# K600 Alphacam Calibration Procedure

**Tram the flange(verify squareness the head).**
NOTE: Measure the squareness of the C and A axis using a Dial Indicator.

**C Axis Adjustment Procedure:**

https://sassousa.freshdesk.com/en/support/solutions/articles/67000331483-c-tram-detailed-correction-instructions-with-pictures

**A Axis Adjustment Procedure:**

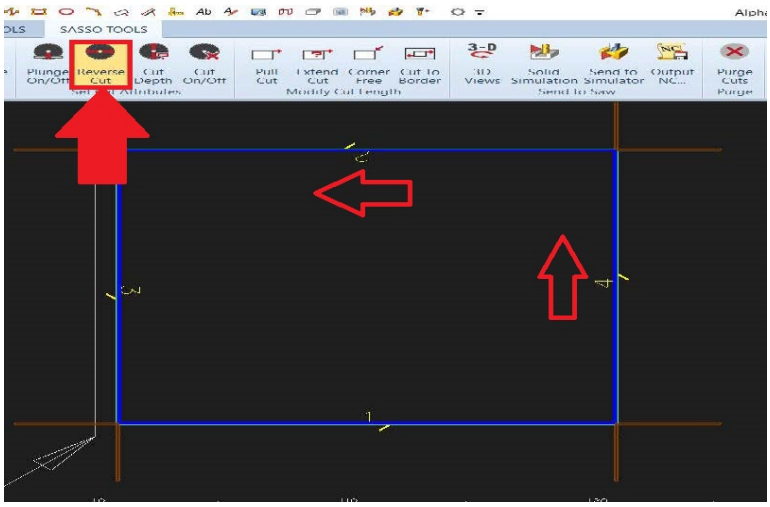
https://sassousa.freshdesk.com/en/support/solutions/articles/67000584975-a-tram-detailed-correction-instructions-with-pictures

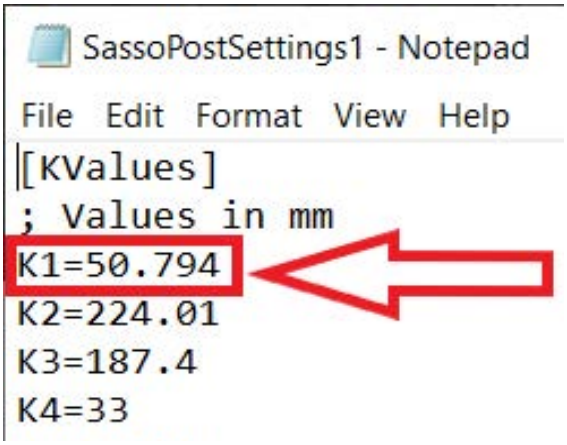
**Measure Blade Diameter with Tape Measure and BladeThickness with Calipers:** The most accurate way to measure the thickness is to measure what the blade is actually cutting. So using calipers measure the kerf of a blade cut.

**Verify Table Thickness:**

https://sassousa.freshdesk.com/en/support/solutions/articles/67000335404-how-to-set-table-thickness

**K1 (Straight cuts with Blade):**
Write a program in Alphacam with a **20x20 square with the motor on the inside for all 4 cuts (Reverse cut)**. Run the program and measure the cuts from inside to inside. Determine the difference/error and divide that number by 2 then convert to metric by multiplying your error by 25.4.
Add or subtract, to or from, the **K1** value in Alphacam after converting into metric. Retest, repeat. NOTE: To make the part bigger increase the K1 value and vice versa. NOTE:**C:\ALPHACAM\LICOMDAT\SPosts.Alp\SassoPostSettings1.ini**
Retest, Repeat.



