

Configuração da Servo Gun

1. Calibração da Gun

MENU

Utilities

TYPE

Gun Setup

Pressionar F4 (Restart)

YES (Enter)

Ok

O item 1 e 2 deverão estar “INCOMP” e o cursor não se movimentar;

Busy	Run	Hold	Fault	TPIF-138 TP: 130.130.130.66 diagnostic 1		5%
Run	Gun	Weld	I/O	2		
UTILS Gun setup						
EQ:1 Gun:1				1/1		
1.Set gun motion sign:				INCOMP		
2.Set Gun specs, master gun				INCOMP		
Tip Displacement:				10.52 (mm/rev)		
Open stroke limit:				-120.0 (mm)		
Close stroke limit:				20.0 (mm)		
3.Auto Tune:				INCOMP		
4.Thickness Check calibration:				INCOMP		
Press enter to perform this step.						
[TYPE] EQUIP SKIP RESTART						

No item 1, “Set gun motion sign”: pressionar ENTER.

(nessa tela define-se o sentido da GUN)

Busy	Run	Hold	Fault	TPIF-138 TP: 130.130.130.66 diagnostic 1		5%
Run	Gun	Weld	I/O	2		
Set Motion Sign						
EQ:1 Gun:1				1/1		
1.HOLD the SHIFT key and SLOWLY Jog the Servo Gun movable tip using the +X key (+Y if 2nd gun of dual gun).						
2.Did the gun OPEN or CLOSE?				*****		
USE F4 or F5 to make selection.						
3.Press F3 COMP when finished.						
[TYPE] COMP OPEN CLOSE						

Ao concluir o “Auto Tune”, executar a rotina “TW_SETG1”.