

Calibration Tool

1 – Machine.

1.1	Take the calibration tool with the small mark pointing up.
1.2	Place it in the center of the machine. Get the claws to grip it.
1.3	Remove sensor cover.



2 - Screen settings.

	X & A	At the Main Screen.
2.1	WHEELREST (***)RE Start Deburring Mode Run Last Scanned Rim Start a 'New Rim' Start a 'Saved Rim'	Select
2.2	Serve Axis's WHEELREST(@)RE Auto Speed 22 mm/s Auto Speed 23 mm/s Auto Speed 23 mm/s Probe AcC 28 mm/s Probe ACC 28 mm/s Manual Speed 13 mm/s Manual AcC 198 198 Manual AcC 198 198 Manual DEC 128 120 Manual AcC 198 198 Manual AcC 198 RPM/s St S Some man RPM <	At the system Setup screen. Select "Tool Change"
2.3	Set Selector to "Soystick"	Set selector to "Joystick"
2.4	Abort	Press the foot pedal and move laser to the Center position* on the calibration tool using the joystick. The power light on top of the laser must be green and the laser Measure must be between 50 and 60 mm. *Note that this must be done very precisely. Select for slow movement. Select for fast movement. Press "Confirm position" once the position has been reached.

WHEEL**REST®RE**

2.5	Move Tool Tip To Center Position Move Tool Tip To Center Position	Press the foot pedal and move the Tool Tip to the Center position* on the Calibration Tool using the joystick. *Note that this must be done very precisely. Select for slow movement. Select for fast movement. Press "Confirm position" once the position has been reached.
2.6	Confirm Position Back Abort	Select "Confirm Position" if the values are set correctly. It's possible to change the values by clicking "Change Values", enter the values according to the parameters required and select "Confirm Position"
2.7	Service Bit Auto Speed 100 Service 100 Auto Speed 100 Auto Speed 100 Probe Acc 100 Manual Speed 100 Manual Acc 1	Select "Exit Setup"
2.8	VHEELREST ()RE Tap screen to start	Tap screen to start.



2.9	Set Selector to 'Wormal"	Set selector to "Normal"
	100	
2.10	Coing To 'Load Position'	Going to "Load Position"
2.11	Start a 'New Rim'	The machine is now ready for operations.