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New OSP 7000 Alarm that is not in the Alarm & Error List

4053-D	VAC Power Supply Voltage Flutter Over

The Power Source Voltage Variation is Too Excessive.

Index: None
Character String: None
Code: Unknown
VAC: VACII & VACIII Control PCB Status = 34

Probable Faulty Locations: Customer Power Source

Measures to take: Use (V1-V0)/V0 to verify the Power Source Impedance.

V0 - VAC Voltage at rest across any two VAC inputs. R, S, T.
V1 - Maximum Voltage when motor is under deceleration.

If the Supply Voltage is 220V, then the maximum variation can be no more than 6%.

It is advisable to use an Analog type Multi-meter or Storage Oscilloscope for optimum accuracy.

Temporary Measure: In case the customer power source is insufficient, we can temporarily mask the Alarm until the power source is corrected.

Spindle Motor Torque Limit

Optional Parameter Word #72, Factory Initial Value is 100%.

100% equates to full spindle motor power; by reducing this value (40-100) we can minimize the power required for machine operation.

It should be noted that reduction of O.P. Word 72, will extend the Spindle acceleration and deceleration time, and, in addition, lower the cutting force.

It is recommended *not* to use this parameter setting as a long term solution, but to correct the shop power for optimum performance and long term component reliability.

If you have any questions, please feel free to contact the OSP Service Group.