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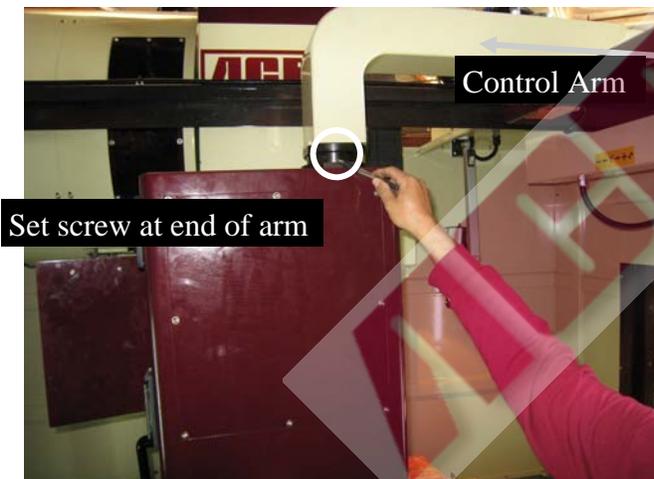
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## PROCEDURE TO SETUP VMC 2240XL W/ FANUC OiMC CONTROL

1. Unwrap the machine, check out machine for any physical damage. If so, report to your dealer as soon as possible. Touch-up paint is inside the toolbox. Use it as needed.



2. Loosen set screw. Swing out control panel. Take out control support, if included.



3. Remove the magazine support.

4. Check input power that will be used for the machine. Power required for our machines are: 230V three phase (3 $\Phi$ ) or 460V three phase (3 $\Phi$ ). Power must be first specified upon ordering. There is a transformer with the machine which converts power to 200V to run control (see picture below).



Power input



Output L1, L2, L3  
(200V to CNC control) **use meter check to make sure 200V**

Input U, V, W which can be adjusted to fit your power needs



5. Hook up air with 90 psi. This is important for ATC machine. For every ACER VMC2240XL, the air pressure would have been already adjusted. If you feel the need to increase the air pressure that goes into the machine, you can pull the knob and turn to adjust the setting. We strongly recommend to use the **AIR HOSE** of the size 3/8" or 1/2".



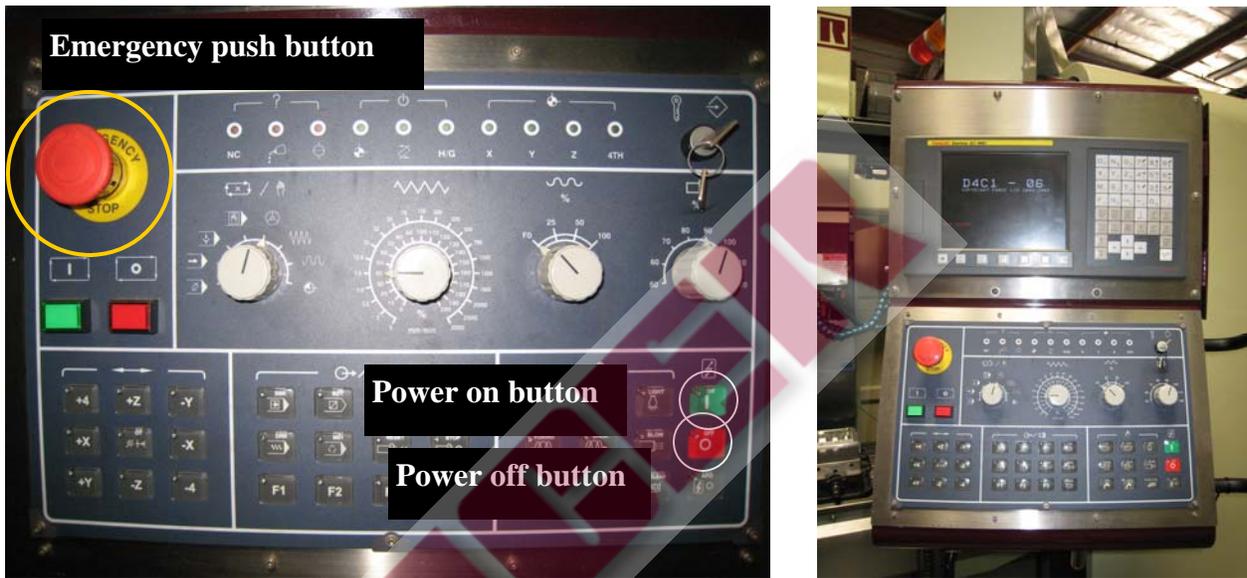
Pull knob up and turn to adjust setting. 90 psi minimum

3/8" or 1/2" air

Make sure oil is full

6. Before powering machine, open the electric enclosing cabinet. Make sure all wires and cables are tight.

7. Release counter balancing support and spindle head support.  
Step 1. Person A, Release emergency push button. Turn on machine by pushing the green power on button. Machine will start to load CNC software in about 20 seconds.



