

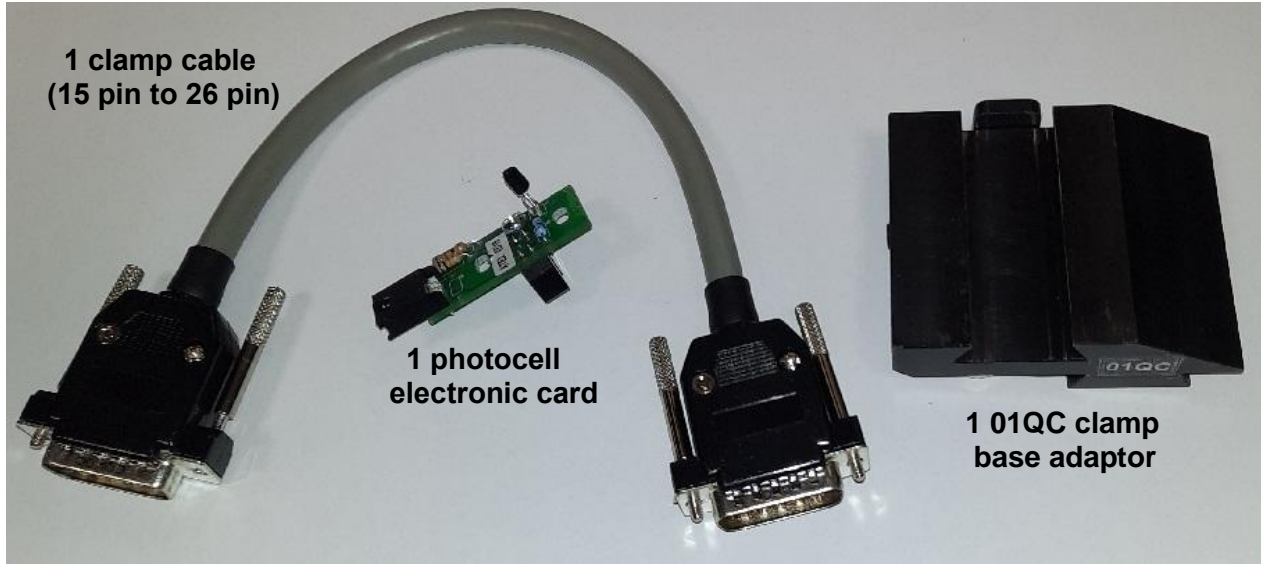


QUATTROCODE *D* Series

R13 Upgrade kit: D7A8922ZB

To be able to use the R13 clamp on the Quattrocode D series machines, one should purchase the R13 clamp upgrade kit: Part number: D7A8922ZB.

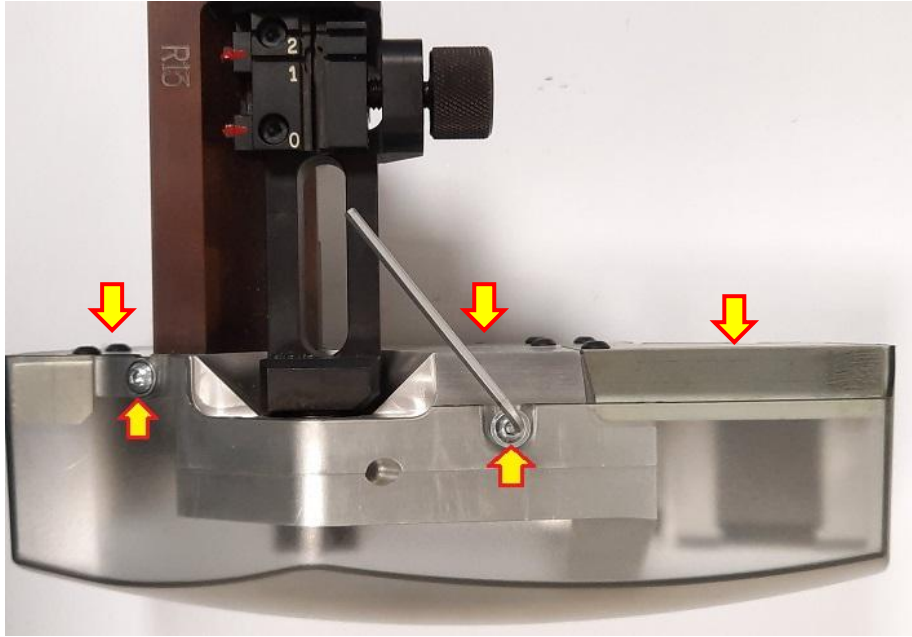
The upgrade kit contains the following parts:



