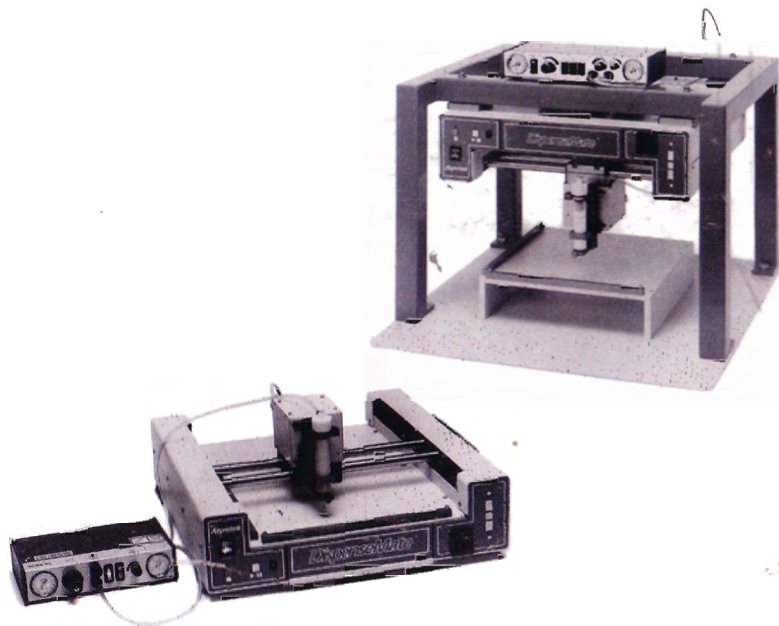
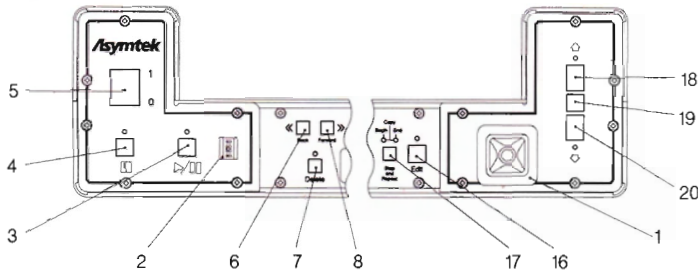


DispenseMate®

<i>DispenseMate® A-512 Specifications</i>	1
<i>Your Equipment Contents</i>	2
<i>Introduction</i>	2
<i>Using This Manual</i>	2
<i>Overview</i>	2
<i>Equipment Setup</i>	3
<i>Programming Tutorial</i>	4
<i>Step and Repeat Tutorial</i>	9
<i>Nesting Repeats</i>	11
<i>Editing Options</i>	14
<i>Boundaries of an Original</i>	16
<i>Adjustments</i>	17
<i>Programming Hints</i>	19
<i>Running a Workpiece</i>	19
<i>Fluid Dispensing Guide</i>	20
<i>Preventive Maintenance</i>	20
<i>Troubleshooting</i>	21
<i>Reordering Information</i>	22
<i>Index</i>	23





Programming SOIC Copies

1. Move the dispensing tip to the first point of the next SOIC.
2. Press the **Step and Repeat** button. The Teach done beep will sound to signal that the copy (C1 on the figure below) has been incorporated in the program at that point. Both Copy LEDs continue to blink.
3. Repeat Steps 1 and 2 for the remaining two SOICs on the top row of the worksheet. Note that each copy is labeled C1, because each is a copy of O1.

Nesting the First Row

When you finish programming the first row of SOICs on PCB 1, you can make a nest of that row and copy those nested repeats as the second row of SOICs. Proceed as follows:

1. After positioning the last copy in the first row, press the **Forward** >> **8** button *once* to exit Repeat and resume Edit mode. The tip will be at the *End* element of the last copy, C1. Both Copy LEDs will be on.
2. Press the **Step and Repeat** button **17** to mark the End

boundary of the first row. *DispenseMate* beeps, the Copy End LED lights, and the Copy Begin LED begins blinking.