Turn function knob to hand wheel function (See page 4) (HND) on display. Select Z on MPG (Manual Pulse Generator). Set to X100, slowly move up spindle (+) and take out spindle support (orange bracket)



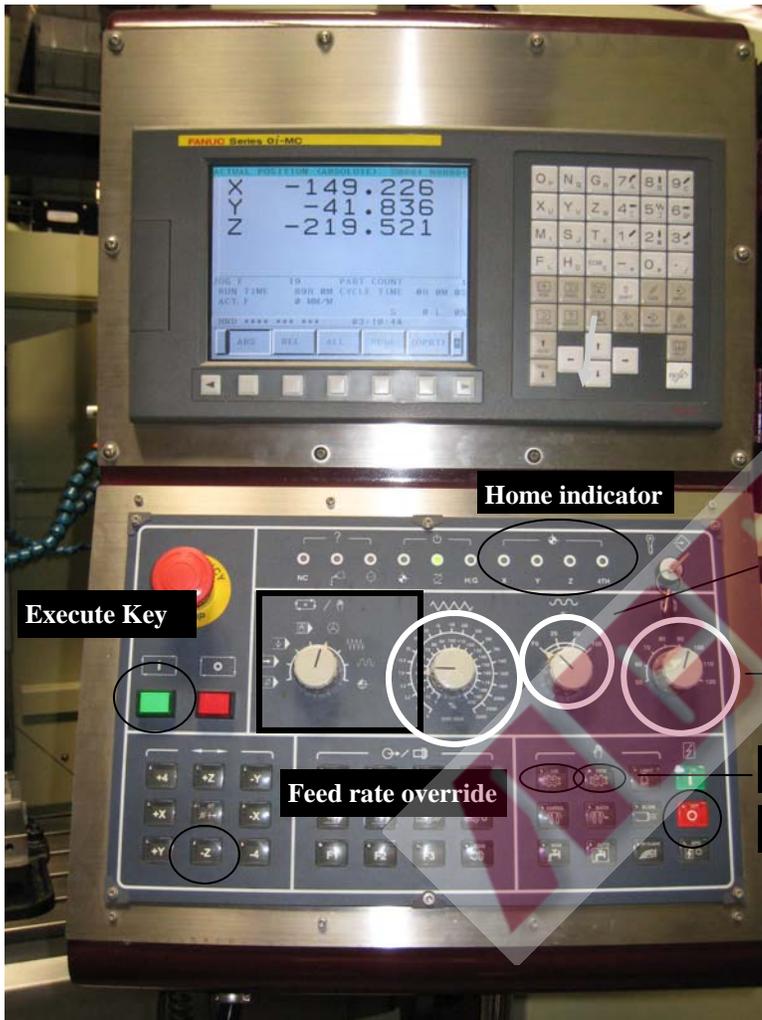
Spindle Support



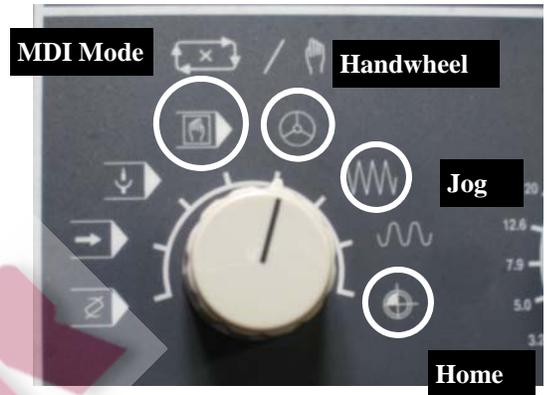
MPG

## Step 2 Release Counter Balancing Weight

Person B, on the top of the machine, give signal to Person A to move the (spindle) Z all the way down (-) slowly by turning jog to “feed” x100 turning feed rate override to 10% and pressing -Z down movement until both chains catch the counter balancing weight. Loosen 2 big screws to release balancing counter weight.



