a.

a.

## **Step 1: Set the parameters for the setworks, if applicable.**

1. From the Main screen press the "Left Arrow" button to go to the Configuration screen.



2. On the Configuration screen, press and hold the "Left Arrow" button until the Parameter 1 screen displays.



3. Imperial Mechanics will be selected so press the "F4" key to select Metric. You will stay in Metric mode and the software will convert to Imperial for the value displayed. Press "Right Arrow" button to go to the Parameter 2 screen.



Document Rev. A Created By: TM 4. The Counts per 0.01mm. should already be set to 0.25, if not use keys "F2, F3, F4" to change it. Now press the "Right Arrow" button to go to the Parameter 3 screen.



a.
5. Use buttons "F1, F2, F3" to set the Travel Upper Limit to "450mm. After setting press the "ESC" key.

			PARAM	LIEK J					
	Back 123mm								
		100	10	1					
a.	ESC	F1	F2	F3	F4	ENT			

PAGE 1

## Step 2: Calibrate Setworks, if applicable.

- 1. Turn on control power.
  - a. From the Main screen press the "Left Arrow" button to go to the Configuration screen.
    - $\begin{array}{c} \text{HEAD POSITION: } 12.345 \text{in.} \\ \text{Set Positions} \\ \text{---} \\ 12.34 \text{in.} \\ 12.34 \text{in.$

SETWORKS MAIN

- 2. Press the "F4" button to go to the Calibration screen.
  - CONFIGURATION Hardware Config Units OFF OFF Imperial Fraction ESC F1 F2 F3 F4 ENT
- Measure the distance between blades.
  - a. Measure the distance between the teeth on each blade that are set in toward the center of the machine. If using a tape measure, you may need to adjust the blade position to be at the nearest 1/8".
     Blades must be less than 10" apart.
  - b. Use the "Function (F)" buttons to set the measured head position. Now press the "Right Arrow" button to save the calibrated position. Your Setworks system will now base all measurements to this calibrated position.



c. Document Rev. A Created By: TM

## Step 3: Test the Setworks, if applicable.

1. Set Preset 1 and Preset 2.

b.

a. From the Main screen press the "Right Arrow" button to go to Page 2 of the Presets.

	SETWORKS MAIN							
	HEAD POSITION: 12.345in.							
Config	Set Posil 1 12.34in.	tions <b>2</b> 12.34in.	<b>3</b> 12.34in.	<b>4</b> 12.34in.	Page 2			
i. Bross the "Bight A	F1	F2	F3	F4	ENT			
riess the Right A	now built	SETWOR	KS MAIN	stup screer	PAGE 2			
	HEAD	POSITION	12.34	5in.				
Page 1	Set Posit 5 12.34in.	tions 6 12.34in.	<b>7</b> 12.34in.	<b>8</b> 12.34in.	Setup			
ESC	F1	F2	F3	F4	ENT			

c. Press the "F1" button to go into the Set screen for Position 1.





- 2. "F3" and "F4" set 1/32 inch at a time.
- ii. After setting desired value press the "ENT" button to save. This will take you back to the set screen.
- iii. Repeat the procedure for Position 2, then press the "ESC" button to return to the Setworks Main screen.

i.

- Rev. C
- e. The values you entered should now be present below the Set Positions. Press function buttons "F1" or "F2" to make the head position to Position 1 or Position 2.



f. Measure the distance between the blades inward set teeth to confirm.