

## PROCEDURE TO SET UP EMC 2240A W/ ANILAM 6000i CONTROL

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



2. Remove the magazine supporter.

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



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



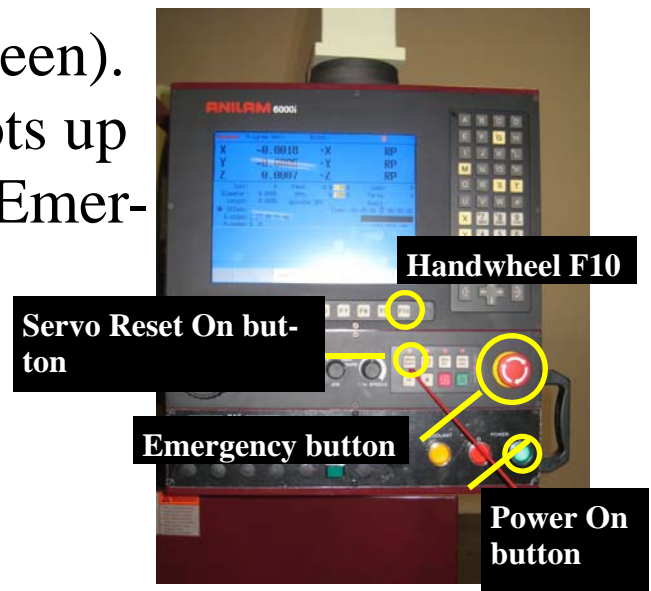
6. Hook up power 230V or 460V as pre-wired by customer request.



7. Turn on machine. Power Ready indicator light will be on (red).



Push power on button (green).  
Wait until the control boots up  
(about 40 sec.). Release Emer-  
gency button. Press the  
Servo Reset On button.  
Select Handwheel (F10).



Using the MPG and select one thousands (10)  
in incremental selector and Z on axes selector.  
Slowly move the Z up. Remove the Spindle  
head support. Move the Z down. The counter-  
balancing weight should be up. Remove the  
bar.





7. Select Home (F4) put in feed mode and set override to 10%. **IMPORTANT: Before pressing the activate button, make sure everything is clear.**



Type “M60” and push the execute (activate) button. 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.



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

