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EASY TO UNDERSTAND INSTRUCTIONS!

CALIBRATION OF CUTTERHEAD SUSPENSION (NEUMANN VMS-80)

FOR STEPS 3.6, 3.7 & 3.9

A--DISCONNECT CABLE BETWEEN CUTTERHEAD SUSPENSION AND LATHE ELECTRONICS. HOLDBACK SPRING ADJUSTMENT FOR FLOATING HEAD POSITION: WITH HEAD LOWERED, ADJUST SPRING USING KNURLED KNOB AT BACK UNTIL FACEPLATE IS FLUSH WITH FRONT OF CUTTERHEAD SUSPENSION. (This adjustment allows you to adjust the radial carriage correctly without letting the faceplate prejudice the verticle reticule reading of 'scope)

B--CARRIAGE RADIAL ADJUSTMENT: WITH HEAD LOWERED ADJUST ENTIRE CUTTERHEAD SUSPENSION BACKWARDS OR FORWARDS BY LOOSENING HEX NUT ON SIDE UNTIL STYLUS FRONT IS IN LINE WITH VERTICLE RETICULE OF CHIP 'SCOPE. (this adjustment ensures you are cutting in a straight line directly across to the center of the disk)

C--HOLDBACK SPRING TENSION WITH ELECTRICAL LOAD CONNECTED: RECONNECT CABLE BETWEEN CUTTERHEAD SUSPENSION AND LATHE ELECTRONICS. (FACEPLATE WILL NOW MOVE FORWARD). NOW READJUST HOLDBACK SPRING FOR CORRECT ADJUST--FACEPLATE SHOULD AGAIN BE FLUSH WITH FRONT OF SUSPENSION. (This adjustment compensates for the electrical load. NOTE: The VMS-80 lathe uses electrical control of depth only-not spring controlled as with earlier lathes)

****MAKE SURE
NO DEPTH IS
DIALED IN**

D--CUTTERHEAD SUSPENSION HEIGHT: WHILE CUTTING WITH LACQUER ON-DIAL IN 1.6 mils DEPTH AND 0.4 mils LAND (THUMBWHEELS @ 0) ADJUST HEIGHT BY TURNING KNURLED KNOB AT TOP UNTIL STYLUS FRONT AGAIN IS IN LINE WITH VERTICLE RETICULE.

E--ELECTRICAL DEPTH FINE TUNE: OBSERVE CUT UNDER 'SCOPE AND USE THUMBWHEELS TO ACHIEVE CORRECT DEPTH FOR ∇ 1.6 mils AND 6.0 mils \blacktriangledown .