

OFFICE

8824 Old Block House Ln
Spotsylvania, VA 22551-3512

PHONE

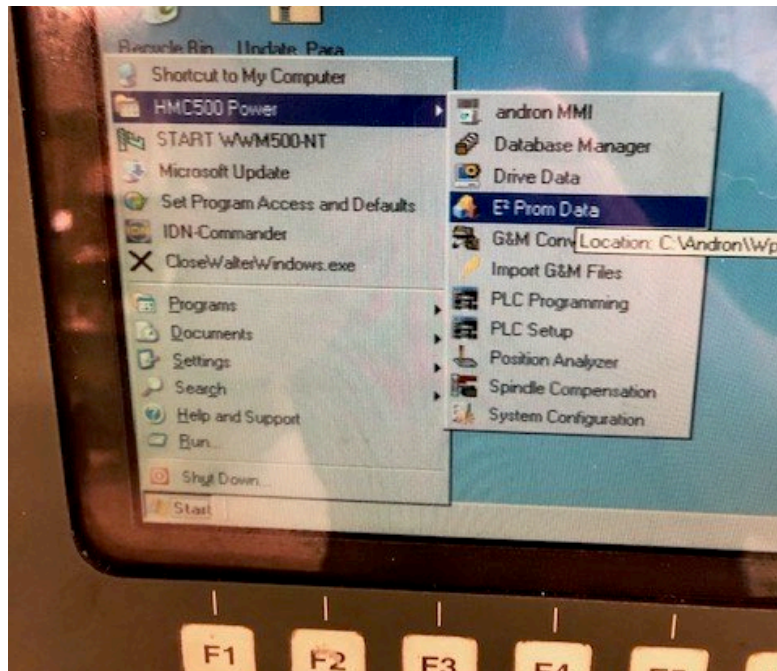
+1-540-940-5977

EMAIL

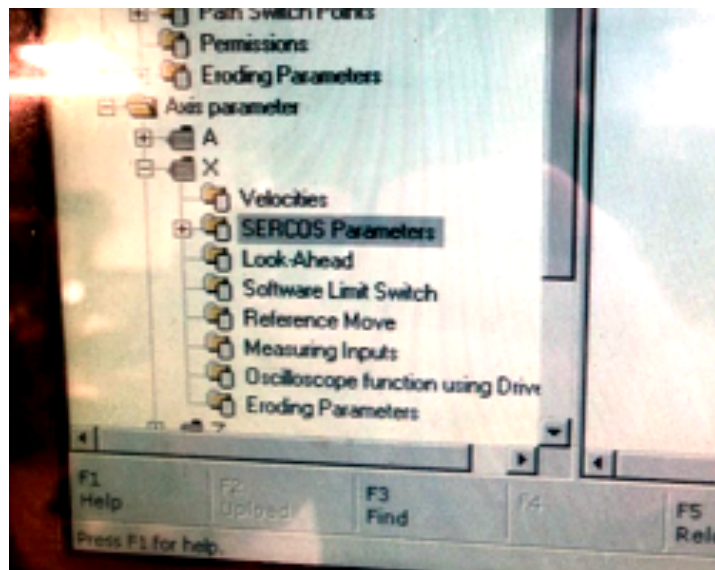
ed@toolroom.solutions

Turning off the glass scale(s) on a WALTER Helitronic machine with the HMC 500/600 control

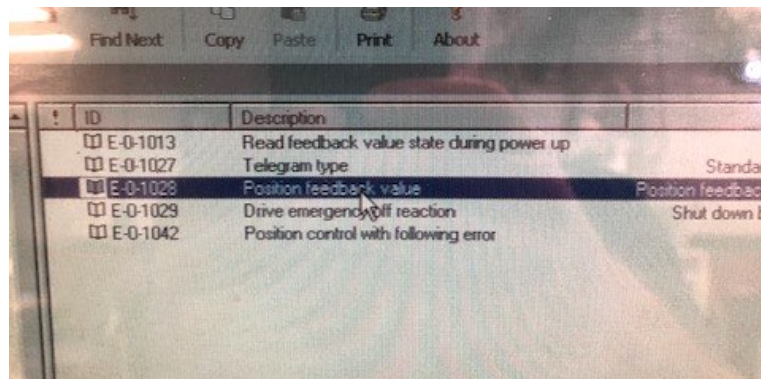
1. Open up the Eprom settings of the control



