

HOW TO UPDATE & RE-CALIBRATE SPT32

INTRODUCTION

Gunnar regularly release updates for SPT32 Software for download on the Gunnar Website every 6-12 months. It is worthwhile downloading these upgrades to keep your system up to date, and can also provide you with new features in the software, eliminating old “bugs” and problems.

OPERATING SYSTEM REQUIREMENTS

Please note that the more recent versions of software have been optimized to work on more recent PC's and operating systems. So if you have an older PC with Windows 98, you may need to upgrade to a newer, more powerful PC with Windows XP, in order to run the latest software for your machine.

DOWNLOADING THE SPT32 SOFTWARE FROM THE INTERNET

1. With your internet browser, locate the following website:

www.gunnar-europe.com

2. You need to login to the **Customer Area** of the website, which will require your authorised login & password, and locate the “downloads” section.
3. Download the latest version of SPT32 to your hard drive.

REGISTRATION PROCESS FOR ACCESS TO THE CUSTOMER DOWNLOADS AREA

- If you have not previously registered in the Gunnar Customer site, you will need to create a new registration. When you do this, you will need to provide some basic details to identify your business. You will also need to provide the serial number for your Gunnar machine (not the controller number), which is usually found on a silver & black sticker, underneath the front left hand corner of the table, with a number in a similar format to the following example: *46.601.643*.
- Once you have requested a registration, you will have to wait a day or so for the Gunnar website administrator to verify your registration identity. You will be informed of this by e-mail. Once this is done, you will then be able to log onto the Customer Area of the Gunnar site whenever you wish.



INSTALLING AND “UPGRADING” YOUR SOFTWARE

- Locate the downloaded file on your hard drive, and execute the **setup.exe** program.
- The Install Program comes up with a series of prompts which we have to select, as follows:

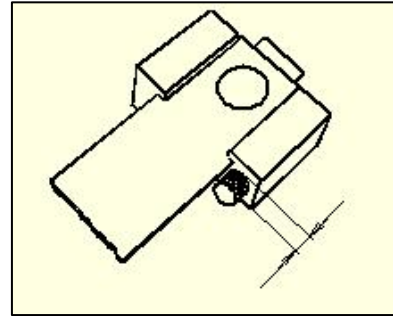
- | | |
|--|--|
| 1. Select Language | - Select “ US English ” and click on NEXT . |
| 2. Welcome | - Click on NEXT . |
| 3. Select Destination Directory | - Click on NEXT . |
| 4. Select ProgMan Group | - Click on NEXT . |
| 5. Define Machine Properties | - Select your Matcutter from the list ... keep in mind that if your machine is 40” x 60” size, then you must select the machine name with “XL” after the description. Click on NEXT . |
| 6. Ready to Install | - Click on NEXT . |
| 7. Installation Completed | - Click on NEXT . |

CHECKING YOUR CALIBRATIONS

- Please do not apply an outside cut (OC) to any of these steps.
- Always start this procedure with a **NEW BLADE**, and a **NEW SLIPMAT**.
- The areas you will need to check are listed in order, as follows -

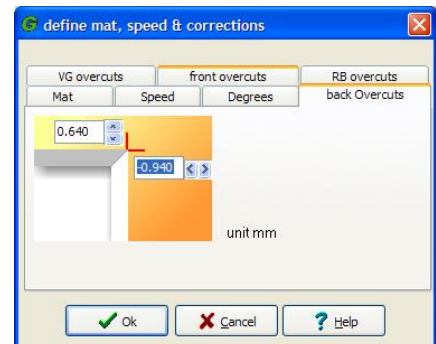
1. Blade Depth

- If you are just upgrading your software over a previous version, then theoretically you **should not have to adjust your blade depth**, as this function is not controlled by the software whatsoever.
- Your blade depth is controlled by adjusting the grub screw on the nylon blade holder.
- The recommended method for setting the ideal blade depth is to cut a small opening in a test piece of matboard, and underneath where the opening will cut, place 4 sheets of standard photocopy paper. After you cut your opening, your blade should comfortably cut all the way through the matboard and also through only 3 sheets of the paper, but not the 4th.



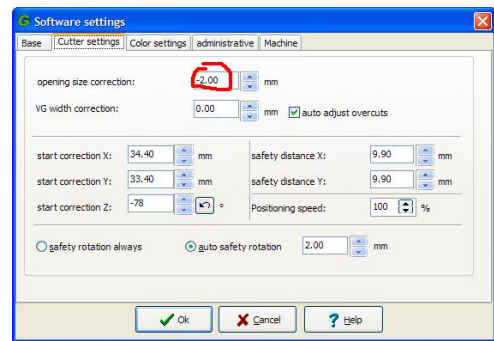
2. Overcuts & Undercuts

- From the back of a matboard, cut a small rectangular opening in a scrap, "test" piece of regular matboard, and inspect the opening for excessive overcut or undercut.
- Go to the **Settings → Cutter Settings Menu** and find the "**Back Overcuts**" option window, and re-adjust the corresponding cuts by increasing or decreasing the values as required.
- You can increase or decrease this value accordingly, using the click arrows up & down. Each click is equal to 0.1 of a millimetre.
- It is easier to calibrate the overcuts/undercuts, when you are working from an extreme "overcut" situation... and work your way back to a nice overcut from there. You may need to cut more openings into a matboard to get this tuned perfectly.
- It is best to set the overcuts for at least 0.25 – 0.5mm into the matboard, to allow for inconsistent variance in matboard thickness from manufacturing, etc.
- Repeat this procedure for "**Front Overcuts**" and "**Reverse Bevel Overcuts**"



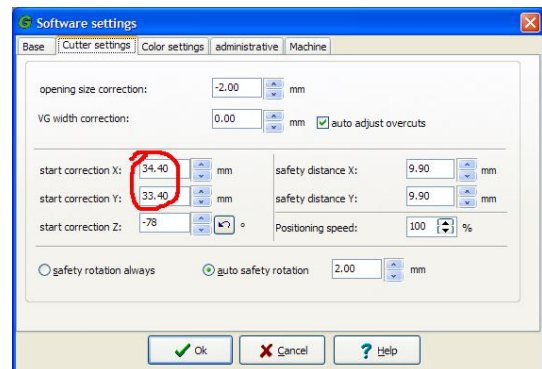
3. Opening Size Correction

- Accurately measure the last cut window from the back of the mat with a quality steel ruler, and compare the measurement with the value indicated in the software for this opening. If it is different, then you will need to make an adjustment.
- If required, you can re-calibrate the opening size for the opening, which is the “**Opening Size Correction**” value in **Settings → Software Settings → Cutter Settings**.
- You can increase or decrease this value accordingly, using the click arrows up & down. Each click is equal to 0.1 of a millimetre.
- Repeat the test cut process, and compare the measurement again to be sure you have corrected any difference.
- It is advised that you keep this setting as accurate as possible, as it can also affect the subsequent widths of your v-grooves.



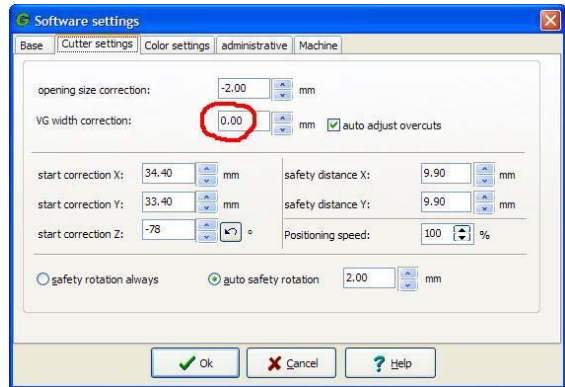
4. Margin Correction

- There are two margins to calibrate on your machine. The “left” horizontal margin (X margin) and the “bottom” vertical margin (Y margin). **It is best to do this step, one margin at a time.**
- From the back of a matboard, cut a small rectangular opening in a scrap, “test” piece of regular matboard, and inspect left horizontal margin of the cut, while the matboard is still positioned under the clamps. This is your “X Margin”
- Measure this left margin width on this test mat & compare this value to the size indicated on the screen.
- If required, re-calibrate this margins but adjusting the **Start Correction X** value, which can be found in the **Settings → Software Settings → Cutter Settings** menu.
- The separate value for the bottom vertical margin is **Start Correction Y**.
- You can increase or decrease this value accordingly, using the click arrows up & down. Each click is equal to 0.1 of a millimetre.
- Repeat the “test cut” process, one margin at a time, and compare the measurement again to be sure you have corrected any difference.
- Please note that you may find that this value adjusts the margin in a different direction to what you would naturally think. Thus repeat testing may be required.



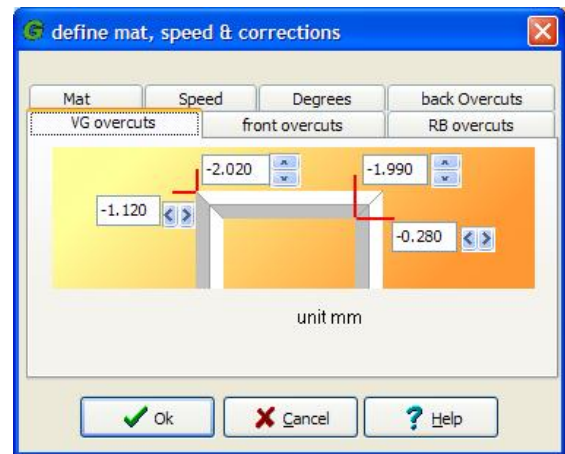
5. **V-grooves – for GUNNAR F1 / 601 / 3001 only**

- The standard width of a v-groove should be 1.4mm.
- If required, any variance in the width of the v-groove can be adjusted in the **Settings → Software Settings → Cutter Settings** by changing the value of the **VG Width Correction**. Make sure that the “auto adjust overcuts” checkbox is ticked too.



- From the front of a matboard, cut a small rectangular opening & a v-groove in a scrap, “test” piece of regular matboard, and inspect the v-groove for excessive overcuts or undercuts.

- Go to the **Settings → Cutter Settings Menu** and find the “**VG Overcuts**” option window, and re-adjust the corresponding cuts by increasing or decreasing the values as required.

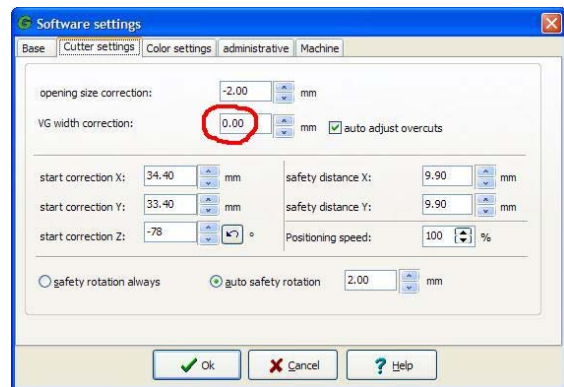


- You can increase or decrease this value accordingly, using the click arrows up & down. Each click is equal to 0.1 of a millimetre.
- It is easier to calibrate the overcuts/undercuts, when you are working from an extreme “overcut” situation... and work you way back to a nice overcut from there. You may need to cut more openings into a matboard to get this tuned perfectly.
- The ideal v-groove should comfortably fall out of the matboard in one piece.

- **V-grooves – for GUNNAR RAPIDO only**

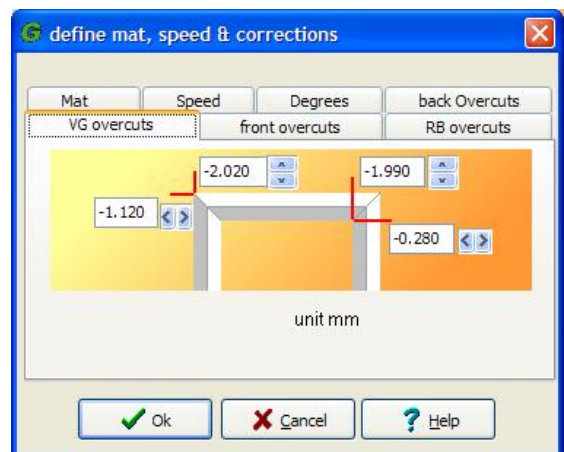
- The standard width of a v-groove should be 1.4mm.
- When you are test cutting v-grooves with the “V-Groove Only” check box (activated in the VG properties), as well as changing the blade, you also need to change the blade profile (at the bottom of the screen) from **C3 – Regular** to **C9 – V-groove**.
- Keep in mind, you may need to set the blade depth for your V-Groove Blade holder, especially if it cuts all the way through. See Step 1.

- If required, any variance in the width of the v-groove can be adjusted in the **Settings** → **Software Settings** → **Cutter Settings** by changing the value of the **VG Width Correction**. Make sure that the “auto adjust overcuts” checkbox is ticked too.



- From the front of a matboard, cut a small rectangular opening & a v-groove in a scrap, “test” piece of regular matboard, and inspect the v-groove for excessive overcuts or undercuts.

- Go to the **Settings** → **Cutter Settings Menu** and find the “**VG Overcuts**” option window, and re-adjust the corresponding cuts by increasing or decreasing the values as required.



- You can increase or decrease this value accordingly, using the click arrows up & down. Each click is equal to 0.1 of a millimetre.
- It is easier to calibrate the overcuts/undercuts, when you are working from an extreme “overcut” situation... and work your way back to a nice overcut from there. You may need to cut more openings into a matboard to get this tuned perfectly.
- The ideal v-groove should comfortably fall out of the matboard in one piece.