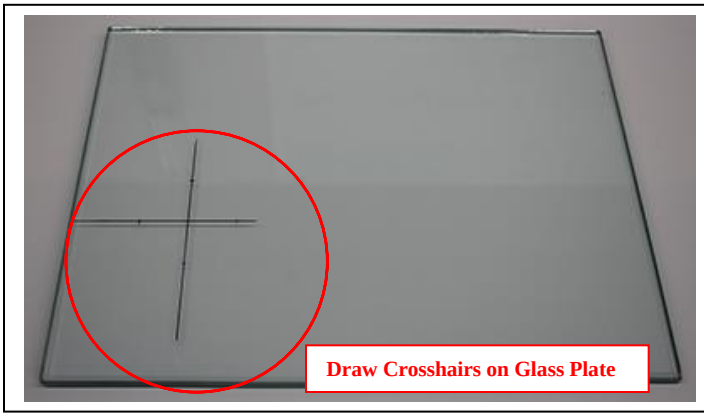
MRT-1048 SWAK-OS 3.0 Calibrating Offsets

Tool List:
Glass plate

- For calibration with cross hairs drawn on it.

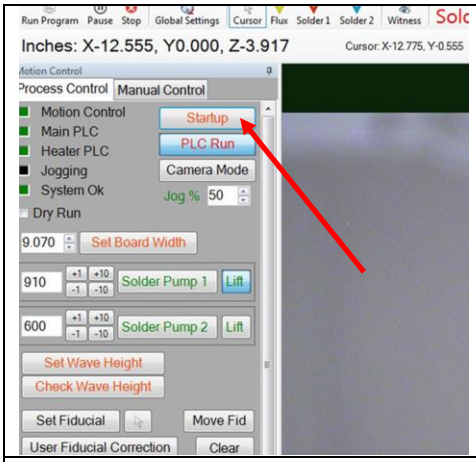
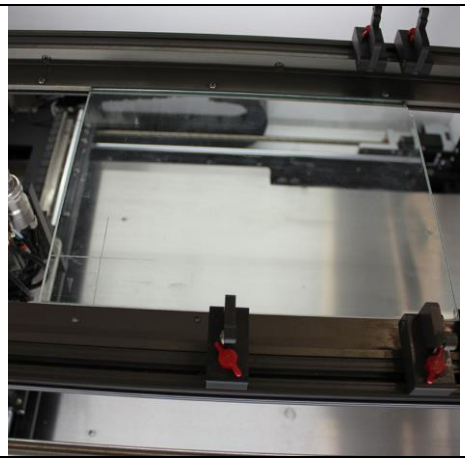
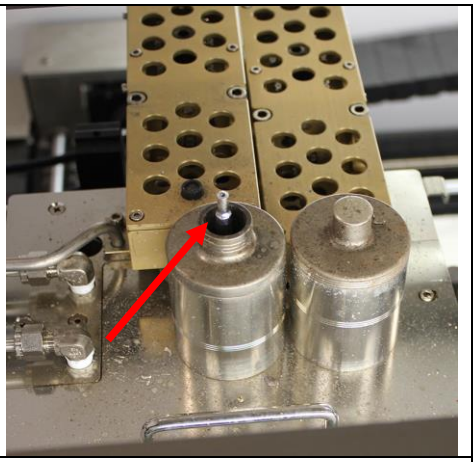


Notes:

- Make sure PC is booted and the Nordson SELECT Kiss Teach Software is running.
- You will need to have Administrator access to the SWAK-OS 3.0 software.

