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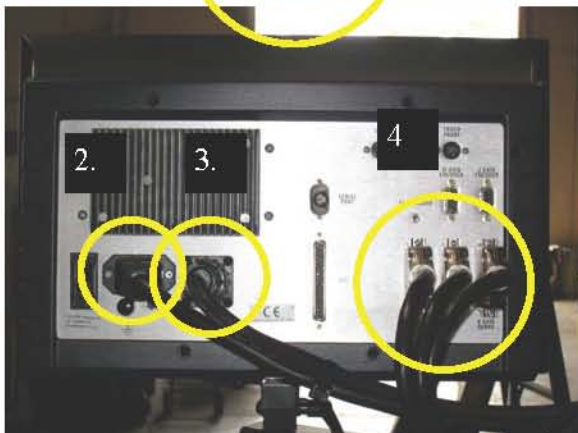
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## PROCEDURE TO SETUP EMILL WITH 3-AXIS ACU-RITE CONTROL

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.

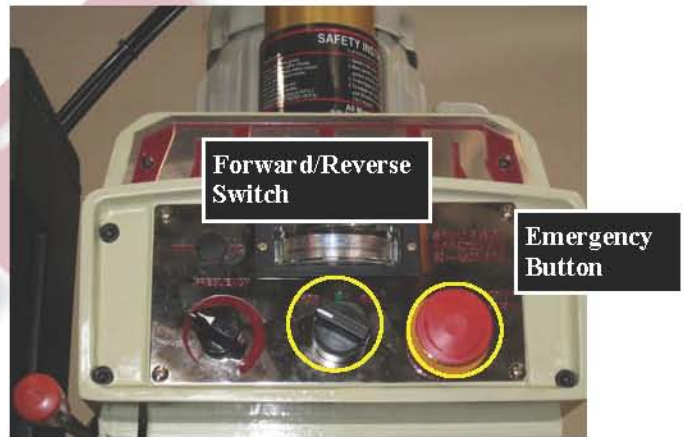
2. Install the control with 1. Lock handle and nut, 2. Power cable, 3. Servo Power Cable, 4. X, Y, & Z Servo Cable, and 5. 110V Power Cable.



3. Hook up 3 phase power 230V or 460V for machine as pre-wired by customer request.



4. Release Emergency Stop button. Check spindle rotation. Make sure it is correct. If opposite direction, please turn off main power with main breaker on your power source. Switch any two power lines that go into the machine.



5. Turn on console power.



Wait until machine boots up. Release Table Stop push button. Press Find Home. (The machine needs at least 2” of travel on all axis to find home.) (See Fig. 1 & 2) Press Move Table (See Fig. 3), press 0.1/0.01/0.001 increment and press Z Up-Down button to test jogging. Press one more time to go back to feed rate. Next press “Z Up” and “Z Down” (See Fig. 4) and slowly move the Z up and down to make sure Z movement is ok.

Fig. 1



Fig. 2



Fig. 3



Fig. 4



6. It is the same procedure to test jogging for X and Y axis.



7. Manual and Auto Test

Press “Move Table” button to cancel Auto Movement. You can run machine in Manual mode w/ D.R.O. function. Press “Move Table” button again to engage servo. You can run machine in Auto Mode.

8. Start & Stop Push Button Test

Program move and test.



## 9. Auto Lube Check

Please fill in the #2 Way Oil. Then turn power on. The Auto Lube indicator light is on. This shows the function is ok.



10. Ready to run your Emil with Acu-Rite 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.