

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

Options				- ×
😑 General	Ξ	Application		Сок
Display		User level	Service 💌	OIX
Measurement		Use OS culture	False	
🖨 Import / Export		Decimal separator		Cancel
 Import assignments 		Language	Default	
- Formats		Units	Millimeters	
Gerber	Ξ	Undo/Redo		
Excellon		Undo/Redo level	10	
LMD	Ξ	User and license information		
STEP		User name	N.N	
Miscellaneous		Organization		
- 2.5D settings		Location	N.N	
Machine		Serial number		
		Enabling code		
		ser level ets the availability of views and operation	ns in the application according to the selected	
Use document preferences		ser level		

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

Processing			•	φ×	¢
+Y	+Z X: 0,000				
	Y: 0,000				
-X 10 +X	1 Z: 0,000				
-Y	- Z rpm: 0				
-Select a Head	- Head actions				
I 🕂 🥇					
~ Operate	- Move to Position	1			
<process all=""></process>	I.				
		1			

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.

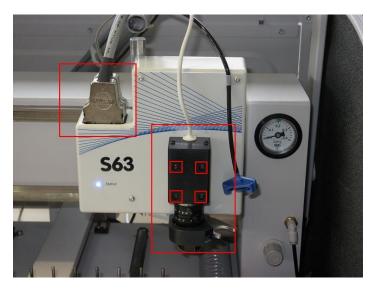
rotomat Machine Setup				
Step 1: Set Machine Name (Current: Unknown)	Disconnect Machine			
Step 2: Teach Table Height		Stop!		
Step 3: Adjust Tool Clamp (Open Clamp)	Correction is alre	Correction is already switched off!		
Step 4: Teach Camera Settings	Open (Open Clamp		
Step 5: Teach Tool Holder Positions	Move To XMin	Move To XMax	X- 10 🕞 X+	
Step 6: Check Tool Holder Positions	Move To YMin	Move To YMax	Υ.	
Step 7: Teach Milling Width Adjuster	Move To ZTop	Move To ZBottom	Z Up	
Step 8: Teach Backlash	Reference X	Move To Pause	5	
Step 9: Drill Calibration Pattern	Reference Y	Move To Home	Down	
Step 10: Load and create Calibration file	Reference Z	Move To Origin	Current Pos	
Step 11: Drill Reference Hole		Packing Position	X= 0,000 Y = 0,000 Z = 0,000	
Step 12: Execute Circle Test Drilling	Show Settings	Simple Tool Exchange	2 = 0,000	
Step 13: Execute Circle Test Milling	MillingWidthAdjusterConfi 💌	Execute	RPM 0	
Step 14: Write To Machine		Default Mode	Set Rotation	
Started.		<u>^</u>	0	
xecuting assembly: CircuitPro Version: 1.4,308.0 Component dll: LPKF. Machines: Protomat Version: 1.6,300.45	Turn On Vac			
Firmware in machine: 999.999.999.999 'PGA Version returned : FUNCTION_NOT_AVAILABLE; Unknown Machine device description: LPKF Protomat VM	Move Pen Down			
		~	Clear Error	



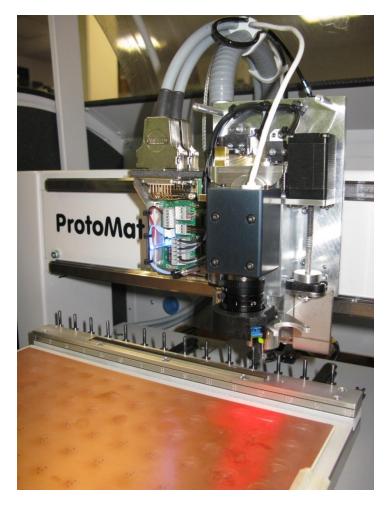
7. Make sure that there is no tool mounted in the tool clamp, if nothing is mounted, please close the clamp.

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.

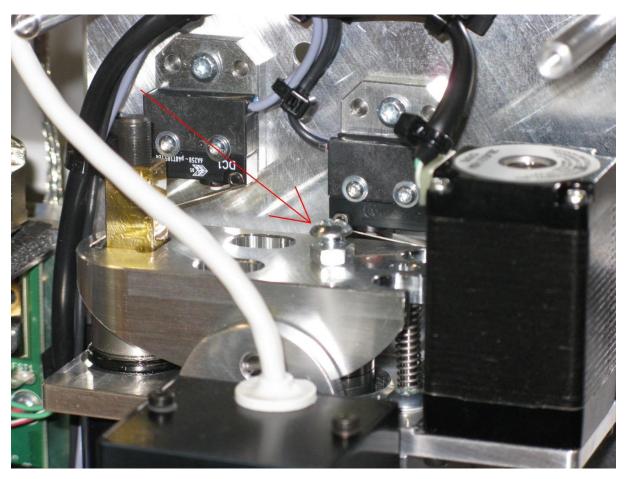


10. You have free view on the mechanic parts. See the picture below.





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.