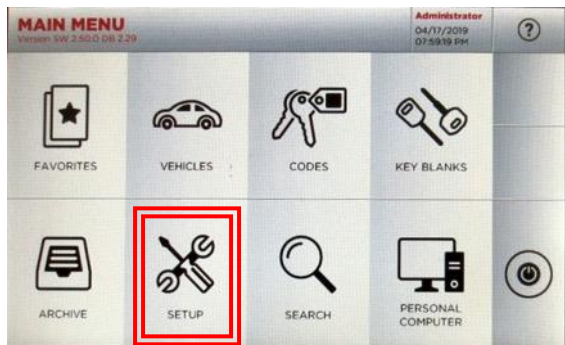# GYMKANA CALIBRATION

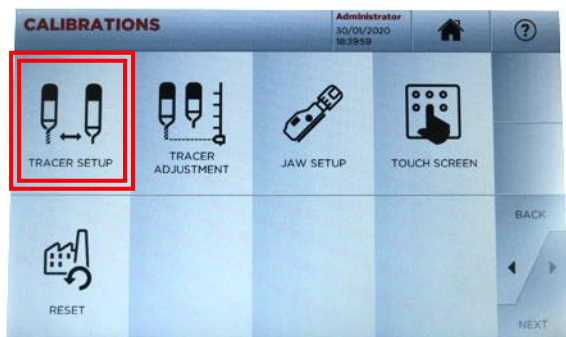**TIP:** Use included stylus with touch screen to ensure accurate selections
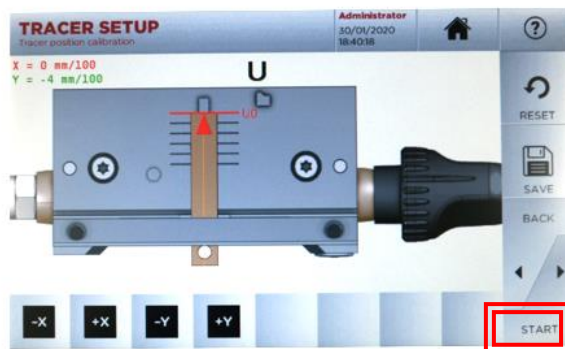
Follow the steps below
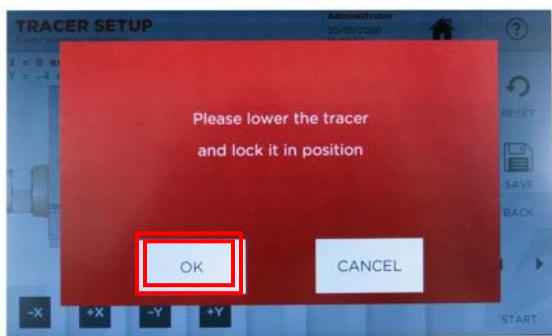

Select **SETUP**.

Select **CALIBRATIONS**.

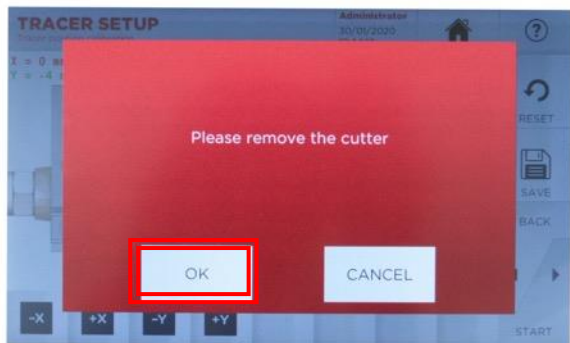**Select TRACER SETUP**.

