

# Mk10 Gripper Setup

Correct Setup of Mk10 Gripper on Flowlines & ZX

## Contents

Potential Problems

Symptom

Root cause

Comments

## Potential Problems

Problem identified at Ultimate 70 and Vale after Mk9 / 10 Universal gripper upgrade fitted. When trimstart is used, there is a potential for the profile to bottom out on the grip jaw holder rather than the gripper nose itself. (see photo)

### Symptom

Pos test will be different when using an offcut (plain end, no trimstart applied) and a full bar length. Accuracy will be affected as the whole trimstart function is negated.

### Root cause



Gripper nose end stop position is not correctly adjusted. The datum point (before and after trimcut) should **always** be the gripper nose, **NOT** the gripper jaw holder. Also check that the trim amount is not too big, this is controlled by the loadpos parameter- it should be 0 to -3.5, never bigger than 0.