

NEWALL NEWALL MEASUREMENT SYSTEMS LTD

DSG & DMG

Linear Encoders



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I.0 INTRODUCTION

This manual will provide connection and mounting instructions for Newall's DSG Digital and DMG Digital linear encoders. It is important that you read and understand this manual prior to commencing the installation.

If, at any time, you have any questions relating to this manual or the installation, contact Newall or your local authorised Newall representative.

I.1 Bracketry

Due to the variety of machine types and applications, it will be necessary to design, make and fit custom brackets for the linear encoder assembly. If bracketry is needed make certain they are rigid enough not to allow any flexing or distorting while the machine is in operation. Newall offers a variety of bracket kits to aid in the installation. Contact Newall or your local authorised representative for details.

I.2 Preparation

Prior to beginning the installation the machine should be studied to determine where the Linear encoder(s) will be fitted. Appendix A shows several different methods of mounting the Reader Head along with its brackets.

In order to reduce erroneous readers caused by machine wear, it is recommended that the Scale be fitted as close to the machine lead screw or axial drive shaft as possible.

The actual overall scale length is approximately 258mm (10.1") for DSG and 173mm (6.8") for DMG longer than the stated scale travel. (e.g. if the travel length is 40" (DSG) the actual overall scale length of the scale will be 50")

Outboard mounting of the scale support brackets will add approximately 20mm (3/4") to the effective scale travel. (Refer to Appendix B)

For a more compact installation, scale travels of 300mm (12") or less may be fitted by supporting one end of the scale only by use of a single end mounting block. (Refer to Figure 6.4 and 6.10)

The moving member of the Linear *Digital* Encoder assembly can be either the Reader Head or the Scale.

Cable routing from the Reader Head should be examined (See Section 8). Each Reader Head is provided with either a 3.5 metre (11') or 7 metre (22') of armoured cable. Extension cables are available in 1 metre (3'), 2 metre (6'), 3.5 metre (11.5'), 5 metre (16.5') and 10 metre (32') lengths. Contact Newall or your local authorised representative for details.

I.3 Warnings

If for any reason the machine axis travel is greater than the actual scale travel it is recommended that 'mechanical stops' are fitted to the machine to avoid damage caused by over travel. Newall will not accept responsibility for Scale and Reader Head damage caused by machine over travel.

Both the Reader Head and the Scale are precision made components and it is important that they are handled with care. By design the Linear *Digital* Encoders can withstand the rigorous harsh workshop environment. However, permanent damage can occur through bending or severe impact.

It is important that the Scale be kept at least 13mm (0.5") away from any magnetic bases on indicators or magnetic chucks.

2.0 TECHNICAL SPECIFICATIONS

Construction:

Housing	Aluminium
Cable	6mm (1/4") Fully interlocked Stainless Steel conduit armour 9-way 'D-Type' connector; Heidenhein 12 pin or 9 pin round connector

Dimensions (reader head):

DMG Digital

Height	35.0mm (1.378")	
Width	75.0mm (2.953")	
Depth	25.0mm (0.984")	
Weight	0.640Kg (1.410lbs)	(max. inc. 3.5m cable)

DSG Digital

Height	53.5mm (2.106")	
Width	131.0mm (5.157")	
Depth	28.5mm (1.112")	
Weight	0.858Kg (1.890lbs)	(max. inc. 3.5m cable)

Operating Voltage: 5 VDC ± 5%

Supply Voltage Fluctuation: Within operating voltage range

Maximum Power Consumption: 80mA + line receiver requirement

Operating Temperature: 0 to 55°C

Storage Temperature: -20 to 70°C

Outputs: Differential Quadrature via RS422 compatible line drivers @ 5V TTL levels, 1Vpp or 11µApp.

Maximum Output frequency: 1,000,000 counts/sec (1Mhz)

Maximum cable length: 20m (using Newall supplied cables)

Required Moving Force:

DMG Digital	10N
DSG Digital	20N

Scale Type:

DMG Digital	Carbon Fibre	5.64mm OD	(0.222")
DSG Digital	Stainless Steel	15.24mm OD	(0.600")

Environmental Conditions: IP67 (fully submergible) according to IEC529.
Exceeds NEMA Type 6

EMC Compliance:

BS EN 50081-2 Electromagnetic Compatibility
Generic Emission Standard - Industrial Environment
BS EN 50082-2 Electromagnetic Compatibility
Generic Immunity Standard - Industrial Environment



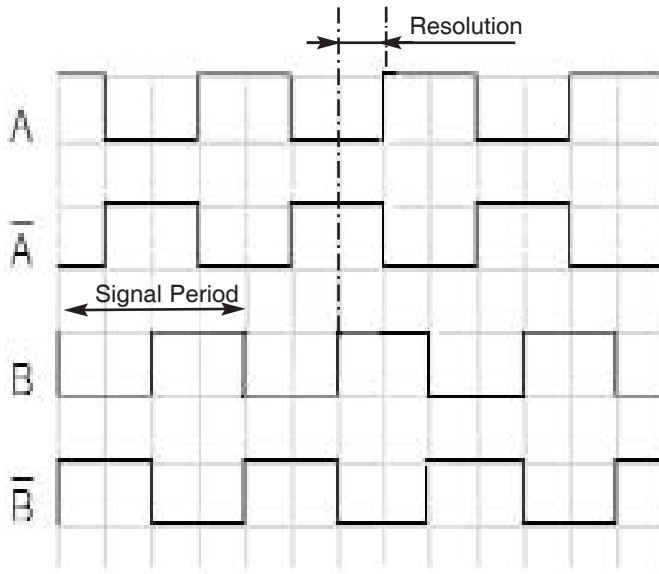
Certificate No FM36096

NOTE: NEWALL MEASUREMENT SYSTEMS LIMITED RESERVES THE RIGHT TO CHANGE THE SPECIFICATION WITHOUT NOTICE

2.1 Out Signals

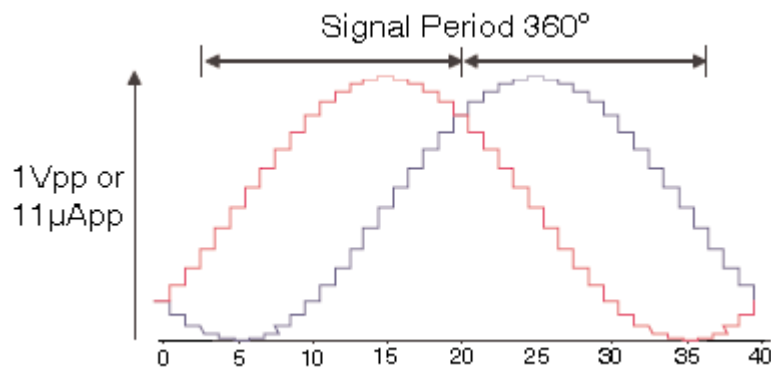
TTL Output Signal - Differential Quadrature

Newall TT Series Linear Encoders provide a differential quadrature output at RS422 TTL levels. The distance between two successive edges of the combined pulse trains A and B is one measuring step (resolution).



EV & EM - 1Vpp & 11 μ App Output Signal

Newall EV & EM Series linear encoders provide differential sinusoidal output signals that are phase shifted by 90°, and can provide 1Vpp or 11 μ App signal levels depending on which model is selected.



1Vpp is available with 20 μ m signal period only

11 μ App is available with 20 μ m or 40 μ m signal period

Assumes 120 Ohm termination resistor

2.2 Resolution and Signal Period Option

Both DSG - TT and DMG - TT are available, to order with a range of pre-programmed resolutions as shown below.

Resolution	DSG - TT	DMG - TT
1µm	√	√
2µm	√	√
5µm	√	√
10µm	√	√

Both DSG - EV / EM and DMG - EV / EM are available to order with the signal periods shown below.

