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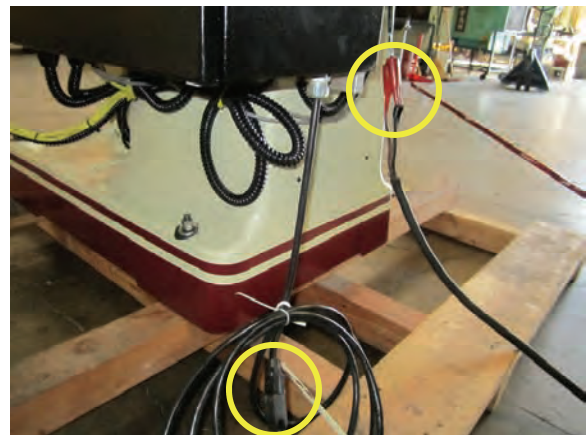
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PROCEDURE TO SETUP EMILL WITH FAGOR 2 AXIS CONTROL

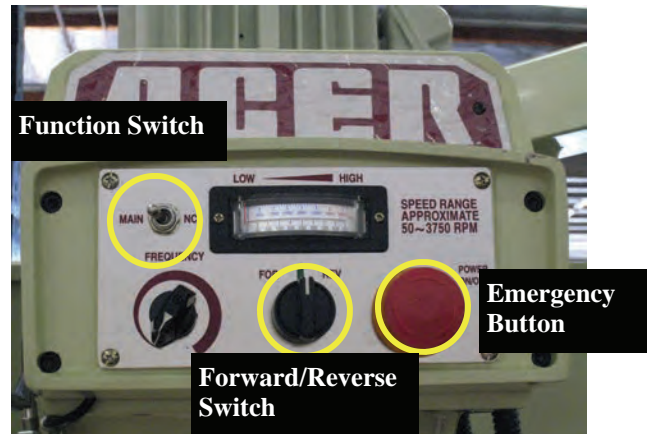
1. Unwrap the machine and check out machine for any physical damage. If so, report to your dealer as soon as possible. Touch-up paint is inside the toolbox. Use it as needed.
2. Install the control with the bolt and nut. Use cable ties to arrange the conduit control cable.



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



4. Release Emergency Stop button. Toggle function switch to “Main”. 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.

5. 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 “X+” (table move left), “X-” (table move right), “Y+” (towards operator), and “Y-” (away from operator) keys to test (Fig 6). Manually move Z up and down to make sure Z movement is ok. “DRO” message will show up on screen.

Fig. 1



Fig. 2



Fig. 3



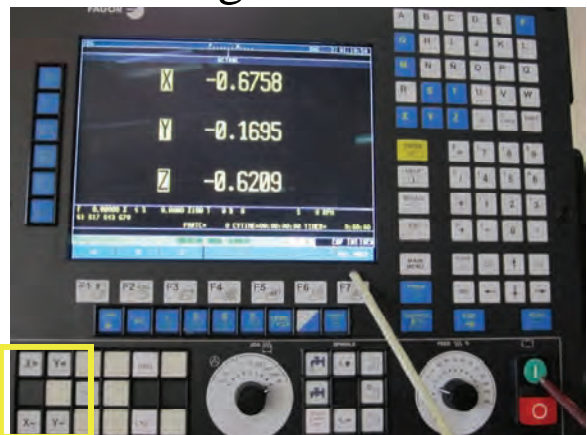
Fig. 4



Fig. 5



Fig. 6

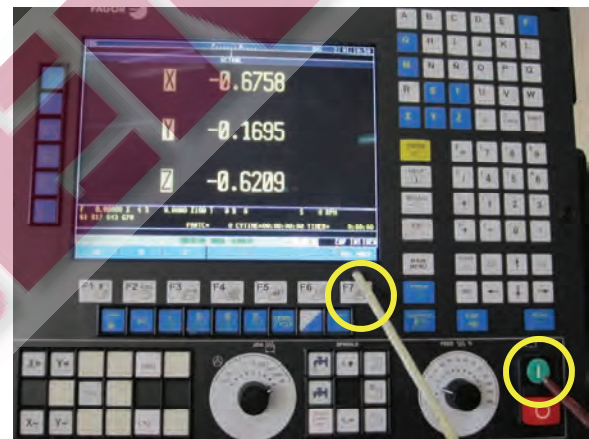


6. Make sure no obstacles are around the machine. “Home” machine before running rapid mode and programming. Press F1, Reference Search (Fig. 7). Press F7, All Axes. Then press the Execute Button (Fig. 8). Table will move. Y+ (towards operator) will move first, then X+ will move (table moves left).

