Accurate Machine Tool Svc, Inc.

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Mills using MAX 400 Amplifiers on KM 3 / 3P - V2 mills.

Tool Requirements:
a. Voltmeter
b. Small Screwdriver

Procedure:
1. Verify all Wago connectors are seated properly and that wiring is correct prior to applying power to the Servo Amps.

2. Turn "ON" Control power and verify 115 VAC input to each servo amplifier at P3 pins 9 and 10.

3. Apply BUSS power by depressing "Manual Mode", "Power On", and "Start".

4. Verify 60 VAC input to each servo amplifier at P3 pins 6 and 7.

5. If axis accelerates toward full speed, switch off the AC power (E-Stop) and reverse the tachometer leads connected at P3 pins 1 and 2.

6. Turn the (LAG) pot CW until the motor starts to oscillate, then turn back CCW until it stops, then an additional 3 to 5 turns CCW.

7. Program positions or drill blocks that move the axis to be adjusted at 25 IPM (inches per minute). Use the (VCS) pot to obtain a reading of 0.900 VDC when connected between pins 1 and 2 of P1 on the appropriate servo amplifier. Note: CCW increases voltage.

8. Adjust (BAL) to adjust the difference between directions to a minimum. Continue in the CW direction. This should be no greater than 0.05 VDC difference. Recheck Step 8.

9. Calibrate the axis after all three servo amps have been setup and verify that the position display reads 0.0000 and that the Marker Dot is displayed. A blinking Marker Dot is OK !

Caution: Use Adjustments below only after performing above procedure and not achieving the desired results.

Presets Note: 16-Turn Pots
RMSI - (RMS Current Limit) - Full CW.
ILIM - (Internal Current Limit) - Full CW.
TACH - (Tach Gain) - Full CW.
BAL - (Balance Control) - Full CCW then 7.5 turns CW.
LAG - (Lag Control) - Full CCW.
VCS - (VCS Gain Scaling) - Full CW