



Accu-Kut/TruKut Bridge Squaring

FOR MACHINES WITHOUT SQUARING BLOCKS

Service bulletin | Walkthrough | 12/6/19

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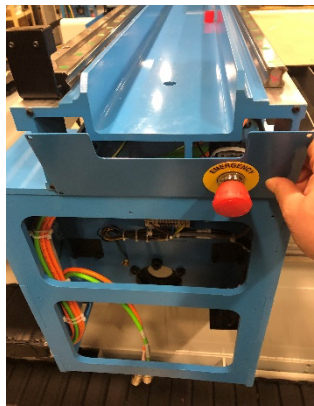
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Tools needed

1. Metric Allen Wrench Set
2. 3/8 Drive Socket Wrench
3. 12 Inch Extension
4. 13mm socket
5. 13mm open/boxed end wrench

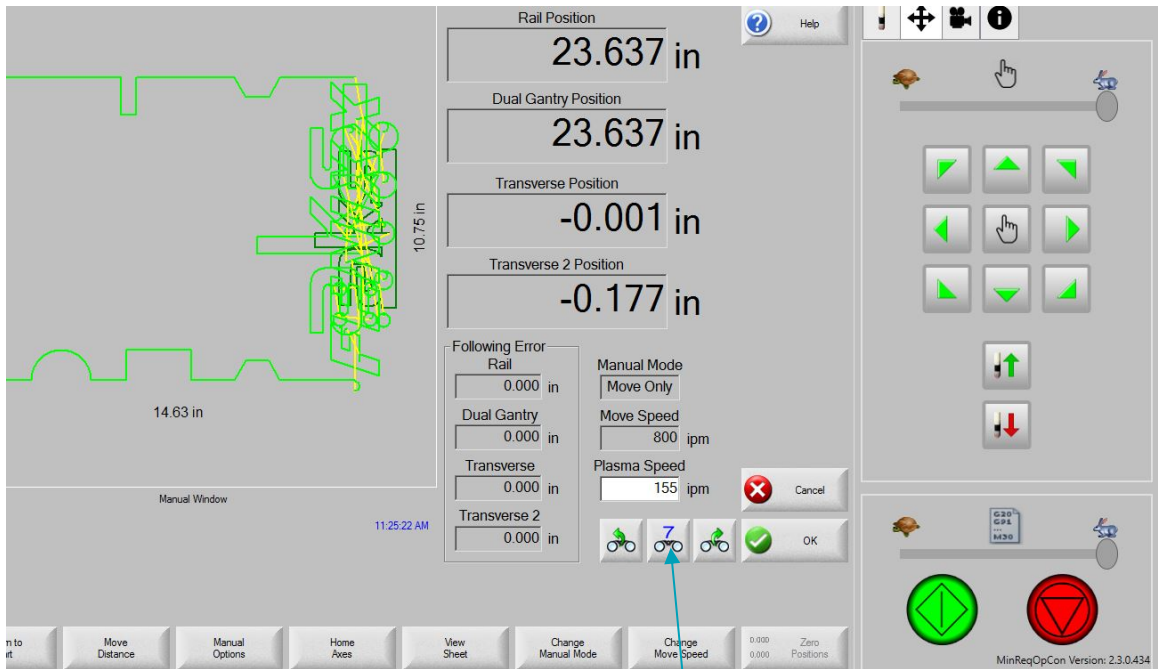
How to check to see if Bridge Tension is present

1. Home out the Rail axis
2. Once home is established walk over to one of the E-Stop buttons located on the side of the rail. See pic below.



3. Place your hand on the rail then press the E-Stop button with your other hand. Does the rail jump or move? The movement you see represents the tension the 2 motors are under to keep the rail straight. The goal is to have no jump or movement.
4. The tension can also be seen on the control screen via watch window 7 in the difference between the Rail position and Dual Gantry position located near the top of the screen. Once E-stop is engaged the numbers should remain under the .032 tolerance of the offset. For example, if the Rail position is 0.00 and the Dual gantry position is 0.012 the difference between the 2 is .012 and is within the tolerance therefore it's ok. but if the Rail position is 0.05 and the Dual gantry position is at 0.000 this will put more strain on the motors and could cause them to exceed their bus voltage allowance causing F501 Drive faults most commonly. See Screen Shot on the next page.

