

NEWALL

NEWALL MEASUREMENT SYSTEMS LTD

A50

Single Axis Digital Readout System



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CONNECTIONS

- The A50 is suitable for use only with Newall Spherosyn and Microsyn analogue encoders.
- Ensure that all cables are secured to prevent their 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 supply before connecting the encoder, by disconnecting power supply connector
- Ensure that the A50 is grounded to the machine before turning on the machine supply.

NOTES

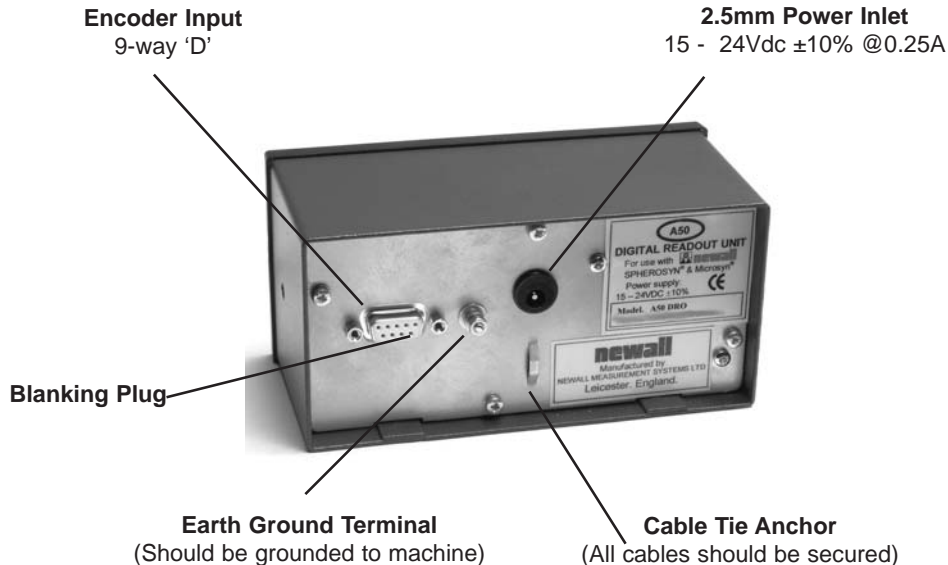


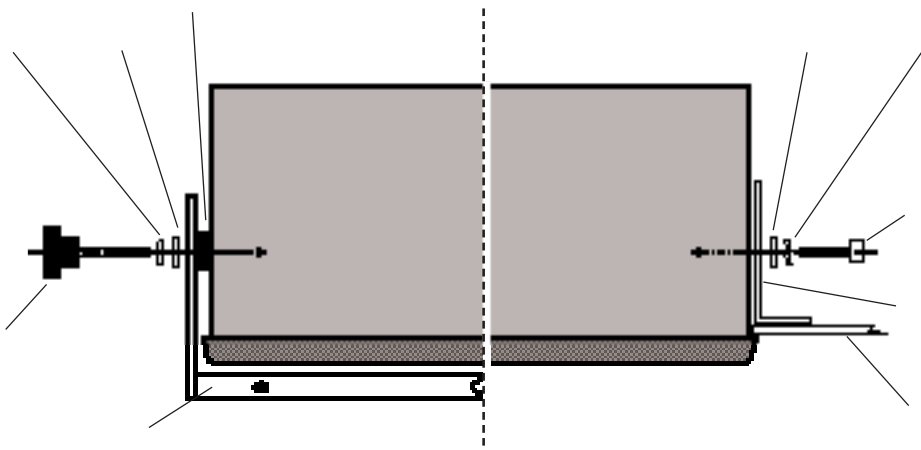
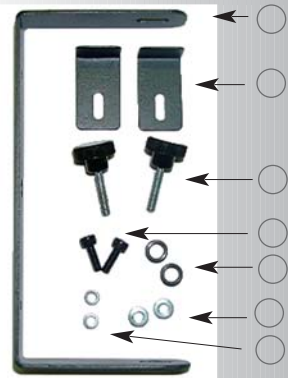
DO NOT CONNECT THIS UNIT DIRECTLY TO THE MAINS SUPPLY.



