

Depth Probe Calibration Procedure

EAC		
SPACER SELECT F1	ROUNDTOP DIS F2	10MM GLASS F4
SPARE SPACER #.### BEAD DIA		
DEPTH PROBE ENABLED F5	CORNERWIPE ENABLED F6	SETUP F8

From the MAIN Screen, Press SETUP (F8) to go to the PASSWORD Screen.

Enter the machine password, which will open the SETUP PARAMETERS 1 Screen.

PASSWORD #####		PRESS F3 OR ENTER PASSWORD FOR PARAMETER SCREENS.	
THICKNESS DETECT DIS F1	TRIPLES DIS F2	PV CNFG F4	
BEAD ADJUST F5	FILL IN DIS F6	STATUS F7	MAIN F8

.200	SUCKBACK TIME		
.250	SUCKBACK SPEED (CUBIC IN / SEC)		
.350	PURGE SPEED (CUBIC IN / SEC)		
SETUP PARAM 1	DEPTH PROBE CALIBRATE F6	NEXT F7	MAIN F8

Press DEPTH PROBE CALIBRATE (F6) to go to the Depth Probe Calibration Screen.

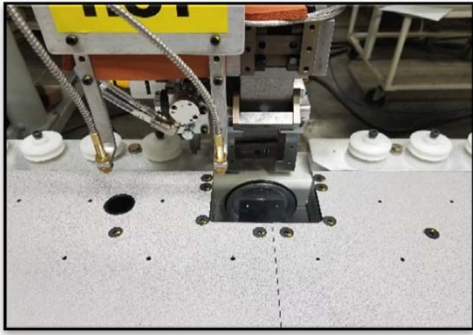
IG DEPTH - The actual distance in INCHES the depth probe is reading.

DEPTH PROBE COUNTS PER INCH - The multiplier used to translate the encoder counts to inches.

DEPTH PROBE HOME OFFSET - This offset is used to zero the IG DEPTH when the depth probe is parallel to the rollers.

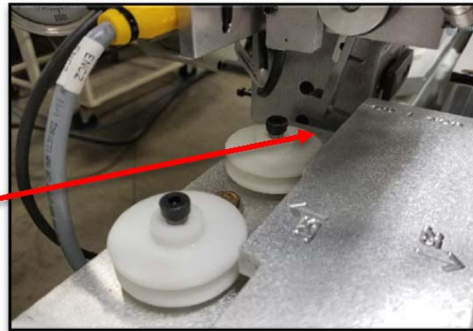
1.135	IG DEPTH
600.0	DEPTH PROBE COUNTS PER INCH
.956	DEPTH PROBE HOME OFFSET
CALIBRATE MODE F5	BACK F8

Press CALIBRATE MODE (F5) to start the Depth Probe Calibrate Mode. The Head will lower.

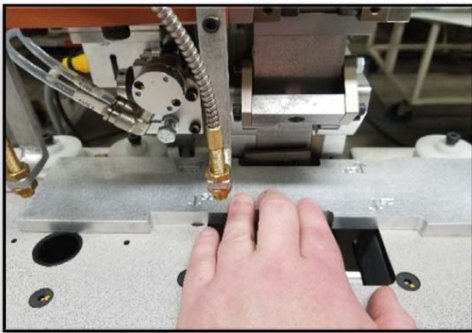


After the head has lowered, the Calibration can begin.

Push the Calibration plate to the rollers, making sure the parallel edges are flat against the rollers. Verify the depth probe is also against the outermost plane.



Adjust the DEPTH PROBE HOME OFFSET until the IG DEPTH is 0.00 ± 0.010



Center the Calibration plate over the nozzle, verifying the depth probe is also in a pocket cutout. The IG DEPTH should match the depth of the cutout on the CALIBRATION plate $\pm .010$. Flip the plate around to test the depth probe at different depths.

If the depth probe is not within tolerance in all pockets, adjust the DEPTH PROBE COUNTS PER INCH. If the small pocket is within tolerance and the large is too high, subtract 5 from the DEPTH PROBE COUNTS PER INCH. Otherwise, add 5 to the DEPTH PROBE COUNTS PER INCH. After changing the DEPTH PROBE COUNTS PER INCH, verify the DEPTH PROBE HOME OFFSET, adjust as needed.

When the calibration is complete, press CALIBRATE MODE (F5) button to return to normal operation.