

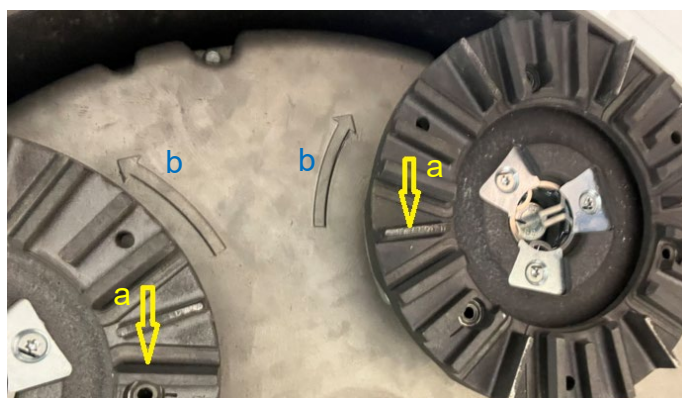
## SB, Disc rotation, PG 6 XR, PG 8 XR, 2024-11

### SYMPTOM/DESCRIPTION

The PG 6 XR and PG 8 XR can potentially be programmed to rotate the disc in the opposite direction (a) compared to the arrows under the drum (b).

This rotation direction can have a negative effect on rotation sensitive tools like T-rex.

To solve the problem, a reprogramming of the VFD parameters to change the rotation is needed.



**Note: This reprogramming is only needed if the 4 discs rotate in the wrong direction (a) compared to the arrows (b).**

### AFFECTED UNITS

- PG 6 XR produced before w.46 2024 with serial numbers up to 202448100026.
- PG 8 XR produced before w.46 2024 with serial numbers up to 202446100045.

### CORRECTIVE ACTION

Check the rotation of the discs to see if a reprogramming of the VFD is needed.

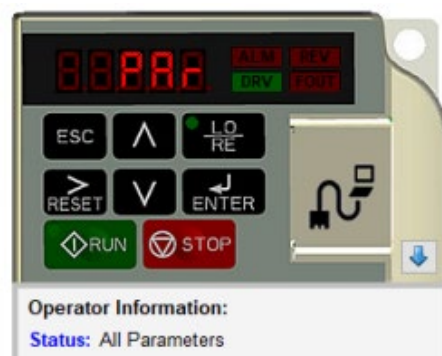
Rotation control procedure:

1. Remove all tool holders or tools, unless they are secured with screws, before proceeding.
2. Set the support wheel in top position so the grinding head is clear of the floor.
3. Set the rotation knob in position "0" or slightly to the right on the remote control.
4. Start the grinder on the lowest speed.
5. Look at the motor fan and stop the grinder. The fan will decrease in speed so you can see if it turns clockwise or counter clockwise.
6. If the motor fan/motor is turning clockwise you have the disc rotation correct and do not need any action on the VFD.
7. If the motor fan/motor is turning counter clockwise you need to reprogram the VFD according to below procedure.

## PROCEDURE

### Reprogramming of the VFD:

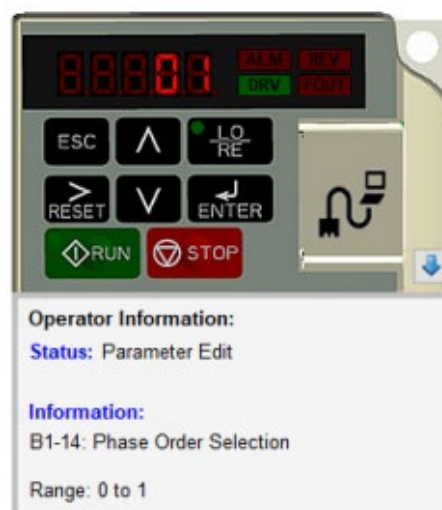
1. Open the electrical cabinet and power up the grinder. The WFD will light up.
2. Use the arrows (up or down) until you see "PAR" in the display.
3. Press ENTER.



4. Use arrows "UP/DOWN" and "RESET" until you see parameter "b1-14".
5. Press ENTER.



6. Use the arrows to change the value to "01".
7. Press ENTER.
8. Press ESC to go back to start menu.
9. **Start the grinder and repeat the rotation control procedure as explained in the corrective action section, to confirm that the fan rotate clockwise.**



**PARTS INFORMATION**

No spare parts needed.

**WARRANTY INFORMATION**

The normal warranty policy applies.

***Revision History***

<b><i>Rev.</i></b>	<b><i>Date</i></b>	<b><i>Order id.</i></b>	<b><i>Description</i></b>
<b><i>A</i></b>	<b><i>2024-11</i></b>	<b><i>00108451</i></b>	<b><i>Created</i></b>