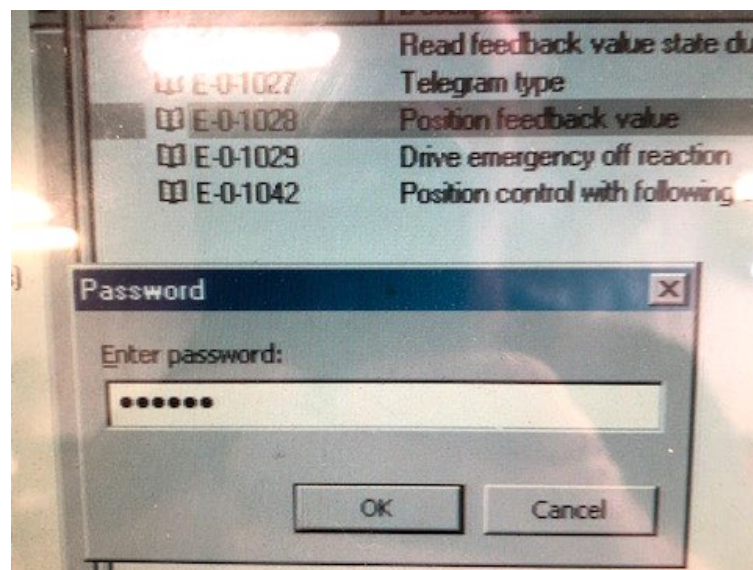
2. Select the desired axis (we're showing the X-axis throughout as an example) and then "SERCOS parameters"



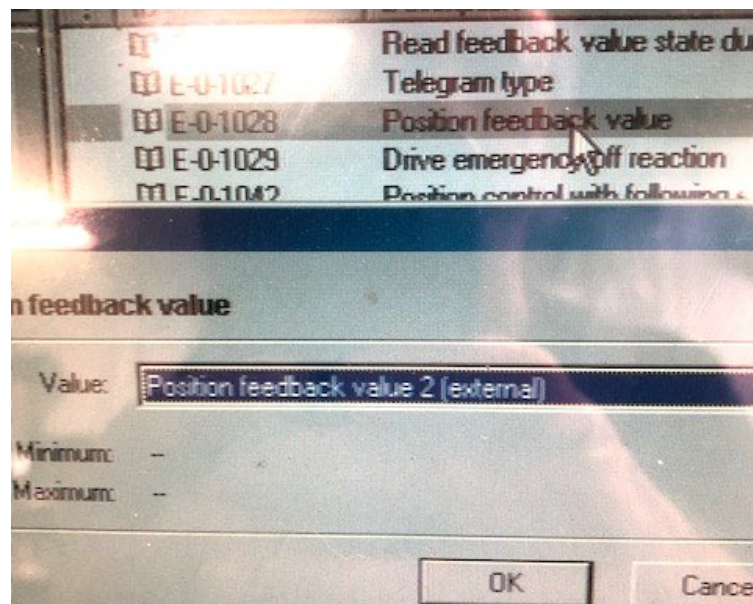
3. Change the position feedback by selecting that option...



