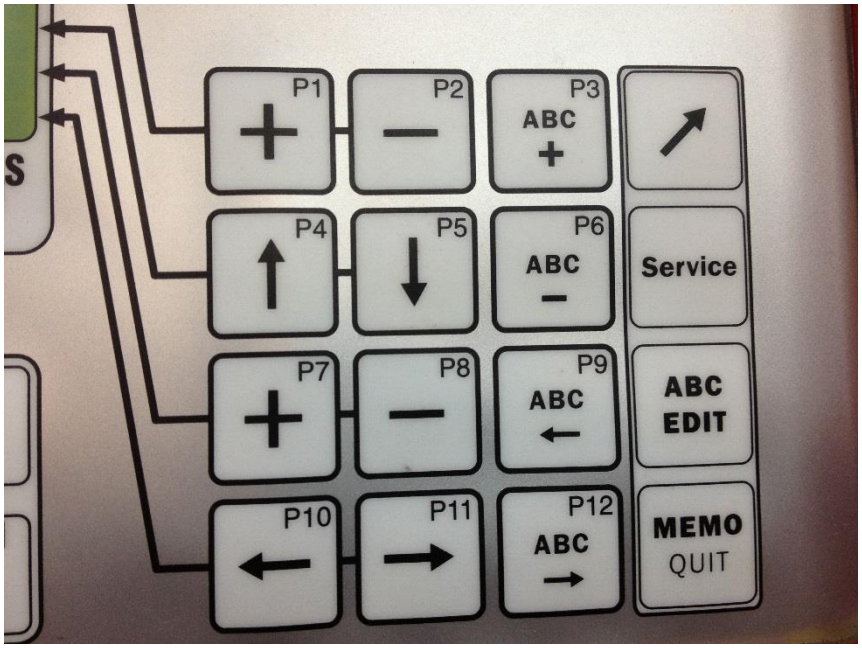
Puma 700 CE /E/EB/E HS/EB HS Re-Calibration Procedure.

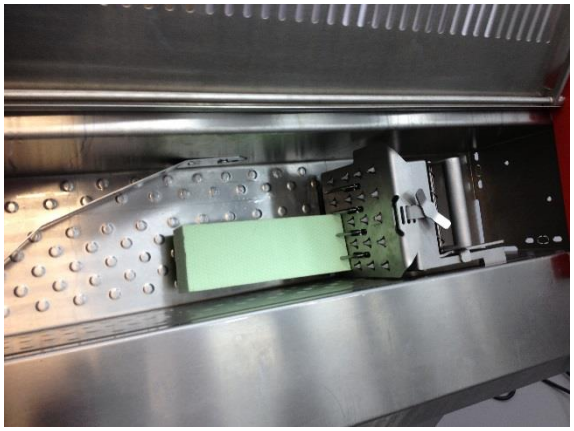
Stage 1: First check nominal data range.

1. From the cutting program screen select ***SERVICE***
2. Arrow down ***P5*** to – "***Service Parameter Edit" (usually number 6)*** Then press **"Service"** again.
3. Whilst holding down the top right hand arrow key, enter the service level password ***P1, P5, P6, P1.***
4. Parameter 01, The distance from the home position sensor to the knife is displayed, (Approximately 650mm nominal but will vary between machines)
5. Arrow up ***P4*** to Parameter 02, The distance from the home position sensor to the product light barrier, (Approximately 594mm nominal but will vary between machines)
6. The difference between parameters 01 and 02 above will equal the distance from the product light barrier to the knife. ***P01 should always exceed P02***
7. If this is not the case (possibly after a crash) manually increase Parameter 01 to 700mm using the ***P7 +*** button
8. Save using ***Memo Quit***



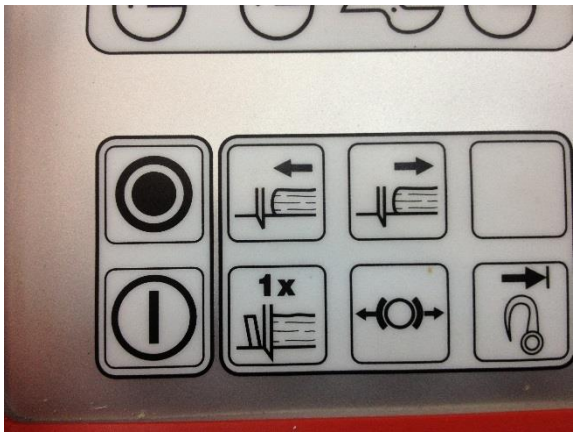
Stage 2: Re-Calibration.