Insert the calibration template as shown. **PRESS START**.
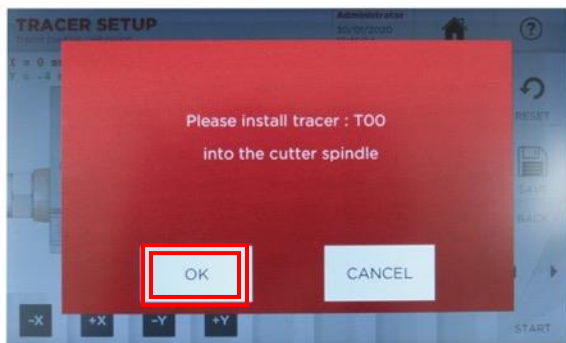

Loosen the tracer knob, lower the **TRACER** and tighten the knob. **PRESS OK**

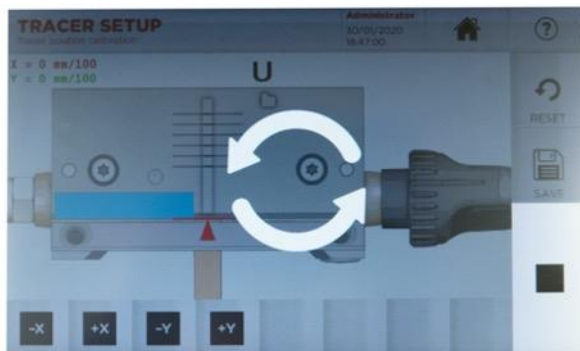# CALIBRATION, cont.

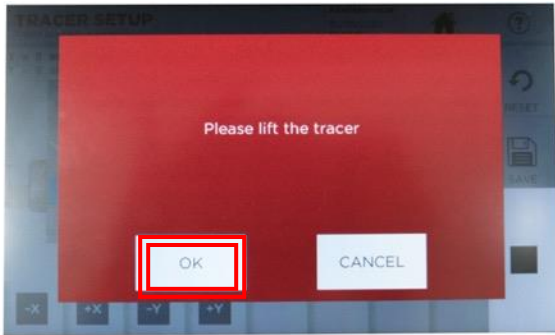**REMOVE** the **V037 CUTTER**. **PRESS OK**

Install the T00 Calibration **TRACER** into the cutter spindle. Tighten the set screw and **CLOSE THE SHIELD**. **PRESS OK**
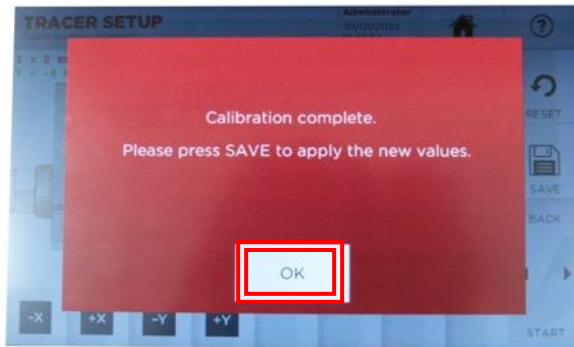

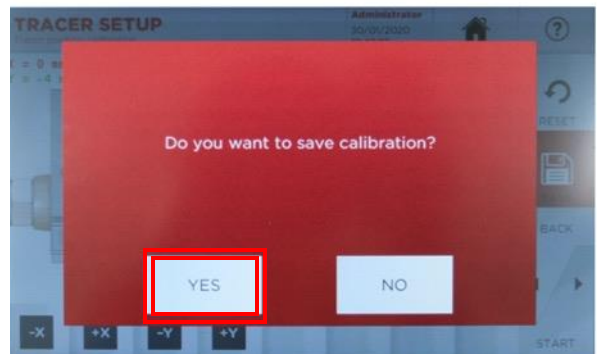The **MACHINE** will **START the setup process**.

CALIBRATION, cont.

When prompted, loosen the tracer knob, **LIFT THE TRACER** and **MOVE IT TO THE RIGHT**. **Close the shield**. **PRESS OK**

PRESS OK.

Write down the X & Y values and **PRESS THE SAVE BUTTON**. **PRESS YES** to save the results. **PRESS THE BACK BUTTON** after checking their values (see next page).

CALIBRATION, cont.

