



# A AXIS TRAM DETAILED CORRECTION INSTRUCTIONS PC

Watch the measurement procedure video! Link: <https://youtu.be/8sb3dCDZ3Q8>

1. Using a magnetic dial indicator measure the tram (squareness of the axis)

Note: Position the head towards the bottom right corner of the table (as shown in the image). Set dial indicator at 0 on the bottom edge of the flange then using a Sharpie, mark the spot where your dial indicator is starting (be sure to only measure on a clean surface area of the flange or blade). Move the head downward in the Z axis until your indicator is touching the upper edge of the flange. Then rotate the flange/blade until your Sharpie mark lines up with your dial indicator. If the tram is not square in the A axis you will have a reading on the indicator (the tolerance of the axis is +/- .002). Write this number down. Note whether your error was negative or positive.



- Click the F19 POWER-STUDIO link (puzzle piece)

| Axis | Absolute | Relative |
|------|----------|----------|
| X    | 9.843    | 9.843    |
| Y    | 0.555    | 0.555    |
| Z    | 24.764   | 24.764   |
| C    | 0.0      |          |
| A    | 0.0      |          |

Machine parameters: Slab Thickness: 16, Max Speed: 100

- Enter the PASSWORD: 0541
- Click CONNECT in the center of the PowerStudio screen

