

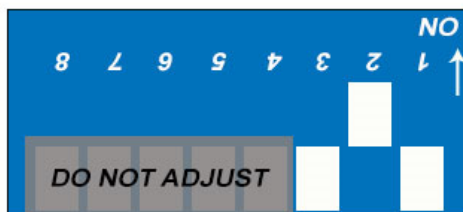
Service Bulletin

3/27/2018

This bulletin pertains to machines with model number KL-5056E stepper motor drives. It has come to our attention that some machine may have been shipped with the current setting on these drives set to the wrong position. Current is set by positioning the DIP switches on the drive.

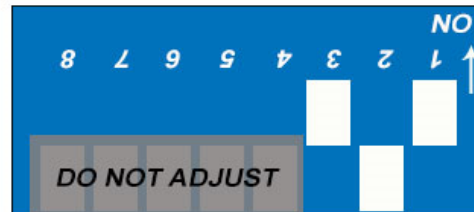
Stepper motors by nature tend to run hot, but if you feel that the motors are running too hot, particularly the Z axis motor, there is a chance that this bulletin pertains to you.

To adjust the current setting on the drive, you will adjust switch 1, 2 and 3 to the diagrams below. Note that SeriesOne machines have 3 drives labeled X, Y and Z while XT machines have 4 drives labeled X, Y, Z and X2. Again, we are only adjusting switch positions 1,2 and 3. Switches 4 – 8 will be left alone. The drives are located in the upper left corner of the control box.



X, Y and X2 Drives

Shown upside down as installed in box



Z Drive

Shown upside down as installed in box

See next page for drive location and orientation.

Drive Location and Orientation

The drives are installed and oriented as shown in the image below. Note that they are installed with the text on the switches upside down.

Note that SeriesOne machines will not have an X2 drive.

