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# I.0 Introduction

## I.1 EMC AND LOW VOLTAGE COMPLIANCE

The B60 Readout conforms to the relevant European standards for electromagnetic compatibility and low voltage directive as detailed below.

BS EN 61000-6-4:	Electromagnetic compatibility. Generic Emission Standard - Industrial Environment
BS EN 61000-6-2:	Electromagnetic compatibility. Generic Immunity Standard - Industrial Environment.
BS EN 61010-1:	Safety requirements for electrical equipment for measurement, control and laboratory use.



Certificate No FM36096

## I.2 TECHNICAL SPECIFICATIONS



<b>Dimension:</b>	
<b>Height:</b>	140mm (5.5in)
<b>Width:</b>	240mm (9.5in)
<b>Depth:</b>	80mm (3.2in)
<b>Weight:</b>	2.5kg (5.5lbs)
<b>Operating Voltage:</b>	115 or 230V (switch selection)
<b>Supply Voltage Fluctuation:</b>	Not to exceed +/-15% of the operating voltage
<b>Supply Frequency:</b>	50 to 60 Hz
<b>Maximum Power Consumption:</b>	18VA
<b>Operating Temperature:</b>	0 to 45°C
<b>Storage Temperature:</b>	-20 to 70°C
<b>Inputs:</b>	Dependant on model, one, two or three Spherosyn/Microsyn encoders
<b>Resolution:</b>	
<b>Spherosyn/Microsyn 10</b>	5µm (0.0002in) / 10µm (0.0005in) / 20µm (0.001in) / 50µm (0.002in)
<b>Microsyn 5</b>	1µm (0.00005in) / 2µm(0.0001in) / 5µm (0.0002in) / 10µm (0.0005in)
<b>Environmental Conditions:</b>	Indoor Use, IP20 (IEC 529)
	Relative humidity - maximum 80% for temperatures up to 31°C decreasing linearly to 33% at 45°C
	Transient overvoltage according to INSTALLATION CATEGORY II of IEC664
	POLLUTION DEGREE 2 in accordance with IEC664

NOTE: NEWALL MEASUREMENT SYSTEMS RESERVES THE RIGHT TO CHANGE SPECIFICATIONS WITHOUT NOTICE.

# 2.0 Installation



This symbol appears on the equipment and refers to the safety aspects detailed below.



## 2.1 MOUNTING

B60 is supplied with a fixing kit consisting of a M10 stud, nut and washers. Figure 1.2b shows use of this in conjunction with a mounting arm.

Be sure that the mounting arrangements are secure as the operator will need to apply pressure to the front panel when using the keypad.

A single or double mounting arm bracket can be supplied as a optional extra.

An optional mounting assembly (Part no: 294-37740) is available which allows for tilt and rotation (See Figure 1.2a).

Select the location of the B60 with due regard to safety and ease of operation. Keep clear of moving parts and coolant spray. Ensure that the natural ventilation around the cabinet is not restricted.

To ensure correct operation of the B60, it is recommended that the unit's case is grounded to the machine upon which it is fitted. Use a wire or strap of a least 1.5mm<sup>2</sup> (16 AWG) from the cabinet equipotential terminal (See Figure 1.3) to a suitable point on the machine body. The wire should be as short as possible. The machine must also be properly grounded to a good earth point.

## 2.2 POWER SUPPLY



**BEFORE CONNECTING THE ELECTRICAL SUPPLY TO THE CABINET, CHECK THAT THE VOLTAGE SELECTOR SWITCH IS CORRECTLY SET.** Figure 1.3 shows the position of this switch.

The mains supply is connected through a detachable supply cord. The B60 is supplied with a cord with a right-angle connector. If another supply cord is used, it must have fitted a IEC320, 10A, EARTHED mains connector with a cord rated for at least 10A.

The PROTECTIVE EARTH CIRCUIT of the mains supply **MUST BE CONNECTED** to the protective earth terminal of the cabinet through the supply cord.

The supply cord should be secured to the mounting arm or pillar with cable ties to ensure that it cannot drop into a hazardous position, ie. the floor or coolant tray, when disconnected from the cabinet.

The supply cord must be routed away from moving parts, swarf, coolant or sources of heat.

If a mains plug is not already fitted to the supply cord or is of the wrong type, then a suitable EARTHED plug should be used which complies with the relevant specifications for plugs and socket-outlets.

The mains supply fuse is a 20x5mm, type T0.5A, 250v. It is not to be replaced by the operator. If the fuse blows it is a possible indication of some significant problem with the power source. Check the supply and wiring carefully. If the fuse is replaced, the cabinet must first be disconnected from the supply by the removal of the IEC socket from the inlet. Do not position the equipment so that it is difficult to operate the disconnect device.

**NOTE:** If the equipment is used in a manner not specified by the manufacturer, the protection provided by the equipment may be impaired.



## 2.3 CONNECTIONS

Figure 1.3 shows the connection sockets at the back of the B60. The **B60** is suitable for use only with Newall Spherosyn and Microsyn analogue encoders.

Ensure that all cables are secured to prevent the connectors from dropping into hazardous positions when unplugged, for example the floor or coolant tray.

Ensure that all cables are routed to prevent them from being caught on moving parts. Turn off the power before connecting the encoder, by disconnecting the power supply connector.

Ensure that the **B60** is grounded to the machine before turning on the machine supply.



## 2.4 SWITCHING ON

The mains supply switch for the B60 is mounted on the back of the unit as shown Figure 1.3.

When you switch on the B60 the unit will automatically go through a brief self diagnostic routine.

During this routine, the name B60 will be shown then the software version number will be displayed and all segments of the displays will be lit.

After this routine, the unit will display measurements and is ready for use.

### CONVENTIONS USED IN THIS MANUAL


The direction of travel of an axis refers to the travel of the tool relative to the workpiece. Keys on the keypad are signified in bold print, such as [ **ent** ] for the enter key.

## 3.0 Set-Up

The Set-Up procedure allows you to to change the main default settings for the B60 (See Table 1). For normal use, you will find that you only need to perform the Set-Up procedure once, and it is possible that the factory defaults are suitable for your needs without change.

The Set-Up procedure can only be activated just after power is switched on to the unit. After switching on, press the concealed key which is located under the “**NE**” of the NEWALL logo on the keypad (See Figure 1.1). The key must be pressed before the end of the initial self diagnostic routine.

When you have entered the Set-Up routine, the letters ‘**SET-UP**’ appear in the **A2** axis display.

The Set-Up procedure makes use of a menu system. The main menu consists of a list of options that can be customised for your use (see table 2). You simply press the [ **abs/inc** ] key to scroll through this list until you reach the option you wish to change. To change the option when selected, press the  key.

The B60 is configured as a generic Digital Readout in either a 2 or 3 axes version. As such it must be configured for the machine type to which it is to be operated on if the benefits of the machine specific functions are to be had. The unit is factory configured for Basic operation and reference to Section 3.1 should be made to select the machine type

To exit the Set-Up routine press the concealed key (“**NE**” of the NEWALL logo).

Table 1 - Default Settings

Default Setting	B60
Type	Basic
Sleep	On
Input Type	Spherosyn
Resolution	0.005mm
Direction	I
Radius / Diameter	Rad
Linear Compensation	0

Table 2 - Menu Options

**TYPE**

- MILL
- LATHE
- BASIC

**SLEEP**

- ON
- OFF

**ENCODER TYPE**

- SPHEROSYN
- MICROSYN

**RESOLUTION**

- (SPHEROSYN) - 5 $\mu$ m / 10 $\mu$ m / 20 $\mu$ m / 50 $\mu$ m
- (MICROSYN) - 1 $\mu$ m / 2 $\mu$ m / 5 $\mu$ m / 10 $\mu$ m

**DIRECTION**

- 0
- I

**READINGS**

- RADIUS
- DIAMETER

**LINEAR ERROR COMENSATION**

- USER DEFINABLE



### 3.1 MACHINE TYPE

The B60 can be configured to act in Lathe, Mill or Basic mode. See Section 6.0 for details on machine specific functions.

In Set-Up press the [ **abs/inc** ] key until the [ **A1** ] axis shows the legend "TYPE". The [ **A2** ] axis will show the current setting. Pressing the [ **A2** ] key will move between the machine type options.

When the selection is made press the [ **abs/inc** ] key to continue to the next option.


### 3.2 SLEEP/DATAHOLD

In the Set-Up routine, press the [ **abs/inc** ] key until "SLP ON" is displayed. Press  and the choice of "SLP OFF" appears. You can toggle between "SLP ON" or "SLP OFF" by pressing the  key.

Select "SLP ON" if you want to be able to use the Datahold facility.( see Section 5.7 below for a description of Datahold). Otherwise select "SLP OFF".

When the selection is made press [ **abs/inc** ] to continue to the next option.

### 3.3 INPUT TYPE

Select between Microsyn or Spherosyn for each axis. Press the  key to toggle between the two selections.


**Warning:** The axis selected for the input type must match the actual encoder (Spherosyn or Microsyn) which is plugged into the corresponding axis. Erroneous readings will occur if this warning is not followed.

### 3.4 RESOLUTION

The resolution option allows you to select the desired axis resolution. The resolutions which are available for each axis are dependant on the Input Type which was selected in section 3.2.

Input Type:	<b>Spherosyn/Microsyn 10</b>	5 $\mu$ m (0.0002in) / 10 $\mu$ m (0.0005in) / 20 $\mu$ m (0.001in) / 50 $\mu$ m (0.002in)
	<b>Microsyn 5</b>	1 $\mu$ m (0.00005in) / 2 $\mu$ m(0.0001in) / 5 $\mu$ m (0.0002in) / 10 $\mu$ m (0.0005in)

It is recommended that the Input Type is established prior to selecting the resolution.

Press the  key to change the resolutions.

**Note:** 1 $\mu$ m resolution is only available in the radius reading mode

### 3.5 DIRECTION

The direction option allows you to change the direction of travel of each axis. For example, if after installation the A1 axis is measuring positive from right to left, you can use this option to change the direction of the A1 axis so it measures positive from left to right.

In the Set-Up routine, press the [ **abs/inc** ] until "DIR" (direction) is displayed.

Each axis display will show "0" or "1"

Pressing each axis key  reverses the counting direction. When the B60 is displaying the choices you wish to use, press [ **abs/inc** ] to continue to next option.

