



Pre-operational	
Power On	Release all E-Stops and turn key for master enable, hold start switch until Power Generator starts
Connect RC	Clear RC M-Stop, switch on RC, press reset after boot to connect
Rail Parameters	At prompts, use paddles/joystick to adjust and press acknowledge to set rail parameters Width: Z paddle adjusts Gantry Legs and Bogies, Gantry System paddle adjusts inches Radius: Driver's side rail radius, joystick down zeros radius for straight rails, press joystick in direction of curve (right/left) to apply the proper sign, paddles (course and fine) adjust value
Position Gantry	Press enable, jog Gantry System to starting location on bridge
Tram Stops	Jog Tram left and right to validate Tram stop locations
Wire Supply	Check wire supply and reload if necessary
Set Coverage	Default is 100%, switch to 50% if desired
Op Direction	Default is forward, switch to Reverse Operations if needed
Position Tram	Jog Tram to starting location

TyBOT[®] Operation Quick Reference

ACR PN: 50-004-0001-A

Manual Home	Hold Pause 3 sec to trigger homing process, wait for complete
Effector Yaw	Jog Tie Module down and to center until effector yaw is displayed on RC, acknowledge effector yaw
Operational	
Engage Auto	Press Auto to engage auto mode (must be enabled)
Tram Direction	At prompt, use Left/Right switch to indicate go right or left
Z Force	Monitor operation to ensure Z Force is adequate (colder temperatures require higher Z Forces, toggle if necessary)
Effector Yaw	Monitor operation to ensure Tie Module is rotated optimally, frequent retries indicates adjustment may be necessary
Operator Intervention	TyBOT will request clearance to advance the Gantry System, ensure area is safe and press Proceed to confirm
Wire Resupply	RS must monitor for the out of wire condition, move Y and Z axes fully up and back, change spool, re-engage auto
QC	Monitor for missed intersections and tie manually as necessary

