



ADJUSTMENTS FOR REPLACING LOGIC BOARD

(part #204945-7)

STEP 1 High Voltage Adjustment (R-34)

1. Connect a DC voltmeter to the magnetic chuck on C1 and C2.
2. Adjust R-34 for either 115 or 230 VDC operation.

STEP 2 Dip Switch Adjustment – SW1

The four (4) position dip switch is used for changing the release time for compensation for difference chuck sizes. Four (4) setting are available:

- A) Fast -all switches closed
- B) Medium Fast -switches 2 and 4 open
- C) Medium Slow -switches 1 and 3 open
- D) Slow -all switches open

STEP 3 Release Adjustment (R-35)

1. Release adjustment (R-35) shifts the release reference voltage up or down to correct for different sides of chucks. Adjusting R-35 may improve release, reducing "stickiness" of material currently being held.
2. Connect a DC voltmeter to the magnetic chuck on C1 and C2.
3. Select the release position.
4. Adjust R-35 so that the last step in the demag cycle reads 5-20 VDC.

STEP 4 SCR/Driver Board (204945-8A)

The two adjustments on SCR/Driver board are used for setting the linearity for the variable control potentiometer. The adjustment closest to the connector is the high end adjustment. The other is the low end adjustment, located in the center of the circuit board. The adjustments only affect the unit when variable speed is selected.

STEP 5

If reversing relay located on sub-panel arcs during release, release speed is too fast and **must** be reduced or control damage may occur.

If you should have any questions regarding these procedures, please contact us immediately.