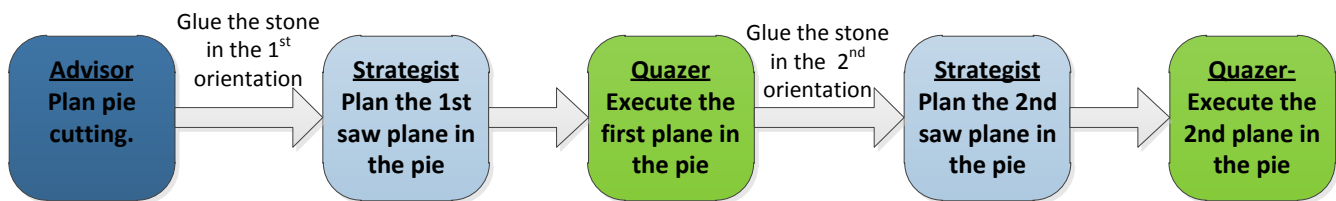# QUAZER 4.0 & STRATEGIST 2.0 NEW FEATURES OPERATION GUIDE

1. Pie cutting

In the past few years, pie cutting has become more and more common due to the high efficiency and ability to increased yield.

This planning ability existed in Advisor for a long time but till now it was very difficult to cut a pie shape and was mainly based on capability of the operator, Using Strategist 2.0 together with Quazer 4.0 allows you now easily and accurately execute pie cutting in a simple manner.
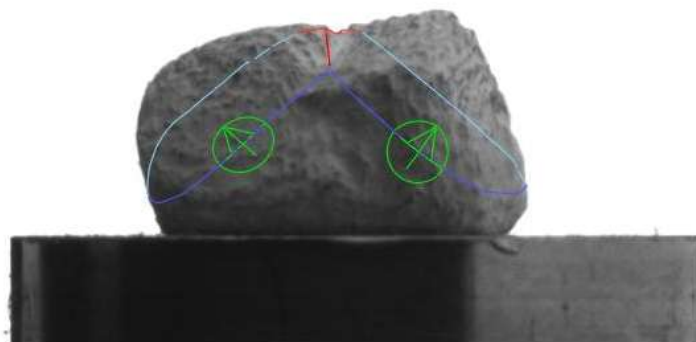
Procedure description:

I. Planning the stone in Advisor

Note: Strategist 2.0 support stones that planed on Advisor 4.7 only! Advisor 5.0 support will be provided in the next service pack.

1. Plan pie cutting stone in Advisor.

2. Go to the marking tab, select the first plane and click the [⊥] button to add a Strategist symbols on the 1st saw plane.

3. Select the 2nd plane and click the [⊥] button to add a Strategist symbols on the 2nd plane.

4. Click the [🏅] button to start burning the saw planes and the realign symbols on the stone.
5. Save Cap/Stn file.

II. Planning the sawing method in Strategist

The pie cutting is actually contains two saw planes, therefore the cutting procedure divides into two parts:

In the first stage the user has to plan and cut the first saw plane, once the first plane has been cut, the user has to repeat the same procedure in order to cut the second saw plane.

1. Glue the stone into the Strategist dop.
2. Select the Quazer target and the cassette information.

3. Click the **Load Stone** button to open the **Load Stn/cap** file window.

You can also click the button to open the **Load Stone** file window.

4. Load the Stn/Cap file planned on Advisor.

5. Click the button to start the scan.

6. Click the saw plane you would like to cut from the following table:

The selected plane will be highlighted

Instruction name	Cut method	Comment	Inscription
Pie Group			
Pie1-2			
Pie1-1			
Saw1-1			

Cutting methods:

Represent single plane.

Represent the glue twice method.

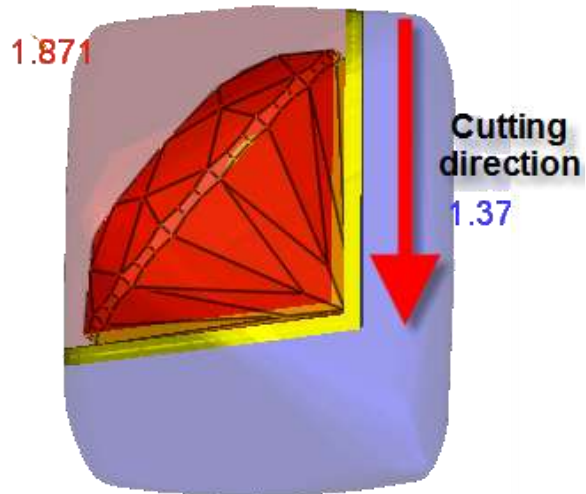To replace between the saw planes click the button.

7. Click the button and then click the arrow where it meets the saw plane.

8. Click the button to start the realignment process.
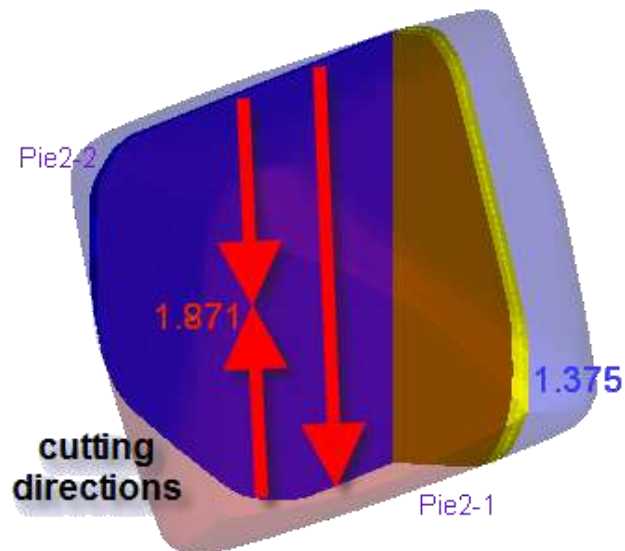
9. Select pie cutting method.
There are two methods for pie sawing:
   a. **Horizontal method** – in this method the laser sawing is starts in one of the pie plane edge and ends in the connection points of both saw planes. (See the image below)

b. **Vertical method**- in this method the cutting of the stone is done from the first pie plane edge to the second pie edge while allowing the user to perform double side sawing

Click the pie button to toggle between the cutting methods

 -Vertical method.

 - Horizontal method.

10. Set a banding layer and select banding profile.

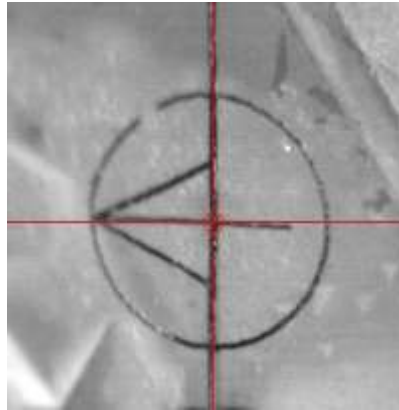11. Click the button to save the job parameters and open the cassette screen.

12. Set the dop position on the cassette click the pair button and add a new dop or pack the cassette.

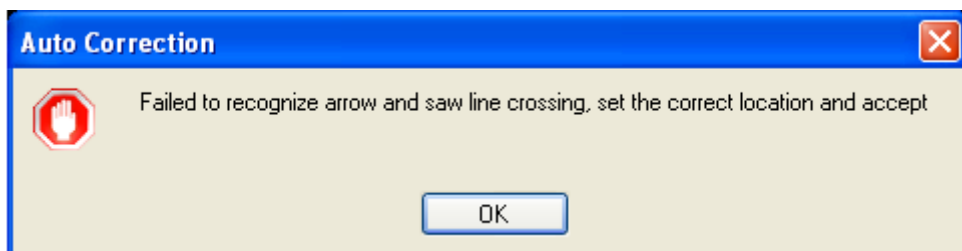## III. Executing the "job" in the Quazer

