

Connecting a rotary device to a CNC milling machine

+86 131 5310 5797 info@wattsan.com

Wattsan

If your equipment is broken or has lost some of its functionality, please contact us in one of the following ways:

1. Write to us at **help@wattsan.com** and specify:
- equipment model.
- visible malfunctions.

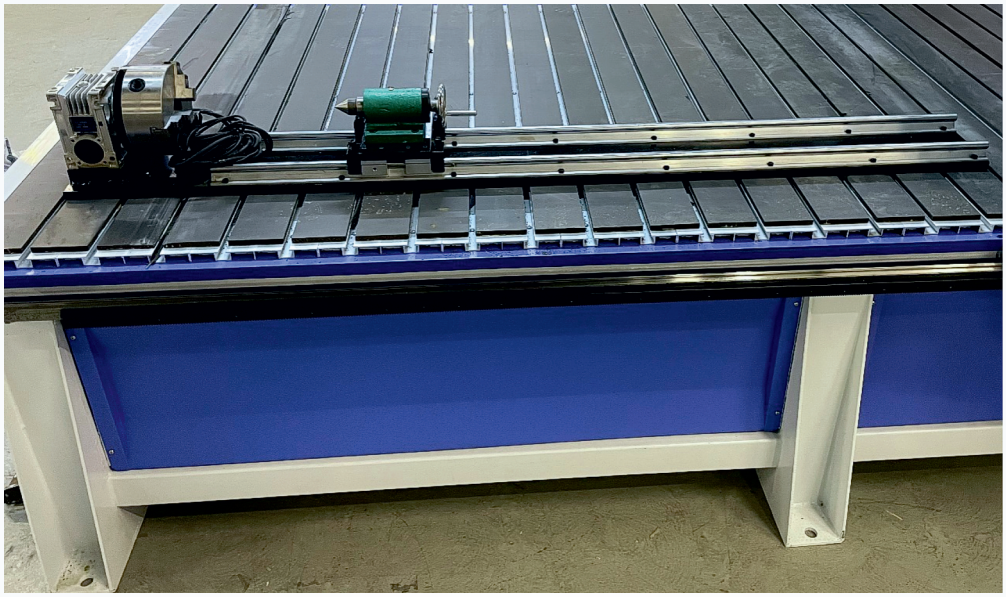
2. Call us at **+86 131 5310 5797**

Table of contents

Section 1. Installing and connecting a rotary device 4
Section 2. Turning off a rotary device 11
Section 3. Replacing chuck jaws on a rotary device 12

Section 1. Installing and connecting a rotary device.

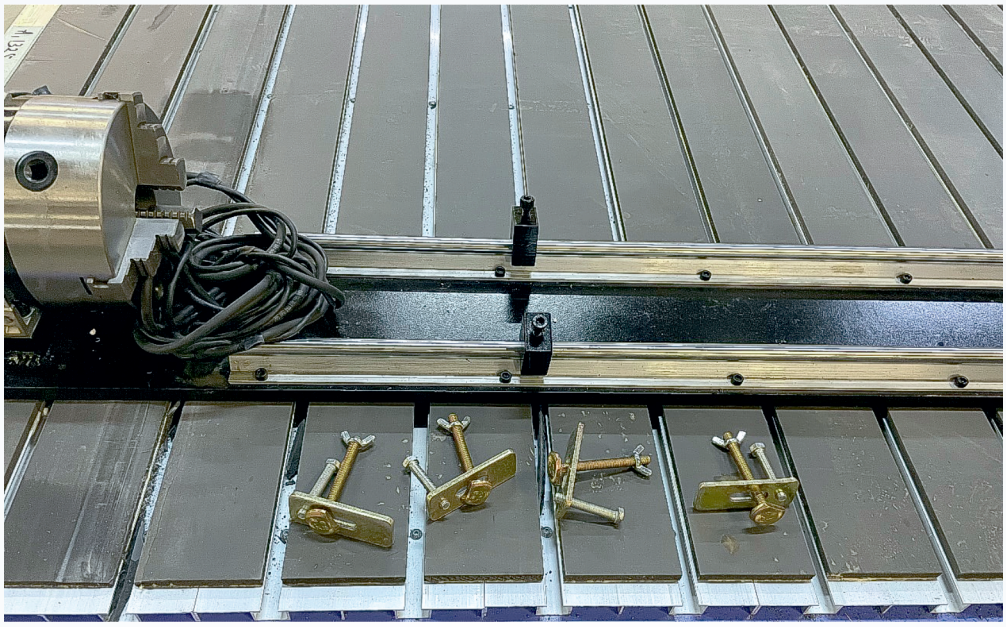
1. Unpack a rotary device.

