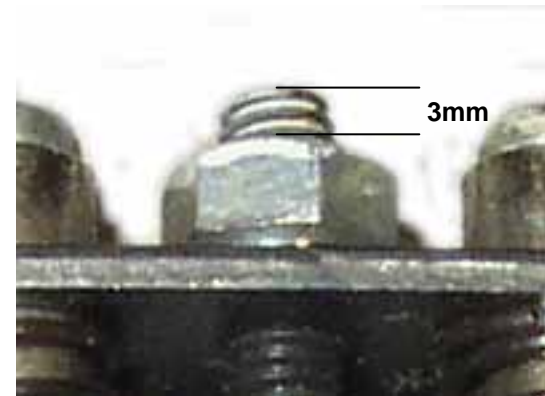


Blade Function Values Calibration

- › Disconnect power to the machine and remove front panel.
- › Locate zeroing assembly shown in figure 1.1

Measure the distance from the top of the nut to the top of the screw.
The distance should measure 3mm.
If not, adjust to proper height.



Note: Blade function values should be within tolerance of the numerical values given in the operators manual. If these numbers vary greater than +/- 10, perform the following steps.

Blade Function Values Calibration

- › Locate sensor flag assembly shown in figure 1.2



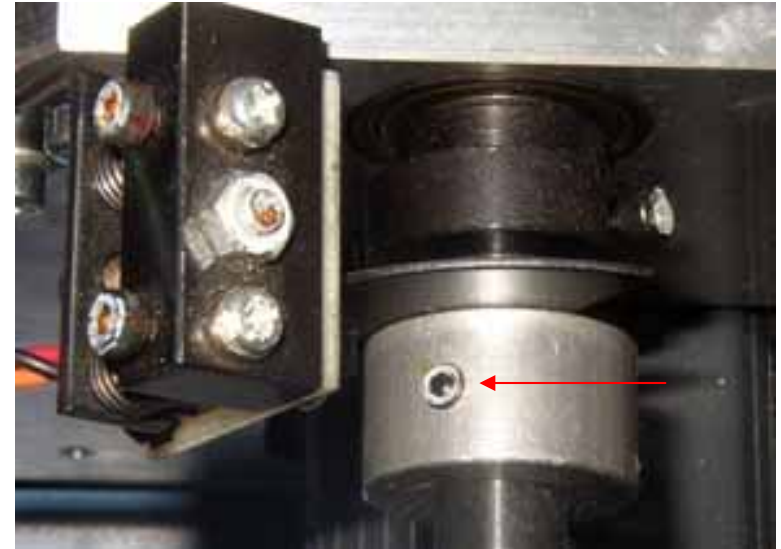
Figure 1.1



Figure 1.2

Blade Function Values Calibration

- Set The S.W/T.W. switch to T.W. (thin wire) and apply power.
- Notice how the set-screw on the sensor assembly rotates to an accessible position.
- Remove power.
- Carefully loosen the set screw and *slightly* rotate the assembly clock wise to increase the opening, and counter clock wise to decrease the blade opening.
- Tighten set-screw.
- Return to S.W. (standard wire) mode.



Blade Function Values Calibration

- › For precise calibration follow the above steps. Select a wire which has run successfully and set your B.F. setting to the target number. Run several pieces to establish which direction of blade change is required (increase or decrease opening). Make the adjustments in small increments until the wire strips properly at your target B.F.

Note: The preceding steps should be performed with the (Y) (way back settings at zero if possible).