

# Nordson

## SELECT

### MRT-1067S SWAK-OS 4.0 & 3.0 Drop Jet Calibration

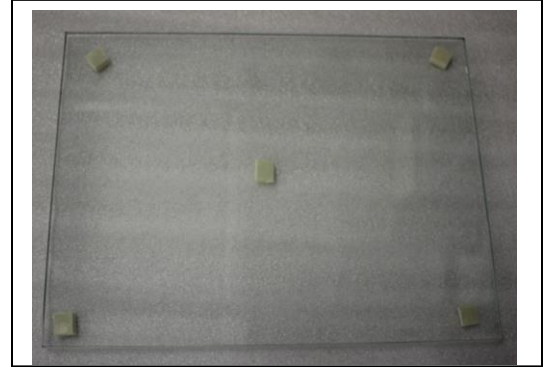
#### Tool List:

Glass plate

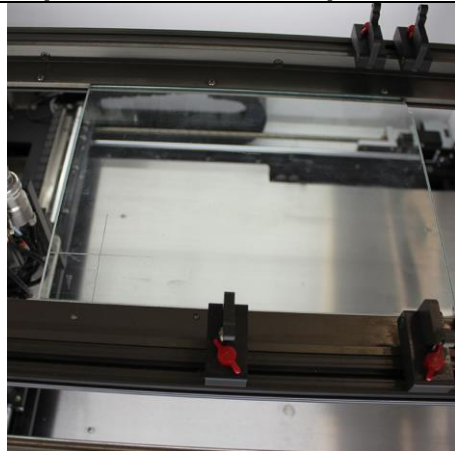
- For calibration.

#### Notes:

- Make sure PC is booted and the SWAK-OS software is running.
- You will need to have Administrator Access.



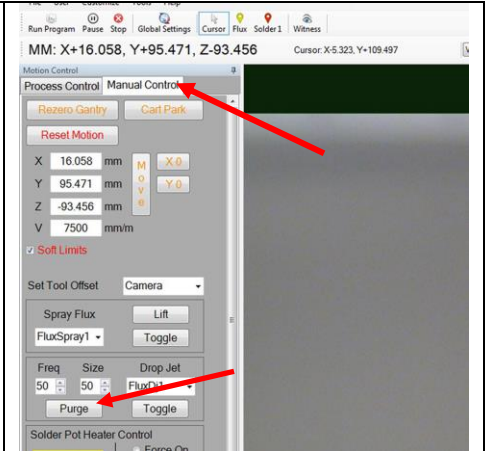
#### Step 1 Calibration Preparation



Open rails approx. 9"  
Place **glass plate length wise**  
on rails. Make sure plate is  
against the stop pin!

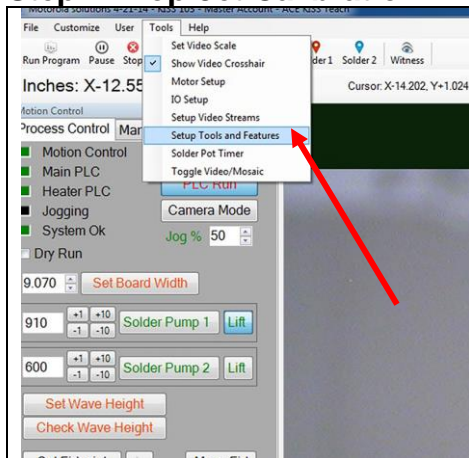


Verify **DROP-JET PRESSURE**  
It should be between 3-5 psi.

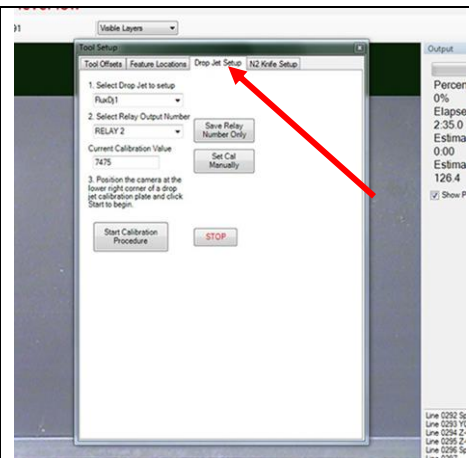


Select the "**Manual Control**  
**Tab**" and then press the drop-  
jet "**Purge**" button and hold to  
verify flux is spraying.

