
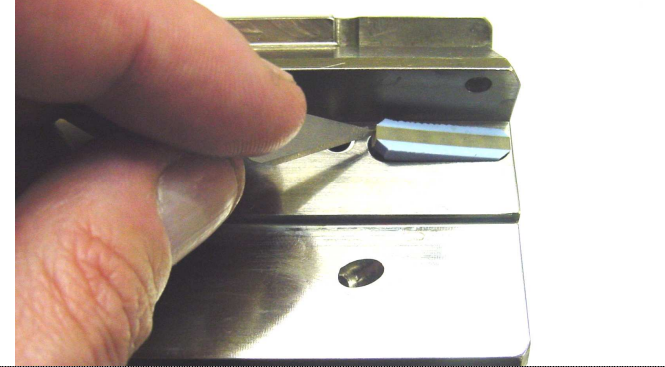
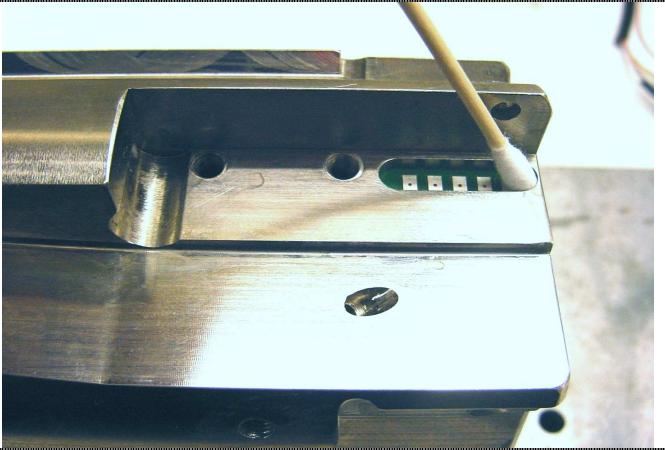
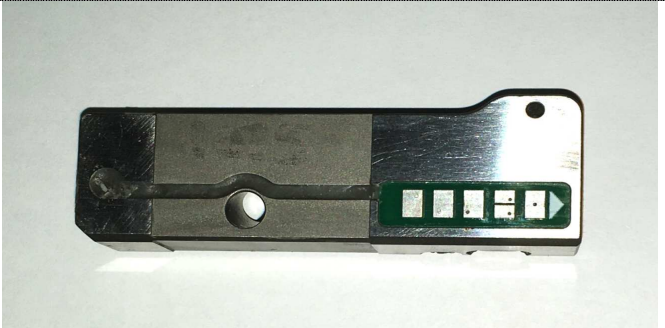

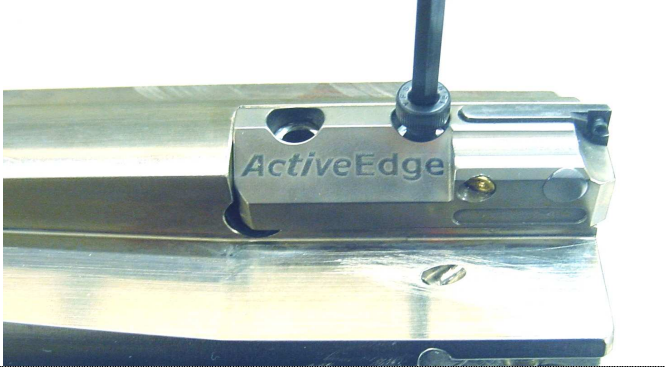
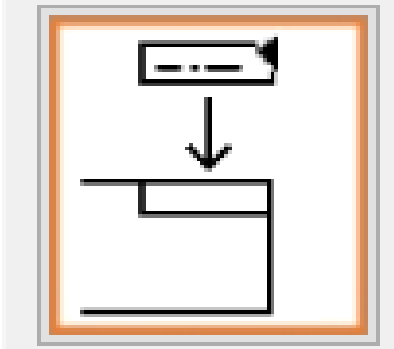
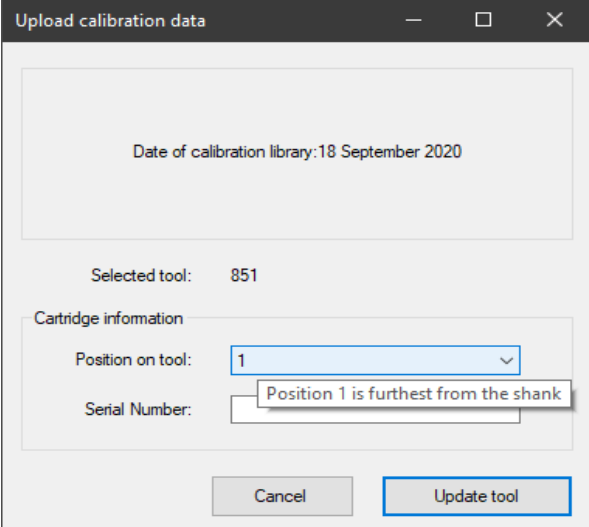