Here below are instructions on how to properly mount the upgrade kits components to the R13 tilting clamp:



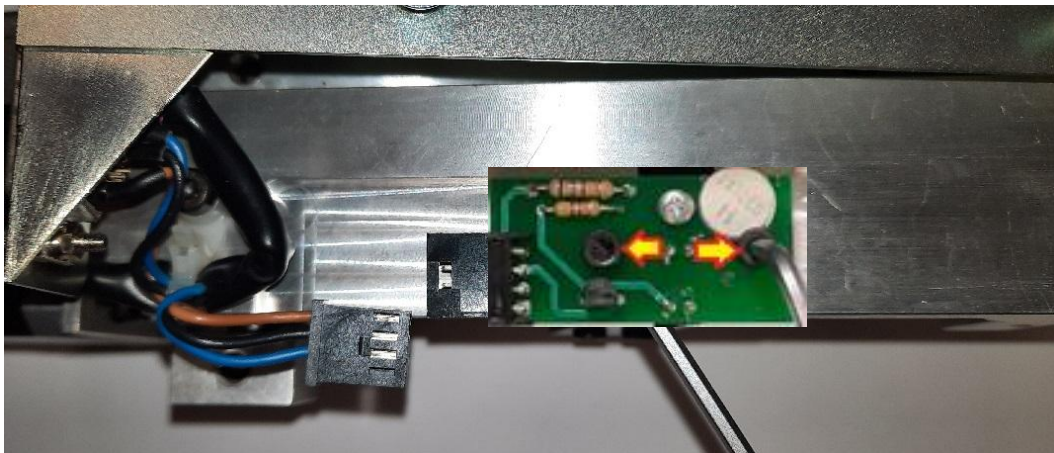
Remove the 15 to 15 pin serial cable from the R13 clamp by unscrewing both screws indicated with the red arrows in the image above.



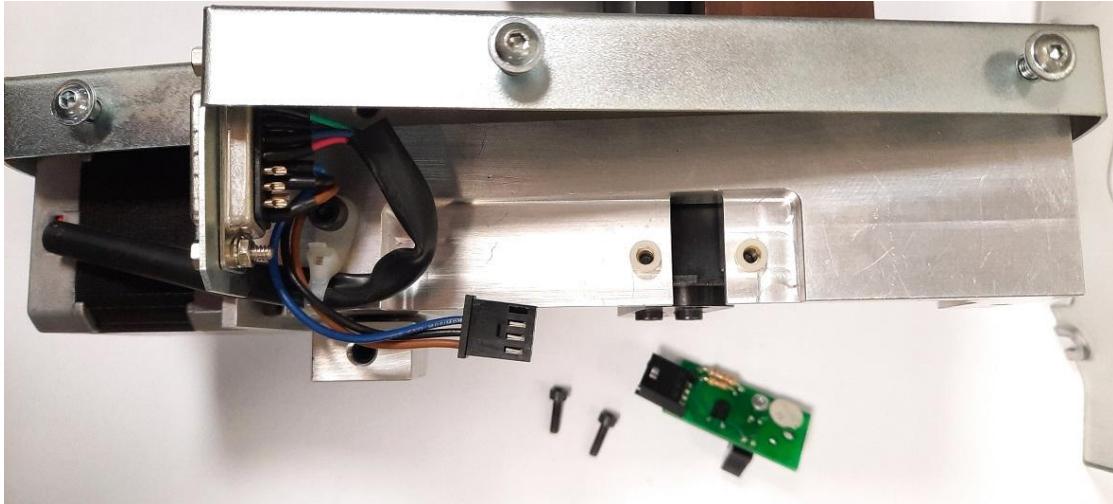
Unscrew all 5 screws indicated with the yellow arrows in the image above that hold the R13 clamps plastic cover and remove the plastic cover.