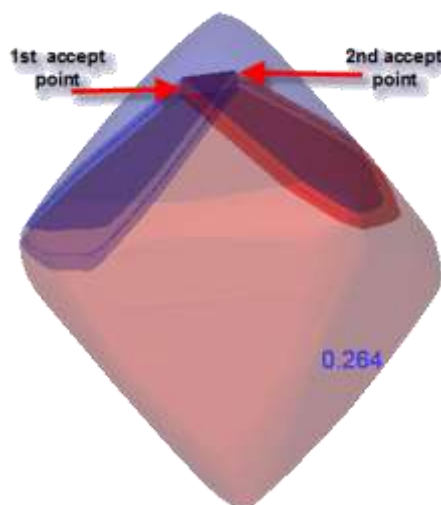1. Open the cassette type list and choose a cassette.

2. Click the button to load the pack information from the Strategist.
3. Log the cassette cross.
4. Double click on the job, the table will move automatically to the strategist arrow on the stone. Make sure the red view finder points exactly on the strategist arrow and the saw plane cross point as showed on the following image:

In case the red viewfinder doesn't points the cross or in case the following message is pop up: You will have to correct the table location manually by using X, Y and Z axes.

Auto Correction

Failed to recognize arrow and saw line crossing, set the correct location and accept

OK

5. Stone verification: the stone position has to be verified on 3 different positions:
    i. The connection point between booth saw panes (side 1)
    ii. The connection point between booth saw panes (side 2)
    iii. Log top

Once the cross position is accepted the table will move automatically to the 1st accept point

If the viewfinders cross locate exactly above the 1st pie shape connection point. Click the "Accept" button in order to continue to the 2nd verification point, if the stone location is not accurate, preform manual correction on X,Y and Z axes and then click the "Accept" button.
Repeat the same procedure for the 2nd and the 3rd verification points.

6. Click "Save & Next Dop" button.
7. Click the **Cut Verified** button.
8. Click the button to perform the selected job.
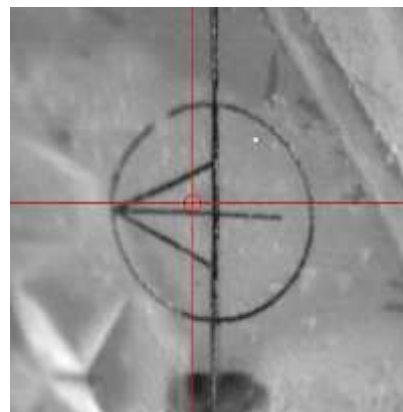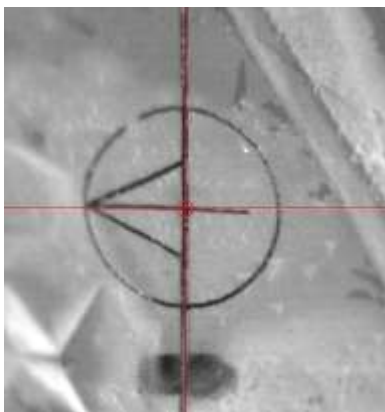
IV.   Cutting the 2nd saw plane

The procedure describes above guide you how to cut the first saw plan to complete the pie cutting process you will have to repeat the same process you did with the 1st plane.
1. Glue the stone in 2nd orientation.
2. Plan the 2nd plane in Strategist.
3. Execute the job in the Quazer.