If you have a Newall encoder which is not fitted with D-type connector, an adaptor cable is available.
Part No: 307-60940

Contact your supplier for details.












OPERATION

Setting The Display

In normal operation, the keys are used as follows:

- Press  to toggle the display and keypad on and off.
- Press  to toggle the display between  inches and  millimetres.
- Press  to toggle the A50 between  absolute and  incremental mode.












Absolute mode

In this mode, the A50 will display the position relative to an fixed datum.

Incremental mode

In this mode, the A50 can be used to display each position relative to the last position. This is also known as *point-to-point* use.

Setting the datum

- To zero the display at the current position:
press . All readings will now be relative to this zero point.
- To set the display to a known fixed point:
Example:       to enter the value . All readings will now be relative to this fixed point.
- If you make a mistake while entering a number, pressing  will clear the entry one character at a time.
- It is advisable to mark the Absolute Datum point physically on the machine, so as to be able to re-establish this datum after power loss. See Digifind Page 6

NOTES

Toggling the display off doesn't turn the power off - as long as the power supply is plugged in, all settings are preserved, and the position is updated.

tip

At the beginning of each working session, set the datum in **Absolute** mode, then switch the A50 to **Incremental** mode.

By using the A50 in this way, you will be able to return the machine to its absolute datum at any time, by simply switching back to **Absolute** mode.

If you are using **Segmented Error Compensation**, see page 10 for details of the datum setting procedure.

NOTES

Digifind works only in **absolute** mode.

Pressing in absolute mode redefines the datum.

Do not move the machine when the A50's power is off.

When the power is switched back on again, the A50 uses **Digifind** to automatically re-establish the datum.

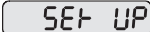
Entering a fixed point, or using **Centrefind**, **will change the datum in absolute** mode - but can still be used to return to the old datum.

SETUP


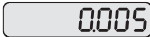

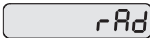

Using Setup Mode

Setup mode is accessible immediately after the power has been switched on, as follows:

When power is applied, the A50 will go through a brief self-test routine. The display shows the model number, then the software version number, all segments and indicators light momentarily, after which the A50 is ready for use.

- To enter **Setup** mode, press **ENTER** anytime before the self-test finishes.
- At the end of the test, the display will read . Press any key to continue.

There are five options that can be configured:

Option	Default	Display
Encoder type	Spherosyn	
Resolution	0.005mm	
Direction	1	
Radius / Diameter	Radius	
Error compensation	Off	

To cycle through the options, press **ENTER**. Each option is described in detail on the following pages.

When you have finished setting all the options, press **ENTER** to return the A50 to normal operating mode.

NOTES

Normally, **Setup** needs to be done only once, and it is possible that the factory default settings are suitable for your needs without change.

If the power is already switched on, pressing **ENTER** will enter setup mode.

If you have entered setup mode in this way, you will need to press **ENTER** twice to return to normal operating mode.

NOTES

The **Encoder** setting must match the actual encoder in use, or the A50 will not display the measurement correctly.

Encoder Type

There are three possible settings:

Spherosyn

Microsyn 10

u5n 10

Microsyn 5

u5n 5

- Press **←** to cycle between the four settings.
- Press **→** to accept the setting and move on to the next option - **Resolution**.

Resolution

The **Resolution** settings available will depend on the encoder, and also on the **Encoder Type** setting.

	Display	Spherosyn or Microsyn 10	Microsyn 5
1µm	(0.001)	(0.00005)	<input checked="" type="checkbox"/>
2µm	(0.002)	(0.0001)	<input type="checkbox"/>
5µm	(0.005)	(0.0002)	<input type="checkbox"/>
10µm	(0.01)	(0.0005)	<input type="checkbox"/>
20µm	(0.02)	(0.001)	<input type="checkbox"/>
50µm	(0.05)	(0.002)	<input type="checkbox"/>

- Press **←** to cycle between the four available settings.
- Press **→** to accept the setting and move on to the next option - **Direction**.

SETUP

NOTES

Direction

The **Direction** setting allows you to match the A50 to the actual direction of travel of the machine.

alternative settings



- Press **0** to cycle between the two settings.
- Press **ENTER** to accept the setting and move on to the next option - **Radius / Diameter**

The **Direction** setting is quite arbitrary. Set it to whichever makes most sense to the job.

