

# Gamma 333 LCD

## Calibration

---

### > Before you begin

- Turn the machine on (Main switch).
- Allow software to load, press green “On” button.
- Do not reset.
- Raise the shield.
- Have pins and calibration block ready.



***If the emergency stop button is pushed during this procedure, the calibration will have to be started once again from the beginning.***

# Calibration

## > Log in


- Select “security” and press enter.

main menu	MAIN				
production	PR0D				
programming	TEACH				
wire list	LIST				
process paramet.	PPARA				
setup	SETUP				
configuration	CONF				
<b>security</b>	<b>LEVEL</b>				
language	LANG				
calibration	CALIB				
PR0D	TEACH	LIST	PPARA	SETUP	CONF

## > Enter password

- “435” is the default password to gain access. Now, enter the calibration screen “CALIB” by pressing F5.

Security	LEVEL			
security code:	██████			
security level:	0			
PR0D	TEACH	LIST	CONF	CALIB



# Calibration

## > Remove blade blocks

- Refer to chapter 10 in operator's book for more information.

## > Calibration page

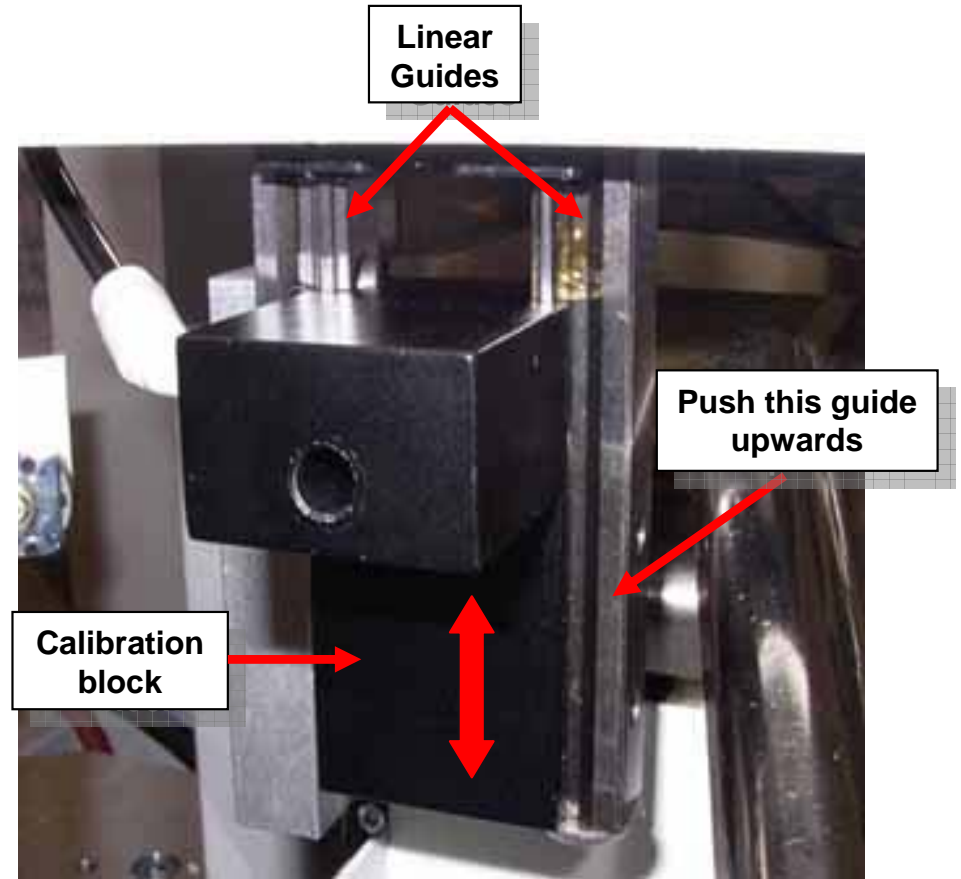
- Scroll to page 3 by pressing F6.
- Select "knife axle".

calibration		3/3	CALIB	
Motor axle		old	new	
knife axle		-89	<input checked="" type="checkbox"/>	0
cut position side 1		-144	<input type="checkbox"/>	0
pull-off axle 1		129	<input type="checkbox"/>	0
cut position side 2		-127	<input type="checkbox"/>	0
pull-off axle 2		390	<input type="checkbox"/>	0
new	old	save	prev	next

# Calibration

## > Install calibration block

- After the block is put in, it should slide up and down easily.
- Make sure the block sits in between the two linear guides, otherwise it could crash.
- Slightly close the right side guide manually, enough to hold the block in place.
- Picture to the right shows a view from side one.



# Calibration

## > Knife axle

- With knife axle selected press “new” with the F5 button; this will home the knife axle.
- Slide the calibration block up and down by hand; at the same time proceed to close the blades with the minus button.
- Stop when all the play is eliminated, then back off one step.

calibration 3/3		CALIB	
Motor axle		old	new
knife axle		-89	0
cut position side 1		-144	0
pull-off axle 1		129	0
cut position side 2		-127	0
pull-off axle 2		390	0
new	old	save	prev next

- When done, hit F3 to save values and scroll down to “cut position side 1”.



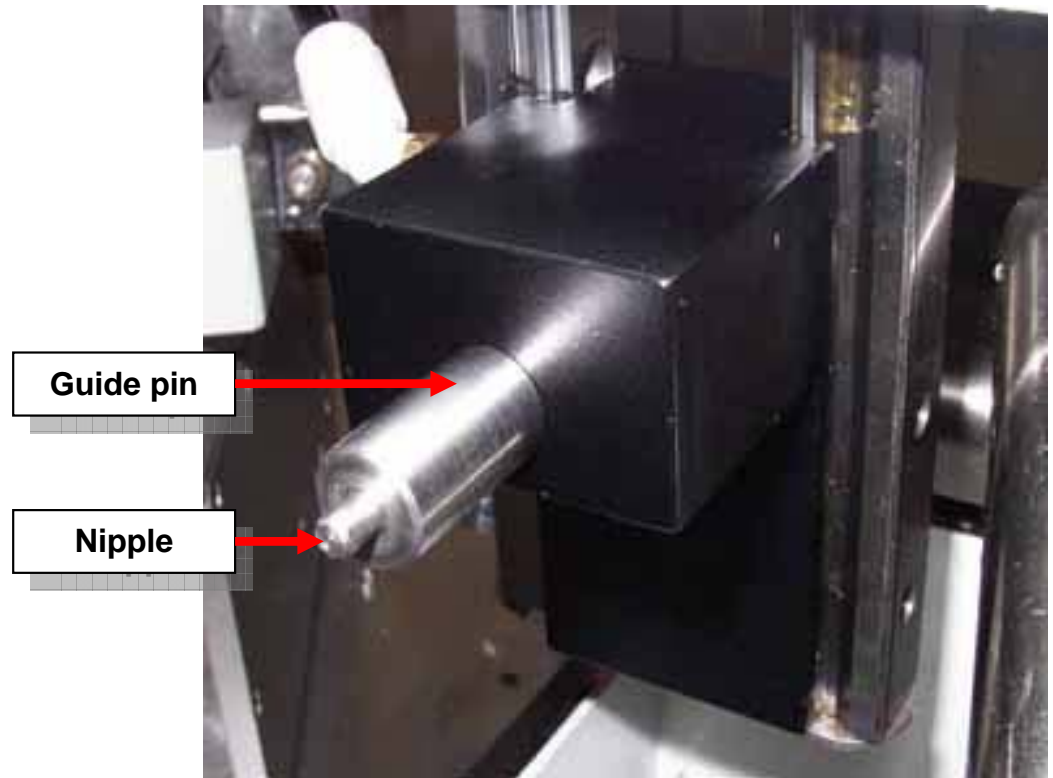
***Do not bottom out, this could damage the calibration block and/or linear guides.***