Signal Period	DSG - EV	DSG - EM	DMG - EV	DMG - EM
20µm	√	√	√	√
40µm		√		√

2.3 DMG - EV and EM Interface Module

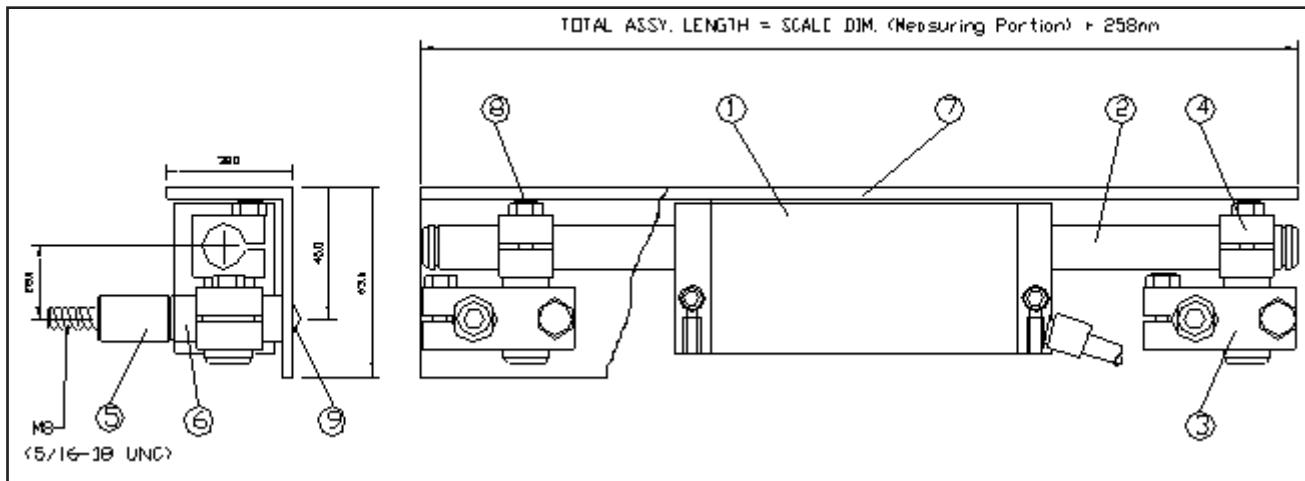
When DMG-EV or DMG-EM linear encoders are supplied, an interface module is included that provides 1Vpp or 11µApp output signals.

1Vpp SVV Interface module (Part Number 600-83640)

11µApp SVM Interface module (Part Number 600-83650)

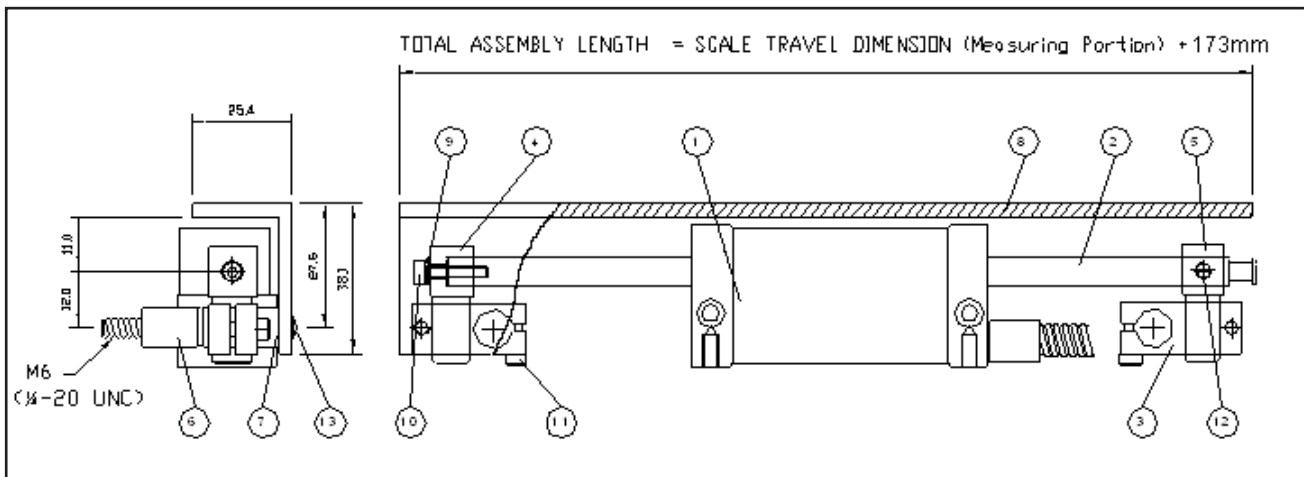


3.0 DSG ENCODER ASSEMBLY



Item	Description	Qty	Item	Description	Qty
1	DSG Digital Reader Head	1	6	Support Pillar Long	2
2	DSG Scale	1	7	Scale Cover	1
3	Scale Support Link	2	8	M5 x 20 Hex Head	6
4	Scale Anchor Pin	2	9	M8 x Socket Button Head	2
5	Support Pillar Short	2			

4.0 DMG ENCODER ASSEMBLY



Item	Description	Qty	Item	Description	Qty
1	DMG Digital Reader Head	1	8	Scale Cover	1
2	DMG Scale	1	9	M3 Spring Washer	1
3	Support Link	2	10	M3 x 16 SHCS	1
4	Anchor Pin	1	11	M3 x 12 SHCS	4
5	Support Pin	1	12	M4 x 5 Nylon Set Screw	1
6	Support Pillar Short	2	13	M6 x 10 Socket Button Head	2
7	Support Pillar Long	2			

5.0 MOUNTING THE DIGITAL READER HEAD

5.1 DSG Digital

Mount the *Digital* Reader Head together with its bracket(s) to the machine and secure the assembly parallel with axis travel to within $\pm 0.05\text{mm}$ (0.002"). (Refer to Figure 5.1)

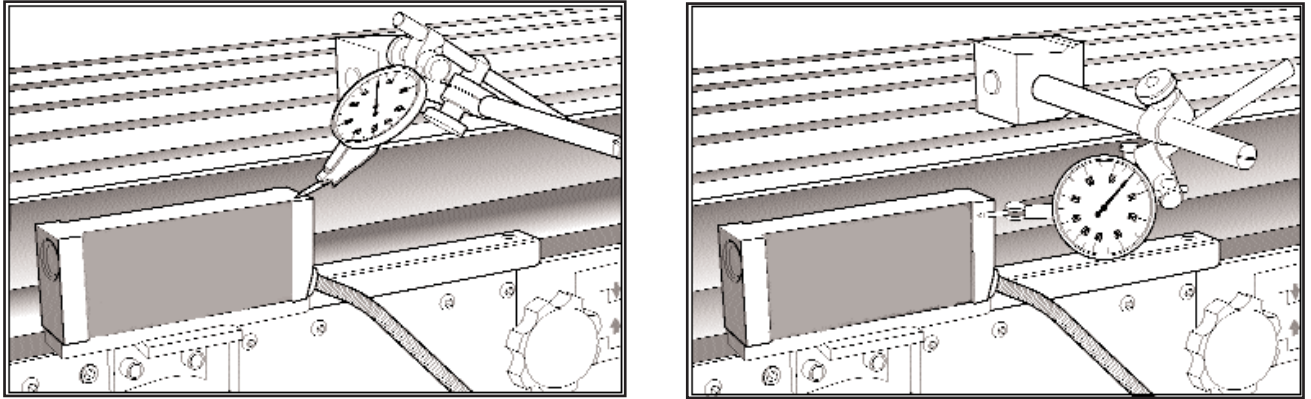


Figure 5.1 - Alignment of the DSG Digital Reader Head

Final adjustments can be carried out by use of laminated shims, which are included with each transducer assembly. Each layer of shim is equivalent to 0.05mm (0.002").

