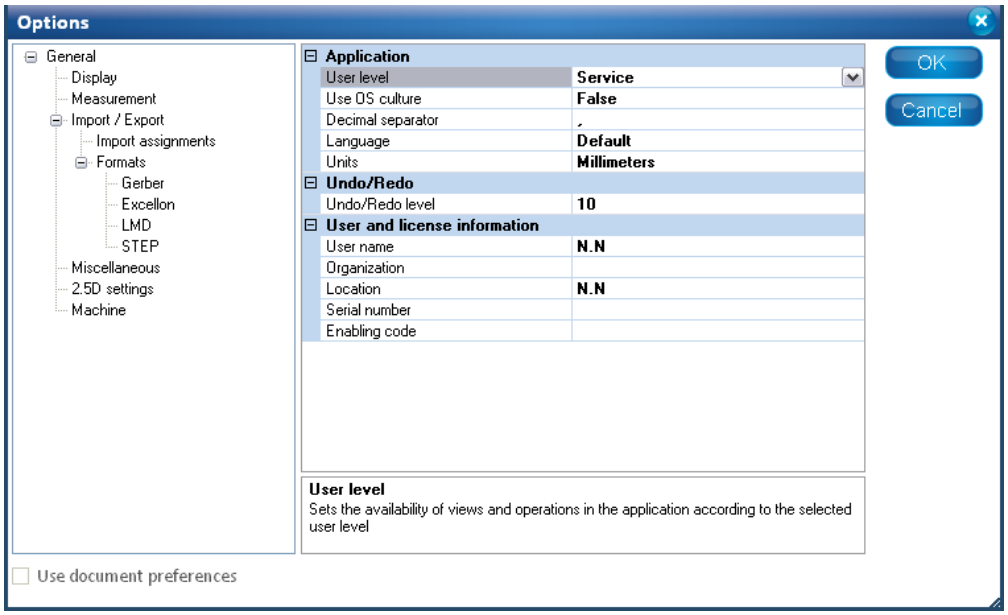
How to adjust the collet at the S63/S103

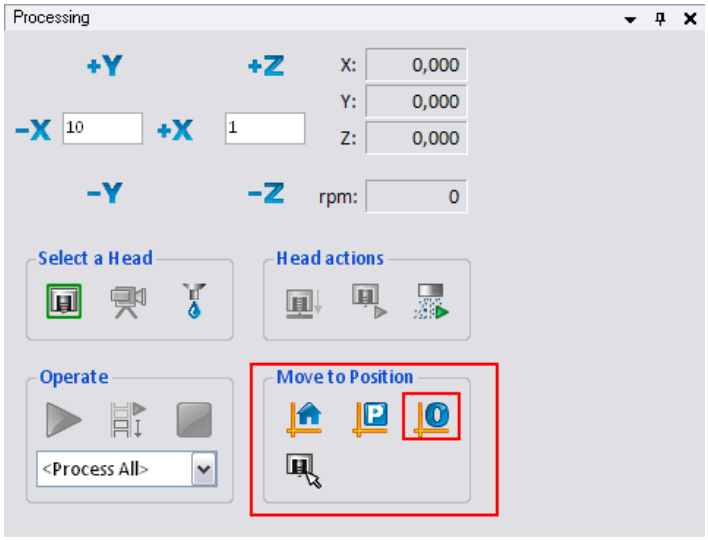
This is a procedure, how you can adjust the open close tolerance of the tool clamp.

