

Servo Amplifier Replacement and Setup.

Equipment.

Basic Tools Only.

Purpose:

To verify correct initial setup, and zero X and Z home position readout.

Method. (Replacement).

The Servo amplifiers are located on the left side of the machine.

1. Ensure the power to the machine is OFF.
2. Remove the plug connections, and carefully remove the header. (Note the orientation of the header).
3. Remove the four fastening screws and remove the amplifier. (Note: The mounting brackets on older machines are separate, later machines use a single "tee" plate for both amplifiers, and the mounting screws are common.
4. Refit the new amplifier in reverse order.
5. Follow the setup procedure below.

Method. (Setup).

1. Turn the "feedback" potentiometer fully clockwise.
2. Turn the "balance" potentiometer seven and one half turns clockwise from fully counter clockwise.
3. Power up the machine, and home both axis.
4. Select the F6 TC/CAL screen, then select one of the tool set screens, either B, C, or D.
5. Adjust the balance potentiometer for each axis until there respective readouts are zero.

Note: the "feedback" potentiometer is next to the L.E.D. The "balance" potentiometer is next to "feedback" potentiometer.