# Intermediate Web Guide — Line Guiding — SCU6x

Quick Start Guide

**Controller:** SCU6x | **Sensor:** ODC 96

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## What You'll Achieve

After completing this guide, your web tracks a printed or physical line — the guide follows the line as it moves across the web.

**Estimated time:** ~30–60 minutes

## What You Need

### Line Guiding — SCU6x

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

[ ] Linear actuator — your ordered LHS model

[ ] ODC Family white-light sensor, sized for the wander range of your line

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

[ ] Backup roller (any roller or dead bar) — supports the web to hold the working distance steady; keep the wrap as small as possible

[ ] 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.

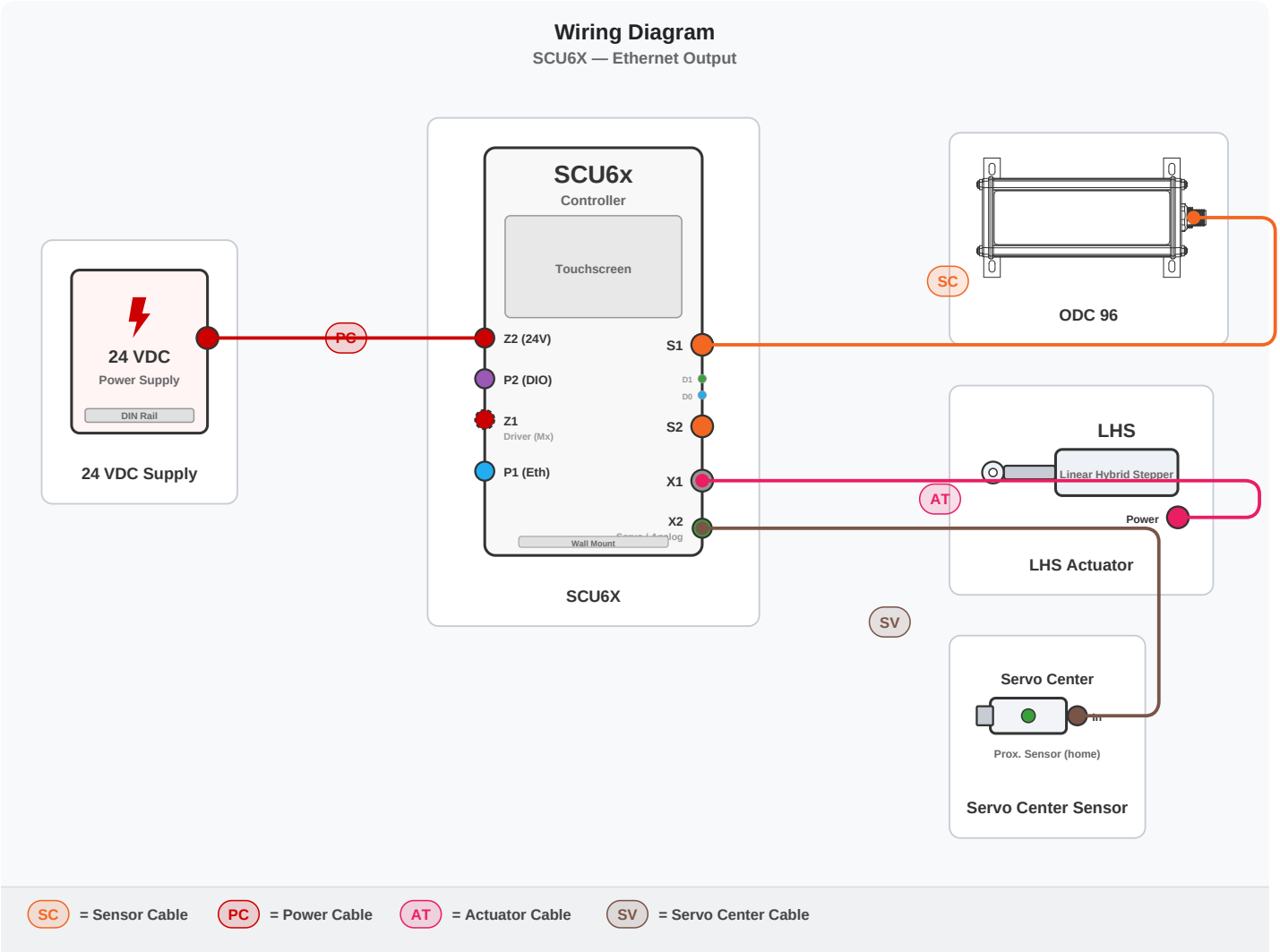
## 2. Install the Sensor

### Install the Sensor — Line Guiding

- Line guiding uses a single ODC Family sensor over the line, and needs a backup roller (any roller or dead bar) directly under the sensor to hold the working distance steady — the sensor reads a plane change as a contrast change. Keep the wrap as small as possible.
- Any roller or dead bar works as the backup roller. Keep its wrap as small as possible so it doesn't change how the web moves in the exit span.

## 3. Wire the System

### Wiring Diagram




### Bill of Materials

| Qty | Item | SKU | Connection |
|---|---|---|---|
| 1 | Quick Disconnect Sensor Cable - 3m (10 ft) | U2-01975 | sensor.connector ? controller.S1 |
| 1 | 24 V DC Input Power Cable for SCU6x or 1DC - 5m | 21218x-5m | power.output ? controller.Z2 |
| 1 | Actuator cordset (M12 4-pin) — 21224 A-coded (LHS-005/020, BLA); 21225 T-coded (LHS-030) | 21224 | controller.drive ? actuator.power |
| 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.

### Line Guiding — Power Up and Commission

Commission single-sensor line guiding — teach the line, prove the motion, then track it in automatic.

1. Power on the controller. If it wakes in Automatic, switch to Manual — every step below runs from Manual.
2. Set the sensor to contrast sensing.
3. Teach the line. On the Operator ? Sensor screen, enter teaching mode, pick the line/contrast mode from the on-screen icons, and use the left/right arrows to land on your line in the live image. Save with the gear button — it turns red and a green box locks around the line. Until a valid feature is taught, the controller stays interlocked and won't enter Automatic.
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 the target onto the line's current position. (To offset it, drag the guide-point bar and press Accept.)
7. Switch to Automatic. The guide now tracks the taught line. If it won't enter Automatic, the line isn't taught or isn't in view — re-teach at step 3.
8. Check the correction direction. Nudge the web so the line moves off target. The guide should bring it back. If it drives the line 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 tracked line to the exact spot — about 0.25 mm (0.01 in) per tap.
10. Prove the safety hold. Pull the line out of the sensor's view. The guide should hold its last position (it won't recenter) until the line returns. When it holds, your line 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.

### YOUR PRODUCTS

**ODC 96**

- Product Page
- 2D Drawing (PDF)
- 3D Model (STEP)

Scan for product info

**SCU6x**

- Product Page
- 2D Drawing (PDF)
- 3D Model (STEP)

Scan for product info

## 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?**
Email: experts@r2r.tech | Phone: +1-888-290-3215