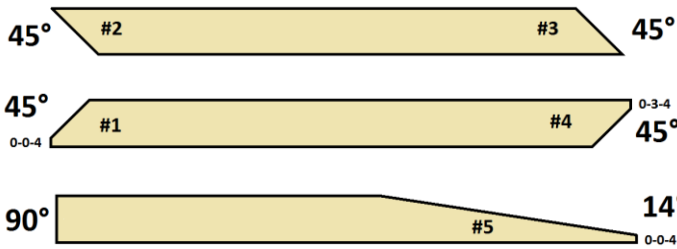


AutoMill SC Calibration Cheat Sheet

Step 1 - Angles



C.C.W	Left	C.W.	Right
1/16 = Move to 89.88		1/16 = Move to 90.12	
1/8 = Move to 89.75		1/8 = Move to 90.25	
3/16 = Move to 89.63		3/16 = Move to 90.38	
1/4 = Move to 89.50		1/4 = Move to 90.50	
5/16 = Move to 89.38		5/16 = Move to 90.62	
3/8 = Move to 89.25		3/8 = Move to 90.75	
7/16 = Move to 89.12		7/16 = Move to 90.88	
1/2 = Move to 89.00		1/2 = Move to 91.00	

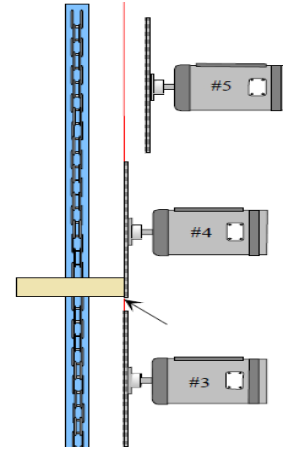
Step 2 - Left / Right Head #4

Cut a 90/90 & run a board up to blade #4 slowly.

Turn on Security Bypass!! Select head #4 Lt/Rt.

Set Joq Speed to .02!!

Move head #4 out slowly until it touches the board.



Step 3 - Left / Right Head #5

Select head #5 Angle, and (Move to) 90°

Run the board up to blade #5 slowly

Select head #5 Lt/Rt. Set Joq Speed to .02!!

Move head #5 out slowly until it touches the board.

Step 4 - Left / Right Head #2

Cut a 90/90

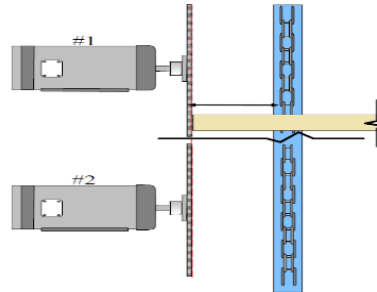
Run a board up to blade #1

Measure the gap between

blade #1 & the board.

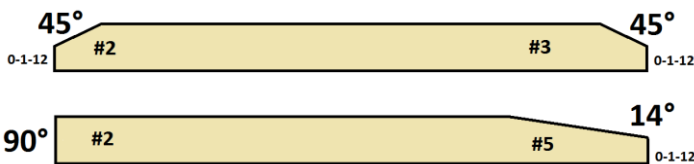
Select head #2 Lt./Rt.

(Move To) & Calibrate



1/16 = Move to -.18
1/8 = Move to -.12
3/16 = Move to -.06
1/4 = Perfect
5/16 = Move to .06
3/8 = Move to .12
7/16 = Move to .18
1/2 = Move to .25

Step 5 - Height (Centerline)



1/16 High = Move to 1.69
1/8 High = Move to 1.63
3/16 High = Move to 1.57
1/4 High = Move to 1.50
1/16 Low = Move to 1.81
1/8 Low = Move to 1.87
3/16 Low = Move to 1.93
1/4 Low = Move to 2.00

Step 6 - Length

If you are short, add to 48"

If you are long, subtract from 48"

Short	Long
1/16 Short = Move to 48.06	1/16 Long = Move to 47.94
1/8 Short = Move to 48.12	1/8 Long = Move to 47.88
3/16 Short = Move to 48.18	3/16 Long = Move to 47.82
1/4 Short = Move to 48.25	1/4 Long = Move to 47.75
5/16 Short = Move to 48.31	5/16 Long = Move to 47.69
3/8 Short = Move to 48.38	3/8 Long = Move to 47.62
7/16 Short = Move to 48.44	7/16 Long = Move to 47.56
1/2 Short = Move to 48.50	1/2 Long = Move to 47.50