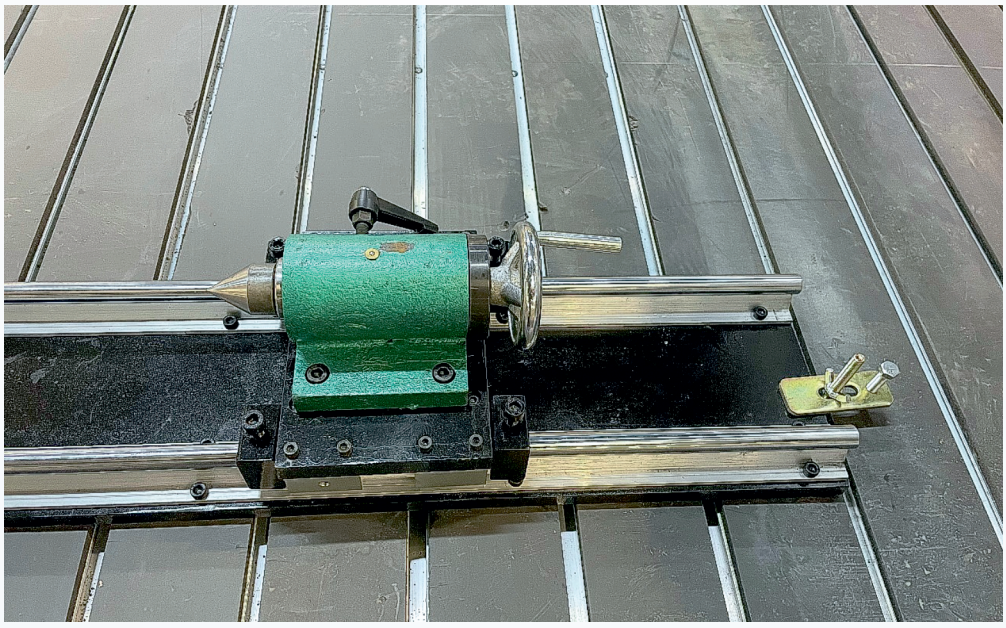


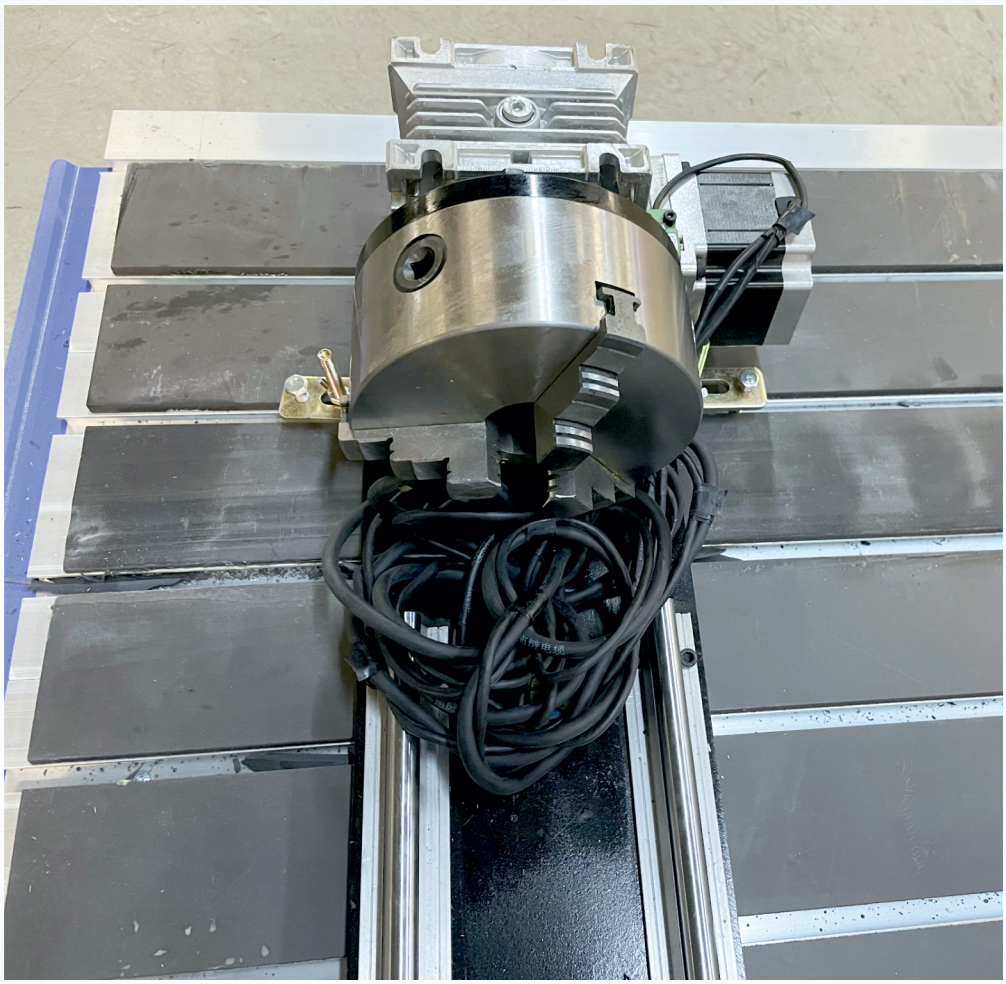
2. Make sure that the rotary chuck is perpendicular to the cutter fitted in the spindle.



3.Fix the rotary device to the table using the clamps supplied with the milling machine.