# Gamma 333 LCD

## Calibration

### > Insert pin

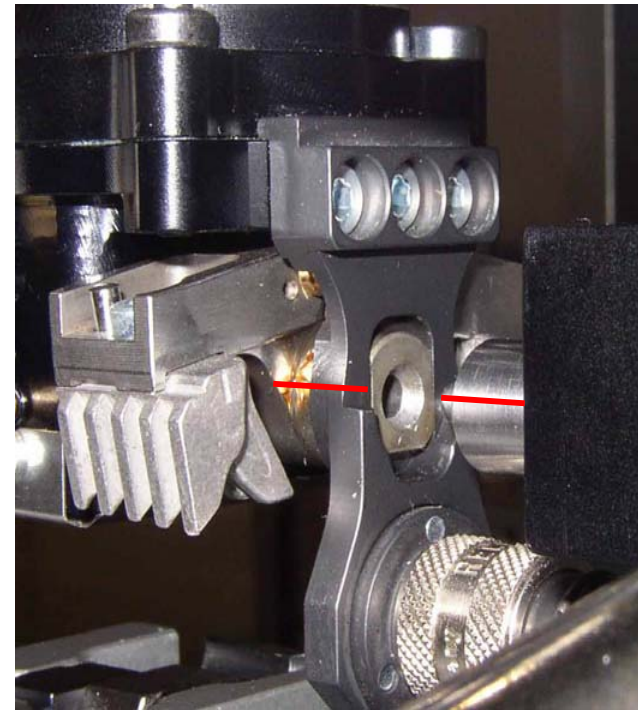
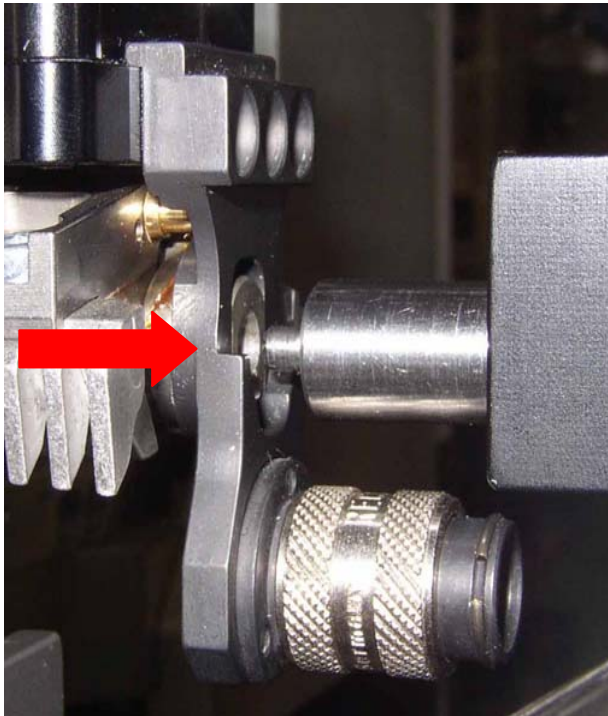
- Insert the pin into the block as shown in the picture to the right.



# Calibration

## > Lining up

- Insert guide pin nipple into hole on gripper head.

