

Gamma 333 PC

Calibration

> Before you begin

- Turn the machine on (Main switch).
- Log into windows with administrator privileges.
- Once Topwin loads, 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.

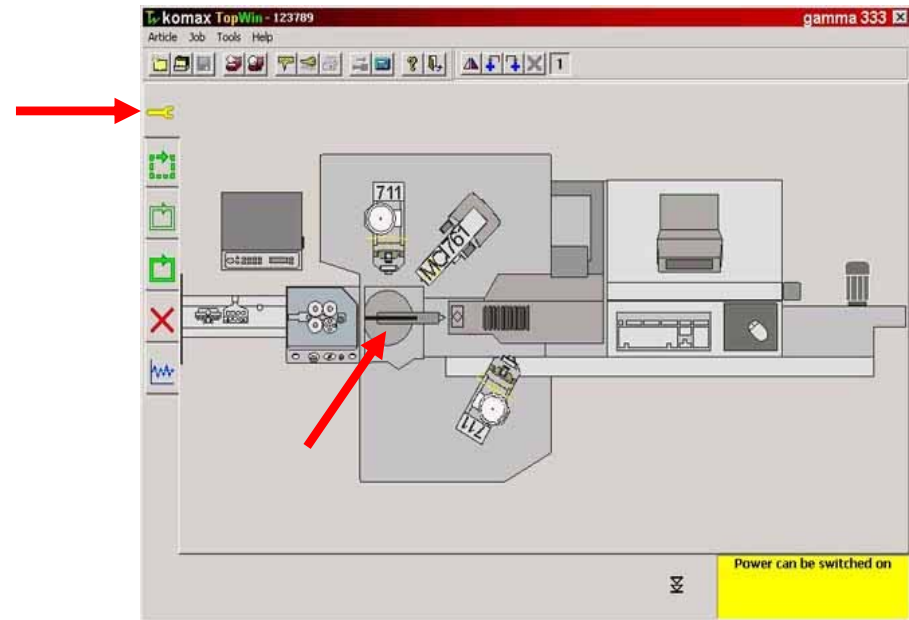
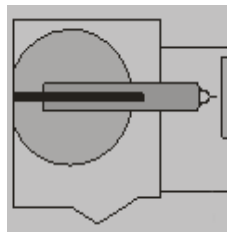
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> Configuration screen

- Click on the configuration tab.

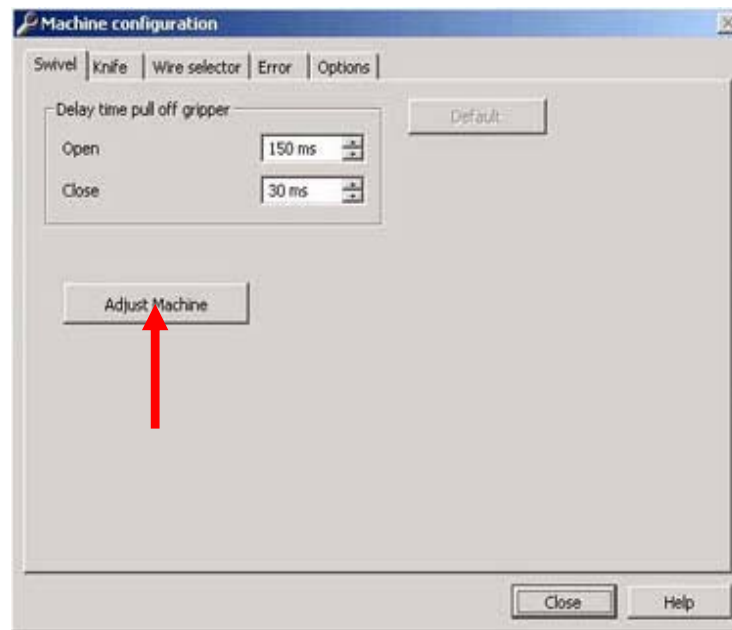


- Then click on the swivel arm. After doing so, another window will pop up.



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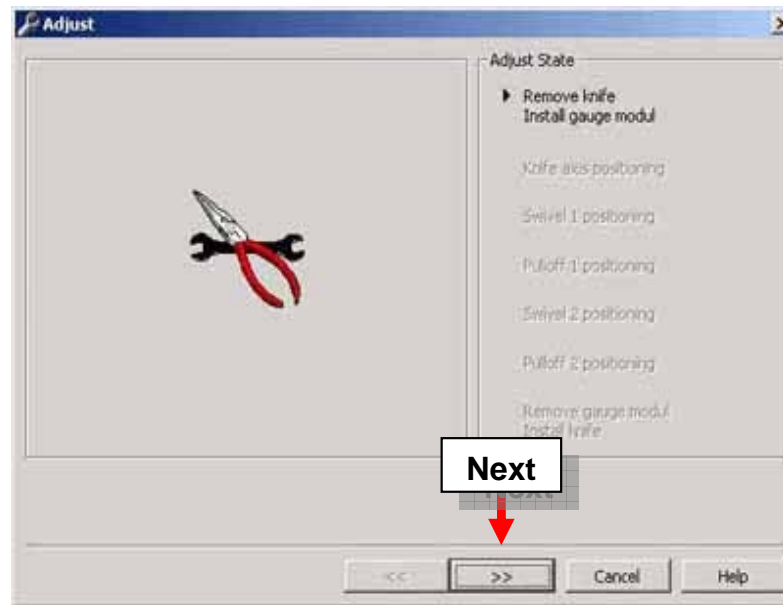
- › **Click “Adjust Machine”**
 - Another window will pop up.



