

Auto lube setting

This document describes how to properly configure the lubrication system on Atrump machines. These guidelines can be used with any automatic lubrication pump.

Software Configuration:

Parameter 179 controls the operation of automatic lubrication pumps. The default value for this parameter is shown below:

Parameter	Description	Value
179	XPLC Parameter LP9	3015

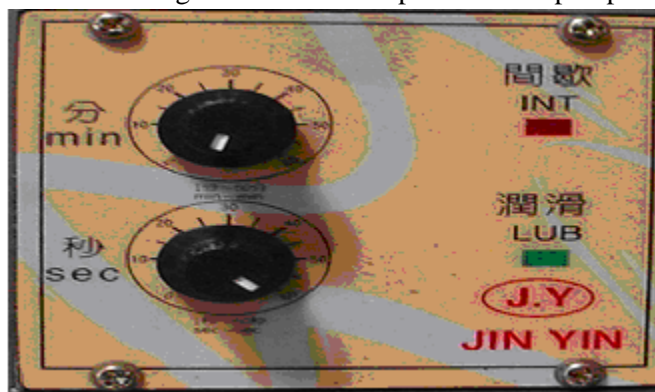
The value 3015 indicates every 30 minutes the lubrication pump will be activated for 15 seconds by applying power through the PLC.

Hardware Configuration:

The pictures below show the correct hardware configuration for Atrump lubrication pumps.



ACT set max 60sec - INT set 0 min



ACT set max 60 sec – INT set 0 min



INT set 0 min

On the Atrump lubrication pumps the interval (INT) timer should be set to 0. When power is applied to the lubrication pump, the interval (INT) timer dictates when the pump will start running. For example, if the interval (INT) is set to 30, the pump will start running 30 minutes after power is applied. The control will only apply power to the lubrication pump for 15 sec. every 30 min. If this is set to anything

other than 0, when power is applied the pump will never be activated.

The Atrump lubrication pumps add an activation (ACT) timer that must be set to its maximum value. The activation (ACT) timer determines how long the pump will run supplying lubrication to the machine. This value must be greater than the activation time set by the control for proper operation.

1. Mill with long job (approximately 30 minutes) that does a lot of slow movements: 3015.
2. Lathe with short job that does fast movements: 1010 – 10 second for every 10 minutes.
3. Mill with many short jobs: 2015.

Parameter 179 :

F1 Set up >>F3 Config >>137 enter >>F3 Params >> F1 Next Table >> Change parameter 179 to “3015” or any setting that fits your use of machine.

NOTE: Failure to configure the hardware and software properly may lead to inadequate lubrication of the machine resulting in premature wear and possible damage.