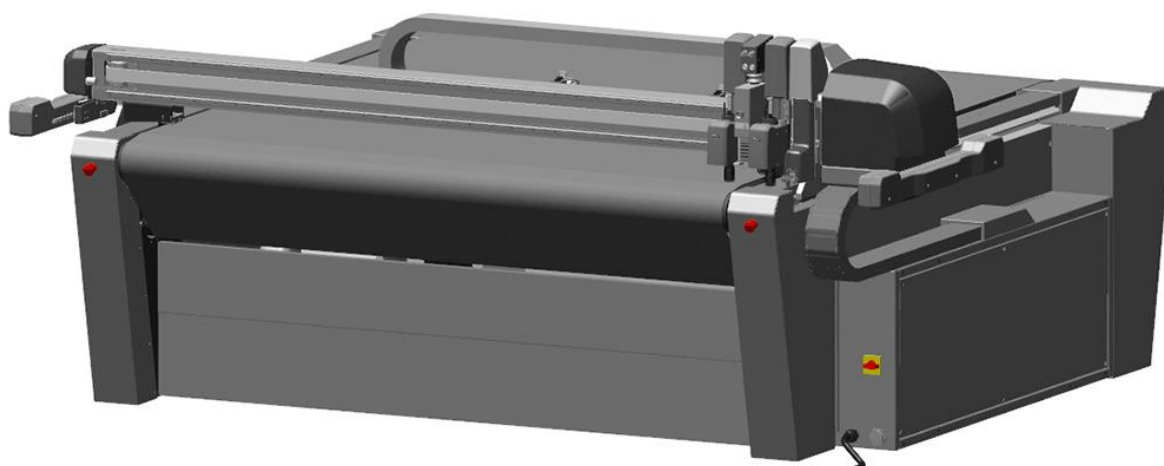




Flatbed Cutters



User manual
Rev 019

FCC Notice

The F Series tables have been tested and found to comply with the limits for Class A digital devices, pursuant to Part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference when the equipment is operated in a commercial environment. The cutters generate, use and can emit radiofrequency energy, and if not installed and used in accordance with the instruction manual, may cause harmful interference to radio communications. The user assumes the risk of any harmful interference caused by operating the cutters in a residential area.

Caution!

Changes or modifications, not expressly approved by Summa's FCC compliance, could void the user's authority to operate this equipment.

DOC Notice

The F Series do not exceed the Class A limits for radio noise for digital apparatus, set out in the Radio Interference Regulations of the Canadian Department of Communications.

Notice

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Waste Electrical and Electronic Equipment (WEEE) Directive

The symbol (right) is shown on this product. It indicates that the product should not be placed in municipal waste but should be disposed of separately. Electrical and electronic equipment can contain materials, which are hazardous to the environment and human health, and therefore should be disposed of at a designated waste facility or returned to your retailer for the appropriate recycling to take place.



If you wish to dispose of this product and the product still functions, please consider recycling/reusing it by donating it to a charity shop, selling it or exchange parts of it with your retailer.

Registering the Flatbed Cutter

Please register the Flatbed Cutter on the following link:

<https://www.summa.com/support/product-registration/>

Failure to register the cutter may result in a delayed response to warranty and service inquiries.

Revision Overview

Revision	Reason for modification	Publication date	Author
019	Update for F1625	April 2025	AL

F SERIES™

Welcome

Congratulations on Your Purchase of the New F Series cutting table

The F Series flatbed cutting tables are capable of cutting rigid materials as well as roll stock.

Up to three tool holders can be inserted at one time on the multi-module tool holder. Changing tools is quick and easy. Automatic tool recognition, combined with digital and mechanical depth control, ensures precision cutting on a wide variety of materials.

The cutting table base unit comes equipped with a drag knife tool module and an optical camera recognition system for accurate contour cutting of printed flexible or rigid substrate materials. A laser pointer is also included for manual origin registration.

A variety of tools, modules and blades are also available, depending on different applications.

For roll stock, the media handling support rollers and the conveyor system will make cutting over long distances a child's play.



This manual gives an overview about the main parts and modules of the F Series. Also, safety precautions are explained. Please refer to the general reference guide and documentation, if delivered with the optional modules, for more detailed information on handling and maintenance of the parts.

F SERIES™

Table of Contents

1	Machine components.....	1
1.1	Safety and Ideal Operating Environment	1
1.1.1	Safety	1
1.1.1.1	General	1
1.1.1.2	Symbols used in this manual.....	1
1.1.1.3	Safety symbols on the machine	2
1.1.1.4	Safety precaution	3
1.1.1.5	Safety Features	8
1.1.1.6	Personal protective equipment.....	9
1.1.2	Operating environment.....	9
1.2	Flatbed Components	10
1.2.1	Front view.....	10
1.2.2	Rear View.....	11
1.2.3	Larger models	11
1.3	Modules	12
1.3.1	Camera unit.....	12
1.3.2	Drag head module.....	12
1.3.3	Tangential module.....	12
1.3.4	Rotary Module.....	13
1.3.5	Router module.....	13
2	Setting up modules / tools	14
2.1	Introduction.....	14
2.1.1	General remarks on the calibration of the tools	14
2.1.2	Automatic Depth Control	14
2.1.3	Installing / Removing a module.....	15
2.1.3.1	Installing a module	15
2.1.3.2	Removing a module	15
2.2	Tool/knife calibration with ADC	16
2.2.1	General calibrations with the ADC	16
2.3	Calibration of the drag module	17
3	Tandem Mode	18
4	Axis Control	19
4.1	Main Window.....	19
4.2	Media menu	21
4.3	Change Tool	21
4.4	Reset.....	22

4.5 Modules	22
4.6 Load	23
4.7 Menu	23
4.8 Events	23
4.9 Reboot	24
4.10 Color Axis Control icon	24
4.11 Axis Control options when table is busy cutting jobs from Summa GoProduce	24
5 GoProduce Flatbed Edition	25

1 MACHINE COMPONENTS

1.1 Safety and Ideal Operating Environment

1.1.1 Safety

1.1.1.1 General

The purpose of the user's manual is not only to explain the operating procedures in order to operate this machine. It also provides the owner, users and operators with precautionary procedures for safe and proper machine operation for its intended purpose.

All information in this manual must be read and understood before any attempt is made to operate the machine.

The manufacturer has no direct control over the machine operation and application. Proper safety practice is the sole responsibility of the owner, user and operator.

All instructions and safety warnings in this manual are based upon the use of this machine under proper operating conditions without alterations from the original design.

The proper use and the limits of the application of the cutting table depend on the module and tool, used in combination with the material.

Any use of the flatbed that is beyond the capabilities of the combination tool/material is considered as improper use and may result in injury and/or serious damage to the machine and will lead to loss of warranty.

The installation of the machine, accessories and spare parts must not be done by untrained or unauthorized persons. Also, the described maintenance procedures need to be followed and performed by trained personnel.

1.1.1.2 Symbols used in this manual



Warning with dark (red) symbol: Refers to immediate threat that can cause serious injuries and effects on health and safety.



Warning with light (yellow) symbol: Refers to a dangerous situation that can cause injuries and serious damage to the machine.