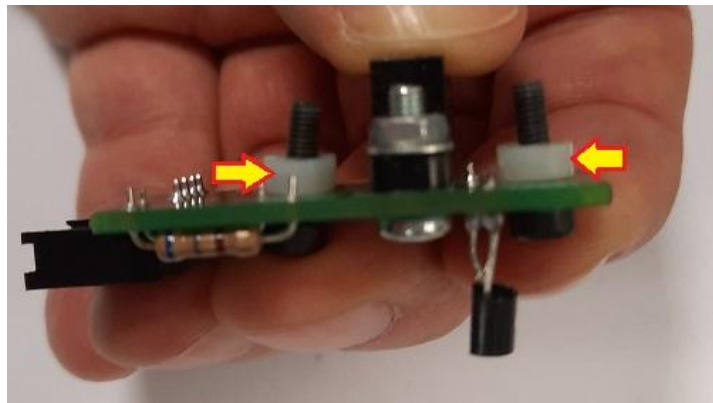
Unplug the photocell cable connector from the photocell's electronic card as indicated with the yellow arrows in the image above.



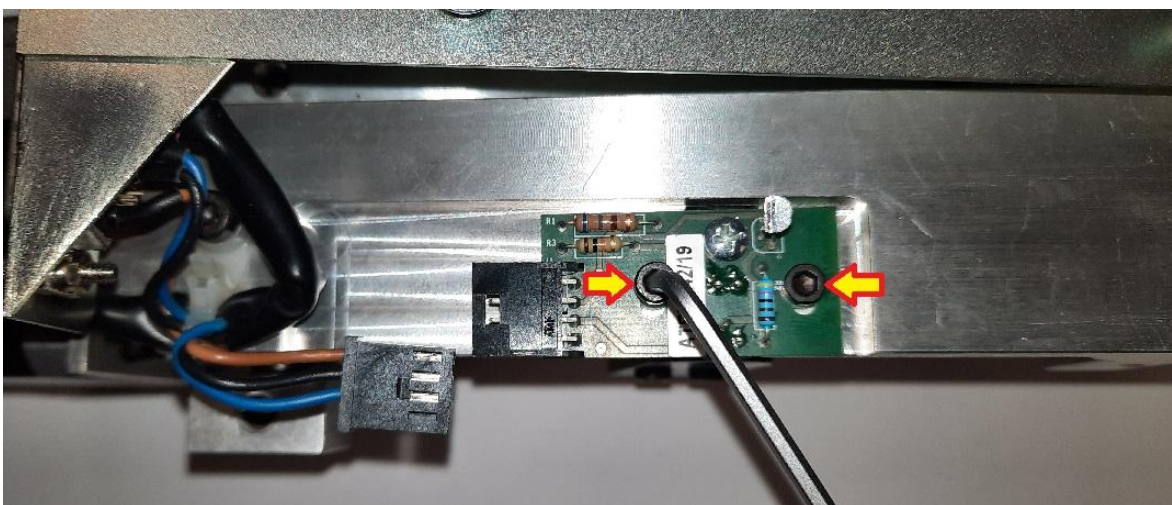
Unscrew both screws indicated with the yellow arrows in the image above that fix the photocell's electronic card to the R13 clamps chassis, then remove the photocell's electronic card from the R13 clamp and replace it with the one that was supplied with the upgrade kit.



Make sure to insert the two screws and white plastic rings as indicated with the two yellow arrows in the image below.



Screw in both screws indicated with the yellow arrows in the image below that fix the new photocell's electronic card to the R13 clamps chassis.



