

**The Standard
Frame**

Measurements of table position are made with a depth micrometer, through cut-outs made in the solid base of the test frame. A depth of 25mm from the upper surface of the base corresponds to the lower surface of a standard stencil.

Switch settings are made at each appropriate reading of the depth micrometer as the table is lowered.

PROCEDURE

Calibration procedure of the lift transducer and setting of the associated limit switches used for error detection follows:

Mechanical Stop

The cross-shaft of the 4-bar link assembly is fitted with an adjustable mechanical stop. The presence of the stop affixed to the structure ensures that table casting cannot descend so as to clash with the structure.

Set the Mechanical stop using the procedure following:

- 1) Locate RV3 potentiometer on the Processor Board in the Service Tray. Set the potentiometer, RV3 (Table Height Display Adjustment) fully anti-clockwise. Ensure that the RS table is under the printhead and on the Table - in Sensor.
- 2) Drive the table down until there is a gap of 2mm above the chassis. Ensure the mechanical down stop is clear.
- 3) Adjust the transducer striker plate manually to obtain a display reading of 254-255.
- 4) Set the Table Down switch on the actuator to just On (Diagnostics display input page).
- 5) Insert a reference test plate into the screen chase assembly, this plate should be designed to allow a depth micrometer to gauge the depth from the zero reference point at the top of the reference plate surface to the full depth of the tooling plate travel.
- 6) Drive the table up until the depth gauge reads 43mm. This corresponds to the depth of (19.5mm) tooling on the tooling plate plus the depth of a standard screen of 23.5mm.
- 7) Manually adjust the transducer striker plate so that the display reads zero (flickering 1).
- 8) Set the Table Up switch to indicate just Off, on the display.
- 9) Drive the table down until the depth micrometer reads 68.5mm.
- 10) Adjust the potentiometer RV3 to give a display of 255 (flickering 254).
- 11) Drive the table down to display a reading of 70mm on the depth Micrometer.
- 12) Adjust the Table Down switch to display just On, on the Display Input Page.
- 13) Make adjustment to the Down Stop on the link shaft until it just abuts the striker plate, secure the adjustable down stop.