Radius / Diameter

Selecting the **Diameter** setting causes the A50 to display double the actual scale / machine movement

radius

diameter



- Press **0** to cycle between the two settings.
- Press **ENTER** to accept the setting and move on to the next option - **Error Compensation**.

The **Diameter** setting is useful for lathes, and other turning applications, to display diameter, rather than radius.

NOTES

If error compensation is applied, it is important that it is absolutely correct. If it is not correct, errors could be increased rather than reduced.

After setting up the error compensation, it is advisable to check its effect in normal operation.

Segmented compensation need not be over the entire scale length.

It can be applied to a length of high importance.

It can be as small as one segment.

Error Compensation

There are three possible settings:



off

linear error compensation

L in Err

segmented error compensation

SEG Err

- Press  to cycle between the three settings
- If you select **linear compensation** or **segmented compensation**, pressing  will take you to the individual settings for the compensation method chosen, described below.

Linear compensation

In this mode, a single constant correction factor for the scale can be applied

t

Linear Error Compensation

Calculating the correction factor

Example - to check the scale against a standard which is exactly 500mm wide:

- Set the tool or probe to one edge of the standard, and press **ENTER**. The display will read **500.000**.

- Set the tool or probe to the other edge of the standard. Assume the A50 displays **499.800**.

- Calculate the correction factor:

$$\text{error} = (500.000 - 499.800) = 0.2\text{mm}$$

$$\text{correction error factor} = \frac{0.2}{500} \times 1,000,000 = +400 \text{ ppm}$$

This measured value needs to be increased to match the standard, so this is a positive correction factor.

If the display had read 500.2 for the same standard, the correction factor would be -400 ppm.

Setting the correction factor

- Enter **Setup** mode, by pressing **MODE**, and select **Error Compensation**.
- Select **Linear Compensation**, as described on page 10.

The display will read **LC 0**, or a previously entered value.

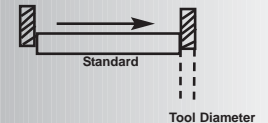
- Press, **4** **0** to enter a correction factor of 400 ppm (as above)
- To enter a different correction factor, press **ENTER** and start again.
- Press **ENTER** to accept the setting and move back to the first option - **Encoder**.

NOTES

The correction factor cannot be established while in **Setup** mode.

Carry out the measurements in normal **operating** mode, then turn the power off and re-enter **Setup** mode as described on page 7.

Where the measurement of the standard included the tool / probe diameter this should be subtracted from the displayed measurement.



Only values between -9999 and +9999 are allowed.

If you make a mistake while entering a number, pressing **DEL** will clear the entry one character at a time.

NOTES

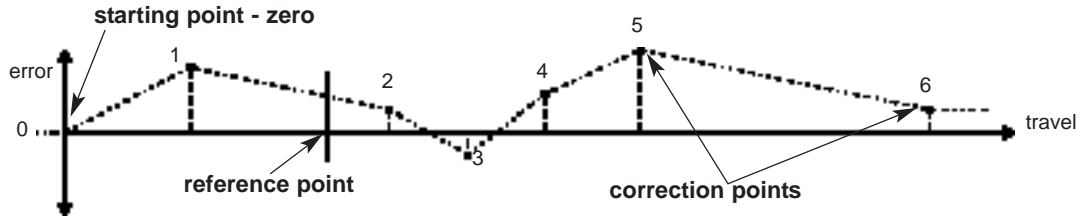
Up to 99 segments can be defined.

To take advantage of **Segmented Error Compensation**, you will need access to a high accuracy standard, such as a laser measuring system.

Error Compensation initially defaults to **off**, with no points set. If **Error Compensation** is set to **OFF** after correction points have been set, the data is retained, but not applied. When **Segmented Error Compensation** is set to **ON** again, the data is applied

Segmented Error Compensation

Identification of correction parameters



The scale travel is broken down into a number of user-defined segments, each with its own correction factor, measured against an high-accuracy standard. The following parameters need to be identified:

Each **correction point** is measured with respect to the **starting point - zero** - which is usually set close to one end of the scale. The **reference point** can be set anywhere along the scale, and does not need to coincide with either the absolute datum or any of the correction points. However, it may be convenient to make the absolute datum and the reference point the same.

