# Unwind/Rewind Web Guide — Oscillation (Open Loop) — SCU6x

Quick Start Guide

**Controller:** SCU6x

Scan for
interactive guide

## What You'll Achieve

After completing this guide, your roll traverses steadily back and forth on a commanded oscillation, with no web feedback.

**Estimated time:** ~30–60 minutes

## What You Need

### SCU6x · Oscillation (Open Loop) — What You Need

[ ] SCU6x web-guide controller with the MxD (7 A) driver, as ordered for the RLA. Unwind/rewind requires the SCU6x MxD option (with or without C(x)D or DIO); port Z1 supplies the driver power.

[ ] RLA sized to your roll (floating -TG mount) — see the sizing article under Learn More

[ ] RC-050A regeneration clamp — absorbs the energy the shifting roll drives back into the actuator

[ ] No web sensor — open-loop oscillation runs without web feedback

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

[ ] Driver-power cable (SKU 21229x) for the MxD driver

[ ] Actuator cordset for the RLA (SKU 21225, T-coded high-current)

[ ] Servo-center proximity sensor (SKU 7-140004) — used for homing

[ ] High-current driver-power supply (SKU PS-10001, 24/48 VDC) for the RLA driver

[ ] 24 VDC control supply, 5 A minimum (SKU 0-100006)

### 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.

[ ] A roll is loaded on the stand, with web ready to thread.

[ ] 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 set up the shifting roll stand — carriage, linear bearings, and the high-thrust actuator — then mount the sensor for your guiding mode.

> **DANGER:** Match the actuator mount to your existing structure — Identify whether your existing carriage uses a fixed (-RF) or floating (-TG) mount before ordering or installing the actuator. Fixed structures take an LHS-RF actuator; floating structures take an LHS-TG, BLA, or RLA sized to the load. Installing a fixed-mount actuator on a floating structure — or a floating-mount actuator on a fixed structure — will damage the actuator.

### Install and Align the Roll Stand

- Bolt the roll-stand base to the machine through its base-plate holes.
- Level the stand: set the roll axis parallel to the machine idlers and square to web travel, with no tilt to either side. Check it with a machine square or a tram rod — whichever you have.
- Slide the moving carriage by hand through its full travel on its linear bearings. It should move smoothly end to end with no binding, notching, or stiff spots. If it binds, clean and re-lubricate or replace the linear bearings before you fit the actuator.

### Retrofitting an existing stand?

- Reuse your existing roll-stand carriage and linear bearings — the moving structure stays.
- Replace the controls and the actuator: the old actuator and its drive come off, and the Roll-2-Roll controller, sensor, and actuator go on. Before you remove the old actuator, sketch or photograph how it attaches at both ends and note its fully-retracted and fully-extended positions — the new actuator matches that geometry and stroke.
- The rest of the install is identical to a new stand.

### Mount the Actuator

- Match the actuator to the stand's mount before you install it: a fixed (-RF) structure takes an LHS-RF actuator — LHS is the only family offered with a fixed mount. A floating (-TG) structure takes a floating-mount actuator sized to the load — RLA for heavy rolls (the unwind/rewind default), BLA for intermediate loads and wide webs needing 6 in of stroke or more, or LHS-TG for small loads.
- Bench-test the actuator before you mount it. Connect its cables to the controller, apply power, and jog it end to end from the operator interface. It should travel smoothly the full stroke. If it doesn't move or it stalls, re-check the cabling and the supply before you commit it to the machine.
- Floating (-TG) mount — connect the front rod eye to the moving carriage and the rear spherical bearing or clevis to the stationary base. Add an anti-rotation feature at the spherical-bearing end so the actuator body can't spin, and let the pins carry the rotation so the actuator self-aligns as the stand moves.
- Fixed (-RF) mount — fasten the mounting plate so the actuator's linear motion is exactly in line with the carriage travel, and apply thread-locker to any fastener screwed directly into the actuator.
- Check the alignment — jog the stand slowly across its full travel and watch it move without struggling or binding. If it fights at any point, loosen the mounts, re-square the actuator to the carriage, and re-check.
- Match the stroke to the stand travel — confirm the actuator's fully-retracted and fully-extended positions coincide

with the carriage's travel extremes, and center the stroke. If the actuator over-travels the stand, reduce the digital stroke length in the controller; if it under-travels, add mechanical stops.