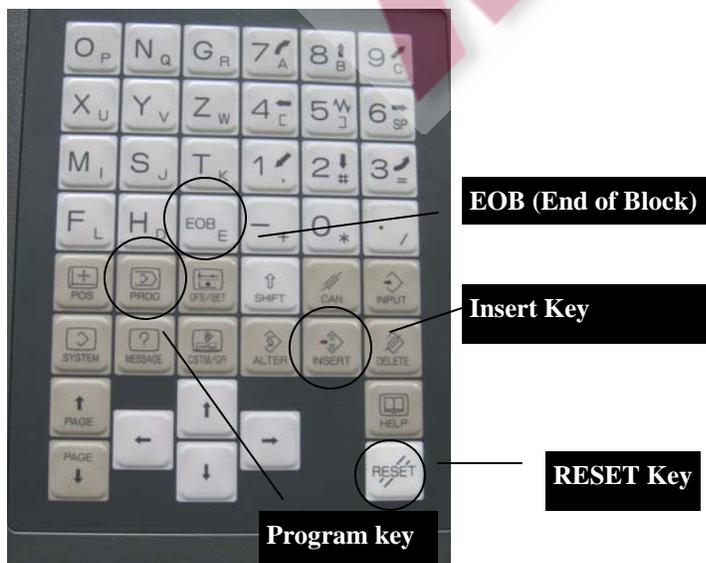
## Function knob



8. Home Machine: Turn function knob to home (See page 4). X, Y, Z Home indicator start to flash. First put rapid rate to F0. Push +Z button. The home light will stop flashing when Z on home position. Push -X, +Y, until all X, Y, Z home light stop flashing. \* (see page 4)

9. Check Magazine Rotation. Turn function knob to MDI mode, type command M60, press Execute green key. (see page 4) Use CCW / CW key to check magazine rotation. If opposite direction, press power off (Red) push button to shut down machine (see page 4). Switch any two power line that go into the machine.

10. Spindle checking: Follow procedure, turn on control. Turn function knob to MDI Mode (see page 4). Press program key. Press EOB key. Type M3S1000, press EOB key. Press Insert key. Press the execution green button. Hit Reset key to stop spindle Turn the function knob to feed rate or rapid mode then push CW pushbutton and Stop, CCW, push to test spindle direction. Once on the spindle on, test spindle override. (See page 4)



### 11. Leveling the machine

Precisely leveling the machine on a solid foundation. Precise leveling of the VMC2240XL is important to the finish of the product and the tolerance of the machine. Machine level in X and Y axes has to be within .0004/12” or better.

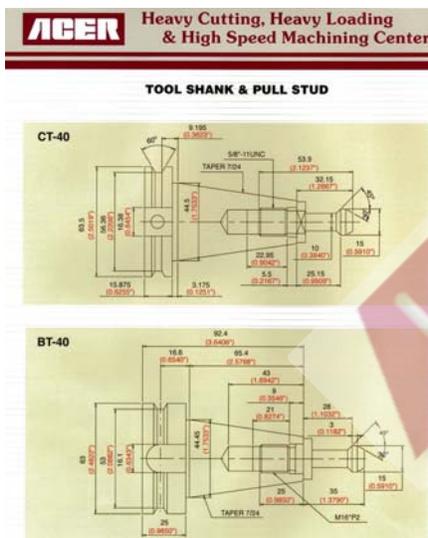
### 12. Warm-up spindle/ X,Y, Z movement

It is recommended that customers should warm up machine by slowly running spindle rpm under 1000 rpm and run machine with low feed rate for 15 minutes everyday before actually cutting anything.

The program can be written in the way that would help machine to “get ready” for production.

13. For auto lube pump, we recommend you to use way oil #2 or follow the manual suggestion.

14. Using the correct tool: CAT 40 or BT 40.



15. Ready to run your CNC machine: please read through the Fanuc manual to familiarize all G code/ M code and programming on the control. Call Fanuc support 888-326-8287 if you have any questions about the programming.

16. If you have any problems or questions, first call your dealer for quick questions and service. If dealer is unable to resolve your problem call Acer at 714-632- 9701 (CA) 732-752-9100 (NJ) or Fanuc at 888-326-8287 (technical support) for further assistance.