

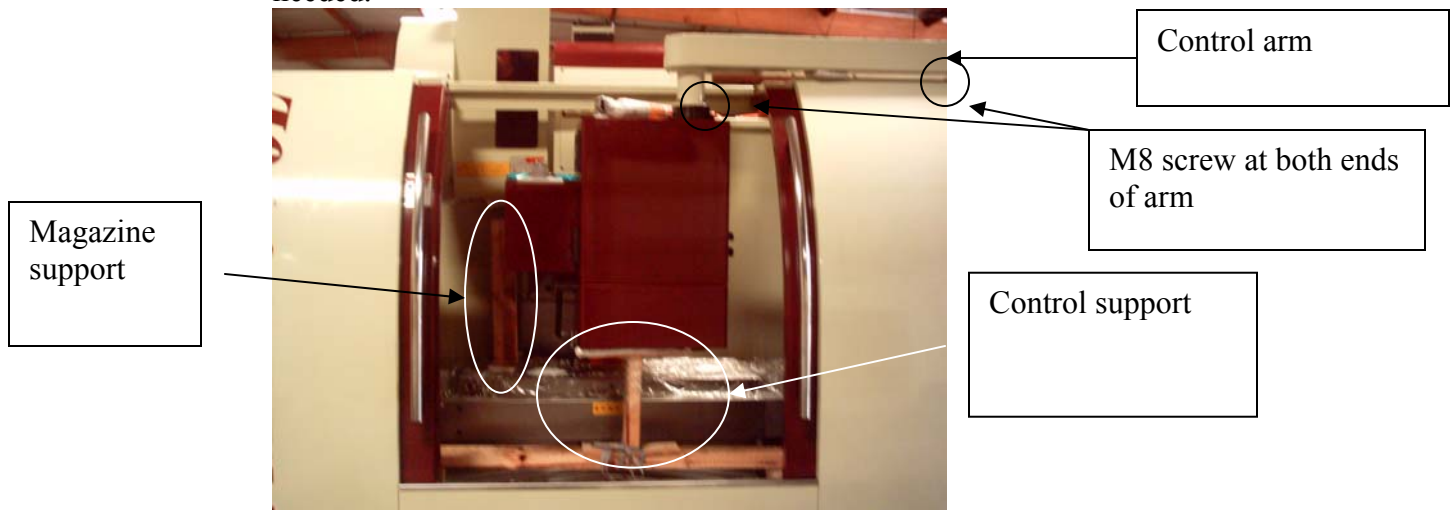
ACER Group

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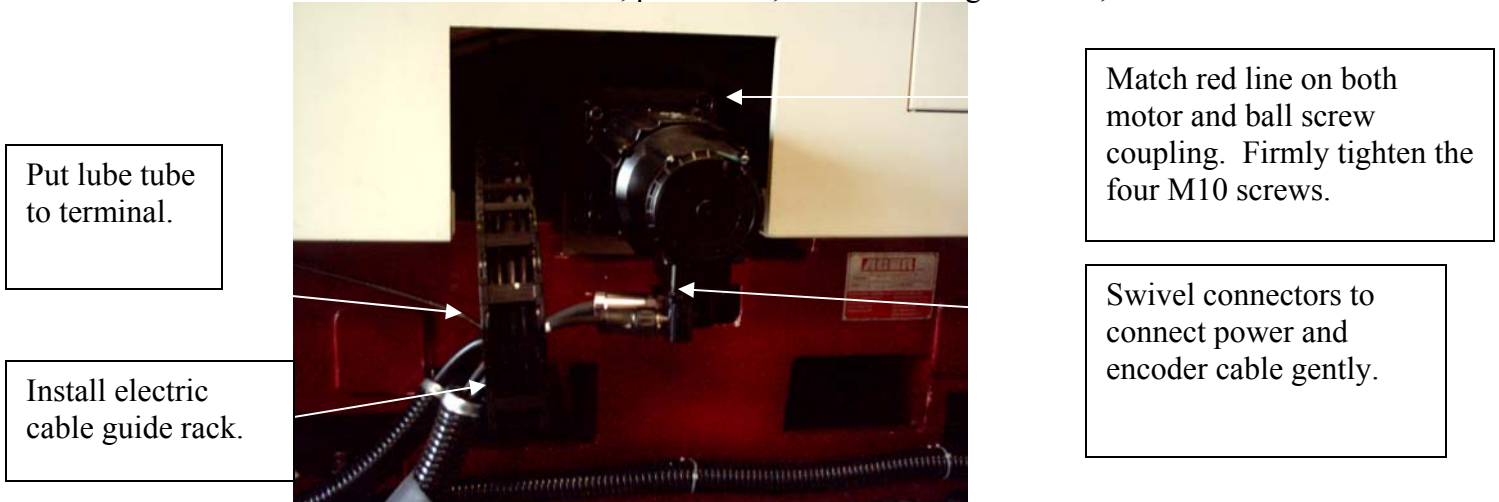
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PROCEDURE TO SET UP ACER MACHINING CENTER