5.2 DMG Digital

Mount the *Digital* Reader Head together with its bracket(s) to the machine and secure the assembly parallel with axis travel to within $\pm 0.05\text{mm}$ (0.002"). (Refer to Figure 5.2)

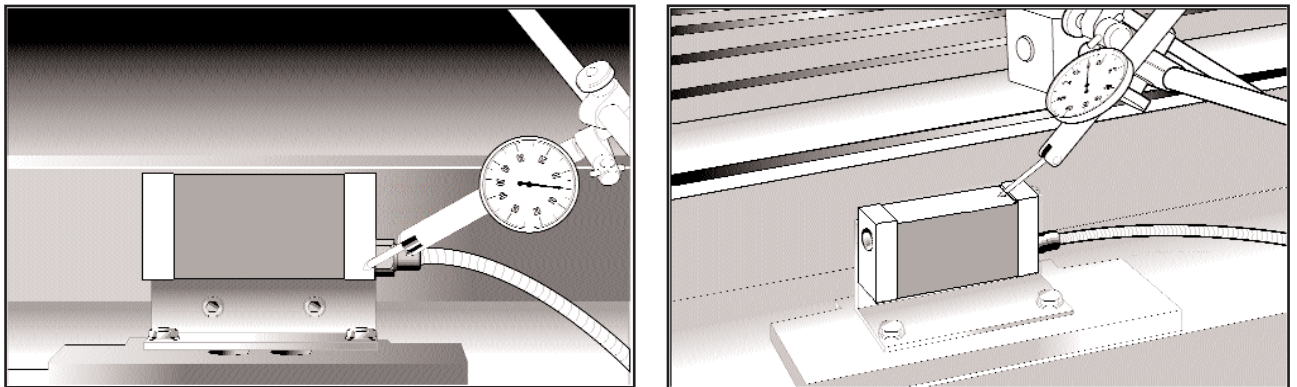


Figure 5.2 - Alignment of the DMG Digital Reader Head

6.0 MOUNTING THE SCALE

6.1 DSG

6.1.1 Double End Mounting

Note: Refer to section 6.1.3 for mounting scales in excess of 2.5 meters.

Each end of the DSG Scale is different and can be identified by the pan head screw at the 'tensioner end' and a nylon snap rivet at the 'fixed end'.

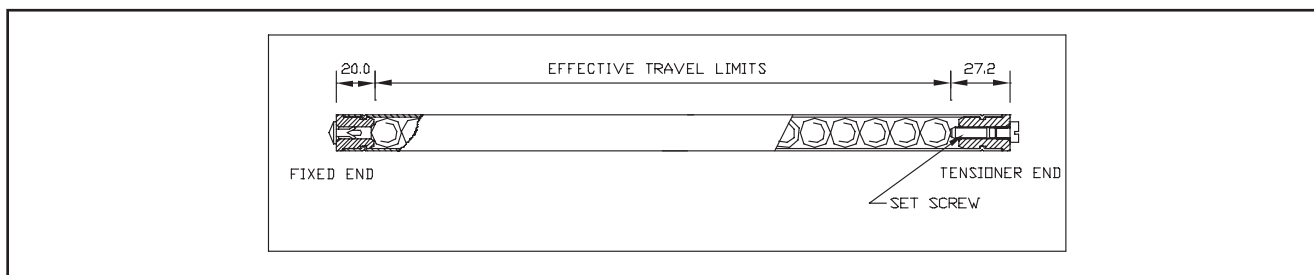


Figure 6.1 - DSG Scale

NOTES:

- (A) Erroneous readings will occur if the *Digital Reader Head* is allowed to travel beyond the Effective Travel Limits. (Refer to Figure 6.1)
- (B) The pre-load on the balls are factory set via the set screw at the tensioner end. Do not tamper with or adjust the set screw as this will alter the calibration and accuracy specification of the scale. (Refer to Figure 6.1)
- (C) When mounting scales in the vertical plane the tensioner end should be positioned at the top.

Once the *Digital Reader Head* is secured and correctly aligned, the scale support brackets can now be fitted. The scale support brackets consist of the support pin, the support link and the pillar(s).

Traverse the machine to its maximum position toward the non-cable entry side of the Reader Head. Maximum position means all available travel, including hand winding past any electrical limits or trip dogs.

Carefully slide the DSG Scale through the *Digital Reader Head*, allowing for a sufficient amount of scale to project from the Reader Head in order to fit the scale support brackets.

Assemble the scale support link to the scale support pin leaving approximately 3mm (1/8") gap between the bottom of the pin shoulder and the top of the link.

Slide the link/pin assembly onto the scale to approximately 5mm (0.2") away from the end of the *Digital Reader Head*.

Transfer punch through the support link and into the machine casting. It is important that the support link is kept square to its mounting surface at all times.

Remove the link/pin assembly and the scale from the *Digital Reader Head*. Drill and tap M8 x 18mm deep (USA 5/16 - 18 x 3/4" deep) into the machine casting as marked by the transfer punch. Fit the pillar(s) to the machine casting by using one of the methods shown in Figure 6.3. The pillar should fit square and flush to the machine surface.

Mounting the Scale

A maximum of two support pillars may be screwed together to allow for sufficient adjustment of the scale. If two pillars are insufficient to enable the scale to be mounted, then additional brackets will be necessary. These brackets must be sufficiently rigid to eliminate any axial movement of the scale.

Loosely fit the support link/pin assembly onto the pillar and pass the scale through the *Digital Reader Head* and into the support pin. While gently sliding the scale forward and back 25 - 50mm (1" - 2") through the support pin, carefully tighten the hex screws on the support link, ensuring that the scale slides smoothly through the *Digital Reader Head* and into the support pin. If any interference is detected then fully loosen the hex screws on the support link and repeat this step.

Note: Do not force the Scale through the Support Pin

IMPORTANT WARNING:

THE CENTRE LINE BORE OF THE READER HEAD MUST BE IN DIRECT ALIGNMENT WITH THE CENTRE LINE BORE OF THE SUPPORT PIN. PERMANENT DAMAGE TO SCALE AND/OR ERRONEOUS READINGS WILL OCCUR IF THIS WARNING IS NOT FOLLOWED. REFER TO FIGURE 6.2

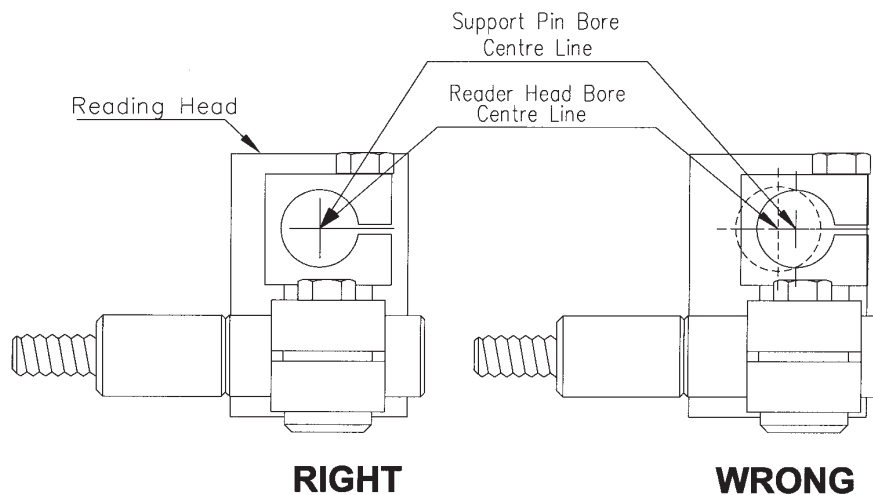


Figure 6.2 - DSG Reader Head and Bracket Alignment

Remove the scale from the *Digital Reader Head* and traverse the machine to its full extent in the **opposite direction**. Full extent means hand winding past electrical limits.

Assemble the scale support link to the scale support pin leaving approximately 3mm (1/8") gap between the bottom of the pin shoulder and the top of the link.

Slide the link/pin assembly onto the scale making certain that there is sufficient clearance between the Reader Head and the support link to prevent damage to the *Digital Reader Head* cable. Do not secure the support pin to the scale at this time.

Transfer punch through the support link and into the machine casting. It is important that the support link be kept square to its mounting surface at all times.

Remove the link/pin assembly and the scale from the *Digital Reader Head*. Drill and tap M8 x 18mm deep (USA 5/16" -18 x 3/4" deep) into the machine casting as marked by the transfer punch. Fit the pillar(s) to the machine casting by using one of the methods shown in figure 6.3. The pillar shoulder fit square and flush to the machine surface.