IMPORTANT

Run the Tracer Setup process a second time and compare the X & Y values of this process with the previous set. The values should not change more than +/- 3.
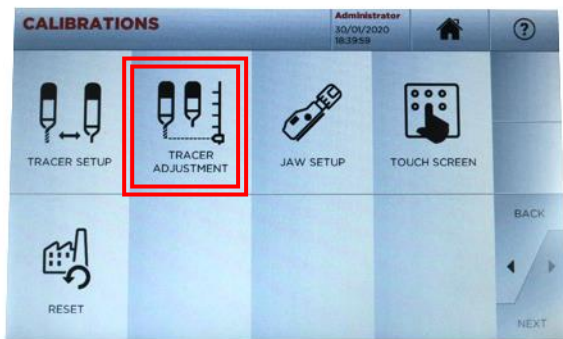
EXAMPLE:
If during the first calibration process X= 0 and Y= -4.
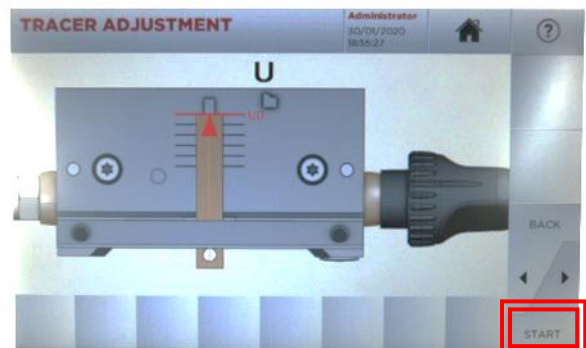In the second calibration process:

        X must be between values -3 and +3
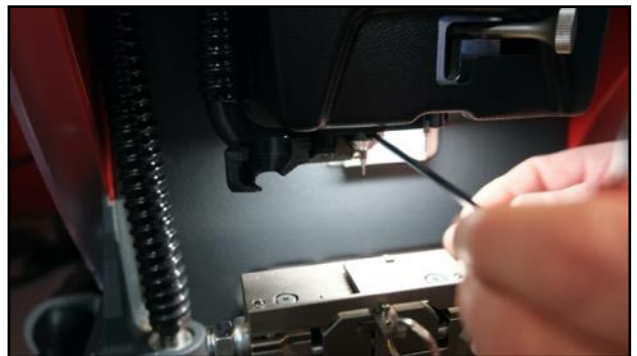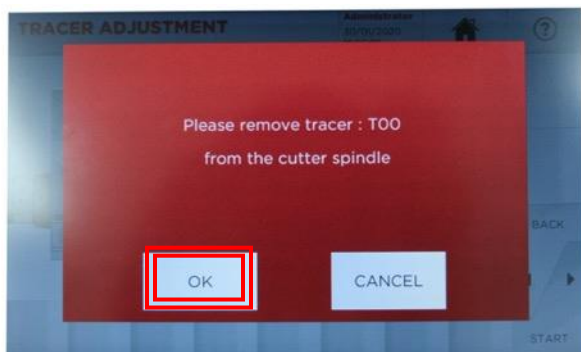   Y must be between values -7 and -1.

If the values are outside the +/- 3 variation run the calibration process a third time and compare the second set of numbers to the third. Press the **BACK** button.

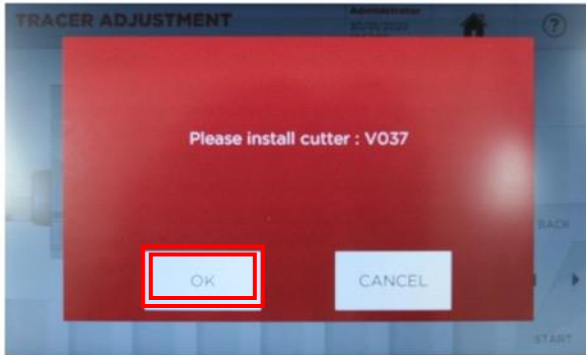

Press **TRACER ADJUSTMENT**.

PRESS START.