Attention with dark (red) symbol: Refers to useful information to prevent damage to the equipment and prolong the service life of the machine.



Attention with light (yellow) symbol: Refers to useful tips to enhance user-friendliness and make the work significantly easier.



Note: Can be considered as a general tip, something that is useful to know.

1.1.1.3 Safety symbols on the machine

Safety labels are used on some parts of the machine. They are explained below.

**Caution**

Servicing instructions are for use by qualified service personnel only. To reduce the risk of electric shock do not perform any servicing other than that contained in the operating instructions unless you are qualified to do so.

**Caution**

Contains Class 2 laser. Do not stare into the beam. Complies with CFR Title 21, Chapter I, Subchapter J, Sections 1010.2, 1010.3, 1040.10 and 1040.11 in effect at the date of manufacture. Use of any controls, adjustments or procedures other than those specified herein may result in hazardous radiation exposure.

**Caution**

Sharp edges. Touching the tools with bare hands may cause injury. Do not touch.

**Caution**

Moving parts. Keep body parts out of the motion path. This equipment is not suitable for use in locations where children are likely to be present. This equipment is not intended for use by children. Avoid touching the moving parts and entering the cutting area with the hands, clothing, jewelry or hair. Unplug this equipment when not used for an extended period of time.

**Caution**

Hot surface. Do not touch marked parts.

**Warning**

In certain cases, eye and/or ear protection must be worn.

Make sure to observe all the caution labels on the table.

There are no user-serviceable parts inside. For servicing refer to qualified personnel only. Turn off the table and contact a service representative in any of the following cases.

- There is visible mechanical damage.
- The power cord is damaged.
- The table (or parts of it) have been damaged by an impact
- Liquid was spilt on the table.
- There is a strange noise, smoke or an unusual smell coming from the table.

1.1.1.4 Safety precaution



WARNING: This equipment is not suitable for use in locations where children are likely to be present.

1.1.1.4.1 SAFETY PRECAUTIONS RELATED TO MOVEMENT

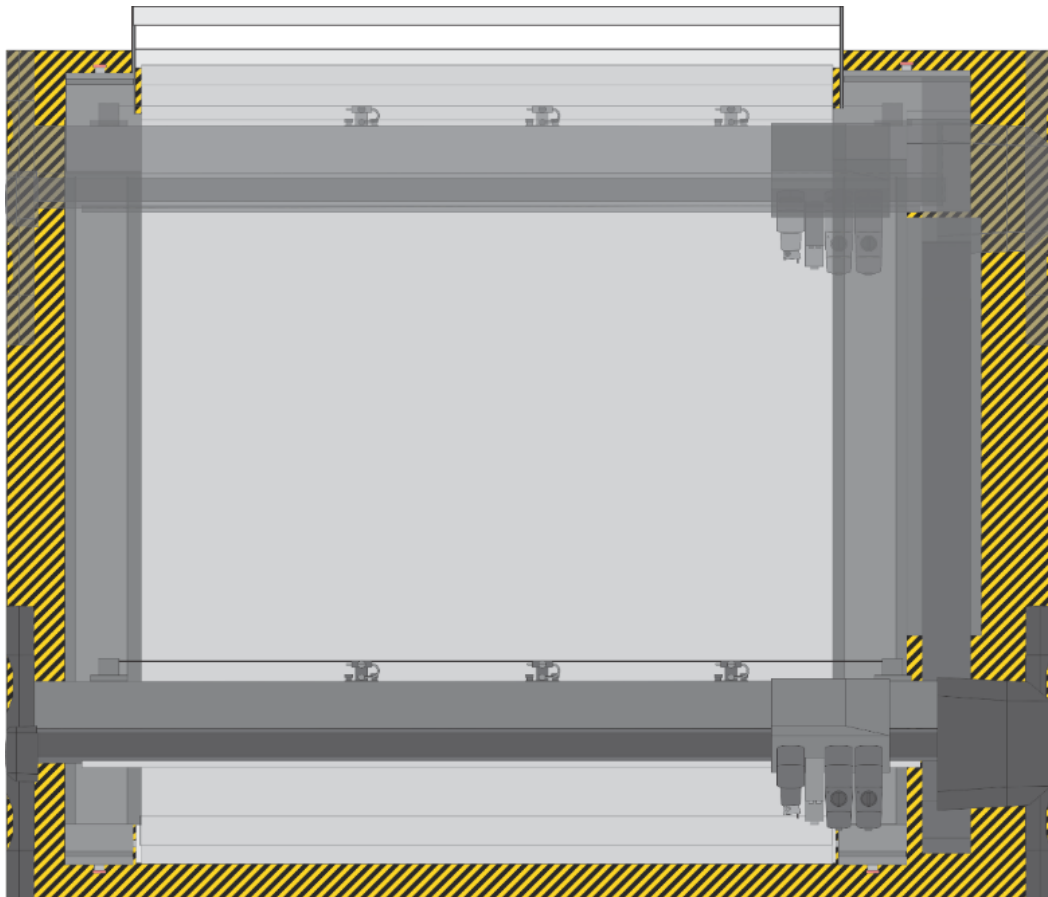


WARNING: There is a risk of injury from being caught or trapped in moving machine parts.

Keep hands, hair, clothing and jewellery away from moving parts. Do not wear jewellery, loose clothing, scarves, open jackets or shirtsleeves.