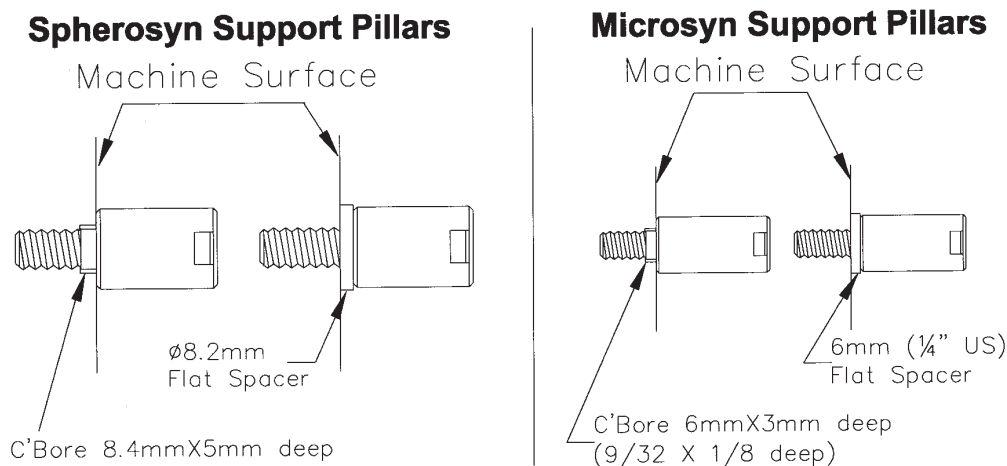


Figure 6.3 - Support Pillars

A maximum of two support pillars may be screwed together to allow for sufficient adjustment of the scale. If two pillars are insufficient to enable the scale to be mounted, then additional brackets will be necessary. These brackets must be sufficiently rigid to eliminate any axial or radial movement of the scale.

Loosely fit the support link/pin assembly onto the pillar and pass the scale through the *Digital Reader Head* and into the support pin. While gently sliding the scale forward and back 25 - 50mm (1" - 2") through the support pin, carefully tighten the hex screws on the support link, ensuring that the scale slides smoothly through the *Digital Reader Head* and into the support pin. If any interference is detected then fully loosen the hex screws on the support link and repeat this step.

Carefully slide the DSG Scale through the support pin, through the *Digital Reader Head* and into the opposite support pin. **FULLY TIGHTEN THE SUPPORT PIN HEX SCREW AT THE FIXED END OF THE SCALE, BUT ONLY 'SNUG UP' THE HEX SCREW ON SUPPORT PIN AT THE TENSIONER END.**

6.1.2 Single End Mounting

Note: The maximum total length of the scale must not exceed 610mm (24") when using a single end mounting kit. The single end mounting kit is sold separately, ask for UK part number 600-63610, USA part number LBK01.

Remove the nylon pan head screw from the tensioner end of the scale.

After the *Digital Reader Head* has been installed slide the scale through the *Digital Reader Head* and insert the tensioner end of the scale into the single end mounting block. (Refer to Figure 6.4)

Once the position for the single end mounting block has been determined mark the machine casting using the slot in the mounting block as the guide. Drill and tap M6 x 12mm deep (USA 1/4 - 20 x 1/2"). Fit the mounting block using the M6 (USA 1/4 - 20) socket head cap screw and washer.

Check the alignment by gently sliding the scale through the head and in and out of the mounting block, adjustments may be carried out by altering the M5 jacking screws. When the alignment is complete secure the scale by inserting the M5 screw and washer through the mounting block and into the tensioner end of the scale.

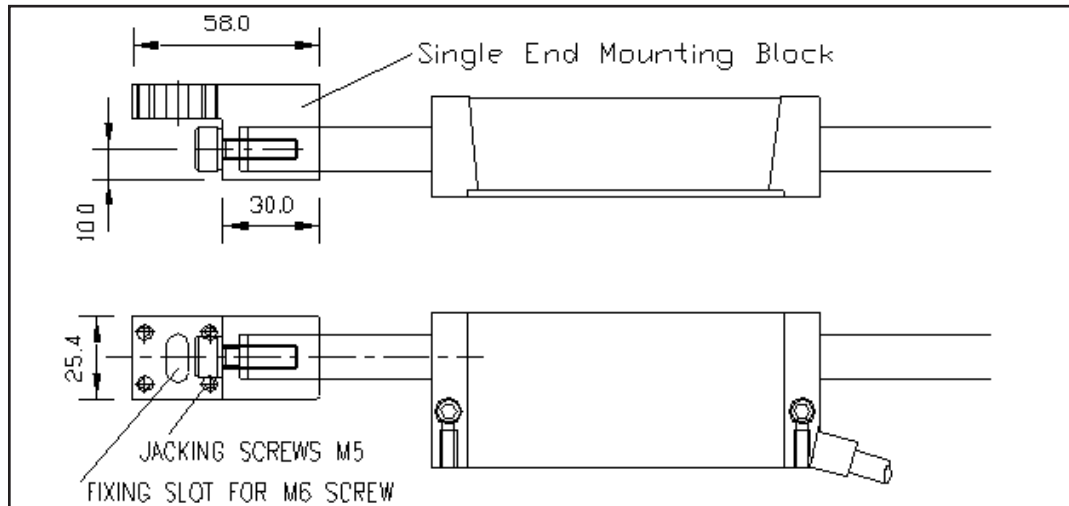


Figure 6.4 - DSG Single End Mounting

6.1.3 Scales in Excess of 2.5 meters

Traverse the machine to fullest extent of travel including hand winding past any electrical limits or trip dogs.

Insert the short blank length of DSG tube into the *Digital Reader Head*, allowing for a sufficient amount of scale to project from the *Digital Reading Head* in order to fit the scale mounting brackets.

Assemble the angle bracket to the scale clamp (Refer to Figure 6.5). The jacking plate is included in each bracket kit, this will only be required if the machine mounting face is not a machined surface. Slide the assembly onto the scale allowing approximately 10mm clearance from the end of the Reader Head.

Mark the position of the jack plate (if required) or the angle support bracket. Drill and tap the necessary fixing holes and assemble the bracket to the machine.

Remove the blank tube and the bracket assembly from the *Digital Reader Head*. Drill and tap M8 x 18mm (USA 5/16"-18 x 3/4") fixing holes. Fit the jack plate (if required) and secure to the machine. Assemble the scale clamp and the angle bracket to the jack plate but do not secure. Traverse the *Digital Reader Head* as near to the bracket assembly as possible. Slide the blank tube through the *Digital Reader Head* into the scale clamp. Adjust the brackets into position and carefully tighten the screws. Check that the blank tube slides through the *Digital Reader Head* and into the scale clamp smoothly without any fouling or interruption.

Remove the blank tube and traverse the machine to the full extent in the opposite direction. Remember the "full extent" is the absolute maximum travel up to the mechanical "dead stops".

Check the overall length of the actual scale and measure from the outside edge of the scale clamp already fitted to the machine and mark the position of the scale on to the machine.

Slide the DSG blank tube into the *Digital Reader Head*, assemble the remaining scale bracket assembly including the jacking plate (if required) and slide onto the tube.

Set the outside edge of the scale clamp level with the mark that indicates the overall length of the DSG Scale and mark the fixing position for the bracket assembly.

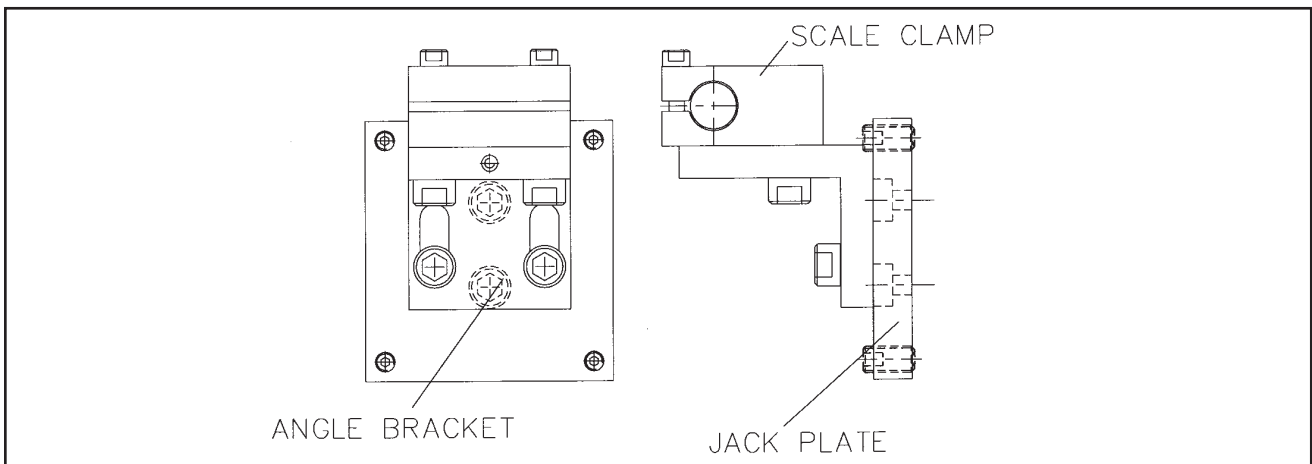


Figure 6.5 - Long Scale Support Bracket Assembly

For scales which are mounted in the horizontal position, spring loaded scale supports are included and should be positioned according to Table I.