1. Unwrap the machine, 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. Swing out control panel. Take out control support. Loosen M8 screw on both ends of controlling arm.
3. Remove the magazine support.
4. Install a cross-feed motor, power line, electric cable guide rack, lubrication tube.

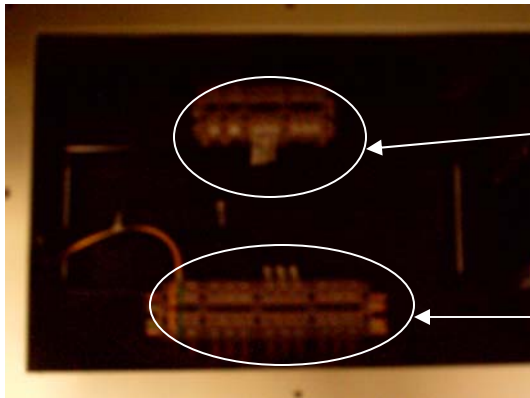


5. Check input power that will be used for the machine. Power required for our machines are: 230V three phase (3Φ) or 460V three phase (3Φ). Power must be

first specified upon ordering. There is a transformer with the machine which converts power to 400V to run control.



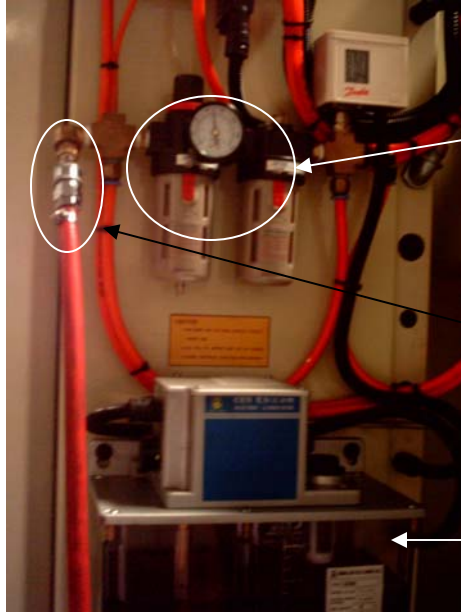
Power source L1,
L2, L3



Secondary power L11,
L12, L13 (400V to CNC
control) **use meter check
to make sure 400V**

Primary power L1, L2,
L3 which can be
adjusted to fit your
power needs

6. Hook up air with 90 psi. This is important for ATC machine. For every ACER EMC/VMC, the air pressure would have been already adjusted. If you feel the need to increase the air pressure that goes into the machine, you can pull the knob and turn to adjust the setting. We strongly recommends for you to use the **AIR HOSE** of the size 3/8" or 1/2".



