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OTS / RTS Tool Setter



This presentation will give you step by step instructions on how to setup and (re)calibrate your Tool Setter.

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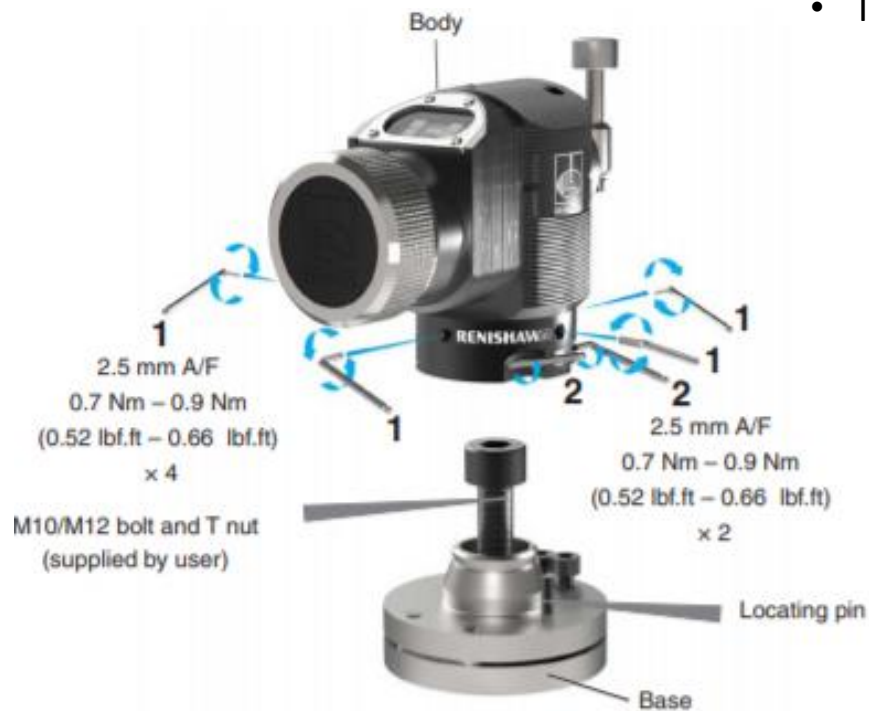


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Moving / Setup:



- If you move your tool-setter to a new location on your table, you must:
 - Ensure the LED panel on back is angled toward your OMI receiver
 - Indicate stylus and re-calibrate
 - *be sure to keep the same orientation when moving the system



Changing Stylus:



- If you need to replace a stylus, loosen the screw holding the stylus in place and replace.
- If your styli was broken you may also need to replace the break stem
- When you replace a stylus you **MUST** indicate so it is parallel in X and Y to the table (next page) then recalibrate

Indicating Stylus:

- When indicating, always adjust when the indicator is on one side.
- Adjust as close to zero as possible
- After adjusting left and right, now do front and back tilt. (next page)



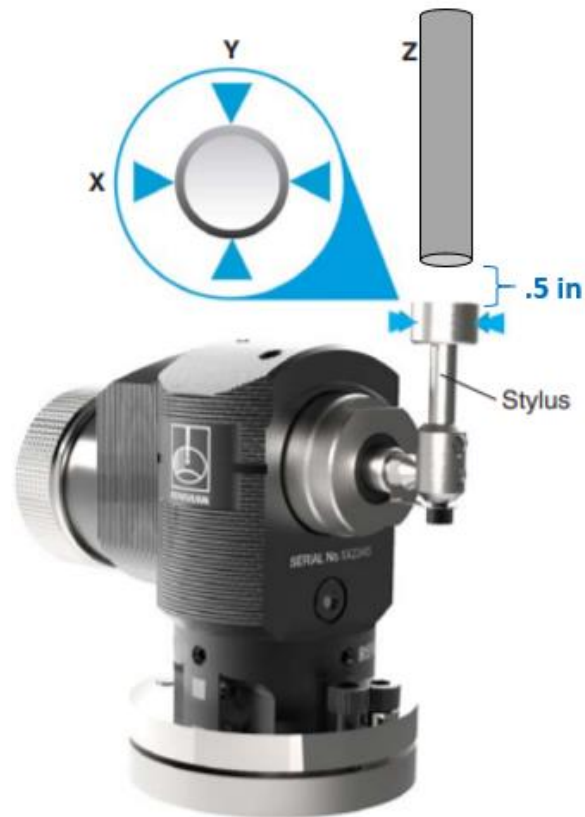
Indicating Stylus:



- Repeat steps until an acceptable number is met
 - Under .0005 in preferably
- Be sure all adjustment screws are tight
 - Don't overtighten
- After you indicate X and Y you MUST Recalibrate your tool setting system



Calibration:



- What you need:
 - Tool with known length and diameter
 - Known Length in Offset, from Specified T# in O8026
 - Reference Diameter in R#
- Drive your calibration tool about half an inch, centered, above the Stylus
- Run O8026

O8026 (OTS CALIBRATION)
(POSITION TOOL ABOVE AND CENTER OF OTS DISK)
(T1= H OFFSET- MUST CONTAIN LENGTH OF TOOL)
(R= REFERENCE DIA OF CAL TOOL)
(D= DIA OF OTS DISK)
G65P9855T1R.4996D.5
M30

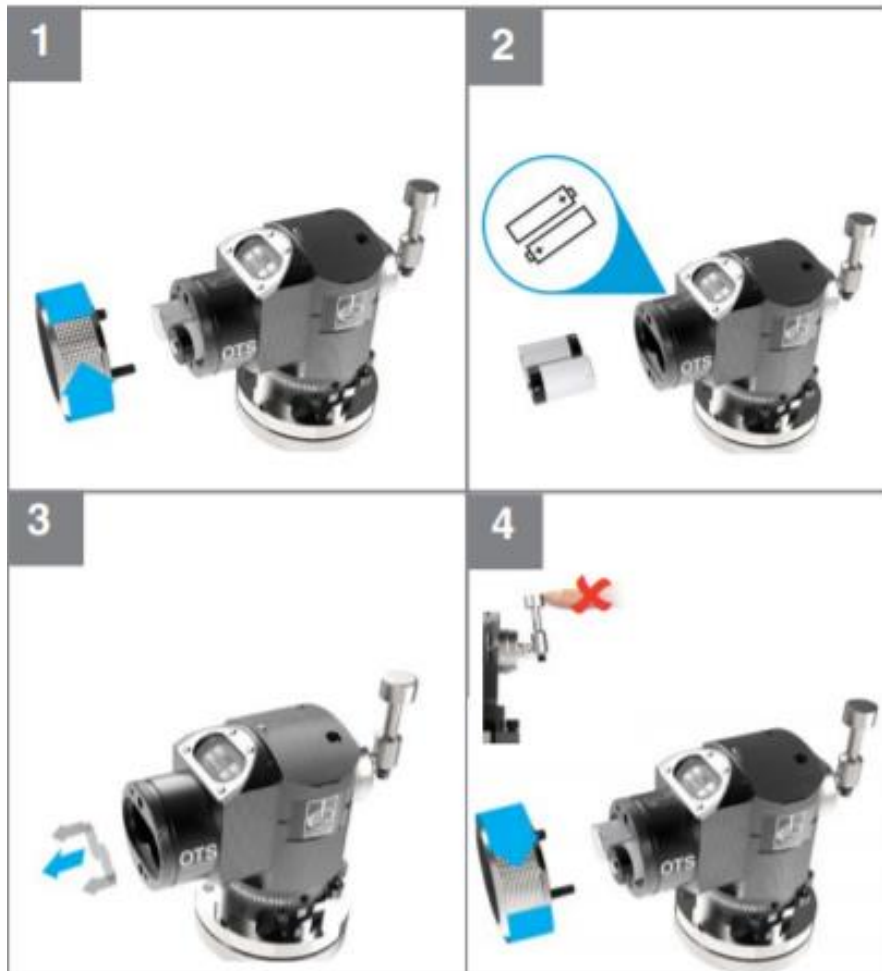


Basic Maintenance:



- The most basic maintenance you can do is:
 - Keep the LED lens clean
 - Recalibrate
 - Replace Batteries

Batteries:



- To replace batteries simply un-screw the back cover and put new batteries in
- Do not deflect the stylus while it goes through the new battery LED cycle
- No Recalibration needed

Basic Troubleshooting:



- If your tool setter will not turn on, or flashes blue/green LEDs when on
 - Replace batteries
- If your tool setter blinks Ren LEDs with nothing deflecting stylus contact PQI
 - Office: 763-249-7149
 - Toll Free: 800-772-0620