+86 131 5310 5797 info@wattsan.com

4. Connect the rotary device cable to the special connector on the machine.



5. Start the machine, do not press "Home".



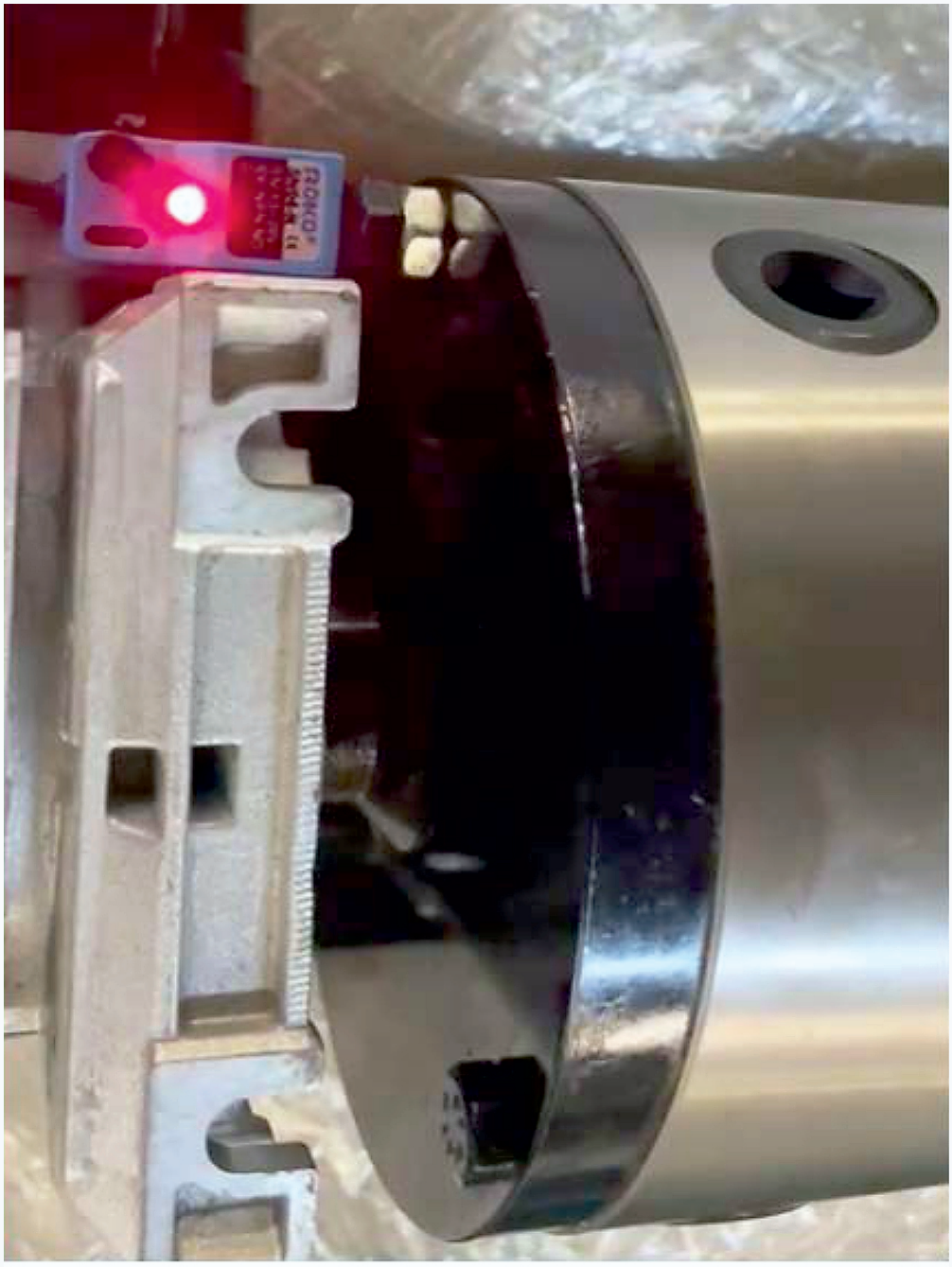
6. Go to Menu -> Machine setup -> Home setup -> Home order, and select Z, XY, A.