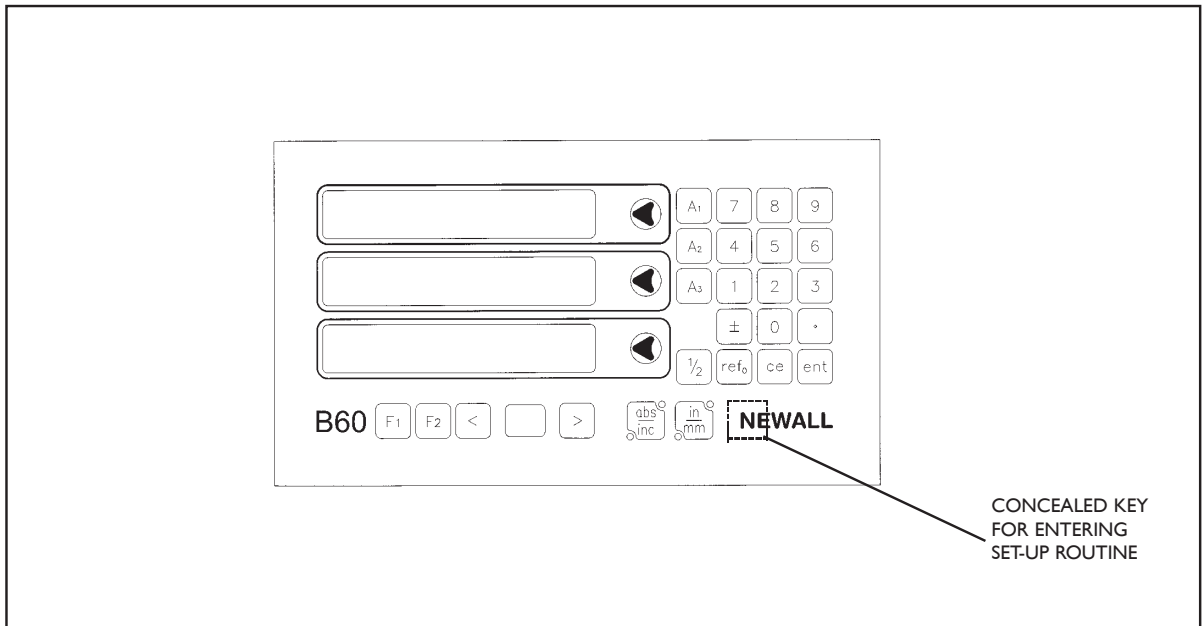


Figure 1.1 Front View

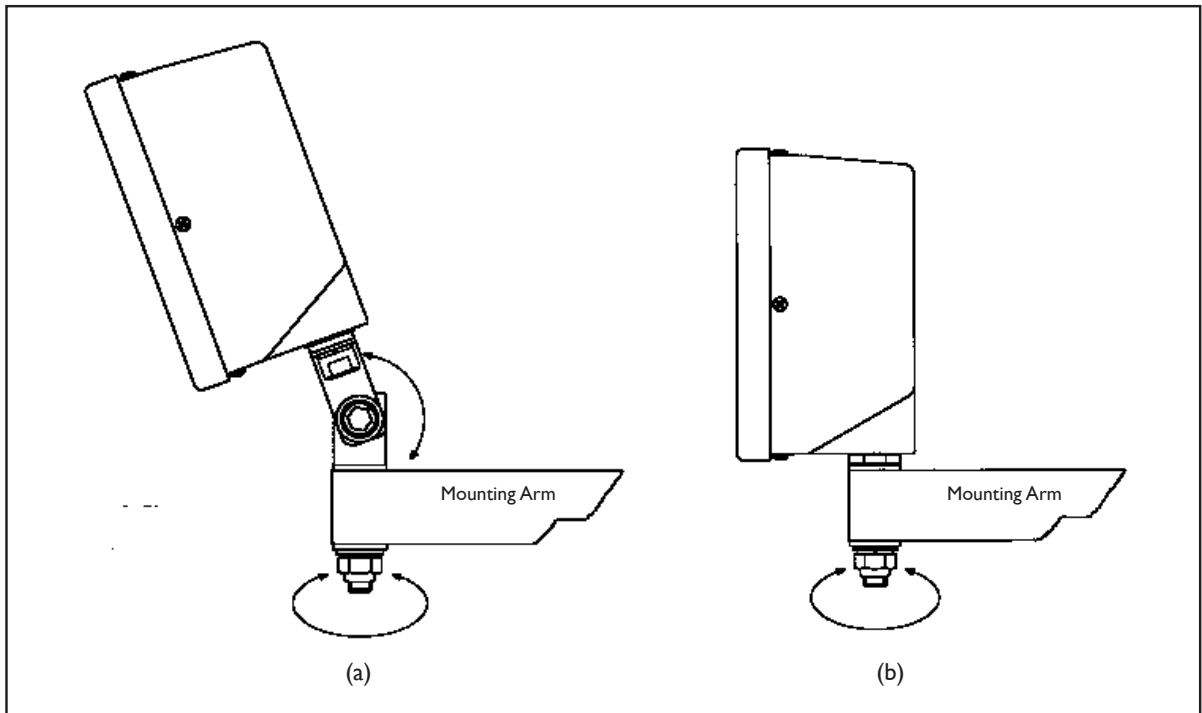


Figure 1.2 Mounting Arrangements



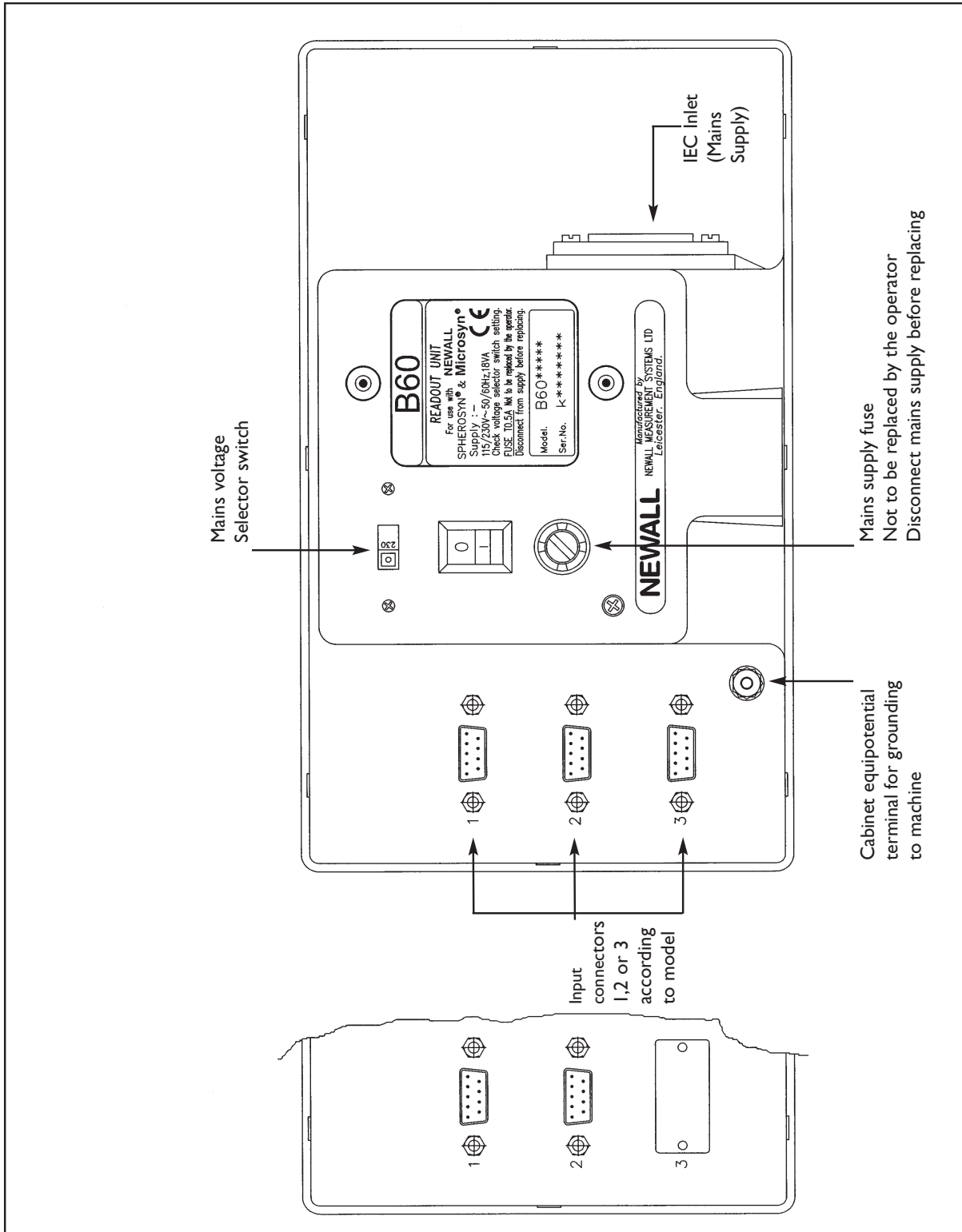



Figure 1.3 Connection Diagram

## 3.6 RADIUS/DIAMETER

This option allows you to select any axis to display measurements at a two times (x2) factor. This is used on lathes and other turning applications to display part diameter rather than part radius.

In the Set-Up routine, press the [ **abs/inc** ] key until "RAD" or "DIA" is displayed.

Pressing each axis key , switches between radius and diameter readings for that axis. When the B60 is displaying the choices you wish to use, press [ **abs/inc** ] to continue to the next option.

## 3.7 LINEAR ERROR COMPENSATION

This option allows you to apply a constant correction factor to all measurements displayed. This factor is expressed in parts per million (PPM).

In the Set-Up routine, press the [ **abs/inc** ] key until LC (Linear Compensation) is displayed. The display will show "LC 0" or the last correction factor entered.

To insert or change a correction factor, select the axis and enter the factor you wish to use.

For example, to apply a factor of 200PPM to the A1 axis, press the following keys:

[ **A1** ] [ **2** ] [ **0** ] [ **0** ] [ **ent** ]

If the unit is displaying measurements less than the actual measurement, enter a positive compensation factor. A factor of 200PPM means displays are measurement x 1.000200. When each axis is displaying the correction factor you wish to use, press [ **abs/inc** ] to return to the first option.

### 3.7.1 CALCULATING LINEAR ERROR COMPENSATION

To establish a multiplication factor, check the measurements displayed by the B60 against a known distance. The multiplication factor should be established while in operational mode and NOT in the Set-Up routine.

For example, you might use a known(actual) distance of 500mm, against which the B60 displays 499.8mm. The correction factor you would then apply is:

$$(0.2\text{mm}/500\text{mm}) \times 1,000,000 = 400\text{PPM}$$

If the B60 displays 500.2mm over the same distance, the correction factor would be:

$$(-0.2\text{mm}/500\text{mm}) \times 1,000,000 = -400\text{PPM}$$

**WARNING.** Once you have entered a multiplication factor for an axis, all measurements will be adjusted accordingly. If you wish to disable this adjustment, you will have to enter a compensation factor of zero.

To leave the Set-Up routine press the concealed key, "NE" of NEWALL.

