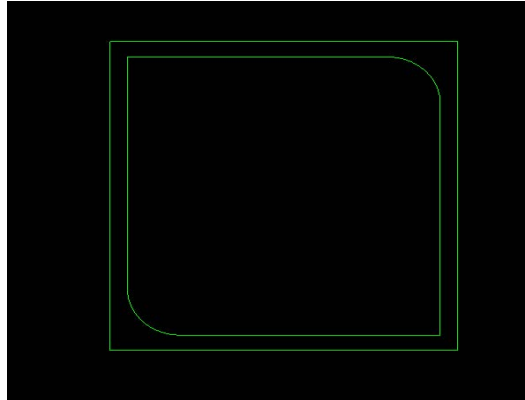




FINGERBIT ALIGNMENT PROCEDURE (2020 MACHINE INSTALLATIONS AND NEWER)

In Alphacam draw a 20x20 rectangle, then insert and offset of 1" as geometry inside your rectangle to simulate an internal cut sink cut-out with a 3" radius on 2 of the 4 corners. Measure the amount the finger-bit digs into the top, outside the blade kerf and correct the finger-bit accordingly (see attached DXF and image)

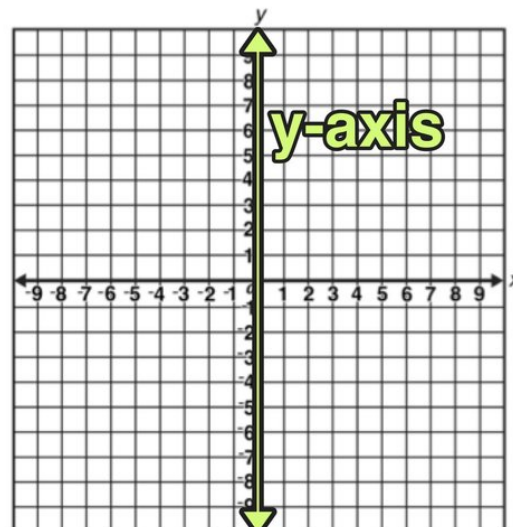
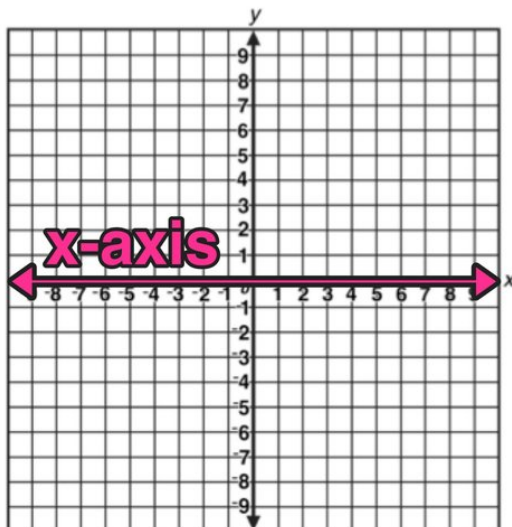


NOTE: The parameters are in Millimeters so YOU MUST CONVERT YOUR ERROR INTO MM.

NOTE: WE ARE BRINGING THE FINGERBIT TO THE BLADE. THIS PROCEDURE DOES NOT BRING THE BLADE TO THE FINGERBIT.

NOTE: To move the Fingerbit LEFT we need to adjust in the negative direction (subtract from the value) and vise versa.

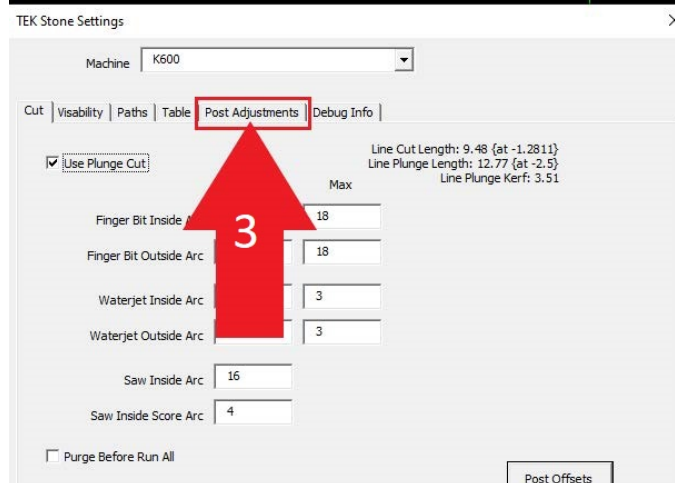
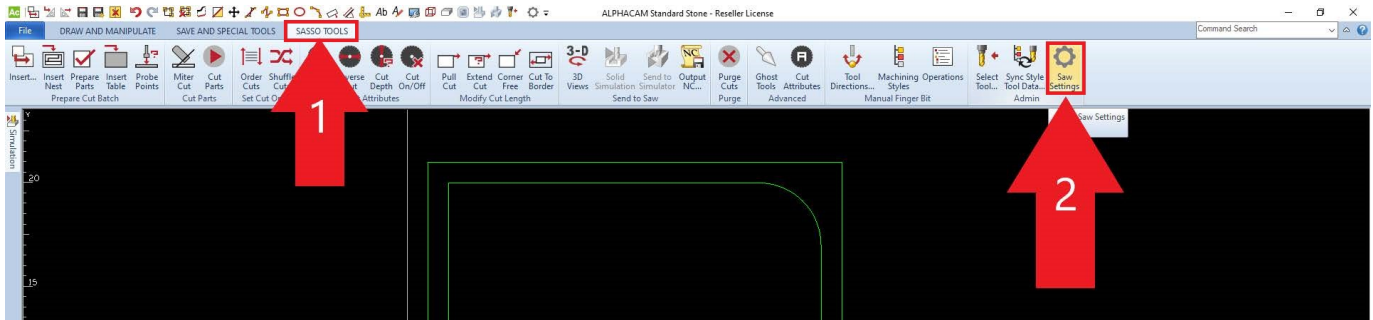
NOTE: To move the Fingerbit TOWARD THE REAR OF THE MACHINE we need to adjust in the POSITIVE Y direction (ADD TO THE VALUE) and vise versa.



To make an adjustment:

Go to **SASSO TOOLS>SAW SETTINGS>POST ADJUSTMENTS**

Then either add or subtract from the Fingerbit Y/X values then click update. See Example Below.



Example: (1) Needing to shift Fingerbit left (negative in X) 1/8th. We would take $1/8 = .125 \times 25.4 = -3.175\text{mm}$. So we would subtract from our X Fingerbit value found in our file by entering -3.175

(2) CLICK UPDATE. (3) CLICK OKAY AND RUN YOUR TEST TO VERIFY THE CHANGE.