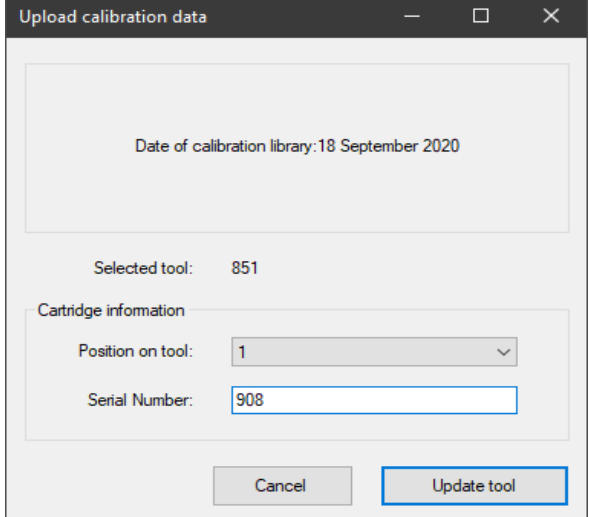


**AE014 - Cartridge Replacement Procedure**

<p><b>1</b> Undo the cap head attachment screw(s) and remove the cartridge from the bar.</p>	
<p><b>2</b> Carefully remove the Zebra strip from the cartridge pocket. Make sure the connector slot is clean and free from debris.</p>	
<p><b>3</b> Inspect and clean the tool electrical contacts in accordance with maintenance document AE030.</p>	
<p><b>4</b> Inspect and clean the cartridge electrical contacts in accordance with maintenance document AE030.</p>	

<p><b>5</b> Fit a new Zebra strip in accordance with maintenance document AE030.</p>	
<p><b>6</b> Fit the cartridge, ensuring that it is firmly seated on all 3 qualified pocket faces.</p> <p>Re-fit the attachment screw(s). Tighten to: 5 Nm. (M5 screws) 3 Nm. (M4 screws)</p>	
<p><b>7</b> If the original cartridge has been re-fitted to the same pocket, use ActiveNet to carry out a tool status check to confirm the tool is ready for use.</p> <p><b>If a different or newly repaired cartridge is being fitted to the pocket, then continue.</b></p>	
<p><b>8</b> Before proceeding to the next step, it is important that your ActiveNet program has been updated with the latest calibration library database from the Rigibore website.</p> <p>For instructions on how to update the library, please refer to the section <b>Updating the calibration library</b> on page 4.</p>	
<p><b>9</b> The correct cartridge calibration data must be uploaded to the tool memory using ActiveNet software.</p> <p>Enter the Tool ID into the Tool Actions section.</p> <p>Press the 'Upload calibration data' button.</p>	

<p>For tools fitted with only one AE cartridge, position 1 must always be selected (this is the default selection).</p> <p><b>10</b> On tools with multiple cartridges, the correct position must be chosen.</p> <p>Position 1 is always located at the end of the tool, furthest from the shank.</p>	
<p><b>11</b> Note the cartridge serial number that is clearly etched on the cartridge body.</p>	
<p>Enter the serial number as shown and press 'Update tool'.</p> <p>ActiveNet uses the serial number to extract the correct calibration data from its internal library. It then connects to the tool and uploads the data to the tool memory.</p> <p>ActiveNet will show a new record to confirm a successful upload.</p>	

### Tools with more than one ActiveEdge cartridge

The cartridge can only access its calibration data when it is fitted to the tool pocket position entered in step 10 above. With multiple cartridge AE tools, if a cartridge is moved to a different pocket on the tool, then the procedure described from step 8 above must be repeated for the new pocket position.

## Updating the calibration library

Each AE cartridge is supplied with unique calibration data, which must be uploaded to the tool to ensure micron-accurate adjustment. The calibration data for ALL ActiveEdge cartridges is contained in one library database. The ActiveNet program uses an internal copy of the library so it can upload the calibration data for any cartridge to any tool.

Calibration data for new and repaired cartridges is immediately added to the online library, so **it is essential to download and update your ActiveNet library, particularly if a cartridge has been repaired or refurbished.**

Using obsolete or incorrect calibration data will result in inaccurate cartridge adjustment.

The library can be downloaded from the ActiveEdge technical section on the Rigibore website, or by following the link below.

<https://rigibore.com/media/activeedge/CalibrationFiles/HandyCDF.dbf>

Place the downloaded library somewhere convenient on your PC (e.g. the desktop).

Press the 'Update cartridge library' button in the top left corner of the ActiveNet window. Navigate to the library location, select the file and press 'Open'. A message will appear confirming that the library has been updated.

## Remote Control handset users

The handset has a copy of the library file 'HandyCDF.dbf' on its SD card.

The old version should be overwritten with the latest version.

Document AE043 (Remote Control User Guide) describes the process of updating the cartridge calibration data using the handset. This document can be downloaded using the link below or from the ActiveEdge technical section of the Rigibore website.

[https://rigibore.com/media/activeedge/AE043\\_Remote\\_Control\\_User\\_Guide.pdf](https://rigibore.com/media/activeedge/AE043_Remote_Control_User_Guide.pdf)

[https://rigibore.com/media/activeedge/AE043\\_Fernbedienung\\_Gebrauchsanweisung.pdf](https://rigibore.com/media/activeedge/AE043_Fernbedienung_Gebrauchsanweisung.pdf)