

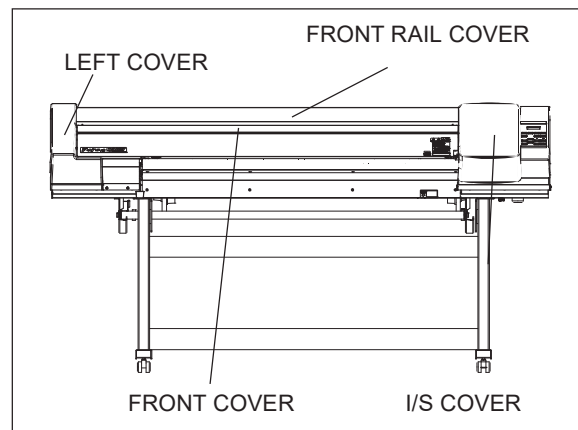
## 4-12 TOOL PRESSURE ADJUSTMENT (Referential Time : 15min.)

### [About TOOL PRESSURE ADJUSTMENT]

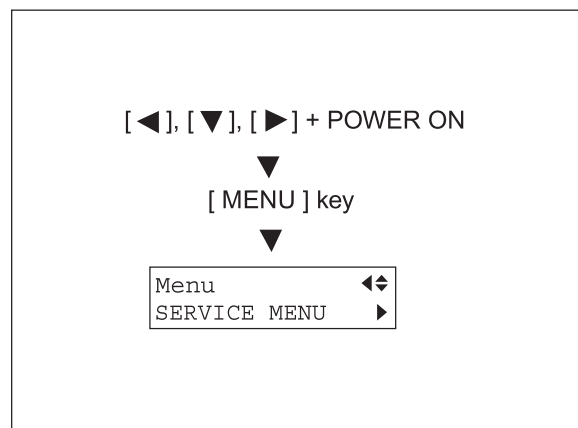
This adjustment is for having the correct tool pressure.

Perform this adjustment at the right end of BED. There is no H mark.

- 1 Remove the I/S COVER, LEFT COVER, FRONT COVER and FRONT RAIL COVER.



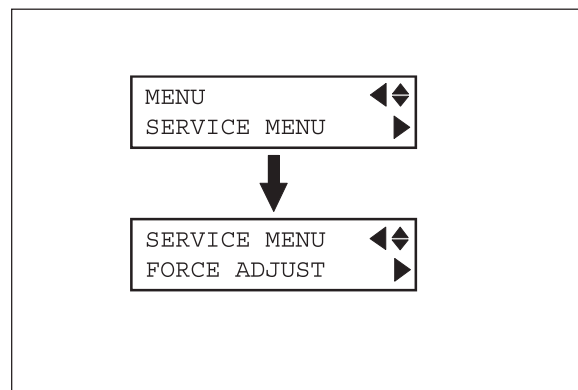
- 2 Turn on the sub power switch while pressing [◀], [▼] and [▶] keys to enter the SERVICE MODE.



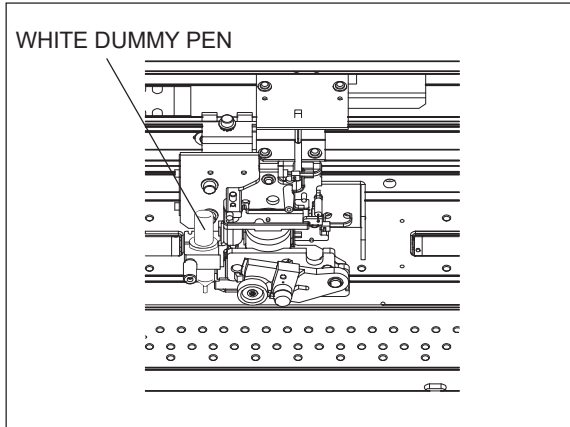
- 3 Select [FORCE ADJUST] in the SERVICE MODE.



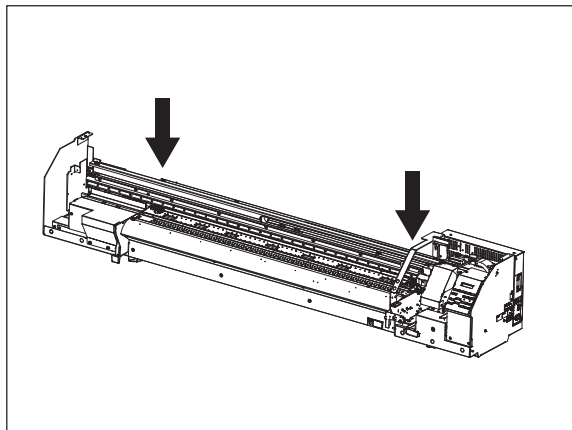
When you enter the [FORCE ADJUST] menu, you can move only the TOOL CARRIAGE.



- 4** Put the WHITE DUMMY PEN (ST-006) on the TOOL CARRIAGE.



- 5** Lower the PINCH ROLLERS at both edges of the GRIT ROLLER.

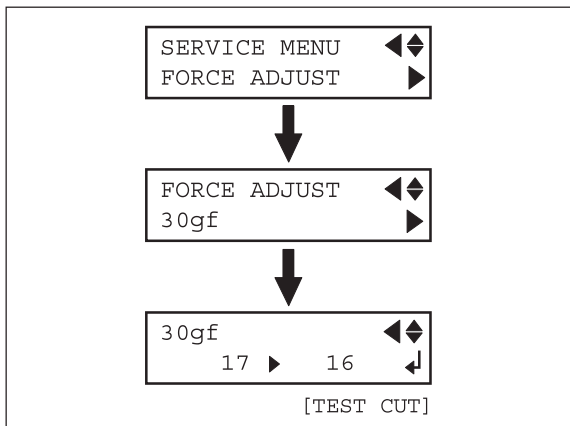


- 6** Move a carriage to the right end of BED.



There is no H mark on this machine.

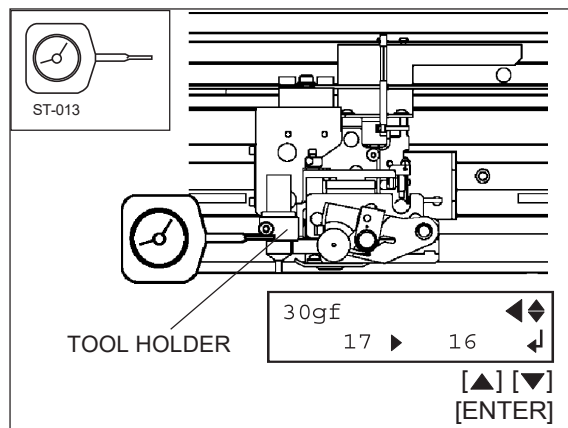
- 7** Select [30gf] under [FORCE ADJUST] menu.  
Press the [TEST CUT] key and move the TOOL down.



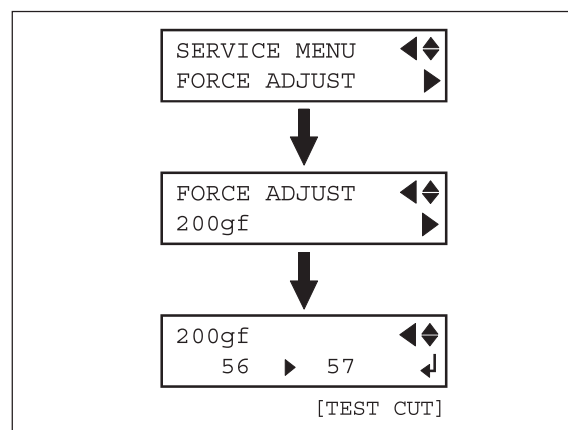
- 8** Pull up the Handle part of the TOOL HOLDER with the DIAL GAUGE (ST-013) and measure the pressure when the pen tip leaves the BED.

Adjust the parameter in the [30gf] menu with [▲] and [▼] keys so that the pressure will be 25 ~ 35gf(0.25N ~ 0.35N).

Press the [ENTER] key to save the settings.



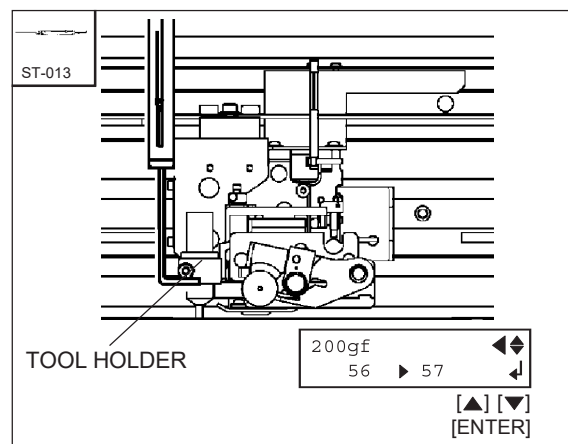
- 9** Select [200gf] under [FORCE ADJUST] menu.  
Press the [TEST CUT] key and move the TOOL down.



- 10** Pull up the Handle part of the TOOL HOLDER with the TENSION GAUGE (ST-002) and measure the pressure when the pen tip leaves the BED.

Adjust the parameter in the [200gf] menu with [▲] and [▼] keys so that the pressure will be 195 ~ 205gf (1.9N ~ 2.0N).

Press the [ENTER] key to save the settings.



- 11** Enter [30gf] menu under [FORCE ADJUST] menu for checking again.  
Press the [TEST CUT] key and move the TOOL down.

