

## Procedure for Calibrating Waffle Pack with Die on Tip

Initial conditions:

System is powered on

Waffle pack output pattern is programmed and selected

Eject head, pickup tip, and optics are properly aligned

Die on film are ready to be picked

Waffle Packs are installed on output fixture.

1. In single step mode, step through one complete cycle. Adjust the pick and place heights upwards so that the tip is clear of the waffle packs or Gel Paks. This is to ensure that the die will not be damaged in the calibration process.
2. In single step mode, pick a die. Adjust the pick height back down as appropriate to successfully pick the die. Continue stepping through the sequence until the LCD reads "Turn off pickup vacuum."
3. Press Down as needed until the die is just above the surface of the waffle pack.
4. Press Output Sizes and scroll down to Calibrate Trays. The calibration can be done with the die still on the tip, which allows for a more accurate calibration.
5. Press Yes to select Calibrate Trays.
6. Use the arrow keys to adjust the fit of the die in the first pocket. Use a magnifying light to aid in die alignment in both axes.
7. Press + to move the die to the last pocket in the tray.
8. Use the arrow keys to adjust the fit of the die in the last pocket. Use the magnifying light to aid in die alignment in both axes.
9. Repeat Steps 7 & 8 until all First and Last cavities have been calibrated
10. Press Yes to save calibration.
11. Select No, then Yes to exit from Calibrate Trays menu.
12. Press Down to lower the pickup head to place height.
13. Adjust the place height as needed and then press the footswitch to place the die in the first pocket.
14. Continue stepping through the sequence, adjusting purge and delay times as necessary, until you are finished with the cycle.
15. Change back to full run mode by pressing Single Step.
16. Pick another die to make sure the recipe settings are working.