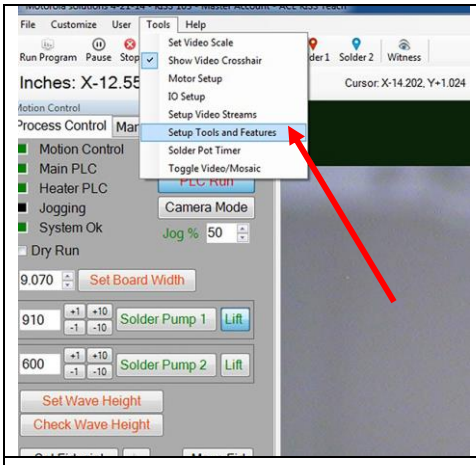
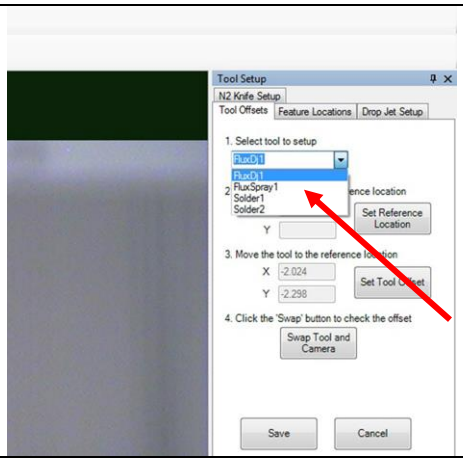
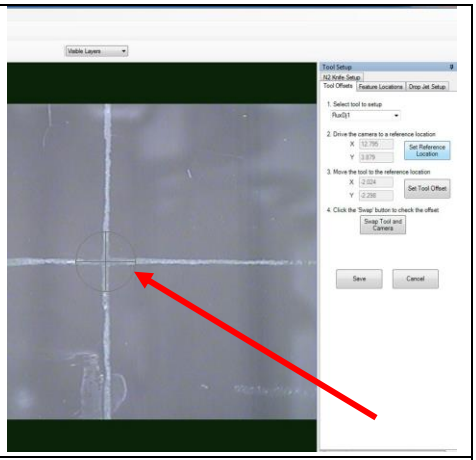
NOTE: For dual pumps both nozzles must be calibrated!

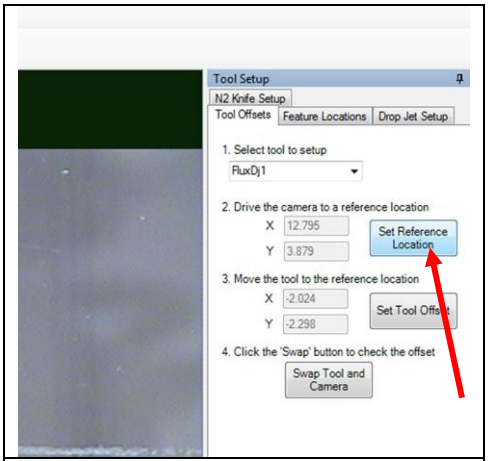
Step 1 Offset Preparation

		
Home the machine by pressing the **"Start Up"** button in the upper left of the screen.	Locate **glass plate** with crosshairs on rails against stop fingers or stop pins.	Place a **4.5mm** or **6mm** bullet nozzle on the solder pump riser. "Larger nozzles are not recommended!"

NOTE: For dual pumps, select tool will be: Solder1 & Solder2

Step 2 Set reference location with the teach camera.

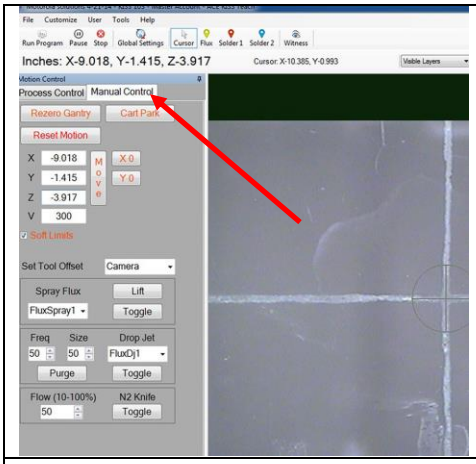
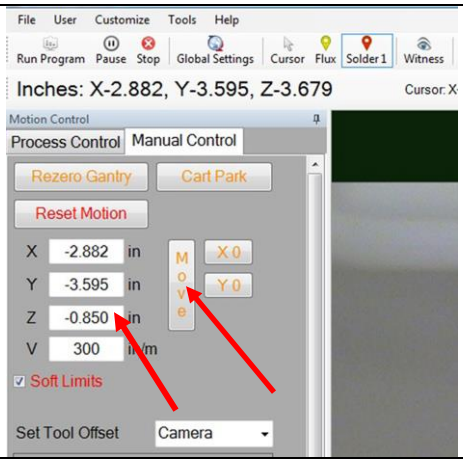
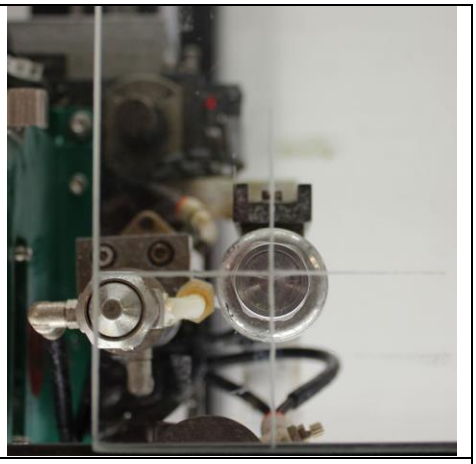
		