If the button is grayed out, close this screen. Next, press the red Off button, then press the green ON button and try once again. If button remains grayed out, log back in as an administrator.

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- › **Remove blade blocks**
 - After removing them, click next.

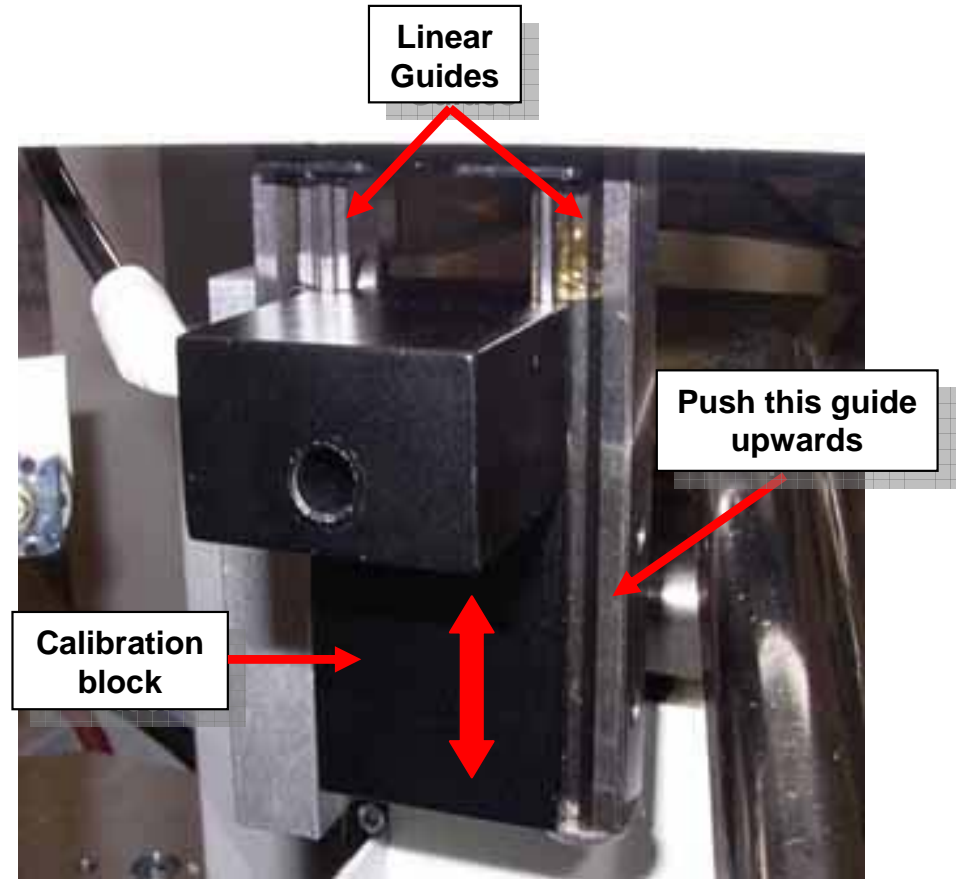


Refer to chapter 10 in operator's book for more information.

Calibration

> Install calibration block

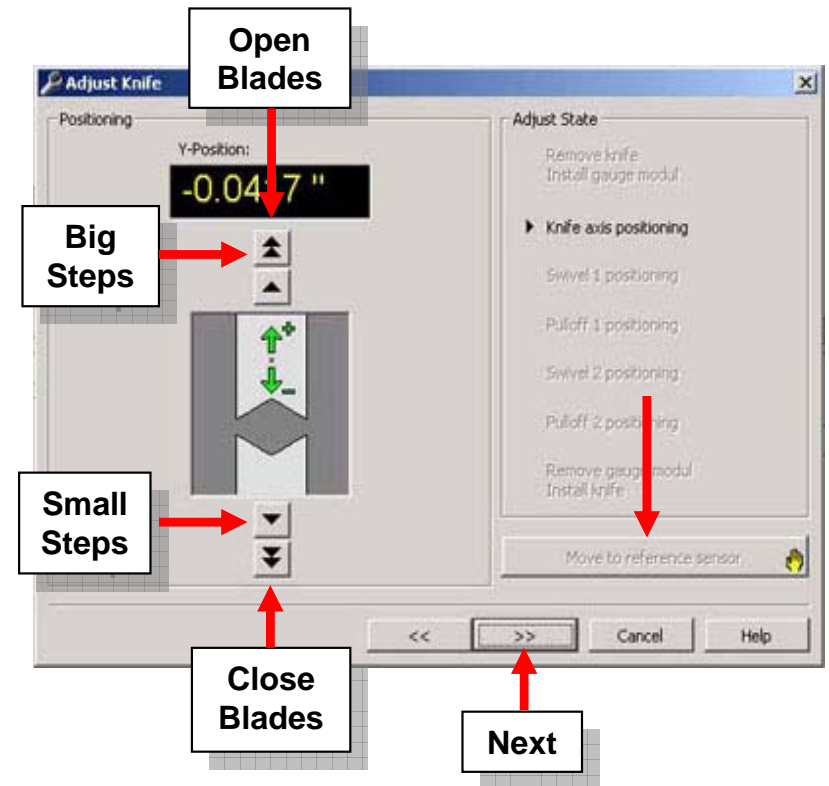
- After the block is put in, it should slide up and down easily.
- Make sure the block sits in between the two linear guides, otherwise it could crash.
- Slightly close the right side guide manually, enough to hold the block in place.
- Picture to the right shows a view from side one.



