

Home and Pre-Home Switch Setup / Replacement.

Equipment.

Basic Tools Only.

Purpose.

To replace home switch core, pre-home switch and reset home switch position.

Tolerance.

± 0.010 " (0.25mm).

Method. (Replacement, pre-home switch. X and Z axis)

The pre-home switch is replaced in the same way as the limit switches.

1. See Limit Switch Setup / Replacement.
2. See Pre-home switch setup below.

Method. (Setup, pre-home switch. X axis)

1. Adjust the pre-home switch to trip at a point $3/16$ " (8mm) from the crash position.

Method. (Setup, pre-home switch. Z axis)

1. Adjust the pre-home switch to trip at a point when the front face of the spindle is $1/8$ " (3mm) sub-flush.

Method. (Replacement, home switch).

The X axis home switch is located on the right hand side towards the back of the slide. The Z axis home switch is located on the left hand side towards the back of the slide.

1. Locate the aluminum bracket that holds the home switch. (The home switch is actually the core from an LVDT)
2. Loosen the single set screw that holds the core and remove.
3. Follow the wiring back to it's origin, and remove from the loom.

Home and Pre-Home Switch Setup / Replacement. (cont.)

4. Replace in reverse sequence.
5. See setup below.

Method. (Setup, home switch. X axis).

1. Adjust the home switch to trip at a point 1/8" (3mm) from the crash position. Make sure the switch probe does **NOT** touch the inside of the core, as it passes through.

Method. (Setup, home switch. Z axis)

1. Adjust the home switch to trip at a point when the front face of the spindle is 5/16" (8mm) sub-flush. Make sure the switch probe does **NOT** touch the inside of the core, as it passes through.