# Intermediate Web Guide — Center Guiding — SCU6x

Quick Start Guide

**Controller:** SCU6x | **Configuration:** Dual Sensor

Scan for
interactive guide

## What You'll Achieve

After completing this guide, your web runs centered between its two edges — the guide holds the center as the edges wander.

**Estimated time:** ~30–60 minutes

## What You Need

### Center Guiding — SCU6x

[ ] SCU6x web-guide controller, as ordered for your actuator

[ ] Linear actuator — your ordered LHS model

[ ] Two ODC Family sensors — one per web edge, each sized for the wander at its edge

[ ] Quick Disconnect Sensor Cable - 3m (10 ft) (U2-01975)

[ ] Second Quick Disconnect Sensor Cable (U2-01975) for the second sensor

[ ] 24 V DC Input Power Cable for SCU6x or 1DC - 5m (21218x-5m)

[ ] Actuator cable for your ordered LHS model

[ ] Servo-center proximity sensor (SKU 7-140004)

[ ] 24 VDC power supply, 5 A minimum

### Prerequisites

[ ] The machine is shut down and locked out per your facility's procedures.

[ ] A 24 VDC supply (5 A minimum) is available at the install location.

[ ] Your web material is on the machine, ready to thread through the guide.

[ ] Keep the SCU6x Sensor and Web Guide Controller User Manual within reach (/documentation/manuals/scu6x-sensor-and-web-guide-controller-user-manual) — you'll use it while commissioning.

# 1. Install the Web Guide

Install the Roll-2-Roll® Web Guide in two stages: first mount and align the web-guide frame on your machine, then mount the sensor for your guiding mode.

## Install and Align the Web Guide Frame

- Bolt the frame to the machine through its base-plate holes.
- Mount it so the web travels in the direction of the arrows on the frame — the guide corrects in one direction only, so a backwards frame fights the web instead of steering it.
- Level the frame: set its rollers parallel to the machine idlers and square to web travel, with no tilt to either side. Check it with a machine square, a tram rod, or by measuring from each entry and exit roller to the web-guide roller — whichever you have.

## Set the Correction Geometry

Set the geometry for the web guide type you received (your Roll-2-Roll application engineer chose it at purchase).

### Displacement guide

- Wrap the web 90 degrees at the entry and exit rollers.
- Make the entry and exit spans each about one-half to one web width (two to three web widths for metal webs).
- Correction happens in the exit span.

### Steering guide

- Make the entry span about three to five web widths (ten to twenty for metal webs).
- Wrap the guide roller 45 to 135 degrees.
- Keep the exit span perpendicular to the direction of roller motion.
- Correction happens in the entry span.

## Choose the Sensor Location and Mount the Sensor

- Mount the sensor in the exit span, just after the guide roller — as close to the roller as your machine allows. The sensor must see the corrected web; mounted anywhere else, guiding becomes unstable.
- Clamp the sensor bracket to your extrusion rail in the exit span, but don't fully tighten it yet.
- Set the working distance from the sensor face to the web to 15-25 mm (0.6-1.0 in); aim for 25 mm.
- Keep everything at least 150 mm (6 in) behind the web clear in the sensor's view — the camera-style sensor can otherwise pick up background objects.
- Guiding a shiny, metallic, or clear web? Tilt the sensor a few degrees toward the web so its angled light returns to the lens, then re-check the working distance.
- Tighten the bracket.
- If the web plane visibly lifts or drops in the exit span when the guide corrects hard (you'll confirm this during commissioning), add a backup roller with minimal wrap just before the sensor to steady the web — then keep the sensor close. Don't move the sensor farther downstream to escape the problem; distance costs you guiding response.

### Pre-Power Mechanical Checks

- Do these with the power off, before commissioning. Don't move the web guide by hand at any point.
- Confirm the web travels in the direction of the arrows on the guide.
- Confirm the guide rollers sit parallel in their neutral position.
- Confirm the guide is level, with no tilt.
- Confirm the wrap angle and the entry and exit span lengths match your guide geometry.
- Install the servo-center inductive proximity sensor (SKU 7-140004) per the Servo Center installation document — the controller uses it to find the actuator's home position during commissioning.

