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Aidit AMW-400 calibration manual



2020.10

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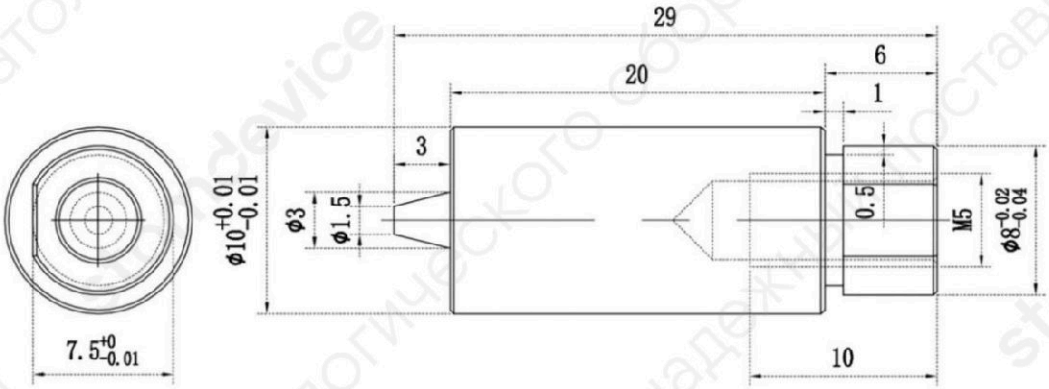
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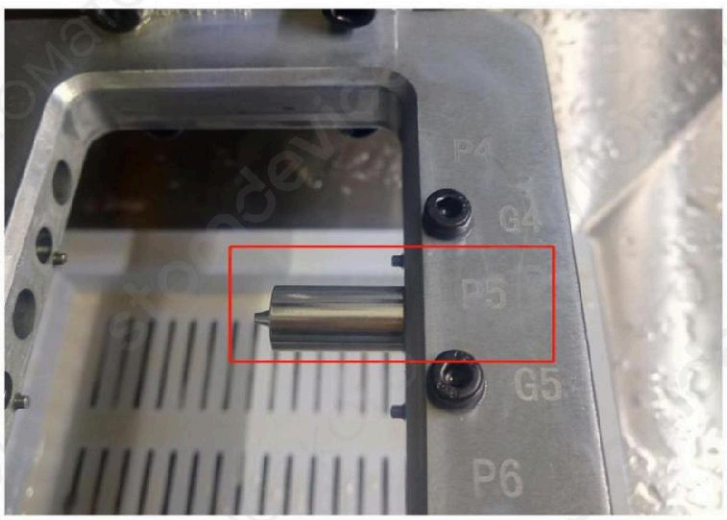
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Prepare

1. calibration material : aluminium
2. calibration rod size : D10 mm
3. calibration rod number : 2
4. calibration tool : T1 (3.0mm)
5. calibration position : P5
6. program:“AMD-400_P5_Y center calibration program. NC" documents,
   “AMD-400_P5_XZ Center Calibration Program. NC" documents





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II calibration block milling

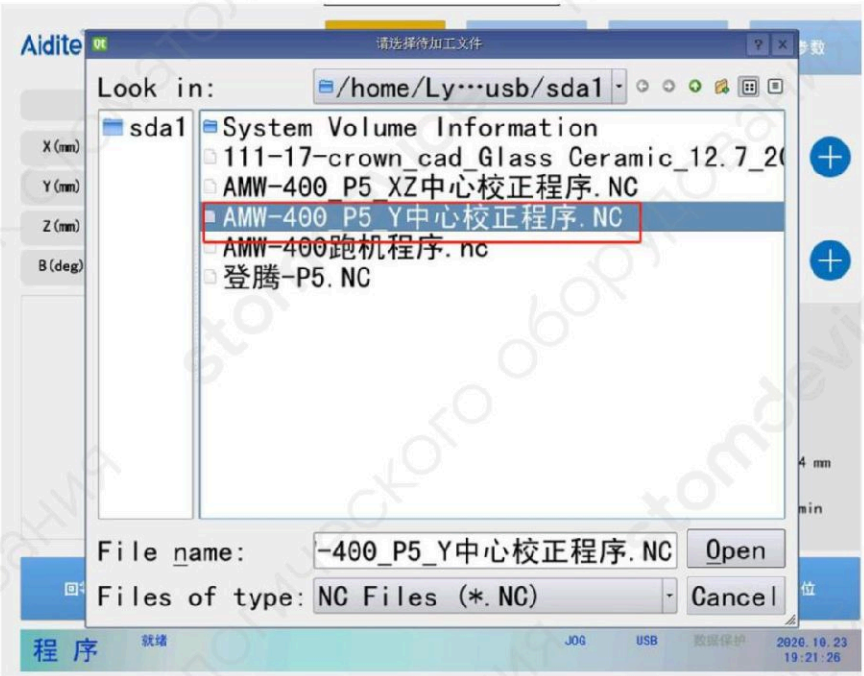
2.1. Y axis central calibration block milling

