Setting up your saw from scratch.

1.First home the machine then take a test cut at minimum length, make sure the length stop is still solid at home when you do this (sometimes it will move back and forward after you home it this is normal the saw is testing the e-stop functionality). The measurement you get should match the "sawbladetolengthstop" measurement in the configuration section. If you want/need to enter this number in 32nd's to be more accurate go to the program settings (under the administration tab) and change the display units to 32nds (make sure you change it back when you have finished!!)

2.Now check the Cal figure in Axis 1 again in the configuration section it should be 55.98 +/- .02. Now set up some Manual 90 degree cuts 4, 6, 8, 10, 12, 14, 16', Do these nick cuts on one long straight piece of stock then run the stop back the other way 16, 14, 12, 10 etc to make sure you have repeatability on the way back in. If these cuts are correct then move on to step 3.. If the cuts are getting longer as the length gets longer decrease the Axis 1 Cal figure by .01 and retry, if getting shorter then increase by .01 retry this test and repeat until spot on.

3.Once you are happy with 90 cuts, cut a board with a 90 degree on one end and a 15 degree on the other. To get this board to cut correctly you will need to adjust the centre point to length (CP to length) the best screen to adjust this in is calibration to get there directly push the question mark in the bottom left corner of the cutting screen and choose calibration. Choose centre point to length then hit calibrate from the sub screen choose CPO plot (don't push calibrate) and make an adjustment to the CP to length measurement save the settings and exit both screens this will take you back to the cutting screen (you do not have to home the machine after making this adjustment) then re cut the 90/15 board and measure again. Repeat this process until the 90/15 board is cutting correctly.

4.Now try cutting a 4 angled web and check the centre point and length, if the length and offset are right then you are finished, if not then you may need to adjust the center point to fence measurement here is where it gets a bit tricky because adjusting the CP to fence will effect the CP to length. See the example below.....make sure you choose cutting on the right face of the board, change the CP to fence measurement (make a small change 0-0-1 or 0-0-2) and hit PLOT, you will get a new graph line as well as your old one then adjust the CP to length measurement and hit PLOT again, you need to get the 2 lines to intersect at the 15 degree mark at the same place they did before the adjustment by adjusting the CP to length. Once you have achieved this save the settings and try web again. Again you may have to repeat this process several times to achieve a perfect web.

5. Re check your 90/15 cut, if you get these right and you are still getting variances it is going to be either 1. some sort of mechanical fault or 2. operator error.

Centre Point Offset Plot - Length Error

Cutting at Left Hand Saw Face - Length Stop Correction

180<-0 + Imp 1/32

	CP to Fence	0	CP to Length	0
		0-0-0		0-0-0
	CP to Fence Adj.	0-0-1	CP to Length Adj.	0-0-5

PLOT (F3)

EXIT (F1)　　　　　　　　SAVE SETTINGS (F2)

EXIT (F1)　　　CALIBRATE (F2)　　　TEST FUNCTION (F3)　　　CF ZONE MAPPING (INS)

Cal. Fun
STOPLE
SAWAN
CENTER
TOUCHS

Calibra

Acc
Vel
Pos
Pro
Der
Inte
Inte
Cal
Cal