## 4.0 User Instructions

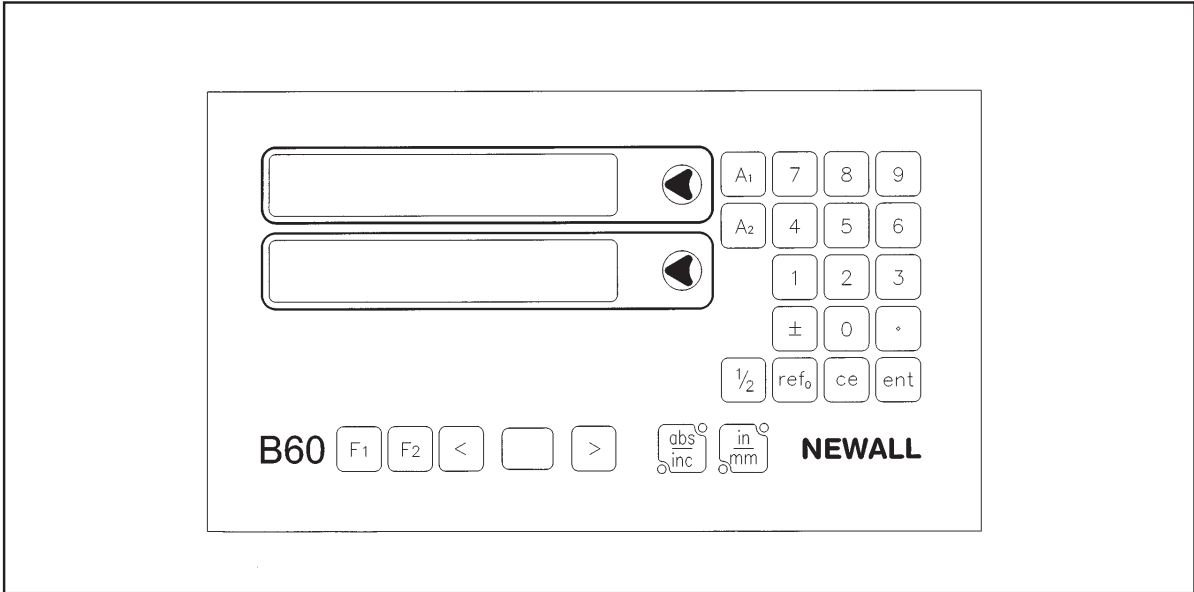
### 4.1 OPTIONS

B60 is available in two either 2 or 3 axes display options Figure 1.4 shows the layout of the various keypad configurations.

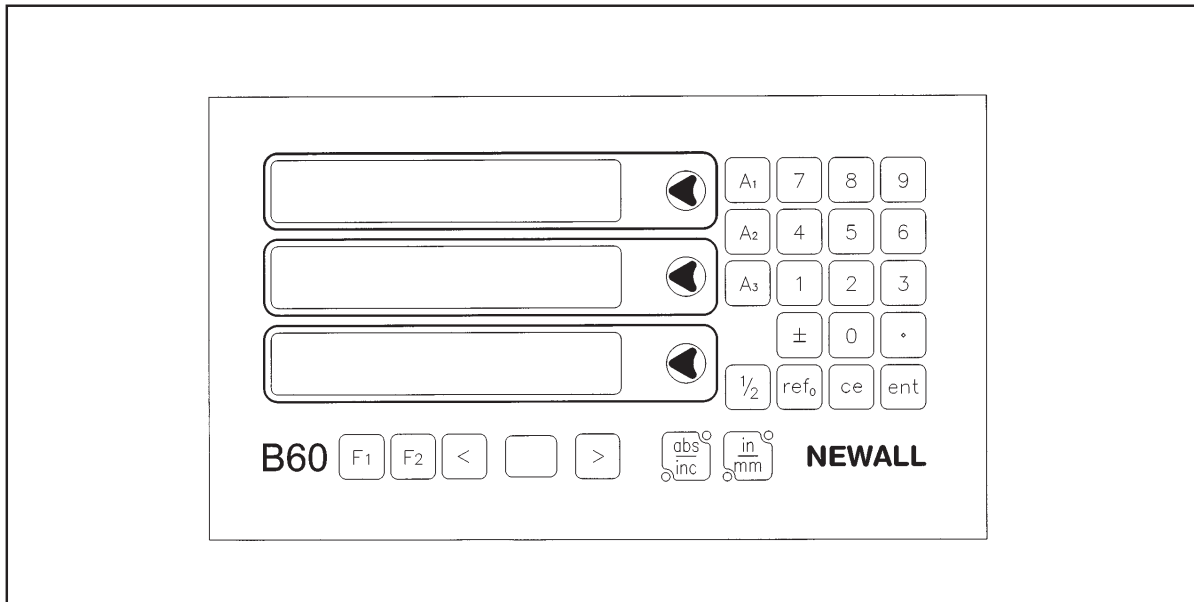
### 4.2 USING THE KEYPAD

Figure 1.4 shows the layout of the keypad. The keys are used as follows:

KEY	PURPOSE
	Set the current position for the axis to zero (reset)
A1 A2 A3	Select axis to enter dimension (preset)
abs inc	Switches between absolute and incremental readings (LED indicates choice of mode)
ce	Clear entry values in preset mode
1/2	Centre find function
ent	Enter key to confirm data entry
ref <sub>0</sub>	Select the Digifind function
in mm	Switches between inch and millimetre display (LED indicates choice of mode)
± 1 2 3 4 5	Numeric keypad for data entry
. 6 7 8 9 0	
F1	For setting tool off-sets (Lathe)
F2	Calls up the tool number to be used (Lathe)
F2	For using the pitch circle diameter (PCD) function (Mill)



B60 2 Axis



B60 3 Axis


Figure 1.4 Keypad Layout

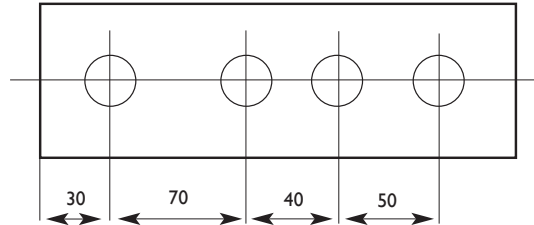
## 5.0 Standard Functions

### 5.1 USING INCREMENTAL

**(a) Purpose and Use**

When the B60 is set to incremental mode, it can be used to display each new position relative to the last position. This is also known as point-to-point use.