Pull knob up and turn to adjust setting. 90 psi minimum

3/8" or 1/2" air hose

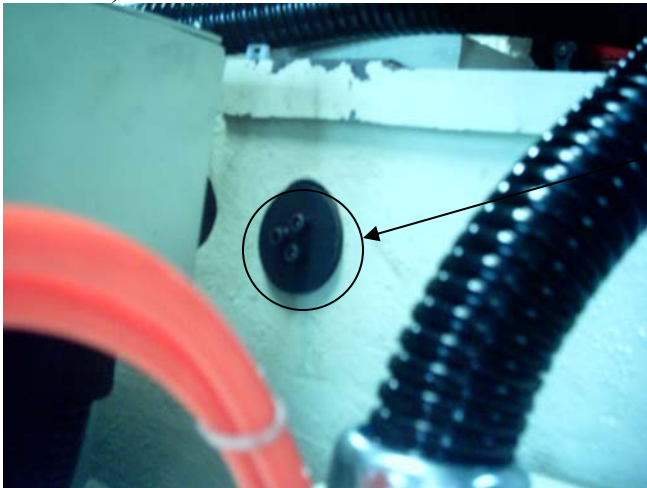
Make sure oil is full

7. Before powering machine, open the electric enclosing cabinet. Make sure all wires and cables are tight.

8. Remove counter balancing support iron bar and spindle head support.

Step 1

Remove three M6 screws and plate on counter balancing support bar (back right of machine).



Three M6 screws (on top column)

Step 2

Turn on machine by pushing the green power on button. Press enter key when screen displays “Type your password”, press enter key again. Machine will start to load CNC software (see picture 2).



Enter key

Push green button



Picture 2

Person A, who is on the ground release emergency push button and press “SERVO RESET” and move jog to 100 and direction function to Z and jogging + sign to raise up spindle head high enough to remove the support.



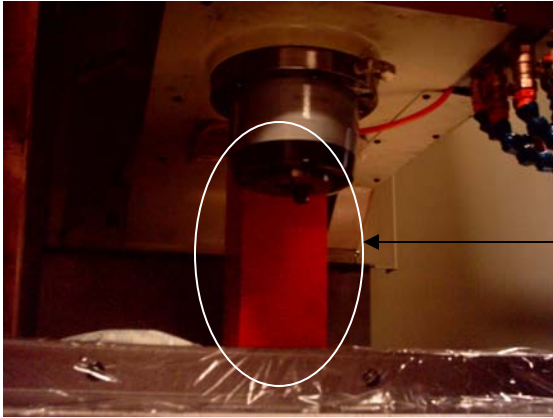
Direction = Z

Jog = 100

SERVO RESET button

Emergency button

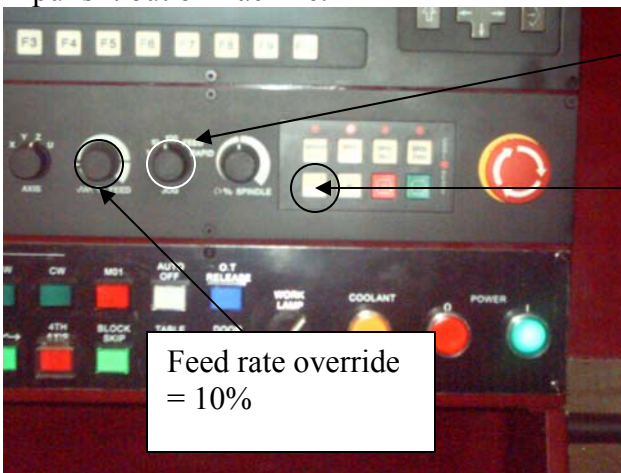
+ sign for raising up spindle



Spindle support

Step 3

Person B, on the top of the machine, give signal to Person A to move the Z down slowly by turning jog to “feed”, turning feed rate override to 10% and pressing “-“ button for Z down movement until counter balancing iron bar loosens and Person B pulls it out of machine.