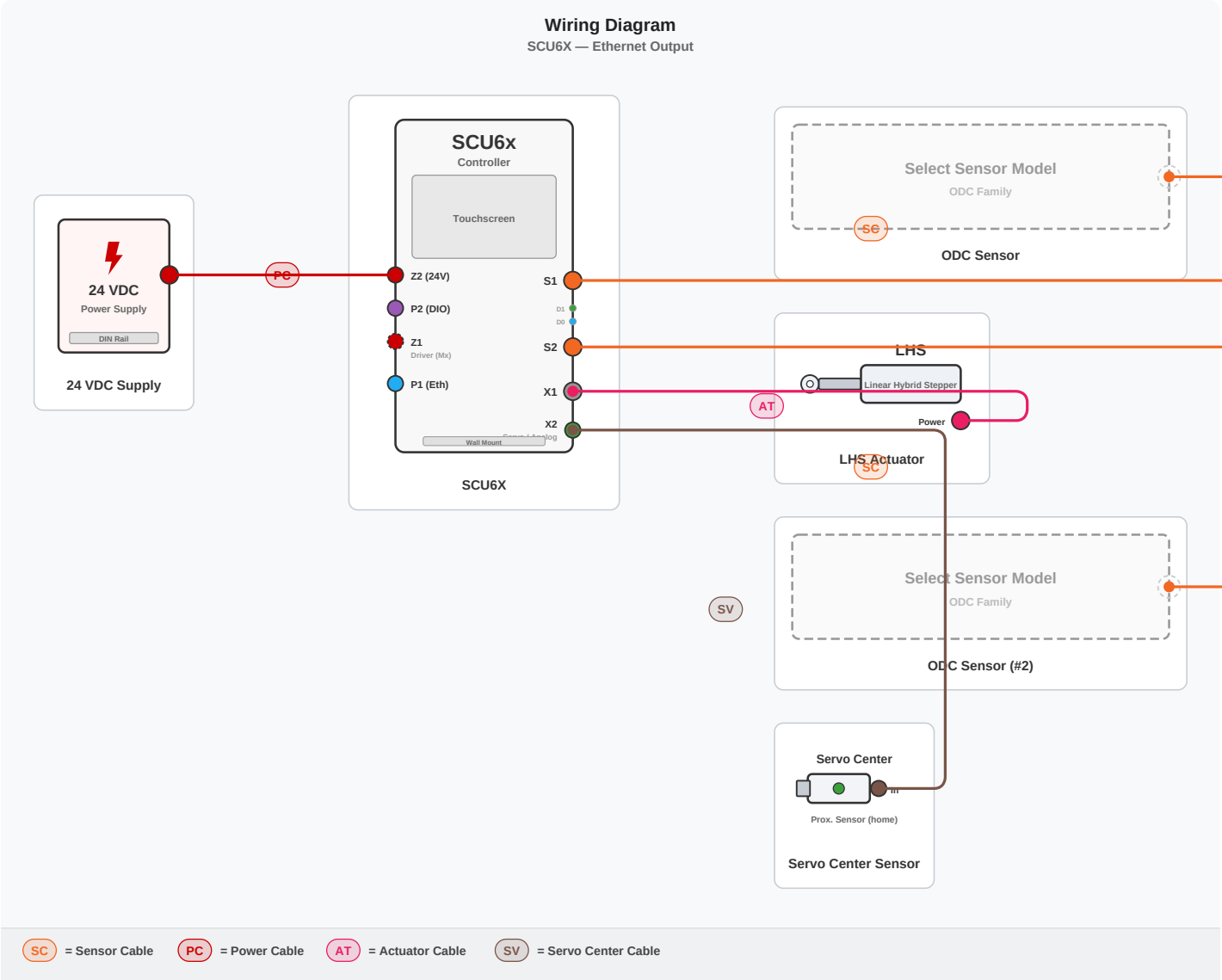
## 2. Install the Sensor

### Install the Sensors — Center Guiding

- Center guiding uses two ODC Family sensors — one over the left edge, one over the right edge. Set their spacing from your web width.
- Mount both sensors the same way round (matching camera pixel direction) so the controller reads both edges consistently.