1. Open Circuit Pro and go to "Extras" and then "Options".

2. In this Window, change the user level to "Service". Your need the password: LPKF

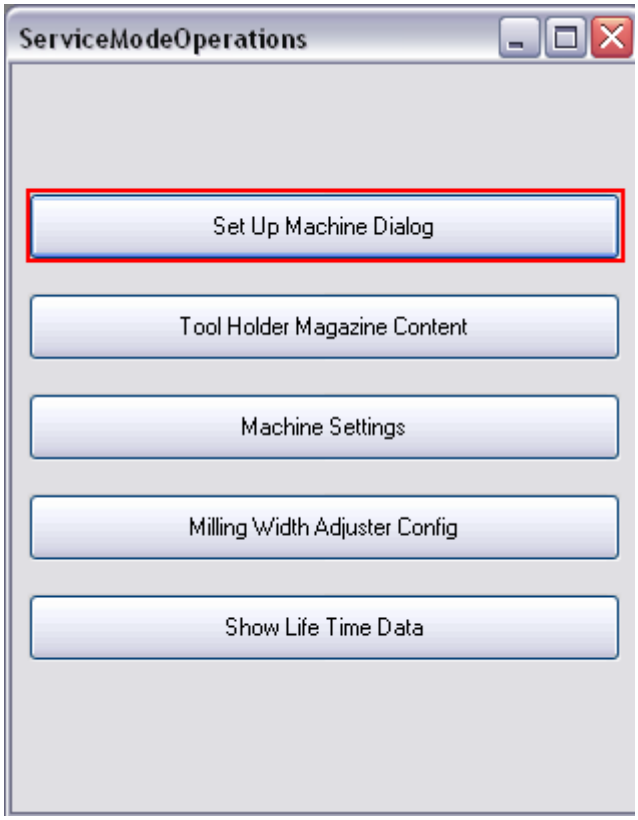


3. Go to the machining view and move the head to the zero position.

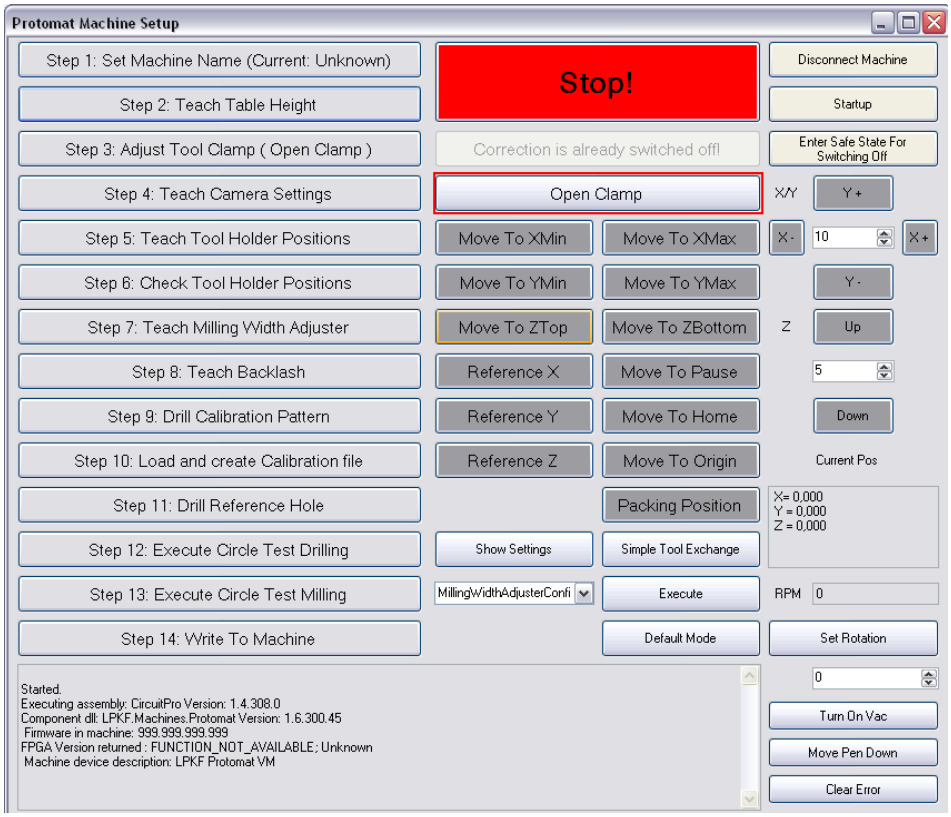


4. Now go to "Machining" and then "Service".

5. In this window you to click on "Set Up Machine Dialog".



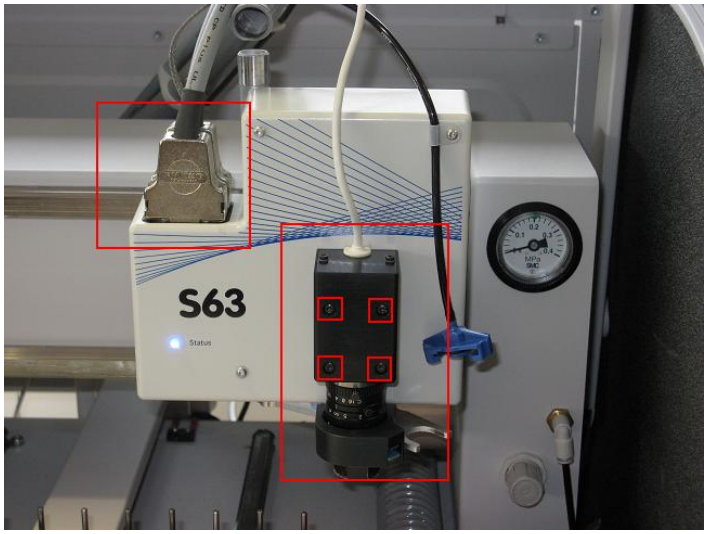
6. In the next window you are able to open/close the spindle. Be sure that there is no tool in the clamp. The red marked button is for open and closing the clamp.



