

Important Notes for Using CD-SVR and CD-SVRSG Issued 06/26/2019

Please review the important notes below while setting up the operation of the servo tip dresser. Failure to follow the proper steps may lead to damage to the tip dresser.

- Ensure the proper gear ratio is correctly set under the motor setup of the controller

Dresser	Gear Ratio	Recommended RPM	
		On Motor Shaft	On Output Gear
CD-SVR	5 to 1	1500 - 2000	300 - 400
CD-SVR-SG	4 to 1	1200 - 1500	300 - 375

- Ensure the correct cutter/holder thickness when the gun is closed for tip dress is correctly set up. Standard CD-SVR cutter/holder thickness is 5mm and CD-SVRSG cutter/holder thickness is 10mm. Please measure to double check before completing the parameter setup. Some may vary.
- Ensure the motor does not rotate the tip dresser at an improper speed. Do not rotate beyond the max acceptable RPM.

Dresser	Acceptable Max RPM	
	On Motor Shaft	On Output Gear
CD-SVR	2000	400
CD-SVR-SG	1500	375

- Ensure the cutter/holder continues to rotate at the full tip dress speed after tip dress has been completed. Keep the tip dresser rotating at this speed until the gun fully opens after tip dress.

Note from Fanuc:

To have the dresser run longer after pressurization is complete. Change the end distance term type to fine or a lower CNT value. This is found by going to the distance schedule under the data screen and selecting detail for the schedule.

- Ensure the cutter/holder rotates at the full tip dress speed and Chip collection system is activated for 3s after tip dress has been completed.