From the menu select **Tools** and scroll down and open the **"Setup Tools and Features"**	Select the **Tool Offsets** tab. Then go to **"1. Select tool to setup"** Use the drop down and choose the proper tool for calibrating offset. Example: **FluxDj1(Drop Jet 1)**	Using the arrow keys, center the camera crosshairs on the glass plate crosshairs, as shown. Drive the camera to a reference location. Press and hold the **Ctrl** key then use the **arrow** keys for more precise movement.



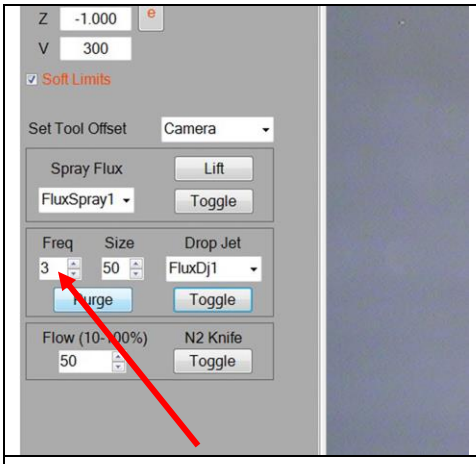
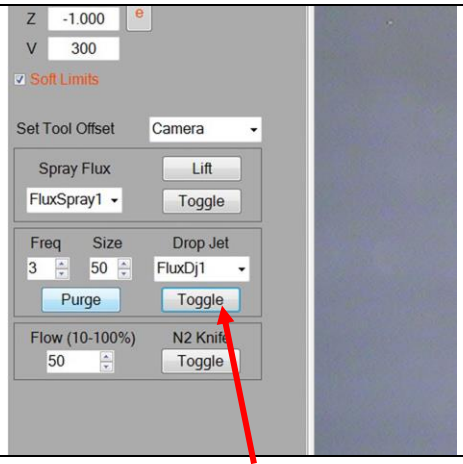
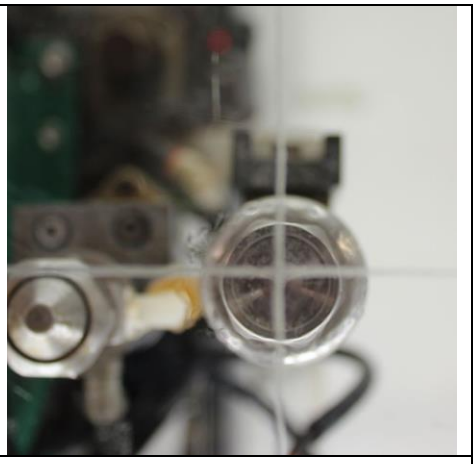
Once the crosshairs are properly lined up. Press the **"Set Reference Location"** button, as seen.
The new coordinates will be displayed.

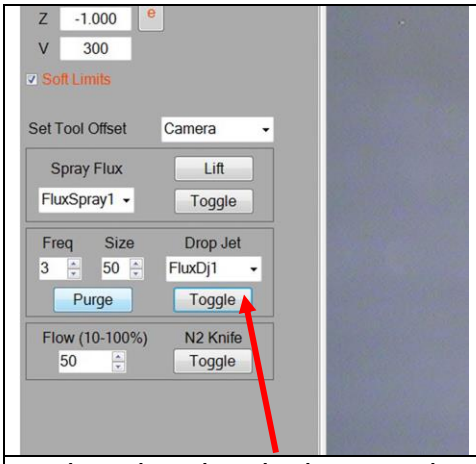
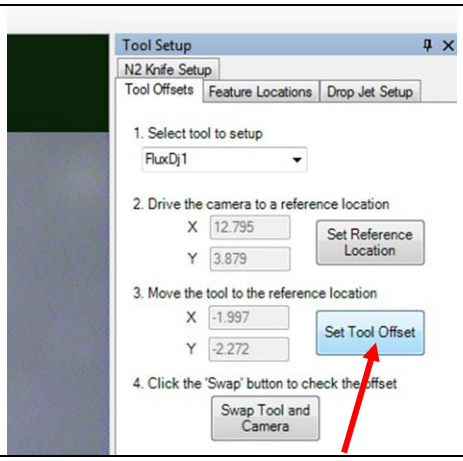
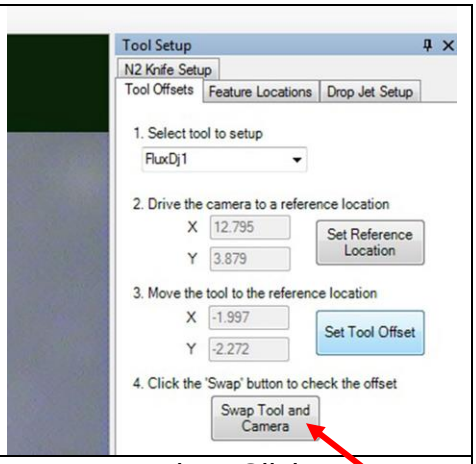
NOTE: Make sure path is clear before pressing the MOVE button!