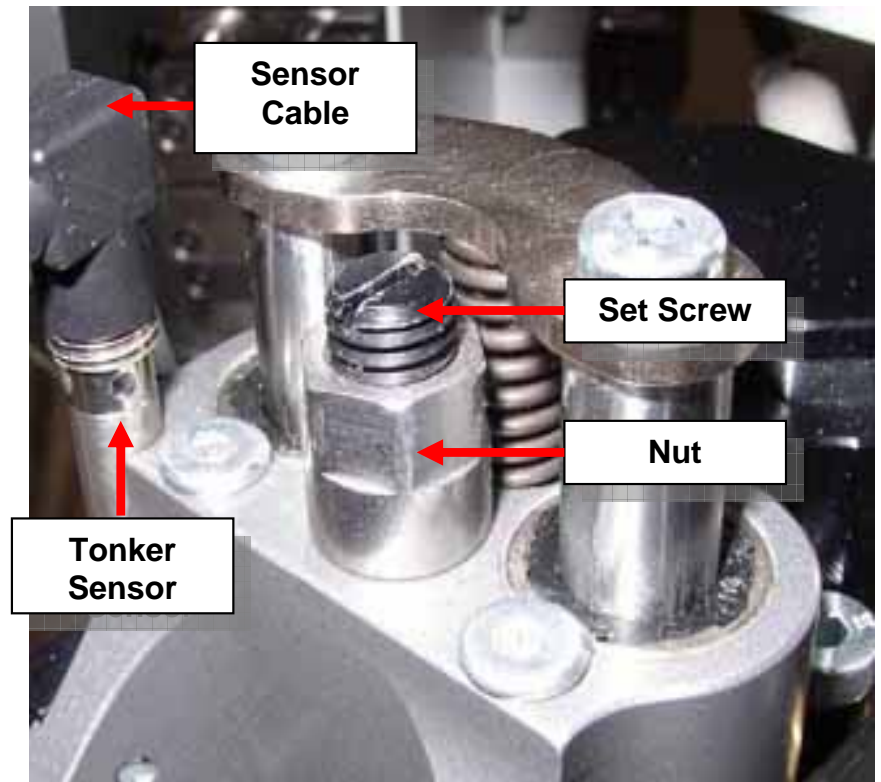


***The following adjustment should only be used for calibration.***

# Calibration

## › Adjusting gripper height

- Manually move the gripper head back and forth. If it seems like the gripper head height is off, we can adjust this now.
- To begin adjusting, remove tonker sensor first to avoid breaking it.
- To adjust height, loosen nut and turn set screw.
- Counter-clockwise = Up  
Clock-wise = Down.
- When done, readjust sensor gap to 0.5 mm (0.019in).



***Adjust only for calibration***

# Calibration

## > Swivel side one positioning

- Move head back by hand (away from calibration block).
- Scroll down to “cut position side 1” and select “new” with the F1 button. This will lock the swivel.

calibration 3/3		CALIB	
Motor axle	old	new	
knife axle	-89	-88	
cut position side 1	-144	<input checked="" type="checkbox"/>	
pull-off axle 1	129	0	
cut position side 2	-127	0	
pull-off axle 2	390	0	
new	old	save	prev next

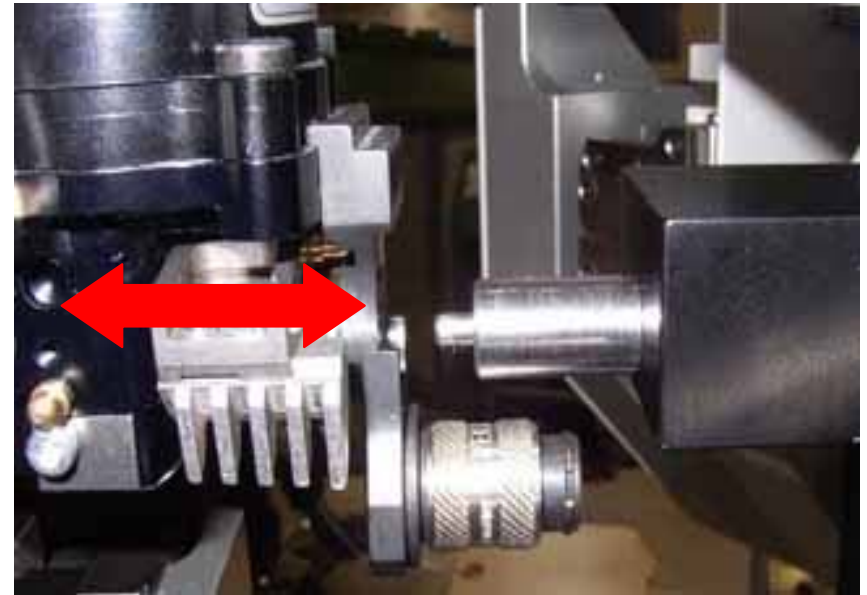


*New values may be the same or close to old values.*

# Calibration

## › Swivel side one positioning

- Proceed to adjust swivel with the minus button and at the same time move the head manually in and out until the pin goes into the hole smoothly.
- Hit “save” with the F3 button, and scroll down to “pull off axle 1”.



