

TITLE: **SABRE™ 408 Router Y-Axis Encoder**

Gerber FastFact #: 2041

Supplied by: Gerber Hardware Support

Last Modified: June 19, 2007

Summary: The following procedure explains how to set the encoder if the machine is inoperable and cannot be oriented.

➤ To establish the Y-Axis encoder pulse position

- 1 Put a piece of paper tape in the trough between the right Y-axis way and the table top. The tape should be from the front edge of the trough and extend toward the back approximately 6".
- 2 Move the carriage to the center of the beam and move the beam to approximately 3" from the front end of the Y-Axis way.
- 3 Push the A key on the keypad to orient the router. The beam comes forward and stops, and the carriage starts to move to the left. While the beam is stopped, hold a pen vertically and firmly against the beam linear bearing block and mark the tape.
- 4 When the carriage completes its travel to the left, the beam moves slightly to the rear of the router and stops. After the beam stops, hold a pen vertically and firmly against the beam linear bearing block and mark the tape again.
- 5 Measure the distance between the two marks on the tape. The distance should be approximately 3/16" or less than 5mm. If the gap is within these specs, the encoder pulse is properly set. If this gap is not within specs, go to "To Adjust the encoder pulse position, if necessary".

➤ To adjust the encoder pulse position, if necessary

- 1 Remove the Y-Axis motor cover plate.
- 2 Loosen the Y-Axis motor pulley clamp.
- 3 Rotate the motor pulley to move the beam forward or backward to adjust the gap between the two marks made during the initial test above.
- 4 Tighten the motor pulley clamp and follow the procedure "To establish the Y-Axis encoder pulse position."
- 5 Replace the motor cover and run a small test job before resuming production work.