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> Closing the guides

- Press and hold the confirm key and then click on the “Move to reference sensor” button, the guides will close.
- Slide the block up and down by hand; at the same time proceed to close the blades in small steps until all the play is eliminated, then back off one small step.
- When done, click next.



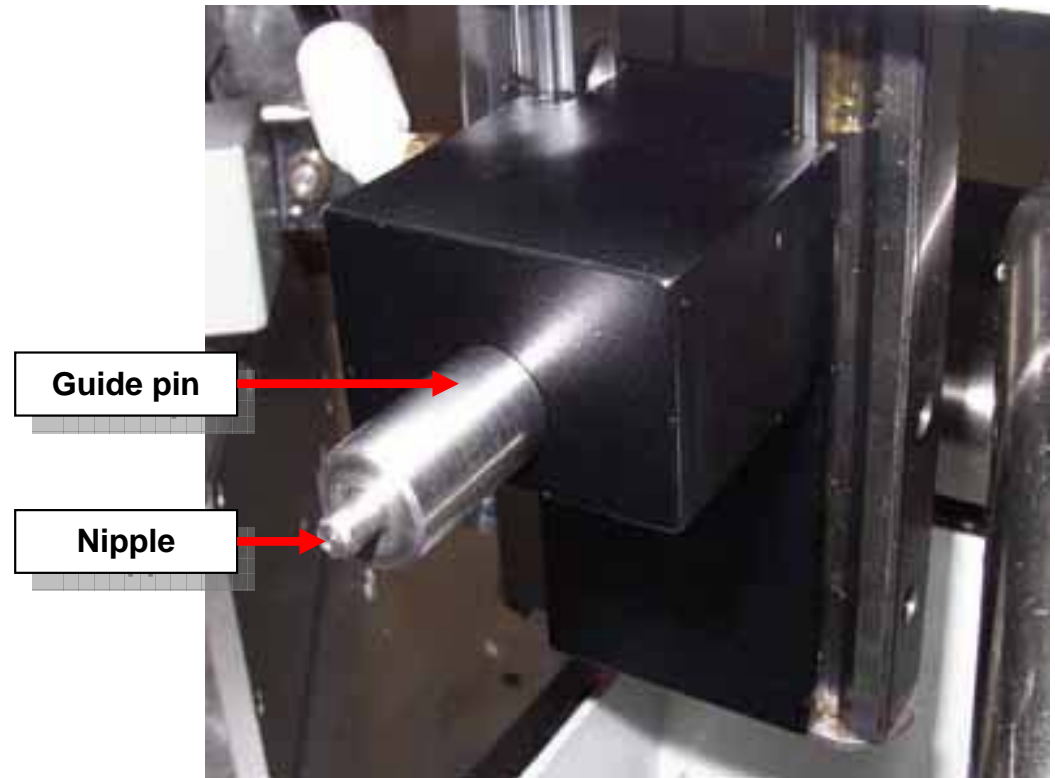
Do not bottom out, this could damage the calibration block and/or linear guides.

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Calibration

> Insert pin

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

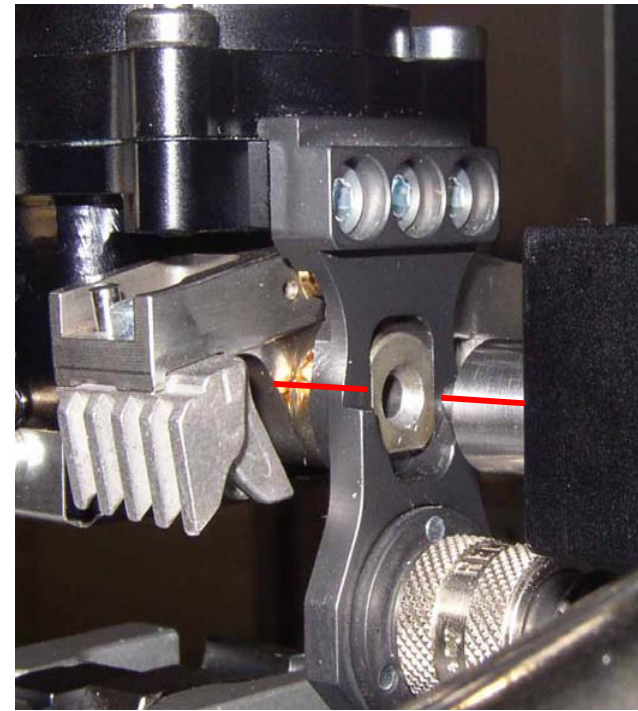
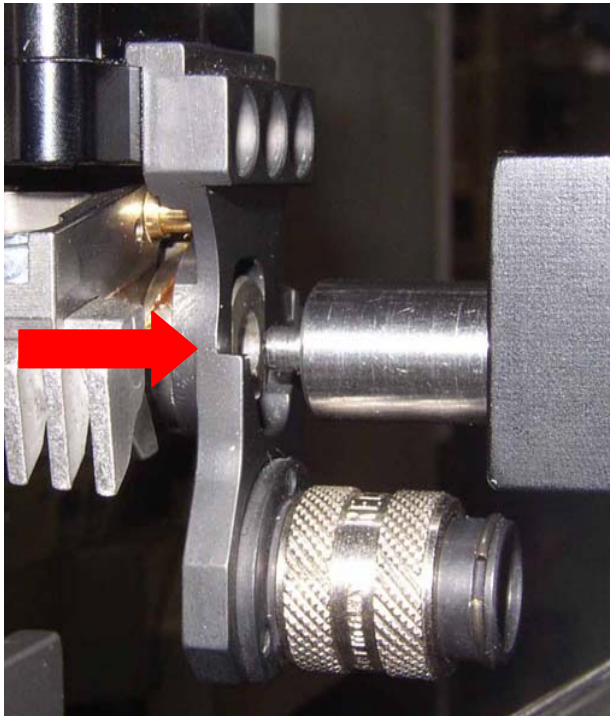