Once the locations for the supports have been determined, the DSG Reader Head should be positioned in the location where the first support is to be fitted. Assemble the support unit including the jack plate if required. Mark the position for the fixing screws, drill and tap (M8 for the jack plate or M6 for the angle bracket). Ensure that the angle bracket has sufficient movement utilising the two slots to allow for adjustment in the vertical plane. It is **important** that the top face of the angle bracket is set to 58.5mm (2.3") from the bottom machined face on the DSG Reader Head.

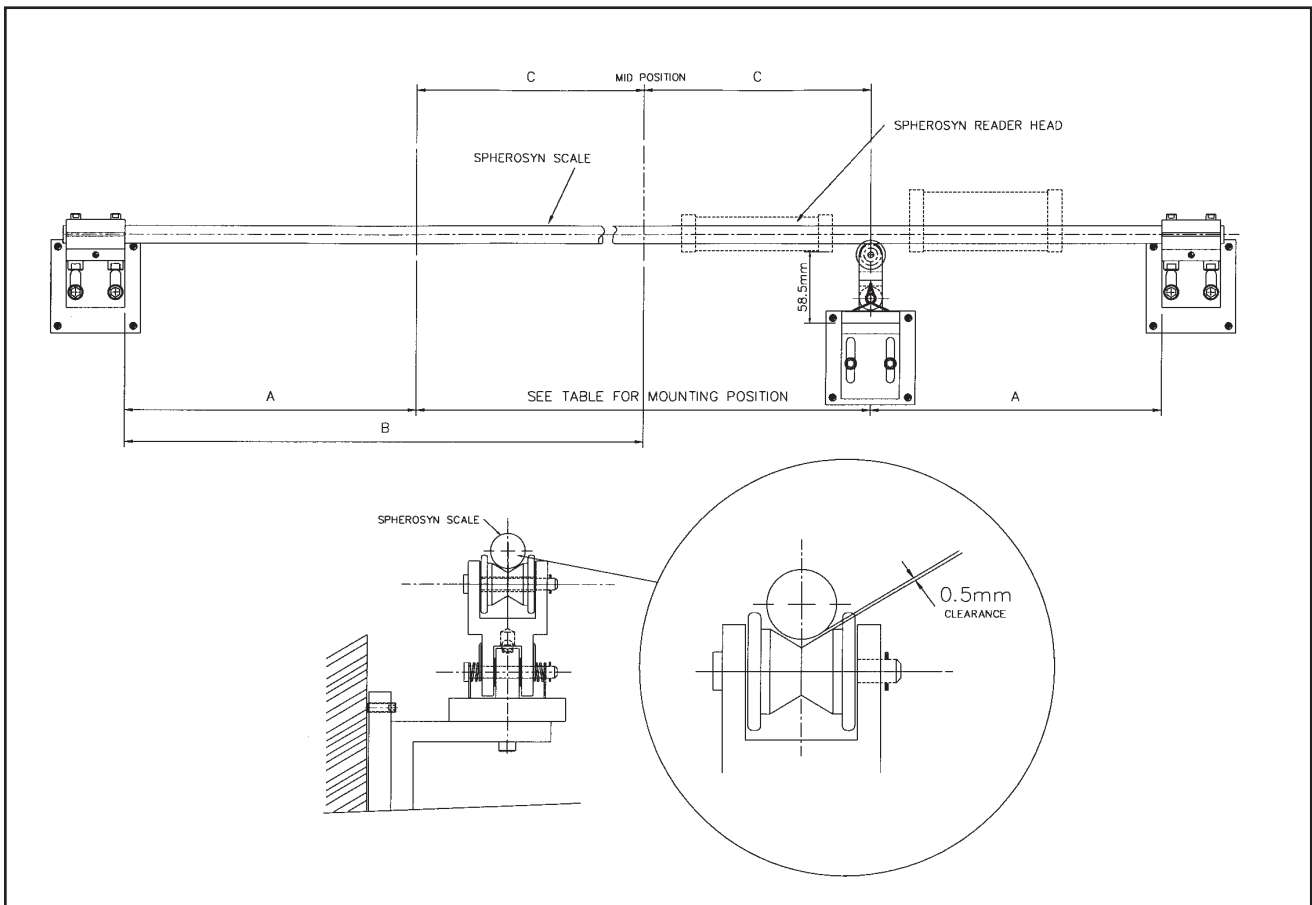


Figure 6.6 - DSG Long Scale Mounting and Support Details

Mounting the Scale

Length	No off Scale Supports	FROM FIXING BRACKET		Mid Position of Travel (B)	Left Side Position of Travel (C)	Right Side Position of Travel (C)
		Left Side (A)	Right Side (B)			
2500mm	2	850mm	850mm	-	-	-
3000mm	2	1100mm	1100mm	-	-	-
3500mm	2	1350mm	1350mm	-	-	-
4000mm	2	1500mm	1500mm	-	-	-
4500mm	3	1125mm	1125mm	2250mm	-	-
5000mm	3	1250mm	1250mm	2500mm	-	-
5500mm	3	1350mm	1350mm	2750mm	-	-
6000mm	3	1500mm	1500mm	3000mm	-	-
6500mm	4	1300mm	1300mm	-	650mm	650mm
7000mm	4	1400mm	1400mm	-	700mm	700mm
7500mm	4	1500mm	1500mm	-	750mm	750mm
8000mm	4	1600mm	1600mm	-	800mm	800mm
8500mm	5	1410mm	1410mm	4250mm	1410mm	1410mm
9000mm	5	1500mm	1500mm	4500mm	1500mm	1500mm
9500mm	5	1580mm	1580mm	4750mm	1580mm	1580mm
10000mm	6	1420mm & 2840mm	1420mm & 2840mm	-	710mm	710mm
10500mm	6	1500mm & 3000mm	1500mm & 3000mm	-	750mm	750mm
11000mm	6	1570mm & 3140mm	1570mm & 3140mm	-	785mm	785mm

Table 1

6.2 DMG Scale

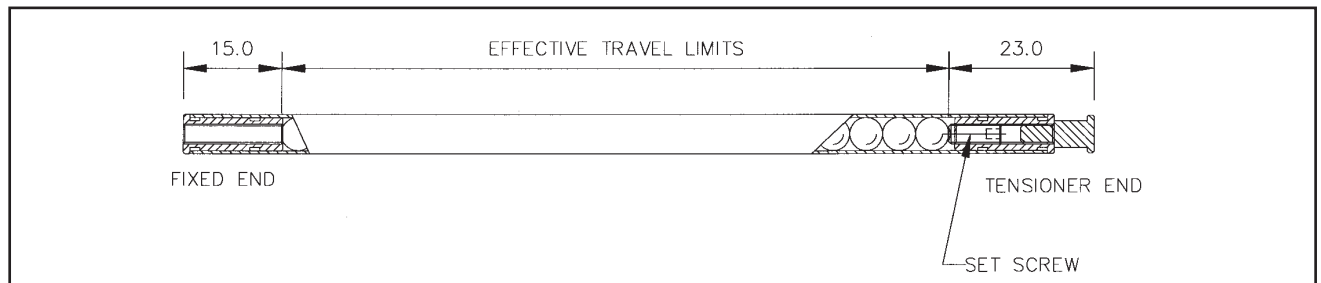


Figure 6.7 - The DMG Scale

NOTES:

- (A) Erroneous readings will occur if the DMG Digital Reader Head is allowed to travel beyond Effective Travel Limits. (Refer to Figure 6.7)
- (B) The pre-load on the balls are factory set via the set screw at the tensioner end. Do not tamper with or adjust the set screw as this will alter the calibration and accuracy specification of the scale and void the warranty.
- (C) When mounting scales in the vertical plane the tensioner end should be positioned at the top.

