**Support: Dial Alignment Procedure**  
  
Occasionally, the Dial will get out of position and the nests will no longer line up with each station. When this happens, you will have to realign the Dial to the stations.

## **Before Aligning :warning:**

* If the Offload Lifts seem to be hitting the nests at the Offload Station, take out the joints and use the manual function to raise the lift up again. If it does not hit the nest this time, it could be that the joints are getting wedged into the nests and the Offload Lifts are popping the joints out. If this is the case, you do not need to align the Dial but should instead not tamp as hard or clean your nests.

Here is how to align the dial...

## **Check the Dial alignment :microscope:**

1. Initialize the machine.
2. Go to the Dial manual function page and hit "Enable Servos" and "Initialize".
3. Make sure that the Dial goes to an increment position such as 0, 40, 80, 120, 160, 200, 240, 320, or 360.
4. Observe the Dial alignment with the Offload Lifts.
5. If the dial alignment is far off such that the Offload Lifts would hit the nests if raised:
   1. Go to the Dial manual function page and press the Auto-Home button.
6. Go to the Offload manual function page and raise the Offload Lifts.
7. Open the doors and look down through the nest above the Offload Lifts to check the alignment with the nests
8. Make note of which direction the dial needs to rotate to center the lifts in the nest.

## **Move the Dial :man-running:**

1. Initialize the machine.
2. Go the the Dial manual function page and hit "Enable Servos" and "Initialize".
3. Find the "Increment Dial" function on the screen and follow the directions.
4. For the "Position Adjustment", use 0.1 for larger movements and 0.05 for fine tuning.
5. Continue to raise the offload lifts to check the dial alignment compared to the Offload Lifts.
6. When the Dial is lined up properly, hit the "Set Home" Button

# **🗺️ Links to Help**

<https://acceleranthq.slack.com/files/U0239EH4KK9/F078SCAEC77/accelerant_pro4_pre-roll_machine_manual_6-13-23__1_.pdf>