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Calibration

> Lining up

- Insert guide pin nipple into hole on gripper head.

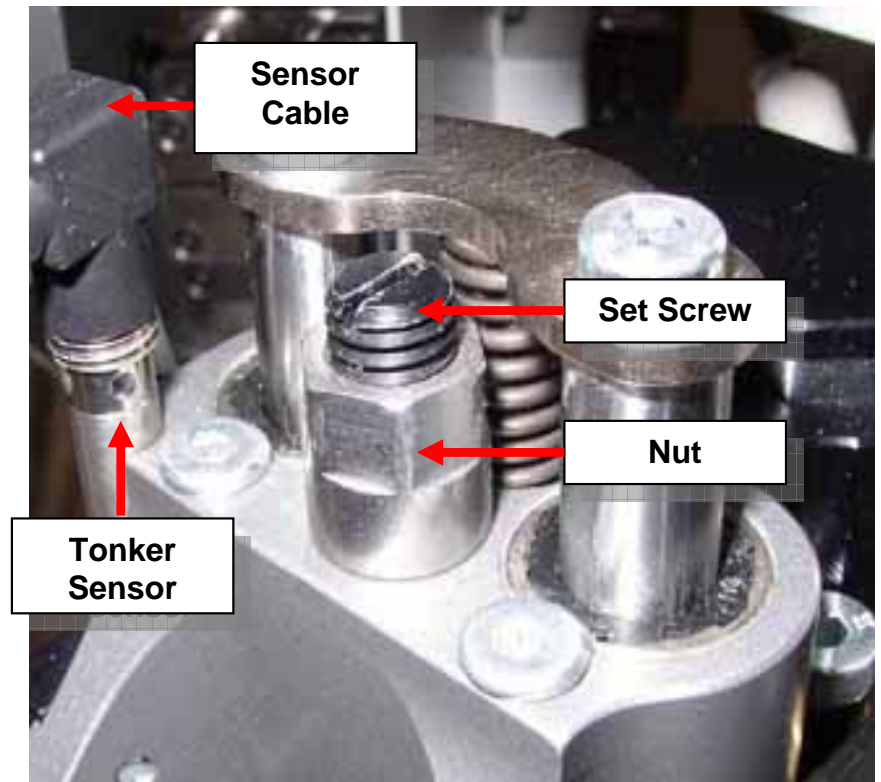


The following adjustment should only be used for calibration.

Calibration

› Adjusting gripper height

- Manually move the gripper head back and forth. If it seems like the gripper head height is off, 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).

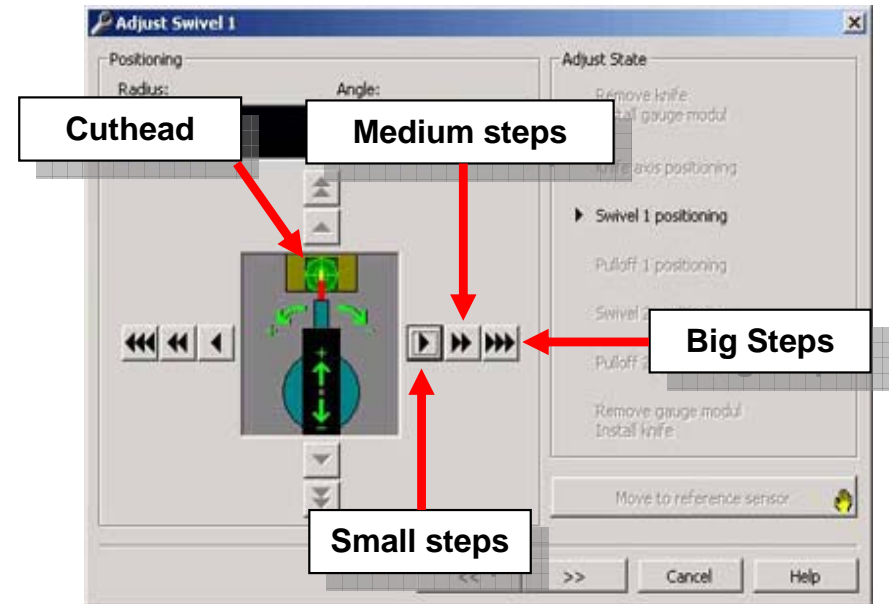


Adjust only for calibration

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› Swivel side one positioning

