



MRT-1100S SWAK-OS 4.0 & 3.0 Set Wave Height Probe Z Axis

Tool List:

No tools required.

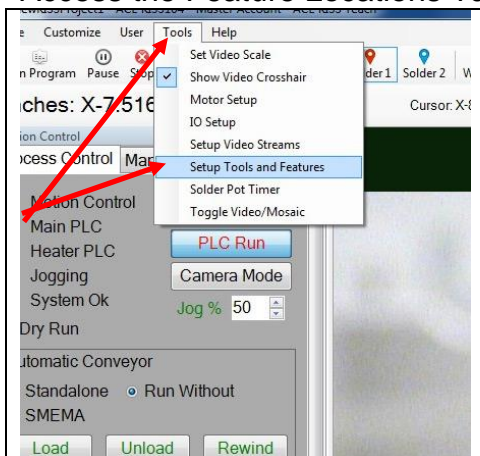
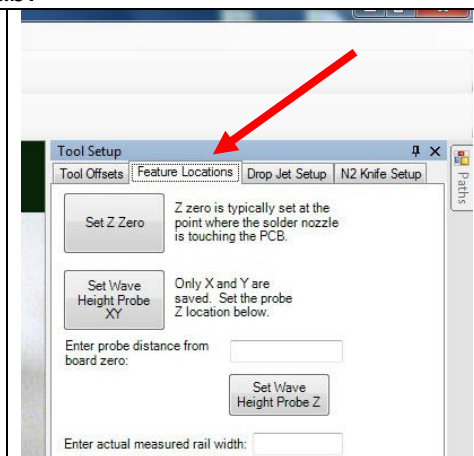
Note: Always be sure the table is cleared before performing Step 1.

Step 1:

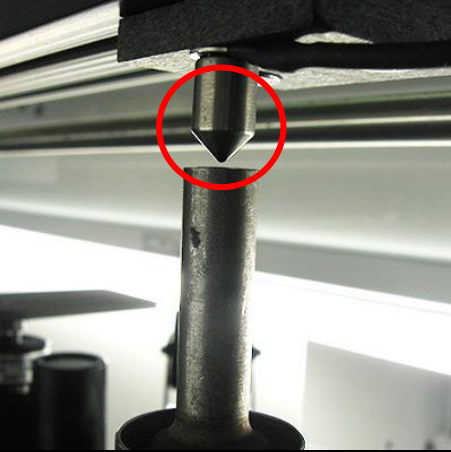
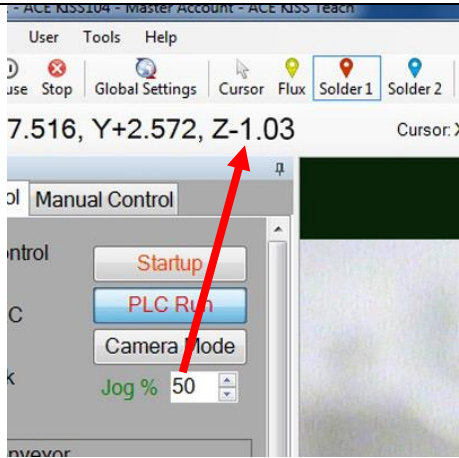
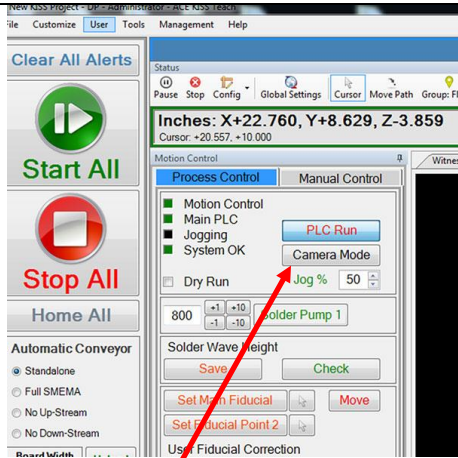
Home the machine by pressing the Start Up/Start All button.

Step 2:

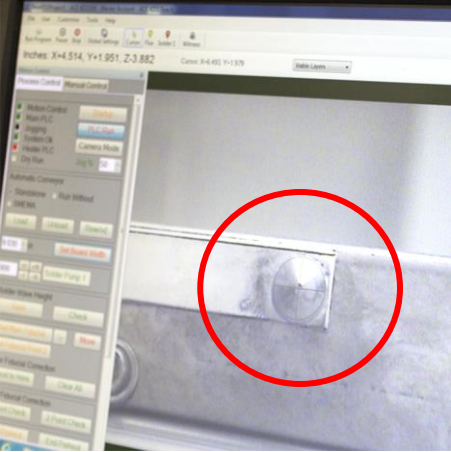
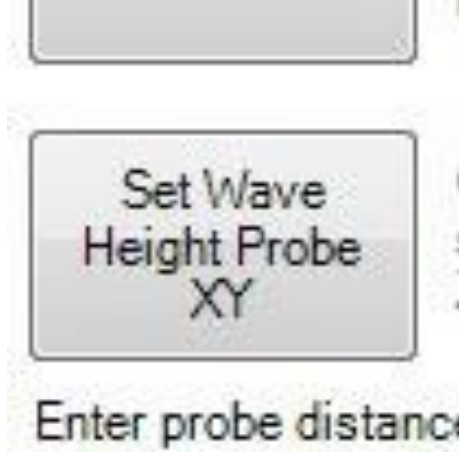
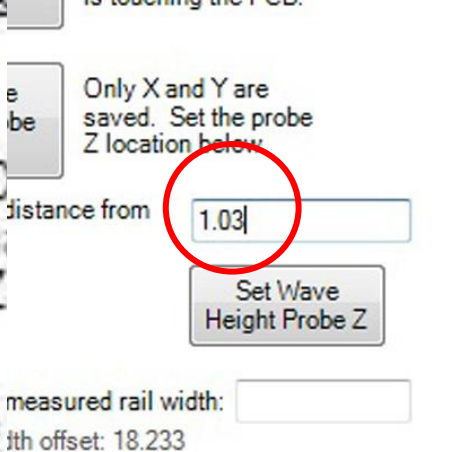
Access the Feature Locations Tab.