1. import calibration file: will AMD-400_P5_Y center calibration program. NC" into U DISK,

Enter the USB port of the machine and click the load button.



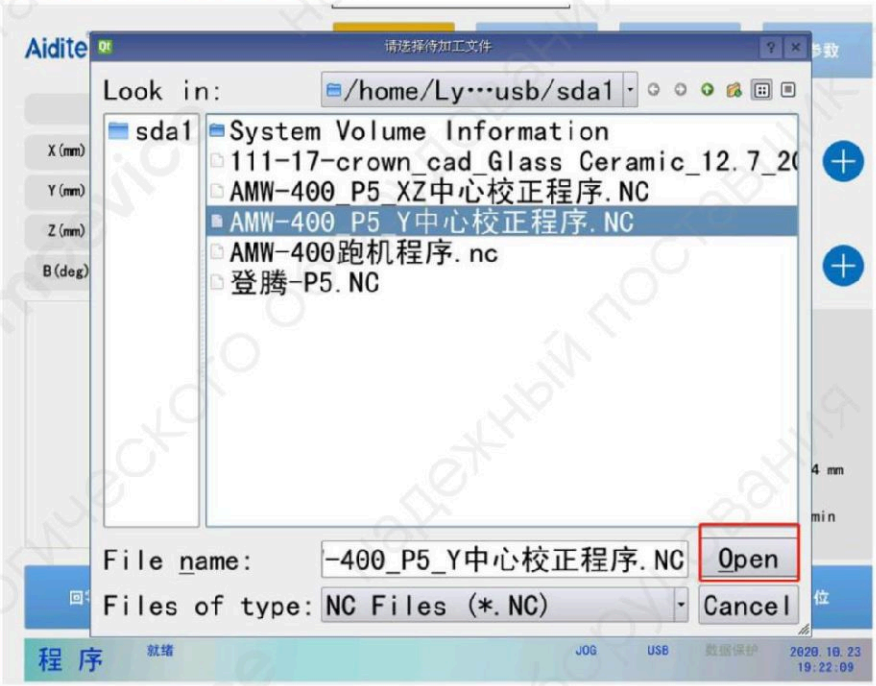
2. find the calibration file AMD-400_P5_Y center calibration program. NC", select and click open.



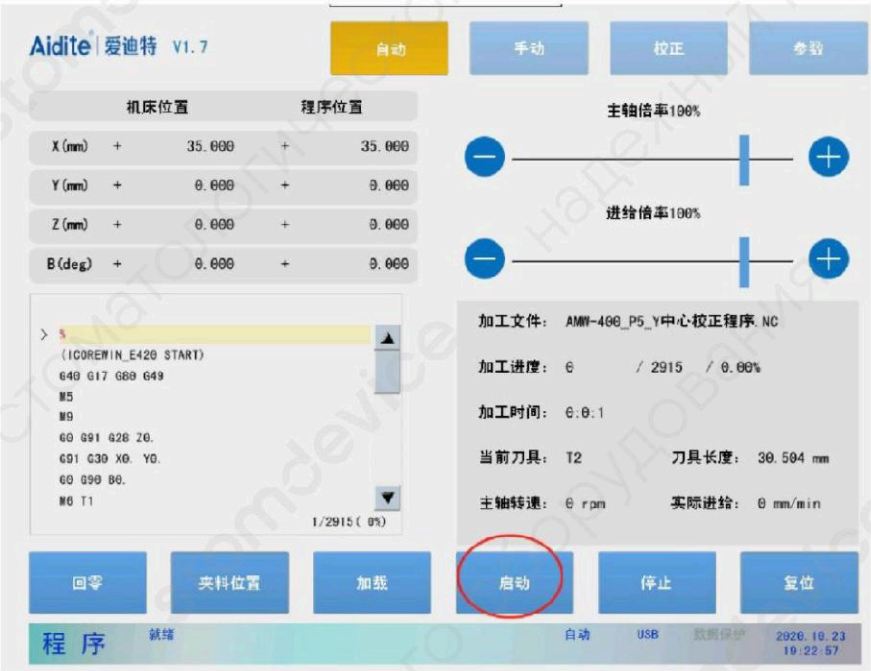
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3. confirm that the D3.0 mm tool and calibration rod are installed and click the start button



4. milling finish

2.2. XZ axis central calibration block milling

1. import calibration file: will AMD-400_P5_XZ center calibration program. NC" into U disk

Insert the USB port of the machine and click the load button.

