

HURCO S-6 UPGRADE INSTRUCTIONS FOR CNC 150

Using name plate at the rear of the backgauge, identify the system as having "S6" suffix at the end of the model number.

1. Remove gauge from pressbrake, turn upside down and re-mount.
2. Remove 4 bolts holding the Hurco amplifier box and set aside. (It will **NOT** be used again.)



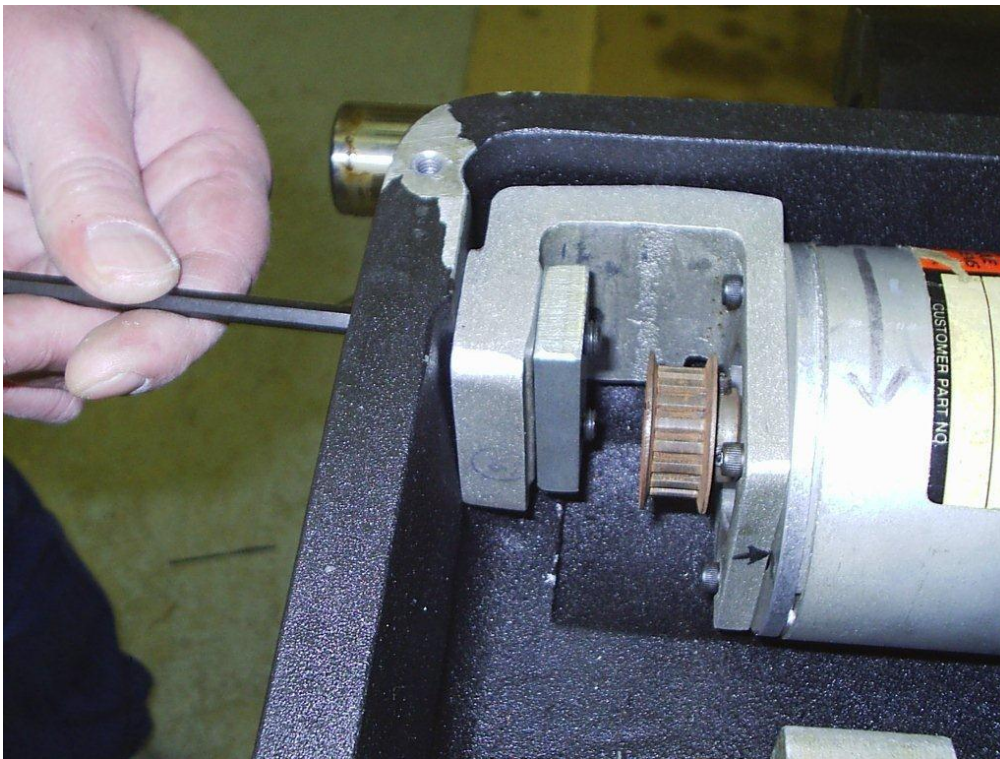
S6 Flipped Upside Down

3. Remove belt tension bolt



