

To receive payment for a Training and Setup, you must have received a written P.O. from Centroid Technical Support. In addition, documentation must be submitted to Centroid verifying that each procedure in the tables below has been performed. This documentation is to include the control report files and a written trip report.

The written trip report must contain:

- 1.) Centroid Purchase Order number
- 2.) A checklist confirming each task has been completed as required.
- 3.) Recorded values for all required measurements.
- 4.) A brief report with details of the training including:
 - a.) Customer name, address and phone number.
 - b.) Date of Training and Setup.
 - c.) Control serial number.
 - d.) Description of the machine and its mechanical condition.
 - e.) Type of parts that they will making on the machine and expected tolerances.

Payment will be made only when all required tasks have been completed and the written and control reports have been received.

Setup and Training Requirements

#	Installation, Configuration and Operational Checkout	Est. Time
1	Console – Cables routed correctly, CPU10, encoder connections well seated etc...	:20
2	Electrical cabinet – Check electrical connections and wiring routed correctly	:20
3	Motors – Belts tensioned correctly, confirm splash guards installed where needed	:10
4	Cabling – No pinch points or excessive strain, signal wires separate from power	:10
5	Supply Voltages - Check and record supply voltages	:05
6	Run report, update control and run drag plots and autotune	:20
7	Accessory Checkout – Verify TT-1, DP4 and MPG work correctly	:20
8	Check / Set / Record pitch and backlash - Prog. Dist. = Actual +- .0005” over 18”	:45
9	Check / Record machine level and head tram	:20
10	Successfully run system test, run report	:25
	Total Time	3:15

#	Part Programming, Part Setup, Control and Machine Operation Training	Est. Time
1	Review Jog and Control panel functions	:15
2	Review menu system navigation	:15
3	Review Report generation, Update, File Ops and Power off sequence	:15
4	Intercon	1:30
5	Tool setup- Both auto w/TT1 and manual methods	:20
6	Part setup- Both auto w/DP4 & CSR and manual methods	:20
7	Cut part- While cutting explain common issues that effect “positioning/accuracy”	1:00
	Total Time	3:55