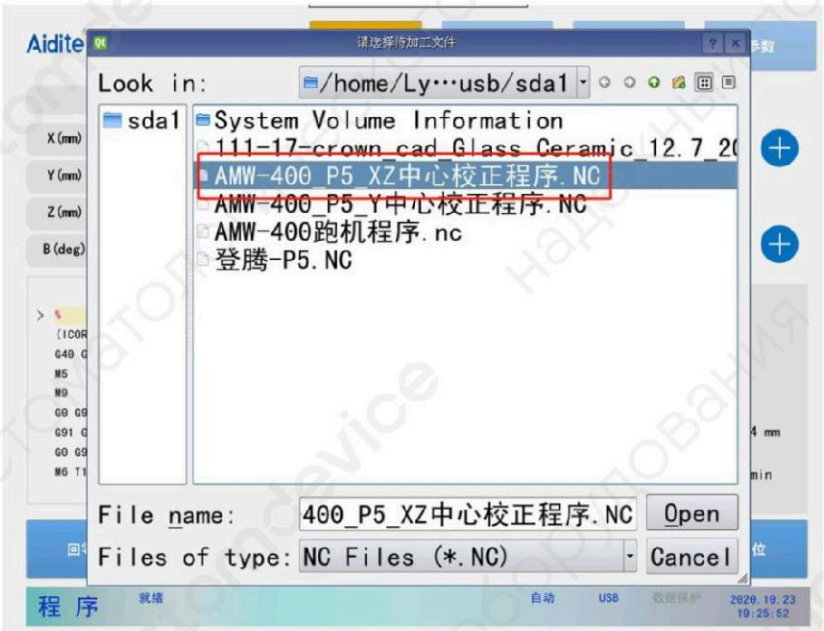
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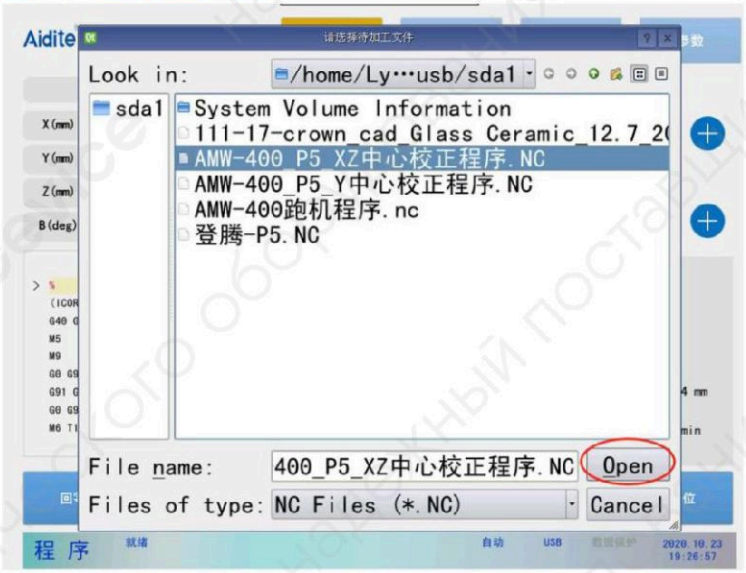
2. find the calibration file AMD-400_P5_XZ center calibration program. NC", select and click open.



