

TECHNICAL BULLETIN - VMD settings adjustment

Enable the Z-Axis Limit Switch (TMX)

Summary of Technical Bulletin: Enable the Z-Axis limit switch in VMD on TMX machines

- Tools Required
- None

Tools:

The default settings in the Visual Machine Designer for certain machines that run on the Accumove 3 controller has the Z-Axis limit switch disabled. This will go through the steps to enable the Z-Axis limit switch.

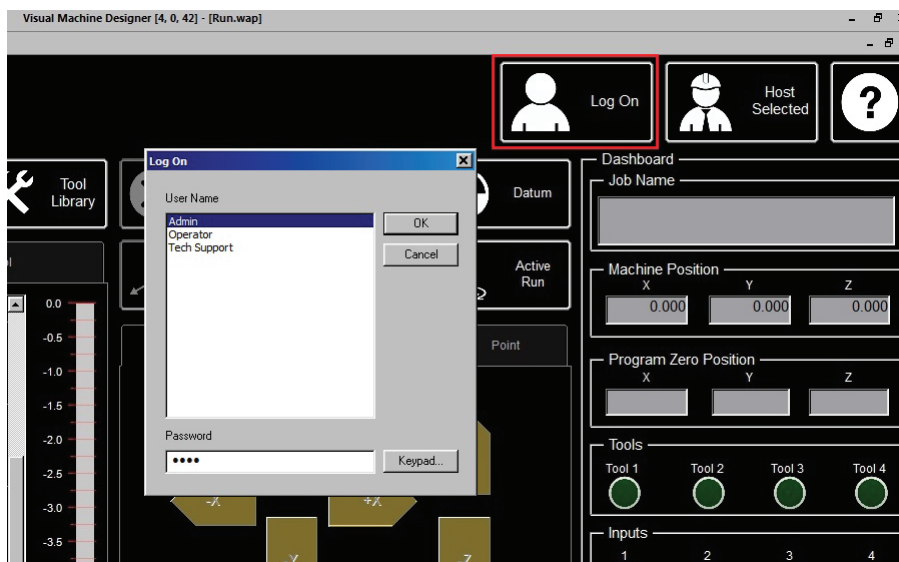
Before you Start:

Have the VMD running along with connection to the Accumove 3 controller. This can be verified by being able to jog the machine.

Access Machine Settings:

In the VMD to access the MACHINE SETTINGS you need to LOG ON. Select LOG ON in the upper right corner of the VMD software. Once in the dialog of LOG ON, select ADMIN and enter "1234" as the password. Once you press OK the MACHINE SETTINGS button will be visible.

Step 1:



Updated on: 1/3/2016

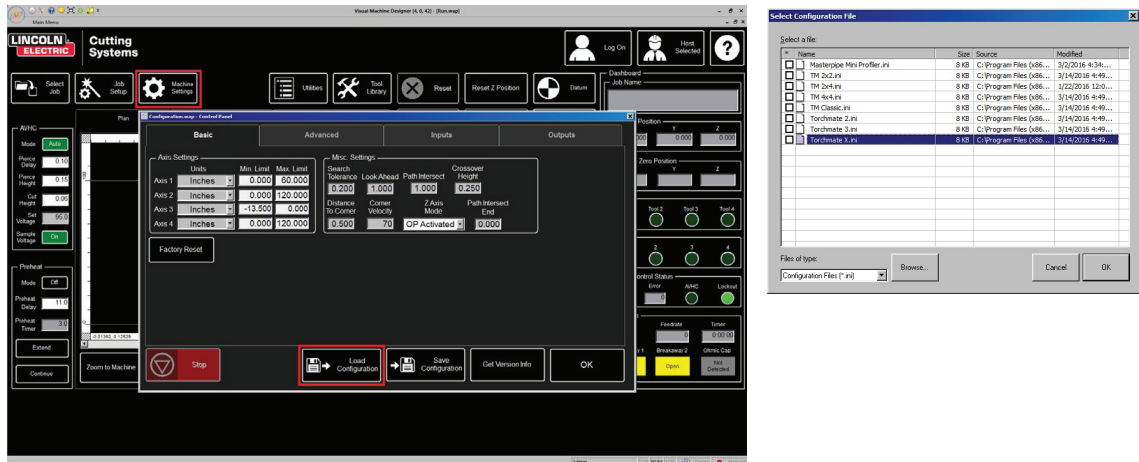
Page 1 of 4

TORCHMATE TECHNICAL SUPPORT: 866-571-1066
www.torchmate.com

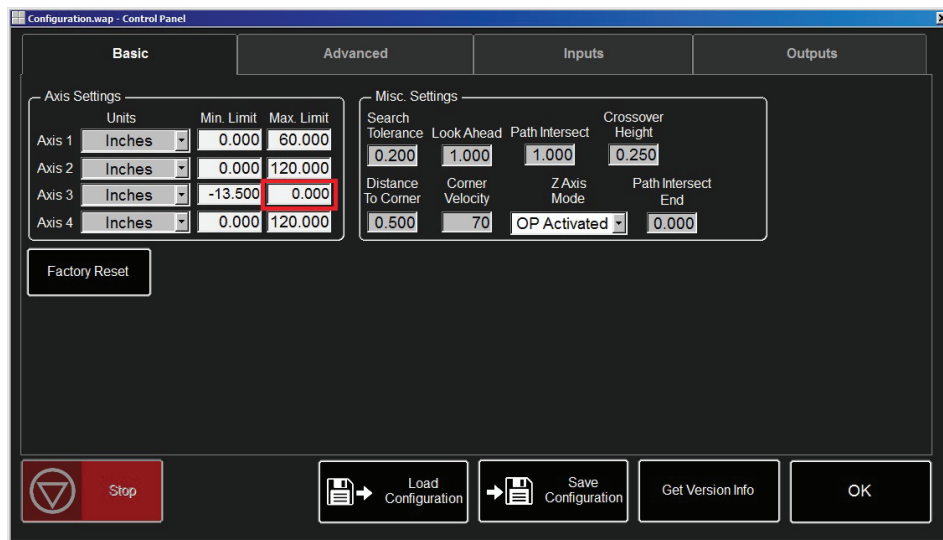
LINCOLN[®]
ELECTRIC

**Cutting
Systems**

Step 2: In the upper left select MACHINE SETTINGS. Once selected will bring up the BASIC tab. Load the DEFAULT configuration for your machine by pressing LOAD CONFIGURATION. Select the configuration by highlighting the machine (not by checking the box). Press OK.

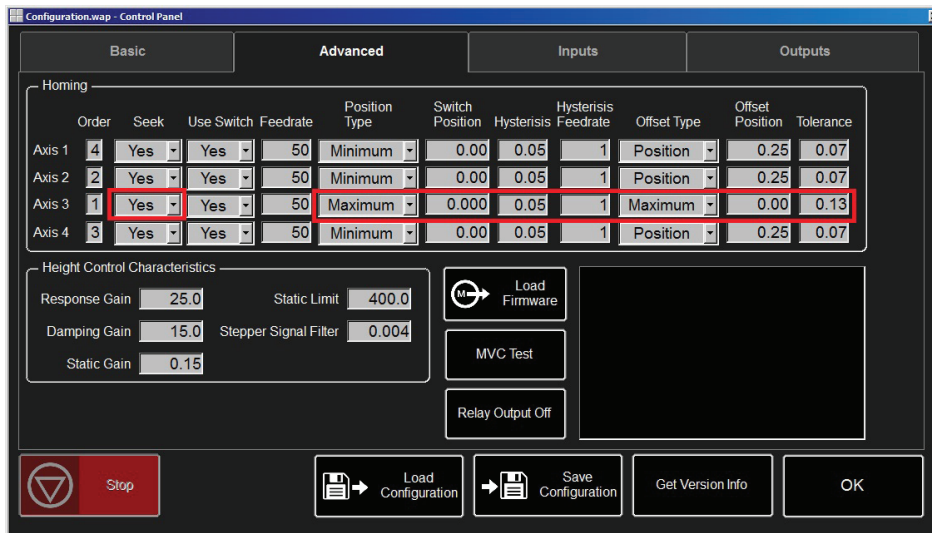


Step 3: Under the BASIC tab, change AXIS 3 MAXIMUM VALUE to 0.000



Step 4: Under ADVANCED TAB, for AXIS 3.

