

Accuracy Diagnosis - Software Settings

Software Settings that operators may have affect accuracy. How to reset to factory settings

Contents

Comments

Software Setting	Description	Common Symptoms	Link to Page	Affected Machines
Fudged V and Y notch depths	Operator has changed software settings for V / Y notch depths without finding the root cause	V and Y notch depths inaccurate		All except Saw
Kerf	Blade kerf incorrectly entered	Saw cuts correct for mitre cuts but not square cuts, or vice versa		All except ecoline
Laser hole swarf	The laser hole is leaving swarf in the profile and creating a laser reading problem when the profile is pushed into the saw	Laser loading Errors Random operation positions		Flowlines, ZX3 / 4 with laser fitted
Drive tuning - following error	X Axis or Saw pusher axis is not tuned correctly Following error when reading laser position gives positional error	Random operation positions, particularly on heavier profiles		All
Rack Calibration / Scaling	Calibration has been altered incorrectly	Random operation positions		All
Grip positions for profiles	Gripper position for a profile is causing it to tip Gripper position is not firm enough causing gripper slip			All except saw
V notch blade vertical angle	Tool angle of V notch blade is not accurately locating it in a vertical plane	v notches too deep or incorrect position		V Notching on ring
Datum holes aligned with V notches	V notch offsets incorrect to datum position	V notches incorrect but routing positions correct, or vice-versa		All except saw
Axis speeds (Pusher deceleration)	Pusher is not connected with end of profile after deceleration - ie pusher stopped but profile carried on	Random operation positions		Saw Flowline ZX3 / 4
Trimstart	Trimstart is incorrectly set up or switched off, and the profile end is not square - ie the machine centre gripper has a different datum position to the saw pusher	Random operation positions on particular profiles		Flowlines, ZX3 / 4 without laser fitted