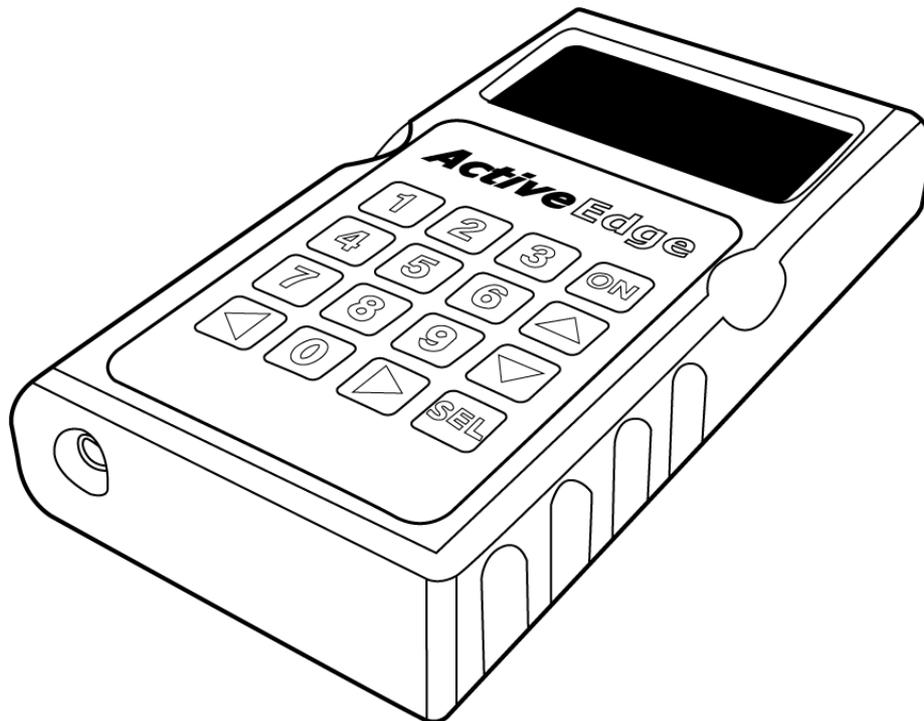


AE043 - ActiveEdge 3T Adjuster – Instructions for use

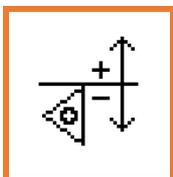


The 3T Adjuster is a battery operated, wireless handset that allows micron adjustments to be made to any ActiveEdge boring tool. It also incorporates a number of useful tool maintenance and data acquisition functions.

Switch on the Adjuster

Press and hold down the ON button until the ActiveEdge splash screen appears.

The splash screen is quickly replaced by the main menu, which contains all of the tool control functions described below. Press the left and right arrows to navigate to the desired function and press SEL. The up, down, left and right buttons can be used to navigate between screen items at any time.



Adjust cutting edges

Send an instruction to adjust up to five cutting edges on one tool.

Use the keypad to enter the tool ID of the tool you wish to adjust, then press SEL to continue to the next screen. A unique tool ID number is clearly etched onto every ActiveEdge tool.

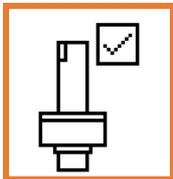
If the tool ID is being entered for the first time, you will be prompted to enter the number of AE cartridges on the tool. The 3T Adjuster records this information so that in future the correct number of cartridges are automatically displayed on the tool graphic.

Enter the desired micron adjustment on diameter for each cartridge. The direction of adjustment can be changed by selecting '+' and pressing SEL. A plus value will increase the cutting diameter and a minus will decrease the cutting diameter.

On multiple cartridge tools, use the up and down arrows to navigate between cartridge adjustment values. Note that cartridge 1 is always located furthest from the shank.

Press SEL twice to start the tool compensation process. Within a few seconds the handset will establish a wireless connection and a graphical representation of the tool will appear, indicating that the tool is executing the adjustment command.

When the adjustment process is complete, the handset displays the tool battery level and the percentage of physical adjustment being used by each cartridge.

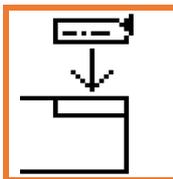


Check tool

Verify that the tool is switched on and ready for use.