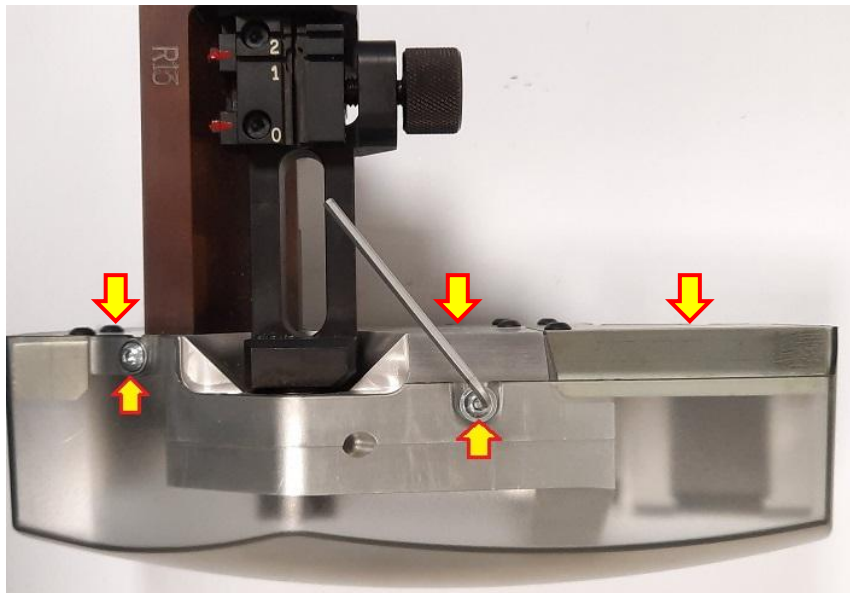


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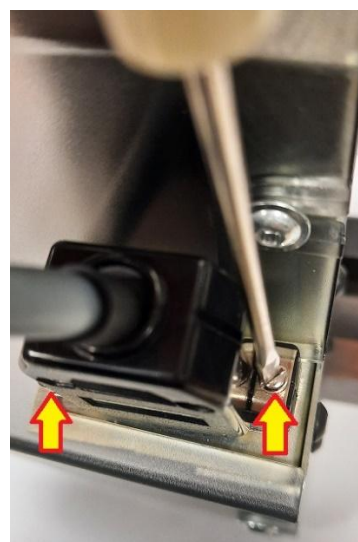
Plug in the photocell cable connector to the photocell's electronic card as indicated with the yellow arrow in the image below.

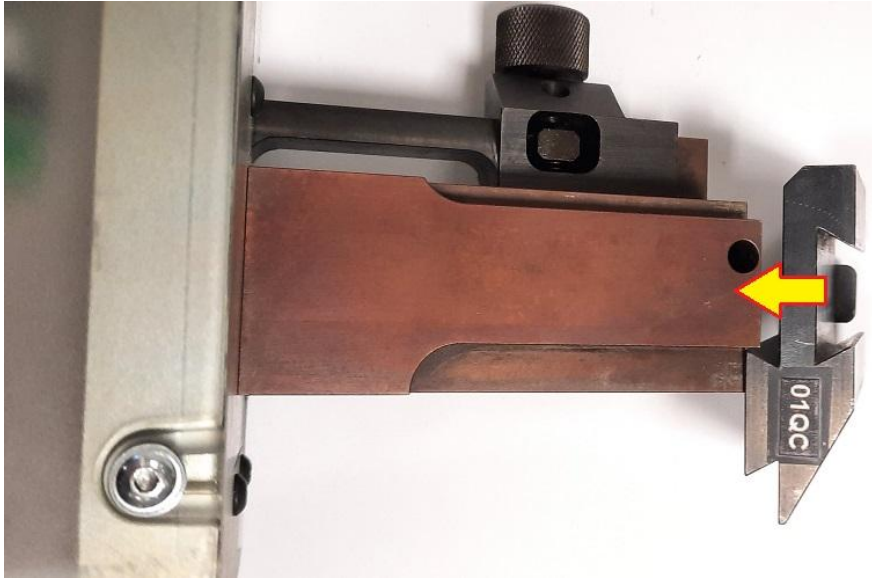


Mount the R13 clamps plastic cover and screw in all 5 screws indicated with the yellow arrows in the image below.

