

# K B Motor Control Board

## Calibration Instructions

Part #994080, 994440

**NOTE: Be sure to set jumpers as follows:  
115 230 jumper - at 115    90 180 jumper - at 90!**

1. Set switches as follows.
  - Power - ON
  - Auto / Weld - AUTO
  - For / Rev - FOR
  - Run / Stop - RUN
  - Lock, Set, Clamp - OFF
  - Hub, 10, 11, 12 - OFF
  - 13 - ON
  - Auto / Man - AUTO
2. Connect a DC volt meter to the top of the terminal strip above the motor control board as follows:
  - a.) Connect the positive lead to A1.
  - b.) Connect the negative lead to A2.
3. Turn the **MAX** pot, located in the upper right corner of the motor control board, fully clockwise.
4. Turn the 13 **WELD** pot, located at the lower left access hole to the speed board, fully counterclockwise and then 1/8 turn clockwise.
5. Push "start" button.
  - a.) Adjust the **MIN** pot, located to the left side of the **MAX** pot, to 25VDC, plus or minus 1 volt.
  - b.) Adjust each **WELD** pot, **HUB** being at the top and 13 at the bottom, with corresponding speed switch on; all others off as follows:  
Tolerances on voltages = +/- 1 volt
    - HUB = 40 volts
    - 10 = 37 volts
    - 11 = 36 volts
    - 12 = 33 volts
    - 13 = 30 volts
6. Switch the **AUTO / MAN** switch to **MAN**. Adjust all **TACK** speeds as follows:  
Tolerances on voltages = +/- 1 volt
  - HUB = 77 volts
  - 10 = 69 volts
  - 11 = 65 volts
  - 12 = 65 volts
  - 13 = 65 volts