Enter the tool ID and press SEL twice to start the tool check process.

Within a few seconds the handset will establish a wireless connection and a graphical representation of the tool appears. Shortly afterwards the display shows the tool battery level and the percentage of physical adjustment being used by each cartridge.



Replace cartridge

Upload cartridge calibration data to the tool memory.

Each ActiveEdge cartridge relies upon its own unique calibration parameters to ensure micron accuracy. The calibration parameters must be uploaded into the tool's memory when the cartridge is fitted to the tool. Parameters for all ActiveEdge cartridges are available in a single database called HandyCDF.sdf, a copy of which is provided on the 3T Adjuster's SD card.

Enter the tool ID of the tool you wish to upload the cartridge parameters to, then press SEL to continue.

If the tool ID is being entered for the first time, you will be prompted to enter the number of AE cartridges on the tool. The 3T Adjuster records this information so that in future the correct number of cartridges are automatically displayed on the tool graphic.

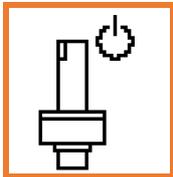
On multiple cartridge tools, use the up and down arrows to navigate to the tool pocket that the cartridge is being fitted to. Note that cartridge 1 is always located furthest from the shank.

Enter the cartridge serial number (ID) that is etched on its side, then press SEL twice to initiate the upload.

After a few seconds the handset will establish a wireless connection with the tool. A confirmation message is displayed when the upload is complete.

Note: It is important to periodically update the cartridge database on the SD card. The most recent version can be downloaded from the Rigibore website using the link below. **It is essential to do this if new cartridges have been purchased or after a cartridge has been repaired.**

<http://rigibore.com/ActiveEdge/CalibrationFiles/HandyCDF.dbf>

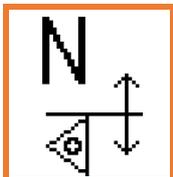


Switch off tool

Shuts down the tool completely to conserve battery power if the tool is not being used for several days.

Enter the tool ID and press SEL twice to start the tool shutdown process.

Within a few seconds the handset will establish a wireless connection with the tool, then display a message confirming that the tool has shut down completely. The tool must be manually switched on before it can be used again.

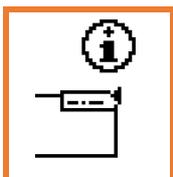


Odometer

Shows the number of adjustment sessions carried out by the tool during its lifetime.

ActiveEdge tools maintain a record of how often they have completed a compensation session. This information can be accessed by entering the tool ID and pressing SEL twice.

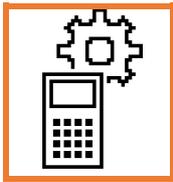
Within a few seconds the handset will establish a wireless connection with the tool. The information is displayed when the process is complete.



Get cartridge IDs

Confirm that the tool memory corresponds with the serial numbers of the cartridges fitted to the tool.

Enter the tool ID and press SEL twice. When a wireless connection with the tool has been established, the handset will display the serial numbers of the cartridge calibration parameters currently held in its memory.



3T Adjuster settings

Enable or disable the sound, vibration feedback, data logging and reset the 3T tool memory.

Navigate to any setting icon and press SEL to enable or disable the feature.

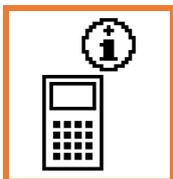
The data logging option is enabled by default. This records an activity log of all commands and tool responses into the HANDYLOG.CSV file, which is located on the SD card. The csv file format allows the file to be opened by any spreadsheet editing program for review and analysis.



3T Adjuster shutdown

Force the 3T to switch off.

Note that if no buttons are pressed for 10 seconds, the unit will switch off automatically anyway.



3T Adjuster lifetime usage

Displays time spent adjusting tools, total 3T 'on' time and the number of times it has connected to a tool.

Also displayed is the handset's part number and serial number.

General information: Recharging

The handset contains a high capacity rechargeable Nickel-metal hydride (NiMH) battery. It must always be recharged with the supplied fast charger AE-CHR08. Please follow the detailed charging instructions supplied with the recharger.

The fast recharge cycle takes about 30 minutes. A full charge should provide several weeks of ordinary use.