Belt Adjustment on S6

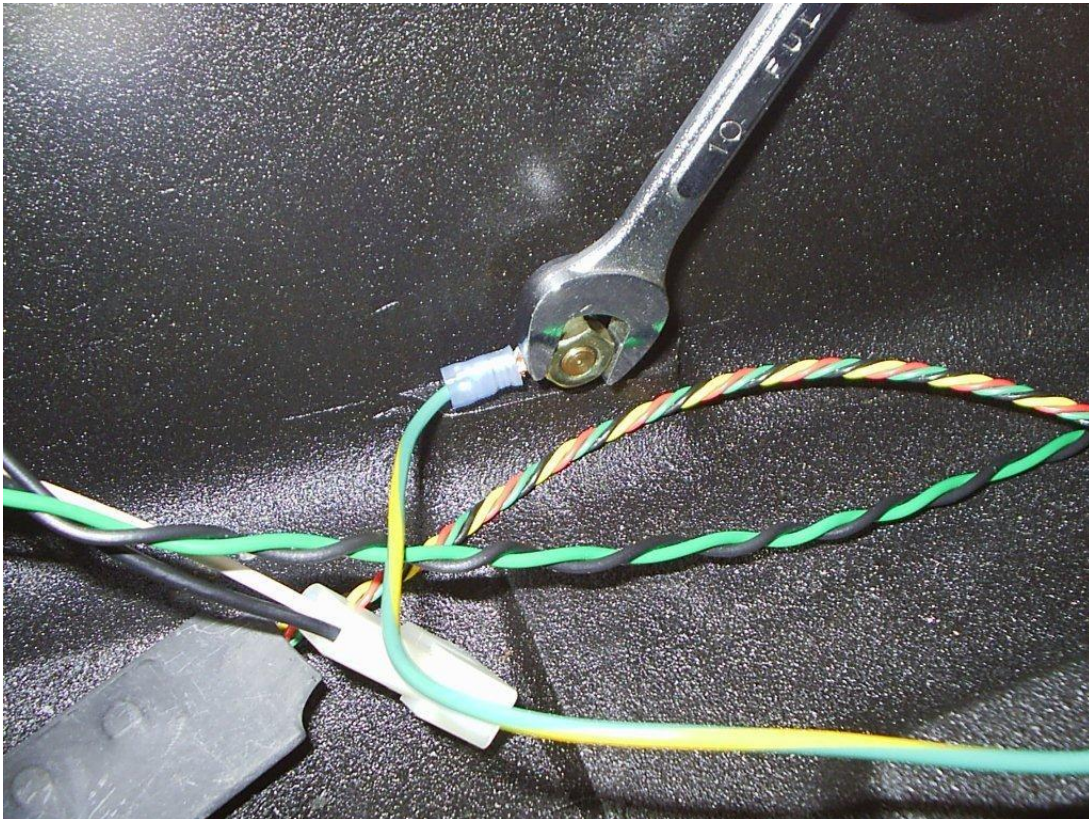
4. Remove motor bolts



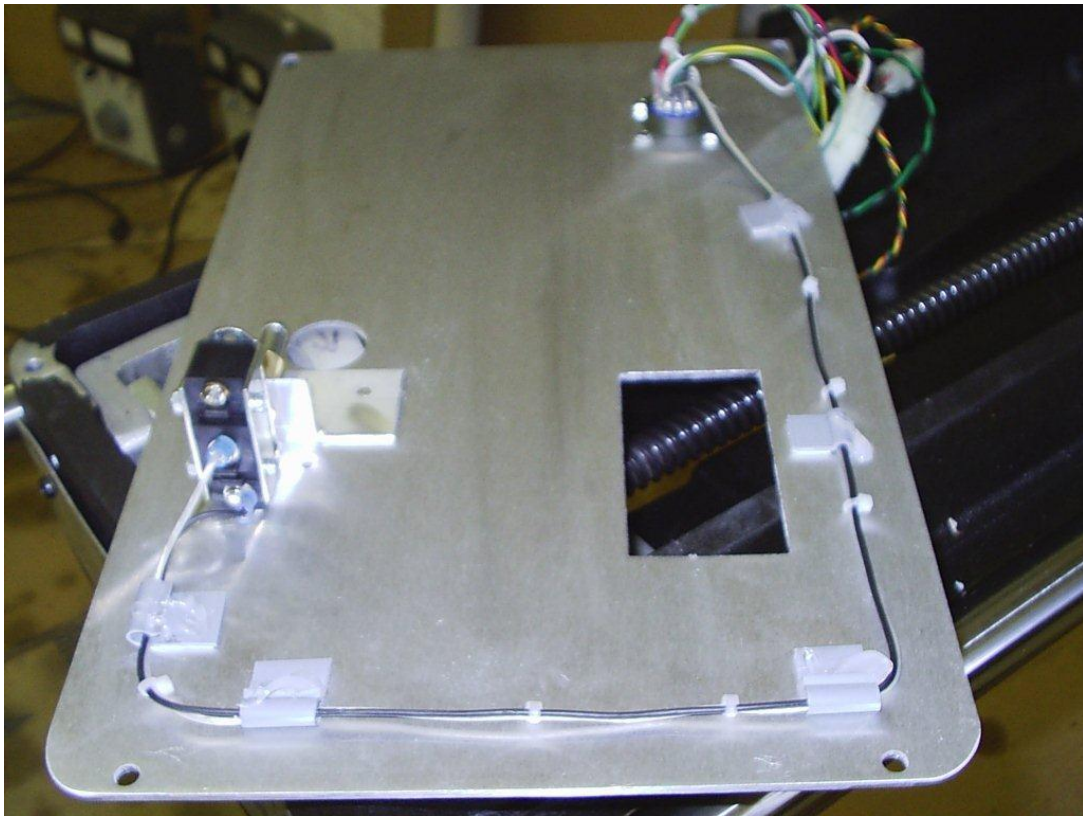
5. Disconnect wires to the motor and carefully remove the motor which will be re-used. Return the motor to Automec, 82 Calvary St., Waltham, MA 02454 and reference your customer name and order number. The motor will be tested and outfitted with an automec optical encoder. It is helpful to take before and after photos.

After Receiving Automec Components Back

6. Mount motor and tighten drive belt
7. Plug in all connections
8. Attach green ground wire to the closest ¼ stud using 6mm nut provided.



9. Mount plate w/switch using the new hardware that Automec provided (m6 x 15mm)

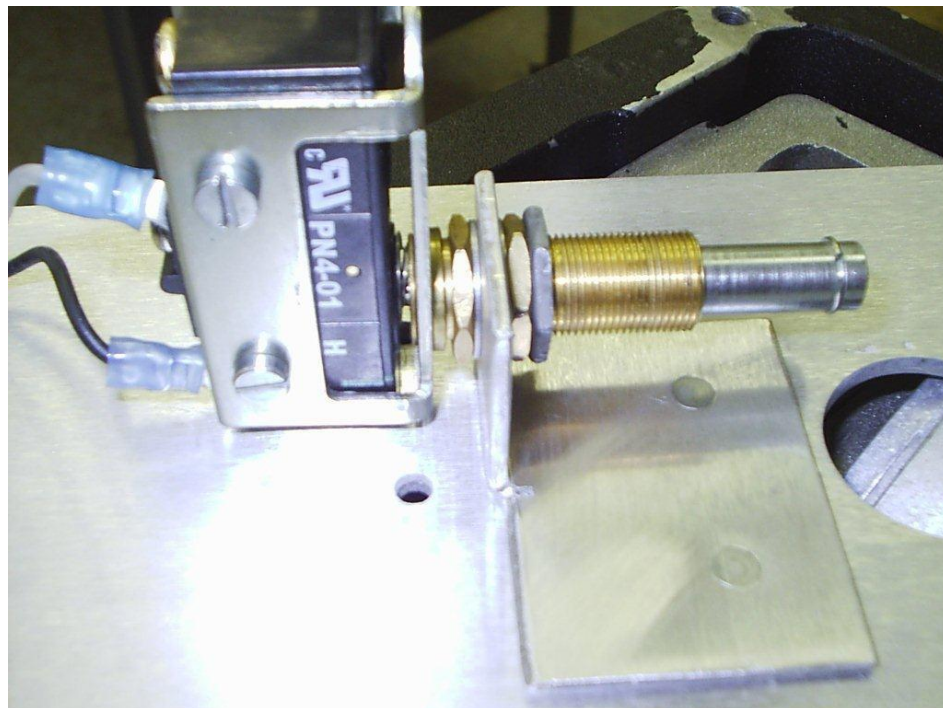


S-6 Hurco.