PowerStudio ver.3.3.1

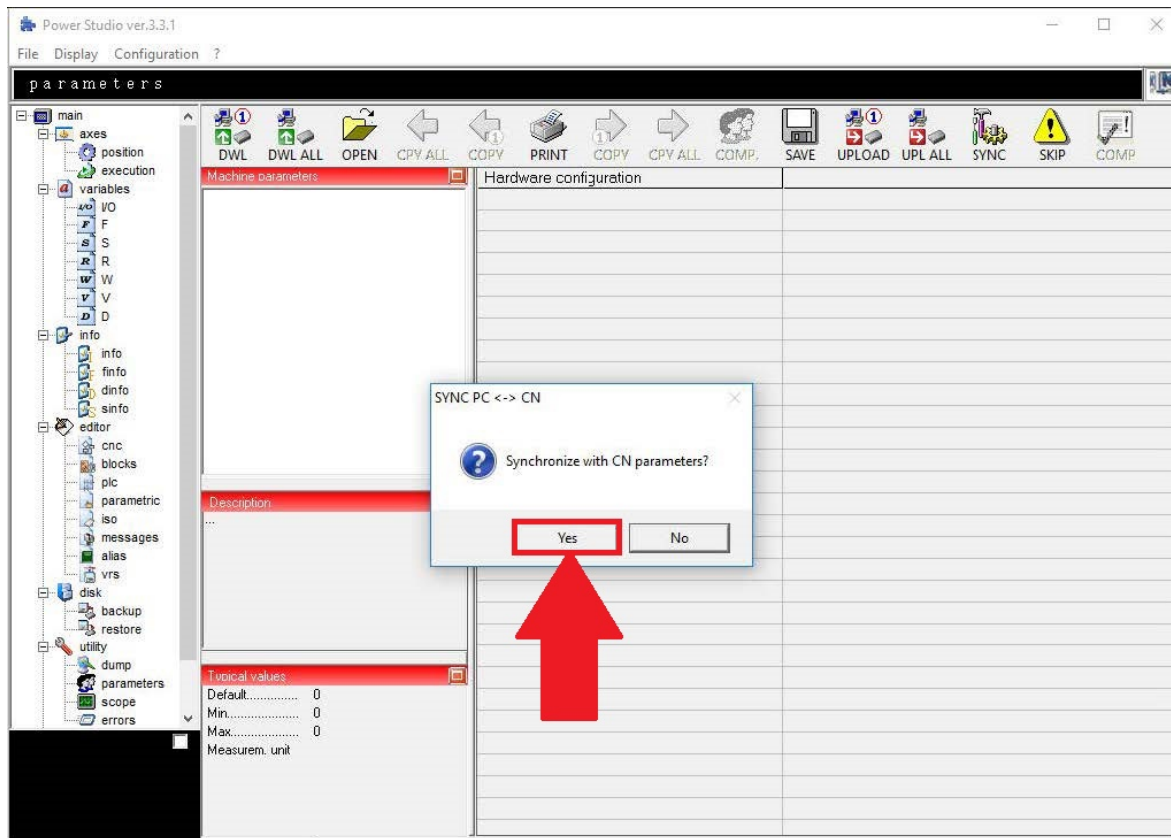
main

Parameters

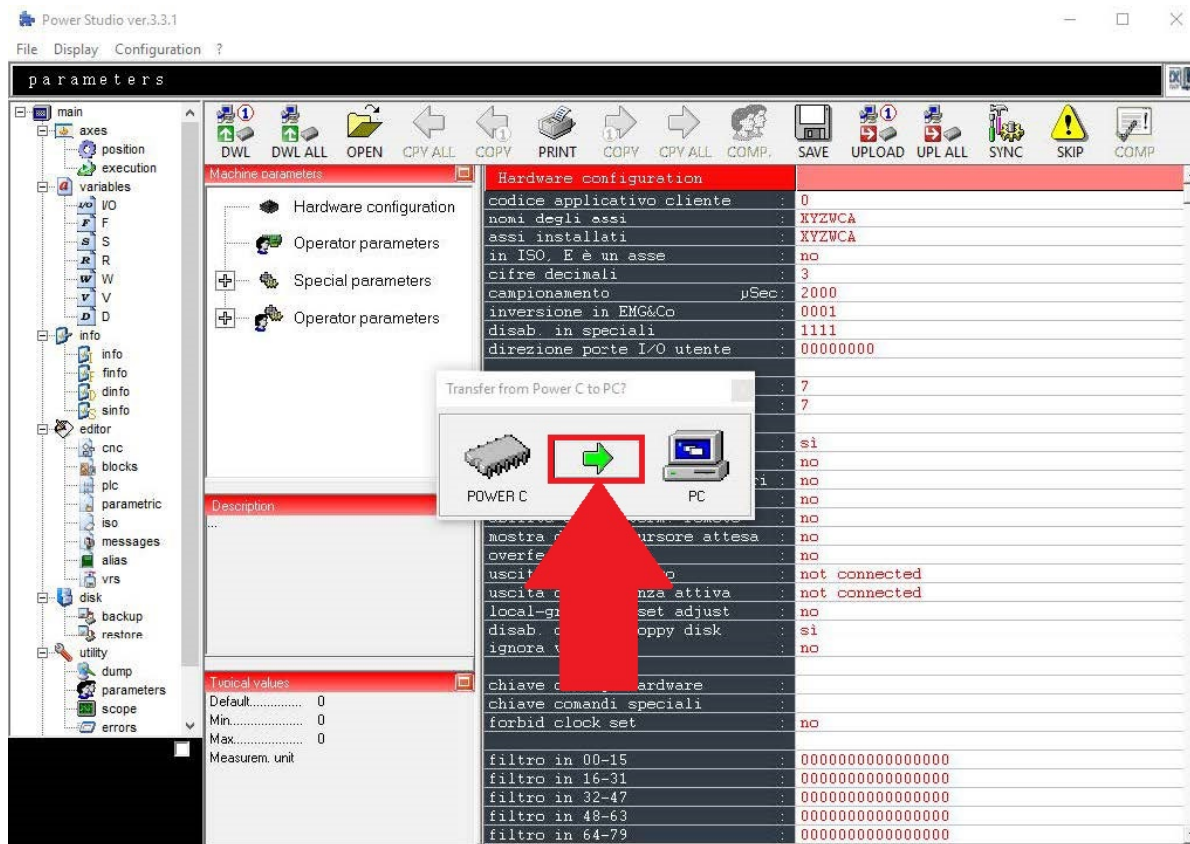