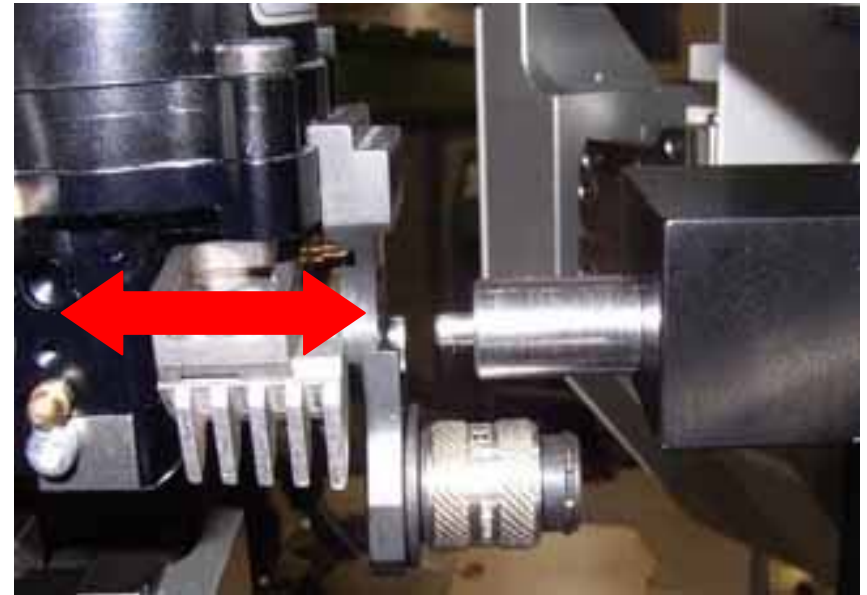
- Move head back by hand (away from calibration block).
- Press and hold the confirm key and then click on the “Move to reference sensor” button, the swivel arm will move.
- Clicking on the arrows that point to the right will move the head towards side one, left arrows moves it away.
- Begin by clicking the arrows on the right.



Calibration

> Swivel side one positioning

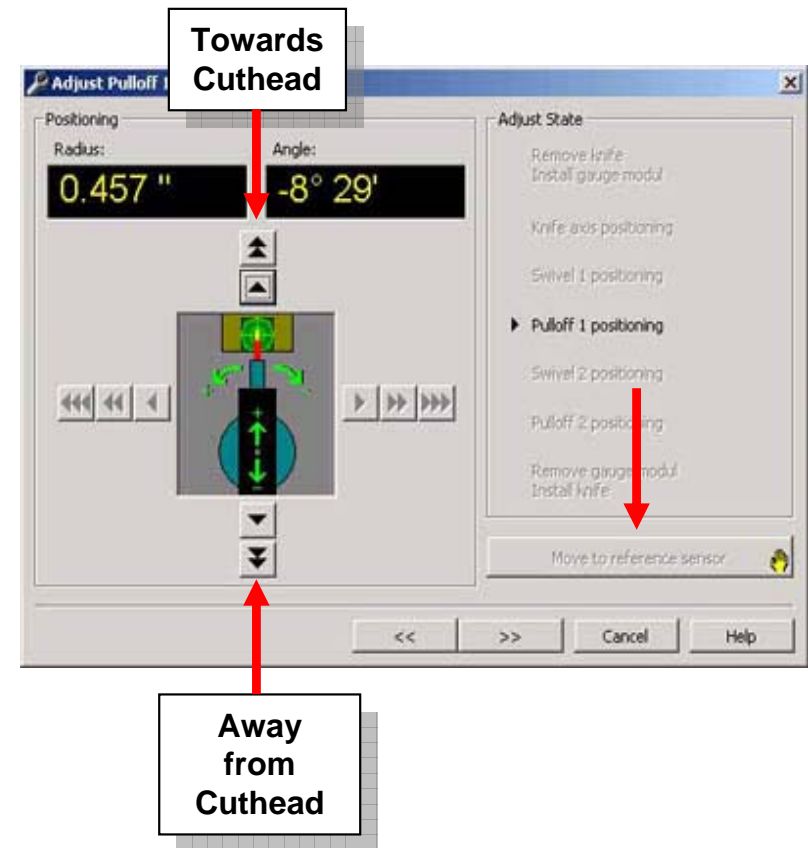
- As the head is adjusted through the computer, move the head manually in and out until the pin goes into the hole smoothly, stop at this point and go to the next screen.



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> Pull off side one positioning

- Press and hold the confirm key and then click on the “Move to reference sensor” button, the arm will lock into place.
- Click the arrows that point upwards, these will move the pull off arm towards the cut head. The arrows that point downwards will move the arm away from the cuthead.

