



Iridium Manufacturing

Charmilles Robofil 500 Nozzle Adjust Height

SWI-029 Rev. A

When the machine state of the Charmilles changes due to a part change or software change, the nozzle adjust height should be changed as well. This way full sealing during cutting and head height is proper during machining and programming.

1. Install flat block on table (flat across surface 0.0005"-.001")
2. The adjusting variable is the Z value or the distance between the guides in the upper and lower head
3. This procedure is done with Sealed nozzles, and then is set for sealed or open nozzles
4. The Parameter "INJ" needs to be set to 16 during this procedure, this is accomplished through the "Generator Parameters" Menu
5. Go to "EXE" then "Measuring", next arrow over and press "Nozzle Adjust"
6. Once in nozzle adjust slowly bring "Z" axis down via hand jog on top of solid block
7. Should see a noticeable difference in flushing, once the nozzles are sealed
8. Once the difference in sealing is noticed, enter your part height as the "Z" height in nozzle adjust
9. Once this process is complete, Perform a "Guide Setup" to verify head is properly aligned and straight