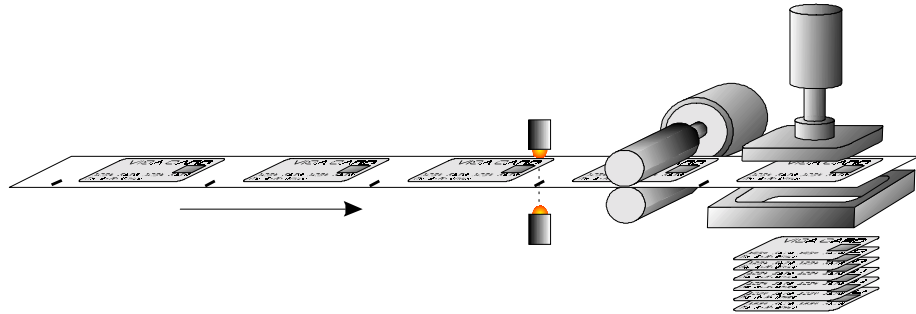


# ATM Card Production

Key Features Used: **REGIST, MOVEMODIFY**

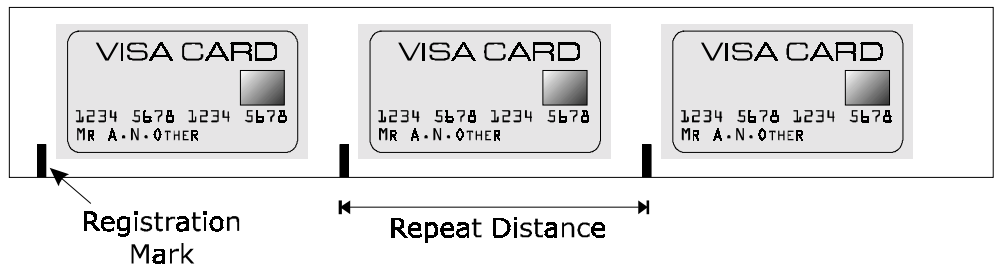
An automated die-cutting machine, is designed to punch out pre-printed plastic cards for use in ATM machines etc.



There is one servo axis which is connected to the draw rollers which feed the card into the machine. A printed registration mark appears once per card and is sensed by an optical sensor connected to the Registration input of the MC2xx's Servo Daughter Board.



The operation of the machine is quite simple, the cards are printed at a known fixed-pitch. Each cycle, the draw rolls must feed the card into position, an output is then fired to operate the punch. An input signals that the punch is clear of the cards and the cycle can repeat.



In an ideal situation we would simply datum the first card and then move a fixed pitch every cycle,

```

loop:
  MOVE(card_pitch)
  WAIT IDLE
  OP(punch,ON)
  WAIT UNTIL IN(punch_clear)=OFF
  WAIT UNTIL IN(punch_clear)=ON
  OP(punch,OFF)
  GOTO loop
  
```

