

HORNET II: MAINTENANCE

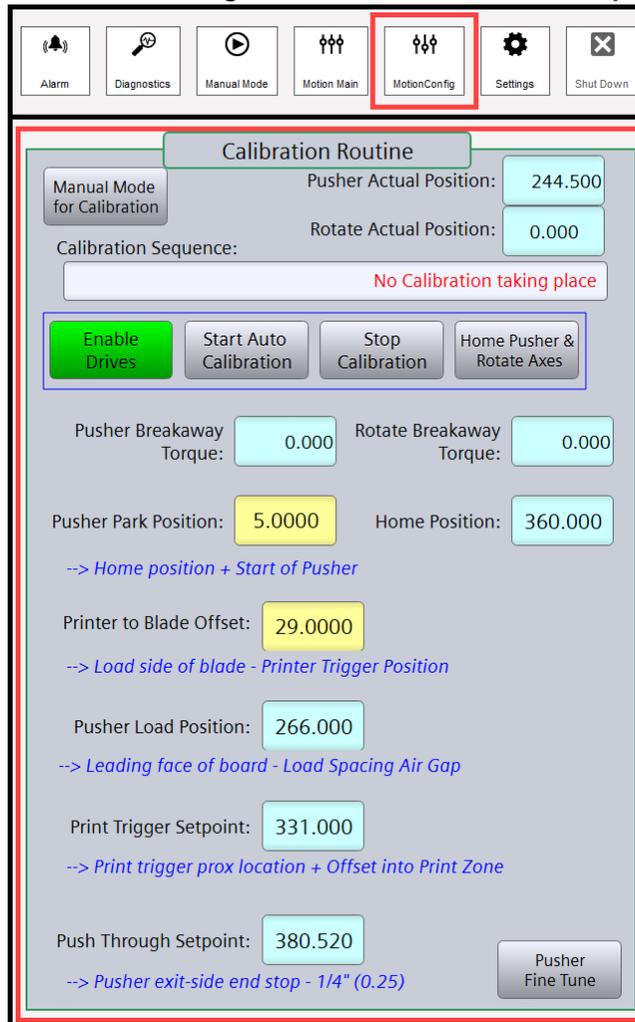
Calibrating

Calibration may be necessary in the following scenarios:

- After significant maintenance, such as replacing a mechanical part
- A saw blade replacement or if the saw blade has been removed from the machine
- If the saw is consistently making inaccurate cuts

The calibration options are available in the *Motion Config* menu in the *CutBuilder* software.

Figure 7-5: MotionConfig Menu and the Calibration Sequence Area



An automatic calibration will calibrate all of the major systems of the saw. To perform an automatic calibration, use the following procedure:

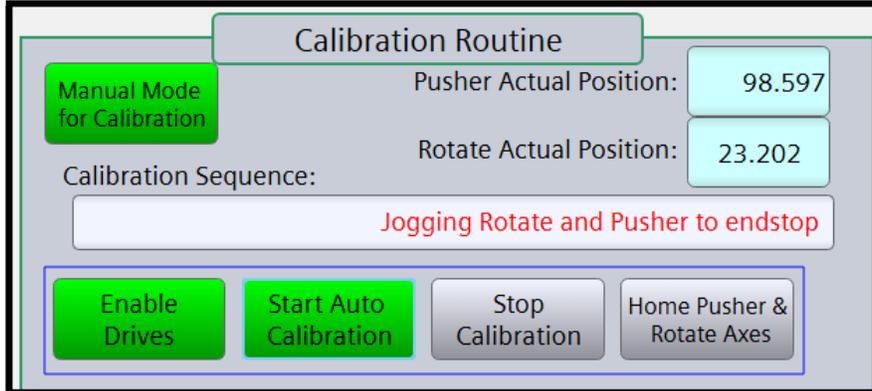
1. Open the MotionConfig menu by selecting the button on the menu bar. See [Figure 7-5](#).
2. Enable drives if necessary.

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- The Enable Drives button is green when the drives are enabled, and grey when they are not. If the button is grey, select it to enable drives
3. Select **Manual Mode** for Calibration. The button will turn green to indicate that the saw is now in manual mode.
 - See [Figure 7-6](#) for an example of an automatic calibration in progress with drives and manual mode enabled.
 4. Select **Start Auto Calibration** to start the automatic calibration process.

