

PROCEDURE TO SET UP BEDMILL 1454

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



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



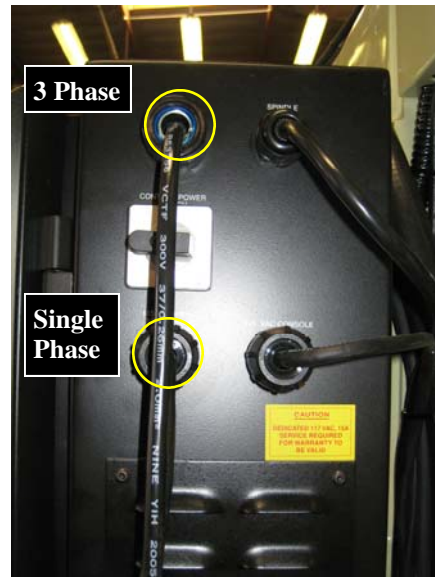
3. Remove the 4 screws on the back cover. Loose the 2 locks on both end of the double nut clamper. Twist the center to remove the clamper. Then take out the hook attached to the counter weight inside column.



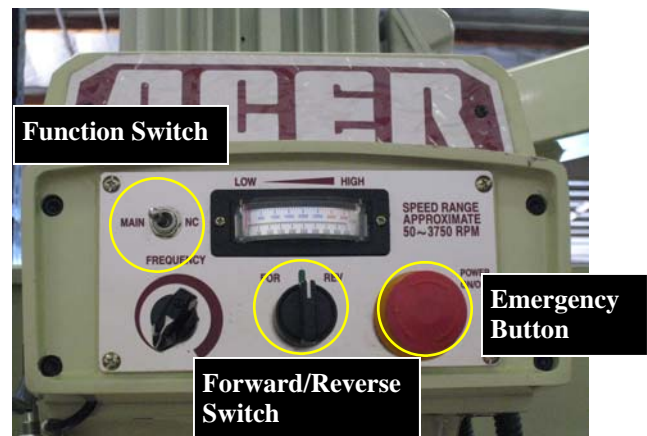
4. Install the control with 2 screws and 1 adjustable nut. Plug in 1. Start/Stop Push Button Plug 2. Hand Wheel Plug, 3. Green Key, 4. Main Control Cable Connector, and 5. 110V Power Cable.



5. Hook up 3 phase power 230V or 460V as pre-wired by customer request and 110V single phase control power source.



6. Release Emergency Stop button. Toggle function switch to “Man”. Turn on spindle Forward/Reverse Switch. Check spindle rotation.



Make sure it is correct. If opposite direction, please turn off main power by pushing emergency button. Switch any two power lines that go into the machine.

7. Turn on console power. After boot up, press “F10”. Then press “ENTER”. Release Emergency push button and push Servo Reset. (See Fig. 1 & 2) Put in feed mode (See Fig. 3) and set override to 10% (See Fig. 4). Next press “Z+” (See Fig. 5) and slowly move the Z up. Remove the spindle head support. (See Fig. 6) Move the Z down. The counterbalancing weight should be up. Remove the bar. (See Fig. 7)

Fig. 1



Fig. 2



Fig. 3



Fig. 4



Fig. 5



Fig. 6



Fig. 7



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

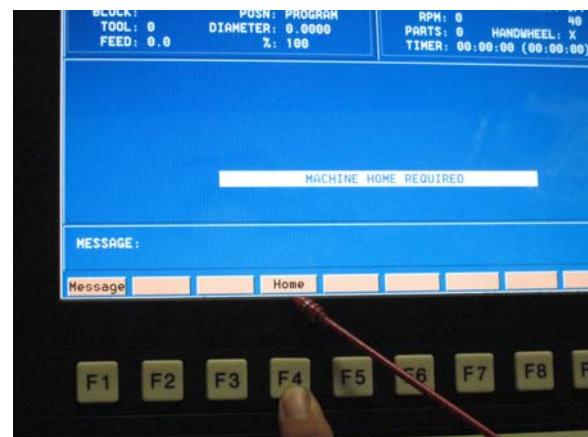


9. Press “X+” and “X-” and slowly move the X left and right to make sure X movement is ok.

10. Press “Y+” and “Y-” and slowly move the Y left and right to make sure Y movement is ok.

11. “Home” machine before running rapid mode and programming (See Fig. 8). Z move first, Y move second, X move third.

Fig. 8



12. Test MPG (Manual Pulse Generator). Turn on MPG on X. The screen “Handwhl” will activate. (See Fig. 7) Turn incremental selector x1, x10, x100 to test 0.0001”/ 0.001”/0.01” incremental move. Do as above on Y, Z movement test.

Fig. 7



13. Reset spindle and control after mechanical break for tool change or emergency stop.

1) Brake spindle. (See Fig. 8)

Fig. 8



Screen will show “Servo off !” (See Fig. 9)

Fig. 9



2) Toggle spindle Forward/Reverse Switch to neutral; then switch to forward or reverse, spindle is turning.

3) Push Emergency stop & release one time then push Servo Reset. The handwheel should lock, to function CNC mode.

14. Manual and Auto Test

Toggle Manual/Auto Switch to Manual. (See Fig. 10) Machine handwheel is free. You can move run the machine manually

Fig. 10



and use CNC display as Digital Read Out. When you go back to auto mode, follow previous step. Push Emergency stop & release one time then push Servo Reset.

The handwheel should lock, to function CNC mode.

15. Start & Stop Push Button Test

Press X hard key (See Fig. 11) Press Start then Stop, to test.

Fig. 11



16. Auto Lube Check

Please fill in the #2 Way Oil. Then turn on Servo. The Auto Lube indicator light is on. (See Fig. 12) This shows the function is ok.



17. Ready to run your Emil with Anilam Control: please read through the mill and CNC manual to familiarize yourself with all functions, features and controls.

Should you have any questions or comments, please contact your local dealer first. They will then refer you to Acer 714-632-9701 (West Coast) or 732-752-9100 (East Coast) for further assistance.