

Request to Change the Procedure for Recutting a Workpiece

Applicable models

All the 3000 and 6000 series models

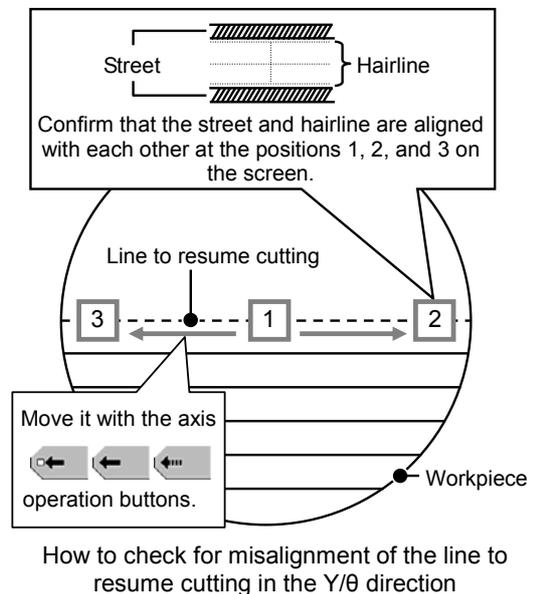
Recutting

Recutting is a function to continuously recut a workpiece half-completed and left on the chuck table, when full automation (or auto cutting) has been stopped during workpiece processing.

Details of the change in the recutting procedure

When checking the line to resume cutting, check to make sure that the line is not misaligned in the Y or θ direction while moving the microscope in the X direction to the both ends of the workpiece.
(The previous procedure was to check for only misalignment in the Y direction at around the center of the workpiece.)

New recutting procedure (overview)
The full automation (or auto cutting) resumes with the half-completed workpiece left on the chuck table.
The microscope moves to the line to resume cutting. The machine stops temporarily.
The operator checks for <u>misalignment in the Y or θ direction</u> of the line to resume cutting <u>while moving the microscope in the X direction to the both ends of the workpiece using the axis operation buttons.</u>
If the result is acceptable, execute the recutting. If the result is unacceptable, cancel the recutting.



Our Request

Manual	Reference section	Request
Operation Manual for all the 6000 series	Section 2-7-1 [Resuming Cutting after Aborting Full Automation] in Chapter B (Section 2-6-1 or 2-8-1 for a part of the models)	Change it to the procedure described in [1. Resuming Cutting after Aborting Full Automation] of this technical newsletter.
	Section 3-3-3-3 [Resuming Cutting from the Line Where Cutting Was Canceled] in Chapter B (Section 3-3-2-3 for a part of the models)	Change it to the procedure described in [2. Resuming Cutting after Aborting Auto Cutting] of this technical newsletter.
Operation Manual for all the 3000 series	None	To resume cutting, follow the procedures described in [1. Resuming Cutting after Aborting Full Automation] and [2. Resuming Cutting after Aborting Auto Cutting] of this technical newsletter.

Inquiry

If you have any questions on this matter, please contact your nearest DISCO office or DISCO service office.

1. Resuming Cutting after Aborting Full Automation

Procedure to resume cutting after aborting full automation

NOTICE

To resume the cutting operation based on the same conditions applied to the previous cutting operation that was cancelled, select the device data used for the previously canceled cutting operation

If the device data is changed, the cutting results before the cancellation and those after the resumption may vary.

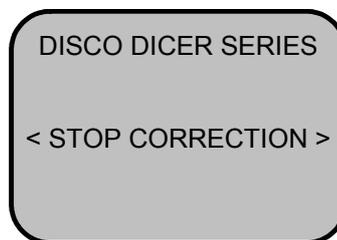
Ensure that the same workpiece used for the FULL AUTO cutting operation that was aborted is set on the chuck table.



Call up the SINGLE DEVICE FULL AUTOMATION screen [1.0] or MULTIPLE DEVICE FULL AUTOMATION screen [1.6].



Make sure that the device data No. is same as the one which was used prior to cutting suspension.



The following message is displayed:
"G1021 Press START key to restart cutting from current position."



Procedure to resume cutting after aborting full automation (Continued)



Check the screen to make sure that the line to resume cutting is displayed and the hairline and street are aligned with each other.

If the hairline and street are misaligned with each other

Cancel the recutting and full automation.

Refer to [Procedure for canceling the recutting and full automation] in the next page.



While pressing the    buttons and moving the microscope image in the X direction to the area close to the workpiece edge, check to make sure that the hairline and street are aligned with each other.