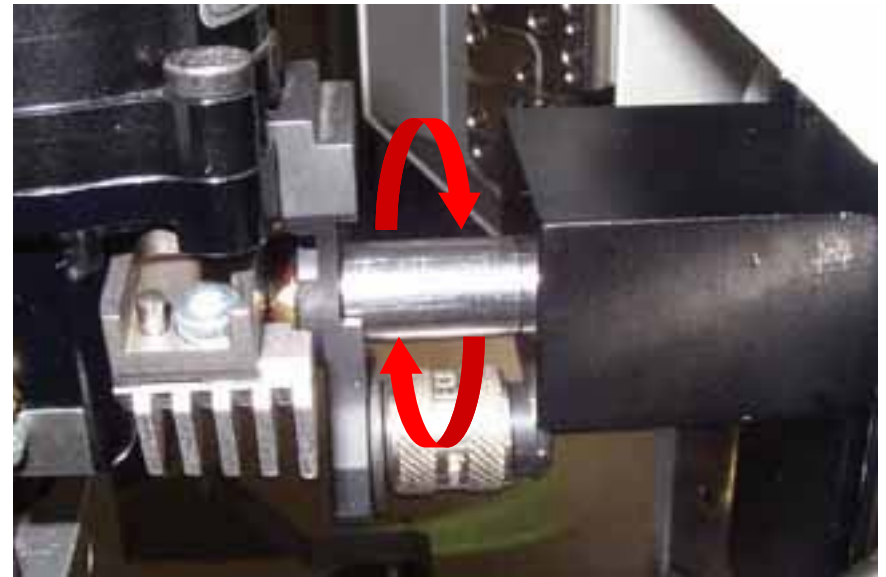


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> Pull off side one positioning

- Bring the head in towards the cuthead until you can no longer twist it by hand.
- Once finished, click next.



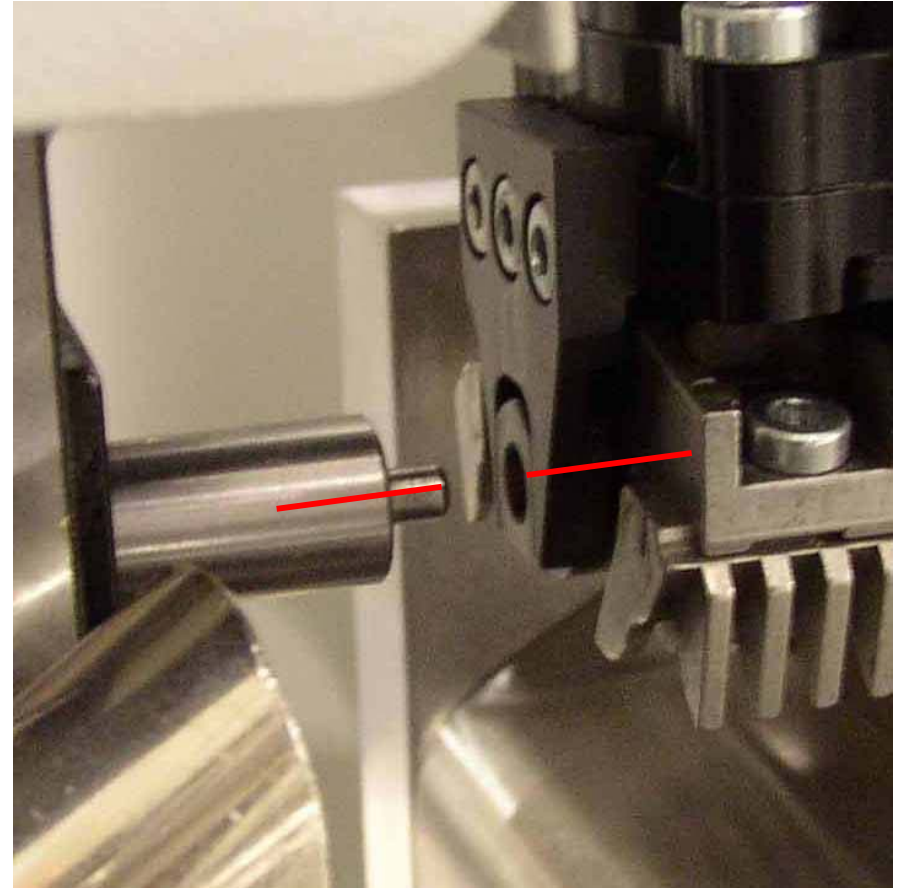
Do not bottom out, this could damage the calibration block and/or linear guides.

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Calibration

> Lining up

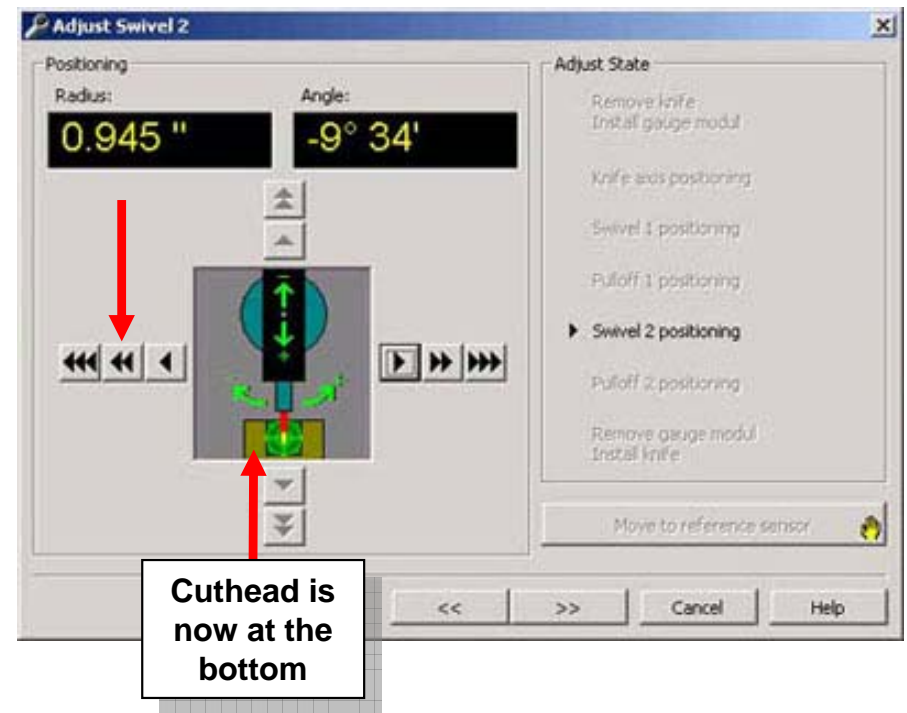
- Insert pin on side two and try to align guide pin nipple into hole on gripper head.
- If height seems to be off, refer to page 9 (adjusting gripper head height) and follow the steps.