7. Go to Menu -> Machine setup -> Pulse equiv and set A Size = 92233720.



8. Move the machine "Home" on all axes (including the A-axis).



9. Secure the workpiece in the chuck and tighten the chuck jaws.

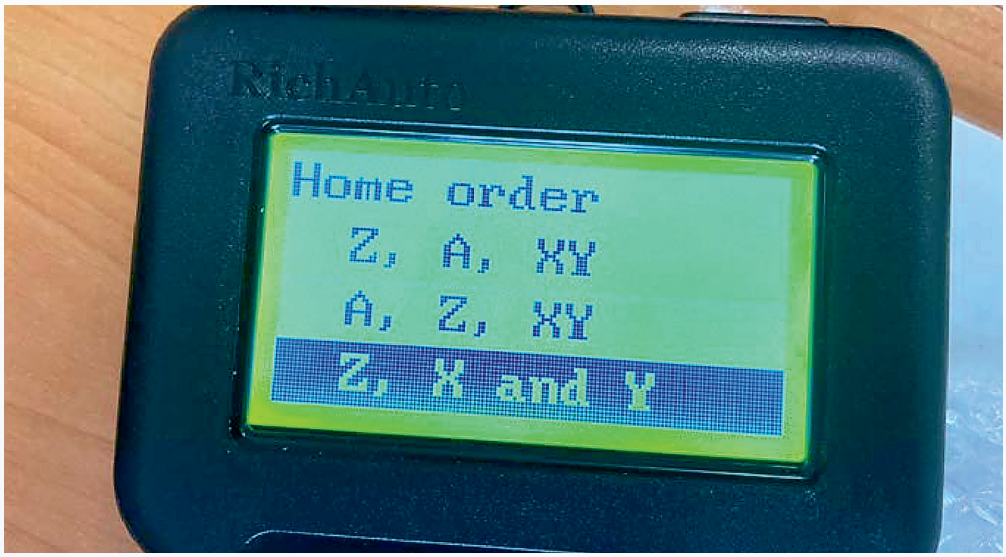


Section 2. Turning off a rotary device.

1. Disconnect the power cable of the rotary device.



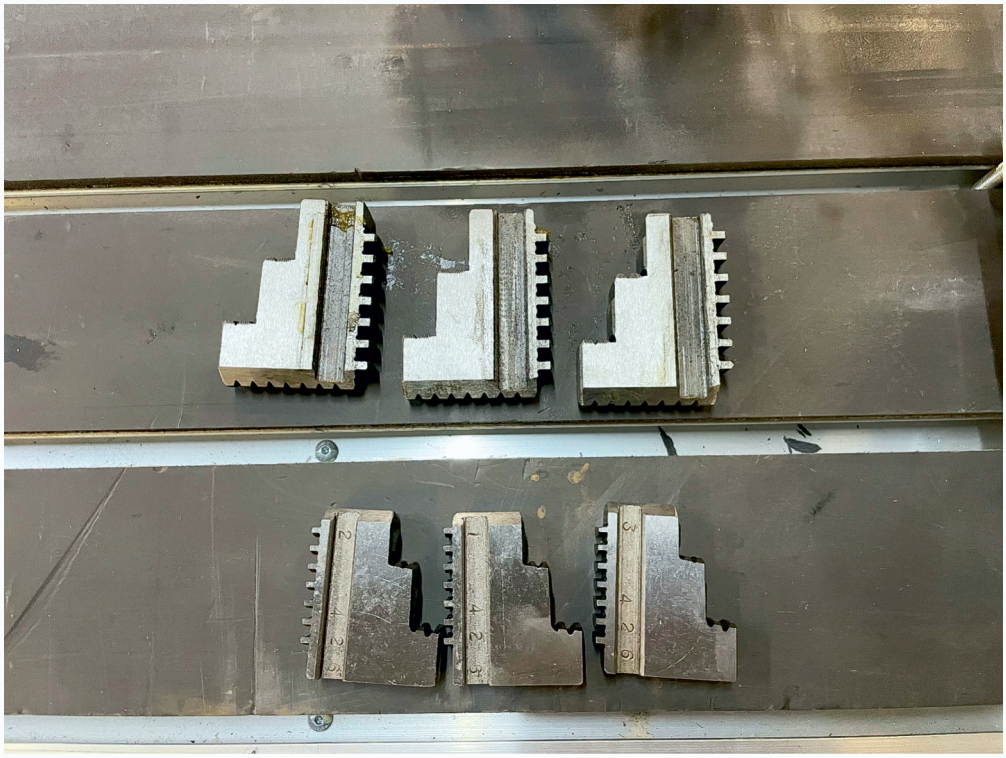
2. Remove the clamps.
3. On the controller, change the order of the spindle moving "Home".
Go to Menu -> Machine setup -> Home setup -> Home order and select Z, XY, A.



