

10. MPT – integrated X-Y positioning table

Integrated manual X-Y positioning table (MPT)



Manual / technical details

10.	MPT – INTEGRATED X-Y POSITIONING TABLE	79
10.1	Delivery content.....	80
10.2	Technical data.....	80
10.3	Safety instructions	81
10.4	Commissioning.....	81
10.5	Operating table and thread tapping machine	82

10.1 DELIVERY CONTENT

Number	Article
1	MPT – matrixtap (workpiece positioning table)
1	adjustable holding
1	fixture out of metal (225 mm)
1	fixture out of metal (125 mm)
1	hexagon key (5 mm)

10.2 TECHNICAL DATA

Model

- Type workpiece positioning table
- Designation matrixtap

Machine data

- Clamping electrical magnets
- Operating voltage, frequency 230V, 50/60Hz
- Power consumption 25W

Dimensions

- L x W x H 680 x 560 x 195 mm
- Working area L x W 600 x 250 mm
- T-slot sliding blocks 8 mm
- Weight 35 kg

Adjustable taken off roller guides

- X- axis 4 sledges
- Y- axis 4 sledges

Envelope

- X- axis 350 mm
- Y-axis 180 mm

10.3 SAFETY INSTRUCTIONS

Safety instructions **please see 1.4** manual microtap / megatap

The transport should be made only with the original packing.

To change the workpiece in working breaks (if the machine remains unsupervised) the switch must be set to "OFF", so that the unintentional pressing of the start lever does not start the thread tapping machine.

The working process can be broken off in operation mode "AUTO" by repeated pressing of the start lever.

- By pressing the start lever during screwing in, the thread tapping unit will be switched to return travel.
- By pressing the start lever during return travel, the machine stops



ATTENTION:

Repeated pressing of the start lever causes a further inserting of the tool..

TIP To unscrew the tool

1. Change turning direction of the motor (MOTOR SETUP)
2. Start by hand lever
3. Change the turning direction of the motor again.



ATTENTION

For cleaning the machine **no compressed air** may be used.

Chips can come in the roller guides and impair the running properties substantially

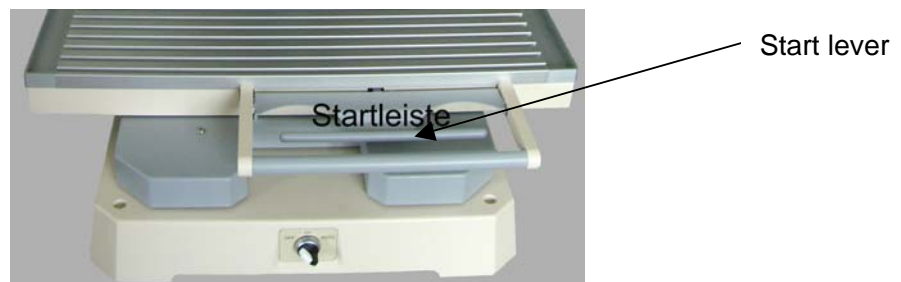
10.4 COMMISSIONING

1. Turn the switch at the switchbox of the table to "OFF"..
2. Remove fans cover (rear side) connect 15 pol. Socket I/O cable of the MPT and secure
Reinstall fans cover
3. Plug the mains cable.
4. Select operation mode vers. 1 or 2

10.5 OPERATING TABLE AND THREAD TAPPING MACHINE

Operating mode „ON“

- Before operating the parameter at the thread tapping unit have to be set.
- Set the turn switch to operating mode "ON".



- By pressing the start lever the clamp of the table will be unlocked. To push the table in another position, press the start lever.
- After positioning release the start lever

Version 1-2 to select operation mode „AUTO““ (see page 5)

- Set turn switch to position OFF
- Hold start lever pressed and set turn switch to ON
- Release start lever.

Now one of the two possible versions is loaded. This version stays saved and can be changed by repeating the a. m.

Operating mode „AUTO“

- The table has to be connected through the interface cable with the thread tapping unit (I/O interface)
The ZAP unit has to be connected. Select the desired start setup .(START Fz; START AUTO Sz; START Fz/Sz +/-)

Version 1

- Turn the switch to „AUTO“.
- Version 1 (you can hear 2 short on/off cycles of the magnets) The table clamping is switched off without pressing the start lever
- Move the table to the first hole.
- To start a working process press the start lever just until the clamping takes place automatically
- Unhold the start lever (latest before the motor is back in the start position)
- After the thread tapping process is completed the table unclamps automatically
- Now the table can be moved free to the next position
- An unfastening abort of the start level causes the break in START AUTO Sz no clamping of the table in START Fz .
A second operation during screwing causes the alteration of the turning direction of the motor.
A second operation during unscrewing the tool in mode START Fz causes a motor stop.
- In this case it is only possible to unsrew the tool manually!
- In mode START AUTO Sz the tool can be unscrewed from the machine by changing the turning direction (MOTOR SETUP).

Version 2

- Version 2 (you can hear the drop down of the magnets). The table clamping is switched off without operating the start lever.
- See version 1, the only difference is the clamping works by realeaseing the start lever not automatically.
The user himself defines the time of the table clamping.
- The switch off takes place automatically.
- An abort takes place after a second operation in mod START AUTO Sz and an alteration of the turning direction in mode START Fz (after the motor has started!)
A second operation during unscrewing the tool in mode START Fz causes a motor stop.
- In this case it is only possible to unsrew the tool manually!