Connect

task 1 task 2 task 3 task 4

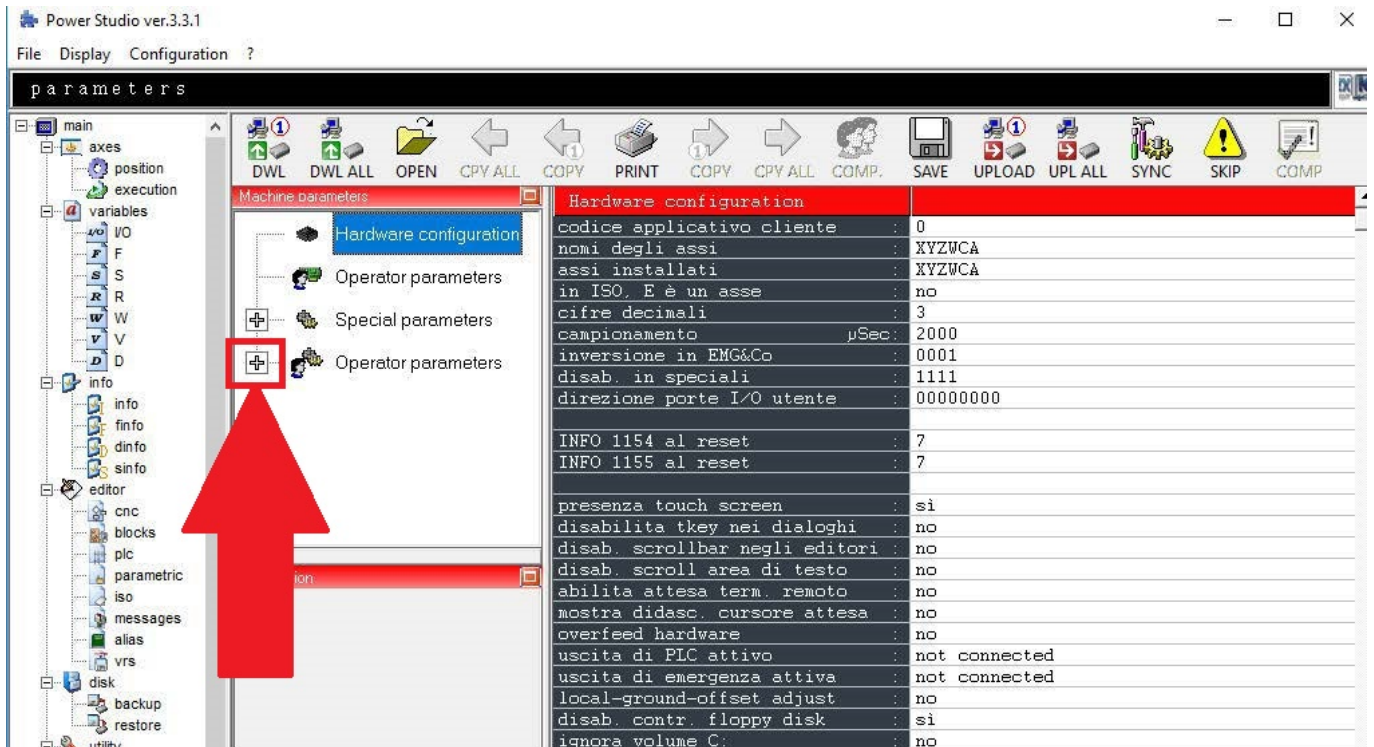
- Click Yes to Synchronize Parameters with PC



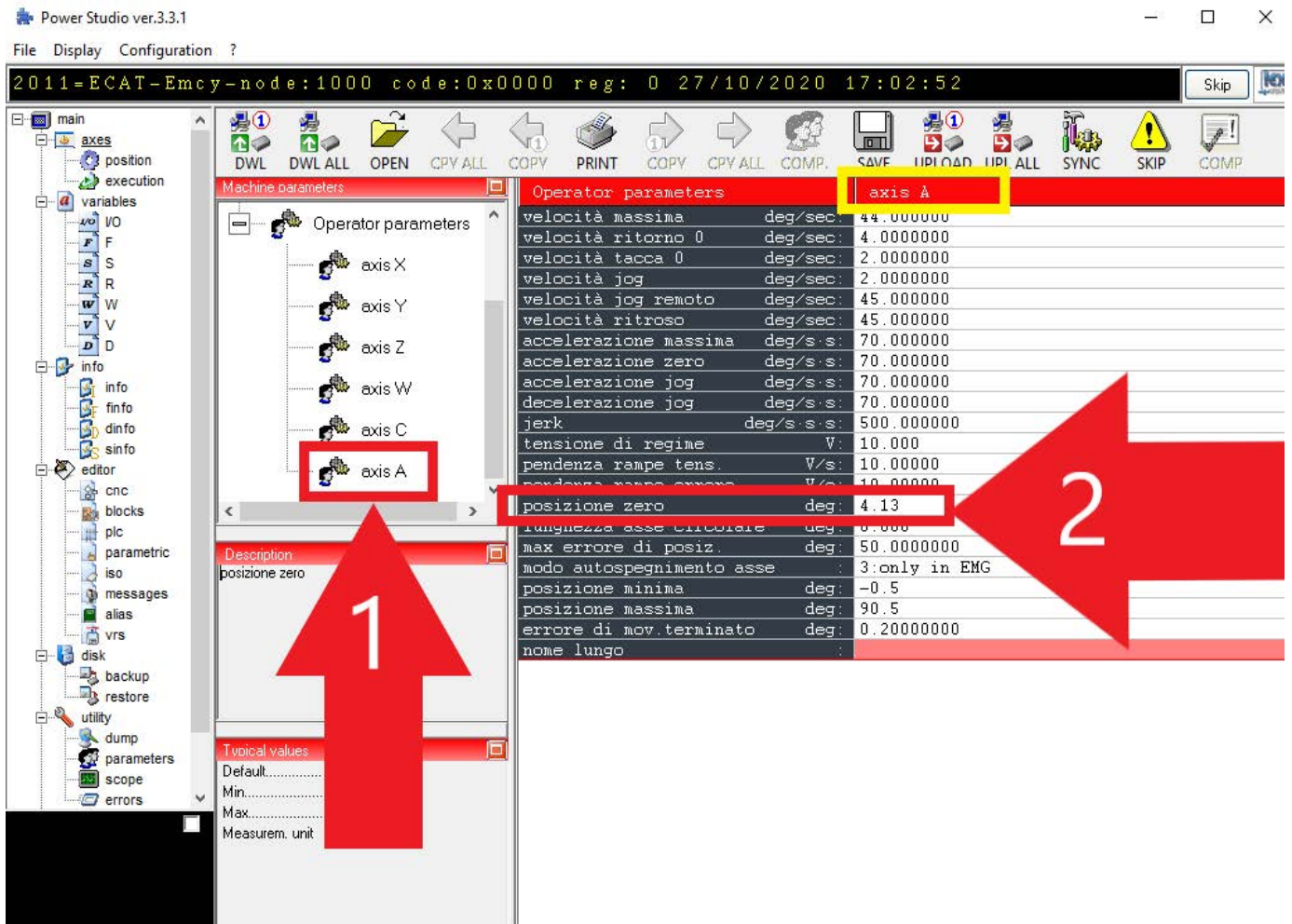
- Click the Green Arrow to Transfer from Power C to PC



- Click OPERATOR PARAMETERS



- Click on A axis (step 1)
- Find "ZERO POSITION" or "Posizione Zero" (step 2)



Note: If the error from STEP 1 is positive then the value must reduce.