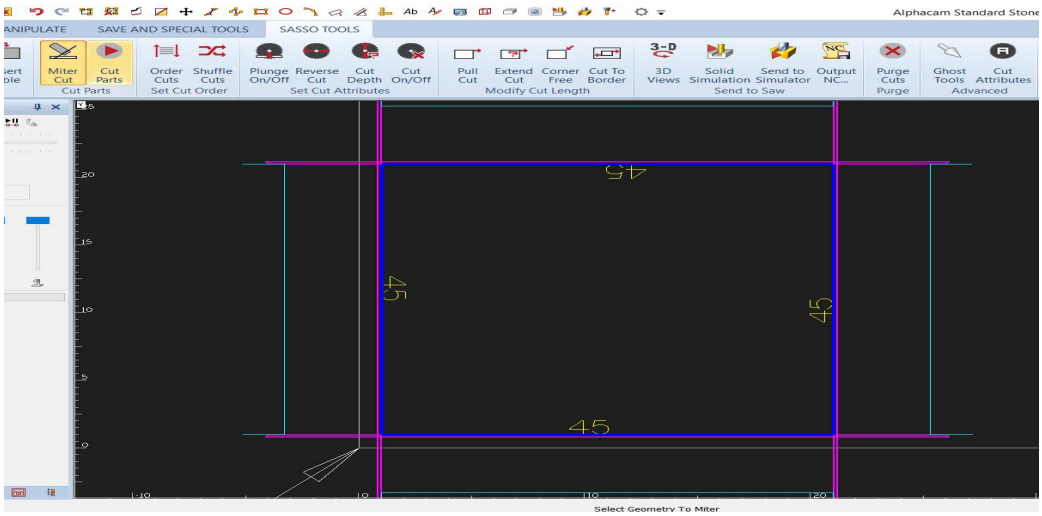



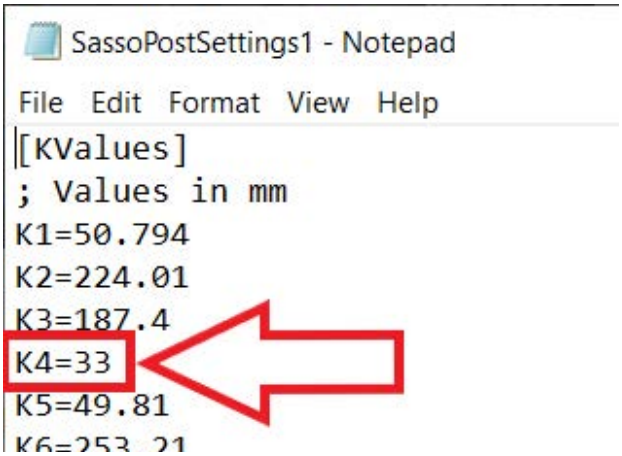

**K1 Example:** If we run our test and the part is 1/16th small we would find our error first by:
1/16th= .0625/2= .03125 x 25.4= 0.79375 Millimeters

So we would take our error 0.79375 and add to our K1 value of 50.794
50.794+0.79375= 51.58775
Update the value then save and close the Settings file. Run another test to verify adjustment.

## K4 (Miter cuts with Blade):

Write a program in Alphacam with a mitered **20x20 square (MITERED ON ALL FOUR SIDES) see example.**
NOTE: SET SLAB THICKNESS ON THE SAW by measuring the slab with calipers or using the Material Thickness Probe.
Run the program and measure the cuts from inside to inside.
NOTE: Determine the difference/error and divide that number by 2 (convert to metric by multiplying error by 25.4).
Either add or subtract, to or from, the **K4** value. Retest, repeat.
NOTE: To make the part bigger increase the K4 value and vice versa.
NOTE: **C:\ALPHACAM\LICOMDAT\SPosts.Alp\SassoPostSettings1.ini**
**Retest, Repeat.**




**K4 Example:** If we run our test and the part is 1/8th small we would find our error first by: 1/8th= .125/2= .0625x 25.4= 1.5875 Millimeters

So we would take our error of 1.5875 Millimeters and add to our K4 value of 33 33 +1.5875= 34.5875
Update the value then save and close the Settings file. Run another test to verify adjustment.

## VERIFY FINGERBIT (INCREMENTAL CUTTER) DIAMETER WITH CALIPERS:

Either measure cuts previously made or our standard is .80". Click Select Tool>Right Click on your FINGERBIT and click Edit Tool to see your current diameter. Adjust as needed.

## FOLLOW THE LINK BELOW TO THE PROCEDURE TO RUN A FINGERBIT TEST:

https://sassousa.freshdesk.com/en/support/solutions/articles/67000676801-fingerbit-alignment-procedure-2020-machine-installations-and-newer-

NOTE: After your test, measure how far and which direction the FINGERBIT (INCREMENTAL CUTTER) needs to move to line up with the blade.
Go back into Alphacam and click on Sasso Tools>Saw Settings>Post Adjustments and you can then add or subtract from the values to shift the waterjet in Millimeters Make sure you click Update after making your adjustment.
Then Purge your cuts and run another FINGERBIT alignment test to verify your adjustments.