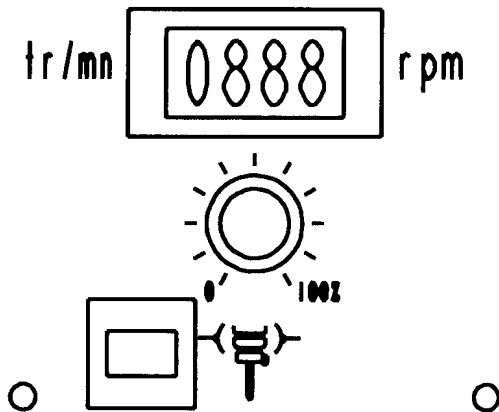


08 Octobre 1998

PRODUIT:SERDI 60/100/M3.1
 PRODUCT: SERDI 60/100/M3.1

OBJET: FREINAGE DE LA BROCHE
 SUBJECT: SPINDLE BRAKE

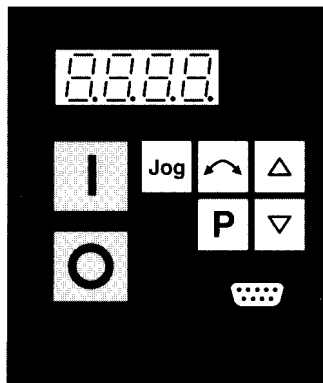
IMPERATIVE MODIFICATION: SAFETY PROBLEM
SERDI 60 WITH SERIAL NUMBER BETWEEN 852 AND 866
SERDI 100 WITH SERIAL NUMBER BETWEEN 2097 AND 2151
SERDI 101 WITH SERIAL NUMBER BETWEEN 98 AND 104
M3.1 WITH SERIAL NUMBER BETWEEN 101 AND 204
M3.1, SERIAL NUMBERS 206 AND 222



Pushing on the spindle brake button when changing tooling may generate a sudden spindle rotation. This phenomenon is rare but was observed in some cases.

Obviously this is dangerous for the operator, making the following modification necessary.

The parameters of the spindle variator must be changed, so the spindle brake works in a safe way. It is then necessary to modify the value of 4 parameters: P9=2, P53=15, P54=6, P55=7 according to the following procedure:



- | | | |
|-------|----------|-----------------------------|
| Press | P | P000 should appear. |
| Press | △ | Go to P009. |
| Press | P | 0000 or 0001 should appear. |
| Press | △ | Go to 0002. |
| Press | P | P009 should appear. |
| Press | △ | Go to P053. |
| Press | P | 0000 should appear. |
| Press | △ | Go to 0015. |
| Press | P | P053 should appear. |
| Press | △ | Go to P054. |
| Press | P | 0000 should appear. |
| Press | △ | Go to 0006. |
| Press | P | P054 should appear. |
| Press | △ | Go to P055. |
| Press | P | 0015 should appear. |
| Press | ▽ | Go to 0007. |
| Press | P | P055 should appear. |
| Press | ▽ | Go to P000. |
| Press | P | 0.0 should appear. |