

X-Y **autotable** Instructions

Elements of X-Y **autotable** for use with Labtap Tapping Torque Test System are:

Controller	Input - 100-240 VAC, 2 amp, single phase for 24 VDC supply. Hub - Programmable interface for drives, pendant, and PC. Stepper Motor Drives - for X and Y axis
Pendant	MMI - Four line LCD and keypad for operator control.
X-Y autotable	Two-axis, stepper motor driven, linear positioning table Work holding fixture for Test Bars.
PC Computer	with serial port and cable WinPCA software SiNet Hub Software
Labtap G8	Thread tapping machine ZAP feed for footswitch or Pendant control Parallel interface cable

Refer to SiNet Hub Programmer Software and WinPCA Manual for computer system requirements.

Basic Operation: The MMI Pendant controls the X-Y **autotable**. The Display contains the instructions for the Keypad operation. Refer to your own laboratory procedure or microtap methodology for desired intentions.

Turn Controller Power On and the display will read THE software version then prompt input of the center distance between holes for each axis. The original setting is retained so pressing ENTER will continue to the prompt for AUTOTEST MODE.



Press NO for MANUAL and the display will illustrate the key functions for operation. Only the numeric keys are functional. The table position will need to be aligned to the first hole of the Test Bar in a test sequence. Set the Labtap Safety switch to 0 and load a tap or alignment tool into the spindle. Check tool-to-hole centricity. For adjustment, the motors need to be free. Press 7 to DISENGAGE and rotate the manual knobs on each motor to locate the best position. Press 8 to ENGAGE the motors.