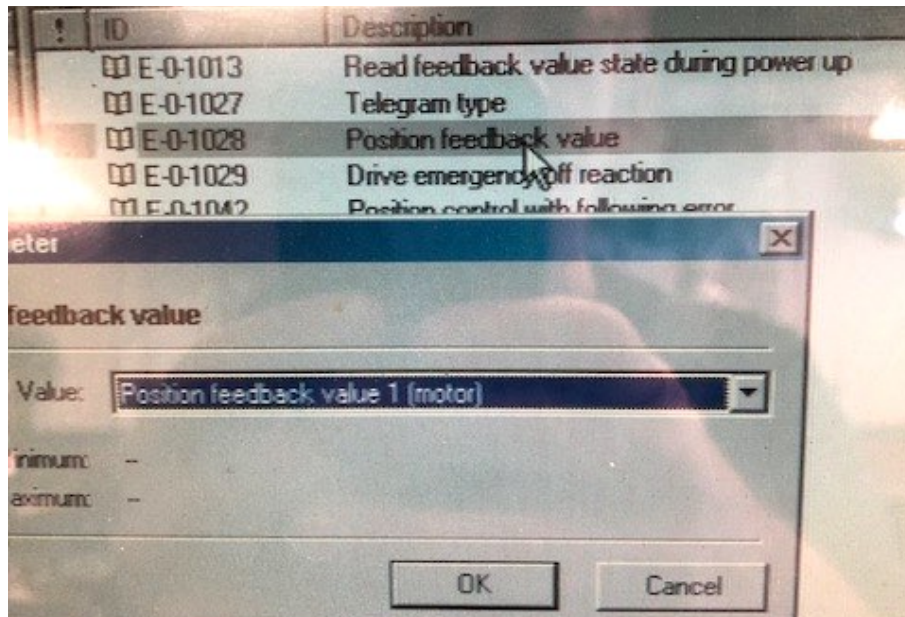
- Enter password **HMC600**



- Then change from "Position feedback value 2 (external)"...

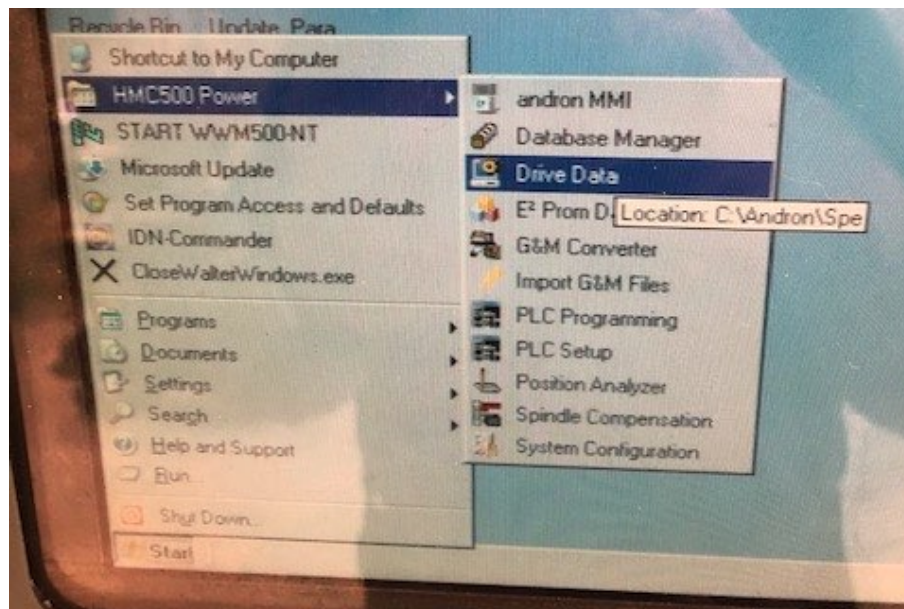


- To “Value 1 (motor)”