 A screenshot of the main SWAK-OS interface. The 'Tools' menu is open, showing options like 'Set Video Scale', 'Show Video Crosshair', 'Motor Setup', 'IO Setup', 'Setup Video Streams', 'Setup Tools and Features' (highlighted with a red arrow), 'Solder Pot Timer', and 'Toggle Video/Mosaic'. The 'PLC Run' button is visible below the menu.	 A screenshot of the 'Tool Setup' window. The 'Feature Locations' tab is selected, indicated by a red arrow. The window contains fields for 'Set Z Zero', 'Set Wave Height Probe XY', and 'Set Wave Height Probe Z', along with instructions and input fields for probe distance and rail width.
<p>Press the Tools tab and scroll down to Setup Tools and Features.</p>	<p>The Tool Setup window will appear on the right side of the screen. Press the Feature Locations tab.</p>

Step 3: Establish Location References.

		
<p>Align the nozzle tip under the probe, (the probe is located under the front rail on the left side) while holding the 'Ctrl' key, to slowly move the nozzle up just short of contacting the probe as seen.</p>	<p>At the top left of the window, is the Z readout reference number. Write down the Z measurement to be used later. It will be used later as a positive number so do not use the minus sign.</p>	<p>Next press Camera Mode in the Process Control tab. This will move the teach camera to proper camera height.</p>

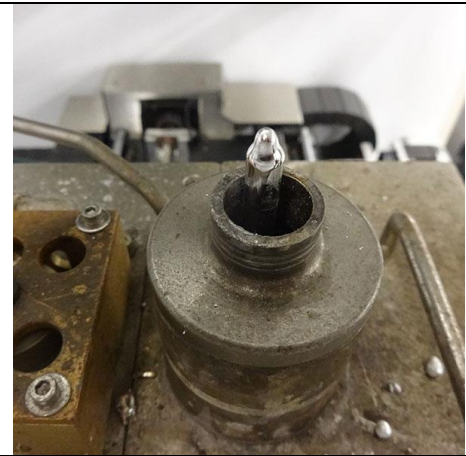
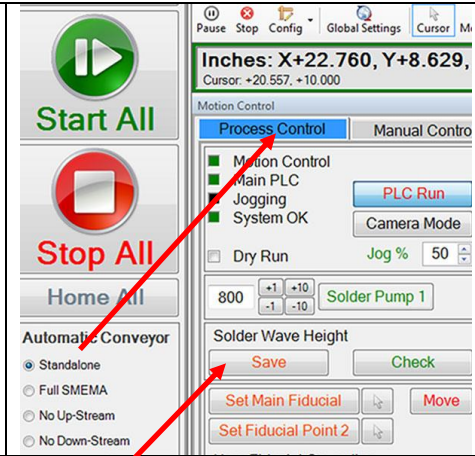
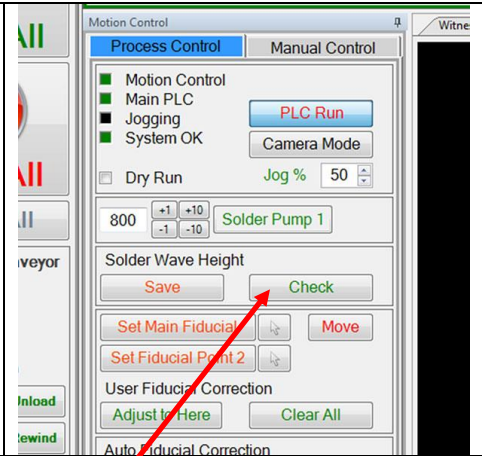
Step 4: Setting the Nozzle Position Offset.

		
<p>Using the arrow keys manually move the crosshairs on the screen to center the teach camera in the X & Y position to the Wave Height Probe as shown.</p>	<p>When the camera is centered, click the Set Wave Height Probe XY Button.</p>	<p>Next Enter the 'Z' measurement referenced earlier as a positive number and click the Set Wave Height Probe Z' button.</p>

Step 5

Save & Check the Actual Wave Height.

NOTE: It's a good practice to dress the nozzle with Superior 75 when the pump is turned on!

		
<p>Manually move solder pump to the center of the machine and turn it on. Make sure to set the solder dome to your preferred height, and dress the nozzle with the proper flux.</p>	<p>Open the Process Control tab and while the pump is running press the Save button. The pump will move to the probe and set the wave height & save it.</p>	<p>You can use the Solder Wave Height Check button to verify wave height.</p>

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