The scale support brackets kit consists of the Anchor Pin, Support Pin, Support Link, and Pillar(s). (Refer to Figure 5.8) In order to avoid the risk of damage to the scale during installation all DMG Linear *Digital* Encoders include a set up bar. The set up bar is of the same diameter as the DMG Scale and will be used to align the brackets to the *Digital* Reader Head.

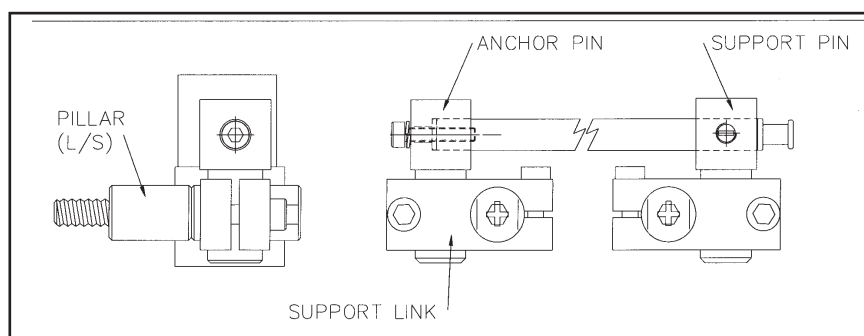


Figure 6.8 - DMG Scale Support Bracket

Traverse the machine to its maximum position toward the non-cable entry side of the *Digital* Reader Head. Maximum position means all available travel, including hand winding past any electrical limits or trip dogs.

Carefully slide the DMG Scale set-up bar through the *Digital* Reader Head, allowing for sufficient scale to project from the *Digital* Reader Head in order to fit the scale support brackets.

Assemble the support link to the anchor pin leaving approximately 3mm (1/8") gap between the bottom of the anchor shoulder and the top of the link.

Slide the link/anchor assembly onto the scale set-up bar to approximately 5mm (0.2") away from the end of the *Digital* Reader Head.

Transfer punch through the support link and into the machine casting. It is important that the support link be kept square to its mounting surface at all times.

Remove the link/anchor assembly and the scale set-up bar from the *Digital* Reader Head. Drill and tap M6 x 12mm deep hole (USA 1/4 - 20 x 1/2") into the machine casting as marked by the transfer punch. Fit the pillar(s) to the machine casting by using one of the methods shown in Figure 6.3. The pillar shoulder fits square and flush to the machine surface.

A maximum of two support pillars may be screwed together to allow for sufficient adjustment of the scale. If two pillars are insufficient to enable the scale to be mounted, then additional brackets will be necessary. These brackets must be sufficiently rigid to eliminate any axial movement of the scale.

Loosely fit the support link/anchor assembly onto the pillar and pass the scale set-up bar through the *Digital* Reader Head and into the anchor pin. While gently sliding the scale set-up bar in and out of the anchor pin, carefully tighten the cap screws on the support link, ensuring that the scale set-up bar slides smoothly through the *Digital* Reader Head and into the anchor pin. If any interference is detected then fully loosen the cap screws on the support link and repeat this step.

Remove the scale set-up bar from the *Digital* Reader Head and traverse the machine to its full extent in the opposite direction. Full extent means hand winding past electrical limits.

Assemble the scale support link to the support pin leaving approximately 3mm (1/8") gap between the bottom of the mounting shoulder and the top of the link. (Refer to Figure 6.8)

Mounting the Scale

Slide the link/pin assembly onto the scale set-up bar making certain that there is sufficient clearance between the *Digital Reader Head* and the support link to prevent damage to the *Digital Reader Head* cable. Do not secure the support pin to the scale at this time.

Transfer punch through the support link and into the machine casting. It is important that the support link be kept square to its mounting surface at all times.

Remove the link/pin assembly and the scale from the *Digital Reader Head*. Drill and tap M6 x 12mm deep (USA 1/4 - 20 x 1/2 deep) into the machine casting as marked by the transfer punch. Fit the pillar(s) to the machine casting by using one of the methods shown in Figure 6.3. The pillar shoulder fit square and flush to the machine surface.

Loosely fit the support link/pin assembly onto the pillar and pass the scale set-up bar through the *Digital Reader Head* and into the support pin. While gently sliding the set-up bar forward and back 25 - 50mm (1" - 2") through the support mounting, carefully tighten the screws on the support link, ensuring that the scale set-up bar slides smoothly through the *Digital Reader Head* and into the support pin. If any interference is detected then fully loosen the screws on the support link and repeat this step.

IMPORTANT WARNING

THE CENTRE LINE BORE OF THE READER HEAD MUST BE IN DIRECT ALIGNMENT WITH THE CENTRE LINE BORE OF THE SUPPORT PIN. PERMANENT DAMAGE TO SCALE AND/OR ERRONEOUS READINGS WILL OCCUR IF THIS WARNING IS NOT FOLLOWED. REFER TO FIGURE 6.9

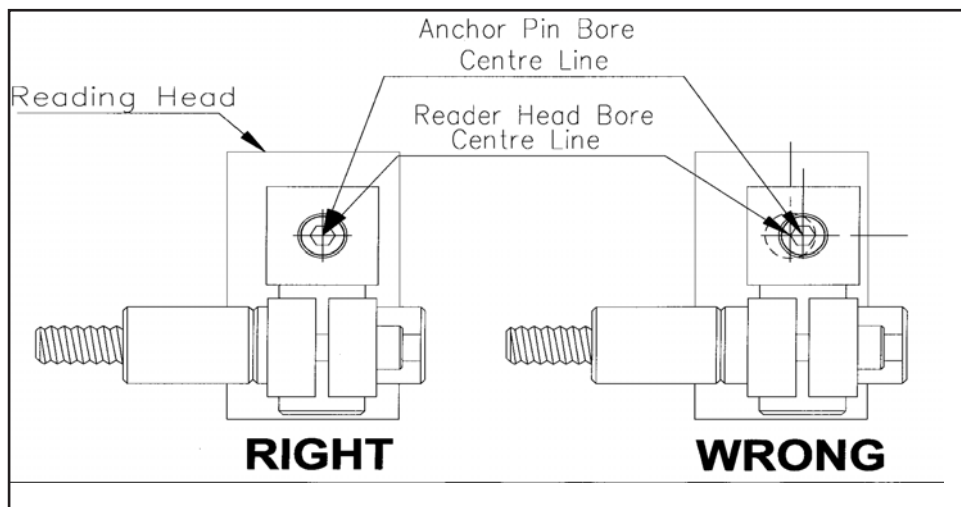


Figure 6.9 - DMG Reader Head and Bracket Alignment

Carefully slide the DMG Scale through the support pin, ensuring the fixed end is inserted first, through the *Digital Reader Head* and into the anchor pin.

Using the M3 x 16 skt cap screw and spring washer, secure the scale to the anchor pin. It is **important** that the nylon set screw on the support pin be only "pinched" to the scale at the tensioner end. **DO NOT OVER TIGHTEN THE NYLON SET SCREW ON THE SUPPORT PIN.**

6.2.1 Single End Mounting

For installations requiring a lower profile assembly, there is an alternative method for fixing the scale at one end only by way of the single end mounting block assembly (Refer to Figure 6.10). The DMG single end mounting kit is sold separately, as for UK part number 600-65340, US part number LBK02 (for DSG & DMG) and LBK03 (for DMG only).

Note: The maximum total length of scale not exceed 450mm (18") when using the single end mounting block.

Once the *Digital* Reader Head has been installed slide the scale through the head and insert the fixed end of the scale into the single end mounting block. (Refer to Figure 6.10)

Once the position for the single end mounting block has been determined mark the machine casting with the slot in the block. Drill and tap a M5 x 12mm deep hole. Fit the bracket using the M5 skt head cap screw and washer. Check the alignment by gently sliding the scale through the head and in and out of the mounting block, adjustments may be carried out by altering the M3 jacking screws. When the alignment is complete secure the scale by inserting the M3 screw and spring washer through the mounting block and into the fixed end of the scale.