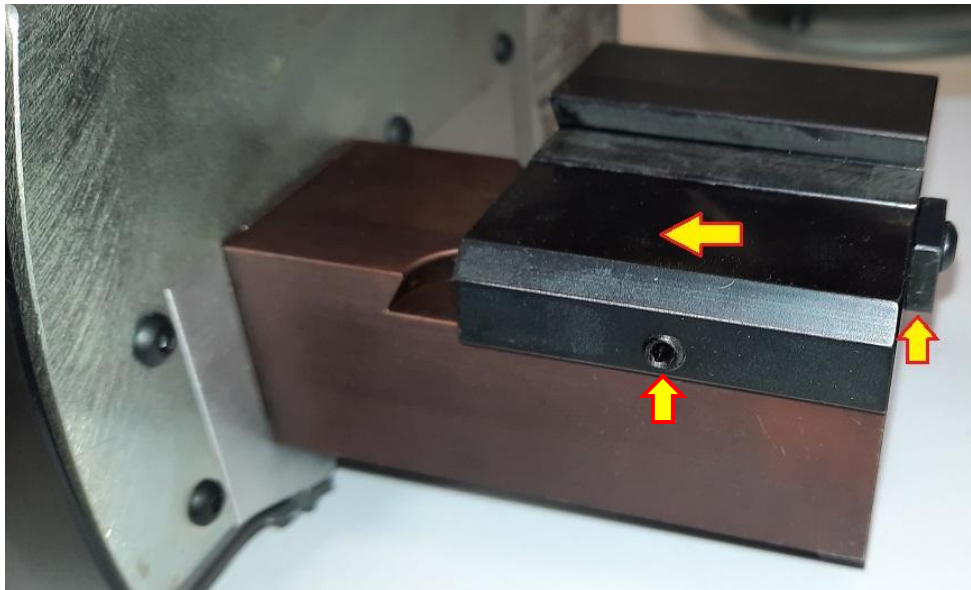


Plug in the new 15 pin (R13) to 26 pin (machine) serial cable to the R13 clamp, making sure that both screws indicated with the yellow arrows in the image below are properly tightened.