# 3. Wire the System

## Wiring Diagram



## 4. Configure & Verify

Power up the controller and commission the guide, one checked step at a time.

### Center Guiding — Power Up and Commission

Commission two-sensor center guiding — set both sensors, prove the motion, then hold the web centered in automatic.

1. Power on the controller. If it wakes in Automatic, switch to Manual — every step below runs from Manual.
2. Set each sensor's electronic orientation by pressing the sensor button (Sensor 1 or Sensor 2) on the home screen to cycle Left ? Center ? Right: the sensor over the left edge to Left, the one over the right edge to Right.
3. Check both on the Web Position Indicator (the home screen shows what the sensors see). With the web threaded, you should see a dark region on the left AND a dark region on the right — one per sensor. If either side reads all dark or all light, that sensor isn't seeing its edge or its orientation is wrong — re-check its working distance and position. Don't continue until both edges show.
4. Check the jog direction. Tap Jog Left, then Jog Right, and watch the guide. It should move the way each button says. If it moves the opposite way, reverse Motor Polarity under Power User ? Actuator ? Motor Polarity, then jog again to confirm.
5. Servo-center the actuator. Tap Servo Center and let the guide travel to its home position (half its stroke each way). If it heads away from home, reverse Servo Center Polarity under Power User ? Actuator ? Servo Center Polarity, then servo-center again.
6. Set the guide point. Tap Reset Guide Point to lock onto the web's current center as the target. (To shift the target, drag the guide-point bar and press Accept.)
7. Switch to Automatic. The guide now keeps the web centered as both edges wander, and the Web Position Indicator holds steady. If the controller won't enter Automatic, a sensor isn't detecting its edge — go back to step 3.
8. Check the correction direction. Nudge the web off center. The guide should bring it back. If it drives the web further off, reverse Error Polarity under Power User ? Controller, then watch it correct again.
9. Fine-tune the position. Still in Automatic, tap Jog Right (+) or Jog Left (?) to nudge the centered web to the exact spot — about 0.25 mm (0.01 in) per tap.
10. Prove the safety hold. Pull the web clear of both sensors. The guide should freeze and hold until the web returns. When it does, your center guide is commissioned.

## 5. PLC Integration

Web guiding controllers support remote command via two routes: Industrial Ethernet PLC remote control, and the DIO option (discrete dry-contact inputs). Both allow a PLC or supervisory system to command guide mode and position without manual touchscreen interaction.

- Route 1 — PLC remote control (C(x) models): send auto mode on/off, jog, servo center, and guide-point commands over Industrial Ethernet (EtherNet/IP, PROFINET, EtherCAT)
- Route 2 — DIO option: discrete dry-contact 24 V NPN inputs for hard-wired remote on/off and mode switching — no Industrial Ethernet required; wired directly from PLC digital outputs or relay contacts
- Both routes can coexist — Ethernet for data and fine control, DIO for hard-wired safety/interlock inputs
- Lock on Lost Edge: when the web edge exits the sensor field of view during edge guiding, actuator motion is inhibited — prevents runaway
- Loss of Contrast Inhibit: for line/contrast guiding, actuator motion is inhibited if contrast is lost until the target feature is re-acquired

**Note:** The register map, EDS file (EtherNet/IP), and Add-on Instruction (AOI) for Studio 5000 are listed under **Your Products** below — grouped on the product card.

## Go Further

### Related Quick Start Guides

- **Unwind/Rewind Web Guiding** — High-thrust web guiding for shifting roll stands
- **Retrofit an Existing Web Guide** — Upgrade a legacy or competitor web guide system with Roll-2-Roll sensors and controllers
- **Web Width Measurement** — Measure web width alongside or independently of guiding
- **Position Measurement** — Measure edge, centerline, or contrast/line position
- **Splice Detection** — Add splice detection to your web processing line

**Need Help?**
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