



Springwood Industrial, Inc.
1062 N. Kraemer Place
Anaheim, CA 92806
Tel: 714-632-9701 Fax: 714-632-9730
<http://www.acergroup.com>

info@acergroup.com

Klim Industrial, Inc.
244 N. Randolphville Road
Piscataway, NJ 08854
Tel: 732-752-9100 Fax: 732-752-9101
<http://www.acergroup.com>

acer_klim@yahoo.com

PROCEDURE TO SETUP VMC 2240XL W/ ANILAM 6000i CONTROL

1. Unwrap the machine, check out machine for any physical damage. If so, report to your dealer as soon as possible. Touch-up paint is inside the toolbox. Use it as needed.

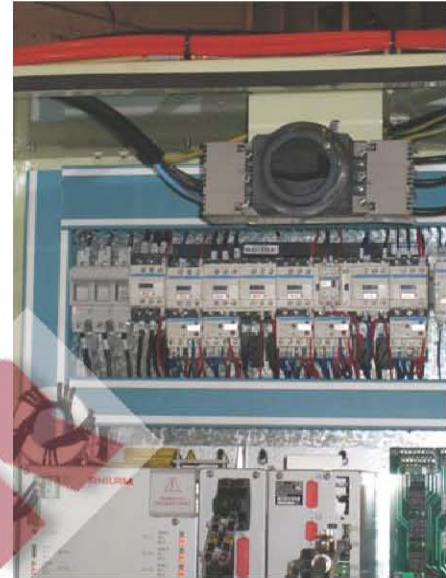


2. Loosen set screw. Swing out control panel. Take out control support, if included.

3. Remove the magazine support.



4. Check input power that will be used for the machine. Power required for our machines are: 230V three phase (3Φ) or 460V three phase (3Φ). Power must be first specified upon ordering. There is a transformer with the machine which converts power to 400V to run control.

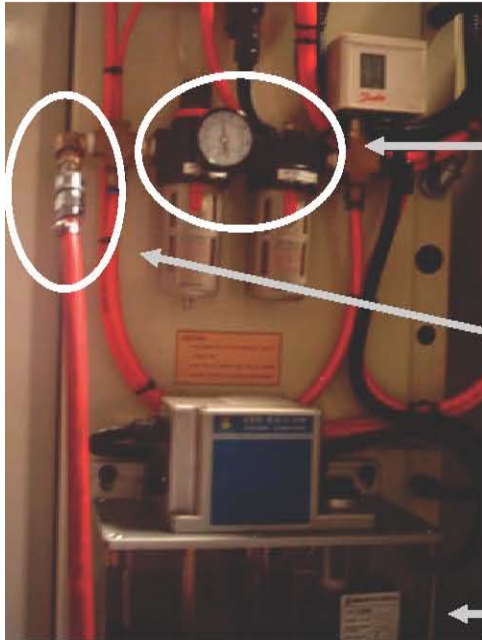


Secondary power L11, L12, L13 (400V to CNC control) **use meter check to make sure 400V**

Primary power L1, L2, L3 which can be adjusted to fit your power needs



5. Hook up air with 90 psi. This is important for ATC machine. For every ACER VMC2240XL, the air pressure would have been already adjusted. If you feel the need to increase the air pressure that goes into the machine, you can pull the knob and turn to adjust the setting. We strongly recommends for you to use the **AIR HOSE** of the size 3/8" or 1/2".



Pull knob up and turn to adjust setting. 90 psi minimum

3/8" or 1/2" air hose

Make sure oil is

6. Before powering machine, open the electric enclosing cabinet. Make sure all wires and cables are tight.

7. Release counter balancing support and spindle head support.

Step 1

Turn on machine by pushing the green power on button. Machine will start to load CNC software in about 2 minutes.



Person A, who is on the ground release emergency push button and press “SERVO RESET” and turn control function to Z, and set Feed to 10%, & jogging + sign to raise up spindle head high enough to remove the support.



Step 2

Person B, on the top of the machine, give signal to Person A to move the (spindle) Z all the way down slowly by turning jog to “feed” 10%, turning feed rate override to 10% and pressing “-” button for Z down movement until both chains catch the counter balancing weight.

Loosen 2 big screws.

* Press F4 (Home), highlight Home press green key (Execute)

In MDI mode, type command M60, press green key (Execute). Use CCW / CW to check magazine rotation.



8. Check rotation of magazine by pushing magazine counterclockwise and clockwise buttons.

If opposite direction, press Shift key then press F10 Shutdown. Press F1 Shut down to confirm. Please wait until the screen say it is ready to shut down, then press the red power off button. Switch any two power lines that go into the machine.

9. Power on. Press the green button. Push home button (F4 key), highlight Home and then press green key (Execute). This will send machine to “home” position. After machine has homed itself, jog all keys slowly and make sure they work. Please check X + and –, Y + and – and Z + and –. Also check spindle and coolant. Make sure the key-board is working.



10. Leveling the machine

Precisely leveling the machine on a solid foundation. Precise leveling of the VMC2240XL is important to the finish of the product and the tolerance of the machine. Machine level in X and Y axes has to be within .0004/12” or better.

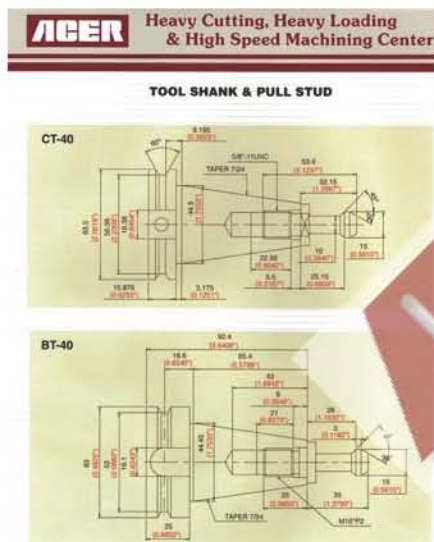
11. Warm-up spindle/ X,Y, Z movement

It is recommended that customers should warm up machine by slowly running spindle rpm under 1000 rpm and run machine with low feed rate for 15 minutes everyday before actually cutting anything.

The program can be written in the way that would help machine to “get ready” for production.

12. For auto lube pump, we recommend you to use way oil #2 or follow the manual suggestion.

13. Using the correct tool: CAT 40 or BT 40.



15. Ready to run your CNC machine: please read through the Anilam manual to familiarize all G code/ M code and programming on the control. Call Anilam support 716-661-1700 if you have any questions about the programming.

16. If you have any problems or questions, first call your dealer for quick questions and service. If dealer is unable to resolve your problem call Acer at 714-632- 9701 or Anilam at 716-661-1700 (technical support) for further assistance.