

TECH BULLETIN

R-026

2/10/92

Subject: MICRON SWITCH INSTALLATION

When installing a Micron switch on the R machines with the PC control, please refer to these instructions:

- 1) Loosen the four (4) M10 x 30mm SHCS from the bracket that holds the Micron unit. Slide the belt off the Micron pulley.
- 2) Remove the four (4) M5 x 16mm SHCS from the Micron switch pulley and remove the pulley. Remove the Canon plug from the Micron unit.
- 3) Remove the four (4) bolts that hold the Micron switch to it's bracket, remove the Micron unit.
- 4) Install the new Micron unit Part # 802029-000 and snug the four (4) bolts just enough to hold the unit in place. Connect the Canon plug to the Micron. Install the pulley, locking elements and the pressure plate verifying to keep the pulley level with the pulley on the jack shaft. Torque the four (4) M5 x 16mm SHCS to 31 in lbs [3.5Nm]. Adjust the bracket that holds the Micron unit so the timing belt at it's mid-way point has a deflection of 0.14 inch [3.56mm] at 0.35 lb. Tighten the four (4) M10 x 30mm SHCS that hold the bracket to the frame.
- 5) Turn on the control and while watching the "C" axis coupling, reference just the "C" axis. You will notice that the coupling will rotate first in the CCW* direction then CW then CCW lastly CW*. If the Micron is set correctly this process will take but a few seconds. If the axis seems to search and take a long time to reference, the Micron will have to be rotated to find the zero window.
- 6) Place a mark on the bracket by the coupling itself to note the position of the coupling. Rotate the Micron in either direction approx. 1/4 turn. Reference the "C" axis again, if it references ok now, place a pencil mark (1) on the Micron can and a corresponding mark on the bracket (see drawing). Rotate the Micron in steps in the same direction less then a 1/4 turn while again referencing just the "C" axis until it no longer references correctly. The mark you made on the bracket by the coupling will now be off. Place a pencil mark (2) on the Micron can at that point (see drawing). The limit in that direction is now known.

7) Rotate the Micron to its original working position, denoted by your first mark (1) and reference the "C" axis. Rotate the Micron in steps in the opposite direction less than a 1/4 turn while again referencing just the "C" axis until it no longer references correctly. The mark you made on the bracket by the coupling will now be off. Place a pencil mark (3) on the Micron can at that point. The limit in that direction is now known.

8) There are three (3) windows on the Micron, each 120 deg. apart. Verify the coupling is still in the same position as when you started.

9) Rotate the Micron switch mid-way between the two outside marks (2 & 3) and that will put the "C" axis home in the middle of the window.

*CCW = Counter Clockwise

**CW = Clockwise

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