3. Press and hold the **Fast** button **19** and press the <<**Back** button **6** to move to the first dot in the first SOIC, which is the *Begin* element for this original.
4. Press the **Step and Repeat** button again to mark the *Begin* boundary of the original. Now both Copy LEDs will blink to signal that you can teach a copy of the nested repeat, which

is actually a new original you have just created. This original is labeled O2 in the figure below left.

5. Move the dispensing tip to the first pad of the first SOIC in the next row.
6. Press the **Step and Repeat** button. The Teach done beep will sound to signal that the copy (C2 on the figure) has been incorporated in the program at that point. Both Copy LEDs continue to blink.
7. Press the **Forward** >> **8** button *once* to exit Repeat and resume Edit mode.

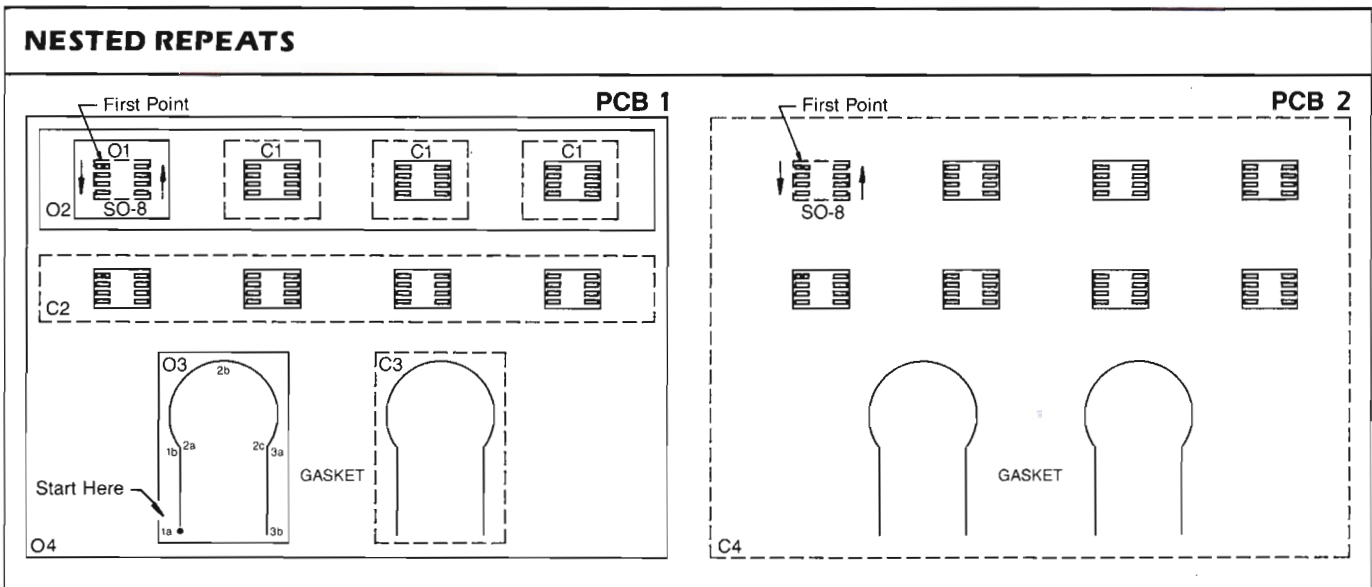
Programming the Gasket

To teach the gasket shape shown on the worksheet, refer to the figure below and proceed as follows:

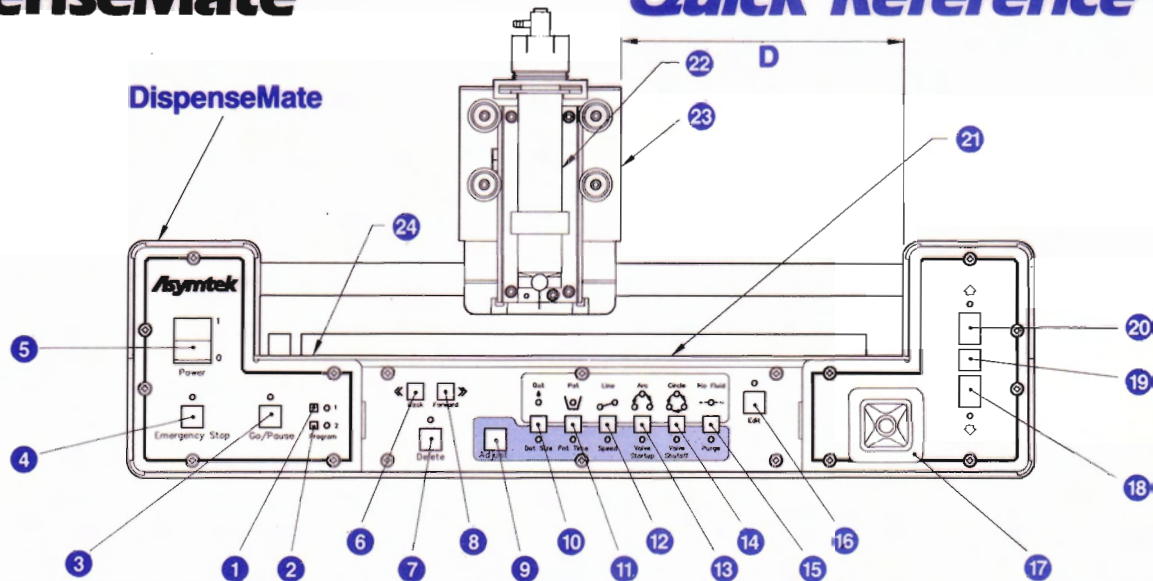
1. Move the dispensing tip to the Start point for the first line (1a on the figure).
2. Press the **Line** button **12**. *DispenseMate* beeps and the Line end (second) LED begins blinking.
3. Move the tip to the Line end point (1b on the figure) and press **Line** again. *DispenseMate* beeps and the Line Start (first) LED lights.
4. *Without moving the needle*, press the **Arc** button **13**. This joins the first line to the arc. At the same time, it marks the beginning of the arc (2a), which forms the top of the line element and the first point of the arc element. *DispenseMate* beeps and the arc midpoint (second point) LED begins blinking.
5. Move the tip to the midpoint for the arc (2b) and press **Arc** again. *DispenseMate* beeps and the Arc end (last) LED lights.
6. Move the tip to the end of the arc (2c) and press **Arc** again. *DispenseMate* beeps and the Arc start (first) LED lights.
7. *Without moving the needle*, press **Line**. Now you have

joined the arc to the second line and marked the beginning of the second line (3a). Once again, *DispenseMate* beeps and the Line end (second) LED begins blinking.

8. Move the tip to the Line end point for the third element (3b) and press **Line** again. *DispenseMate* beeps and the Line Start (first) LED lights. This completes the first gasket, which is labeled O3 in the figure.



A Nested Repeat



RUNNING A DISPENSEMATE PROGRAM

1. Set up equipment per the **Owner's Manual**.
2. Turn **Power** switch **5** on.
3. Fill syringe **22**. Fit needle & set Dispensing Control Unit's (DCU i.e. your hand held syringe dispenser) air and vacuum settings to the values you normally use.

NOTE: Be sure DCU is set to Timer Off (Steady ON).

4. Load parts on platen **21**. Fixture as required.
5. Press the desired **Program** button **1** or **2**.
6. Press the **Go/Pause** button **3**. Be ready to press **Emergency Stop** **4** if needle in danger of hitting parts. Correct problem and restart.
7. Use joystick **17** to position needle directly over reference point on part.
8. Use Up/Down arrow buttons **20** and **18** to adjust needle height. (Set height to about half the line thickness.)
NOTE: The height selected here will affect needle height throughout the program.
9. Press **Go/Pause** again. DispenseMate will immediately begin the dispensing sequence.
10. To pause the sequence momentarily, press **Go/Pause**; press again to continue. To restart from beginning press the **Program** button then press **Go/Pause**.
11. To start the same sequence over from the beginning, press **Go/Pause**.

DELETING A PROGRAM

If necessary, clear memory as follows.

1. Turn the **Power** switch **5** off.
2. While pressing the **Delete** button **7**, turn power back on. Do not release the **Delete** button until you hear a beep.
3. Press the applicable **Program** button **1** or **2** to clear selected memory, press **Delete** button **7** to clear both programs. Deletion is complete when the front panel lights stop flashing.

EDITING A PROGRAM

NOTE: If the Edit LED is not glowing steadily, review the paragraph titled Entering Edit Mode under TEACHING A PROGRAM.

1. To delete an element, use the **<<Back** **6** and **Forward** **8** **>>** buttons to move to the incorrect element and press **Delete** **7**. If desired, insert a replacement element.
2. To delete a series of elements, move to the *last* element and press **Delete** for each element. (DispenseMate always deletes the *current* element and moves to the *preceding* element.)
3. To insert a new element, move to the element before the point where you want to make the insertion. (The new element is inserted after the current one.)
4. You cannot revise or delete *Joined Elements* once you've taught them. Use the procedure in step 2 to delete the joined elements, then teach the correct sequence. (See *Joined Elements* under **TEACHING A PROGRAM**.)
5. If you make a mistake and recognize it during or immediately after teaching an element, press the **Delete** button and reteach the element correctly before teaching the next one.

ADJUSTING FLUID FLOW

Factors affecting fluid flow include material, needle size/type, and fluid pressure (set on DCU). (See **FLUID DISPENSING TIPS** in the owner's manual.) The following DispenseMate functions also affect fluid flow, and can be adjusted at any time.

Pot Time and Purge Adjust.

1. Press **Adjust** button **9**.
2. Press **Pot Time** button **11** or **Purge** button **15** for the function you want to adjust. The corresponding LED will begin blinking to signal you're in Adjust Mode.
3. Move the needle over the pot area or purge cup.
*To set **Pot Time**, press and hold the **Pot Time** button **11**. Material will flow into the potting area as long as you hold in the button. You can change dispensing height and repeat bursts up to five times to allow proper material flow.

*To set **Purge**, press and hold the **Purge** button **15**. Material will flow into the purge cup as long as you hold in the button.

Adjusting Other Functions.

1. Press **Adjust** **9**. The LED's for all adjustable functions will start blinking.
2. Press the button for the function you want to adjust. The needle moves to the Adjust location (left rear) and the corresponding LED begins to flash.
*NOTE: Now you can also press the **<<Back** **6** and **Forward** **8** **>>** buttons to quickly increment one adjustment smaller or larger on **Dot Size**, **Speed**, **Valve Startup** and **Valve Shutoff**.*
3. Using the joystick **17** and Up/Down arrow buttons **20** and **18**, adjust needle height and location as desired.
4. Place clean paper or a suitable receptacle in the area where the sample will be dispensed, then again press the button for the function you're adjusting.
5. The needle dispenses five rows increasing from left to right. The center row uses the current adjustment. Select a size as follows:
 - a. If a row matches what you want, use the **Forward** **8** **>>** or **<<Back** **6** **<<** button to move the needle there and press the button for the function you're adjusting.
 - b. If the desired size falls somewhere between two samples, use the joystick to move the needle to the corresponding point between those samples and press the button for the function you're adjusting.
 - c. If the change wasn't great enough, move the needle to the extreme (largest or smallest dot, for example) left or right. Press the button for the function you're adjusting, then repeat steps 1 thru 3.

RESETTING FLUID ADJUSTMENTS

If necessary, reset all adjustments to factory settings.

1. Turn the **Power** switch **5** off.
2. While pressing the **Delete** button **7**, turn power back on. Do not release the **Delete** button until you hear a beep.
3. Press and release **Adjust** button **9**.