On setting to incremental you can reset each axis by pressing respective  key.



As an alternative to resetting the axes, you can enter the coordinates relative to the current incremental position.

Each time you switch to incremental mode, the B60 display will show the position relative to the last reset position while in the incremental mode.

**(b) Keystrokes**

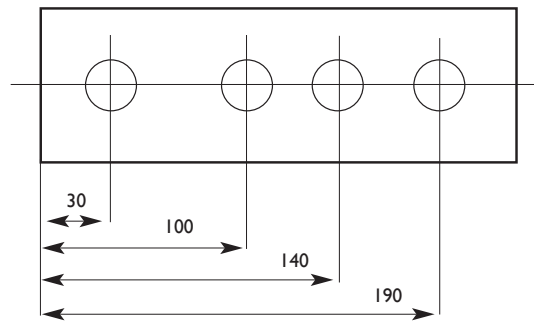
OPERATOR STEPS	KEYSTROKES	AXES DISPLAY
Set to incremental mode	[ abs/inc ]	
Reset axes	  	A1 0.00 A2 0.00 A3 0.00
Enter the coordinates of a position, eg A1 100, A2 50, A3 25	[ A1 ] [ 1 ] [ 0 ] [ 0 ] [ ent ] [ A2 ] [ 5 ] [ 0 ] [ ent ] [ A3 ] [ 2 ] [ 5 ] [ ent ]	A1 100.00 A2 50.00 A3 25.00

### 5.2 USING ABSOLUTE

**(a) Purpose and Use**

When the B60 is set to absolute mode it will display the position relative to an established datum point.

**(b) Keystrokes**




OPERATOR STEPS	KEYSTROKES	AXES DISPLAY
Set absolute mode	[ abs/inc ]	

## Standard Functions

### (c) Establishing the Datum

When you reset the display in absolute mode, you are setting the current position of your machine as your datum point. All absolute positions will be measured relative to this datum.

To set the datum, position the machine at the point you intend to establish the datum and then reset any or all axes, while in the absolute mode.

OPERATOR STEPS	KEYSTROKES	AXES DISPLAY
Set to absolute mode  Move machine to the datum location  Reset axes	[ abs/inc ]  	A <sub>1</sub> 0.00 A <sub>2</sub> 0.00 A <sub>3</sub> 0.00

### 5.3 DIGIFIND

Digifind is a reference point used to find the datum should it be lost by power loss or accidental key stroke entry.

#### (a) Using Digifind to Re-establish a Lost Datum

In the event that the datum positions are lost, align each axis to within  $\pm 6\text{mm}$  for Spherosyn or  $\pm 2.5\text{mm}$  for Microsyn to the datum point.

By pressing the [ ref. ] followed by the corresponding axis key, the display will update to a distance equal to the distance from the current position to the datum point.

Each time the B60 is powered up the cabinet will automatically use Digifind to compensate for any axis movement of up to  $\pm 6\text{mm}$  ( $\pm 0.25''$ ) for Spherosyn and  $\pm 2.5\text{mm}$  ( $\pm 0.098''$ ) for Microsyn.

### 5.4 DATA PRE-SET

To pre-set an axis dimension the following steps are required.

#### (a) Keystrokes

OPERATOR STEPS	KEYSTROKES	AXES DISPLAY
To enter a negative dimension for A <sub>1</sub> the axis	[ A <sub>1</sub> ] [ ± ] [   ] [ 9 ] [ . ] [ 6 ] [ ent ]	A <sub>1</sub> -19.600

Dimensions can be entered in either absolute or incremental modes.

### 5.5 INCH/MILLIMETRE


To change between millimetre and inch readings, press [ in/mm ]. The displayed data will be converted instantly. The LED beside the key reminds you which mode is being used.

When you switch on the B60, it will display the same unit of measurement which was set prior to power loss.

### 5.6 CENTRE FIND

Centre Find halves the dimension displayed for any or all axes selected. You can use Centre Find in either absolute or incremental mode. The keystrokes are the same in either case.

In the following example, Centre Find is being used on the A1 axis to find the centre point of a workpiece that is 100mm wide.

OPERATOR STEPS	KEYSTROKES	AXES DISPLAY
Locate to your first position (one edge of your workpiece- and zero the axis)		A1 0.00
Locate to the second position (the other edge of the workpiece)		A1 100.00
Use Centre Find to locate the centre point	[A1][½] or [½][A1]	A1 50.00

In either absolute mode or incremental mode, once you have used Centre Find you can locate to the centre point by moving until the display is at zero.

**Note:** If you are in absolute mode, remember that using centre find will set the datum to the centre point.

### 5.7 DATAHOLD (SLEEP)

Datahold allows you to disable the B60 but retain power to the measurement encoders and the memory circuits. You can use datahold to prevent unauthorised or accidental use of the B60 whilst unattended.

To select datahold, press the concealed key under the “NE” of the NEWALL logo (See Figure 1.1).

While the B60 has been set to datahold, the keypad will not function and the displays will be blank. If the machine axis is moved, "DISPLACD" (displaced) will appear in the display window. The B60 will continue to record all encoder movement and will update the display once datahold is cancelled. If a key is pressed, "TOUCHED" (touched) will appear in the display to alert the operator that data entry has been attempted.