Example:

➤ Original Zero position=4.13

Error measured = +.005

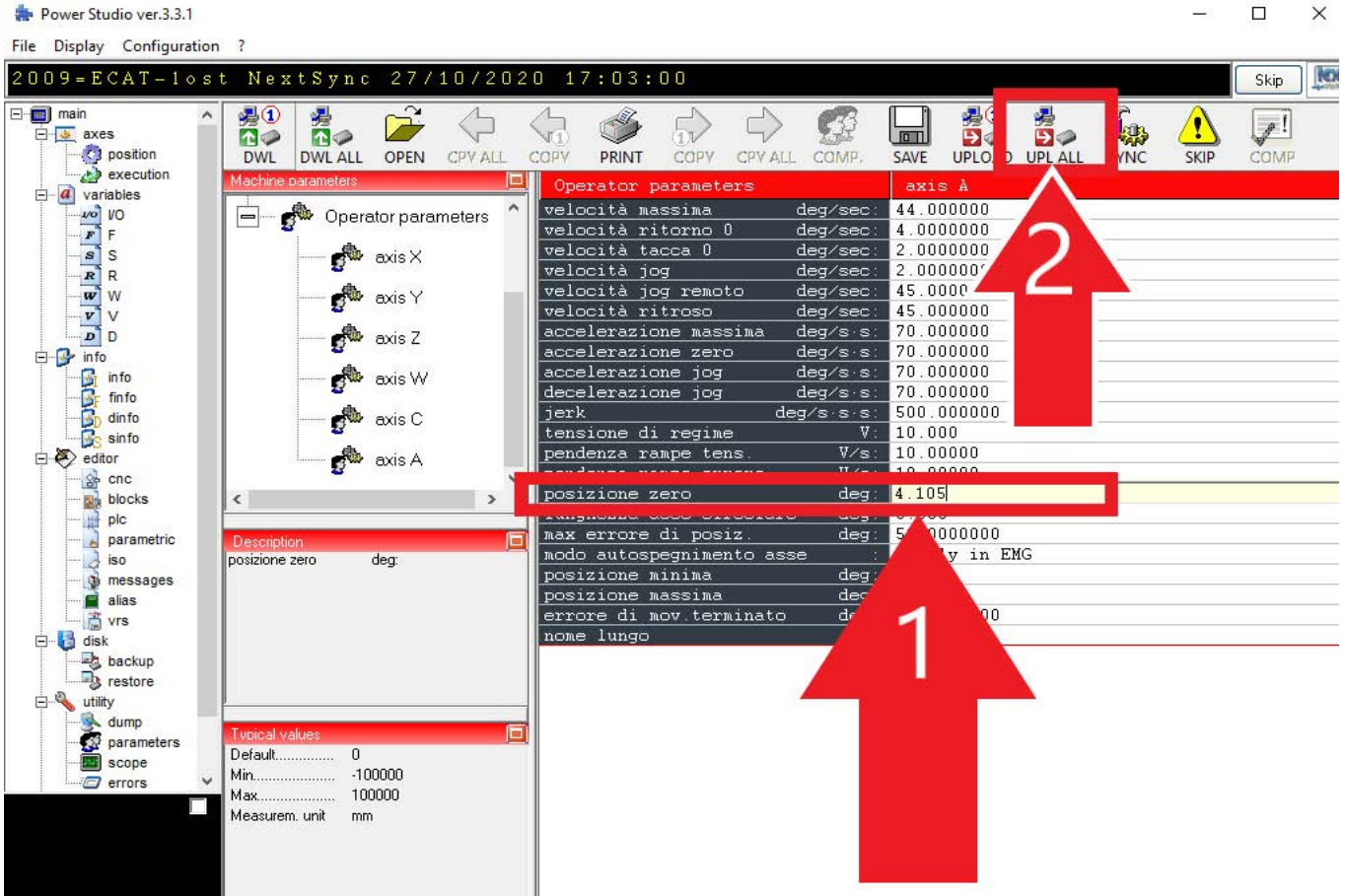
Take your error and multiply it by 5

$+.005 \times 5 = +.025$

