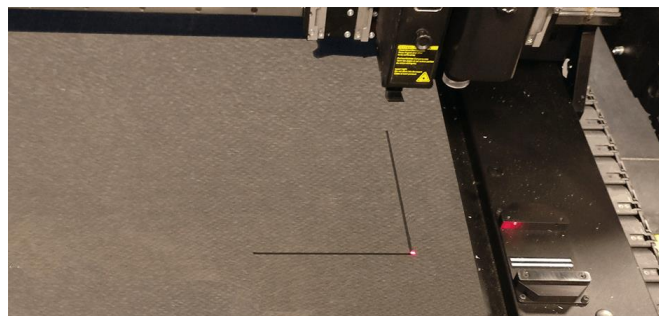


In Tandem mode, the active work area on the flatbed can be divided into a front and rear processing area, allowing you to load and unload material on one side of the table while cutting material on the other side of the table. This avoids periods of inactivity during material processing, significantly improving the overall workflow.



To facilitate loading jobs on the table, we recommend marking the loading position of the material. It will not be necessary to do this every time the tandem mode is used; only when the lines have faded is it necessary to redraw them:

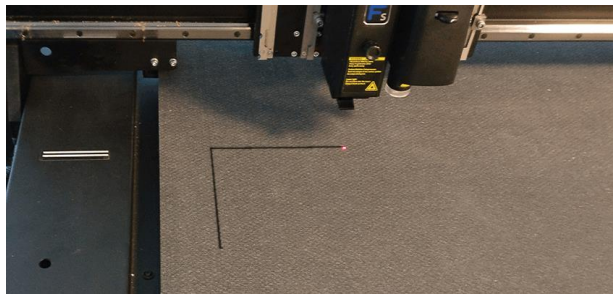
1. In Axis Control, go to the **Media** menu > **Origin** > **Pointer**.
2. Use the arrow buttons to move the carriage as far as possible to the front right, or set both origin values to 0 and click **Update**. Mark this point on the conveyor.
3. Use the arrow buttons to move the carriage 150 to 200 mm to the left, or change the Y-value to a value between 150 and 200 and click **Update**. Mark this point.
4. Use the arrow buttons to move the carriage as much as possible to the right and then 150 to 200 mm to the rear, or set the origin values both to 0, click Update, change the X-value to a value between 150 and 200 mm and click **Update** again. Mark this point.
5. Move the carriage out of the way and draw a line from the origin point (step 2) to the other two points (steps 3 + 4).
6. Use the arrow buttons to move the carriage back to the origin point or set both origin values to 0 mm and click **Update**. Then click **Apply**.



7. Click **Size** > **Pointer**.
8. Use the arrow buttons to move the carriage as much as possible to the rear left, or change the length value to 3200 and the width value to 3260, then click **Update**. Mark this point on the conveyor. This is the full size marker point.
9. Use the arrow buttons to move the carriage 150 to 200 mm to the right, or change the width value to 3060 and click **Update**. Mark this point.
10. Use the arrow buttons to move the carriage as much as possible to the left and then 150 to 200 mm to the front, or set the length value to 3000, the width value to 3260 and click **Update**. Mark this point.

Move the carriage out of the way and draw a line from the full size marker point (step 8) to the other two points 11. (steps 9 and 10).

12. Use the arrow buttons to move the carriage back to the full size marker point, or change the length value to 3200 and the width value to 3260, then click **Apply**. This marks the opposite origin point for the tandem mode.



Now that all the required markings have been drawn on the conveyor belt, tandem mode can be started.

**If, however, the position of the conveyor and the origin points need to be corrected after the conveyor has moved because of another job, perform the following steps:**

1. If the front origin point is visible on the right side, click **Media** in Axis Control > **Origin** > **Pointer**.
2. Place the pointer above the corner of the origin mark and click **Feed**.
3. If the origin mark is not accessible, click **Feed** and feed the conveyor 3000 mm.
4. Perform another check.

**To start tandem workflow:**

1. In Summa GoProduce, click the **Tandem mode** action set.
2. If necessary, change the parameters (the default setting for the number of jobs/sheets is 100). Once the parameters are set, click **Run**.
3. While the job is being processed, you can place a new sheet on the other side of the flatbed.
4. Once this is done, click **Release rear/front zone** (depending on which side the flatbed is cutting). If the zone is not released, the table will pause after processing the job and prompt you to replace the sheet. The machine will wait until this is done. Click **Resume**, otherwise the table will continue processing the next copy.