Danger areas can be split up into three parts

General danger area

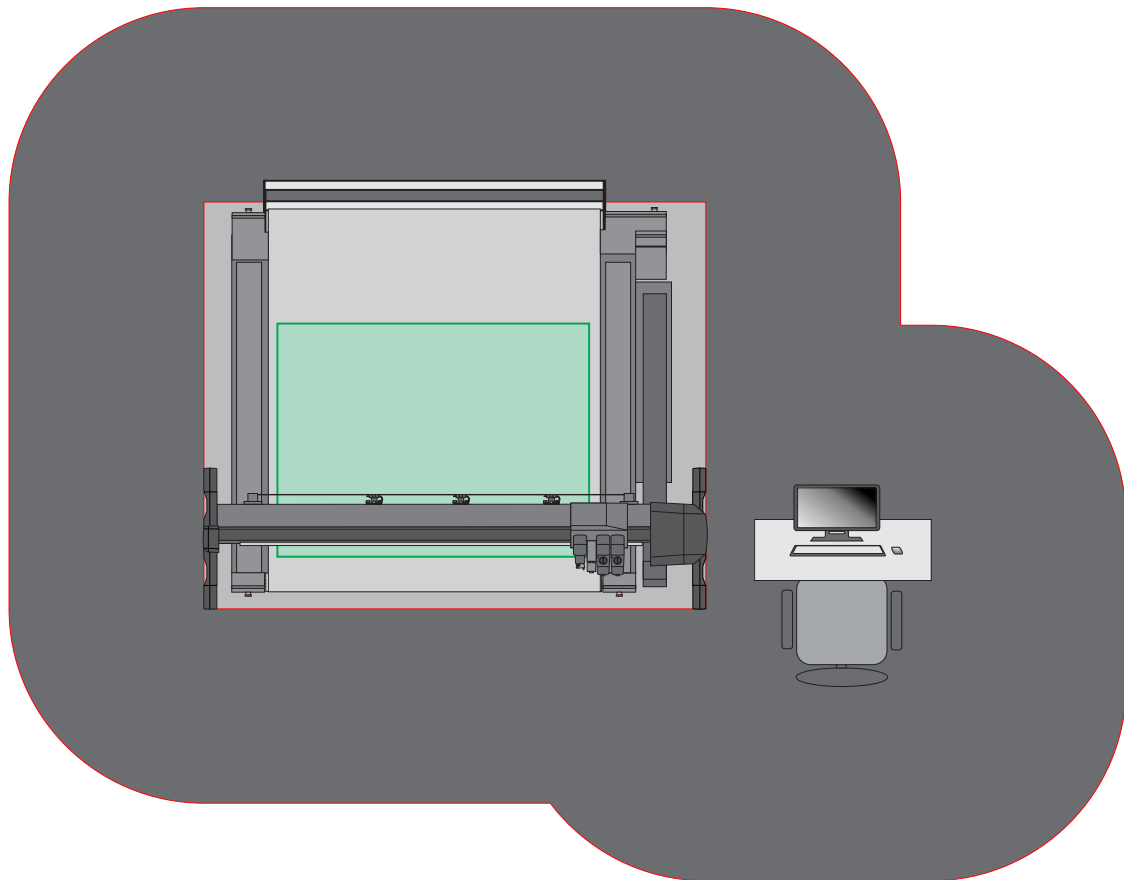


The easiest way to define the general danger area is the complete area where the table itself stands and which also covers the moving parts.



WARNING: The top beam is wider than the table itself. This means that the danger area is wider than the table itself. On the figure, the top beam is shown the furthest to the front of the machine. The maximum rear position is shown in a lighter colour.

Safety area during operation



During normal production, the operator should stay out of the area marked in light grey colour. If the operator moves inside this area, then trip switches or optical sensors can detect the presence of the operator and then the flatbed table pauses automatically. The current job is not lost but nothing will move on the table until the operator leaves the area and tells the flatbed cutter to continue its job (with Axis Control).

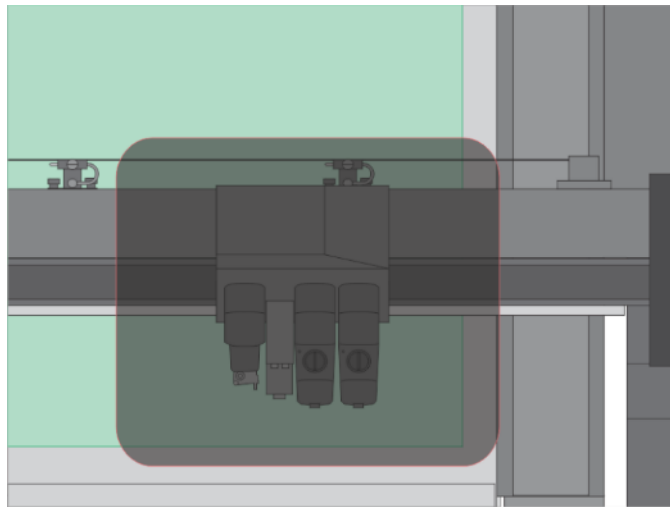


WARNING: If the operator needs to be within the area, marked in light grey to change media or tools, the procedures to perform these actions need to be followed strictly, as described further in the manual.

The safety area for other personnel is marked in dark grey. It covers 1 meter outside the danger area and 1 meter away from the operator's desk.



WARNING: The operator must always make sure the remote is in its loading station when it is not in use. This way no other person will inadvertently press the buttons and start up the machine while the operator is in the danger area.

Danger area around the head

The head with the modules and about 20 cm around it can be considered as the extra danger area during module/tool installation. When the operator is working within this area, he has to be extra careful. When a module or a tool needs to be changed, the operator is obliged to perform certain actions within the danger area around the head. So the operator must be sure that the machine will not make any unexpected movement while performing the changes. There are only two possible ways to be sure the machine will not make any sudden movements: either changing the module/tool while the machine is switched off, or following the module/tool change procedure.

WARNING: When changing a module or a tool, always make sure that Axis Control



is initiated and check whether the second button in Axis Control is



If it is



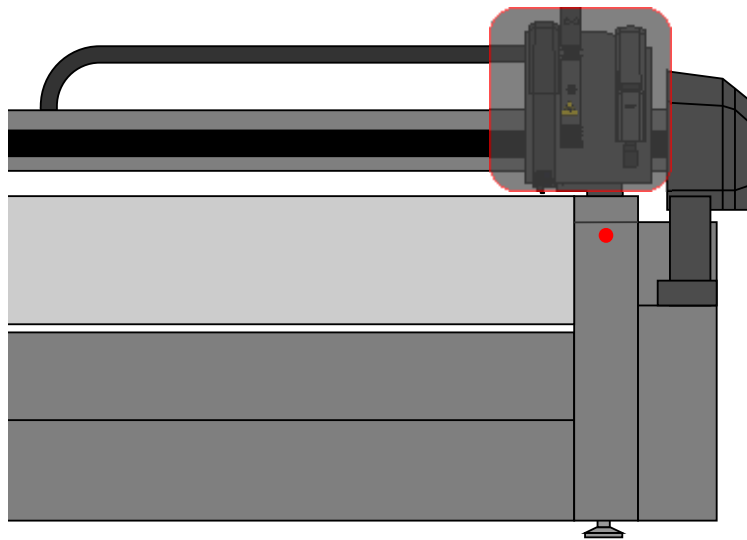
, then click it, so the machine comes offline and will not move anymore.

1.1.1.4.2 SAFETY PRECAUTIONS RELATED TO THE BUILT-IN LASER POINTER



WARNING: Contains Class 2 laser. Do not stare into the beam.

On the carriage is a laser pointer to help to define the position of the carriage (origin and full size). The laser is located on the camera module.



1.1.1.4.3 SAFETY PRECAUTIONS RELATED TO TOOLS



WARNING: The F series cutters use razor-sharp tools. Touching the tools with bare hands may cause injury. Do not touch the tools while the machine is cutting.

All knives and router bits should be handled with caution to prevent injury.



WARNING: Eye and/or ear protection is necessary when using certain power tools

The router options and tool holders that use pneumatic air produce loud noises that require using ear protection if the user is exposed to it for a long time. The router option can also throw around debris so eye protection is also needed when using the router option.

1.1.1.5 Safety Features

1.1.1.5.1 CONTROLLED START-UP

The table will not start up when it is just switched on. Before the machine is switched on, it has to be connected with the computer and the program Axis Control needs to run. A short time after the machine is powered on, a message will appear in Axis Control on the computer asking the operator for confirmation to start up.

1.1.1.5.2 BUMPERS ON TOP BEAM

On the left and right side of the top beam, there are bumpers with trip switches that can detect if an operator is standing in the way of the path the top beam will move. When something pushes against it the table will stop moving.

1.1.1.5.3 LIGHT BARRIER

A safety beam is created from left to right along the top beam with optical sensors mounted in the bumpers. If the light beam is interrupted, then the machine stops. The interruption is a controlled stop. The machine will stop the movement in less than five seconds and hold the position where it stopped. This means that the machine can continue the job when enter is pressed.