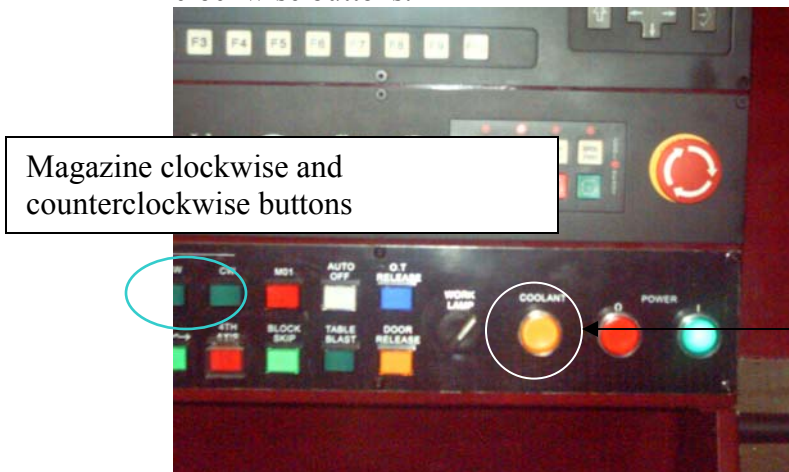


Jog = Feed

- for Z down

Feed rate override = 10%

9. Check rotation of magazine by pushing magazine counterclockwise and clockwise buttons.



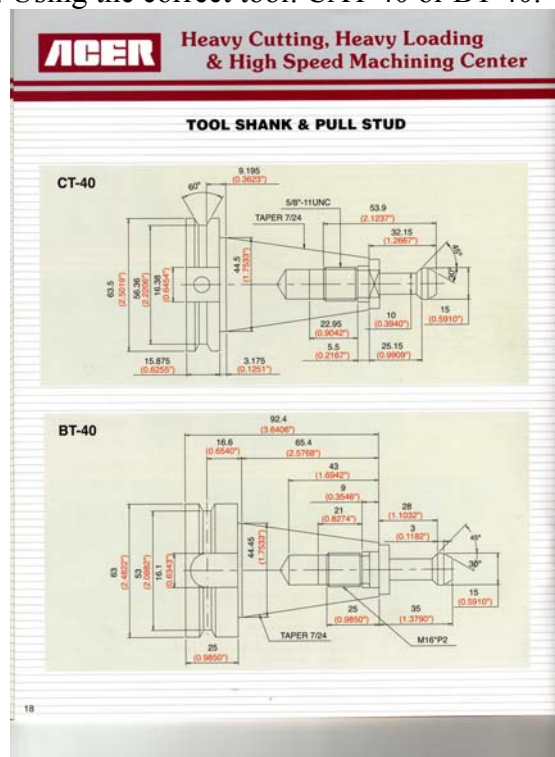
Magazine clockwise and counterclockwise buttons

Power off switch

If opposite direction, please turn off main power by pushing emergency button,

exit and pressing the red power off button. Switch any two power lines that go into the machine.

10. Power on. Press enter key twice, push home button (F key). This will send machine to “home” position. After machine has homed itself, jog all keys and make sure they work. Please check X + and –, Y + and – and Z + and –. Also check spindle and coolant. Make sure the keyboard is working.
11. Leveling the machine
Precisely leveling the machine on a solid foundation. Precise leveling of the EMC/VMC is important to the finish of the product and the tolerance of the machine. Machine level in X and Y axes has to be within .0004/12” or better.
12. Warm-up spindle/ X,Y, Z movement
It is recommended that customers should warm up machine by slowly running spindle rpm under 1000 rpm and run machine with low feed rate for 15 minutes everyday before actually cutting anything.
The program can be written in the way that would help machine to “get ready” for production.
13. For auto lube pump, we recommend you to use way oil #2 or follow the manual suggestion.
14. Using the correct tool: CAT 40 or BT 40.



15. Ready to run your CNC machine: please read through the Anilam manual to familiarize all G code/ M code and programming on the control. Call Anilam support 716-661-1700 if you have any questions about the programming.
16. If you have any problems or questions, first call your dealer for quick questions and service. If dealer is unable to resolve your problem call Acer at 714-632-9701 or Anilam at 716-661-1700 (technical support) for further assistance.