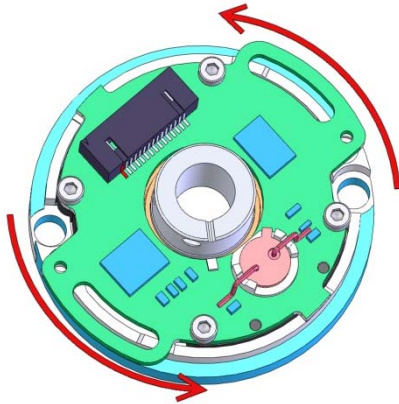


(QM35 Connector shown in illustrations)

STEP 1:

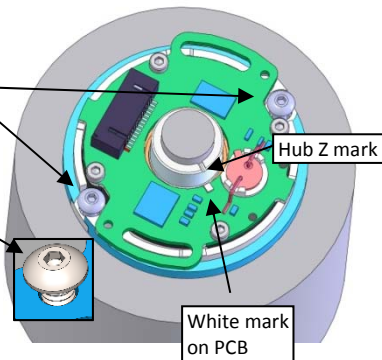
Rotate printed circuit board (PCB) to expose the mounting holes. This is the Lock position. Mounting/motor surface must be clean and flat.



STEP 2:

a.) Install mounting screws through encoder into mounting/motor surface. Insert 1-2 turns. **DO NOT** tighten screws.

b.) Align Z mark on hub to White mark on PCB.



STEP 3:

a.) Press down on the hub with a force between 150gr (.33lbs) and 700gr (1.5lbs). This will center the encoder assembly to the motor shaft.

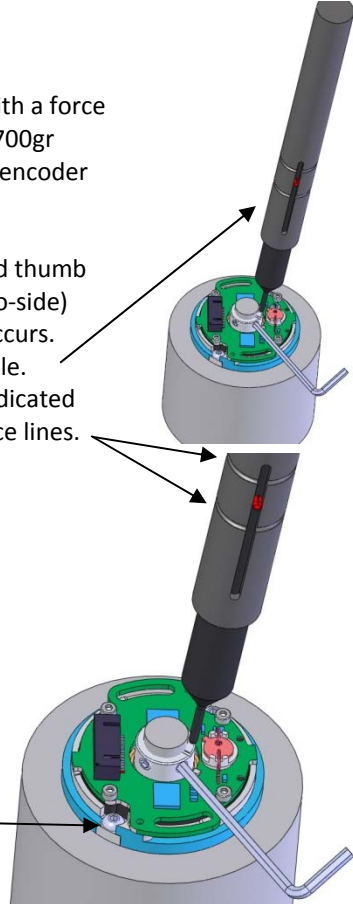
b.) Using slight forefinger and thumb force, verify no radial (side-to-side) movement of the encoder occurs. Illustrated is accessory Q-Scale. Proper downward force is indicated when pin is between the force lines.

STEP 4:

a.) Tighten hub set screws (28-32oz-in) to motor shaft.

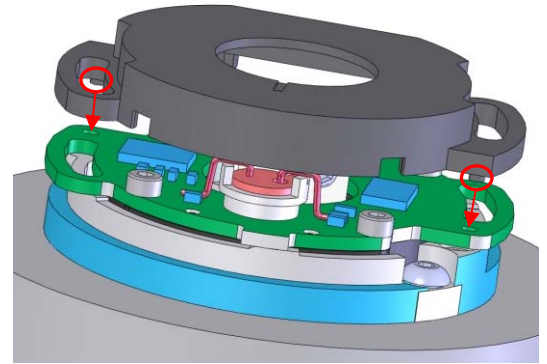
b.) The downward force on the hub can be removed.

c.) Tighten mounting screws to 48oz-in.



STEP 5:

Place cover on encoder. Observe the cover dowel pins positioned into mating PCB holes.

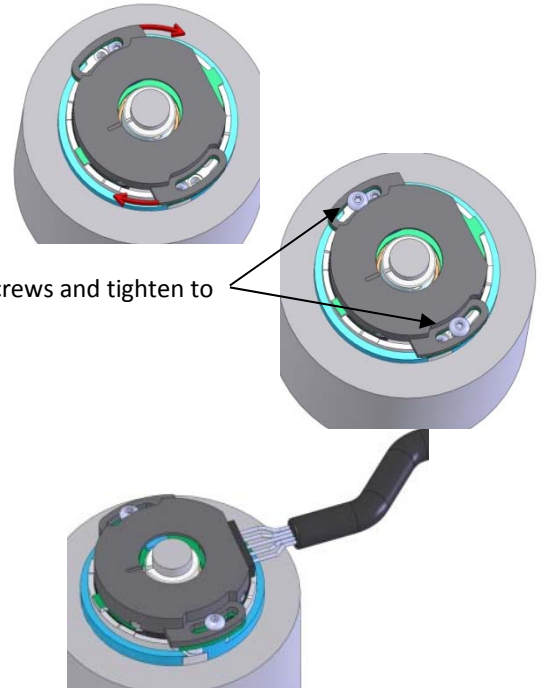


STEP 6:

a.) Twist cover/PCB to expose screw holes for cover screws.

b.) Install cover screws and tighten to 40oz-in.

c.) Install cable to complete installation.

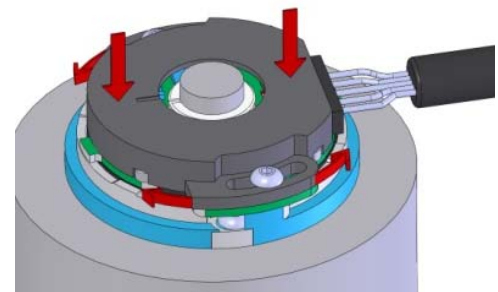


DYNAMIC ALIGNMENT OF U, V, AND W COMMUTATION CHANNELS:

a.) Loosen the cover screws slightly, to allow the encoder body to be rotated.

b.) Maintain a slight downward pressure on the cover.

c.) Rotate encoder to align commutation channels to motor windings. Tighten cover screws to 40oz-in.



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