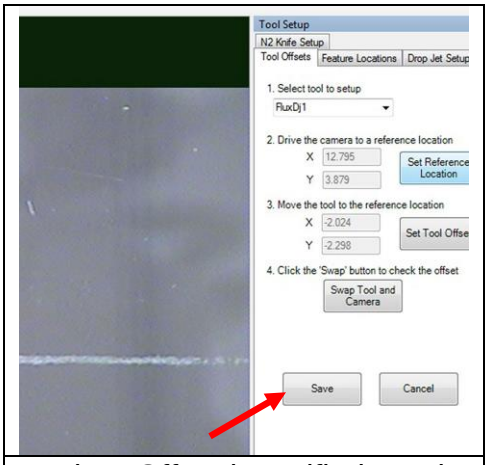
Step 3 Drop-Jet Offset

		
Note: The following steps are for the **Drop-Jet.** Press the **"Manual Control Tab"** in the upper left of the screen.	Type **-0.850** in the Z field Then Press the **"MOVE"** button Pressing the MOVE button is a direct command. **Make sure path is clear! Drop-Jet will move 1 inch below board zero!**	Using **arrow keys** on keyboard, center the **Drop-Jet** to the crosshairs on the glass plate**.** Press the **Ctrl** key then use the **arrow** keys for more precise movement.

NOTE: Frequency needs to be set to a small number between 2 and 5 and the Dot size will need to be set at 50 as this is the calibration size and dot should be 2mm in diameter. If the dot size is not 2mm at a 50 dot size then calibrate your drop jet using MRT-1120 SWAK-OS 3.0 Drop Jet Calibration document.

		
Enter **2** into the Drop-Jet **frequency** field and **50** into the **Size** field in the lower left of the screen as seen.	**Press** the Drop-Jet **"Toggle"** button To turn ON the Drop-Jet!	Next **center the flux dot** on the glass plate crosshairs! On the keyboard press the **Ctrl button** then use the **arrow keys** for more precise movement.

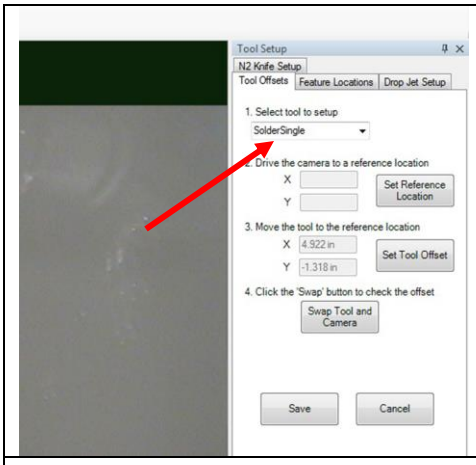
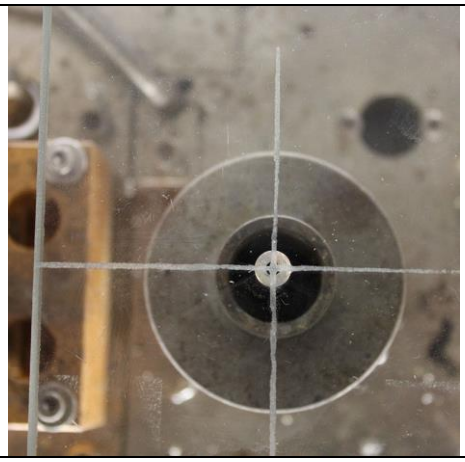
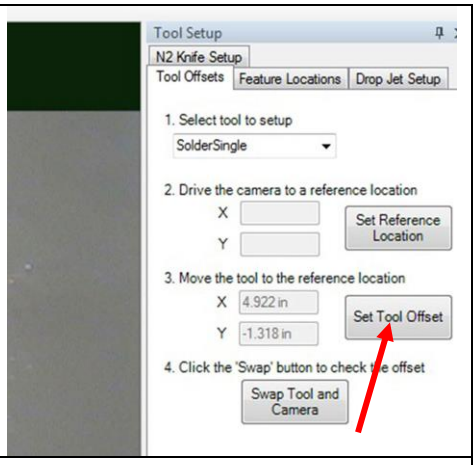
		
