

Setting Auto Index Micron Switch (CNC 2680)

When replacing or reinstalling switch this procedure is essential

WARNING THIS PROCEDURE REQUIRES OPENING THE MACHINE MAIN DISCONNECT AND REESTABLISHING POWER. PROPER CARE MUST BE EXERCISED TO AVOID SHOCK. THIS ADJUSTMENT ALSO REQUIRES A CLOSE PROXIMITY TO MOVING PARTS. IF YOU ARE UNCOMFORTABLE WITH ANY PORTION OF THIS PROCEDURE STOP AND CALL A QUALIFIED TECHNICIAN.

- Install MICRON unit pulley leaving hardware loose
- Install MICRON UNIT leaving the bolts slightly loose to allow you to turn the can
- Inspect belt for damage replace if it is damaged (CNC 2670)
- Visually check height of pulley comparing it to the motor couple to insure it is relatively level
- Tighten 4 SHCS on top of the pulley being careful not to strip threads on the aluminum retainer
- Install belt by rotating into place
- Turn machine on and reference Turret watching the direction the belt turns on the can
- Connect Multimeter set to read 24-30 VDC, RED to TB1-25 for upper auto index, or TB1-26 for lower, then connect the black lead to one of the terminals marked LVR. You should read 24-30 VDC at this time
- Press ESTOP on control
- Rotate pulley on can in a direction OPPOSITE the direction noted while referencing while observing meter, stop when the meter indicates 0 volts
- Rotate pulley very slowly in opposite direction until meter reads 24-30 volts again.
- This point is considered the null point of the switch
- At the control press DGNS button on keypad
- Type N802 IINPUT
- Observe the number in diagnostic 802, for the upper unit, and 803 for the lower
- This number should be 3000 +- 200 counts.
- If the number is lower than 3000 then turn the can (not the pulley) in the opposite direction from reference
- If the number is higher than 3000 then turn the can in the same direction as reference.
- Recheck by turning PULLEY in referencing direction until the meter again reads 24-30 volts, then opposite direction until it just goes back to 0. Then turn back until you see it go back to 24-30 VDC. Recheck the diagnostic. Repeat until you get it to 3000 counts +- 200.
- Tighten all hardware.
- Reference the machine and check each AI station visually for alignment. If they are aligned all is good. Use station belts to realign top to bottom. Eyeball should be close enough. Engage the motor in each station to fine tune the alignment.
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