

FANUC: Replacing Belts on the 10/15K RPM Machines

Occasionally you will need to replace the belts on the Fadal built machines with the Fanuc Oi-M and 18i series controls. Setting the orientation position after replacing the belts really cannot be simpler.



Fadal, as they did for years, really gave some thought to the service guy or better yet, the operator on the floor who can certainly replace the belts but who really doesn't want to be fat fingering parameters hoping he is changing the correct one. All you do is make sure the belts you just replaced are tracking properly and the guides and pulleys were cleaned thoroughly, then replace the head cover, cold start the machine and issue the M84 calibration command. Simple as that. Once it is complete, which takes a minute or two, it is correct. Change tools cautiously the first time through.

If it does not come in the correct position, you can either manually change the orientation position by changing the values in parameters 4031 or 4077 depending on the orientation sensor used, but use this only as a last resort....and write down the original value in case you have to revert back to a solid starting point.

If your machine tends drift on the correct position for tool changes, or tool change orientation position, you likely have a maladjusted or bad orientation pickup sensor. Call FadalCNC.com for the replacement unit and we can ship immediately. Be sure to give us the Fanuc part number of the pick up unit as there was more than one type used.

Alright, let's get back to Chips on the floor, Parts out the door!!