**Note:** To cancel datahold, press the concealed key (“NE” of the NEWALL logo).

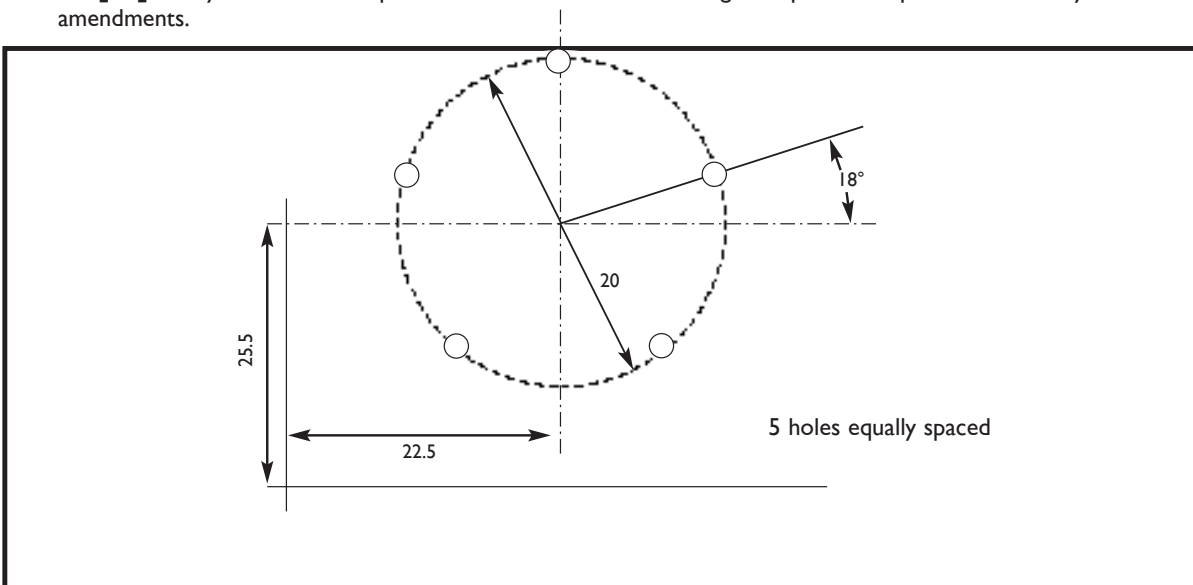
## 6.0 Functions

### 6.1 B60 MILL FUNCTION

The B60 offers Pitch Circle Diameter (PCD) in addition to the Standard functions. PCD is also known as “Bolt Hole Circle”. The convention for angular position is that the 0 degree position is at 3 o’clock and positive angles are measured anti-clockwise.

#### 6.1.1 MILL FUNCTION

- (a) To access the PCD function press **F2**
- (b) The two digit LED shows the letter “**C**” for centre. Each of the axes display the last entered coordinates for the circle centre
- (c) Enter the required centre points for the new PCD. eg **[A1][2][2][.][5][ent],[A2][2][5][.][5][ent]** Press **[>]** to move to the next input.
- (d) The two digit display now shows “**D**” prompting the diameter input. The A1 axis shows the last entered value for a circle diameter. The other axes are blank.
- (e) Enter a new diameter eg **[2][0][ent]** Press the **[>]** key to move to the next input.
- (f) The display now shows “**N**”, prompting the number of holes to be input. The A1 axis shows the last entered value for the number of holes.
- (g) Enter the number of holes in the pattern followed by **[ent]**, eg. **[5][ent]**. Press **[>]** to advance to the next input.
- (h) The display now shows “**A**” for angle of the first hole. The X axis display shows the last entered angle.
- (i) Enter a new angle in decimal degrees followed by **[ent]** eg. **[1][8][ent]**. Note: Until this point the **[<]** key will allow the operator to move backwards through the previous inputs and make any amendments.





- (j) Pressing [ > ] key after the angle input will display the first hole position.
- (k) [ < ] or [ > ] now scrolls through the various hole locations. Each hole number being identified in the two digit display. The PCD feature functions as a “go to zero” command. The coordinates displayed with each hole number indicate the distance needed to travel to reach the hole location. To position to each hole location, move the axes until both of the displays read “**0.000**”.
- (l) Pressing the PCD icon **F2** returns the display to the standard function.

### 6.1.2 3 AXES MILL VERSIONS

The 3 axes mill operates in a similar manner to the 2 axes version except that the PCD is plane selectable.

- (a) On the 3 axes version when the PCD icon is pressed **F2** the first input in the 2 digit display is the plane “P”. The plane is identified by the horizontal LED segment adjacent to the corresponding axis.
- (b) The [ abs/inc ] key scrolls between (A1,A2), (A1,A3) and (A2,A3) planes when pressed. When the desired plane is displayed press [ > ] to move to the next input “C” for centre position. All subsequent inputs are as the two axis version.

## 6.2 B60 LATHE FUNCTION

**Note:** The conventional method of setting a lathe is to set the A1 axis as the cross travel and the A2 axis as the longitudinal.

### 6.2.1 TO SET THE OFFSETS

- (a) Press **F1** to activate the tool set mode
- (b) Press [ > ]. The two digit display will show the first tool as “01”.
- (c) To datum the A1 axis take a skim cut along the outside diameter. Move the tool away from the part but do not move in the A1 axis. Measure the diameter and enter the diameter of the part in to the A1 display. i.e. [A1][ 2 ][ 5 ][ent]
- (d) To datum the A2 axis take facing cut and move the tool away from the part but do not move in the A2 axis. Enter zero in the A2 display. i.e. [A2][ 0 ][ ent ]. The A3 key is inactive in the tool set mode.
- (e) Press [ > ] to advance to the next tool. i.e. “02” will be displayed in the two digit display.
- (f) To set the remaining tools repeat (c) as above to datum the A1 axis. To datum the A2 axis for each tool touch the tool onto the face and enter [A2][ 0 ][ ent ].
- (g) Press **F1** to exit the tool set mode.