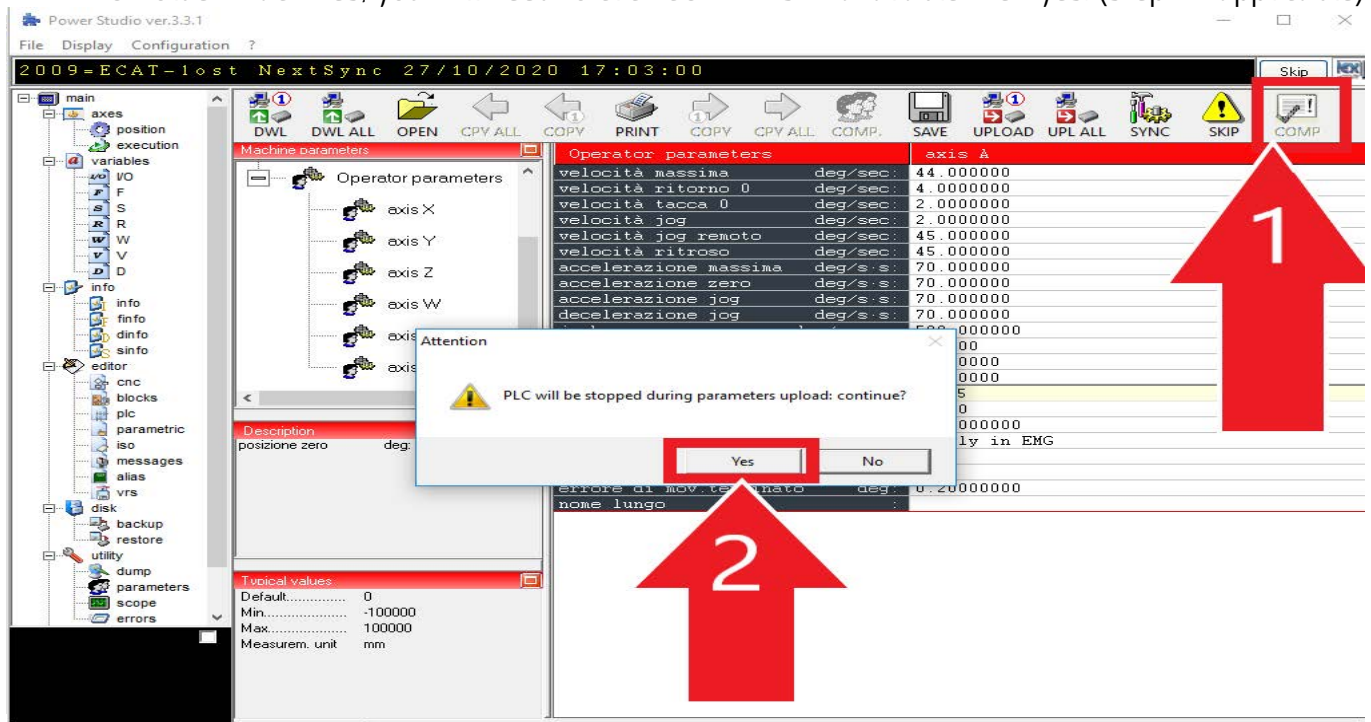
Original Zero Position =  $4.13 - .025 = 4.105$  New zero position = 4.105

Input your new ZERO POSITION value (step 1)