1.1.1.5.4 EMERGENCY STOP SWITCHES

There is an emergency switch on each corner of the flatbed table. This allows the operator to switch off the machine quickly in hazardous situations. If the emergency stop is pressed, the power to the motors is cut immediately. This means that the machine stops immediately, but it also means the current job is lost.

To unlock an activated emergency switch, turn it clockwise.

1.1.1.5.5 OVERCURRENT

The cutter constantly measures the current through the motors. If the machine detects the current is too high, the current is cut off to the motors and a fatal error message will be displayed in Axis Control.



WARNING: All the built-in safety features cannot prevent the high level of kinetic energy that can be released during an emergency stop or an unforeseen malfunction of the machine. So they are not a guarantee against injuries.

1.1.1.6 Personal protective equipment

The required safety equipment depends on the installed modules and the material that needs to be cut/milled.

During operating or servicing the machine the operator should wear close-fitting clothing and use appropriate protective equipment.

Appropriate protective equipment can include:

- Work clothes.
- Goggles because when processing the material large particles can be generated.
- Ear protection if the continuous sound level pressure is above 80dB.



WARNING: There is a risk of injury from being caught or trapped in moving machine parts. Keep hands, hair, clothing and jewelry away from moving parts. Do not wear jewelry, loose clothing, scarves or open jackets or shirtsleeves.

1.1.2 Operating environment

Environmental conditions can significantly affect the machine's performance. Most restrictions or recommendations for the ideal operating environment are already described in the site preparation document. The environmental conditions of the machine (without media) are as follows:

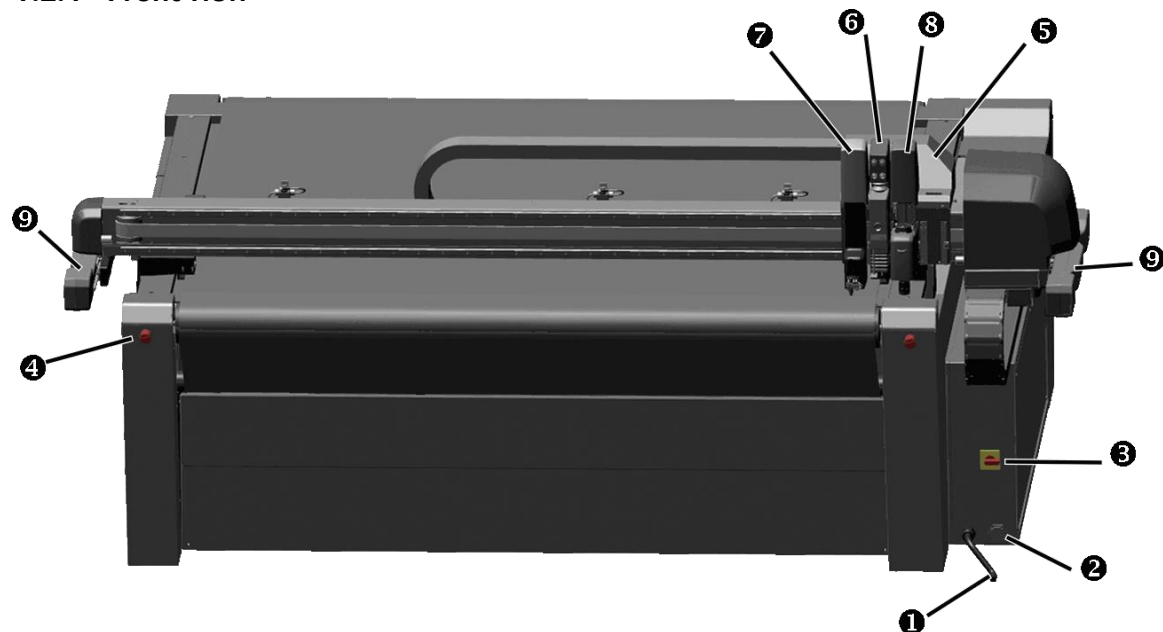
Operating Temperature	15 to 35° C	59 to 95° F
Storage temperature	-30 to 70° C	-22 to 158° F
Relative humidity	35 - 75 %, non-condensing	35 - 75 %, non-condensing

It is possible that the environmental conditions of the used media are stricter than those of the machine itself. Please refer to the documentation about the used media.

Also, make sure that the media has had enough time to acclimatize.

1.2 Flatbed Components

1.2.1 Front view



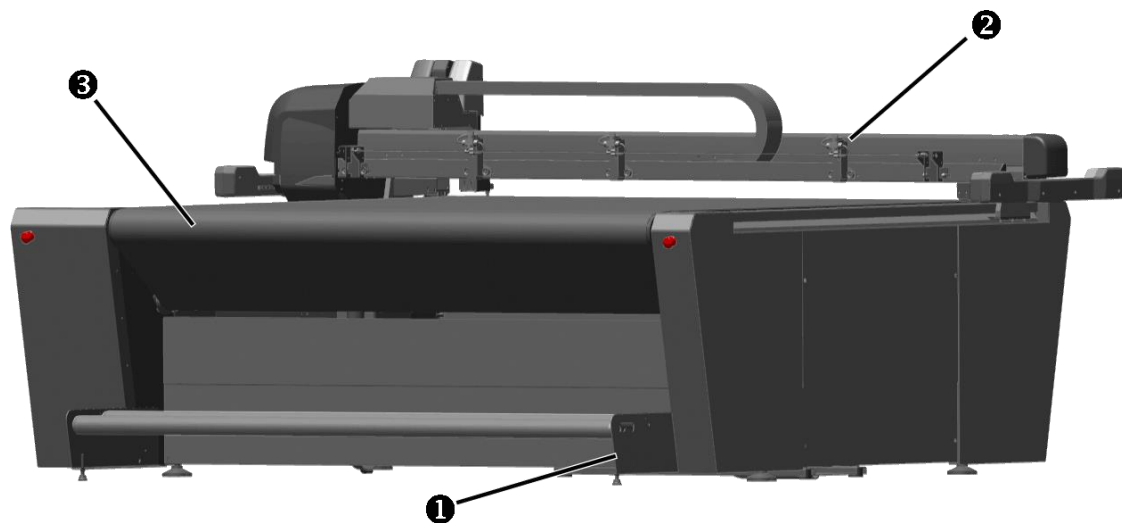
1. **Power cable entry:** The F series table cutters have no power entry plug. The power cable has to be made on-site and it has to be connected directly inside the machine itself. The cable will have to be guided through this entry.
2. **USB connection:** This interface is based on the standards, specified in the Universal Serial Bus. A minimum of USB 2.0 is needed for the camera connection.



ATTENTION: The table cutter needs to be connected directly to a computer. The USB cable shouldn't be longer than 3 meters (+0.5 m) and no hubs should be used.



