

**R50i Dynamic Alignment
Mounting instructions**

Verify the following items were received:

- R50i Encoder**
- Mounting Screws – 2 each**
- Cover**
- Setscrew wrench (1 per shipping tray)**

Additional Items needed to complete installation:

- Cable Assembly (Purchased separately)**
- Mounting screw wrench (Not included)**
- Servo cleats (not included)**
- Oscilloscope**

Step 1:

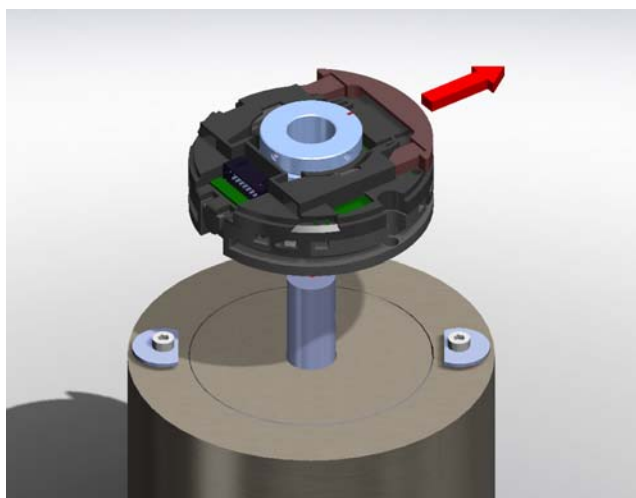


Figure 1

Energize appropriate motor windings to lock shaft. Verify slide is fully extended. If needed, apply threadlocker to mounting holes. Loosely install servo cleats with flat side facing shaft. Rotate hub so line on hub is 180° from connector. Slide encoder over motor shaft as shown in Figure 1.

Step 2:

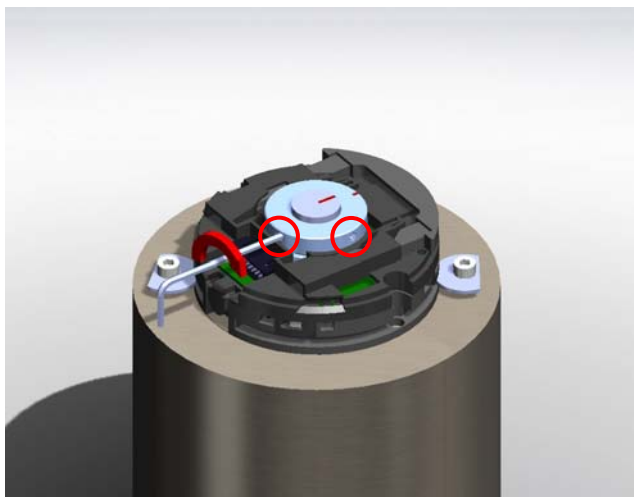


Figure 2

Rotate servo cleats to position shown in figure 2. Housing should be allowed to rotate, but not lift up. Torque both set screws to 20 oz-in.

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Step 3:

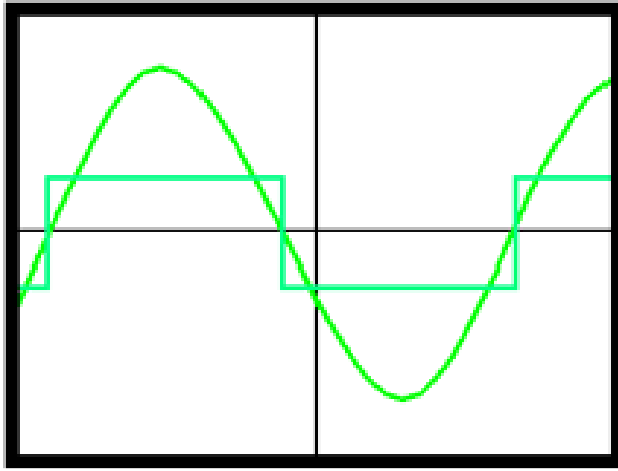


Figure 3

De-energize motor windings and install the encoder cable. Connect channel U and appropriate motor winding to oscilloscope. Back drive the motor and rotate the encoder until the waveforms match figure 3. Torque the mounting screws to 40 oz-in. **NOTE: motor can only be back driven at 500RPM max for 30 seconds max while slide is out.**

Step 4:

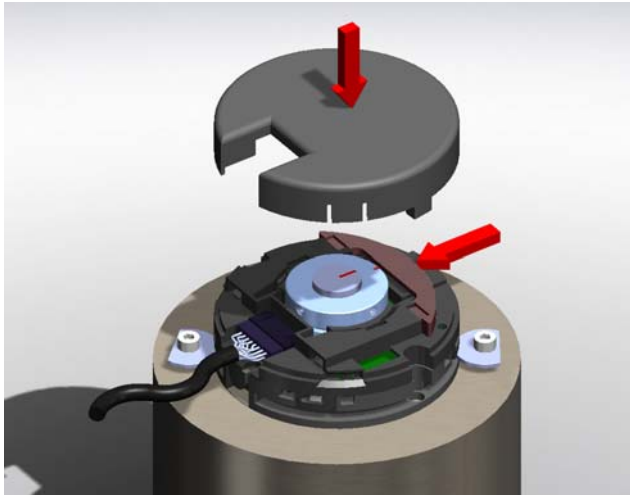


Figure 4

Push in slide and install cover.

Step 5:

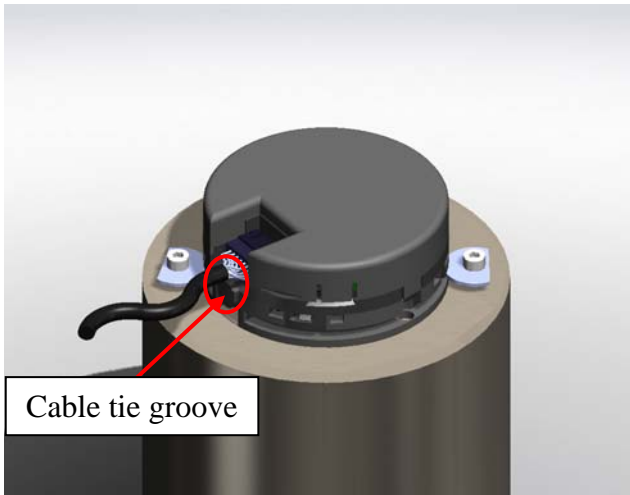


Figure 5

Add cable tie for strain relief if desired.

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