

3WL0088 SPEED CALIBRATION INSTRUCTION

NOTE: This procedure is dangerous as it involves high voltage that can kill. The procedure must only be carried out by a **qualified electrician or service engineer**.

Once the replacement board, located at the back of the electrical enclosure has been fitted to the machine (Fig.1) the high and low speed limit settings need to be re-calibrated.

Setting the Lower Limit

1. Ensure there is no work piece or chuck in the spindle.
2. Set up the belt in the lower speed position.
3. With the speed setting dial (Fig.1) set to the slowest position, start the machine and make a note of the speed on the display. It should be 450rpm +/- 20 rpm. If it is within spec, then move to step 6 if not follow steps below
4. DISCONNECT THE MACHINE FROM THE POWER SUPPLY
5. Adjust the Low Limit Potentiometer by rotating the dial clockwise to lower the speed or counter clockwise to increase. (Fig.2)
6. Reconnect the power to the machine and check the speed, if the correct speed has not been set repeat steps 3, 4 and 5 until correct speed has been set.

Setting the Upper Limit

1. With the speed setting dial set (Fig.1) to the slowest position start the machine and slowly increase the speed until the dial is at the highest point and make a note of the speed on the display. It should be 1800rpm +/- 50 rpm. If it is within spec, then the machine is all good to go if not then follow steps below
2. DISCONNECT THE MACHINE FROM THE POWER SUPPLY
3. Adjust the High Limit Potentiometer by rotating the dial clockwise to lower the speed or counter clockwise to increase. (Fig.3)
4. Reconnect the power to the machine and check the speed, if the correct speed has not been set repeat steps 1, 2 and 3 until correct speed has been set.



FIG. 1

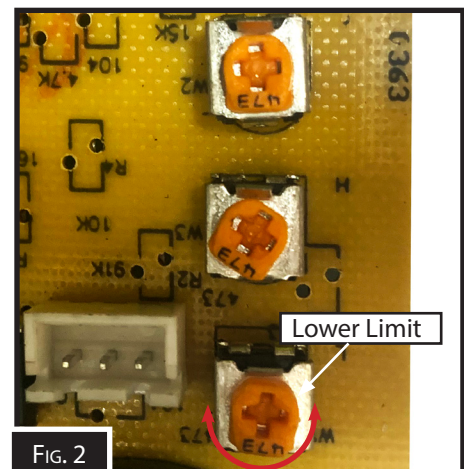


FIG. 2

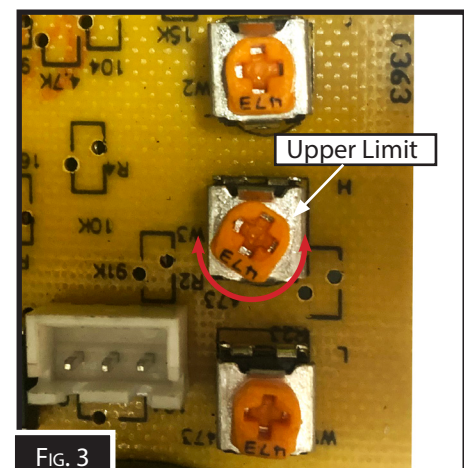


FIG. 3