*Summa*®

The **continuous sheet feed** procedure can be done with any F1612 with conveyor, pneumatic pack and extension tables. The safety beam height should be around 65cm and fit under the extension tables (Note: Early installations may have higher safety poles).

1. In order to find the best starting position make sure the actual **working area is the full length of the table**. Set the origin and size to do so.   Start the load roll procedure. Set the Park position to 1150mm (see further for more info on this distance).
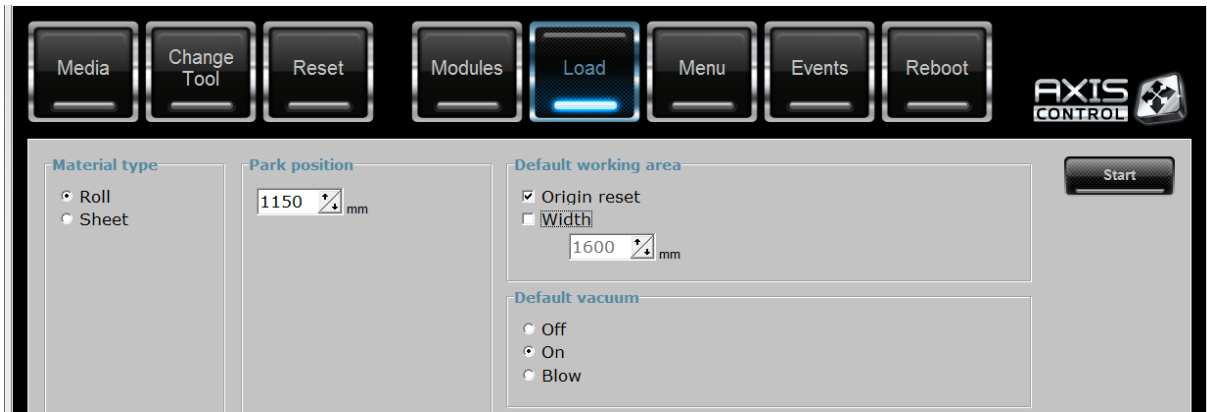

During the load roll procedure place a row of sheets on the extension table and on the back of the machine. Also place the media clamps making sure every sheet will be pulled forward. As the F1612 is equipped with 3 clamps, 3 sheets can be fed at once. However, if sheets are smaller, they lay completely on the conveyor (nothing on the table). In this case the sheets will be pulled forward without media clamp and more sheets can be positioned.

Find the most convenient position to place the sheets at the back making sure they will be clamped. Depending on the sheet size and type of material, the sheets may be pushed more or less onto the table. It is convenient to place alignment marks on the table to know the final position.

Cancel the load procedure.