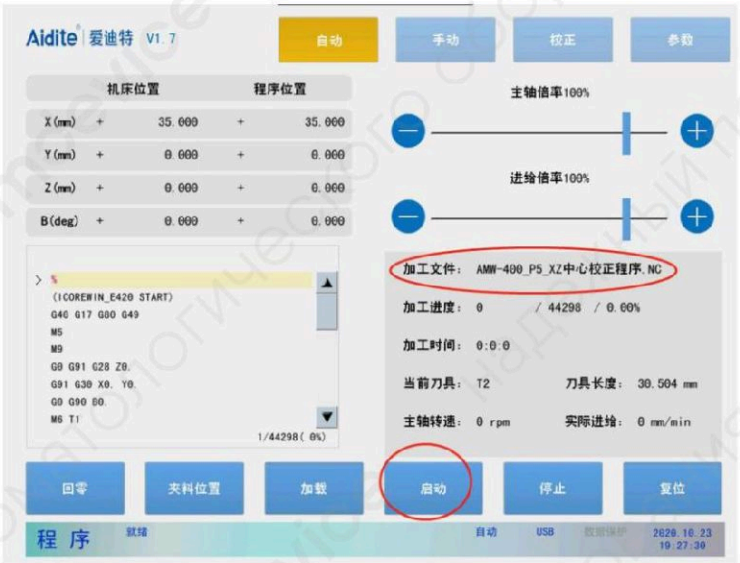
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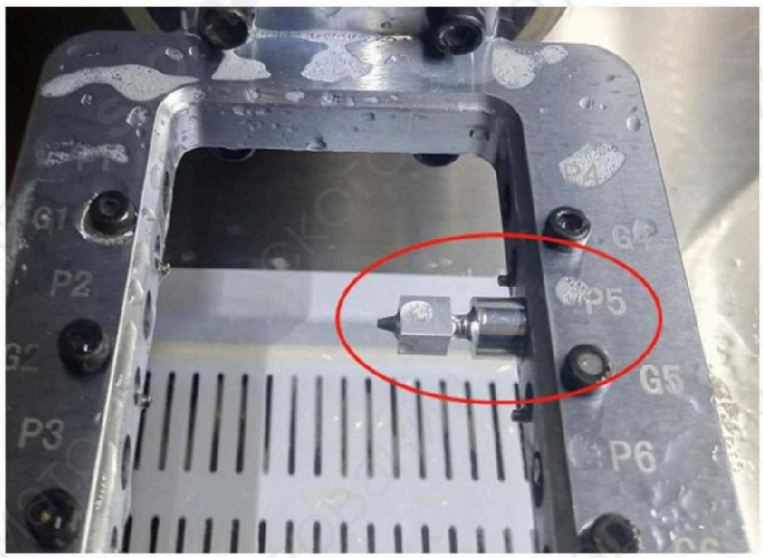
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3. confirm that the D3.0 mm tool and calibration rod are installed and click the start button



4. milling finish



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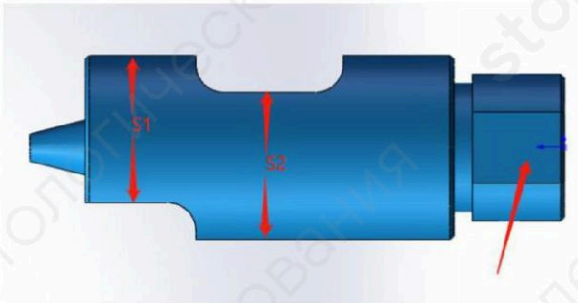
III calibration blocks

1. Prepare the digital display Vernier caliper and remove the calibration rod, total two calibration blocks.



2.Y axis center calibration block: put the flat surface of the calibration block's fixture end upward, the width of the cone interface end is S1, the width of the middle section is S2.
Please make sure don't measure the Chamfered area of the plane during the test.



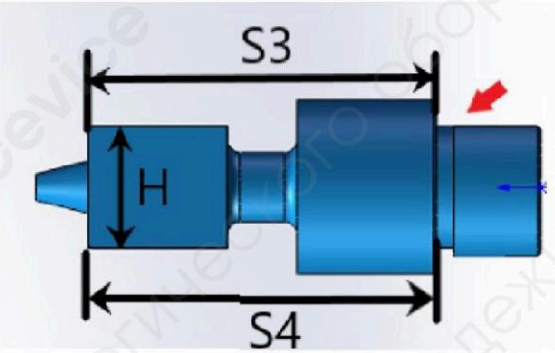


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3.XZ axis calibration block : put the flat surface of the calibration block's fixture end upward, the radial size of the upper part of the calibration block square to the fixture end is S3, the corresponding part of the bottom radial dimension is S4.
H is the height of the calibration square block.



