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HURCO FET AMPLIFIER SETUP

Mills using Hurco "FET" Servo Amplifier. (Part No. 415-0157)

Tool Requirements:

a. Voltmeter
b. Small Screwdriver

Move the current limit switch on the logic board down to the 5 - ampere position, turn the (RESPONSE) control CW until the motor oscillates. Then turn the (RESPONSE) control CCW until the oscillation stops. After motor oscillation stops, turn the (RESPONSE) control approximately five more turns CCW.

Move the current limit switch back up to its normal position.

Connect a DVM across the DAC command signal. On Servo Control Board, Connectors J2 (X), J3 (Y), and J4 (Z), Connect meter to Pins 8 and 9 for axis to be adjusted.

With the servos on, adjust the (BALANCE) to produce a zero reading on the DVM (+/- .009vdc). Leave the DVM connected across the DAC signal to adjust the (SIGNAL) control:

(B control) - with the axis running at a feed rate of 25 IPM, adjust the (SIGNAL) control to produce a **.9 vdc** (+/- 10%) reading on the DVM.

(BX control) - with the axis running at a feed rate of 25 IPM, adjust the (SIGNAL) control to produce a **.65 vdc** (+/- 10%) reading on the DVM.

(ULTIMAX Control) - with the axis running at a feed rate of 40 IPM, adjust the (SIGNAL) control to produce a **.9 vdc** (+/- 10%) reading on the DVM.

Tool Calibrate, Table Zero. Ensure the screen axis reading is 0.0000 (+/- .0001).