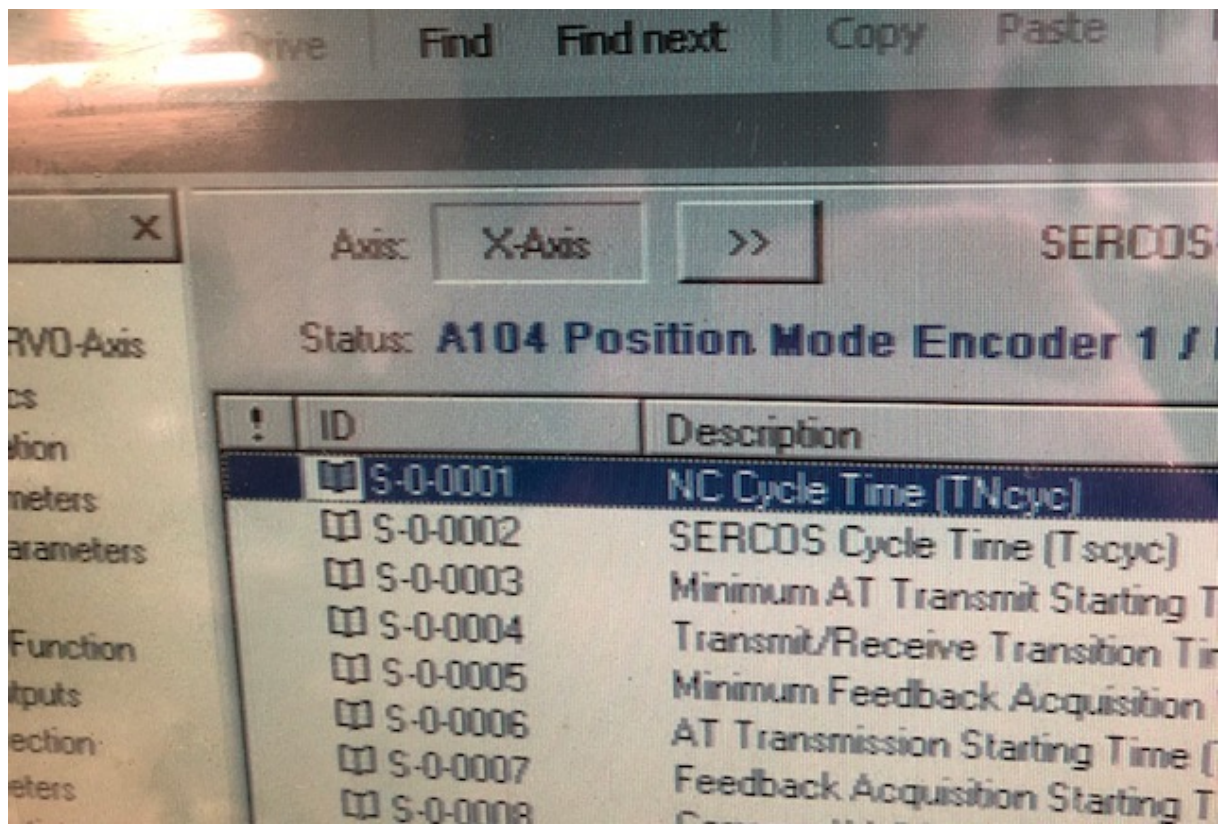


- Then exit out of EProm

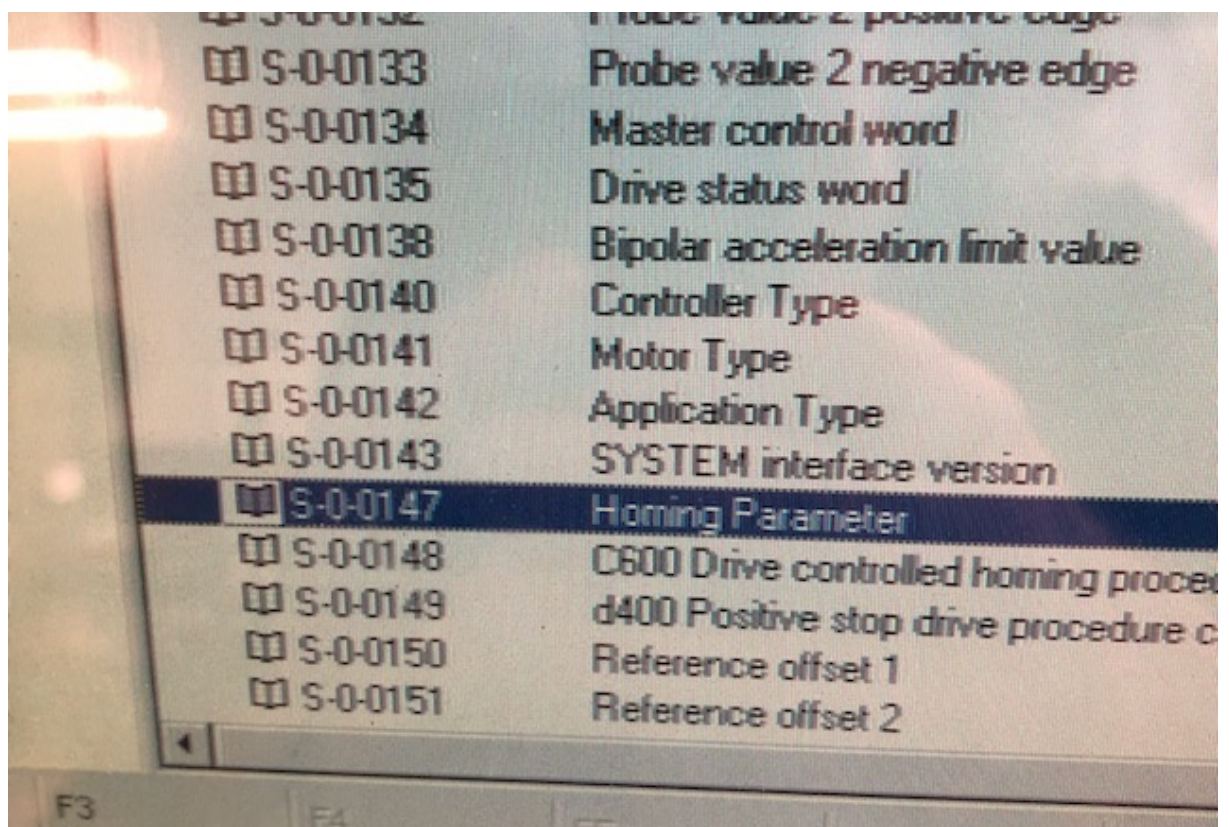
4. Open up drive data



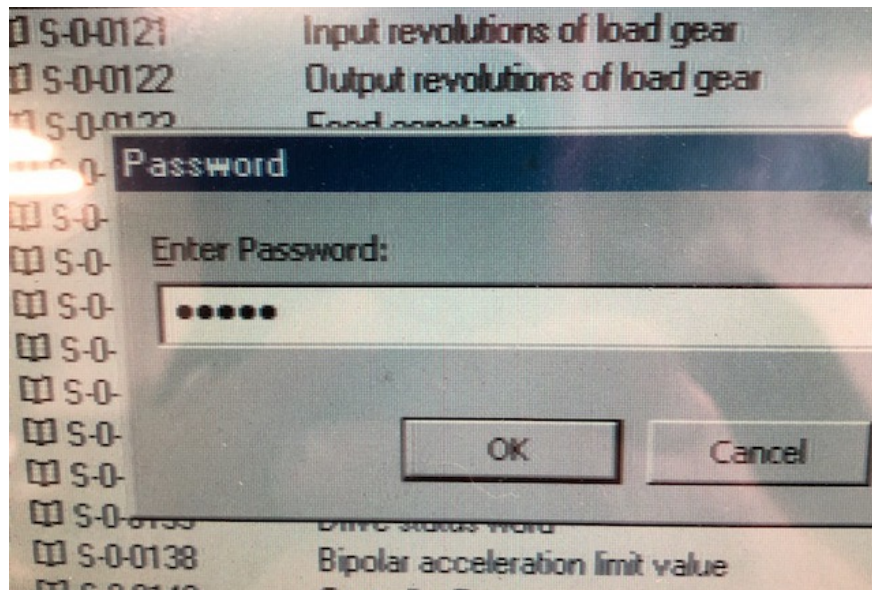
5. Select X-axis