4. Measure the S1, S2 and S3, S4, H values with a digital vernier caliper and take photo as record, for example, S1=7.94mm, S2=7.98mm, S3=19.55mm, S4=19.56mm, H=7.02mm.
Note: The burrs on the measuring end face should be scraped off before measuring the size. Accurately measure S1, S2, S3, S4, H value.



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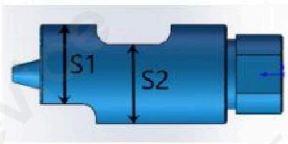
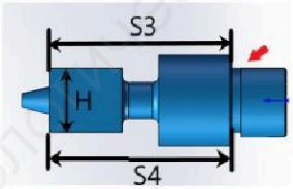
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IV. Login calibration mode input record value.

1. open a temporary AMW-400 calibration calculation gadget on EXCEL notebook.

名称

AMW-400 CALIBRATION TOOL.xlsx

AMW-400 CALIBRATION TOOL			
NOW G55	X(mm)	Y(mm)	Z(mm)
	123.539	-20.27	-99.58
			
S1(mm):			
S2(mm):			
			
S3(mm):			
S4(mm):			
H(mm):			
NEW G55	X(mm)	Y(mm)	Z(mm)
	123.539	-20.27	-96.08

2. Enter the machine parameter screen, parameter screen login password is: PASSWORD, view the current machine's G55 values, and take photo as backup, to prevent input errors, can not find the original parameters.

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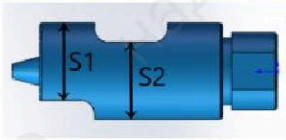




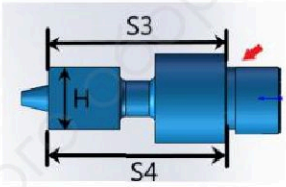
3. enter the value of the machine's current G55 in the table.

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AMW-400 CALIBRATION TOOL			
NOW G55	X(mm)	Y(mm)	Z(mm)
	123.539	-20.27	-99.58



S1(mm):	
S2(mm):	



S3(mm):	
S4(mm):	
H(mm):	

NEW G55	X(mm)	Y(mm)	Z(mm)

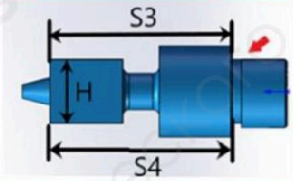
4. Enter processed and accurately measured dimensions in the table: S1、S2、S3, S4 and height H.

A new G55 workpiece coordinate value is obtained after inputting the value.

AMW-400校正计算临时小工具			
机器当前G55	X(mm)	Y(mm)	Z(mm)
	123.539	-20.27	-99.58



S1(mm):	7.99
S2(mm):	7.94



S3(mm):	19.52
S4(mm):	19.58
H(mm):	7.02

机器新的G55	X(mm)	Y(mm)	Z(mm)
	123.509	-20.245	-99.59

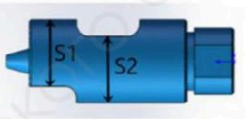
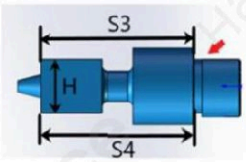
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5.On the machine parameter screen, use the soft keyboard or external USB keyboard to enter new G55 values.

Press enter to confirm, the input value will change from red to black.

AMW-400校正计算临时小工具			
机器当前G55	X(mm)	Y(mm)	Z(mm)
	123.539	-20.27	-99.58
			
S1(mm):	7.99		
S2(mm):	7.94		
			
S3(mm):	19.52		
S4(mm):	19.58		
H(mm):	7.02		
机器新的G55	X(mm)	Y(mm)	Z(mm)
	123.509	-20.245	-99.59



V. Effective calibration

G55 XYZ coordinates value input enter OK, click automatic mode, and then click "duplicate ". The corrected deviation value takes effect. calibration procedure completed.

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VI Calibration Confirmation Note (Important)

1. To confirm that the coordinates of the machine have been corrected back to the standard calibration range, need to mill the calibration block again and measure the value of S1、S2、S3、S4 and height H.
2. Standard range: S1/S2=7.95±0.05 mm,S3/S4=19.55±0.05 mm, H=7+0.03$_0$mm

3. If the corrected value is not within the above standard range, the calibration procedure needs to be performed again.

4. Calibration cycle:

When the pre-interface customized abutment interface has been over cut, glass ceramics appear chippings, unfit position or other abornomal situations, could do the calibration anytime.

It is recommended that the periodic calibration operation to be done once a month.

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