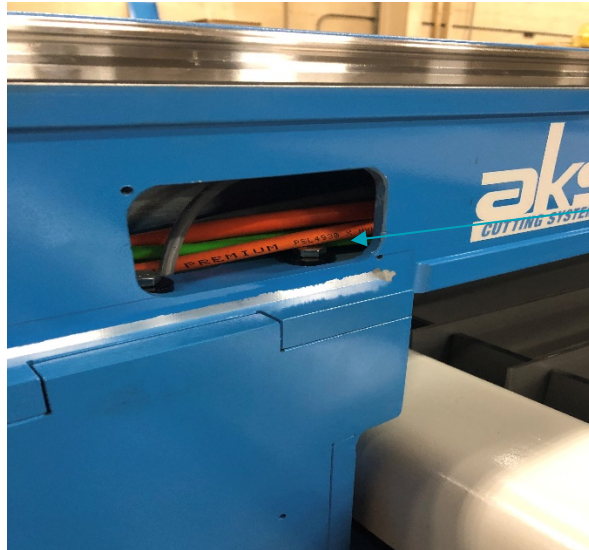
Rail and Dual Gantry position



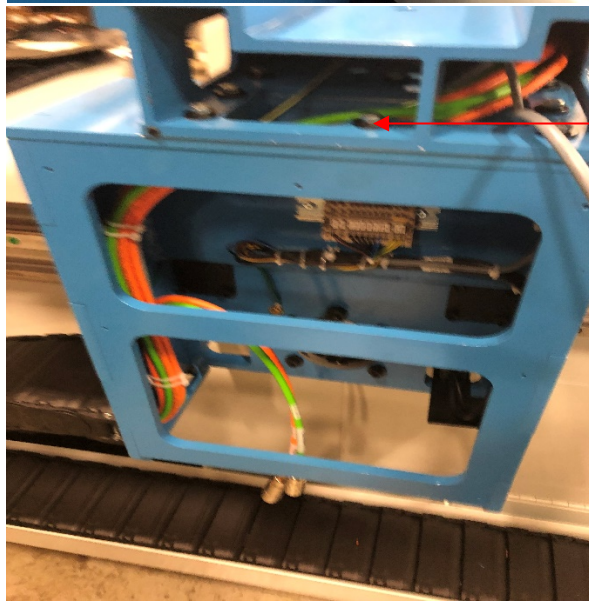
Watch Window 7

SQUARING THE MACHINE

1. Start by removing all the access panels on the rail, the E-Stop panels on either side of the rail, along with the side panels (larger covers that cover the motors) located just below each Rail E-stop. See pics on next page for reference

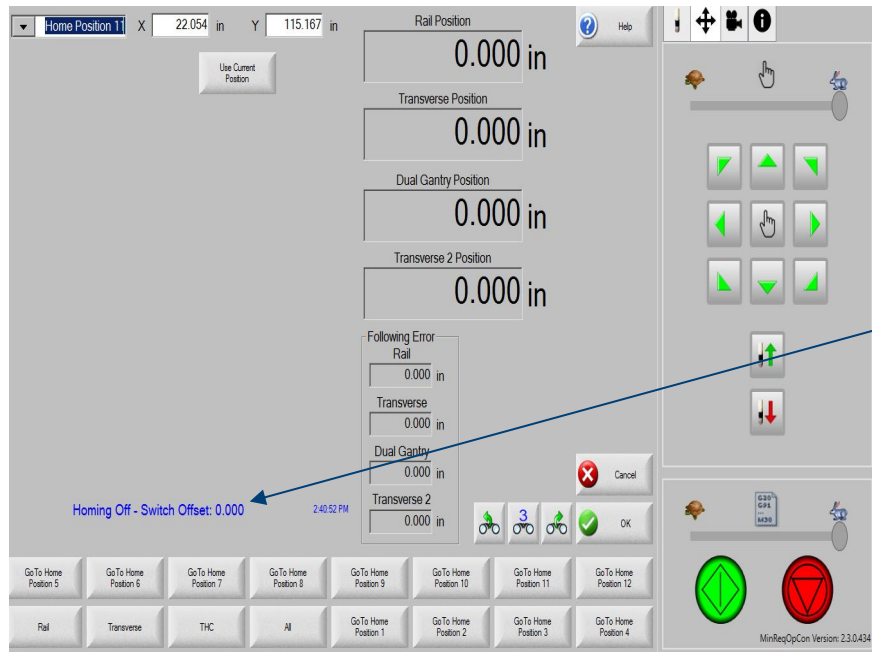


Access Panels (2 on each end of the bridge)



Bridge Bolts (bolt and nut are 13mm)

2. Once you've removed the panels loosen (not remove) all 16 bolts (8 per side) to free up the rail.
3. Now home the Rail axis continuously till your switch offset reads 0.00x
4. Keep the motors engaged. Then tighten up all the bolts, turn off all power to the control cabinet and home the machine one last time. Your switch offset should be 0.000 or very close to it.
5. Once your offset is verified then go ahead and re-install all access panels and covers. Once installed you can resume production.



6. If you have any other question or after completing this procedure your still having problems, please call us back for further instructions. Thank you