MRT-1061 (11/26/12)
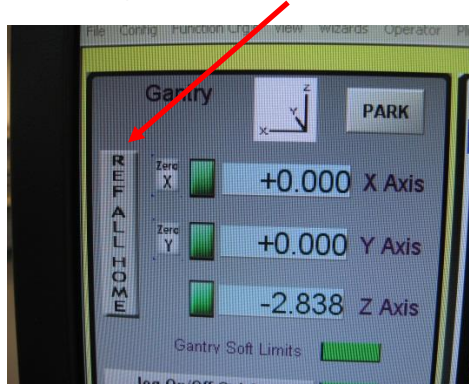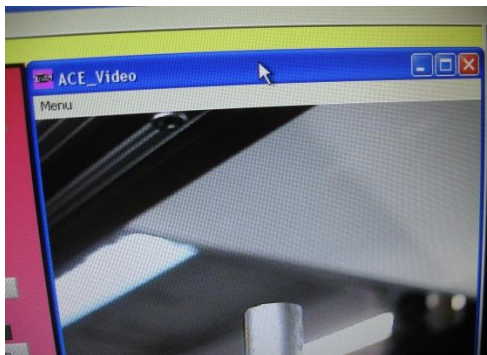**Wave Height Probe Coordinates**
**Note: Pump must have a NOZZLE on the riser**

1. Home machine by clicking **REF ALL HOME** on the screen.

2. Select camera 2 (Is Witness #1) by clicking on the **ACE_Video** field on the screen. Click the **Input Select** button for **CHANNEL 2.** As shown.
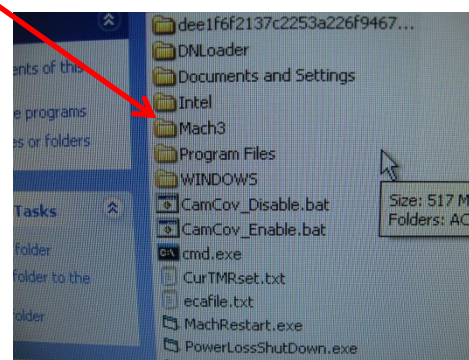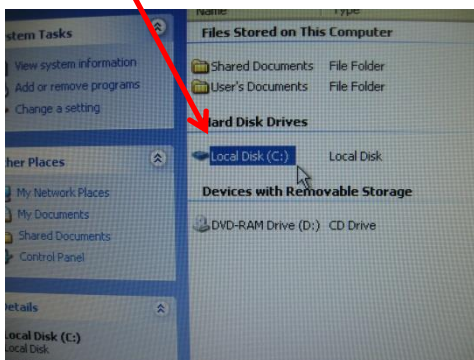

3. Using the **arrow keys**, manually **center** the nozzle to the probe leaving approx. 0.100 inch gap between the probe tip and the nozzle. **Nozzle MUST NOT hit the probe tip!**
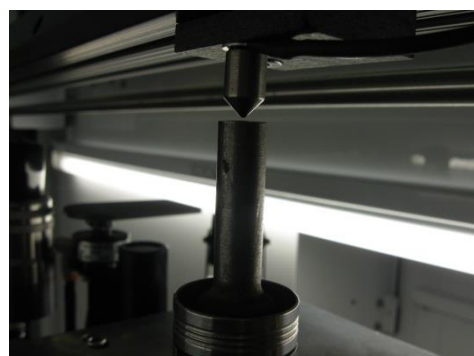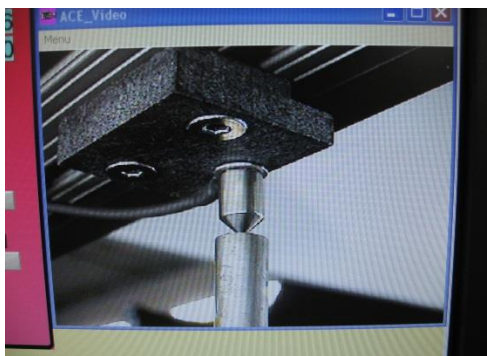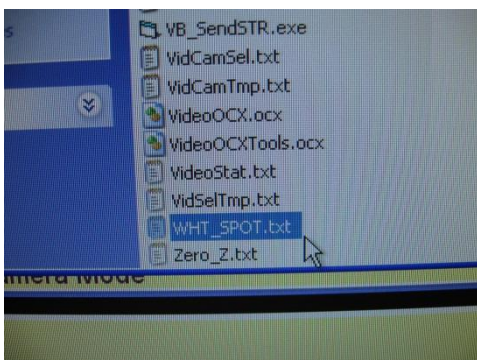
4. Press the **Start** button, next click on **My Computer** as seen below.
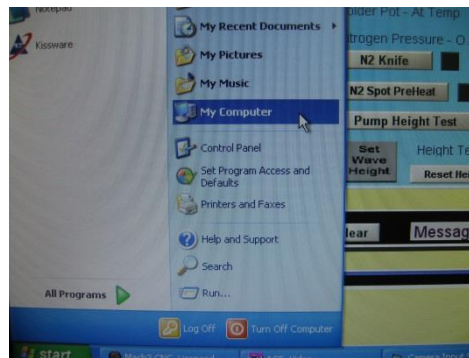
5. Click on **Local Disk C,** next open the **Mach 3** folder as shown below.