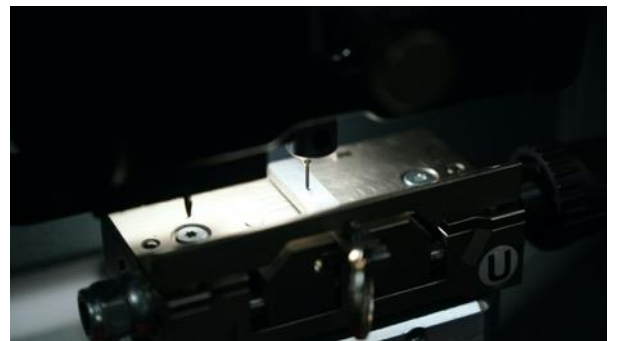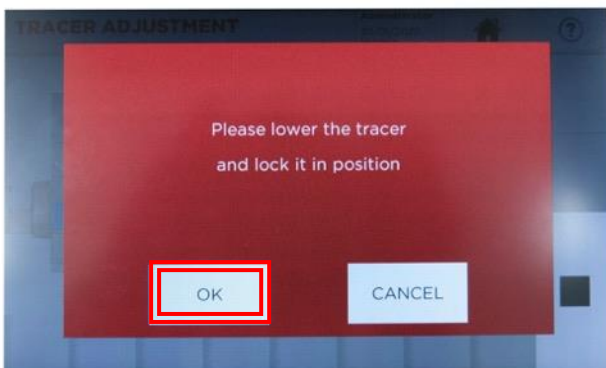**REMOVE CALIBRATION TRACER** T00 from the cutter spindle. **PRESS OK**

CALIBRATION, cont.

Install the **CUTTER V037. PRESS OK**
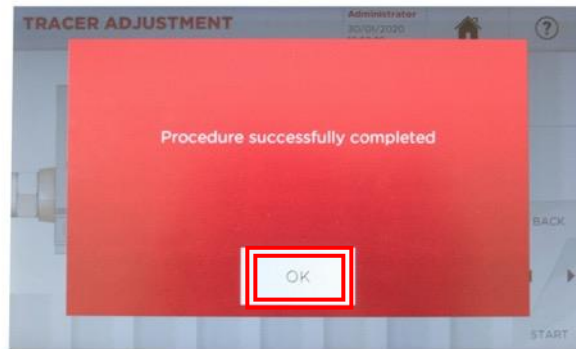

The machine will move the tracer over
the jaw.

Loosen the tracer knob, lower the **TRACER**, **tighten** the **KNOB**. PRESS OK
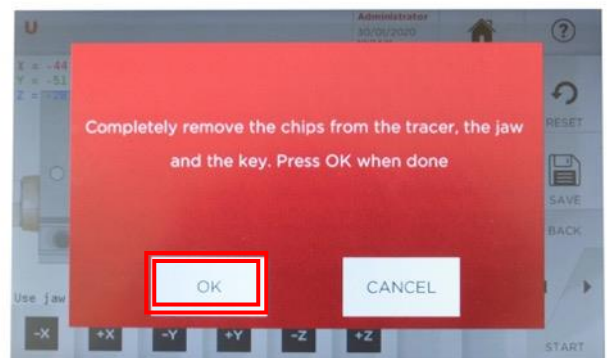
CALIBRATION, cont.

PRESS OK and then **PRESS BACK**.
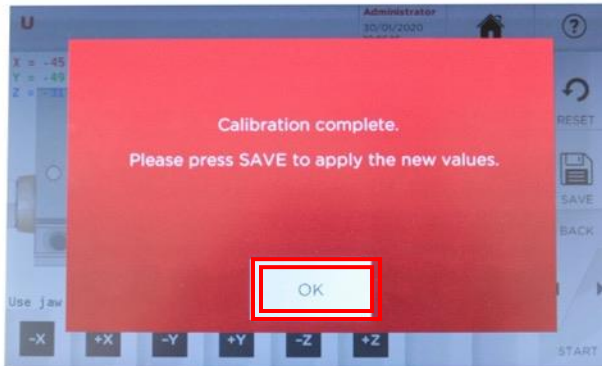

Press **JAW SETUP and SELECT U JAW**

Make note of the values of **X,Y,Z**.
PRESS START.

Completely remove the **CHIPS** from the
TRACER, the **JAW** and the **KEY**.
PRESS OK.

CALIBRATION, cont.

PRESS OK.

PRESS SAVE.

IMPORTANT

Run the calibration a second time and compare the X, Y & Z values with the first set of numbers and make sure that they do not change more than +/- 3.

EXAMPLE:
If the first calibration values are X= -44, Y= -51 and Z= -28
In the second calibration values can be:
        X must be between -47 and -41
        Y must be between -54 and -48
        Z must be between -31 and -25

If the values are outside the +/- 3 variation run the calibration process a third time and compare the second set of numbers to the third.