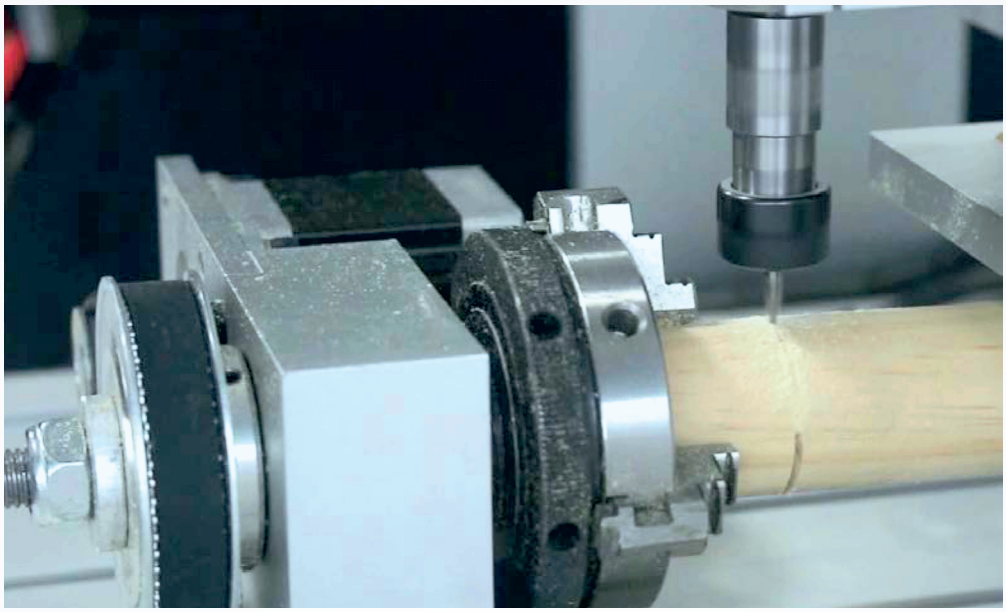
4.Remove the rotary device from the working table.

Section 3. Replacing chuck jaws on a rotary device.

1. The rotary device comes with 2 types of jaws: one for clamping medium-diameter workpieces and the other for clamping large-diameter workpieces.



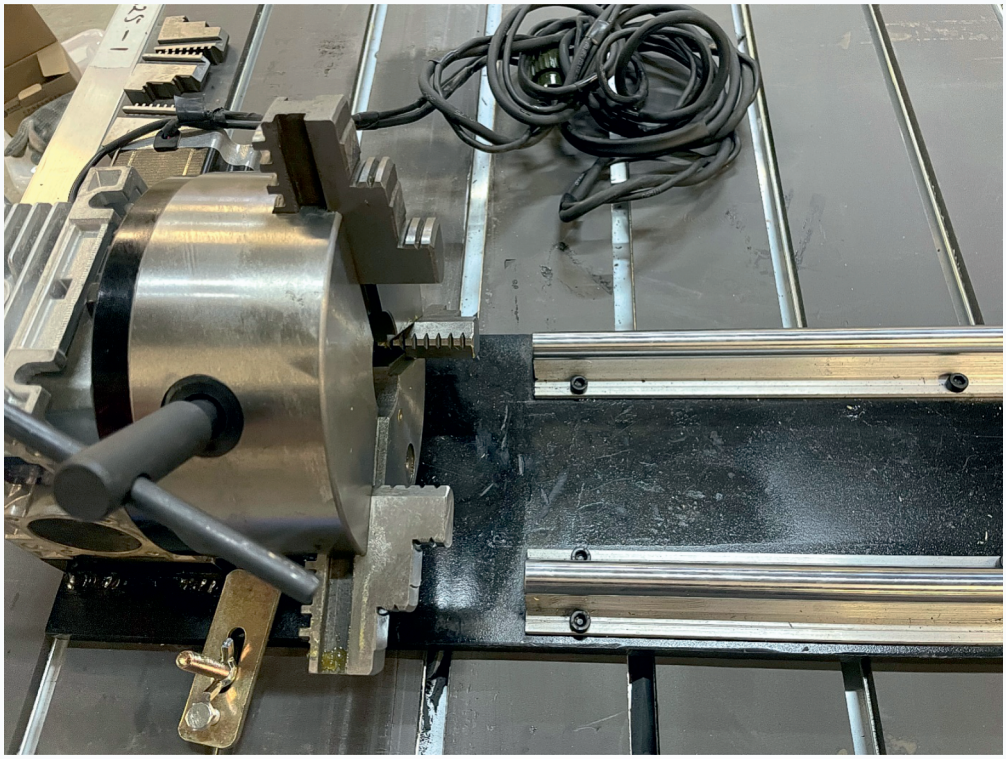
Clamping a workpiece with a small diameter.