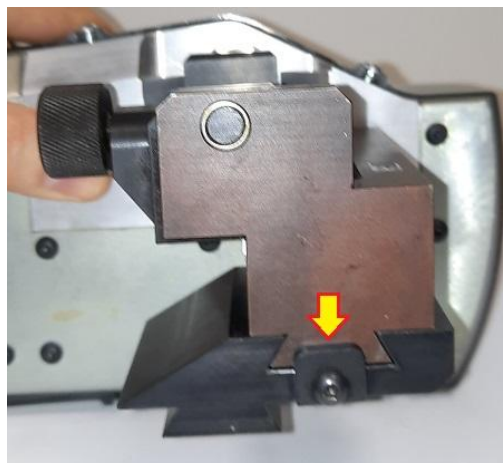


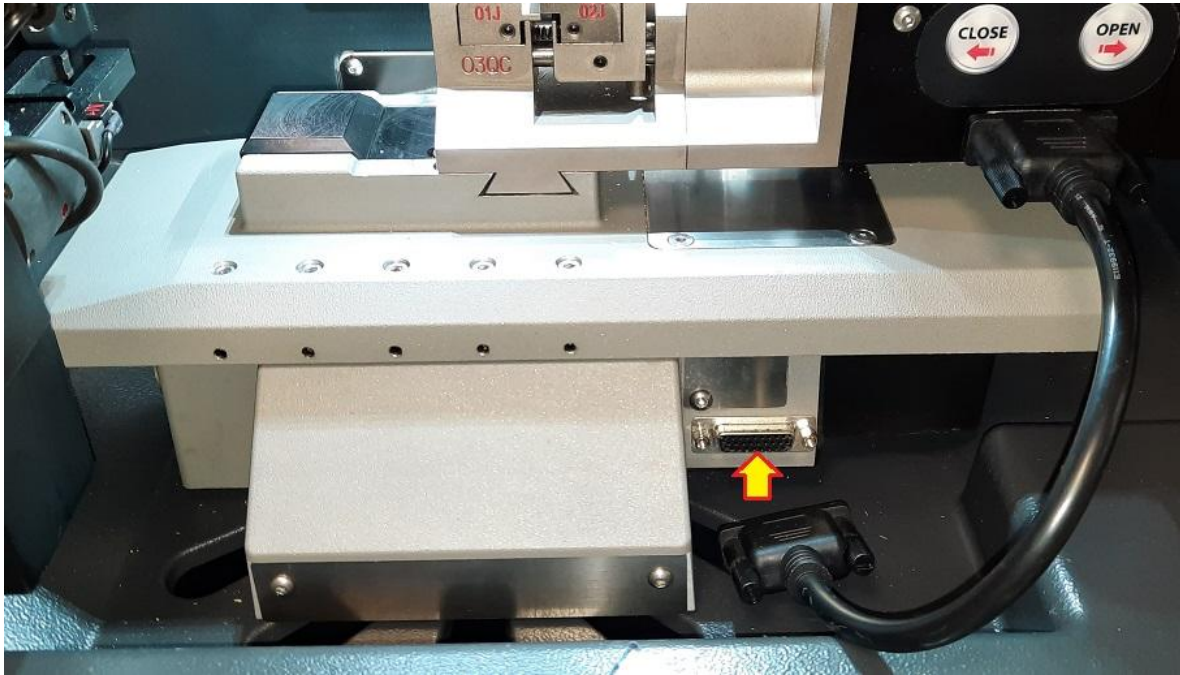


Slide the 01QC clamp base adaptor to the R13 clamps dovetail base as indicated with the yellow arrows in the image below then tighten the 01QC clamp base adaptors grub screw to firmly lock it to the R13 clamps dovetail base.

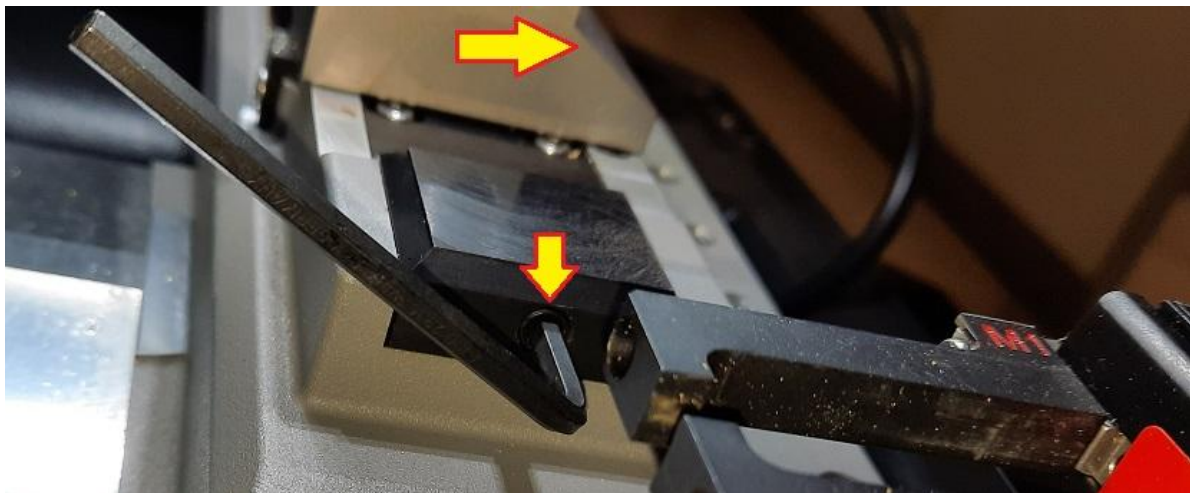


Make sure that the R13 clamps dovetail base touches the 01QC clamps end plate as indicated with the yellow arrow in the image below.