Calibration

› Swivel side two positioning

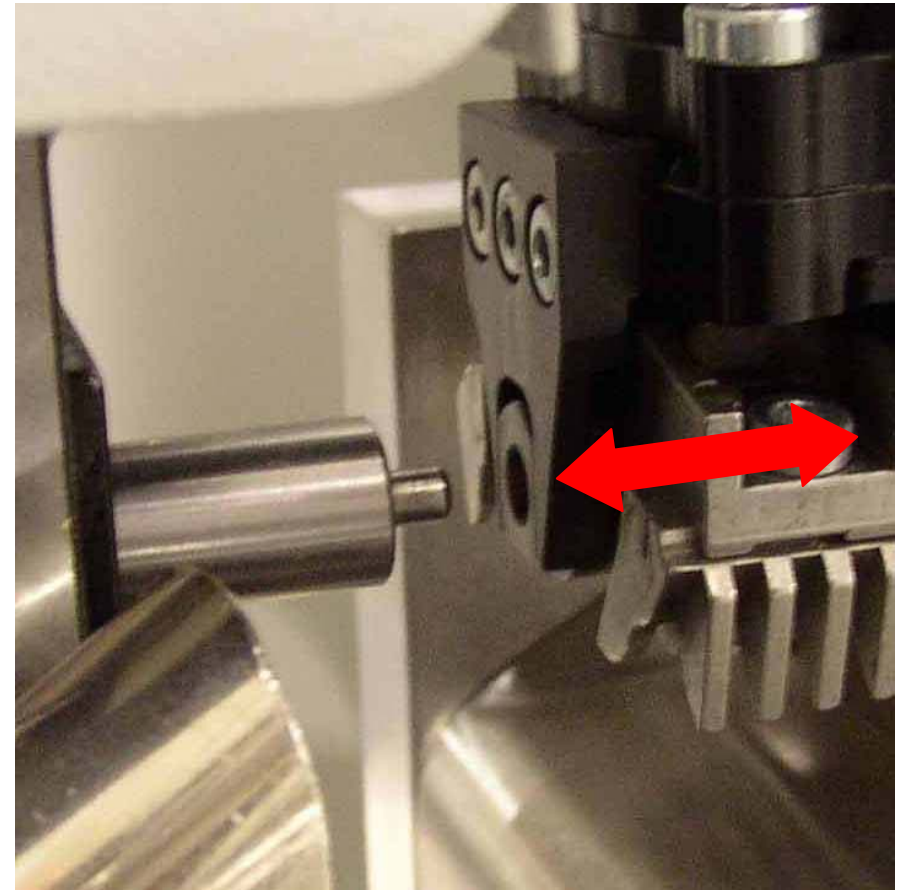
- Swivel two will be adjusted in the same manner as side one.
- If the gripper height adjustment was performed and the pin on side two was left inserted, move the head back (away from cuthead).
- Now press and hold the confirm key and click on “Move to reference sensor”.
- Begin by clicking on the arrows on the left.



Calibration

> Swivel side two positioning

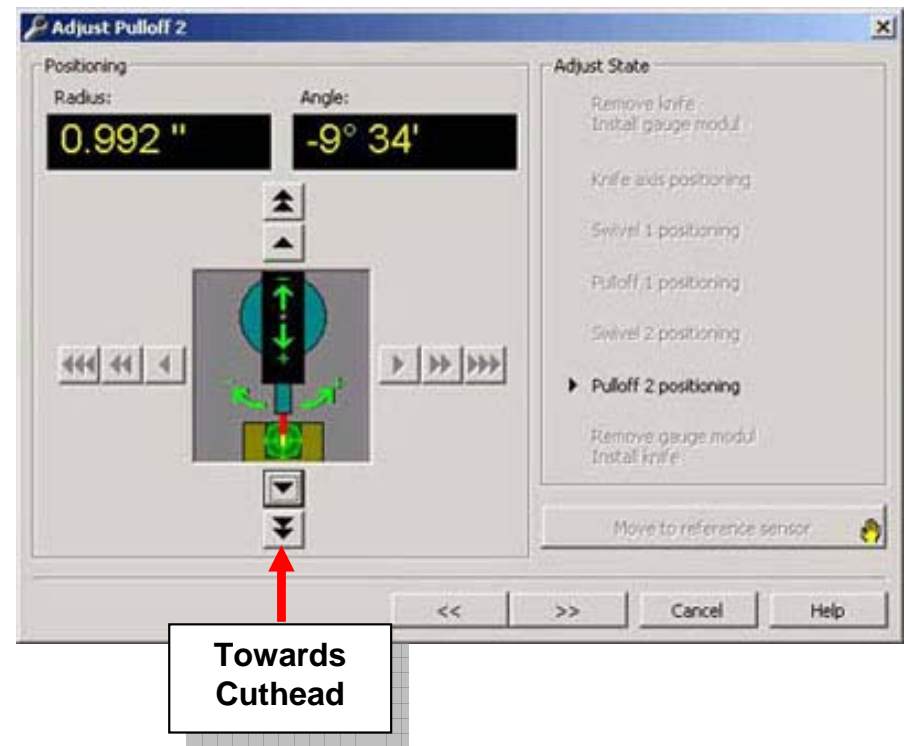
- As the swivel is adjusted, move the head in and out by hand until the nipple goes smoothly into the hole.
- Once done, click next.