- Change Seek to YES
- Change POSITION TYPE to MAXIMUM
- Change SWITCH POSITION to 0.000
- Change HYSTERISIS to .05
- Change HYSTERISIS FEEDRATE to .5
- Change OFFSET TYPE to MAXIMUM
- Change OFFSET POSITION to 0.000
- Change TOLERANCE to .125

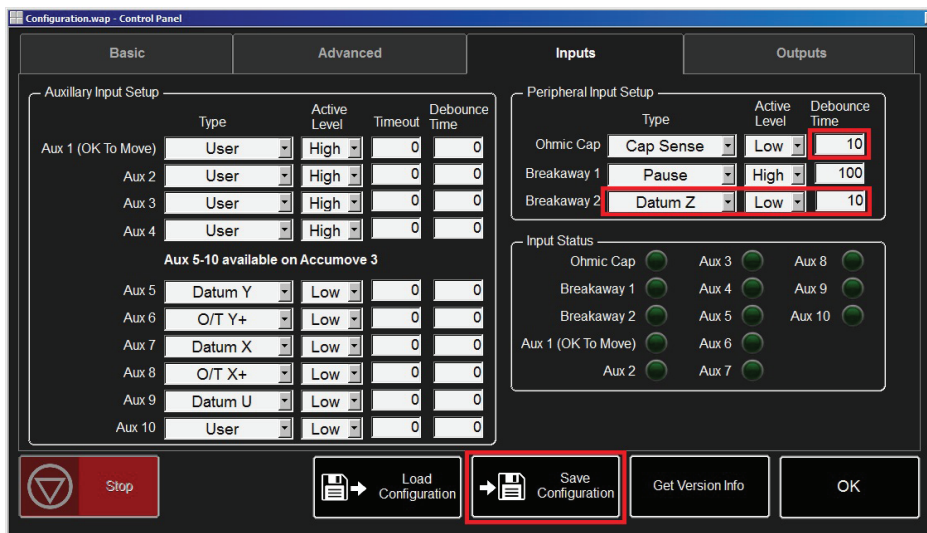


Step 4 (cont):

Under INPUT TAB

- Change OHMIC CAP DEBOUNCE TIME to 10
- Change BREAKAWAY 2 from PAUSE to DATUM Z
- Change ACTIVE LEVEL for BREAKAWAY 2 to LOW
- Verify that AUX 5-10 has no DATUM Z, if it does then change to USER.

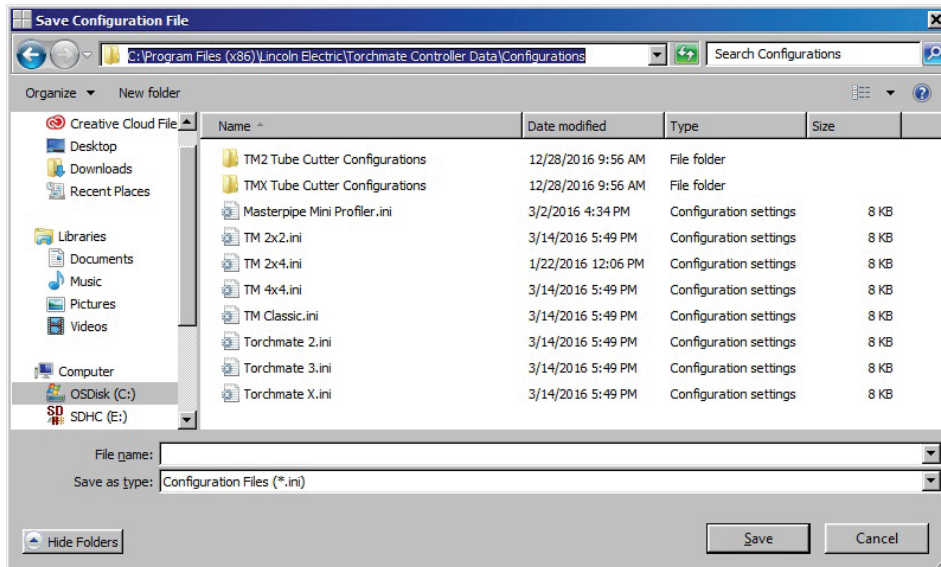
Step 5:



Once the settings are verified you need to save the configuration. Press SAVE CONFIGURATION. When the BROWSE window pops up double click CONFIGURATIONS. Type in a name for the new configuration and press SAVE. VMD will load this configuration every time it opens.

Step 6:

Step 6 (cont.):



Final: This will properly configure the breakaway with the proper settings. If you ever need to reinstall VMD for any reason you can save the configuraton and load it. Then you will not have to go through these settings again.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.