### 6.2.2 TO USE THE TOOLS WITH OFFSETS

- (a) Press **F2** The 2 digit display now shows "01". Use the [ < ] and [ > ] keys to advance to the tool which is to be used.
- (b) Datum the displays in the normal way. Use the [ < ] and [ > ] keys when changing tools. The display will show you true A1 and A2 readings for the tool shown in the two digit display.
- (c) Press **F2** to exit tool use mode.

### 6.2.3 EDITING TOOL OFFSETS

Tool editing allows you to update a tool offset should the tool become worn, broken or need replacing.

- (a) Before editing the offset it is first necessary to activate an unchanged tool in tool use mode. Press **F2** and select the tool.
- (b) To datum the A1 axis take a skim cut along the outside diameter. Move the tool away from the part but do not move in the A1 axis. Measure the diameter and enter the diameter of the part in to the A1 display. e.g. [ A1 ] [ 2 ] [ 5 ] [ ent ]
- (c) To datum the A2 axis, take a facing cut and move the tool away from the part but do not move in the A2 axis. Enter zero in the A3 display. i.e. [ A2 ] [ 0 ] [ ent ]. The A3 key is inactive in the tool set mode.
- (d) Press **F2** to exit tool use mode.
- (e) Press **F1** to activate the tool offset mode.
- (f) Use the [ < ] [ > ] keys to scroll to the tool to be edited. As an alternative the tool number may be entered directly. e.g. [ 1 ] [ 1 ] [ ent ].
- (g) To establish the A1 axis offset take a skim cut along the outside diameter. Move the tool away from the part but do not move in the A1 axis. Measure the diameter and enter the diameter of the part in to the A1 display. e.g. [ 2 ] [ 5 ] [ ent ]
- (h) To establish the A2 axis offset touch the end face with the tool and enter zero in the A2 axis display. e.g. [ 0 ] [ ent ]. The A1 and A2 keys are inactive in the tool set mode.
- (i) Press **F1** to exit tool set mode.

## 7.0 Troubleshooting

SYMPTOM	SOLUTIONS
Nothing happens when the unit is switched on.	<ul style="list-style-type: none"> <li>• Check that the B60 is correctly connected to a working power source.</li> <li>• Check the power lead is not damaged.</li> <li>• Check the selector switch on the B60 is set to accept the correct power supply voltage.</li> <li>• Check the fuse. Note that if the fuse has blown, this suggests a fault with the power source which must be corrected before the fuse is replaced. (See Section 2.2)</li> </ul>
When the unit is switched on the displays are frozen.	<ul style="list-style-type: none"> <li>• This suggests that the mains supply voltage is too low. Check that the power source is within the limits accepted by the B60. (See Section 2.2)</li> </ul>
The displays work, but reset from time to time without the keys being pressed.	<ul style="list-style-type: none"> <li>• This suggests either that the mains supply voltage is too low, or that the power source has an intermittent fault.</li> <li>• Check the power source as above.</li> <li>• Check that all connections are sound.</li> </ul>
The displays work, but give erratic readings, the last digit jitters or the measurements jump to new figures unexpectedly.	<ul style="list-style-type: none"> <li>• This suggests that there is a poor earth (ground) connection. Both the B60, and the machine on which it is installed, must have proper earth (ground) connections. (See Section 2.1)</li> </ul>
"NO SIG" or "SIG FAIL" appears in the display.	<ul style="list-style-type: none"> <li>• This means that the unit is not receiving a proper signal from the measurement transducer.</li> <li>• Check that the encoder connection is good.</li> <li>• Check that there is no damage to the connectors or to the encoder lead. If only one axis is displaying this message, connect the encoder from a working axis into the faulty axis. If the same message appears, the fault is likely to be in the B60 and you should contact your local dealer. Note: The B60 is to be switched off then on again to remove the "NO SIG" message.</li> </ul>
The unit will not respond to keys.	<ul style="list-style-type: none"> <li>• Switch the B60 off and back on. Note that providing the machine has not been moved more than +/-6mm in any direction for the Spherosyn and +/-2.5mm for the Microsyn, you will not lose your current position by switching off and on.</li> </ul>
Readings are incorrect	<ul style="list-style-type: none"> <li>• Check Encoder Type to ensure correct selection.</li> <li>• Check the Radius / Diameter setting. The Diameter setting will cause the axis to read double.</li> <li>• Check Error Compensation factors.</li> <li>• Swap the encoder to another axis to confirm whether the encoder or the B60 is at fault</li> <li>• Check that there is no damage to the encoder or its cable.</li> <li>• Check that the encoder is fixed firmly and aligned correctly, as described in the Spherosyn / Microsyn Installation manual.</li> <li>• Check that there is no binding on the scale. With the scale brackets slightly loosened, you should be able to slide the scale back and forth with minimal resistance</li> </ul>

## 8.0 Cleaning

- Disconnect the power supply from the **B60** before cleaning.
- Do not use corrosive or abrasive cleaning materials.
- Do not use compressed air.
- Apply a small amount of mild soap to a lint-free cloth. Use this to wipe over the case and keypad, taking care not to allow fluid into the connectors.

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