1. From the cutting program screen select "***SERVICE***"
2. Arrow down ***P5*** to - ***"Measuring Procedure"*** (usually number 4) then press" **Service**" again.
3. Whilst holding the top right hand arrow key down, enter **service code *P1, P5, P6, P1*** or ***Operator code P2, P5, P4, P6***
4. Place a piece of sterofoam in the gripper centrally, and just off the base of the chamber. (preferable with at least two teeth into the foam.



5. The machine run light/switch should be in the unlit/off position

6. Close the chamber lid and drive the gripper forward with the ***forward jog button*** until it reaches the forward stop, ensure the DVS system does not engage. If it does, jog the gripper back with the ***reverse jog button*** approximately 1mm.



7. Press ***Machine Start***

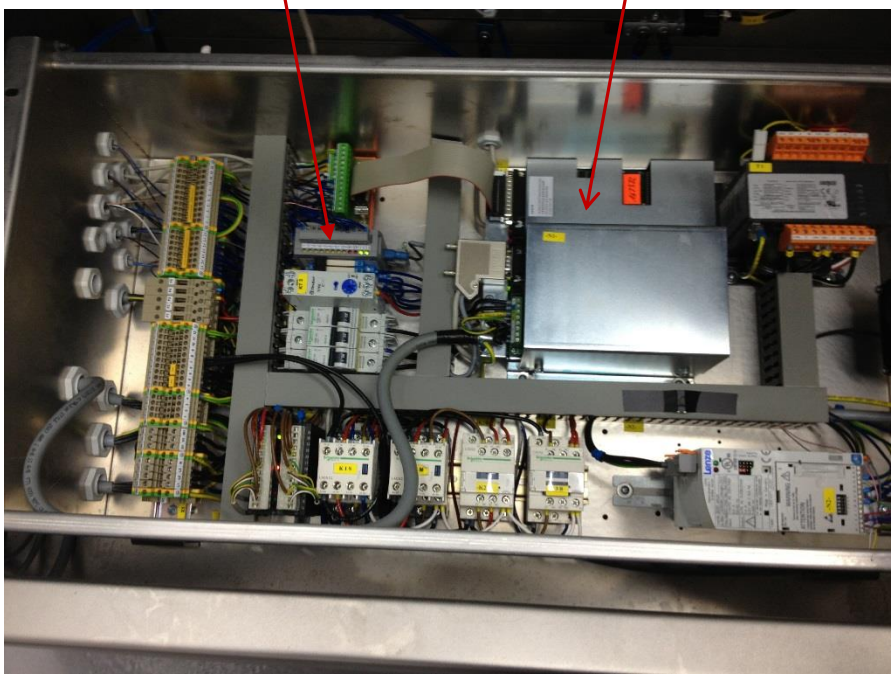
8. The machine will carry out the following sequence:
    - Knife will cut off the Sterofoam
    - Gripper will travel in reverse to the home position sensor
    - Gripper will travel forward to the product light barrier, ***OK*** will be displayed
    - Gripper will return from the light barrier to the home position sensor.
9. Save and Exit the Service menu with ***Memo Quit*** button
10. Go back to ***6 - Service Parameter Edit (as per lines 1 to 5 above)*** and check parameters ***P01 and P02***, Approx 650mm, 594mm respectively

11. Service parameter ***P03***, Knife Gearbox rpm, nominal 200. The gearbox nameplate and P03 must match. In this case 204

Notes:

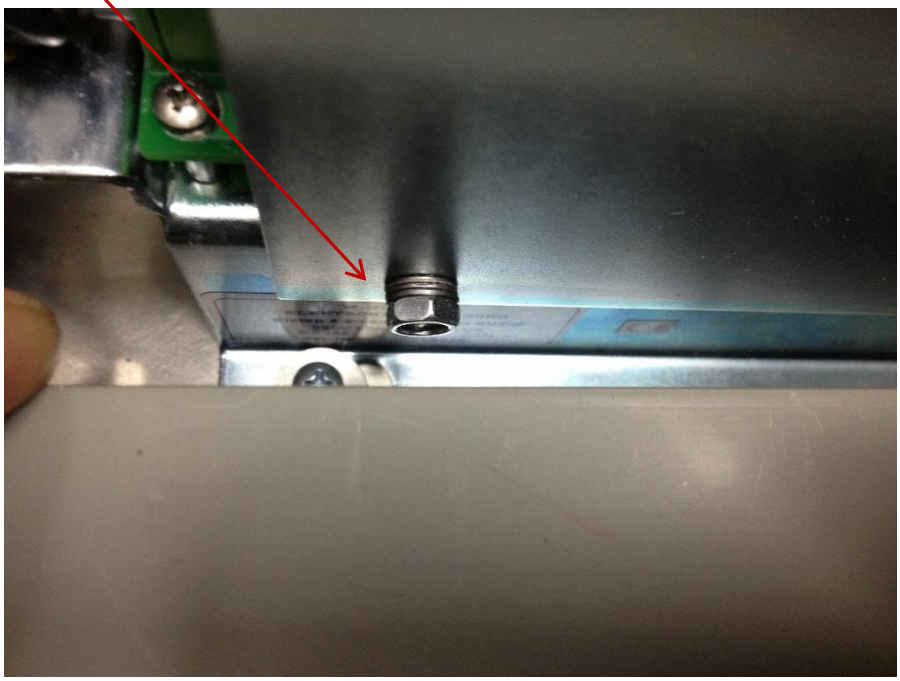
Basically it's the module that controls the pneumatics. It's having this unit (for the pneumatic lid) that determines if the main board is a NC non cambus, or a CAN cambus board.

Mother Board N1



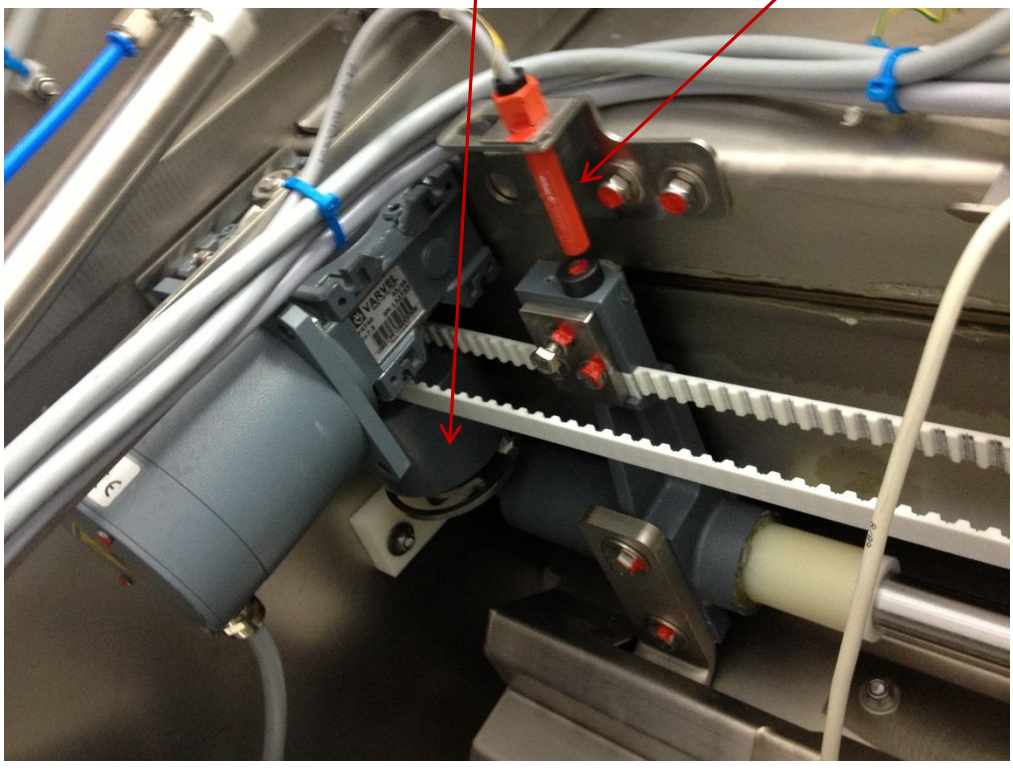
CAN = Pneumatic Machine, ***NC*** = Older Non pneumatic machine

This can be seen on the Mother board name plate (Silver label – Blue writing)



DVS System

Home Position Sensor



Product Light Curtain Sensor (Send and receive sensor type)