Enhanced Calibration Process

Making Micro Adjustments

If you notice that the JWX-30 is not quite dimensionally accurate, you can make fine adjustments to dial in its accuracy. This process will help make the small adjustments necessary to ensure that your machine is producing great models.

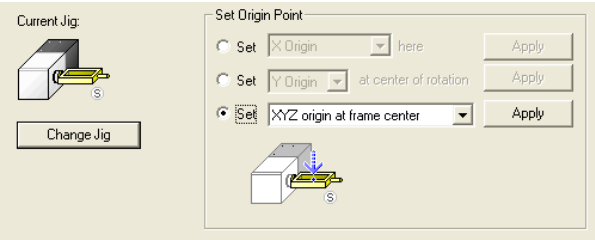
The process will involve the following steps.

1. Calibrate small clamp using standard procedure.
2. Run “Test Block” program using either 0.125” square end mill or 1.0mm ball end mill.
3. Measure X, Y, Z dimensions of test block.
4. Enter values into “Correction” spreadsheet.
5. Modify “Distance Correction” values in JWX-30 VPanel.
6. Recalibrate small clamp using standard procedures.
7. Run “Test Block” program again to double check if desired.

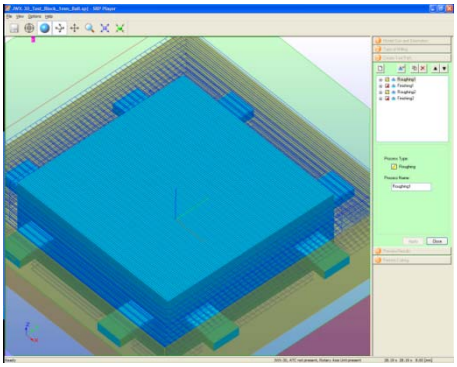
Please note that these small adjustments only need to be done once and not every time a clamp is installed. If you need to make adjustments using the JWX-30 VPanel, you will need to update the firmware before making any adjustments are made.

Adjustment Process

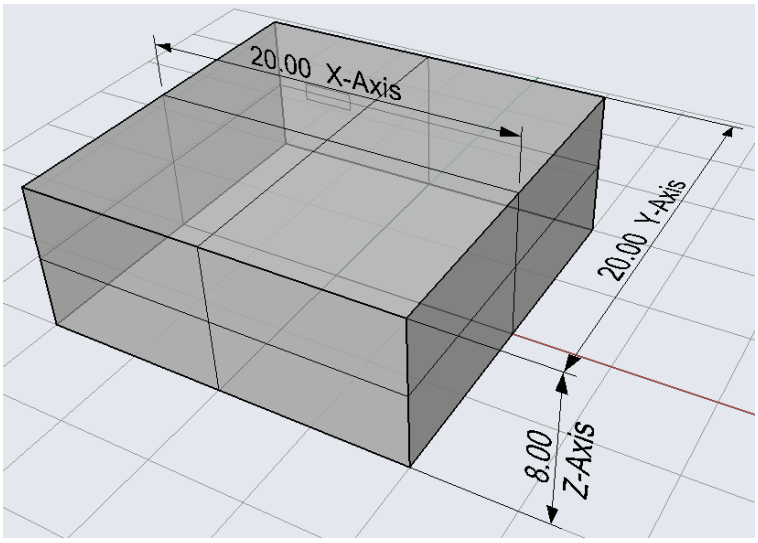
1. Calibrate small clamp using standard procedure. This will be the same process described in Chapter 4 of the JWX-30 User’s Manual.



2. Run “Test Block” SRP Player program using either 0.125” square end mill or 1.0mm ball end mill. Confirm that you have the correct size of material and tool selected before running program.



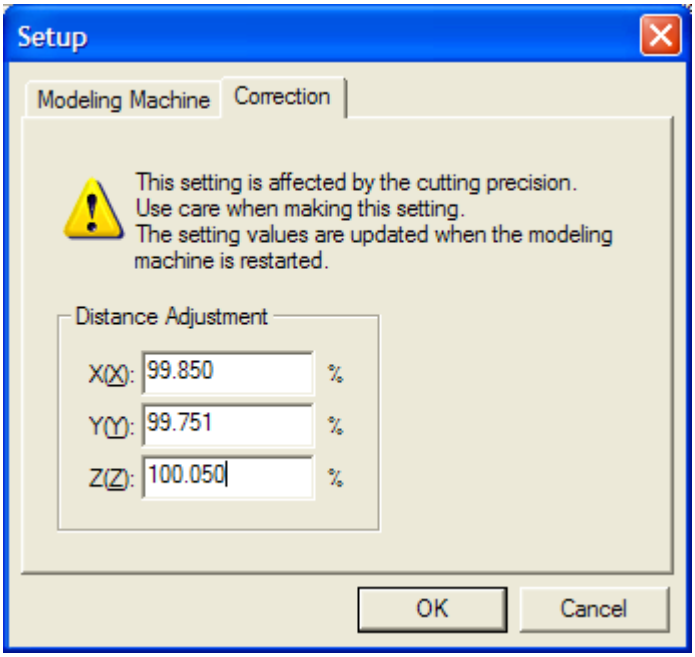
3. Remove the test block from the machine. Measure the test block on the sides (X-Axis), fore and aft (Y-Axis) and its thickness (Z-Axis).



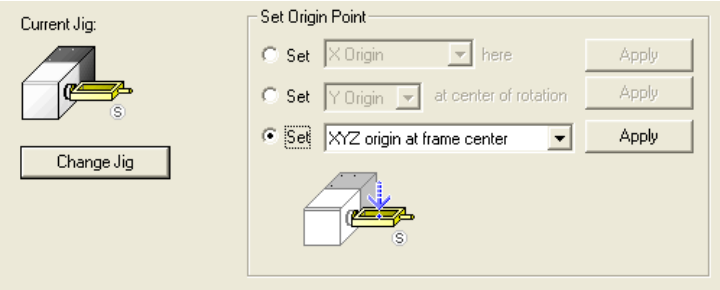
4. Enter the measured values into "Correction" spreadsheet under the "Measured" column. The spreadsheet will automatically update and give you the appropriate "Distance Adjustment" value.

Axis	Target	Measured	Distance Adjustment	
X	20.00	20.03	99.850	%
Y	20.00	20.05	99.751	%
Z	8.00	8.05	100.050	%

5. Enter the given "Distance Adjustment" values in the JWX-30 VPanel. With the VPanel open, click on "Setup" then click on the "Correction" tab. Enter the values here. Click ok when finished.



6. Recalibrate small clamp using standard procedures.



7. Run “Test Block” program again to double check if desired.