3. **Power On/Off switch:** This turn switch can be used to switch the flatbed on or off. There is a hole provided, so the switch can be locked with a padlock.
4. **Emergency stops:** There are four emergency stops on the flatbed. If they are pressed, the flatbed stops immediately to prevent damage to the operator and to the machine itself. Once pressed, they stay in a safe locked position and need to be turned to the right to unlock again.
5. **Carriage for modules:** The carriage can hold up to three removable modules and has a fixed central unit.
6. **Central unit:** The central unit houses a positioning laser and an integrated camera system for fast and accurate registration mark recognition.
7. **Drag head module:** The drag head module comes standard with the flatbed cutter. It can be used to mount the drag knife or pen.
8. **Tangential module (optional):** The tangential module is used for the tangential tools.
9. **Safety bumpers:** These bumpers have trip switches and optical sensors to detect the presence of the operator so the machine stops when the operator is too close.

1.2.2 Rear View



- 1. Roll support:** Media support bars and a set of core holders for loading roll material.
- 2. Pneumatic clamps:** Pneumatic media advance system. It clamps the conveyor belt and holds the media down while pulling it forward in order to work continuously, in panels or for multiple jobs.



NOTE: The clamps that hold the media down can be moved from the left to the right and can be enabled () or disabled () individually by turning the handle on top of each clamp.

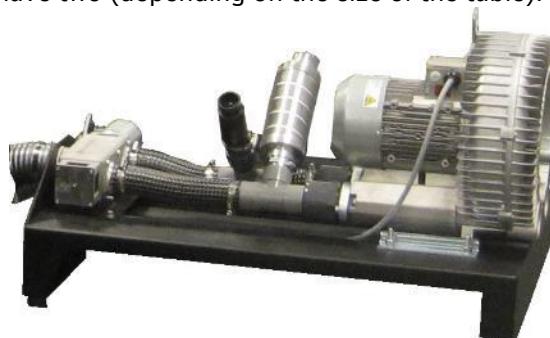
- 3. Conveyor belt:** The conveyor system is needed for feeding the media when the cutout tool is used.

General Directional information:

- Front right of the machine: Where the on/off switch is located (this determines automatically the left and back of the machine).
- X-axis: From front to back.
- Y-axis: From right to left.
- Origin: The origin is situated on the right side at the front.

1.2.3 Larger models

For the larger models, the vacuum pump(s) are not located under the table, but they can be set either next to or at the distance (for noise reduction). Some larger models have one external pump, others have two (depending on the size of the table).



1.3 Modules

1.3.1 Camera unit



The carriage has a central unit. This central unit is fixed to the carriage and cannot be taken off. The central unit houses a positioning laser and an integrated camera system for fast and accurate registration mark recognition while contour cutting. The camera module of the F1612 and F1625 also has connections for the special tools or modules that require compressed air. For the larger models, these connections for compressed air are situated at the side of the carriage.

Both the knob and black camera adjust plate is part of the manual height adjustment mechanism. Each time material is loaded with a different thickness than the previous one, the height of the camera needs to be adjusted (only with contour cutting).

1.3.2 Drag head module



The drag head module comes standard with the flatbed cutter.

The Drag Module is a fast-moving drag knife and pen holder for making notations or kiss-cutting a wide range of materials, using up to 600 grams of downforce.

The clearance between the standard drag knife holder and the flatbed base is approximately 3 mm (0.11"). So, it has to be removed when thicker materials are used.

1.3.3 Tangential module



The tangential module offers a vertical force of 10 kg and corresponds to a wide range of matching tools. Each tool has a barcode ID that ensures automatic recognition and separate parameter settings.

For each application, a corresponding tool can be installed on the tangential module.

1.3.4 Rotary Module



The Rotary Module has a decagonal tangentially controlled knife, which is driven by an electronic motor.

Depending on the used speed and knife diameter, all kinds of materials up to 5 mm thickness can be cut with the rotary knife.

However, the main focus is on single-layered textiles because certain types of fibre are hard to cut with other knife types. Ideal materials to cut with the rotary knife are: flag & banner material, felt, technical textiles, fabric, foams,...

The module allocates slot 2&3 of the head. It also requires compressed air (standard on large tables).

Knives have to be mounted directly in the module; there are no tools available for this module.

1.3.5 Router module



The router module has a motor capable of handling most used solid boards in the graphic and sign industry.

The router system comes with a vacuum cleaning kit to take away the chips and dust. The kit includes a brush assembly, a hose and a mounting pole. The vacuum cleaner is optional.

The module allocates slot 2&3 of the head. Of course, the module can be easily dismantled and parked on the pole of the gantry, making the two slots available again.



ATTENTION: Use of a routing mat is mandatory.



NOTE: The actual router module may differ from picture. Different type of the router modules are available.

2 SETTING UP MODULES / TOOLS

2.1 Introduction

2.1.1 General remarks on the calibration of the tools

There are four kinds of modules: the drag module, the tangential module, the miller module and the rotary module. The tangential module automatically recognizes which tool is mounted. The router module is specially made for the miller only. The rotary module has no tools; the knife is mounted in the module itself. The drag module cannot automatically recognize whether a pen or drag knife is mounted.

The flatbed has no control panel or screen. Everything is done with the program Axis Control.

Certain calibrations will need to be done after installing a tool. Those parameters have a double function. Setting them correctly makes sure that the cutting quality is optimized and also makes sure that the print and cut jobs are more precise. These calibrations can be done automatically with ADC.



NOTE: It is absolutely recommended to label the modules. Also, always put them in the same position on the carriage. The tool parameters are automatically saved when a tool is used. However, tool parameters are also partly module dependent. If the same module is always mounted at the same place, the tool parameter dependency of the module will be nullified.

2.1.2 Automatic Depth Control

The ADC measures the tip of the knife or bit accurately and sets the down position of the tool to the level of the table.



When starting up the table or after a tool change, the down position of each installed knife is measured to detect changes and avoid operator errors if the ADC is installed.



NOTE: Only the drag knife cannot be calibrated with the ADC, the rest of the tools/knives/bits can be calibrated with the ADC.

2.1.3 Installing / Removing a module



WARNING: For safety reasons, always make sure no tool is installed in the module. Only install a module when the flatbed is switched off or after clicking 'Change Tool' in Axis Control.



2.1.3.1 Installing a module

In order to install a module, line up the 5 highlighted areas and slide the module down. The module glides into the carriage in a dovetail guiding. Do not use excessive force, otherwise, the connector can be damaged. Recheck the alignment when in doubt. The module must be pushed down approximately 15 mm (0,6") and is secured with one screw on the right side. Before securing the module check if the connector of the module is completely seated in the connector of the carriage.



2.1.3.2 Removing a module

To remove a module, loosen the screw at the right side of the module for about 1 turn counterclockwise with the hex screwdriver. Put this screwdriver in the hole under the module on the right side. Now gently lift the module with the screwdriver 3 to 4 mm (0.12 to 0,16"). Guide the module manually for an extra 10 mm (0,4") and remove it from the carriage. The drag module does not have such a hole to lift the module, so just lift it manually.



NOTE: It is recommended to remove any unused modules. Leaving unused modules on the carriage can lead to poorer cutting quality.

2.2 Tool/knife calibration with ADC

The ADC works by interruption of a light beam. This is harmless for the tools. The sensor unit on the right-hand side cover is used to measure the tools in slot 2 & 3. The sensor in the left-hand side can measure the tools in slot 1.