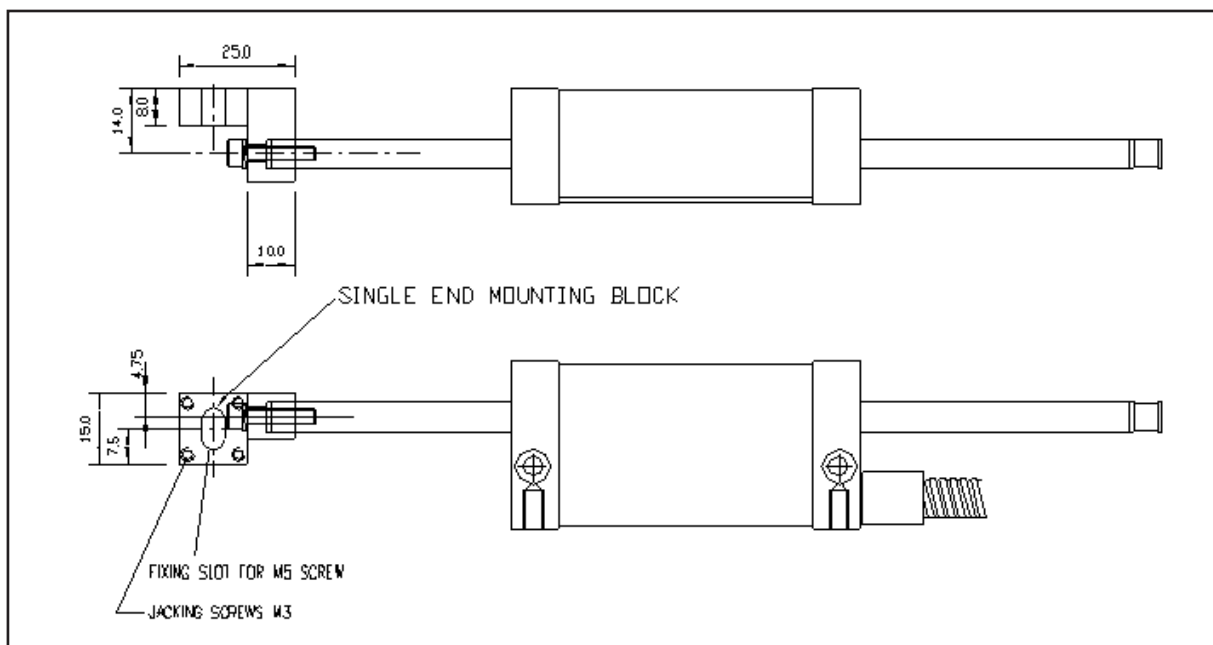


Figure 6.10 - DMG Single End Mounting

7.0 FITTING THE SCALE GUARD

Each Encoder includes a protective guard. This aluminium guard is intended to protect the scale from impact damage. The guard can be attached to the machine casting or by means of the scale support pillars. (Refer to Figure 7.1)

To fit the guard to the support pillars, measure and mark off the distance between the centre of each pillar. For DSG drill two 8.5mm (3/8"), for DMG 7mm (9/32") holes at either end of the guard. The guard can be attached to the pillars by using the button head screws provided. After the guard is attached, move the machine axis to both extents of its travel ensuring that the guard does not interfere with or rub against the *Digital* Reader Head.

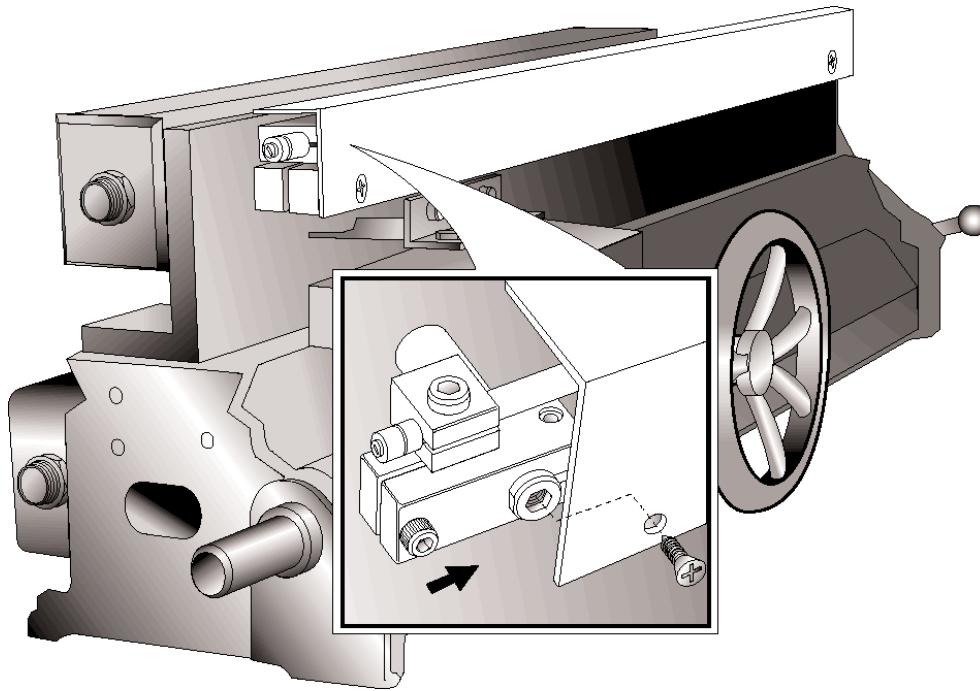


Figure 7.1 - Fitting the Scale Guard (example shown using a DSG Scale)

8.0 CABLE ROUTING

The most important and the most over looked aspect of fitting the Encoder is proper cable routing. Dangling and loose cables can be snagged or broken causing irreparable damage. Care should be taken in order to ensure that the cables are secured to the machine and that cable loops do not interfere with any part of the machine or the Encoder movements. "P" clips and thread forming screws are provided to route the cables from the *Digital Reader Head* to the digital readout unit.

Note: The armoured cable is an integral part of the *Digital Reader Head*. If the cable becomes damaged, then it would have to be replaced complete with the Reader Head.

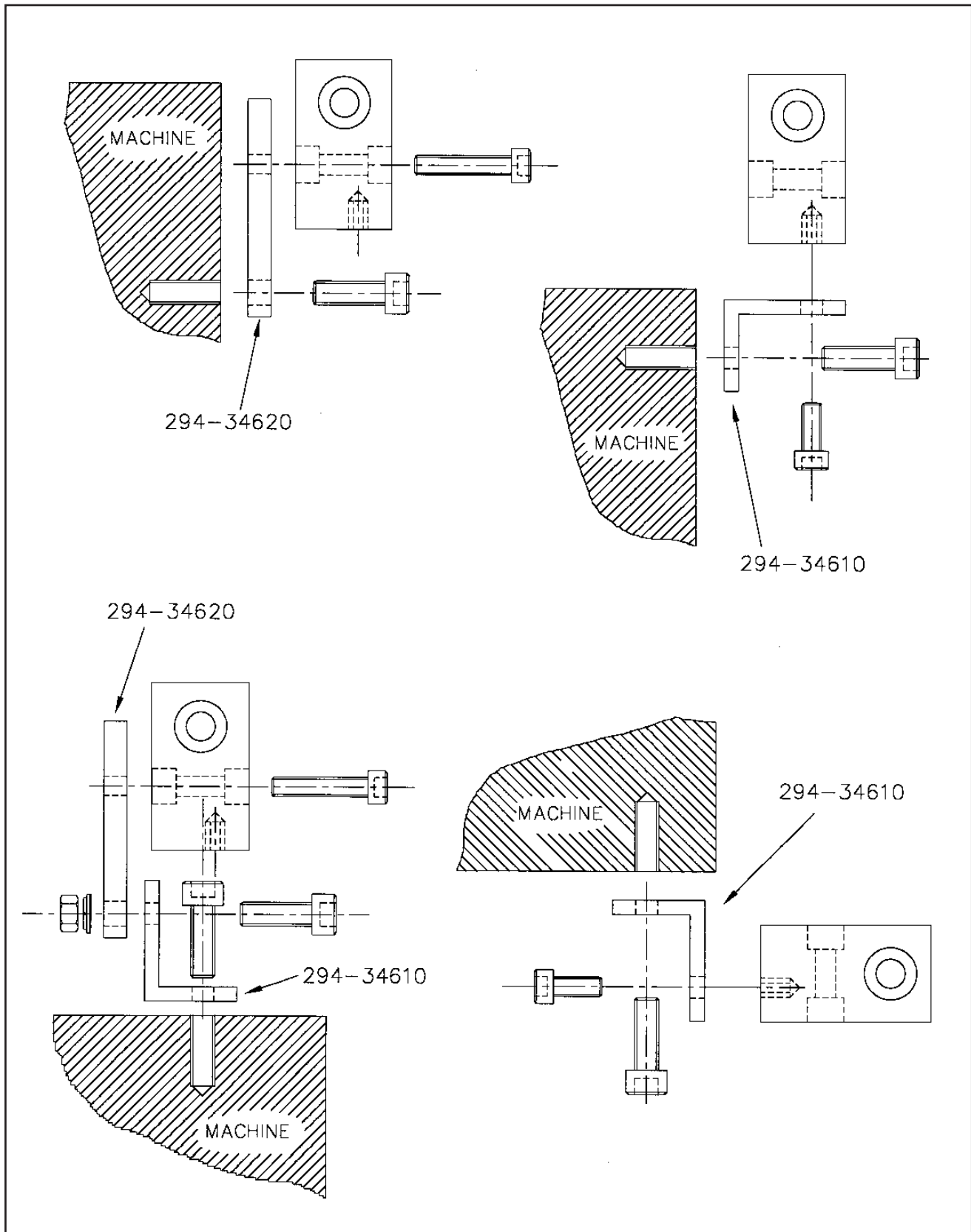
If extension cables are used, do not allow the plug and socket junction to lie in the swarf tray or in the direct flow of coolant or oil.