Setting the correction points

- Enter **setup** mode, by pressing **ESC** and select **error compensation**.
- Select **segmented compensation**, as described on page 10.

The display will read **Err SET**.

Press **ENTER** to continue, or press **ESC** to accept any previous settings and move back to the first option

- **Encoder Type**

Setting the correction points *continued*

The display will change to **SET 2Er0**.

1 Set the machine to the point you have chosen to be the **starting point**, and zero the high-accuracy standard at this point. Press **0**.

2 The display will change to **Go to 1**.

Set the machine to the point you have chosen to be **correction point 1**. Press **1**.

3 The display will change to **Ent 5d 1**.

Enter the distance from the **starting point**, measured by the standard.

Example, Assume the laser measuring system displays 678.9. Then press **7** **8** to enter a correction point position of 678.9. The A50 will calculate the correction factor, and record this against its own position measurement.

- Repeat steps **2** and **3** for each correction point.

When all correction points have been entered, Press **0**.

4 The display will change to **Go to rEF**.

Set the machine to the point you have chosen as the **reference point**. Press **0**.

5 The display will return to **00000000**.

Press **0** to accept the settings and move back to the first option - **Encoder Type**

Exit SetUp and begin normal operation

NOTES

This procedure must be carried out in strict sequence, and in full, to be valid. There must be no reversals in direction.

Pressing **0** at steps 2 or 3, will display the current position relative to the **starting point**.

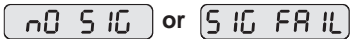
Do not worry about the direction of the standard measurement. eg. 678.9 and -678.9 are treated the same.

Pressing **0** will clear the entry one character at a time.

When all characters are deleted, pressing **0** will take you back one step at a time.

NOTES

TROUBLESHOOTING

Symptom	Solutions
The display is blank.	<ul style="list-style-type: none"> Press ON. The display may have been switched off. Check that the power supply is correctly connected to a working mains outlet. Check that the power supply cables are not damaged. Check that the power supply voltage is at least 13.5Vdc (minimum operating limit)
The display works, but resets from time to time without any keys being pressed.	<ul style="list-style-type: none"> This suggests either that the supply voltage is too low, or that the power supply or mains supply has an intermittent fault. Check that the power supply voltage is 15-24Vdc $\pm 10\%$. Check that all connections are sound.
The display works, but gives erratic readings, the last digit jitters or the measurements jump to new figures unexpectedly.	<ul style="list-style-type: none"> This suggests that there may be a poor earth (ground) connection. Both the A50, and the machine on which it is installed, must have proper earth (ground) connections. (see page 3) There may be a problem with the encoder (see below).
 <p>appears in the display.</p> <p style="text-align: right;"><i>continued</i></p>	<ul style="list-style-type: none"> This indicates that the unit is not receiving a proper signal from the encoder. Check that the encoder connections are sound. <p style="text-align: right;"><i>continued</i></p>

TROUBLESHOOTING

Symptom <i>continued</i>	Solutions <i>continued</i>
	<ul style="list-style-type: none"> • Check that there is no damage to the connectors or to the encoder. • Substitute a known working encoder, if one is available. • Switch the A50 off, then back on again.
The unit will not respond to any key presses.	<ul style="list-style-type: none"> • Switch the A50 off and back on again.
Readings are incorrect	<ul style="list-style-type: none"> • Check encoder type to ensure correct selection • Check error compensation factors • If using segmented error, verify datum position

If the solutions suggested above do not solve your problem, contact Newall for further instruction

CLEANING

- Disconnect the power supply from the A50 before cleaning.
- Do not use corrosive or abrasive cleaning materials.
- Do not use compressed air.
- Apply a small amount of cleaning fluid to a lint-free cloth. Use this to wipe over the case and keypad, taking care not to allow fluid into the connectors.

NOTES

Providing the machine has not been moved more than:

6.3mm (0.25") for a Spherosyn encoder or 2.5mm (0.1") for a Microsyn encoder

you will not lose the datum position by switching the power off and back on again.

FOLLOW THESE INSTRUCTIONS CAREFULLY TO AVOID DAMAGE TO THE A50.

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