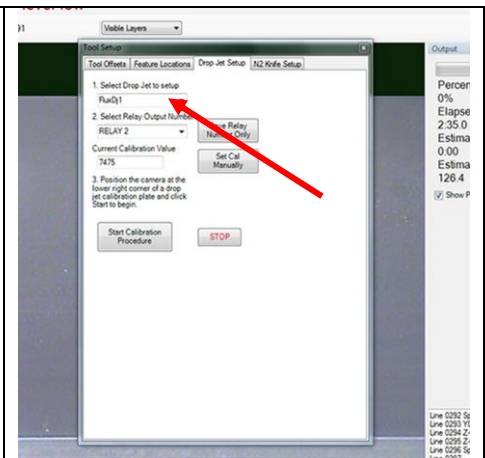
## Step 2 Drop-Jet Calibration



Select the **"Tools Tab"** and scroll down to open the **"Setup Tools and Features"**.

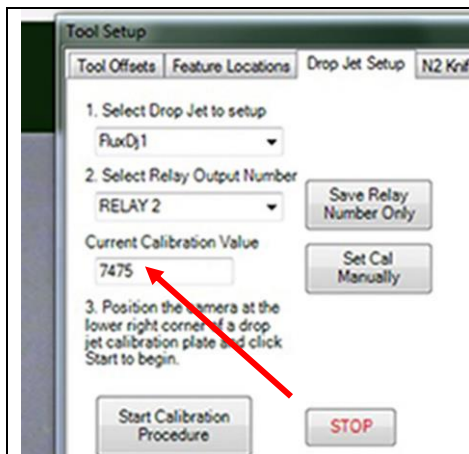


Select the **"Drop-Jet Setup"** tab.  
**Note:** "Relay Output" should be **RELAY2**.

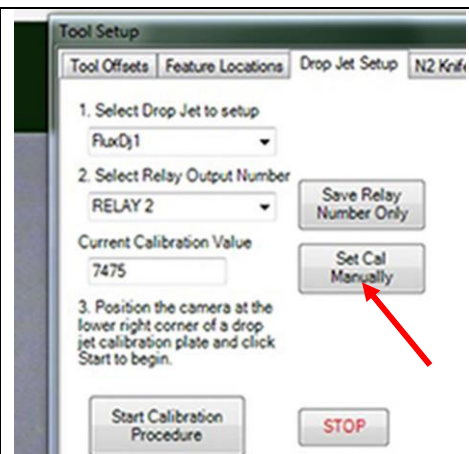


Then go to  
**1. "Select drop-jet to setup"**  
Use the drop down to select the proper drop-jet.  
Example: **FluxDj1(drop-jet 1)**  
**FluxDj2 (drop-jet 2)**

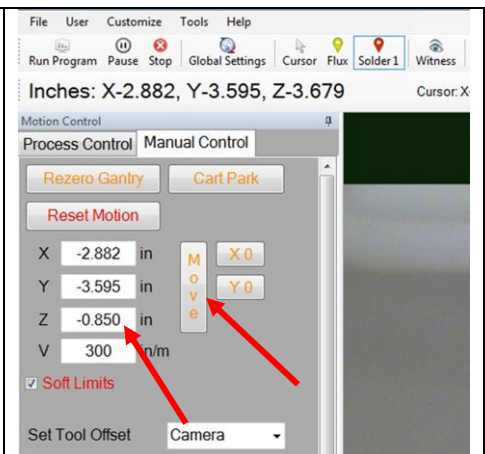
**NOTE: Make sure path is clear before pressing the "MOVE" button!**  
**The table will move in the upward position.**



Increase current calibration value by 100. By highlighting numerals with the mouse. Then type in the new value.



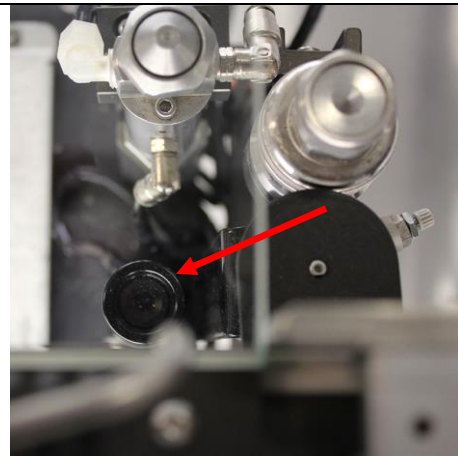
Next press the **"Set Cal Manually"** Button.