- Install the servo-center proximity sensor (SKU 7-140004) so it switches exactly at mid-stroke — with the stand centered, position it to see metal within 2 mm for one half of the travel and clear space for the other half. Jog through mid-stroke and confirm its LED toggles on and off right at center; the controller uses this transition to find the actuator's home position during commissioning.
- Connect the RC-050A regeneration clamp into the actuator drive circuit as shown in the wiring diagram — a heavy roll decelerating or reversing drives regenerated energy back into the drive, and the clamp dissipates it.

### Mount the Driver Power Supply and Regen Clamp

- Mount the 24/48 VDC driver power supply (SKU PS-10001) in the machine's electrical cabinet — it is a DIN-rail / chassis-style supply. The SCU6x's MxD driver is built into the controller, so there is no separate driver box to mount.
- Route the Z1 driver-power cable (SKU 21229x) from the cabinet to the SCU6x's Z1 driver-power port. The cable splits to the supply and the RC-050A regeneration clamp.
- The RC-050A clamp is DIN-rail mounted — clip it to the rail next to the 24/48 VDC supply in the cabinet and connect it to the clamp leg of the Z1 split.

### Choose the Sensor Location and Mount the Sensor

- **Unwind stand:** mount the sensor in the first free span downstream of the idler that follows the roll — it has to read the web after the shifting stand has moved it, not before.
- **Rewind stand:** mount the sensor just upstream of the fixed idler ahead of the rewind stand, so it reads the edge before the web winds on. Mount it on the rewind frame itself, not the machine frame — rewind guiding chases the web, and the sensor must move with the stand to hold the relative position between the web and the rewind roll.
- Clamp the sensor bracket to its rail, but don't fully tighten it yet.
- Set the working distance from the sensor face to the web to 5–15 mm (0.2–0.6 in).
- 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.

### Pre-Power Mechanical Checks

- Do these with the power off, before you commission. With the actuator mounted, don't force the stand by hand — you can back-drive the actuator.
- Confirm the actuator is mounted in line with the carriage travel and its retracted and extended limits line up with the stand's travel extremes.
- Confirm the servo-center proximity sensor is installed and its LED changes state as the carriage passes mid-stroke.
- Confirm the RC-050A regeneration clamp is connected in the actuator drive circuit per the wiring diagram.
- Confirm every cable is routed and strain-relieved, and that nothing is powered yet.