***Do not bottom out, this could damage the calibration block and/or linear guides.***

# Calibration

## > Pull off side one positioning

- With “pull off axle 1” highlighted, hit “new” with F1. This will cause the arm to lock up.
- Start moving the arm towards the cut head with the plus button.

calibration 3/3		CALIB	
Motor axle		old	new
knife axle		-89	-88
cut position side 1		-144	-145
pull-off axle 1		129	0
cut position side 2		-127	0
pull-off axle 2		390	0
new	old	save	prev next

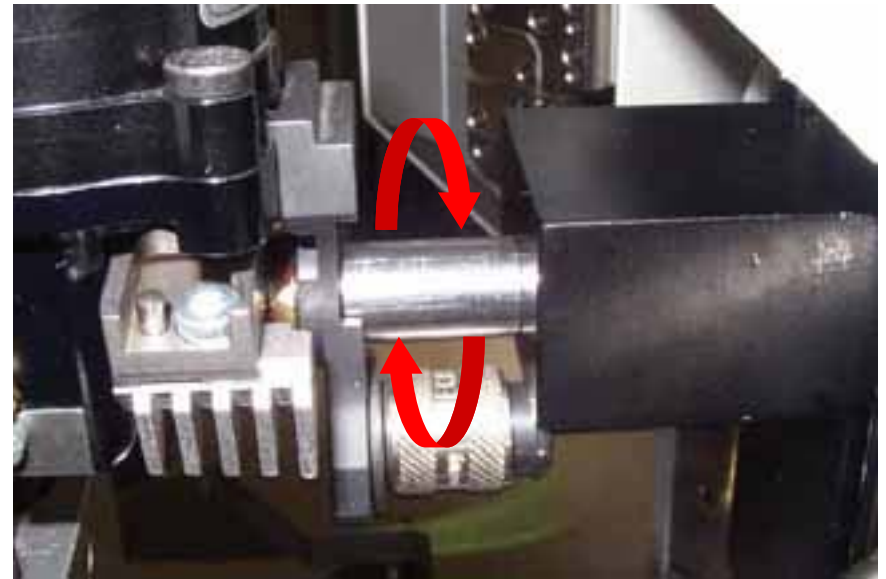


***Do not bottom out, this could damage the calibration block and/or linear guides.***

# Calibration

## › Pull off side one positioning

- Bring the head in towards the cuthead until it gets difficult to twist the pin by hand.
- Once finished, hit “save” with F3 and scroll down to “cut position side 2”.



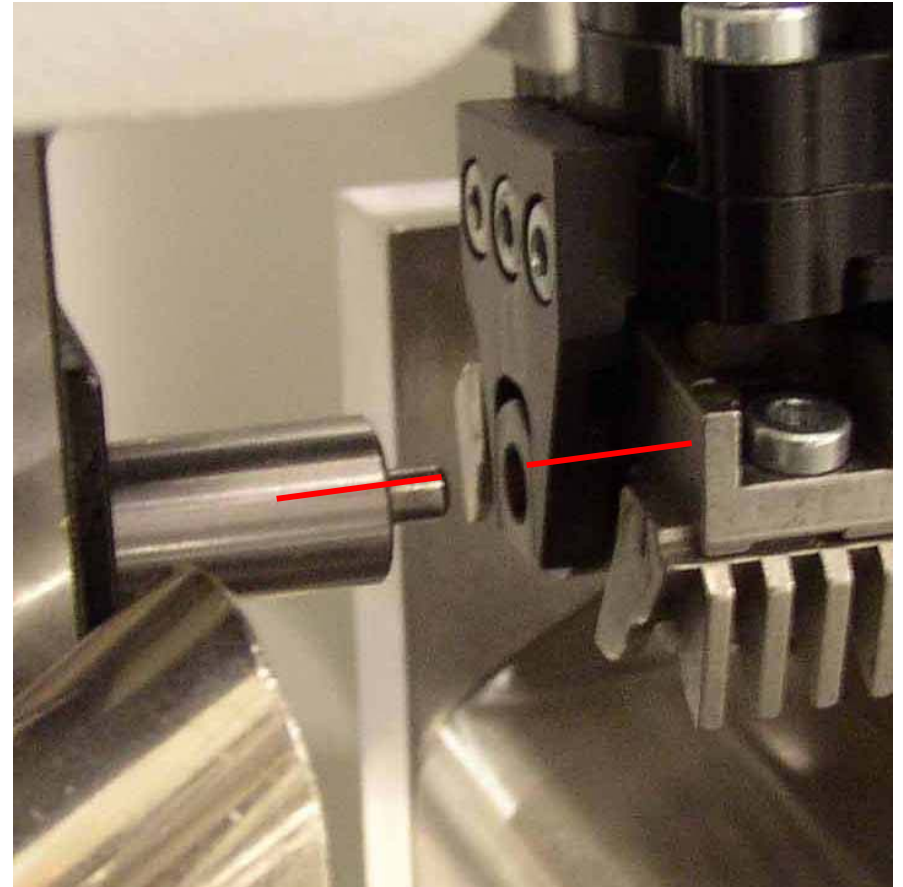
***Do not bottom out, this could damage the calibration block and/or linear guides.***

