

ISCT-23 SERVO CENTER

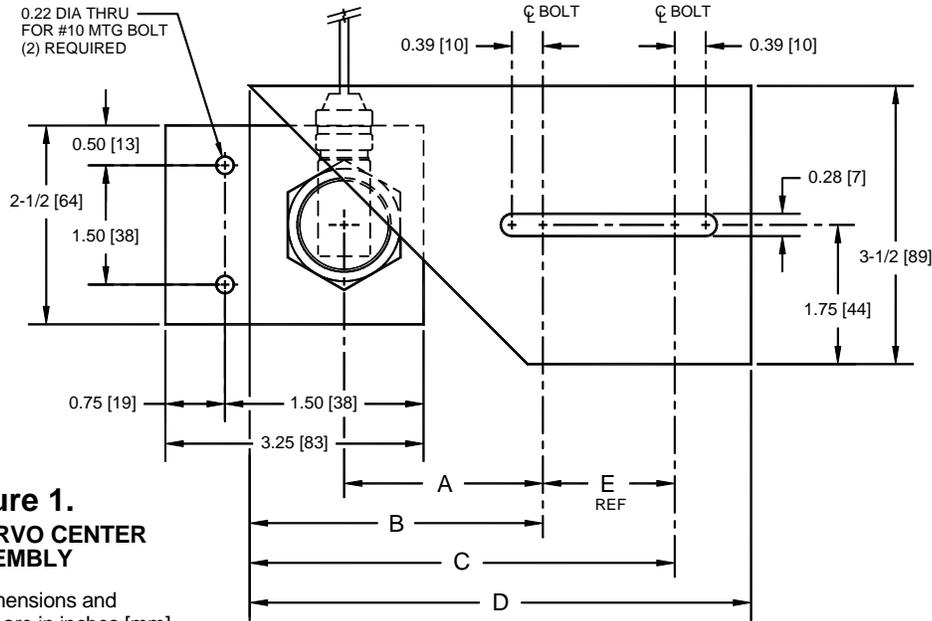


Figure 1.
**ISCT-23 SERVO CENTER
ASSEMBLY**

NOTE: All dimensions and specifications are in inches [mm] unless specified otherwise.

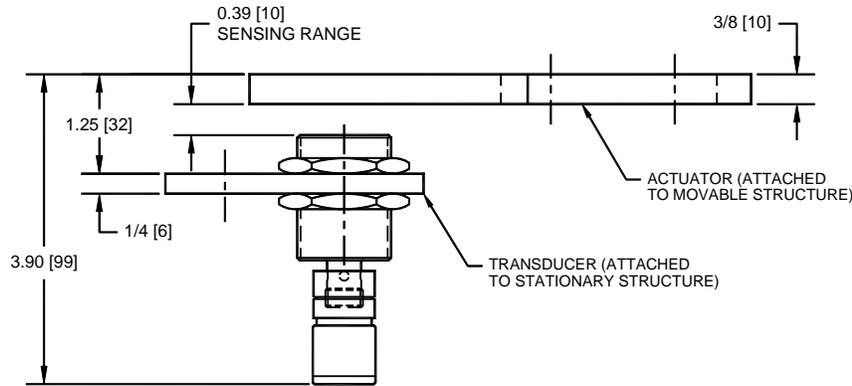


Table 1.
ISCT-23 SERVO CENTER ASSEMBLY DIMENSIONS

ISCT-23 SERVO CENTER PART NO.	WEB GUIDE CONTROLLER	A DIM Inch [mm]	B DIM Inch [mm]	C DIM Inch [mm]	D DIM Inch [mm]	E DIM Inch [mm]	MAX GUIDE STROKE Inch [mm]
200072-001/-002	DP-20	2.12 [54]	3.31 [84]	4.97 [126]	6.31 [160]	1.66 [42]	2.0 [51]
200072-003/-004		5.27 [134]	6.46 [164]	8.54 [217]	9.50 [241]	2.08 [53]	9.0 [229]
200072-005/-006		7.63 [194]	8.82 [224]	10.85 [276]	11.81 [300]	2.03 [52]	13.0 [330]
200072-007/-008		8.40 [213]	9.59 [244]	12.85 [326]	13.75 [349]	3.26 [83]	15.0 [381]
200072-009/-010		9.90 [251]	11.09 [282]	14.35 [365]	15.25 [387]	3.26 [83]	18.0 [457]
200072-011/-012	D-MAX	2.12 [54]	3.31 [84]	4.97 [126]	6.31 [160]	1.66 [42]	2.0 [51]
200072-013/-014		5.27 [134]	6.46 [164]	8.54 [217]	9.50 [241]	2.08 [53]	9.0 [229]
200072-015/-016		7.63 [194]	8.82 [224]	10.85 [276]	11.81 [300]	2.03 [52]	13.0 [330]
200072-017/-018		8.40 [213]	9.59 [244]	12.85 [326]	13.75 [349]	3.26 [83]	15.0 [381]
200072-019/-020		9.90 [251]	11.09 [282]	14.35 [365]	15.25 [387]	3.26 [83]	18.0 [457]



Servo Center Installation

WARNING When the guide system is turned on, or activated, and placed in the SERVO CENTER mode, adjusting the servo center will cause the guide to move. **Keep hands clear of the moving guide structure.**

Installation procedures for mounting the servo center device are as follows:

1. Provide mounting holes in both members as shown.
2. Mount the servo center and the actuator as shown.
3. Connect the servo center cables to the signal processor.

4. Move the guide (or stand) to its midstroke. Adjust the actuator to center the guide.
5. With the system powered, place the **MODE SELECTOR** switch in the SERVO CENTER position. If the guide does not move, the initial adjustment is correct. If it does move, adjust the actuator in or out until the desired position is obtained.
6. Tighten all screws and/or nuts.

NOTE The "A" dimension can be increased or decreased within the limits of the adjustment range. Changing the "A" dimension will decrease the available amount of adjustment in one direction.

Servo Center Adjustment

When the system is in the SERVO CENTER mode, the actuator causes the guide to respond to signals from the servo center. This places the guide rollers parallel to the other rollers in the process line. If the guide rollers are not satisfactorily parallel to the other rollers, then a fine adjustment is needed.

Adjustment procedures for the servo center device are as follows:

1. Place the system in the SERVO CENTER mode.

2. Loosen but do not remove two actuator mounting screws.
3. Move the actuator slightly until the guide rollers are satisfactorily parallel to the other rollers in the process line.
4. Retighten the actuator mounting screws.

NOTE The air gap (distance) between the sensor and the actuator must be 0.39 inches (10 mm).



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