Quick mill print manual

It's important to follow this instruction in the right order. Wrong order will result in incorrect 0 setting.

1. Check mill servo motor direction by using IND + UD buttons.
IND = to 0
UD = to Max distance
Reverse servo by changing connections Ø13 and Ø14

2. Use IND button to mechanical stop

3. Adjust mechanical stop (see page 2 or mill manual)

4. Adjust scale to 0

5. Set precision Potmeter (RP1) to max by turning it clockwise

6. Set reference Potmeter to 0V. To measure Potmeter use connections Ø6 and Ø7.
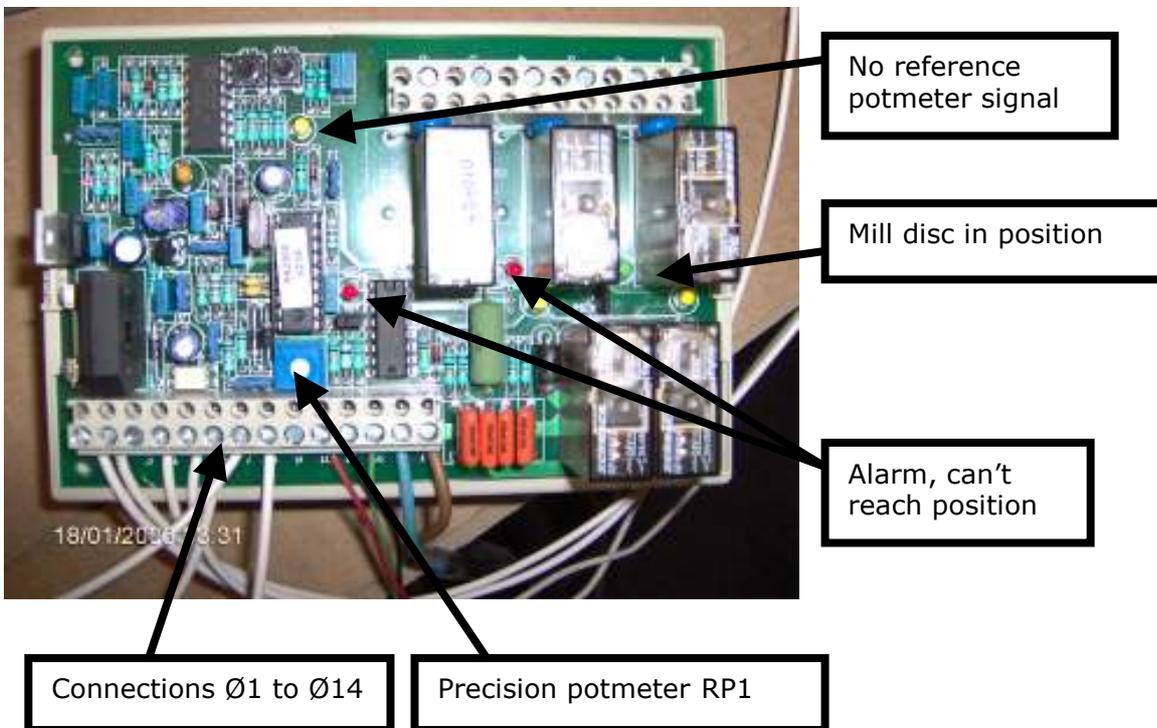
7. Set mill Potmeter to 2.4V. To measure Potmeter use connections Ø10 (+) and Ø11 (-)

8. Give print a start signal (start mill) or bridge connections Ø4 and Ø5.

9. Mill disc goes first to max distance (mechanical stop) then down to about 1 mm.
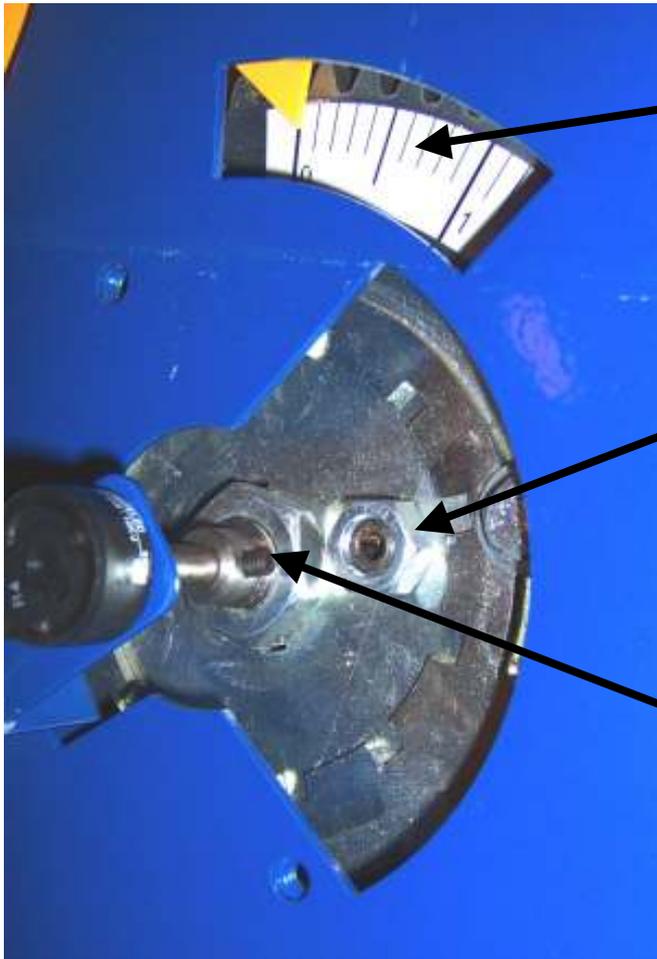
10. Slowly turn precision potmeter (RP1) counter clockwise until 0 on mill scale. If print goes in alarm then turn precision potmeter a little clockwise and give print a new start signal.