# Gamma 333 LCD

## Calibration

### > Lining up

- Insert pin on side two and try to align guide pin nipple into hole on gripper head.
- If height seems to be off, refer to page 8 (adjusting gripper head height) and follow the steps.



# Calibration

## > Swivel side two positioning

- If the gripper height adjustment was performed and the pin on side two was left inserted, move the arm back (away from cut head).
- With “cut position side 2” selected, hit “new”. The swivel function of the arm is now locked.
- Start by pressing the minus key, this will move the swivel arm on side two.

calibration		3/3	CALIB	
Motor axle			old	new
knife axle			-89	-88
cut position side 1			-144	-145
pull-off axle 1			129	127
cut position side 2			-127	<input type="checkbox"/>
pull-off axle 2			390	0
new	old	save	prev	next

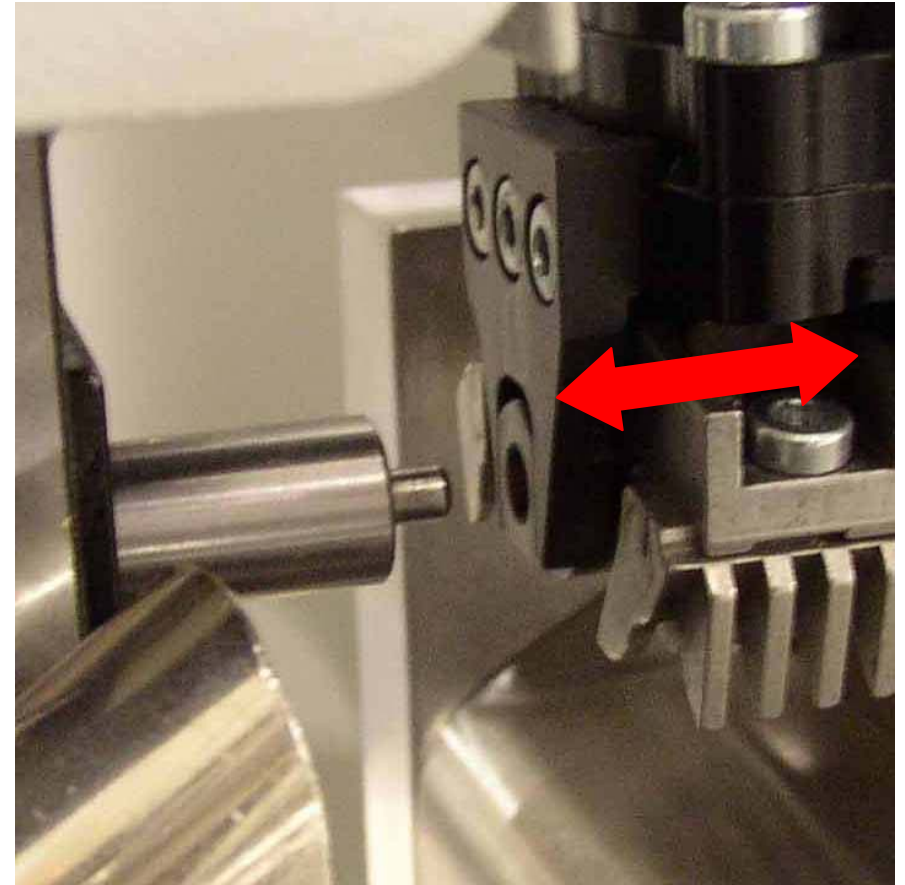


***Do not bottom out, this could damage the calibration block and/or linear guides.***

# Calibration

## > Swivel side two positioning

- As the swivel is adjusted, move the arm in and out by hand until the nipple goes smoothly into the hole.
- Once completed, hit “save” with F3.
- Scroll down to “pull off axle 2”.



# Calibration

## > Pull-off side two positioning

- With “pull off axle 2” highlighted, press “new” with F1. The arm will now lock.