6. Open the **WHT_SPOT.txt** file. Enter the **X & Y** coordinates **ONLY** from the current **Gantry** position into the Notepad file. **DO NOT change the Z coordinate in the Notepad file!**

Notice how Notepad file matches the Gantry X & Y

7. Save the Notepad entry by pressing **File,** then **Save,** then close **Notepad** and **Mach 3** windows**.**
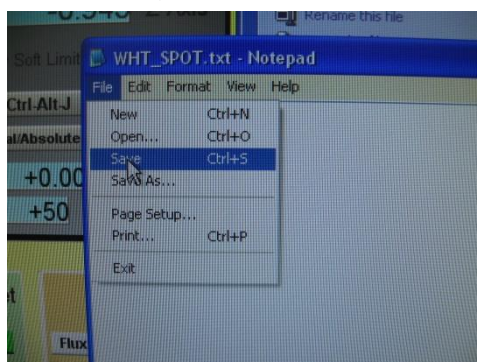
TEST

8. When completed set and test wave height by manually moving the solder pot to the center of the machine using the keyboard.
9. Next turn the pump on & adjust the flow on the nozzle to the operating dome height. (See MRT- 1054.1 Nozzle Prep)
10. Press the "Set Wave Height" button on the run screen.
11. When complete, the solder pot will move back to the center of the machine.
12. Then lower the pump speed 10-15 RPM.
13. Next press the "Pump Height" test button on the run screen.
14. The pump should move to the probe and adjust to the desired height.

NOTE: For **DUAL PUMPS** follow **Steps 1-7**. The file names in **Step 6** are changed. Please follow the instructions below.

15. First center **nozzle 1** on the **Dual Pump** as shown in **Step 3**. Then open the (**Steps 4-6**) **WHT_D_POTN1.txt** file. And enter **X & Y** coordinates **ONLY** as shown in **Step 6**. Then **Save** as seen in **Step 7**.
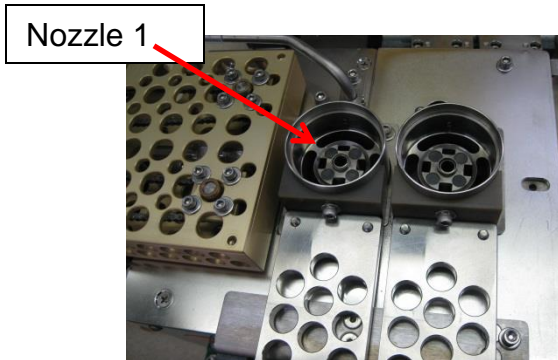
16. Next center **Nozzle 2** on the **Dual Pump** as shown in **Step 3**. Then open the (**Steps 4-6**) **WHT_D_POTN2.txt** file. And enter **X & Y** coordinates **ONLY** as shown in **Step 6**. Then **Save** as seen in **Step 7**.
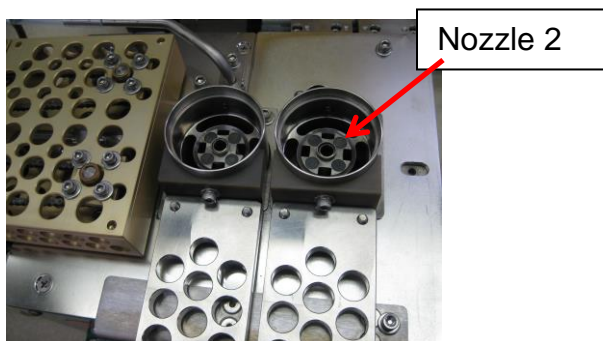
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