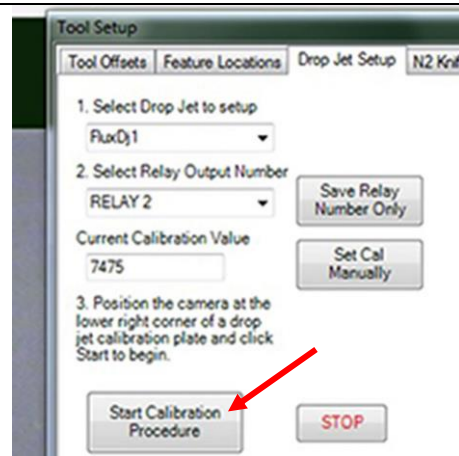
Type **-0.850** in the Z field.  
Then Press the **"MOVE"** button.  
Pressing the MOVE button is a direct command.  
**Make sure path is clear!**  
**The drop-jet will move approximately 1 inch below board zero!**

**Note:** When dispensing coarse calibration, lines watch for 2mm dots that are defined and separate from one another in each row. Make sure to watch each line and note the line number with the best 2mm dot results. The machine will make 10 passes. Row 1 will start at

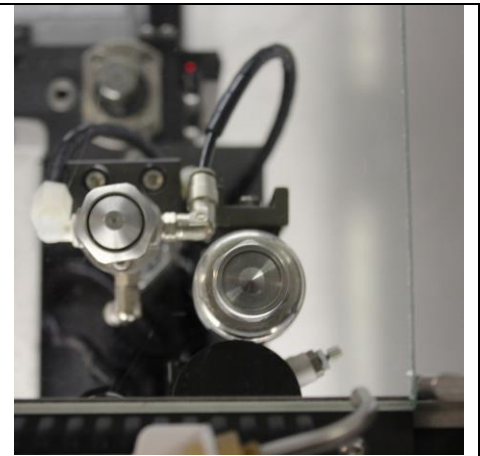
the front of the machine and then move to the rear. You may not see any dots for the first several lines!



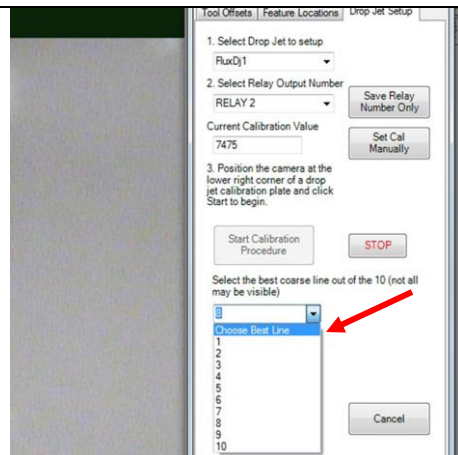
Using the arrow keys position the **camera** in the front right corner of the glass plate as shown.



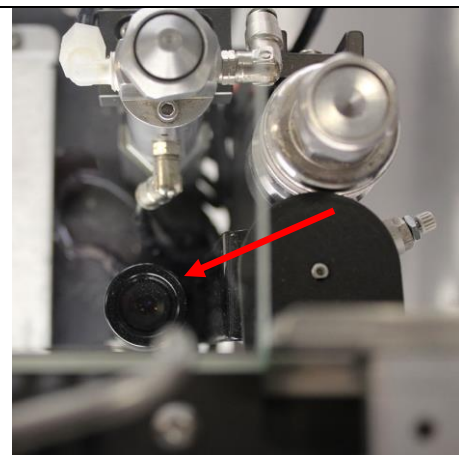
Then press the “**Start Calibration Procedure**” button.



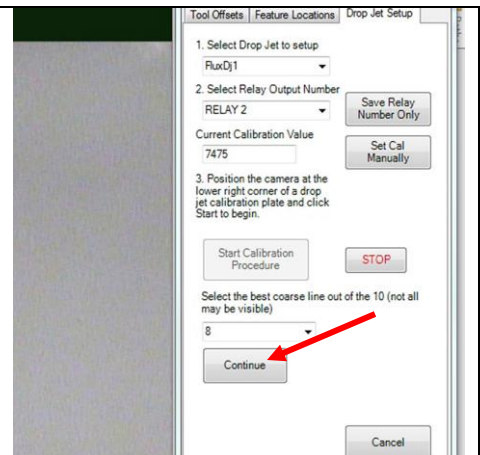
The drop-jet will move into position and begin the sequence for making coarse lines.



When the sequence is completed, select the best coarse line by using the drop down in the “**Choose Best Line Box**” and scroll down and select the best line number 1-10.



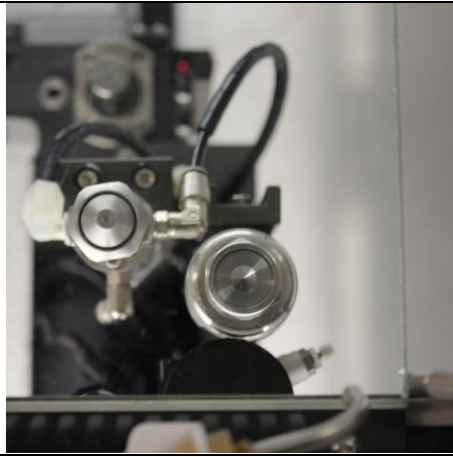
The camera should be in the home position. Next, clean the glass plate and return it in the same position.



