

CARTRIDGE REPLACEMENT

Follow the steps below when you change an ActiveEdge cartridge. It is important to adhere to the procedure so that the tool will operate correctly after a new cartridge has been installed.

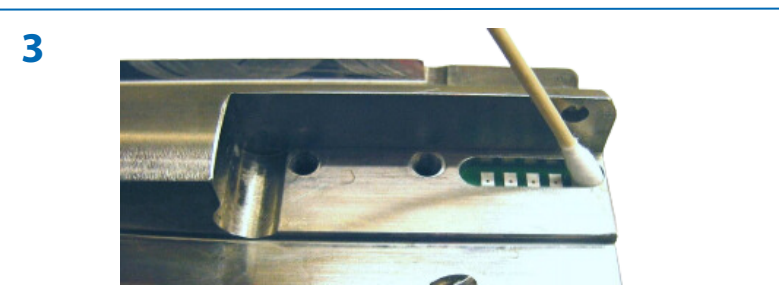


Undo the cap head attachment screw and remove the cartridge from the bar.



Carefully remove the zebra strip from the cartridge pocket.

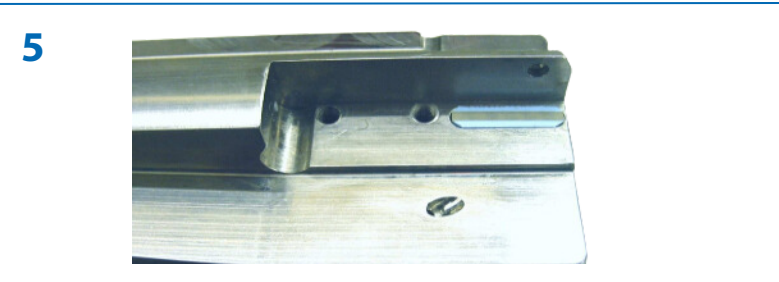
Make sure that the connector slot is clean and free from contaminants.



Inspect and clean the electrical contacts in accordance with maintenance document AE030.



If the contacts do not clean sufficiently, contact Rigibore for further advice.



Fit a new zebra strip in accordance with maintenance document AE030.



Fit the cartridge ensuring that it is firmly seated on all three qualified pocket faces.

Re-fit the attachment screw (s).

Tighten to:

5 Nm - M5 screws

3 Nm - M4 screws

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7 Perform a tool check

ActiveNet



AE-Link



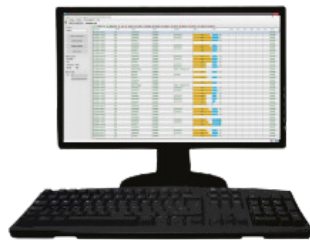
If the original cartridge has been re-fitted to the same pocket, use ActiveNet or AE-Link to carry out a tool status check to confirm that the tool is ready for use.

Please see Tool Maintenance document AE030 for further details.

If a new cartridge is being fitted to the pocket continue.

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ActiveNet

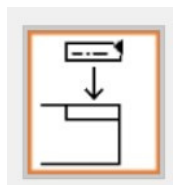


Before proceeding to the next step it is important that your ActiveNet program has been updated with the latest calibration library database from the Rigibore website.

Instructions on how to update the library follow on page 3 of this document.

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ActiveNet



'Upload calibration data'

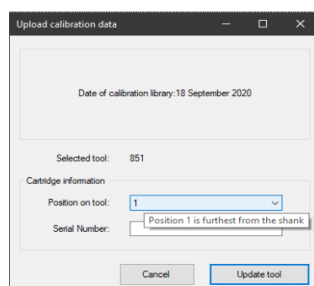
The correct cartridge calibration data must be uploaded to the tool memory using ActiveNet software.

Enter the tool ID into the Tool Actions section.

Press the 'Upload calibration data' button.

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ActiveNet



For tools fitted with only one AE cartridge, position 1 must always be selected. This is the default selection.

On tools with multiple cartridges the correct position must be chosen.

Position 1 is always located at the end of the tool furthest from the shank.

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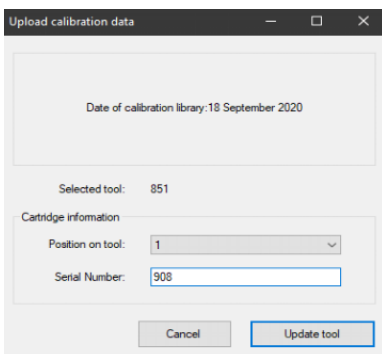
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Note the cartridge serial number that is clearly etched on the cartridge body.

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A screenshot of a software dialog box titled 'Upload calibration data'. The dialog box has a white background and a dark title bar. It contains the following information: 'Date of calibration library: 18 September 2020', 'Selected tool: 851', 'Cartridge information' section with 'Position on tool: 1' (in a dropdown menu) and 'Serial Number: 908' (in a text input field). At the bottom, there are two buttons: 'Cancel' and 'Update tool'.

Enter the serial number as shown and press 'Update tool'.

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.

ActiveNet will show a new record to confirm a successful upload.

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 the procedure in step 8 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 our 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 navigating to: <https://rigibore.com/automation/activeedge-technical-information/>

ActiveNet Software Download	TYPE: ZIP SIZE: 4.34 MB	DOWNLOAD
AE Cartridge Calibration Database	DATE: 11TH JUN 2024 TYPE: RAR SIZE: 49.60 KB	DOWNLOAD

Place the downloaded library somewhere convenient on your PC.

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.