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PROCEDURE TO SETUP BED-MILL WITH FAGOR 3 AXIS CONTROL

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



3. Remove the 3 M8 screw on the bracket on the X-axis (facing machine's



4. 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.



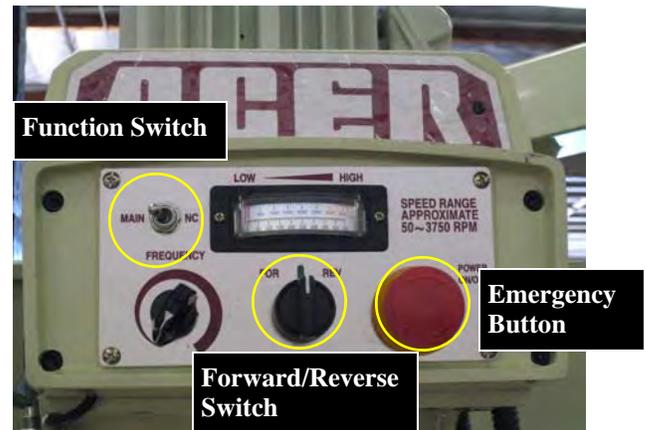
5. Take out control support. Plug in 1. Start/ Stop Push Button Plug 2. Hand Wheel Plug



6. Hook up 3 phase power 230V (only) for control power & machine power.



7. 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 spindle motor.



8. Turn on main control switch (Fig. 1). Control will take 30 seconds to boot up. (Fig. 2). “Emergency Pressed” warning signal will appear. Release Emergency Stop button. (Fig 3). Warning message will disappear. Table will engage (activate Servo power). Put in feed mode and set override to 10% (See Fig. 4). Press Jog (F4) (Fig. 5). Next, press the “Z+” and slowly move the Z up. (Fig. 6). Remove the spindle head support. (Fig. 7) Move the Z down. The counterbalancing weight should be up. Remove the bar. (Fig. 8) Next press the “X+” (table move left), “X-” (table move right), “Y+” (towards operator), and “Y-” (away from operator) keys to test (Fig 9).

Fig. 1



Fig. 2



Fig. 3



Fig. 4



Fig. 5



Fig. 6



Fig. 7



Fig. 8



Fig. 9



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



9. Make sure no obstacles are around the machine. “Home” machine before running rapid mode and programming. Press F1, Reference Search (Fig. 10). Press F7, All Axes. Then press the Execute Button (Fig. 11). Table will move. Y+ (towards operator) will move first, then X+ will move (table moves left).

Fig. 10



Fig. 11



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

1) Brake spindle. (Fig. 12)

Fig. 12



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

3) Servo motor will engage, so you can move the table in auto mode. If you do not do step 2 to reset, you won't move table in auto function.

11. Manual and Auto Test

You can move run the machine manually, (with manual pulse generator, M.P.G.) and use CNC display as Digital Read Out. When you go back to auto mode, press the “CNC” button.

12. Test Jogging

Put function select Jogging mode to 100 (Fig. 13) in jogging mode, follow picture. Press one of the four “X+”, “X-”, “Y+”, and “Y-” keys to test.

Fig. 13



13. Auto Lube Check

Please fill in the #2 Way Oil. Then turn on Servo. The Auto Lube indicator light is on. (Fig. 14) This shows the function is ok.

Fig. 14



11. Programmable RPM Testing
Put in NC Mode (Fig. 15). Press MDI (Fig. 16). Put in Speed Range in Hi Gear Range (Fig. 17).

Fig. 15



Fig. 17



Fig. 16



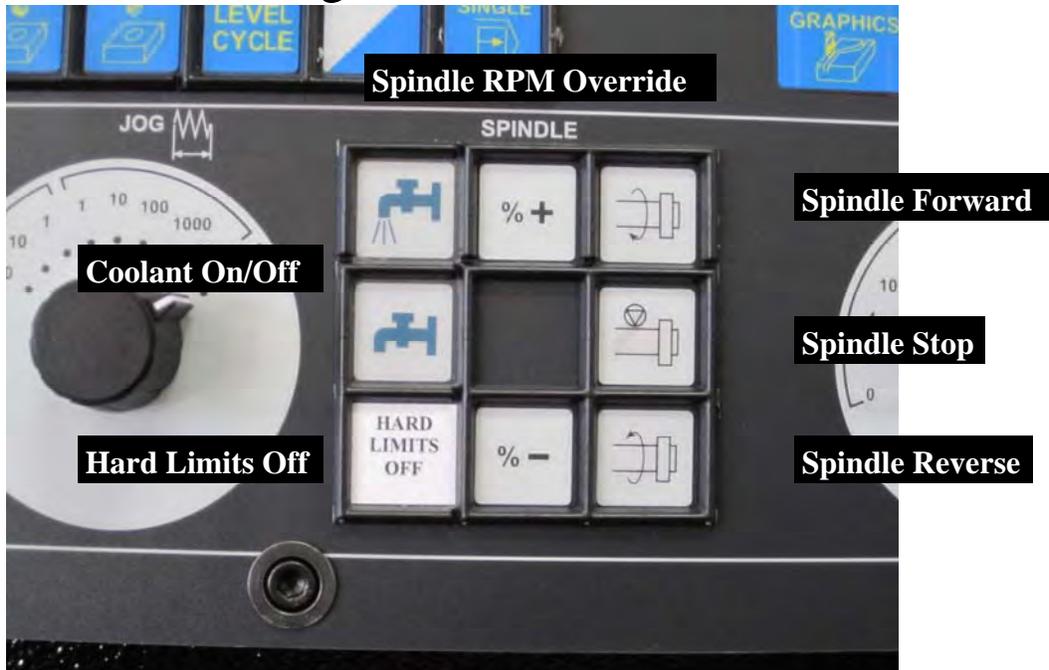
Fig. 18



Type "S1000M3". Press the Execute button (Fig. 18). Spindle start running. Then press Spindle Stop. Press Spindle Forward. Then press Spindle Stop. Press Spindle Reverse. Always press Stop before changing spindle direction. (Fig. 19).

12. Miscellaneous Functions

Fig. 19



13. Ready to run your E-mill with Fagor 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.