	 WARNING
	<p>Ensure all personnel are clear of the Restricted Zone before starting calibration.</p> <p>Motion will start automatically when Start Auto Calibration is selected.</p>

Figure 7-6: Calibration In Progress



Calibration Routine

Manual Mode for Calibration

Pusher Actual Position: 98.597

Rotate Actual Position: 23.202

Calibration Sequence:

Jogging Rotate and Pusher to endstop

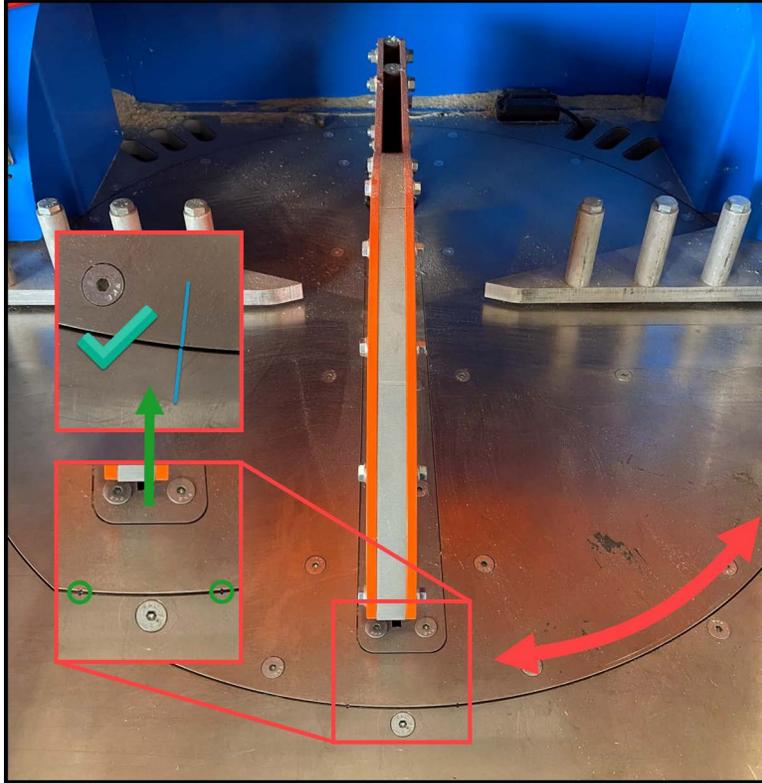
Enable Drives Start Auto Calibration Stop Calibration Home Pusher & Rotate Axes

As the calibration progresses, the Calibration Sequence area on the Calibration Routine screen will indicate which part of calibration the machine is currently performing. Watch for the following message, then proceed to the next step:

- Jogging Rotate and Pusher to endstop
5. While the saw rotation table is moving, observe its motion through the saw hood window to see if it lines up with the witness marks on the saw table as seen in [Figure 7-7](#).
 - If the witness marks on the saw rotation table and saw table are not aligned, select the **Enable Drives** button in the MotionConfig menu (see [Figure 7-8](#)) to disable the drives.

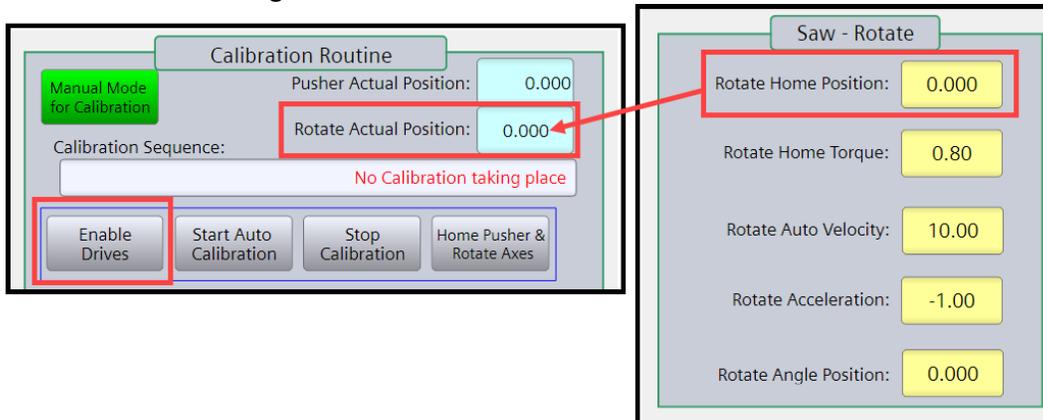
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Figure 7-7: Saw Rotation Table and Saw Table Witness Marks



6. With the drives disabled, open the saw hood and move the saw rotation table by hand until the witness marks are aligned as seen in [Figure 7-7](#).
7. Note the value in the “Rotate Actual Position” field and input this value into the “Rotate Home Position” field as seen in [Figure 7-8](#).

Figure 7-8: Enable Drives and Rotate Position



8. Enable the drives by selecting the **Enable Drives** button (see [Figure 7-8](#)) and re-start the calibration using the **Start Auto Calibration** button.
9. “No calibration taking place” will display in the Calibration Sequence area and the Start Auto Calibration button will no longer be green when calibration is complete.