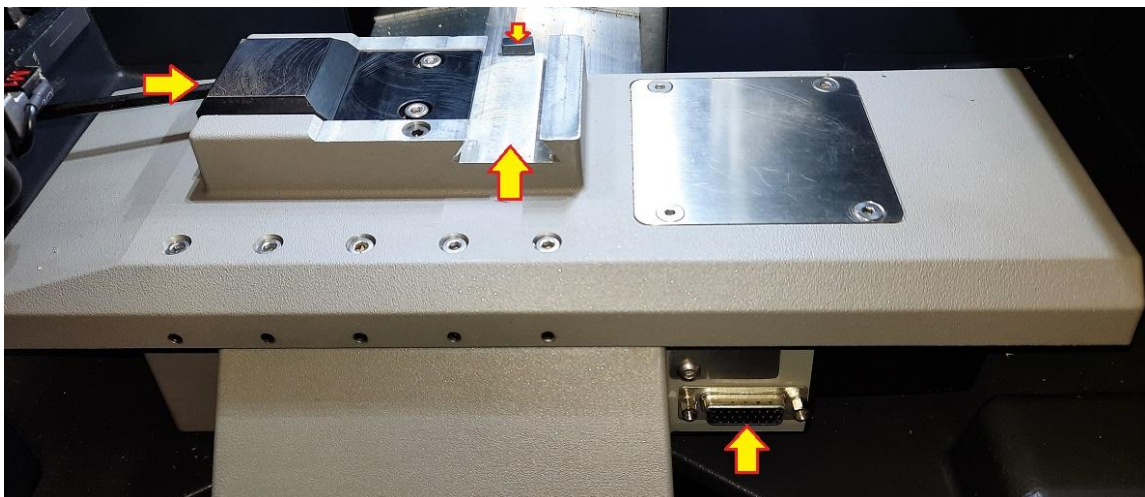


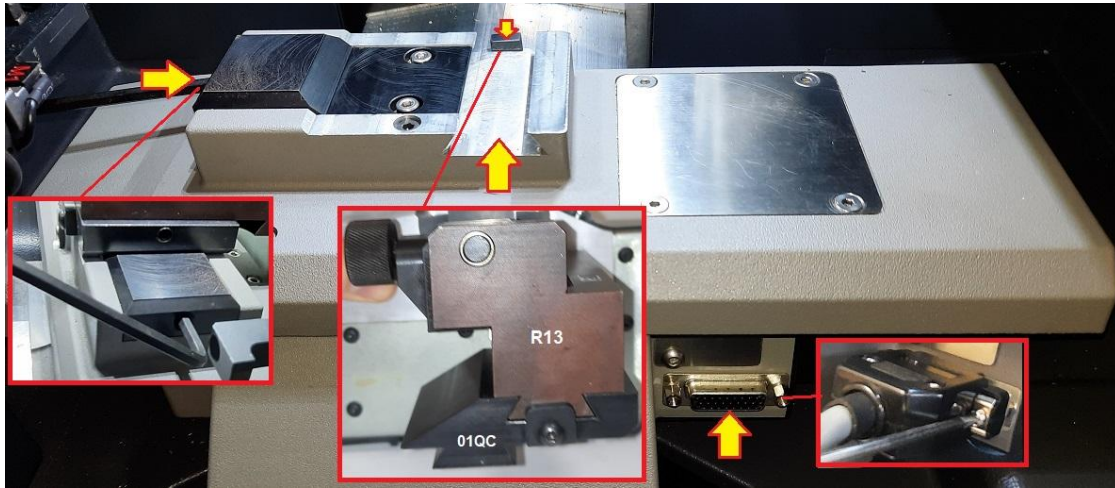


Unplug the 03QC electric clamps cable from the machine as indicated in the image above.

