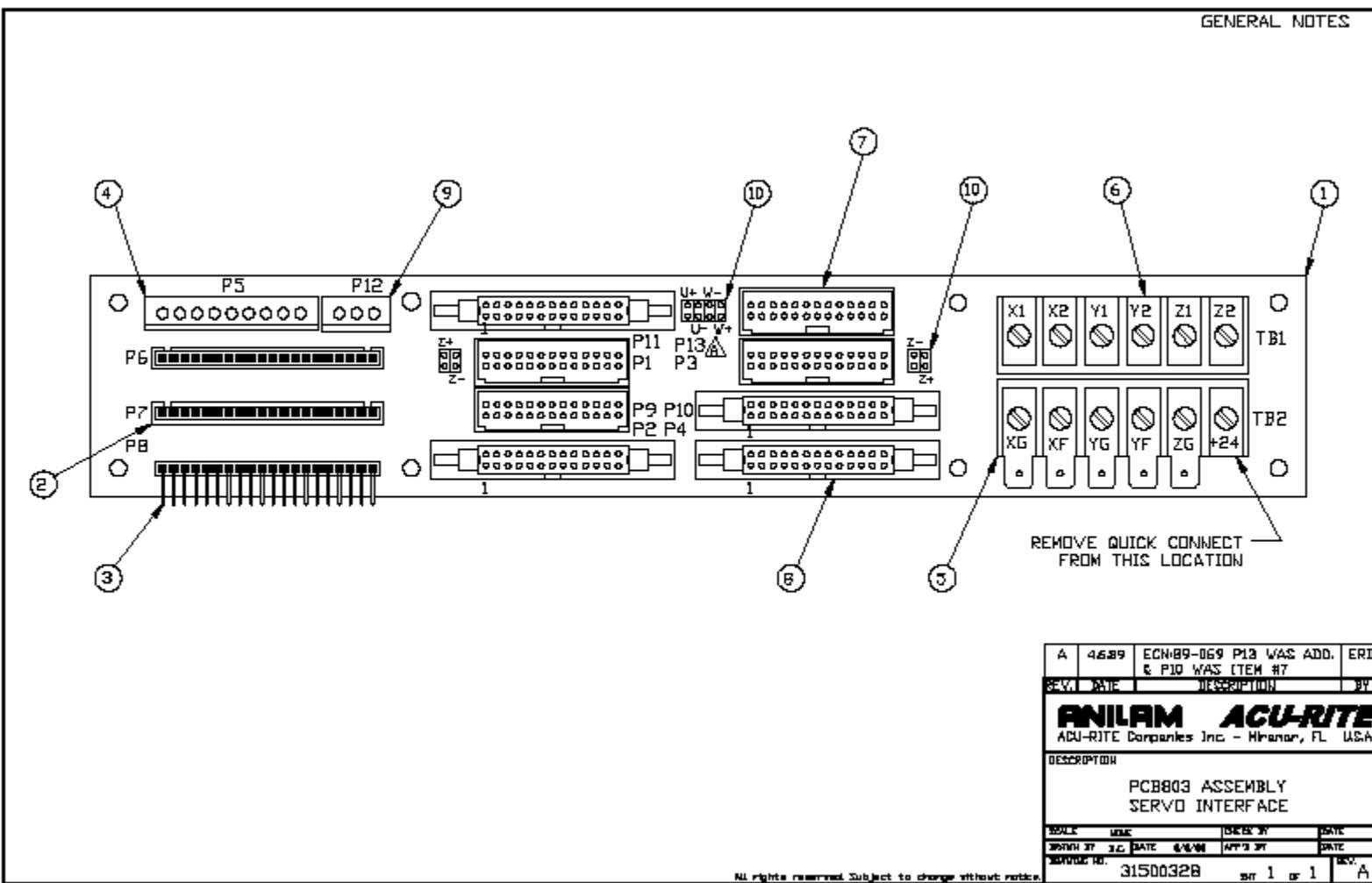


# ADJUSTMENT OF SIGNAL FOR WESTAMP DRIVE CARDS For Lathe

- 1) Press the Emergency Stop push button and turn the power off to the control. Reconnect the encoder feedback.
- 2) The Westamp type servo system were made 2 ways. Please check the following 2 schematics to determine which type you have.
- A. schematic part # ☐ **30100155** has the PC 803 type board part # ☐ **31500328**,



the P8 connector (Pin 1 is closet to the edge of the board). P8 Pins 1 and 2 = X, pins 3 and 4 = Y, and pins 5 and 6 = Z axis signal from the console. Continue to [step 3](#).

B. schematic part # **30100131** has a terminal strip type system, A and B is the X axis signal, C and D are the Z axis signals from the console. Continue to [step 8](#).

3) If you have the PC 803 board version part # [31500328](#) do the following:

A. Hook up meter leads to P8 connector (Pin 1 is closet to the edge of the board), P8 Pins 1 and 2, see drawing [31500328](#) if necessary.

4) Turn the power on to control and reset the servo.

5) Write a Loop program so the X axis will move back and forth at a feed rate of ten percent of rapid.

Example: If rapid speed is 240 IPM program a 24 IPM feed rate. The following is an example of such a program for a Crusader ML.

```
1 Do 30
2 Feed 24
3 X Feed 0" Abs
4 X Feed 5" Abs
5 END
6 END
```

6) **Note: PC 803 P8 Pins 1 and 2 = X, pins 3 and 4 = Z axis signals from the console.**

Check across pins 1 and 2 of PC 803 P8 connector. You are looking for .8 volts D.C. If you don't have .8 volts D.C., adjust on the drive card the potentiometer labeled SIG until you achieve .8 volts D.C. See [figure 1](#) at the bottom of the page for potentiometer adjustments.

7) Repeat step 5 but changing the program to do Z axis back and forth and adjusting the SIG pot on the Z axis board.

**Remember to move your meter leads to P8 pins 3 and 4 for Z and repeating [step 5](#).**

8) For a terminal strip type system, A and B is the X axis signal, C and D are the Z axis signals from the console.

A. Hook up meter leads to A and B for the X axis adjustment and run the program from Step 5. You are looking for .8 volts D.C. If you don't have .8 volts D.C., adjust on the drive card the potentiometer labeled SIG until you achieve .8 volts D.C. See [figure 1](#) at the bottom of the page for potentiometer adjustments.

B. Repeat step 5 but changing the program to do Z axis back and forth and adjusting the SIG pot on the Z axis board.

**Remember to move your meter leads to (C and D) for Z when repeating [step 5](#).**

