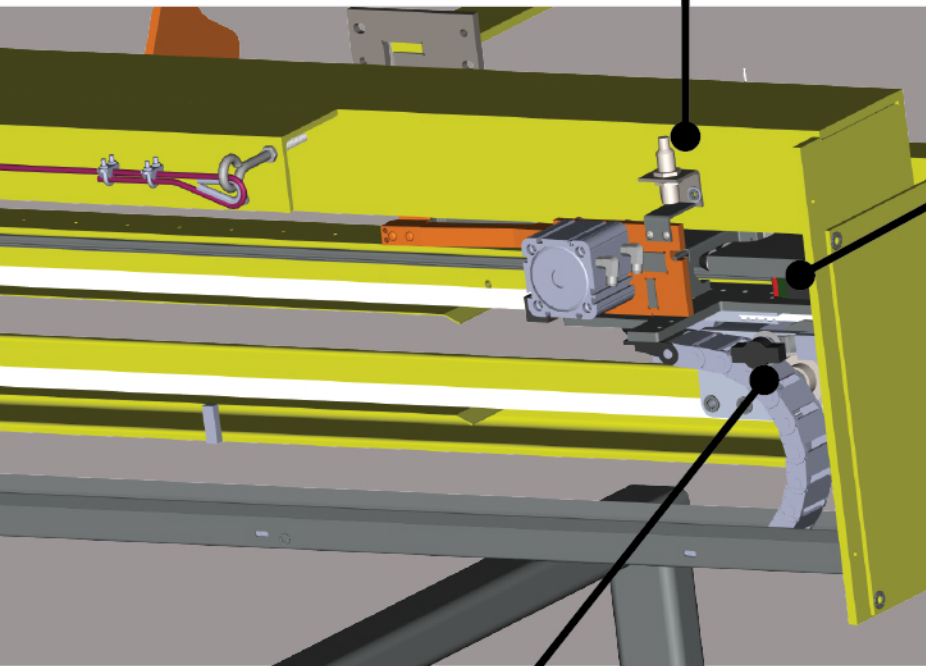


# Potential Causes of GRIPPER Slippage Error



1. Check for mechanical obstructions like wedges, damaged parts, etc. that may be inhibiting the axis from moving freely.

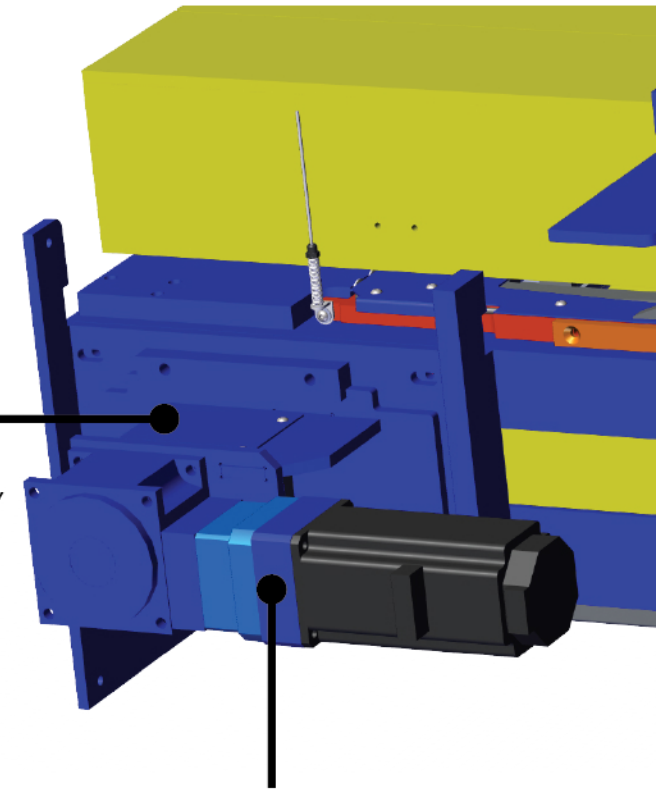
2. Check the home sensor, bracket, and target plate for damage. Should be 1/32" gap (paper folded in half should slide easily under it).



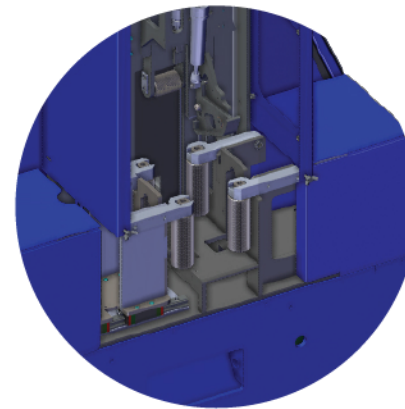
3. Check timing belt tension moves 1/4" up and down. Check pulley: teeth should not be worn and shaft should not have movement.

6. Lubricate linear guide bearings.

5. Torque Setting:  
309 in-lb  
use 4-mm hex key  
2 places



4. Tighten coupler between motor and gearbox.  
Detailed procedure is on Servo Troubleshooting web page.  
Torque Setting: 89 in-lb  
use 4-mm hex key



7. Ensure gripper nor boards are hitting the infeed side clamp rollers or printer at the saw frame.