

FSNR 910 of 9.11.78/FI

Basic alignment necessary for operation of VMS 80 for production:

1. Drop cutterhead outside turntable diameter.
 2. BASIC DEPTH knob fully counter clockwise.
 3. Both thumb controls DEPTH ADJUST in mid position.
 4. Adjust cutterhead suspension knurled knob for spring until front tiltable face of suspension is flush.
 5. Adjust chip tube in this position so that it is 1 mm behind stylus and 0.3 mm higher than stylus tip.
 6. DO NOT change SA spring tension after this.
 7. Depth of cut on VMS 80 is only handled electrically!
 8. Set vacuum for at least 80 mb.
 9. Mechanically release cutter drop lever and turn suspension up in height.
 10. Advance carriage until cutter is above lacquer.
 11. Set required stylus heat. Set INCREASED HEAT fully counter clockwise.
 12. Set BASIC DEPTH to indicate 1.6 mil on meter; set land to 0.4 mil.
 13. Lower cutterhead. Watch through chip scope and turn down vertical position of suspension until stylus starts cutting and tiltable face is again flush. (It may be necessary to raise and lower cutter to catch chip.)
 14. With left hand DEPTH ADJUST thumb control set 1.6 mil depth as seen in the scope.
 15. Advance BASIC DEPTH control to the 6 mil mark. Adjust right hand DEPTH ADJUST thumb control to cut 6 mils.
- A. Set all controls on the new SK-A to zero. Push START button.
- B. Leave cutterhead up! 1.6 mil depth and 0.4 mil land equals exactly 2 mil pitch.
- C. Inject 100 Hz at +10 dBm into LEFT PREVIEW channel. Pitch should go to 6 mils.
- D. Using trim pot PREVIEW LEFT (or RIGHT) on print VSA set to 6 mils.

A test tape is under way which has two impulse series on it and a photo. This test tape is to be played to disk and examined for overcuts. If there are some, reverse phase between preview and modulation using the switch shown in the photo on card VSA.

To correct lead screw overload problem, put carriage at extreme right; Remove the two Allen screws which hold it to the feed nut. Set the carriage by hand to the 4" diameter. Put some Tellus oil on the lead screw ahead of the feed nut. Using the manual lead screw lever, run the feed nut carefully under the carriage and retighten the two Allen screws.

On the VME card, replace the 56k resistors R 30 and R 36 between base and emitter T8 and T9, with a 39k value.

SFT
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CC: GN, Berlin

+10 peak for (H) DIN
+6 peak for (O) NAB
+12VU for 0 NAB

+10VU for DIN
+6VU for NAB

+10 dBm for +H
+6 dBm for 0
+2VU for 0

+10 dBm = +6VU = 0 peak