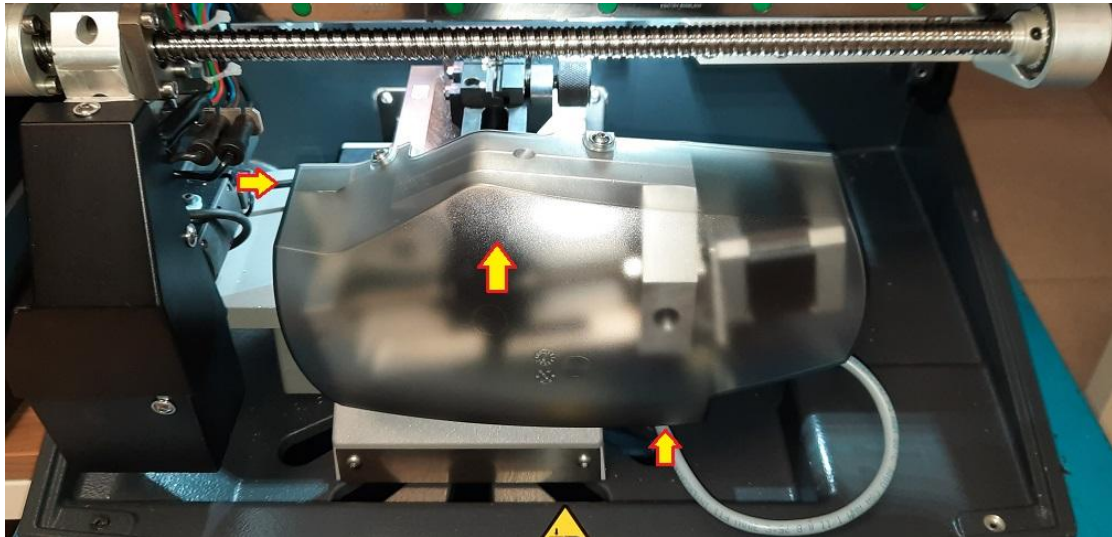


Slightly unscrew the 03QC electric clamps locking grub screw and slide the 03QC electric clamp off the Quattrocode machine as indicated with the yellow arrows in the image above.





Slide the R13 clamp onto the machine's dovetail base up until it touches the end of run stop plate at the end of the machines dovetail base as indicated by the yellow arrow in the image above, then tighten the 03QC electric clamps locking grub screw on the left side of the clamp and screw in the R13 cable to the machine as indicated in the images above and below.



Proceed with calibrating the R13 clamp as indicted below:

SEARCH
 SETTINGS
 FAVOURITES

	Clamps	Zero-point Calibration
Info		
Calibration	<ul style="list-style-type: none"> 01QC-R156 01QC-R92 ▼ 04QC rotating 04QC ✓ ▼ 01QC rotating <li style="background-color: #e61e20; color: white;">01QC-R13 ▼ 03QC electric 	<div style="display: flex; align-items: center;"> <div style="flex: 1;"> <p>Clamp 01QC-R13</p> <p>Tracer 10T</p> <p>Clamp calibrated ×</p> </div> <div style="flex: 1;"> </div> </div> <p style="color: red; font-size: small;">Note that the R13 tilting clamp must be mounted on the optional 01QC clamp base adapter (D7A8434ZB) and must be connected to the machine with a 26 to 15 pin serial cable.</p>
Settings	<p style="color: blue; font-weight: bold;">Tap on Calibration, Clamps Dimple/Track keys and 01QC-R13 clamp to proceed with calibrating the R13 tilting clamp.</p>	
Maintenance	<div style="border: 1px solid #ccc; padding: 5px; display: inline-block;"> Calibration </div>	

CLAMP CALIBRATION

Clean carefully the clamp and the tracer. Totally close the clamp.

CLAMP | 01QC-R13
SIDE | A
TRACER | 10T

Tap on open (spindle) to insert the 10T tracer point into the cutter chucks collet, then tap on close. To proceed with calibrating the R13 tilting clamp tap on Start.

CANCEL CLOSE OPEN START



CLAMP CALIBRATION

Calibration in progress...

STOP

If for any reason you need to stop the R13 clamp calibration cycle, just tap on Stop.

Calibration completed

Axis	A
X	11
Y	6
Z	-2
B	77

Save the data ?

SAVE

To save the machine's new R13 tilting clamps Axial calibration values, TAP ON SAVE.

You can now use your R13 tilting clamp on your Quattrocode D series machine.