

$$\frac{\text{MAXIMUM COMMAND SIGNAL}}{\text{MAXIMUM FEEDRATE}} = \frac{\text{COMMAND SIGNAL FOR PROGRAMMED FEEDRATE}}{\text{PROGRAMMED FEEDRATE}}$$

Example 1:

$$\begin{aligned} \text{If, Maximum Command Signal} &= 7 \text{ volts} \\ \text{Maximum Feedrate} &= 400 \text{ ipm} \\ \text{Programmed Feedrate} &= 100 \text{ ipm} \\ \\ \text{Command Signal For} &= \frac{7 \times 100}{400} = 1.75\text{V} \\ \text{Programmed Feedrate} & \end{aligned}$$

Example 2:

$$\begin{aligned} \text{If, Maximum Command Signal} &= 10 \text{ volts} \\ \text{Maximum Feedrate} &= 480 \text{ ipm} \\ \text{Programmed Feedrate} &= 50 \text{ ipm} \\ \\ \text{Command Signal for} &= \frac{10 \times 50}{480} = 1.042\text{V} \\ \text{Programmed Feedrate} & \end{aligned}$$

8. Adjust potentiometer R11 (Tacho) to obtain proper voltage. See Figure 3.1.6.

9. Re-check the Gain and Balance for the control and make any adjustments if necessary. If adjustments were necessary, re-check the Command Voltage.

This procedure is repeated for each axis.

| SETTING OF SWITCH S101 | MAXIMUM CURRENT LIMIT (I <sub>max</sub> ) | ACTUAL CURRENT AT TESTPOINT "W" (AMPERE/VOLT) |
|------------------------|---|---|
| 0                      | 14  | 1.4   |
| 1                      | 24  | 2.4   |
| 2                      | 30  | 3.0   |
| 3                      | 36  | 3.6   |
| 4                      | 50  | 5.0   |
| 5                      | 56  | 5.6   |
| 6                      | 57  | 5.7   |
| 7                      | 60  | 6.0   |
| 8                      | 75  | 7.5   |
| 9                      | 75  | 7.5   |

Figure 3.4.5  
Switch S101, Maximum Current Limit and Ampere/Volt Comparison

Note: The maximum setting for Switch S101 varies with the size of the drive. Refer to the Adaption Tables in Section 3-3-1.

| Size of Drive | Maximum Setting of Switch S101 |
|---------------|--------------------------------|
| 12            | 3                              |
| 25            | 4                              |
| 30            | 9                              |