When the Flux dot is properly centered turn OFF the Drop Jet By pressing the proper **“Toggle”** button	Enter the offset coordinates by Pressing the **“Set Tool Offset”** button 3. Move the tool to the reference location	Then Click **“Swap Tool and Camera”** button to Verify offset is correct. 4. Click the “Swap” button to check the offset

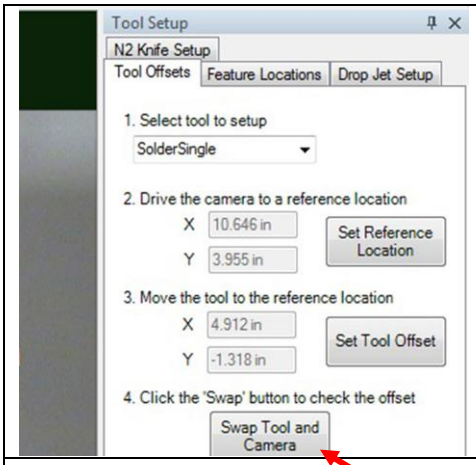
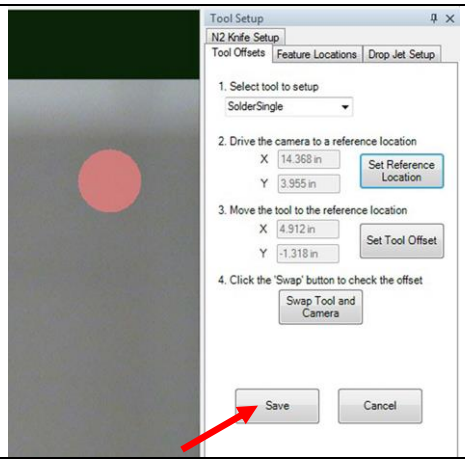
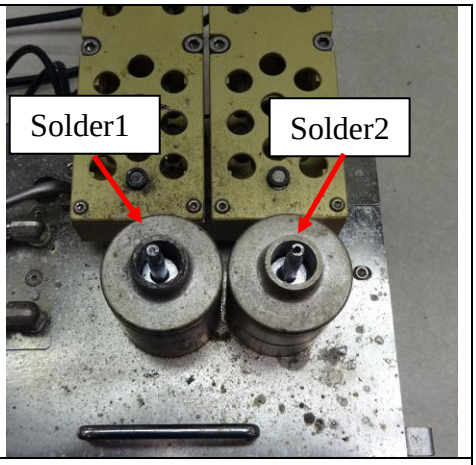


When Offset is verified good Press the **“SAVE”** button

NOTE: Whenever solder pots or pumps are changed out.
You will need to calibrate offsets!