Fabricated Adapter Plate from Automec which Bolts Right onto S-6 Hurco



An Upside-Down View of S-6 Hurco Outfitted with Automec Adapter Plate.



Close-Up of Automec Calibration Limit Switch

10. Re-mount backgauge right side up and mount Automec gold amplifier in a convenient place.



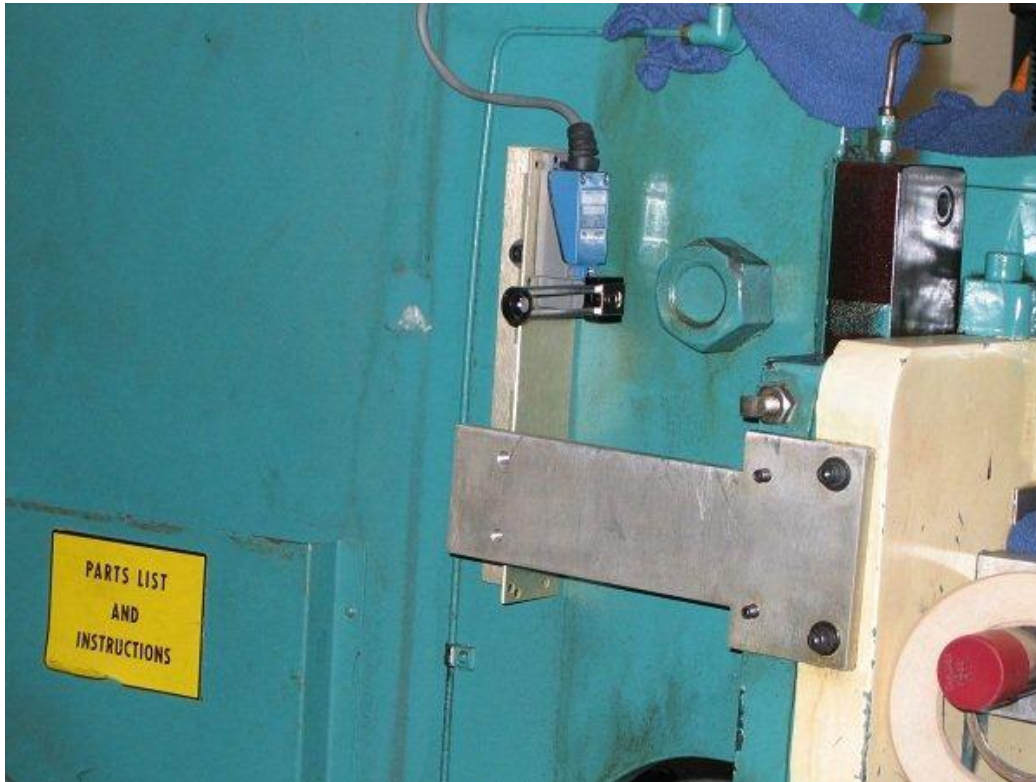
**Automec Servo Amplifiers Mounted to Side Frame. This is a 2-Axis Upgrade
On an Upstroking Pressbrake (Category 2) so There are Two Amplifiers.
A Single Axis Will Have one Amplifier.**

11. Mount control to existing Hurco pendant by making an adapter bracket depending on which Hurco pendant is found.



CNC 150 Control Mounted to Old Hurco Pendant

12. Mount the Automec auto advance switch similar to the old Hurco switch.



Typical Auto Advance Switch Mounting.

13. Dress cables and plug into 110V outlet.
14. Program the Automec CNC 150 to 2 inches and calibrate in the normal manner.

HURCO S-6

MTR SPROCKET – 18XL

BALL SCREW SPROCKET – 30XL

BELT – 130XL

MOTOR TURNS CW (LOOKING AT SHAFT) WHEN UNIT COUNTS UP TO REFERENCE (CARRIAGE

MOVES BACK)

