

## Setting Delta VE with different ratio motor pulley and spindle pulley

Some customer wants to upgrade spindle with more power, they change the pulley of motor smaller (32 tooth). A Trump's machine, ratio of motor pulley and spindle pulley is 1:1 (pulley: 48 tooth).

Changing pulley of motor is 32 tooth, and pulley of spindle is 48 tooth so ratio 1:1.5, and spindle maxima RPM is 4000 ( $6000/1.5=4000$ ).

Centroid control: F1 [set up] → F3 [config] → 137 enter → F1 [control] change maxima high gear RPM is 4000. → F10 [save].

Delta inverter VE

Set parameter 10-27 to 32 (pulley of motor 32T).  
10-28 to 48 (pulley of spindle 48T).

After that, doing Auto turn and set spindle orientation. **If the spindle encoder mounts on the spindle motor, you could not do the spindle orientation.** You have to move spindle encoder to the spindle with the pulley 1 to 1.