Clamping a workpiece with a large diameter.

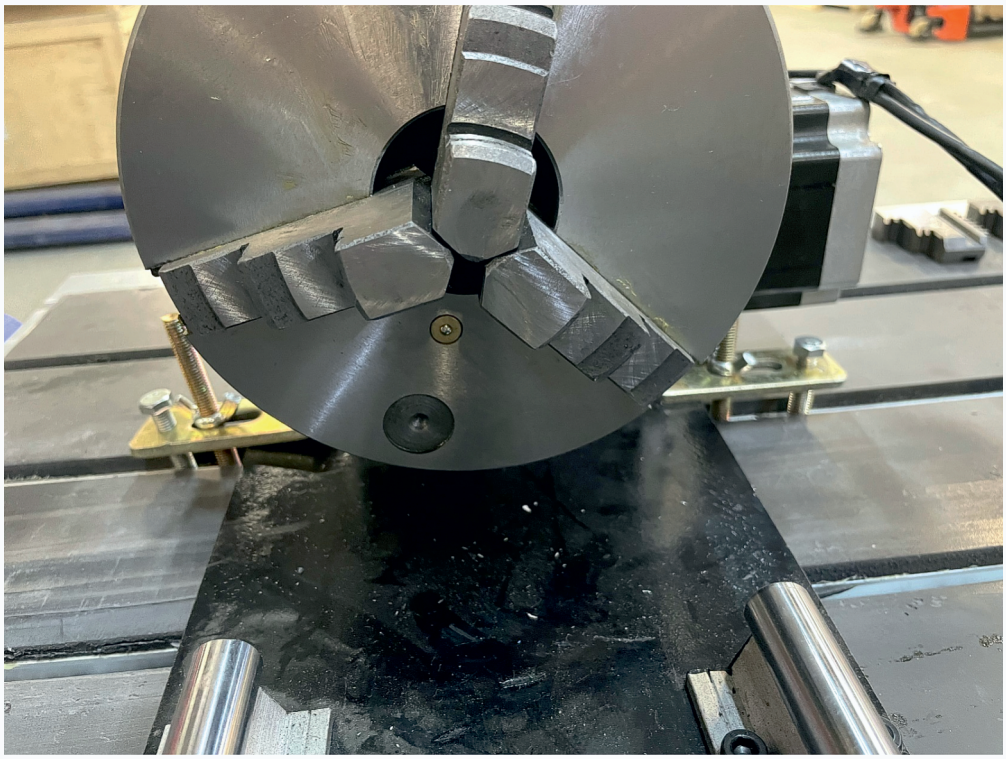


2. To replace the chuck jaws, take the hex wrench supplied with the rotary device, put it into the hex slot in the chuck, and turn it anticlockwise. The jaws will unclench. When the jaws stop moving, pull them out with your hands.



3. Place the new jaws in the chuck and turn the wrench clockwise to clamp the jaws. Screw the jaws all the way in to check that they converge exactly in the centre of the chuck.

Incorrect positioning jaws when they are not aligned in the centre of the chuck:



4. If the jaws are not aligned in the centre of the chuck, unscrew them and place them back into the slots in the other order.

Correct postioning jaws when they are aligned in the centre of the chuck:

