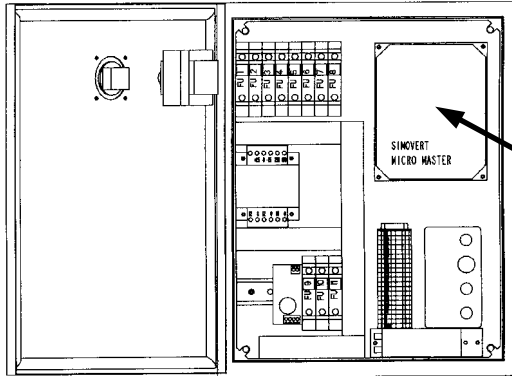


PRODUIT: **SERDI**  
PRODUCT: **60/100/200**

OBJET: **VARIATEUR DE FREQUENCE**  
SUBJECT: **FREQUENCE MOTOR DRIVE**



Our new machine range SERDI 60, 80 and 100 is fitted with an asynchronous three-phase motor driven by a microprocessor-controlled inverter SIEMENS.

This inverter is programmed and parametered in factory and does not need any further adjustment before starting up of the machine.

If any problem appears with the spindle, the following points should be checked first:

✂ **Power supply of the machine:**

- ✂ Voltage : **230V +/- 15%** single phase
- ✂ Section of wires: **2.5 mm<sup>2</sup>**
- ✂ Power : **2.5 kVA**

The wires should be **as short as possible** to avoid power and voltage dissipation.

✂ **Spindle drive working conditions:**

- ✂ Avoid too heavy drilling or milling operations
- ✂ When free, the spindle should rotate without any effort
- ✂ Chek that the spindle quill is not overheating during spindle rotation, that would indicate an overtightening of the ball bearings.

Once those points are checked, only qualified persons are allowed to control the inverter parameters according to the following list ( pages A1 to A4).

For this control, only three keys of the inverter front panel are used:

- ✂ the **P** key allows toggling between parameter number and parameter value.
- ✂ The key ✂ is used to increase the number displayed.
- ✂ The key ✂ is used to decrease the number displayed.

Please refer to the SIEMENS user's manual for complete information on the inverter and its parameters.

A programming console making parameterization and parameters memorization easier is available under reference number **009442**.

Machines concerned: SERDI 80 et 100 from serial number **1949**  
SERDI 60 from serial number **658**