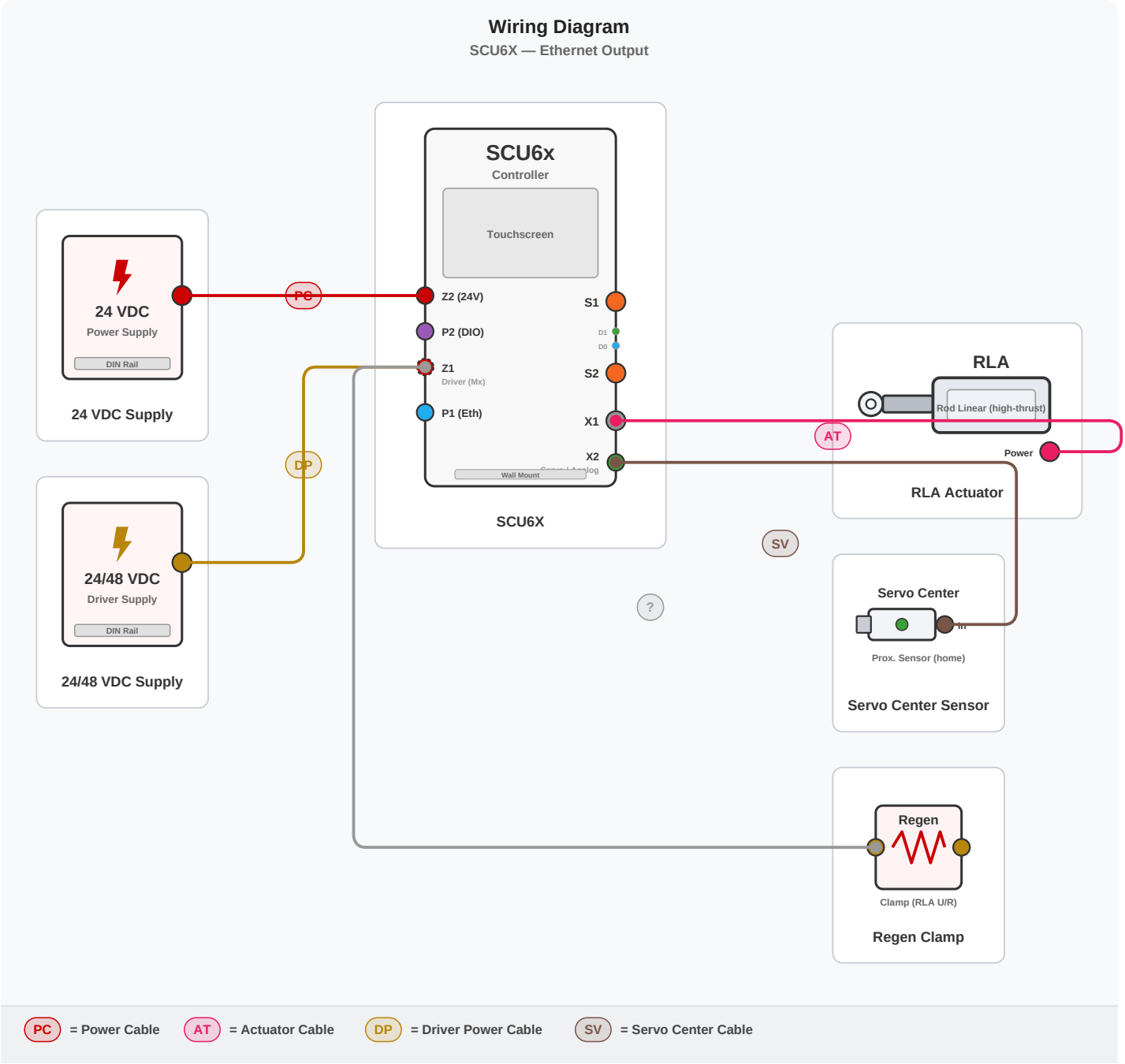
## 2. Install the Sensor

### Install the Sensor — Oscillation (Open Loop)

- Open-loop oscillation uses no web sensor — there's no web feedback, so there's nothing to mount here. Homing uses the servo-center proximity sensor you installed with the actuator.

## 3. Wire the System

### Wiring Diagram



### Bill of Materials

| Qty | Item | SKU | Connection |
|---|---|---|---|
| 1 | 24 V DC Input Power Cable for SCU6x or 1DC - 5m | 21218x-5m | power.output ? controller.Z2 |
| 1 | Actuator cordset (M12, T-coded) — 21225 high-current (RLA) | 21225 | controller.drive ? actuator.power |
| 1 | Driver power cable — SCU6x MxD port Z1, splits to the 24/48 VDC supply and the regen clamp | 21229x | psu48.output ? controller.Z1 |
| 1 | Regeneration clamp — on the Z1 driver-power cable split; absorbs regenerated energy from the RLA under unwind/rewind duty | RC-050A | controller.Z1 ? regen.in |
| 1 | Servo Center Sensor with M8 QD cable | 7-140004 | controller.servo ? servo.in |

## 4. Configure & Verify

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

### Oscillation (Open Loop) — Power Up and Commission

Commission open-loop oscillation — home the actuator, set the profile, and run the reciprocating motion (no web sensor).

1. Power on the controller. If it wakes in Automatic, switch to Manual — every step below runs from Manual.
2. Check the jog direction. Tap Jog Left, then Jog Right, and watch the roll stand move through its travel. If it moves the opposite way to the button, reverse Motor Polarity under Power User ? Actuator ? Motor Polarity, then jog again to confirm.
3. Servo-center the actuator. Tap Servo Center and let the stand travel to its home position — this is the center the oscillation runs about. If it heads away from home, reverse Servo Center Polarity under Power User ? Actuator ? Servo Center Polarity, then servo-center again.
4. Set the oscillation. Turn Oscillation ON and set the type to open-loop. Set Amplitude as a percent of the actuator stroke, Speed as a percent of the actuator's top speed, and Dwell as a number of samples (the pause at each turnaround).
5. Press Auto from the home screen. The actuator now ramps the stand back and forth about its home — linearly out to the amplitude limit, a dwell, linearly back, a dwell, repeating.
6. Watch a few full cycles. Confirm the travel stays inside the mechanical limits and the period matches your speed and dwell. If it reaches a stop, lower the amplitude; if the timing is off, adjust speed or dwell. Your oscillation is commissioned when it runs full cycles without hitting a limit.

## 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

- **Intermediate Web Guide** — Guide the web mid-machine with an intermediate web guide and LHS actuators
- **Retrofit an Existing Web Guide** — Upgrade a legacy or competitor web guide with Roll-2-Roll sensors and controllers

**Need Help?**
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