7. Make sure that there is no tool mounted in the tool clamp, if nothing is mounted, please close the clamp.

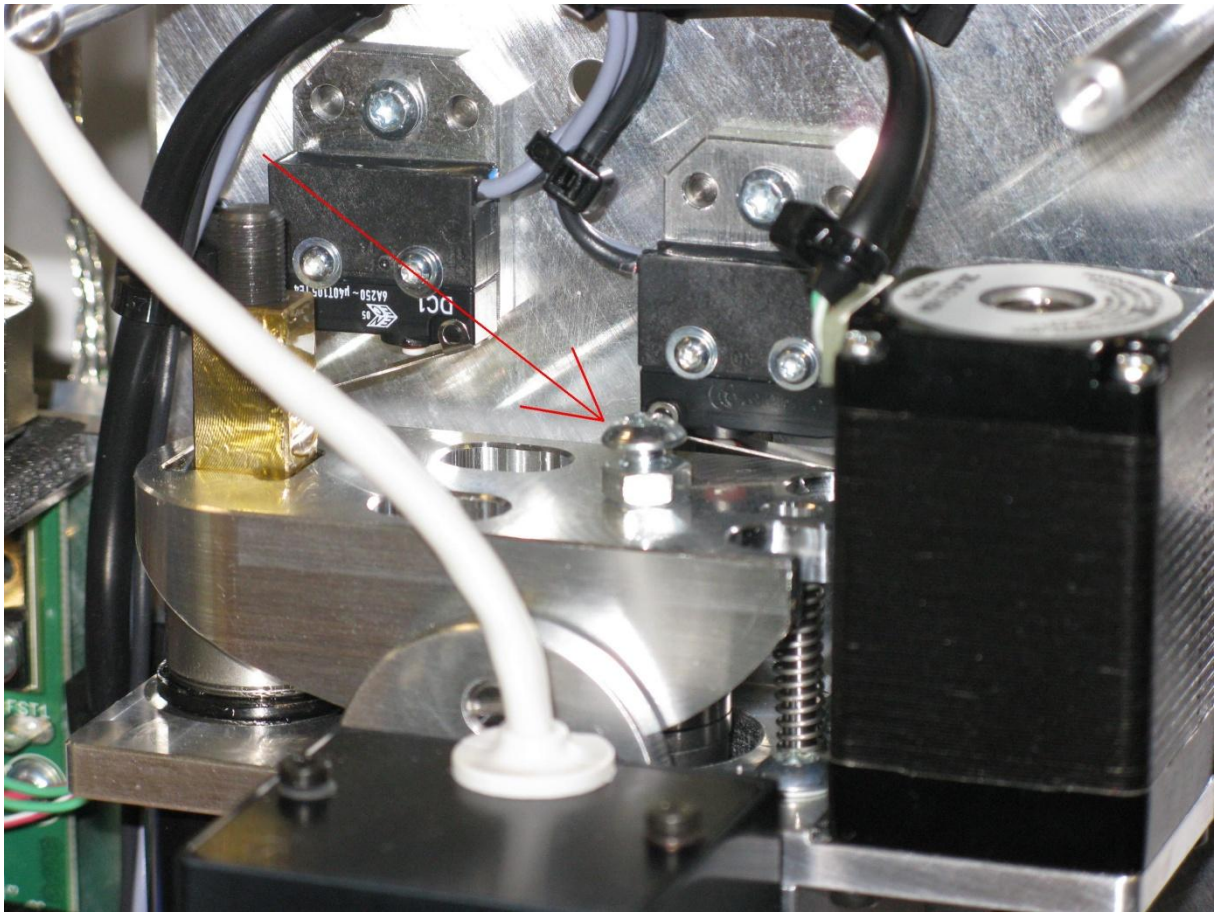
8. Switch off the machine.

9. Now open the cover of the machine and dismount the connectors and the camera, marked red in the picture below.



10. You have free view on the mechanic parts. See the picture below.

11. There you can find a screw on top, that is fixed by a locknut. See the picture below.



Now you have to keep fix the counter nut with a open-end wrench and screwing the screw ¼ round to the right to get stronger clamp closing. (If you need to get more open the clamp, you have to scre right). **Attention:** If you have to loose a little bit the counter nut, don't forget to fix it!

12. Now please test the measurement of the drill/mill tools. If the alignment is not perfect, please make it again. To test, you need only to pick up a tool.

13. If it's done, please go back to advanced user and mount the housing the head unit.

14. Please set a new camera/head offset.

15. Close Circuit Pro, to save all the files to the machine log file.