

Length Variations

The following steps will need to be taken when experiencing varying lengths on the KO40S.

- Check your roller and wire straightener tensions. Make sure the wire straighteners are not too tight. If you have checked these two tensions, and they are alright, then move to the next step.
- Inspect the drive wheels, encoder wheel and encoder tension wheel for wear or a build up of oil or dirt. Clean or replace as necessary.
- Remove all tension on the wire before it enters the Komax machine.

Length Variations

- Decrease the settings for wire feed and acceleration.
- If none of these suggestions correct the problem, the cause could be the calibration of the "Grossenbacher" motor controller and the "A" board are no longer valid. If you have access to a second KO40S machine, try swapping the "Grossenbacher" and "A" board together as a set from the other machine. The "Grossenbacher" is located in the control console behind the front panel in the bottom left corner. The "A" board is located in the back of the console behind the flip panel, next to the "I/O" cards. If the problem is corrected by replacing these two items, they can be sent back to Komax for calibration.