In order to avoid problems associated with electrical noise and interference, do not allow the cables to lie across electrical motors, fuse boxes or electrical pumps.

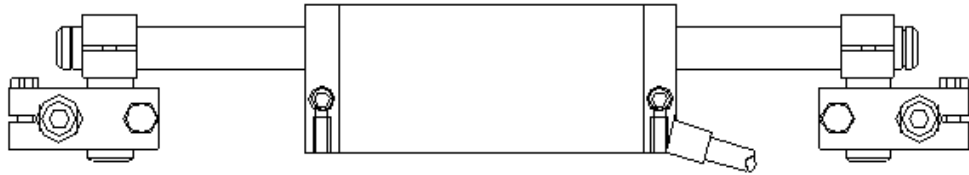
9.0 FINAL CHECK

Prior to putting the Encoder into operation, slowly traverse the machine axis to both extents of its travel checking at all times that the cables are secure and that machine over travel cannot occur. Newall will not accept responsibility for Encoder malfunction caused by over travel or damaged cables.

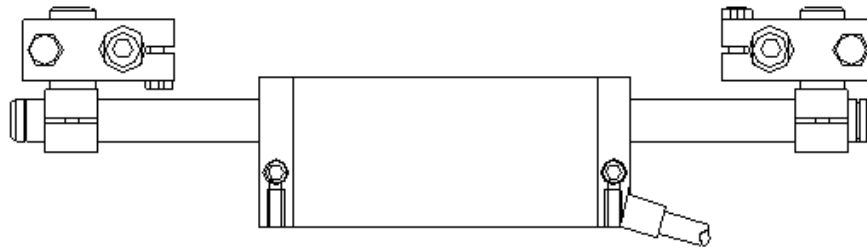
Appendix A -- Mounting the Digital Reader Head



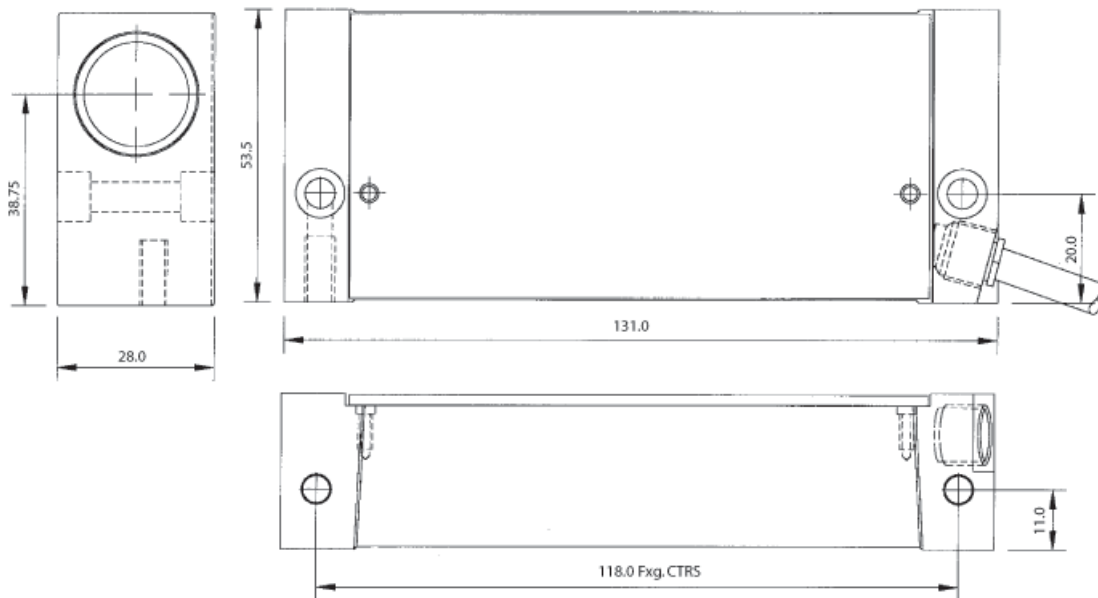
Appendix B - DSG Scale Support Brackets



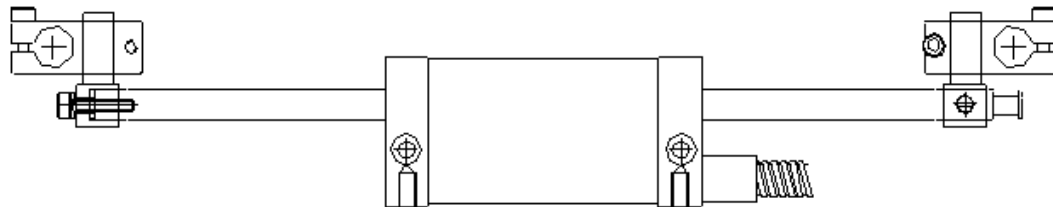
Outboard Scale Support Mounting



Scale Supports Inverted



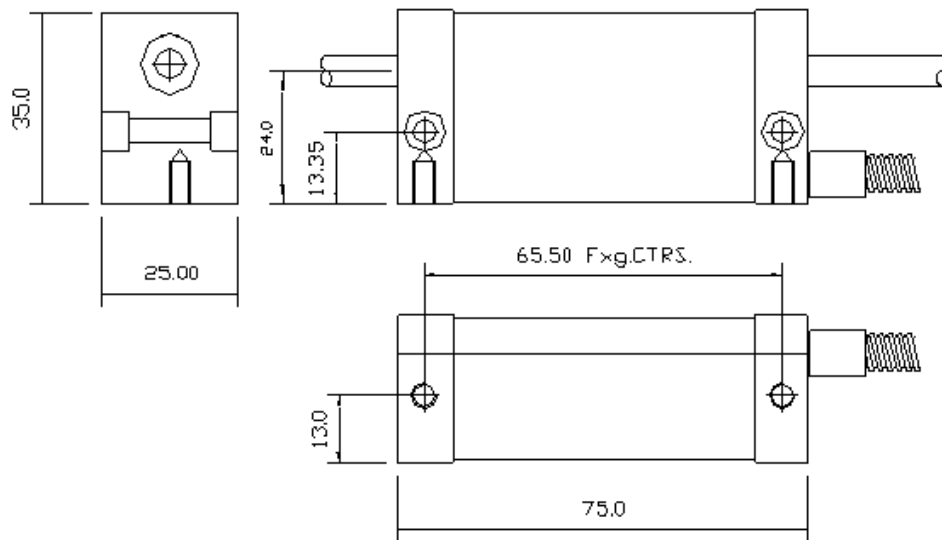
Appendix B - DMG Digital Scale Support Brackets



SCALE SUPPORT INVERTED



OUTBOARD SCALE SUPPORT MOUNTING



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