Fig. 7



Fig. 8



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

1) Brake spindle. (See Fig. 9)

Fig. 9



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

3) The handwheel should lock (Servo motor on), 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.

8. Manual and Auto Test

Press the “DRO” button. Machine handwheel is free. “3 All Axes DRO” Message will show up on control display. You can move run the machine manually and use CNC display as Digital Read Out. When you go back to auto mode, press the “CNC” button.

9. Test Jogging

Put function select Jogging mode to 100 (Fig. 10) in jogging mode, follow picture. Press one of the four “X+”, “X-”, “Y+”, and “Y-” keys to test.

Fig. 10



10. Auto Lube Check

Please fill in the #2 Way Oil. Then turn on Servo. The Auto Lube indicator light is on. (See Fig. 11) This shows the function is ok.

Fig. 11



11. Programmable RPM Testing

Put in NC Mode (Fig. 12). Press MDI (Fig. 13). Put in Speed Range in Hi Gear Range (Fig. 14).

Fig. 12



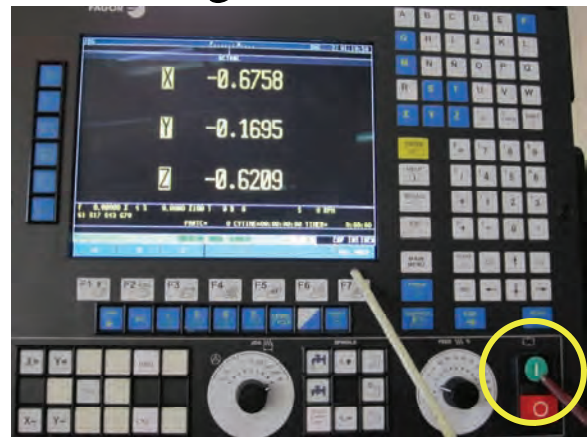
Fig. 13



Fig. 14



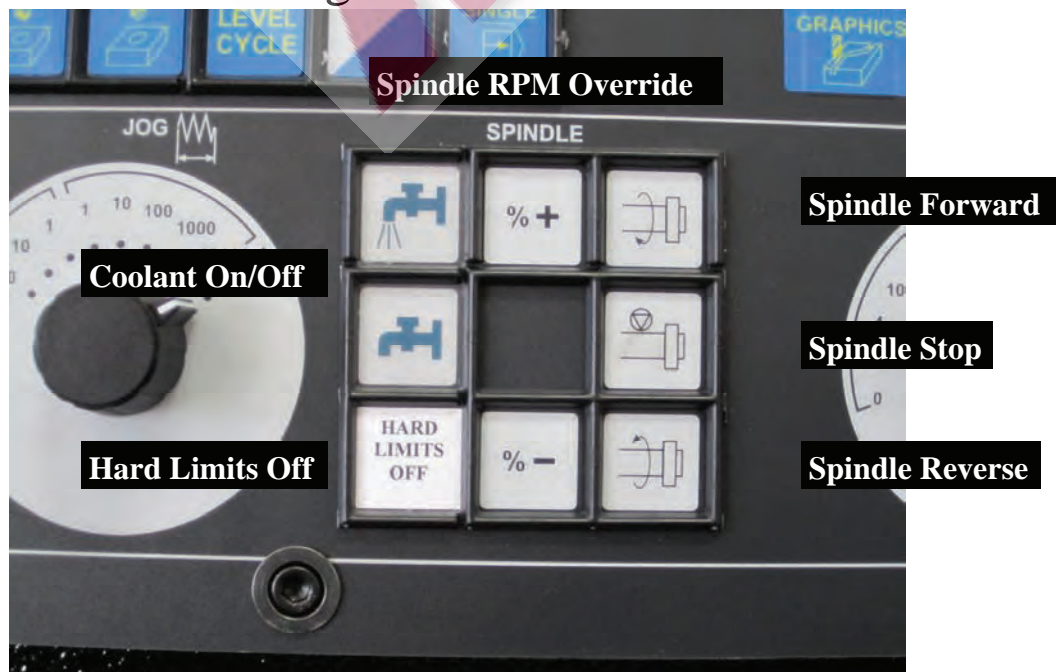
Fig. 15



Type "S1000M3". Press the Execute button (Fig. 15). 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. 16).

12. Miscellaneous Functions

Fig. 16



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.