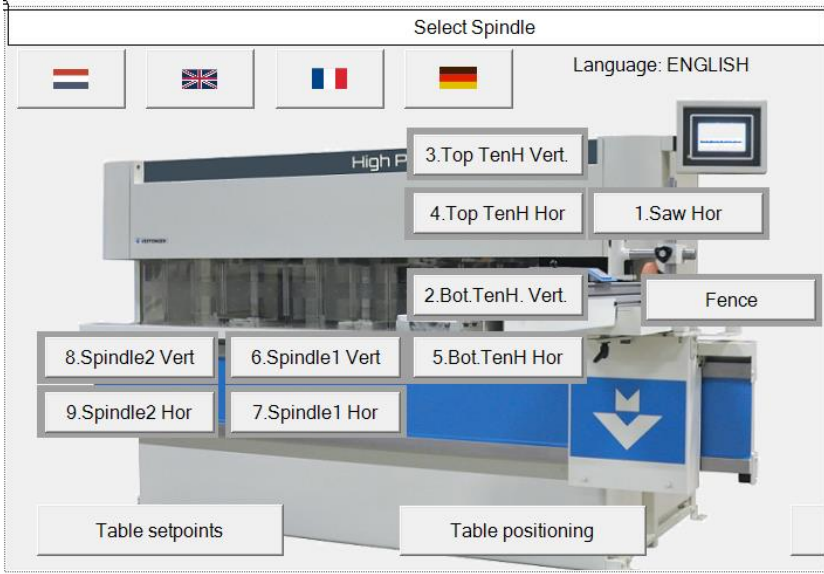


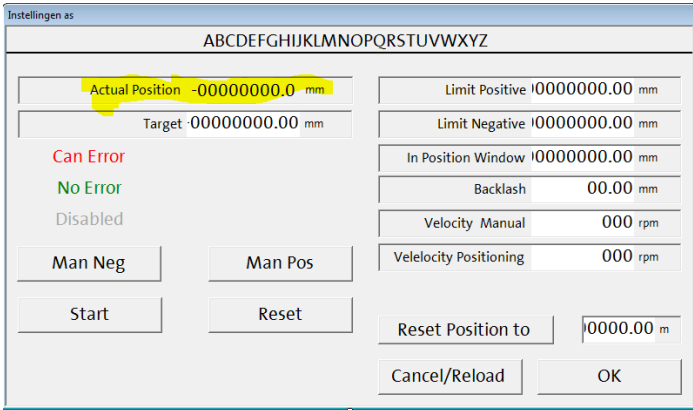
# Manual changing position actuators Siko

In case position actuator(s) from Siko type "AG05" need to be changed please follow carefully all steps as mentioned below:

1. Switch on the machine with the original actuator(s) and look up the "Can-adres" and "actual position" of the actuator(s) to be replaced:
  - a. The Can-address is the mentioned number in the screen "Settings": (f.e. 1=saw;2=bottem ten.head vert.....)

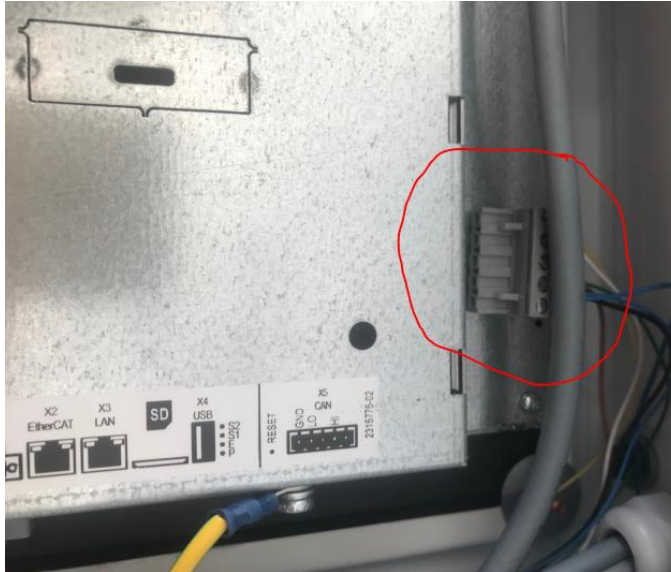


- b. The actual position can be found once the corresponding motor is selected under settings:



2. Switch the machine off and replace the positioning motor(s) that need replacement

3. Disconnect the Can-connector from the touch screen:



4. Switch on the machine again and install for every replaced motor the Can adress with the keys of the display at the back of the motor:



- a. Press the “ \* ” key until the display changes to “Para ChPar”
  - b. Press the “ \* ” key , the display changes to “Pin”
  - c. Press the “ \* ” key , the display changes to “Para Quit”
  - d. Press the left key (Up) , the display changes to “Para Bus”
  - e. Press the “ \* ” key , the display changes to “ID” with the actual Can adress on the lower display
  - f. Press the left key (Up) until the Can adress corresponds with the number you’ve written down in point 1.a
  - g. Confirm this number by pressing the “ \* ” key , the display changes to “baud 500”
  - h. Press the “ \* ” key , the display changes to “Para Quit”
  - i. Press the “ \* ” key
  - j. Repeat point a to i for the next motor(s)
5. Switch off the machine and plug in the Can-connector again (see point3)
  6. Switch on the machine, Press “Login” and enter the code 3854.

7. Select Settings and enter for every replaced motor the value of the actual position that you've written down in point 1.b as follows:
  - a. Enter the value at the marked position
  - b. Press "Reset Position to" to copy this value to the actual position

The screenshot shows a software interface for motor settings. At the top, it says "Instellingen as" followed by a long alphanumeric string "ABCDEFGHIJKLMNOPQRSTUVWXYZ". The interface is divided into several sections:

- Positioning:** Includes fields for "Actual Position" (-00000000.0 mm), "Target" (00000000.00 mm), "Limit Positive" (00000000.00 mm), and "Limit Negative" (00000000.00 mm).
- Operational Status:** Shows "Can Error" (red), "No Error" (green), and "Disabled" (grey).
- Control Buttons:** "Man Neg", "Man Pos", "Start", and "Reset".
- Velocity Settings:** "Velocity Manual" (000 rpm) and "Velocity Positioning" (000 rpm).
- Advanced Settings:** "In Position Window" (00000000.00 mm) and "Backlash" (00.00 mm).
- Reset Function:** A "Reset Position to" button followed by a text input field containing "0000.00 m". This input field is highlighted with a red circle.
- Navigation:** "Cancel/Reload" and "OK" buttons at the bottom right.