11. Mill scale should now read 0 mm.

No reference potmeter signal

Mill disc in position

Alarm, can't reach position

Connections Ø1 to Ø14

Precision potmeter RP1

Mechanical adjustment guide

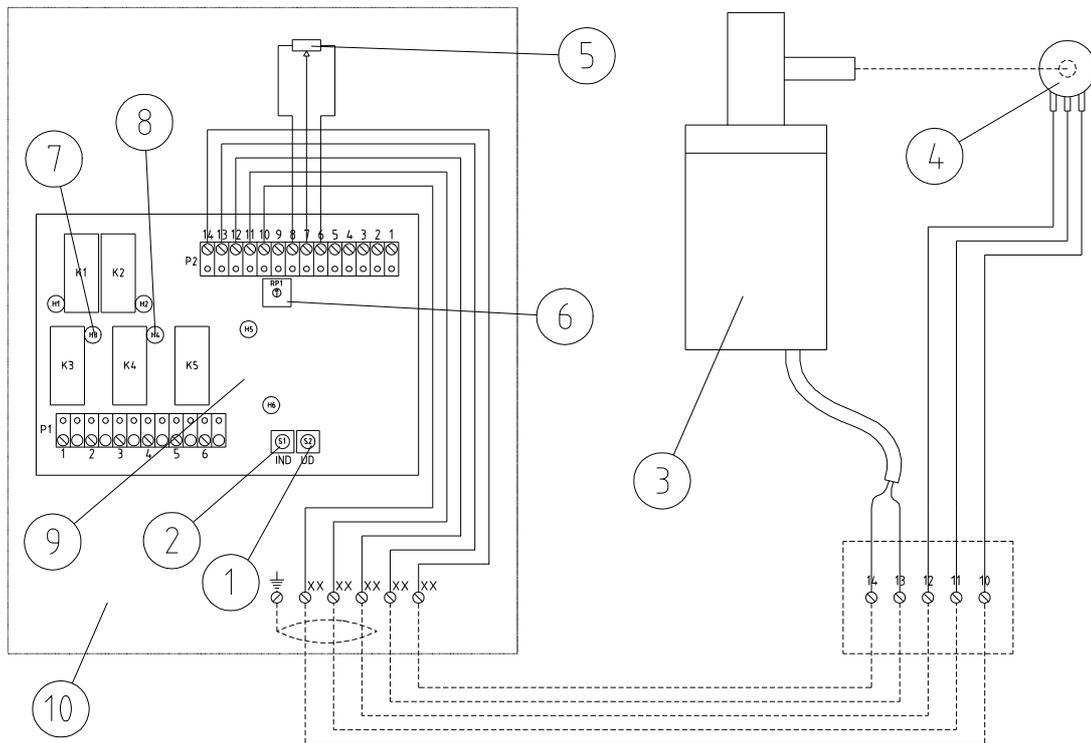See Mill manual page 11 item 5.4.0 for more info

Mill scale

Mechanical stop for adjusting 0 mm.

Loosen the bolt and use an allen key to adjust the allen screw. Screwing it down will increase distance. Screwing it up will decrease distance. See Mill manual page 11 item 5.4.0 for more info

Mill Potmeter

NB: Before starting the running-in procedure, the shaft of the mill potentiometer is loosened by turning the allen screw

Connection of electronic mill controller

Pos. 1 - Manual activation of servomotor for increased opening between the grinding discs

Pos. 2 - Manual activation of servomotor for smaller opening between the grinding discs

Pos. 3 - Servomotor of the mill

Pos. 4 - Potentiometer for position decision of the mill

Pos. 5 - Reference potentiometer in control box

Pos. 6 - Potentiometer for 0-point adjustment of controller

Pos. 7 - Green light for indication of correct distance

Pos. 8 - Red light for indication of alarm

Pos. 9 - Control print

Dictionary

A. Reference Potmeter
The Potmeter tells the print what distance mill should adjust to.

B. Mill Potmeter
Mill Potmeter is placed on the mill

C. Measuring Potmeter
This means that you must use a Analog/Digital Multimeter to measure current between the connection points (0-10VDC)

Mill manuals can be downloaded from the Skiold support homepage:
http://87.48.222.145