NOTE: The drag module, which moves low over the table, can't pass over the ADC sensor units. The drag module must be used in slot 1. If the left ADC sensor is installed, the working area will be reduced when using the drag module in order to avoid that the module hits the ADC sensor unit. The front margin is moved 80 mm to the rear, so module 2 and module 3 can use the full table width.

2.2.1 General calibrations with the ADC

The *down position* of ADC controlled tools is set automatically each time the machine is switched on or when a tool is changed. The down position is a value, relative to the table height.

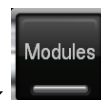
The *up position* should be set manually. The up position is the relative distance from the down position. Make sure the up position measures significantly more than your material thickness.

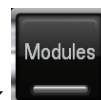



To set the up position, first click . If Axis Control is not automatically selecting the tool, whose up position needs to be checked/set, click the picture of the corresponding module. Click 'Up position' in Axis Control or press 'Up' on the remote. Press the down arrow until the tip of the knife is about 4 – 5 mm above the material, then press apply. It is not necessary that the material is on the table, the up position can also be set if the thickness of the material is known. Just press the up/down arrow until the value is 4 – 5 mm higher than the thickness of the material.



The *origin*, *lateral* and *longitudinal* parameters can also be set by the ADC. Those parameters are material independent and should only be set during the first installation of a tool or when there are quality issues.




In order to automatically calibrate those parameters, first click . If Axis Control is not automatically selecting the tool, whose tool calibration needs to be checked/set, click the picture of the corresponding module. Then click . The ADC will now measure the three parameters and store the values.

2.3 Calibration of the drag module

Although the machine does not automatically recognize the tool, mounted in the drag module,



it is still necessary to click  to mount the pen or knife in the module. This to make sure the machine does not make any unexpected movement while the user is changing tools.

3 TANDEM MODE

In Tandem mode (available on F1432, F1625, F1832, and F3232), the active work area on the flatbed can be divided into a front and rear processing area, allowing you to load and unload material on one side of the table while cutting material on the other side of the table. This avoids periods of inactivity during material processing, significantly improving the overall workflow.

Tandem mode is explained in detail in the GoProduce Flatbed Edition user manual, available for download on our website (www.summa.com/en/support/user-manuals/).

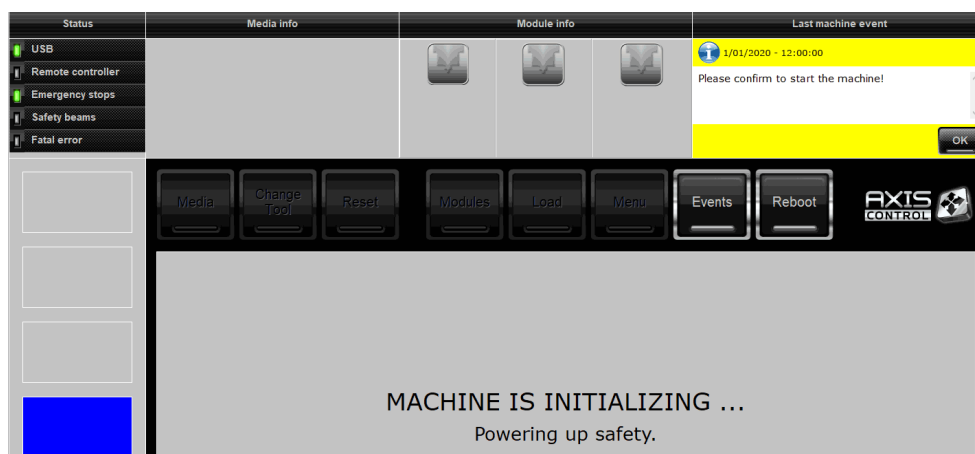
4 AXIS CONTROL


Axis Control is standard delivered software that gives full control over the flatbed. The optimized design for touch screen control makes Axis Control the optimum interface for the machine operator.



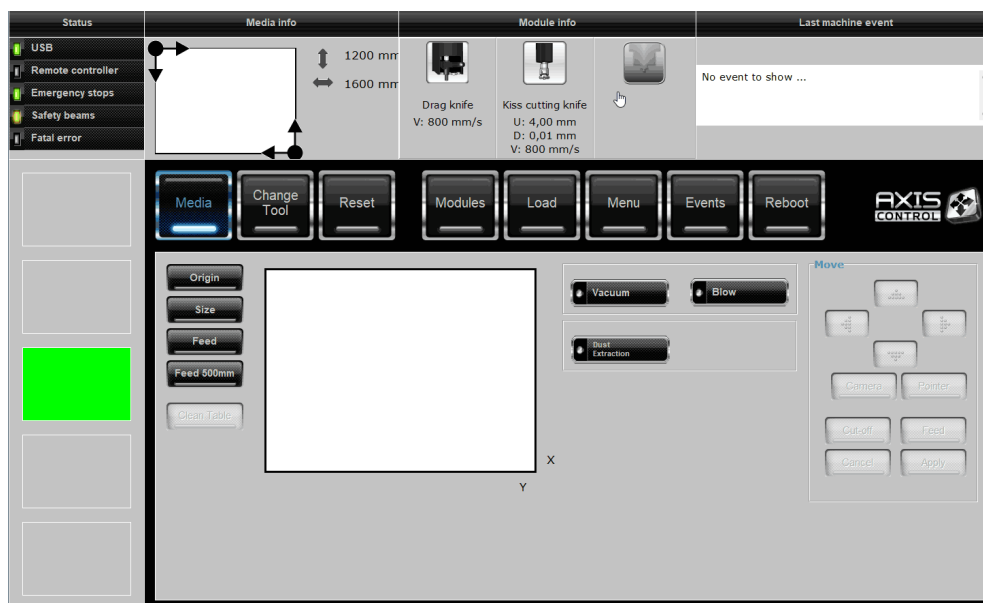
ATTENTION: Always start up Axis Control before the machine is switched on or before the remote is connected. Close Axis Control always as last.

When the flatbed is powered on, a message will appear asking the operator permission to proceed with the start-up sequence. This prevents the table from accidentally moving.



Click  to proceed with the startup sequence. In the next step the emergency buttons will be checked and after that the safety trip switches and the safety light beams.

4.1 Main Window



After startup and initialization of the table, the window as above is displayed.
Status (left side of the screen)

This part displays the status of several items that are being monitored.

USB: can be green (connected) or red (not connected).

Remote controller: can be green (activated), or grey (not activated).

Emergency stop: can be green (machine ready), red (emergency stop pushed in) or grey (machine not connected).

Safety beam: can be green (machine active), orange (not active), red (interrupted) or grey (machine not connected).

Fatal error: can be red (fatal error happened) or grey (OK).

The large colour blocks make the status visible from a distance there are 5 possible colours.

Red: Means there is an error message that needs confirmation from the operator. Possible events: Emergency button pressed, trip switch or optical sensors from safety system were activated, fatal error or machine is rebooting.

Yellow: Means a warning message is displayed that needs confirmation from the operator.

Green: Normal status of machine, might be busy with a job or waiting for a job.

Blue: This means an intervention of the operator is needed. Is shown when a job is paused or interrupted because an operator intervention is needed.