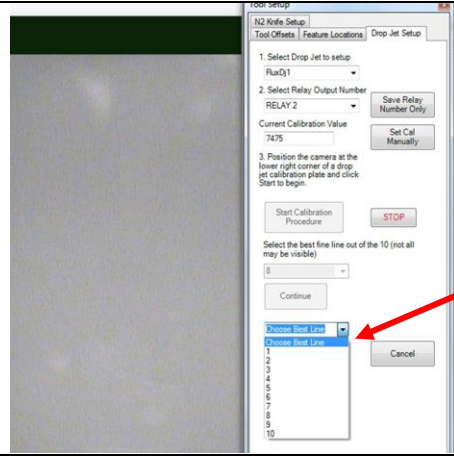
Next press the “**Continue**” button.

**Note:** When dispensing fine calibration, lines watch for 2mm dots that are defined and separate from one another in each row. Make sure to watch each line and note the line number with the best 2mm dot results. The machine will make 10 passes. Row 1 will start at the front of the machine and then move to the rear. You may not see any dots for the first several lines!

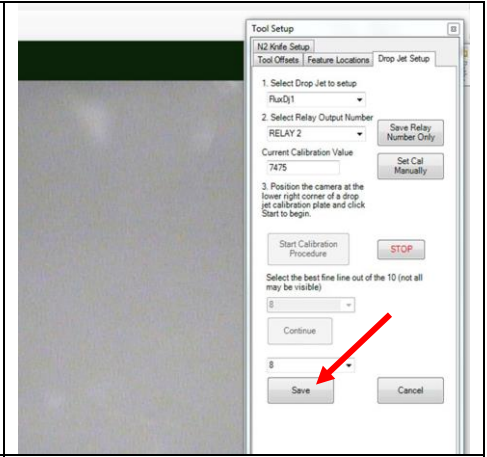




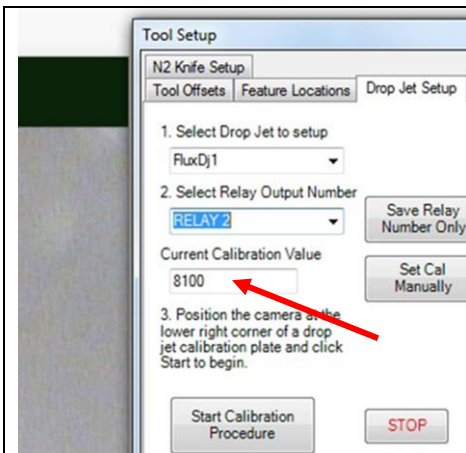
The drop-jet will move into position and begin the sequence for making **fine lines**.



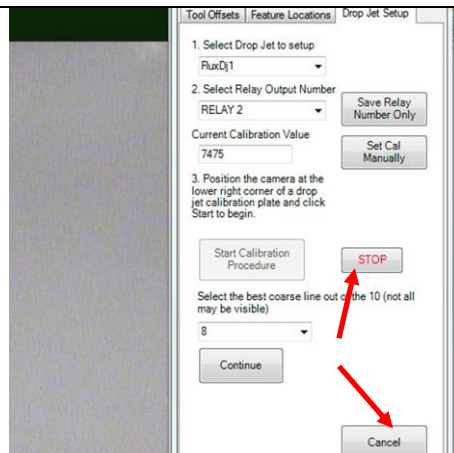
When the sequence is completed. Select the best fine line by using the drop down in the **“Choose Best Line Box”** and scroll down and select the best line number 1-10.



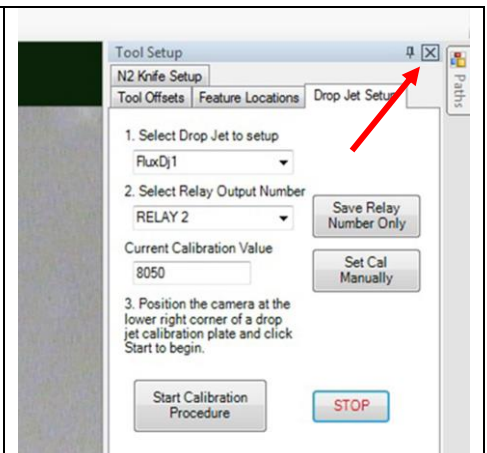
Then press the **“Save”** button.



The **“Current Calibration Value”** may change to a new value.



When the **“Stop”** or **“Cancel”** button is pressed during the sequence, you will need to use the arrow keys and position the camera in the front right corner of the glass plate and resume by pressing the **“Start Calibration Procedure”** button.



You can close the **“Tool Setup”** window by pressing the **X** in the upper right corner as shown.

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