CALIBRATION INSTRUCTIONS
for
SUNNEN® CV-616 VERTICAL HONING MACHINE

GENERAL
The CV-616 must be calibrated to the line voltages encountered in your shop. This will give you the ability to adjust the display so that 100% on the display matches the FLA (Full Load Amps) of the spindle motor. The only adjustment necessary is to the potentiometer labeled “ZERO”. The potentiometer labeled “GAIN”, should not be touched. Once the machine has been calibrated to a particular locations line voltage, it will not require any future adjustments.

CALIBRATION PROCEDURE
Once the machine has been prepared for service, for safety reasons, place a tool in the spindle and place a scrap work piece on tool during calibration. Then calibrate as follows:
1. Open the operator station enclosure and locate the “ZERO” potentiometer on the CV-1627 circuit board (it is near the top of the enclosure). If orange torque seal has been placed on the potentiometer, it must be carefully scraped off so that the potentiometer can be turned freely.
2. Set the feed rate at one and make any stroke adjustments necessary for the scrap work piece.
3. Turn the power to the machine on, retract the stones fully, and start the motor. Engage the spindle/stroker motor.

NOTE: It is imperative that there is no load between the stones and the work piece.

4. With a small screwdriver, adjust the “ZERO” potentiometer until you get a 10 to 15% reading on the load display.
5. Turn the machine off. At this time, check the tooling in the work piece. If a load exists between the stones and the work piece, steps 3 and 4 must be repeated.