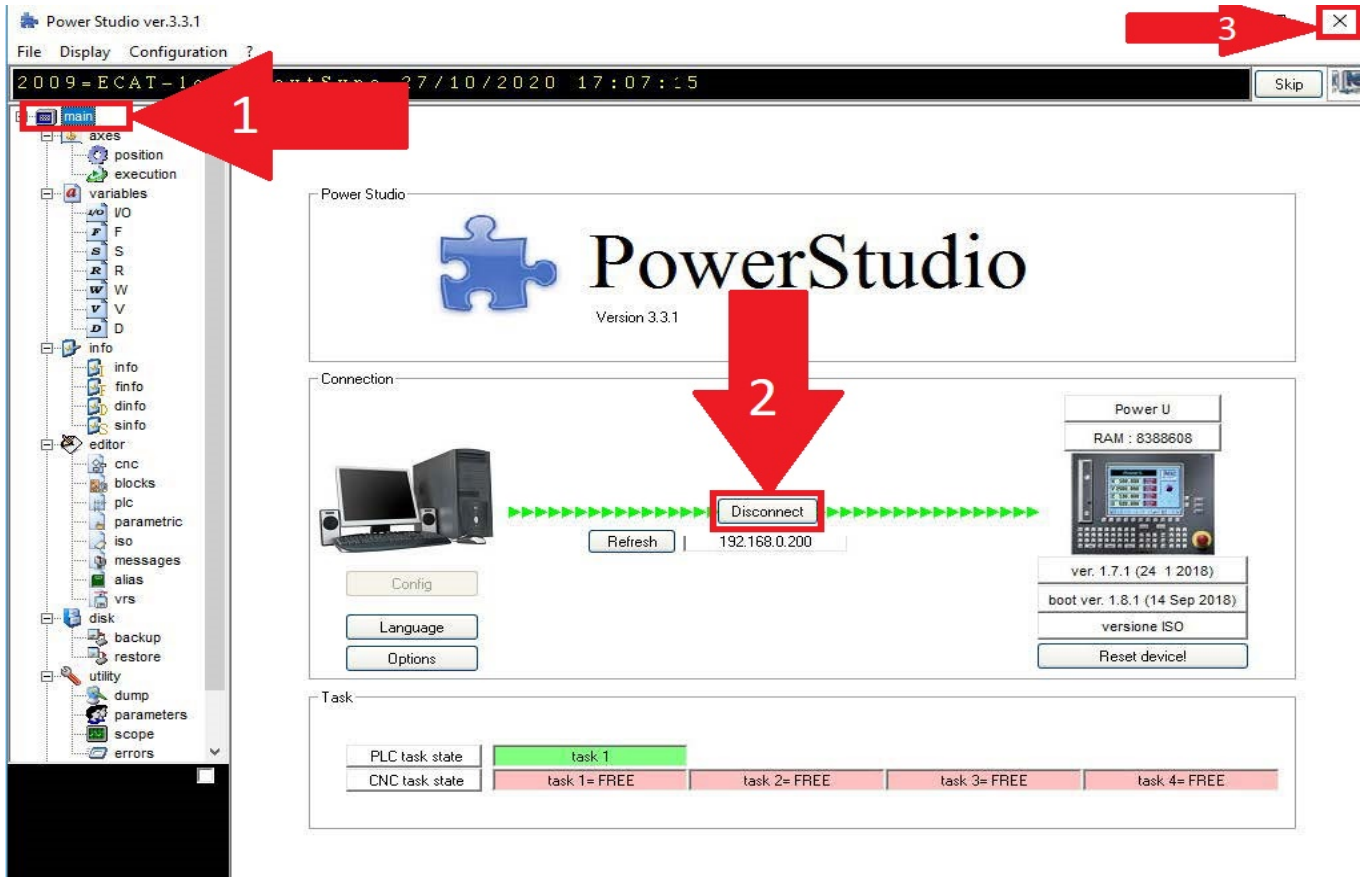
Click UPLOAD 1 or UPLOAD ALL (step 2)



- On newer machines, simply click yes (step 2)
- On older machines, you will need to click COMP first if available then yes. (step 1 if applicable)



- Click MAIN on the menu on the left hand side (step 1)
- Click DISCONNECT (step 2)
- Close the PowerStudio Window (step 3)



- Move the head away from the magnetic dial indicator
- Reset all axis (On the main screen click F1 and F1 again, then click YES to reset Axis)
- Re-measure the A Axis tram.
- Repeat process as needed