

## **Allteq - Scriber Setup /Programming**

Once the scriber has been installed, turn on machine. The machines motors will reset. The machine needs to be in the READY state in order to proceed to the steps listed below.

### **Calibration:**

Press the "MODE SELECT" key, clear the existing mode, and enter the numbers 998. The screen will be as shown below:

B/Scriber is Active, to Calibrate Push  
ENTER; to Select Another DID Push CLEAR

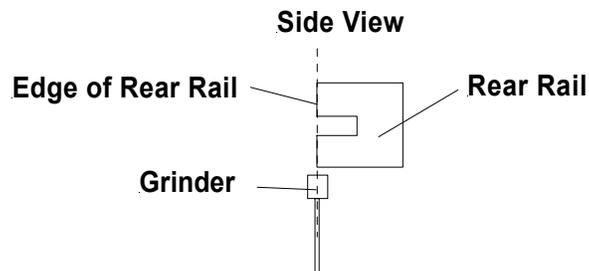
At this time press the "ENTER" key to continue, the display will be below:

WARNING – Set-Up Mode Please See Manual  
Push ENTER to Continue or CLEAR to Exit

At this time press the "ENTER" key again to continue, the display will be below:

First, use Key 2 and Key 8 to Move Scriber  
under Edge of Rear Rail: ENTER when Done

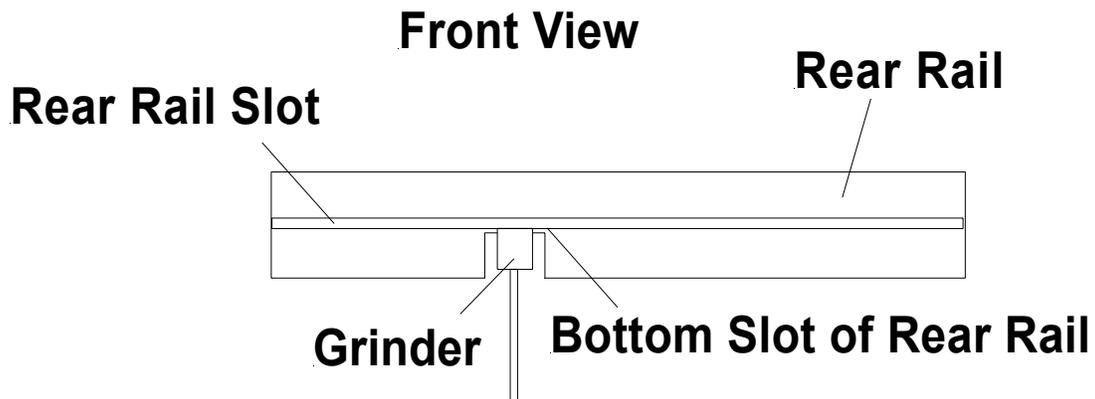
The objective here if the Calibration is to move the Scriber so that it is in the Middle of the Front Edge of the Rear Rail. Refer to drawing below. This is the "Y" Calibration adjustment.



Once this adjustment is made, press the “ENTER” key. The display will be shown below:

Next using NEXT/LAST keys to move Burr  
To Bottom of Slot (Home). ENTER when Done.

The objective here is to position the Burr so that it is at the Bottom of the Rear and Front Rail Bottom Slot. Refer to drawing below. Using the “NEXT” and “LAST” keys will move the Burr up or down. This is the “Z” Calibration adjustment.



Next is the Front Rail “Z” Calibration adjustment. Press the “ENTER” key to advance to the next screen. The display will be shown below:

Use Numeric 2 key to move Burr forward  
to the Front Rail. ENTER when Done.

To move the scriber forward to the Front Rail, press the “2” key. It may need to be pressed several times until it reaches the Front Rail. Once this is done, press the “ENTER” key and the display will be shown below:

Next using NEXT/LAST keys to move Burr  
To Bottom of Slot (Ext.). ENTER when Done.

Using the “NEXT” and “LAST” keys will move the Burr up or down. Once this has been completed, the “Y” and “Z” Calibration is completed.

**Programming:**

The next step is to program the Scriber for scribing. To program the Scriber for a particular strip/frame is done by pressing the "PARAMETER SELECT" key. Then advance through the display until you reach the area, which is shown below:

Y_idx	Grab	Scribe
-	125	*REJECT

Make sure at this point that the B/Scribe has "REJECT" listed below it. If it does not say, "REJECT", press the "CLEAR" key when the cursor is at that position. Then press either the "NEXT or LAST" keys to toggle from "OFF" to "REJECT". Once this is done press, the "ENTER" key and the display will be shown below:

B/Scribe	Ya	Xid	Depth
mil	320	0	20

The "Ya" parameter is the distance from the BACK EDGE of the strip/frame to the area that will be scribed; this is the "Y" direction setting. The "Xid" is the area on the strip/frame in the "X" direction that will be scribed. This is measured from the CENTER of the device in the Left or Right direction. Last, is the "Depth", this function determines how far the Grinder will travel into the bottom side of the strip/frame for marking. Refer to the drawing for parameter references.