Adjust the working width (by setting the size) to optimize the vacuum. Keep some extra margin in case the next sheets may be slightly shifted.
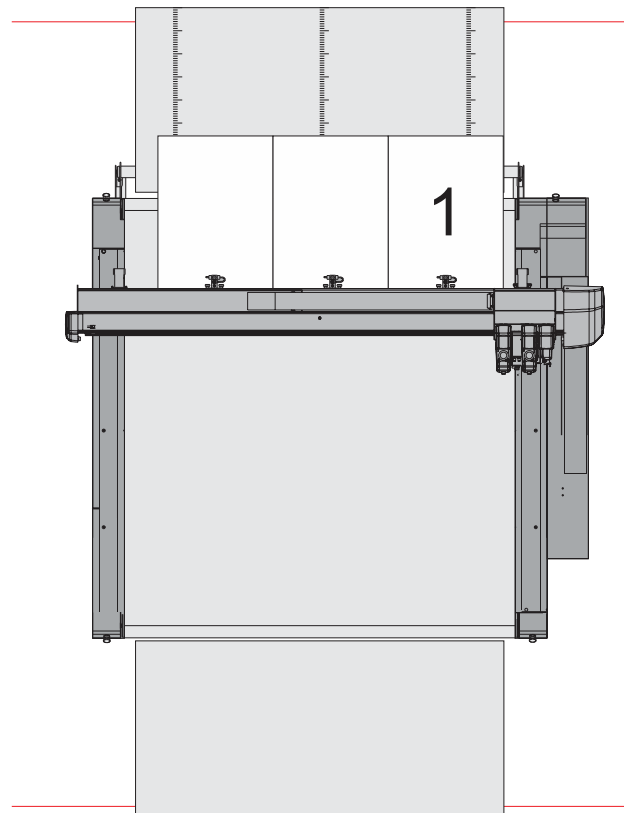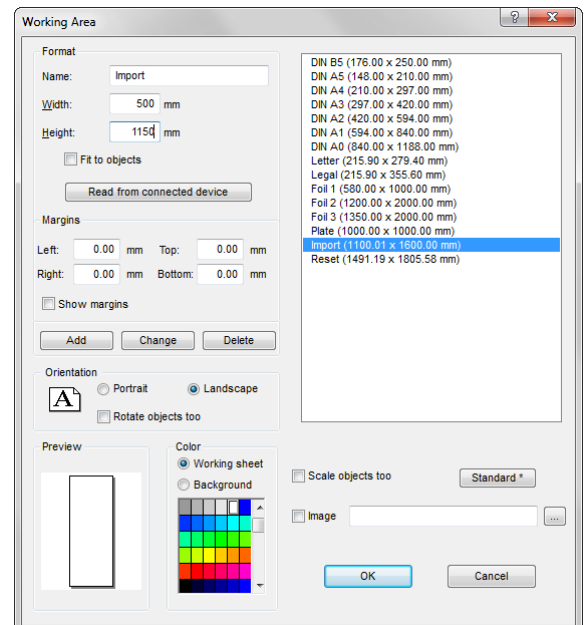
2. In Axis Control make a **feed of 1150mm** and **place a second row** of sheets on the staring position in the back.
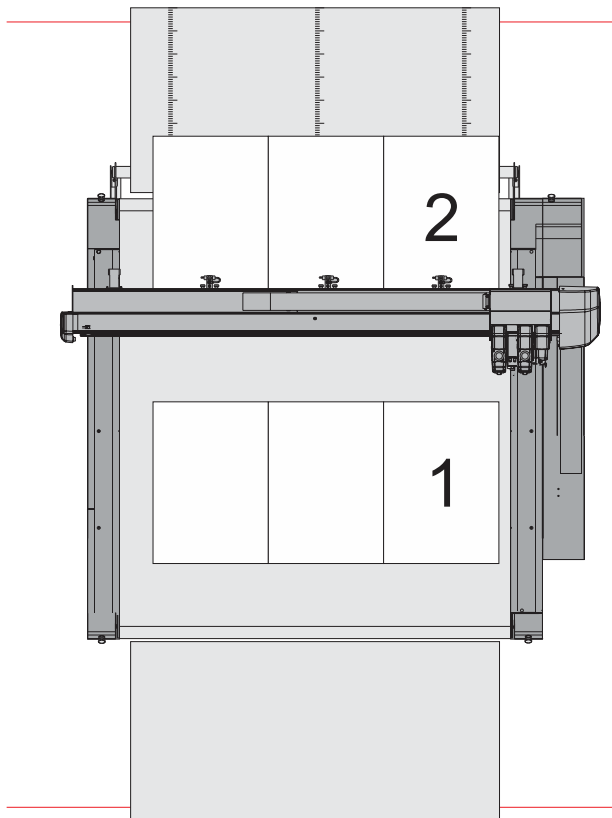
3. In SummaFlex Pro, open the job and prepare all settings as a regular job. Then go to Setting - Working area. Set the **height of the Working Area to 1150mm** and the width of the working to the actual width of the sheets.

4. Output the job to device and make sure following settings are correct:
   a. Material : **Roll** → feed: feed
   b. Total number of copies: total amount of sheets to cut.
   c. Number of copies in Y-direction: amount of sheets next to each other (3 in this example)
   d. Number of copies in X-direction: **1**
   e. Offset between copies in Y-direction : **0** (as sheets are next to each other and we have set the working area width to the sheet width)
   f. Offset between copies in X-direction :**0** (we have set the sheet height to the feed length of 1150mm)

5.   Output the jobs, indicate the first mark, ….

6.   Once the first row is cut, the machine will execute a feed of 1150mm, row 2 will now be in position for processing. Now a third row can be placed in the back, and the first row can be removed.

Remark: Depending on the size and type of sheets it may be convenient to use another feed length. The proposed 1150mm will work in most cases. Lower values may give some extra space in the back but with values lower than 900mm it may become difficult to push the media far enough on the table. With values just below 1200mm or above 1200 it may result that the feed will happen in two passes. This works fine but it is time consuming.