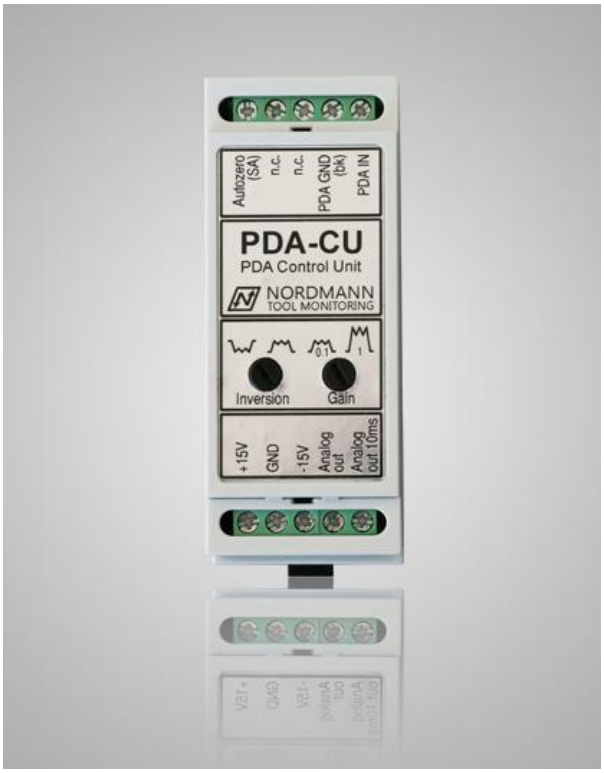
NORDMANN
METAL CUTTING MONITORING

PDA-CU Sensor Adjustment Module



Technical Data:

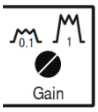
Supply voltage:	+/- 15 V / 3 mA
Temperature range:	+5 °C to +70 °C
Connection cable (to the tool monitor):	4 x 0.25 mm² + shield (e.g. LiYCY) (Not included in scope of delivery, Length: max. 100 m)

PDA-CU housing:

Material:	Makrolon 8020 UL94V-1
Weight:	60 g
Protection type	IP40 (terminals IP20 BGV A3)
Dimensions (Width x Height x Depth):	35 x 89,6 x 31,25 mm
	For installation in the electric cabinet either using 2 M4 screws or on TS 35 standard rail (according to DIN EN 60715)

- **Standard housing for rail installation**
- **Automatic zero point alignment via external 24 V control signal**
- **Measured value rectification (optional)**

Settings:



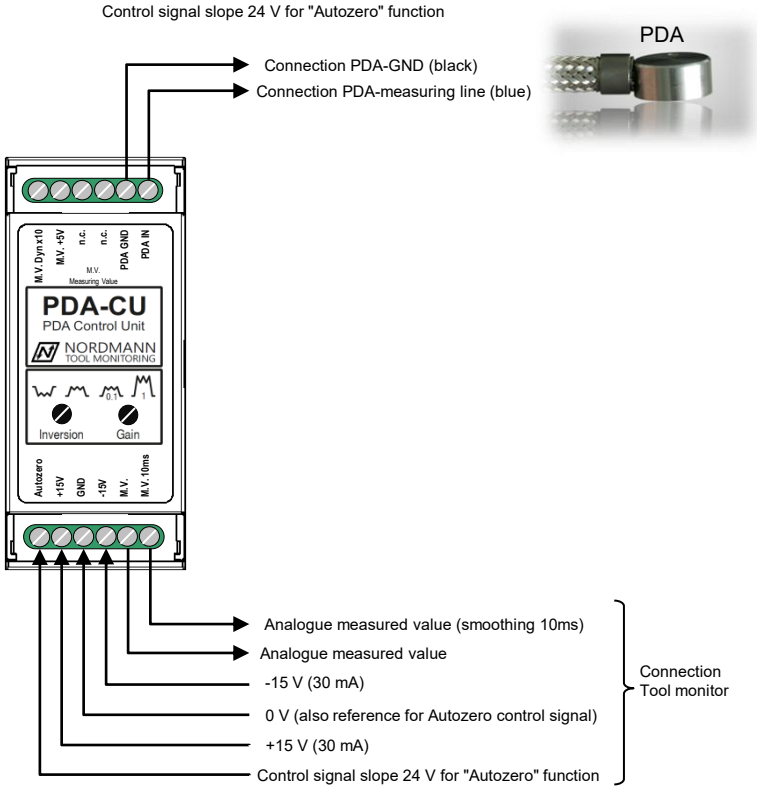
Adjusting the measurement amplification

If the measured values are too high even at amplification 1, they can be reduced by the factor of 10 (gain at 0.1)

Defining the measurement direction

If the measurement curve is "on its head", it can be inverted using the "Inversion" switch.

Pin assignment:

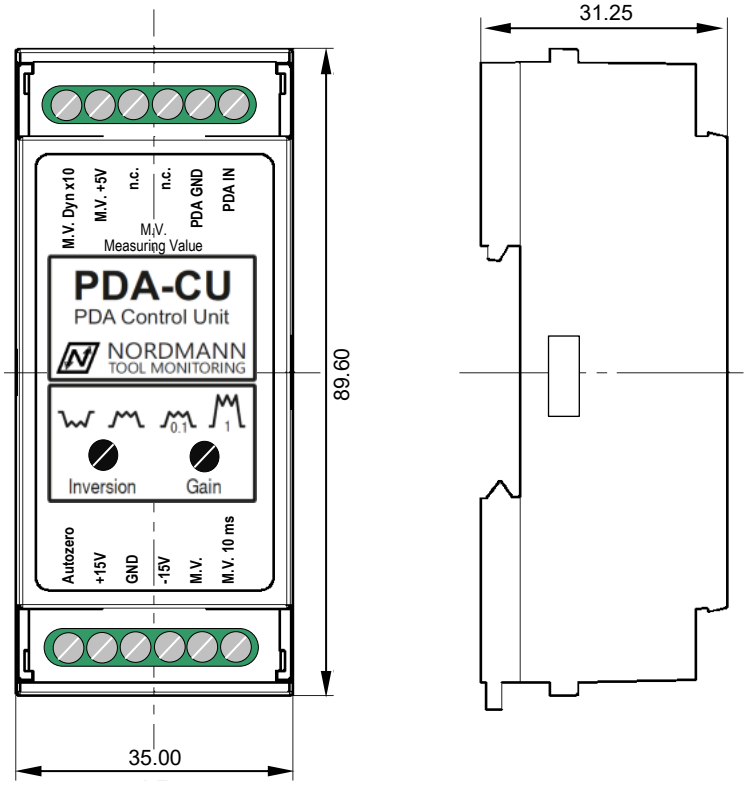


Automatic zero point alignment:

With an external 24 V control signal at terminal "**Autozero**", the measured value returned for a rising slop of this signal is set to zero. The "cut active" signal SA, which also triggers monitoring at the tool monitor, can be used as a control signal.

This zero point alignment must be performed **before every measurement**. This eliminates any mechanical and temperature-dependent zero-point drifts before each measurement.

Dimensions:



Order designation:

8.3.9	PDA-CU