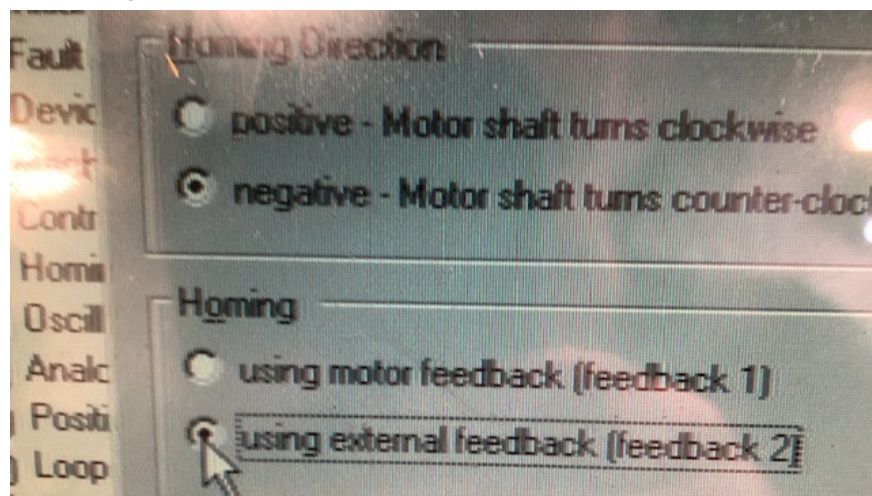
6. Scroll down to S-0-0147



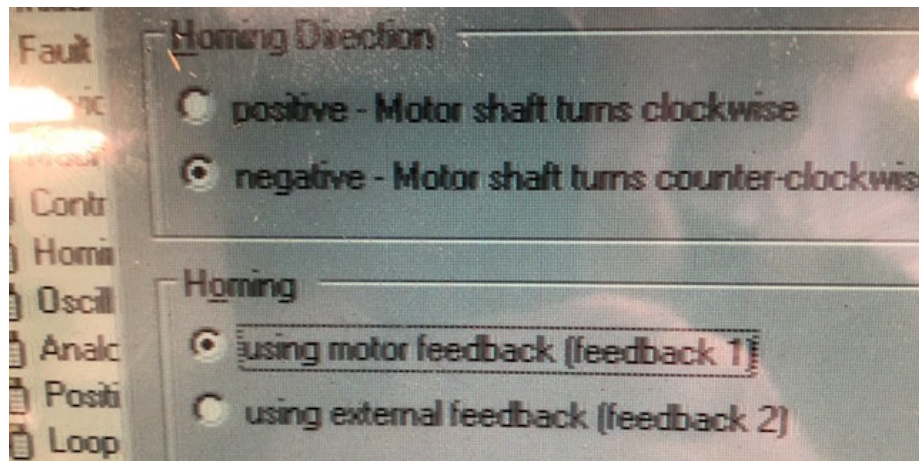
7. Enter password **pass1**



8. Change from "Using external feedback"...