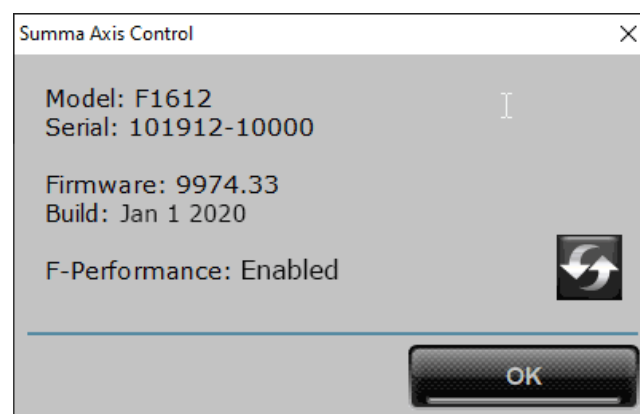
White: Special status means the machine is not ready for sending a job to it, it might be busy re-flashing firmware or just offline.

Media info: Displays the currently set media size.

Module info: Info about modules/tools. The mounted tool is shown and the up /down value and the speed set for internal tests.

Last machine event: Here the last message, sent from the flatbed to the computer, is displayed. This message disappears if it has been acknowledged by the user.

Click on the Axis Control logo to show the model, serial number and firmware revision.

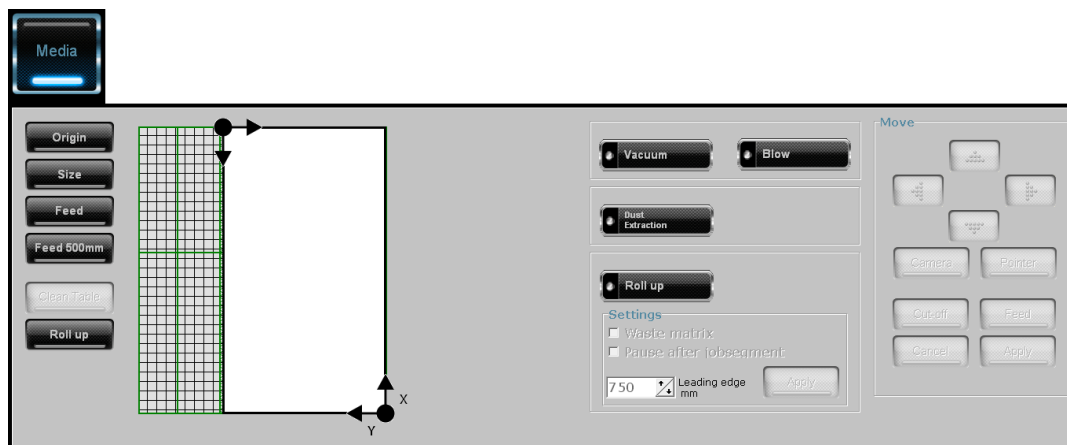


The rest of the Window shows the different menus of Axis Control to interact with the flatbed. They are explained in the next sections.

4.2 Media menu

The media menu is used to load media and set up media size. Extra control buttons are also available for making media loading easy. Some functions are only available if certain options are installed.

The buttons under the move sections become active during the setup of the media (origin and size setting).

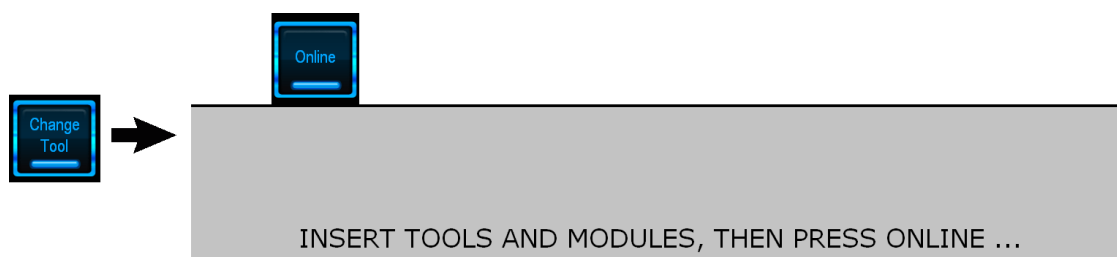


NOTE: The dust extraction parameters function only when a router module (optional) is installed. The parameters for the roll-up are only available if the roll-up (optional) is installed.

4.3 Change Tool

The change tool menu must be used when a module or tool is changed on the flatbed. If a tool or module is changed while the flatbed is not in the change tool menu, the machine will not detect the change and the cutting surface may be irreversibly damaged if a job is started afterwards.

After a module or tool change, click the Online button. The machine will then detect any module or tool change. It will also remind the operator to calibrate the tool before using it.



WARNING: Only change/install a module or tool after clicking 'Change Tool' in Axis Control. The machine will not make any unexpected movements after the change tool button is pressed and as long as the online button is visible. The power to the motors is cut, so after Online is clicked, the motors return to their original position. Do not move them too far out of their original position.

4.4 Reset

Click Reset to stop the table with the current job. The origin of the loaded media is also reset.



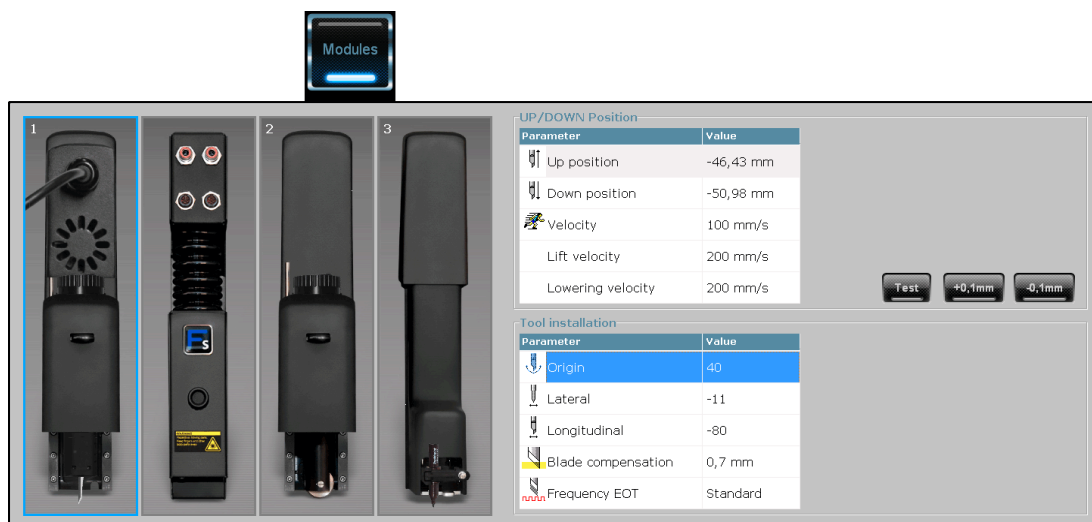
NOTE: When the table is cutting a job from Summa GoProduce, there are more options available than just resetting .

4.5 Modules

This menu is the menu to set the tool parameters. Each time a tool is changed, the parameters need to be at least checked.

If the machine detects a new tool is installed (after change tool), it will refuse to use that tool until it has been calibrated.

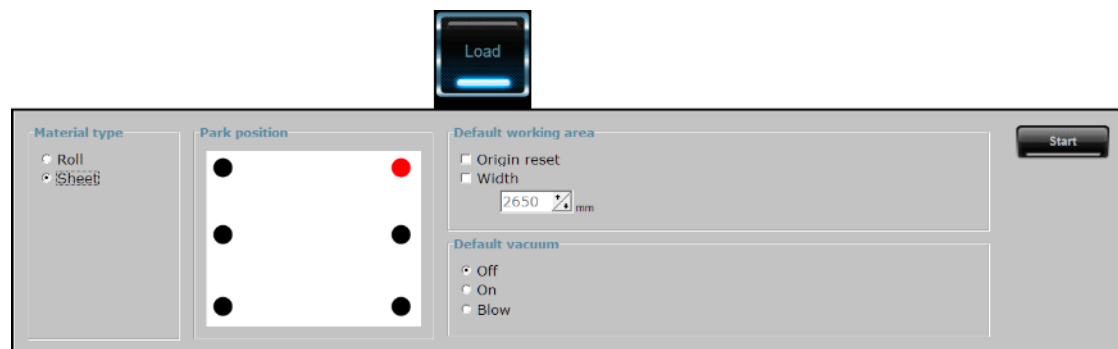
The module that is chosen to calibrate has a blue border around it. The parameter that is currently chosen to calibrate is highlighted in blue or magnified.



ATTENTION: The up and down head positions can also be set with the remote. It is even advised to use the remote for this.

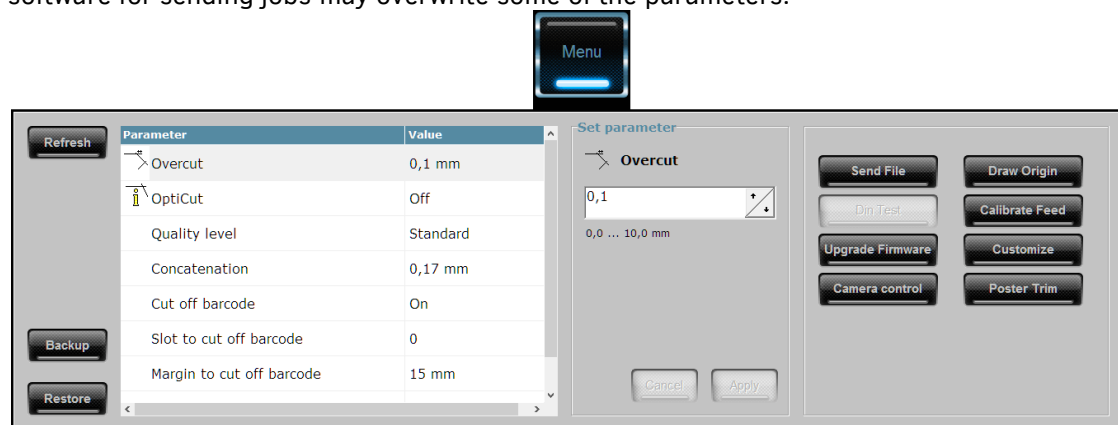
4.6 Load

With this menu, media is loaded.



4.7 Menu

With this menu, the standard parameters for the cutting table can be changed. Select the parameter that needs to be changed. Then use the up/down arrow to change the value. The software for sending jobs may overwrite some of the parameters.



4.8 Events

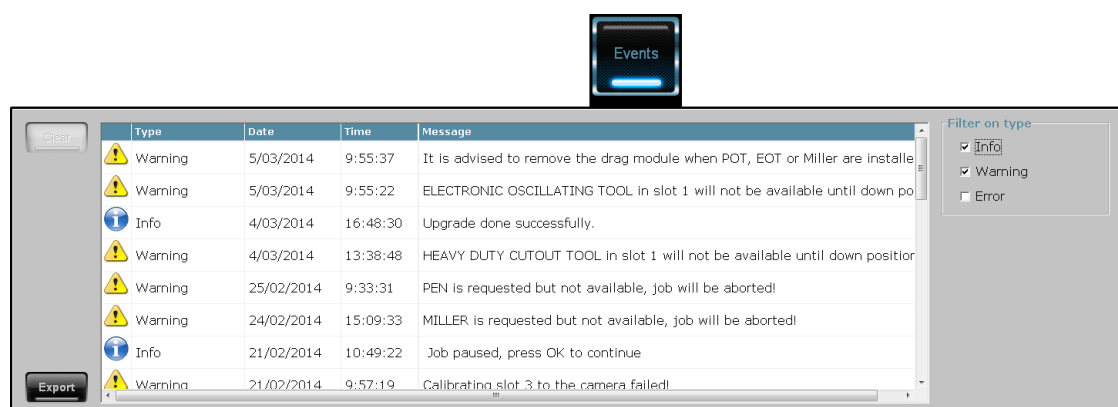
This menu shows all the messages that have been displayed by the flatbed cutter.

There are three types of messages:

Info: This is a message of the machine to the user.

Warning: This is a message, reminding the user a certain action needs to be taken.

Error: This is a message, reporting an error that needs the user's attention.



4.9 Reboot

This button is for restarting the machine completely. It is a 'warm restart'. The flatbed goes through its entire initialization procedure, which is normally run when the machine is switched off and back on again.

This reboot does not reboot the camera in the flatbed.

4.10 Color Axis Control icon


The colour of the icon of Axis Control in the tray menu can differ.

The normal colour is **white**.

When the icon is **yellow**, this means the flatbed is busy (resetting, cutting a test pattern, waiting for a response from the user,...).

When the icon colour is **red**, this means Axis Control has no connection with the flatbed cutter.

4.11 Axis Control options when table is busy cutting jobs from Summa GoProduce

When a job is started from Summa GoProduce, the emergency stops become active () and the view of Axis Control changes. There are now two main buttons.



Click this button to stop the current job. The table will finish the vectors, loaded in the buffer and reset the origin. The computer will send the rest of the job but the table will not cut it out.



Click this button to pause the current job. The table will finish the vectors loaded in the buffer, pause and show the two new buttons.



Click this button to resume the job. The table will start cutting the rest of the job.



When the table is paused, the job can be aborted by clicking this button. The carriage will move back to the current origin. The computer will send the rest of the job but the table will not cut it out.

If the safety beams are interrupted or the trip switches in the bumpers are triggered, then the table will stop and the table will pause. Summa Axis Control will give a message. Click the OK button in the message window to continue.



NOTE: Do not use the emergency stop as a pause button. It will reduce the cutting quality. A controlled pause makes sure all vectors are cut out with the correct speed and acceleration.

5 GOPRODUCE FLATBED EDITION

Summa GoProduce Flatbed Edition is a software that integrates the flatbed into the workflow. It is the perfect link between the design station, RIP station, printers and cutting devices. Once the workflow is set up, macros automate the process. Consequently, the number of times the operator has to intervene to start the next job is reduced to a minimum, as is the downtime of the machine.

The user manual of GoProduce Flatbed Edition is available for download on our website (www.summa.com/en/support/user-manuals/).