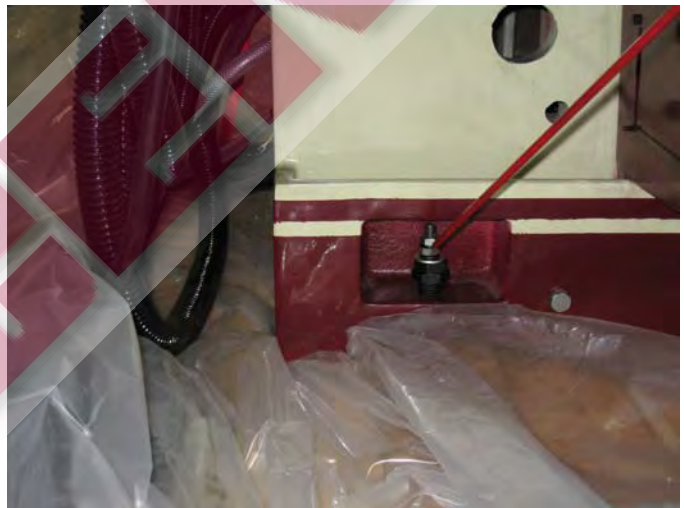


## PROCEDURE TO SET UP EMC 2240A W/ FAGOR 8055i/A-MC CONTROL

1. Connect Power Cable and Encoder Cable.



2. Set up leveling pad, screws (total 6 pieces), and leveling machine.



3. Remove the magazine supporter.

4. Remove the 3 M8 screw on the bracket on the X-axis (facing machine's right hand side) from back.



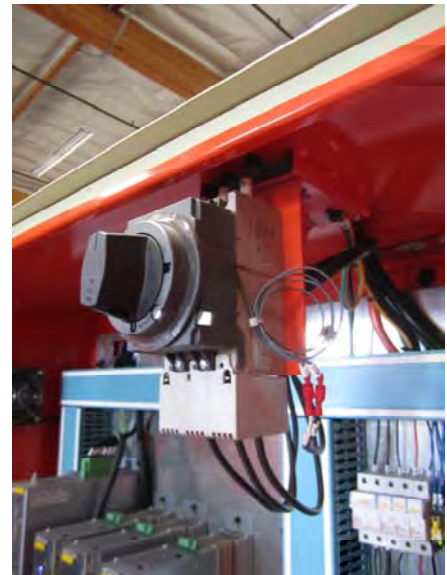
5. Remove the 4 screws on the back cover. Loose the 2 locks on both end of the double nut clamper. Twist the center to remove the clamper. Then take out the hook attached to the counter weight inside column.



6. Loose M8 Screw on control panel and turn it around.



7. Hook up power 230V or 460V as pre-wired by customer request.





8. Hook up Air, 96 PSI. Turn on machine.  
Wait 30 sec. for machine to boot up.



Release Emergency button. Press the Servo Ready On button.



Press Jog F4, select Handwheel select one thousands (10) in incremental selector. Using the MPG and Z on axes selector. Slowly move the Z up. Remove the Spindle head support. Move the Z down. The counterbalancing weight



Remove Spindle Head Support

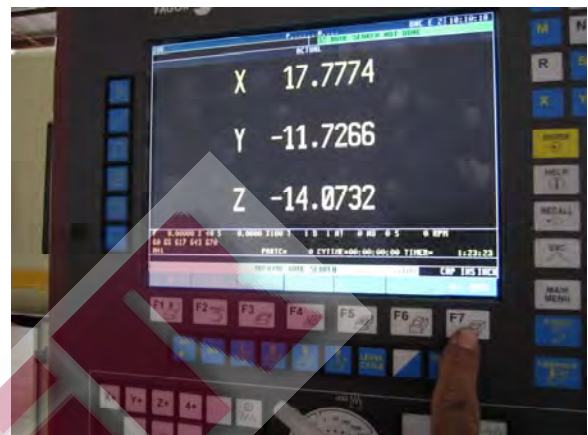


Remove Balancing Weight Supporting Bar

9. Push the magazine rotate button “CW”, make sure magazine rotates clockwise. If not, change power source direction by swapping any of the two of the three power wires.



10. Press “Reference Search” (F1), Home, then press “All Axes” (F7). Press the execute button. **IMPORTANT: Before pressing the execute button, make sure everything is clear.**



11. Assemble the coolant pipe and way cover.  
(Make sure the left & right way cover is put on the machine correctly)!