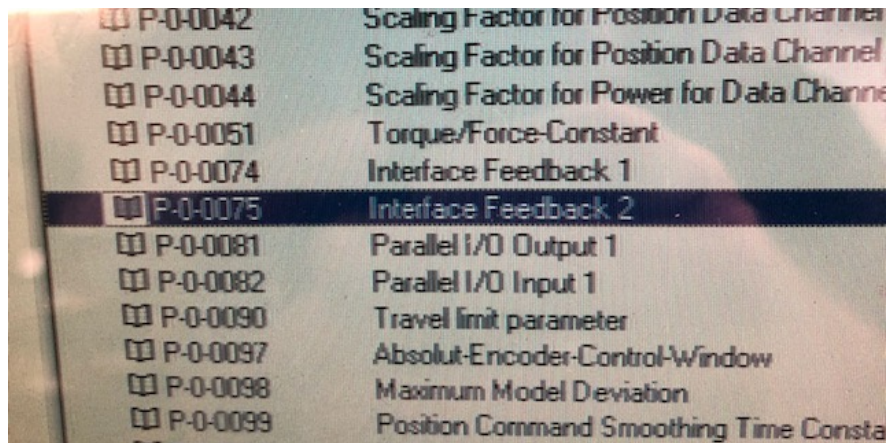


9. To "Using motor feedback"

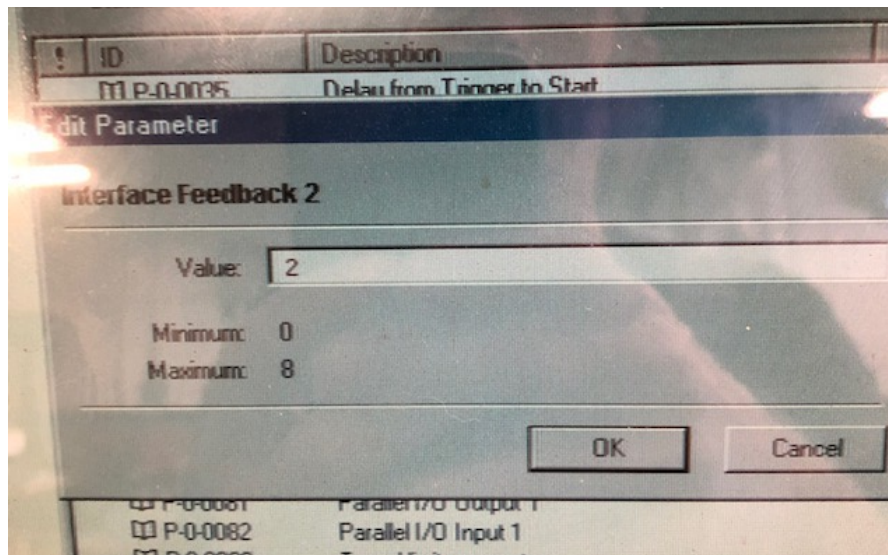


10. Scroll down to P-0-0075

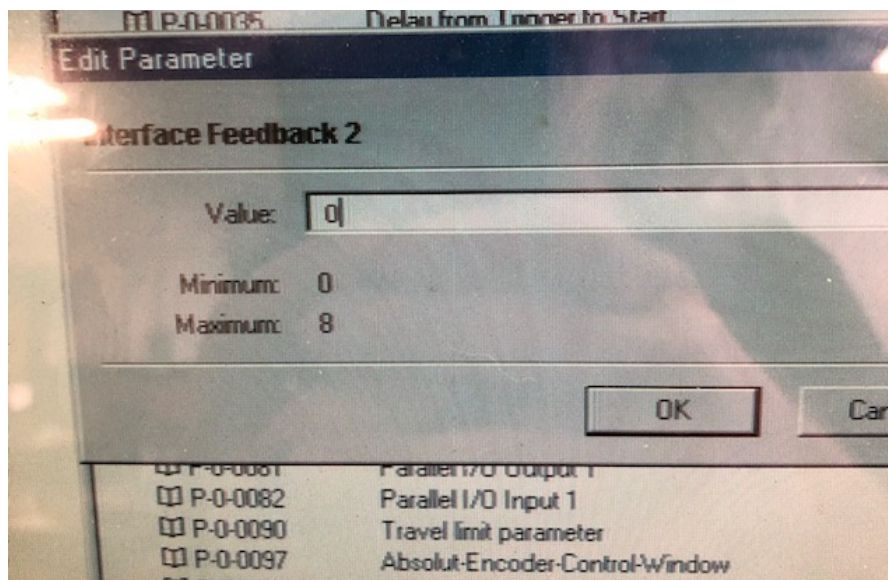
11. Change "Interface Feedback value 2"...



- From 2...



- To 0



12. Close out drive data
13. Shut down the control and the machine/main switch
14. Disconnect the glass scale cable from the drive
15. Turn the machine back on.