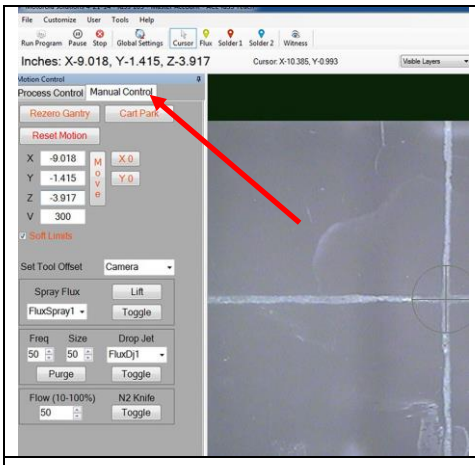
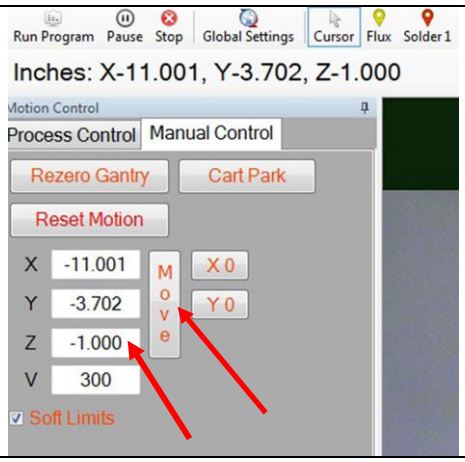
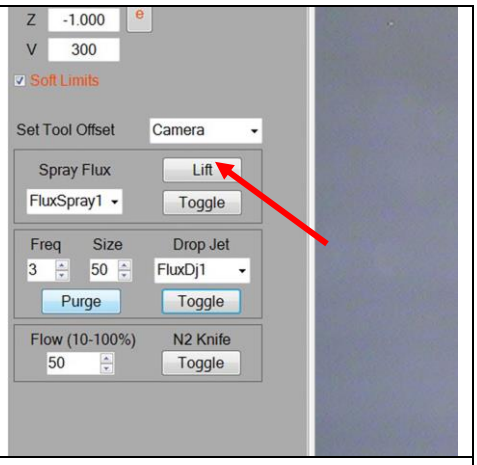
Step 4 Solder Nozzle Offset

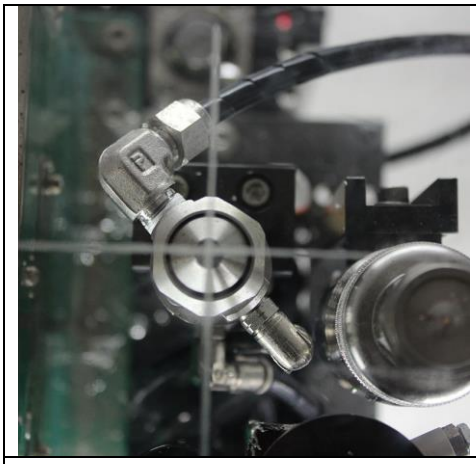
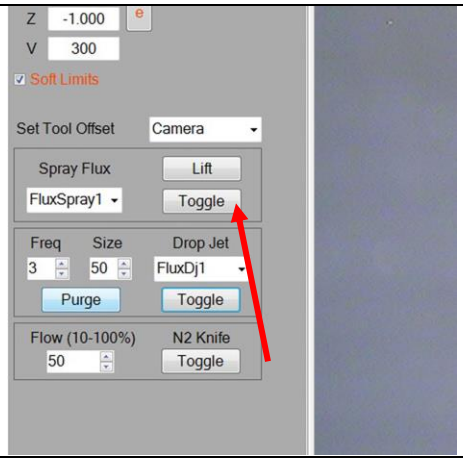
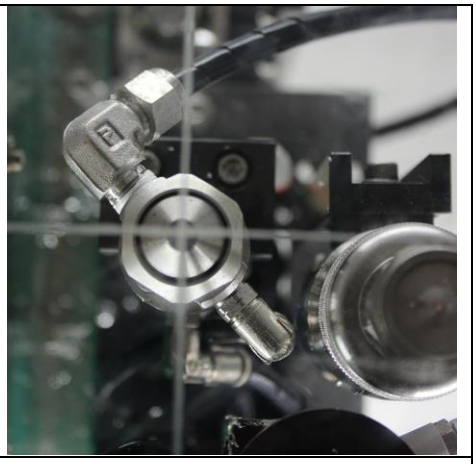
		
Follow **Steps 1 & 2.** When following **Step 2** 1.Select tool to setup Select: **Solder Single** For standard Pumps. **Use Solder1 & Solder2 for dual pumps.**	Next bring the nozzle up to the bottom of the glass plate. Center the nozzle on the **glass plate crosshairs!** Press the **Ctrl button** then use the **arrow keys** for more precise movement.	Enter the offset coordinates by pressing the **"Set Tool Offset"** button

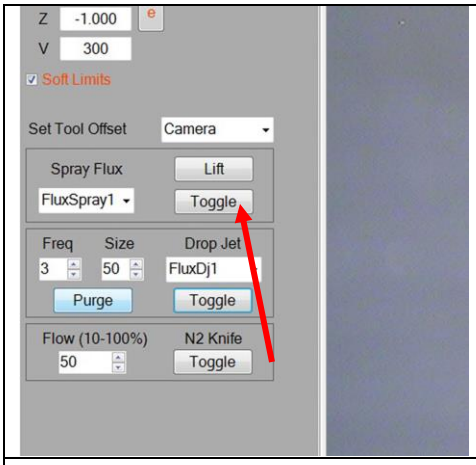
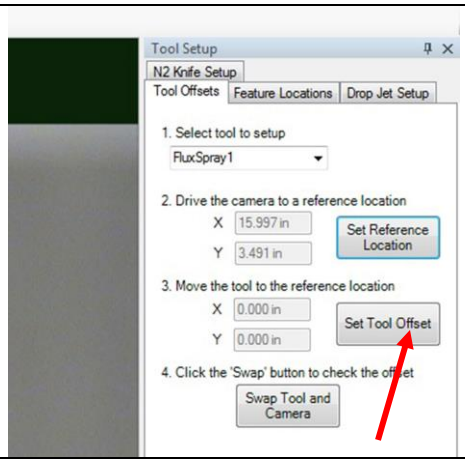
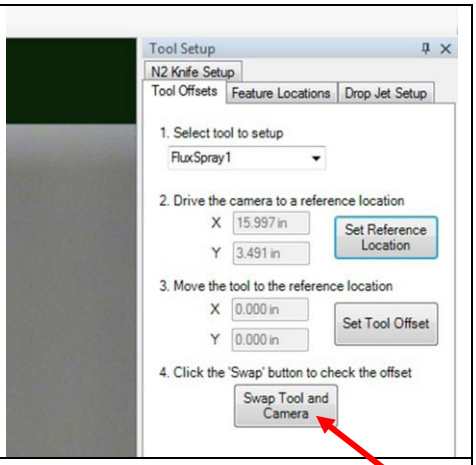
		
Then click **"Swap Tool and Camera"** button to verify offset is correct. 4. Click the "Swap" button to check the offset.	When Offset is verified good Press the **"SAVE"** button	For dual pumps use: Solder1 & Solder2 when selecting a tool for set up

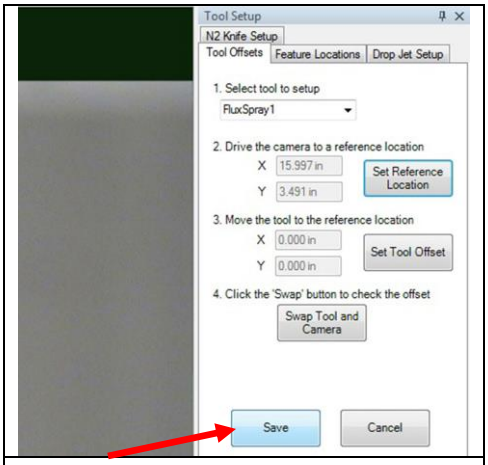
NOTE: Follow steps 1 & 2 before starting step 5 (When following step 2 use SprayFlux1)

Step 5 Spray Fluxer Offset

		
Note: The following steps are for the **Spray Fluxer.** Press the **Manual Control Tab,** upper left on screen. Follow steps 1 & 2 before starting.	Type **-1.000** in the Z field. Then Press the **"MOVE"** button pressing the MOVE button is a direct command. **Make sure path is clear!** **"Spray Fluxer will move 1 inch below board zero."**	Press the **"Lift"** button to position the Spray Fluxer in the up position.

		
Using **arrow keys** on **k**eyboard center the Spray Fluxer to the crosshairs on the glass plate. Press the **Ctrl button** then use the **arrow keys** for more precise movement.	Press the Spray Flux **"Toggle"** button To turn on the **Spray Fluxer,** then quickly press the toggle button again to turn off the fluxer.	If the spray did not land on center of the crosshair, adjust position as needed and repeat the toggle on/off! Press and hold the **Ctrl button** then use the **arrow keys** for more precise movement.

		
After you verify the flux cone is properly centered, make sure the spray fluxer is **turned off** by pressing the **"Toggle"** button.	Enter the offset coordinates by pressing the **"Set Tool Offset"** button. 3. Move the tool to the reference location.	Then Click "**Swap Tool and Camera"** button to verify offset is correct. 4. Click the "Swap" button to check the offset



When offset is verified good, press the **"SAVE"** button.

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