ZX5 Adjusting V Notch Depth and Position

How to change the depth and position of the V notch on a ZX5 machine

Difficulty Very easy

Ouration 2 minute(s)

Contents

Introduction

Step 1 - Check the shape of the V notch

Step 2 - Adjust the V Notch Depth

Step 3 - Check V notch position compared to Datum hole

Step 4 - Adjust the Position

Comments

Introduction

The ZX5 has a twin blade system for the V notches that is designed to be easier to set up.

The overall process is:

- 1. Set the shape of the V notch (Mechanical adjustment)
- 2. Set the Depth of the V notch (Software adjustment in Notching Tab)
- 3. Set the Position of the V notch (Software adjustment in Notching Tab)

Step 1 - Check the shape of the V notch

If the blades do not meet properly, or form a "W" shape, the mechanical setup is not correct. Please follow procedure: https://stuga.dokit.app/wiki/ZX5_V_Notch_Blade_Mechanical_Setu p



Step 2 - Adjust the V Notch Depth

...Remember that the width of the V notch is HALF the depth

Open the 'Settings' screen and the 'Notching' tab

- 1. For the front V Notches, the depth is adjusted by changing the dOffsetVI variable
- 2. For the rear V Notches, the depth is adjusted by changing the dOffsetWI variable
- + will make the V notch deeper, will make it shallower



Step 3 - Check V notch position compared to Datum hole

Run a manual test with a shallow V notch and datum hole in the same x axis position The goal is to adjust the 'xOffset' variable to get the datum hole and V notch to line up

-> Error	

Pass	
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Step 4 - Adjust the Position

Open the 'Settings' screen and the 'Notching' tab

- 1. For the front V Notches, the position is adjusted by changing the xOffsetVI variable
- 2. For the rear V Notches, the position is adjusted by changing the xOffsetWI variable

The direction of change will depend on the handing or feed direction of the machine:-

Feed Direction+ Value- ValueRight to LeftV Notch moves leftV Notch moves rightLeft To Right (OH)V Notch moves rightNotch moves left

Fin	e Tune Notchin; feed Side Front	,			Outleed Side Front			V	Notching Fine Tune	
	Depth (dOffset VI)	-5	.1	•	Depth (dOffsetVO)	-5	.1:		Notch Seperation (VSEPERATION)	0.0:
1	Posities V	558	.8	•	Position (xOffsetV0)	558	.8:		Compensation (VCOMPENSATION)	0.0.
	Rear				Rear			1 1	Rear	
	Depth (dOffset WI)	4	.4	•	Depth (dOffsetWO)	4	.4:		Notch Seperation (WSEPERATION)	138.0:
2	Positio	558	.0	•	Position (xOffsetWO)	558	.0.		Compensation (WCOMPENSATION)	0.0: