

Notes Janome aug 16 2019

Notes: August 16, 2019

Run tests for 2 different thicknesses

make program 19 with waitTime at start of line dispense as a parameter for the function
using points program file called: File_2019Aug15.cpd

tests earlier this week:

changed lengths of lines longer line from A=8.5 to A =8

shorter line from B,C = 7 to B,C = 7.3 (to compensate for the volume dispensed)

but the levelness was better when the inner lines were shorter and A was longer (and the dark crosses in the cured samples did not disappear)

idea:

So - today make A 7.9 (to remove any overlap with araldite dots)

make B,C = 7 (again)

decrease the speed of the long line from 16 to 12

SE (G5) out at 9:38

SE is a bit lighter in color towards the top of the syringe

First keep settings from last time, A = 8, B,C =7.3

Mass test:

psi 3, waitTime: 1100

mass = 0.12g

psi 4, wait time = 900

mass = 0.15

ARALDITE CALIBRATION

x = 130.44

y = 236.92

measure:

z = 139.75

deltaZ = 140.-119.55 = 20.45

put -0.4 into point job 26

change A = 7.8, B,C = 7, wait time = 1050, both line speeds = 12

psi = 4, mass = 0.16

psi = 3, mass = 0.14

change wait time to 850:

psi = 4, mass = 0.15

samples 6,7

A = 7.5, B,C = 7, wait time = 850, both line speeds = 12

psi = 4

mass = 0.15

samples 8,9

SE4445 syringe out at 11:08

little bit of white streaking visible in the syringe.

First keep settings from last time, A = 8, B,C = 7.3, long line speed = 16, short = 12

Mass test:

psi 4, waitTime: 1100

mass = 0.15

psi 3, waitTime: 1100

mass = 0.12

A = 7.5, B,C = 7.5, wait time = 800, both line speeds = 12

psi = 3

mass = 0.12

psi = 4

mass = 0.15

ARALDITE CALIBRATION

x = 130.44

y = 236.92

measure:

z = 140.01

deltaZ = 140.01 - 119.55 = 20.45

put -0.4 into point job 26

run araldite dots at 11:47

se:

A = 7.5, B,C = 7.5, wait time = 800, both line speeds = 12

run samples 13,14

place slide on 13, first short line "broke" on dispensing SE of sample 13

run araldite dots

se:

A = 7.5, B,C = 7.3, wait time = 800, both line speeds = 12

run samples 16,17

place slide on 17

run araldite dots

se:

A = 7.5, B,C = 7.3, wait time = 800, both line speeds = 12
run samples 18,19,20
place slide on 19,20
psi level was high on sample 18 (still on araldite setting)

slide placement is a little off should come negative in x and positive in y
pick up big glass plates

AFTERNOON Session:

ARALDITE CALIBRATION

x = 130.44

y = 236.92

measure:

z = 139.725

$\Delta Z = 139.7 - 119.55 = 20.15$

put -0.1 into point job 26

Recenter the glass slide placement
move to placement center

x=147.7

y = 314.58

add 26×3 to 147 = 225.7

decide by eye better center is better at

x = 226.2

y = 314.38

$\Delta X = +0.5$

$\Delta y = -0.2$

code changed to

x = 148.2

y = 314.38

SE REMOVAL:

SE (G7) out at 2:54

Run Araldite dots

A = 7.5, B,C = 7.3, wait time = 800, both line speeds = 12

psi = 4, h20 = 7

samples 2,3

A = 7.5, B,C = 7.3, wait time = 800, both line speeds = 12

psi = 4, h20 = 7

mass test
mass = 0.17 (scale was frozen - unplugged and re-plugged)
repeat mass test = 0.16

3:27
run dots for samples 6-9
slide was out of place (y was too negative)
canceled program after slide was placed on sample 6 - no recovery possible

adjusted 7 to be more positive
y = 314.48 (+0.1)
ran samples 11-12
user error on sample 11 cause SE spill over
sample 12 slide placement still y is too negative
large air bubbles from

samples 13-14
psi = 3
wait time = 1000

Last Session
ARALDITE Calibration
x = 130.44
y = 236.92
measure:
z = 139.912
 $\Delta Z = 139.912 - 119.55 = 20.362$
put -0.4 into point job 26

SE REMOVED at 5:13pm
mass test:
A = 7.5, B,C = 7.3, both line speeds = 12
wait time = 1000, psi = 3
mass:
wait time = 800, psi = 4
mass:

NO MASS test - scale is broken

Samples 2,3
A = 7.5, B,C = 7.3, both line speeds = 12
wait time = 1000, psi = 3
stopped before araldite was complete - first dot was really small - forgot to enter the

calibration to program 26

took a long time to get started: scale didn't work, program was loaded to robot properly
araldite dot was really small on first sample

Samples 6,7,8,9

wait time = 1000,psi = 3

Samples 11,12,13,14

wait time = 800,psi = 4

broken line sample 6

semi broken line sample 8

dots wicking in sample 11

left slide in place for much longer than usual on sample 11

splotches of different color (white and dark) in the final samples

idea: could move araldite dots in to encourage SE to travel around the dot

- could spray the surface to make it cooler

Many things seemed to go wrong today:

- the scale for measuring the mass broke, and I lost time trying to fix it
- the SE mixture of the 4th syringe was bad and resulted in a flawed test
- I adjusted the glass slide placement over corrected it and lost some samples
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Things in my control that went wrong today:

- both my laptop and phone ran out of power and I was not able to take photos