- Begin by pressing the plus button.

calibration 3/3		CALIB	
Motor axle		old	new
knife axle		-89	-88
cut position side 1		-144	-145
pull-off axle 1		129	127
cut position side 2		-127	-130
pull-off axle 2		390	0
new	old	save	prev next

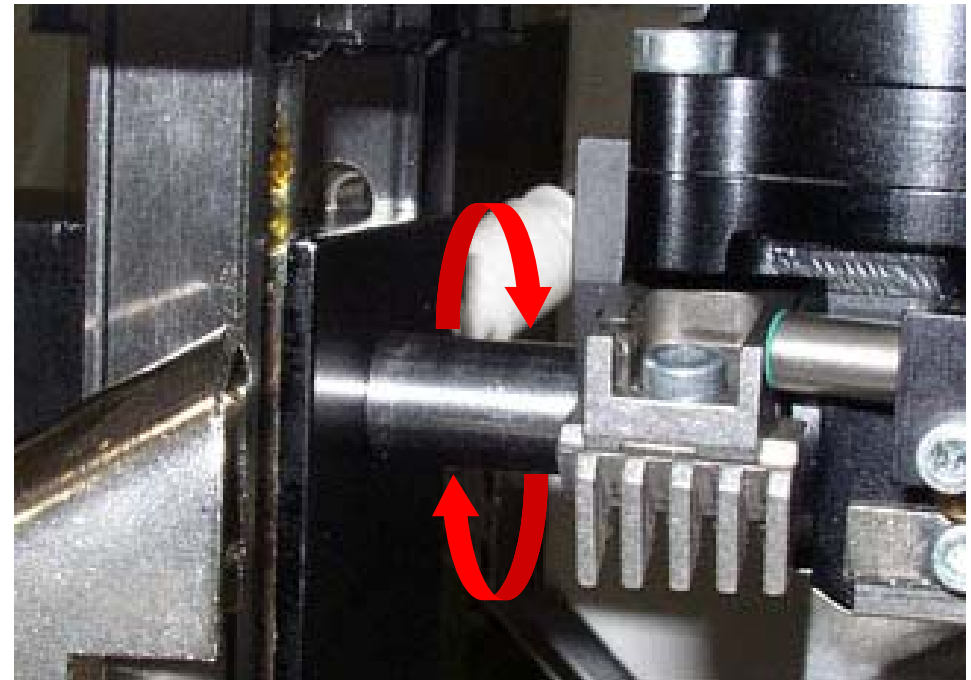


***Do not bottom out, this could damage the calibration block and/or linear guides.***

# Calibration

## > Pull-off side two positioning

- Continue to bring the arm in towards the cut head and at the same time twist the pin by hand.
- Stop when the pin can no longer twist easily.
- When done, press “save” with F3.



***Do not bottom out, this could damage the calibration block and/or linear guides.***

# Calibration

## > Pull-off side two positioning

- Press the main button to exit the calibration screen.
- At this point the calibration block may be removed and blade blocks can be installed.

calibration 3/3		CALIB	
Motor axle		old	new
knife axle		-89	-88
cut position side 1		-144	-145
pull-off axle 1		129	127
cut position side 2		-127	-130
pull-off axle 2		390	<input type="text" value="389"/>
new	old	save	prev next



***When installing the bottom blade block, push down while tightening it. For the top blade block, push it up while tightening it.***