- To move the microscope image, be sure to use the    buttons. If the microscope image is directly touched and it moves in the Y direction, it becomes impossible to check misalignment of the hairline and street.

If the hairline and street are misaligned with each other

Cancel the recutting and full automation.

Refer to [Procedure for canceling the recutting and full automation] in the next page.



While pressing the    buttons and moving the microscope image in the X direction to the area close to the opposite workpiece edge, check to make sure that the hairline and street are aligned with each other.

- To move the microscope image, be sure to use the    buttons. If the microscope image is directly touched and it moves in the Y direction, it becomes impossible to check misalignment of the hairline and street.

If the hairline and street are misaligned with each other

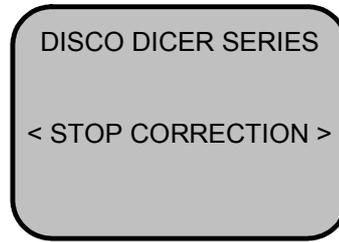
Cancel the recutting and full automation.

Refer to [Procedure for canceling the recutting and full automation] in the next page.

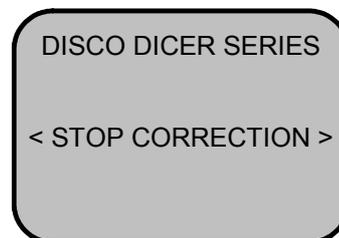
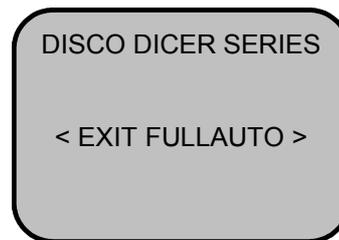


The machine will resume the cutting operation.

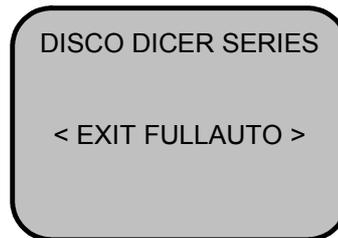
Procedure for canceling the recutting and full automation



Only for the 6000 series



Procedure for canceling the recutting and full automation (Continued)



The recutting and full automation are canceled.

For workpieces for which recutting was canceled

To recut a workpiece for which recutting was canceled, process it in semi auto cut mode.

2. Resuming Cutting after Aborting Auto Cutting

Procedure for resuming cutting after aborting auto cutting

NOTICE

To resume the cutting operation based on the same conditions applied to the previous cutting operation that was cancelled, select the device data used for the previously canceled cutting operation

If the device data is changed, the cutting results before the cancellation and those after the resumption may vary.

In order to resume cutting from the position where cutting was canceled, press

the  button

On the AUTO CUT screen [2.4] in the automatic cutting cancellation state, when the  button is pressed before the  button, the machine resumes cutting from the first line.

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2.4

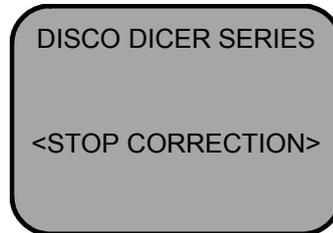
<AUTO CUT>



Confirm that the same workpiece used for the previously canceled automatic cutting operation is set on the chuck table.



Procedure for resuming cutting after aborting auto cutting (Continued)



The following message will be displayed:
"G1021 Press START key to restart cutting from current position."



Check the screen to make sure that the line to resume cutting is displayed and the hairline and street are aligned with each other.

If the hairline and street are misaligned with each other

Press the  button to cancel the recutting.



While pressing the  buttons and moving the microscope image in the X direction to the area close to the workpiece edge, check to make sure that the hairline and street are aligned with each other.

- To move the microscope image, be sure to use the  buttons. If the microscope image is directly touched and it moves in the Y direction, it becomes impossible to check misalignment of the hairline and street.

If the hairline and street are misaligned with each other

Press the  button to cancel the recutting.



Procedure for resuming cutting after aborting auto cutting (Continued)



While pressing the    buttons and moving the microscope image in the X direction to the area close to the opposite workpiece edge, check to make sure that the hairline and street are aligned with each other.

- To move the microscope image, be sure to use the    buttons. If the microscope image is directly touched and it moves in the Y direction, it becomes impossible to check misalignment of the hairline and street.

If the hairline and street are misaligned with each other

Press the  button to cancel the recutting.



The machine will resume the cutting operation.

For workpieces for which recutting was canceled

To recut a workpiece for which recutting was canceled, process it in semi auto cut mode.