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> Pull-off side two positioning

- Push and hold the confirm key and click on “Move to reference sensor” button.
- Bring the head in towards the cut head.

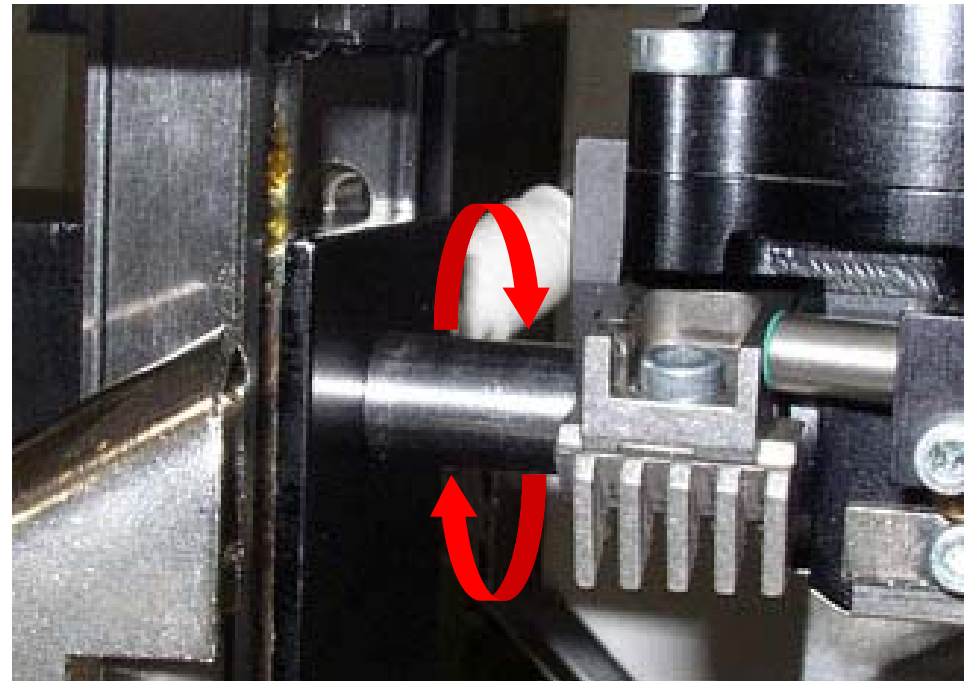


Do not bottom out, this could damage the calibration block and/or linear guides.

Calibration

> Pull-off side two positioning

- Continue to bring the head in and at the same time twist the pin by hand.
- Stop when the pin no longer twists easily.
- When done, click next.

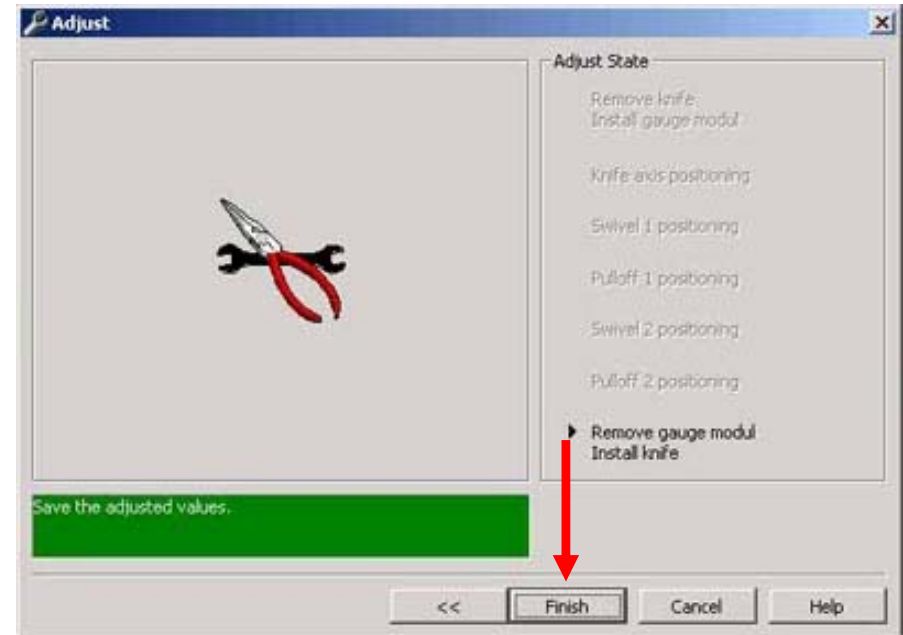


Do not bottom out, this could damage the calibration block and/or linear guides.

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> Pull-off side two positioning

- At this point the calibration block may be removed and blade blocks can be installed.
- Hit “Finish” to save values.



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