2. Automated deviation correction

In order to insure accurate execution of strategist jobs a new automated correction feature was added to the Quazer- "Auto correction".
This feature corrects even the slightest location deviations before execution, insuring the highest correlation between the plan and the outcome.
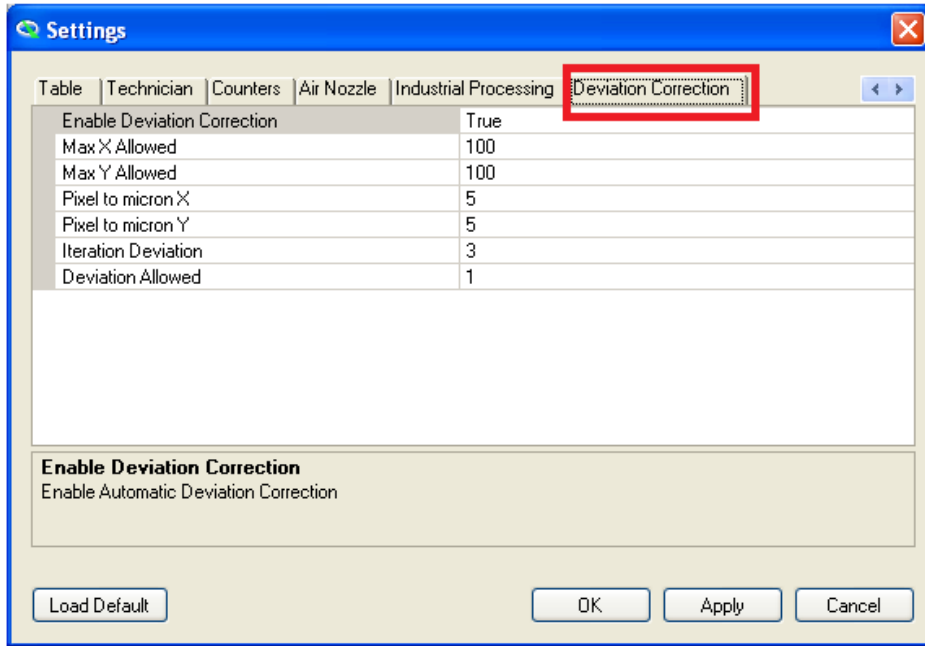

This feature is available as a default on Quazer 4.0.
A new tab was added into the setting dialog- "Deviation Correction".
Supervisor and technicians can modify those settings.
To disable this feature you should change the key: *"Enable Deviation Correction"* to False.
In order to see a description of all other keys under Deviation Correction tab just click their text.
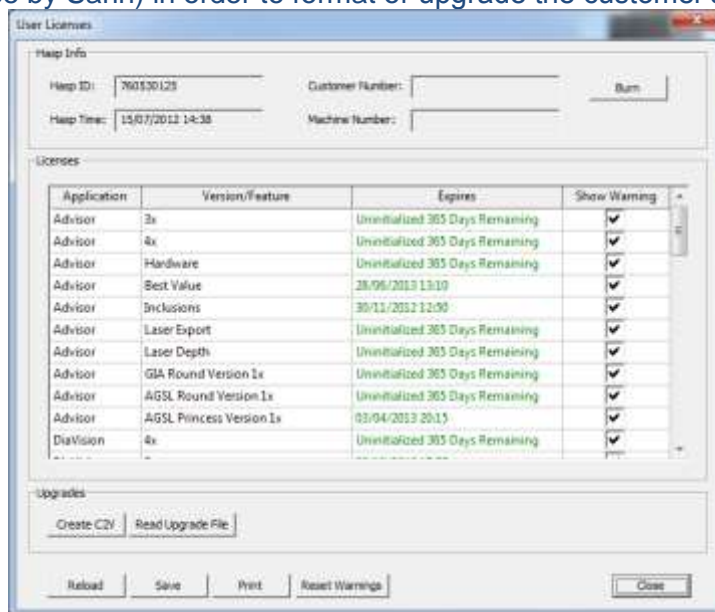
3. Hasp Show

The hasp show dialog allows the users to see a list of applications, versions and features which burned on their hasps, in addition the user can see the expiration date of each application or feature.

Show warning mechanism is notifying the user in case one of the features is about to expired.

The Hasp Show dialog also allows to create C2V files and run V2C file (small size upgrade files produce by Sarin) in order to format or upgrade the customer's

HAPS).

Show warning

This feature enables getting a warning before HASP feature is expired – time limited and executions limited, and gives you enough time to initiate the upgrade and renewal process.
In case the show warning check box is True, warning message will pops up when launching the application in case one of the feature is about to expired or already expired. (See the following image), each feature that was expired will be highlighted in red text.

Unchecking this check box will cancel the warning messages.
Clicking on the *"Reset warning"* button   will change the features: *"Show Warning"* checkbox flags to TRUE.