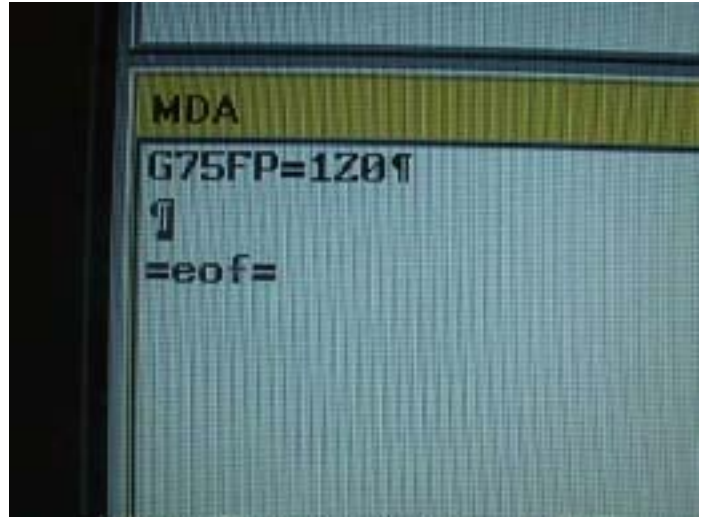


Adjuster Tool Change Position Point.

1. Select MDA Mode.



2. Key in G75 FP=1 Z0 for Z axis home position.



3. After zero return, the Motor position.

make must be same point position by Z axis. If not same must check Z Axis

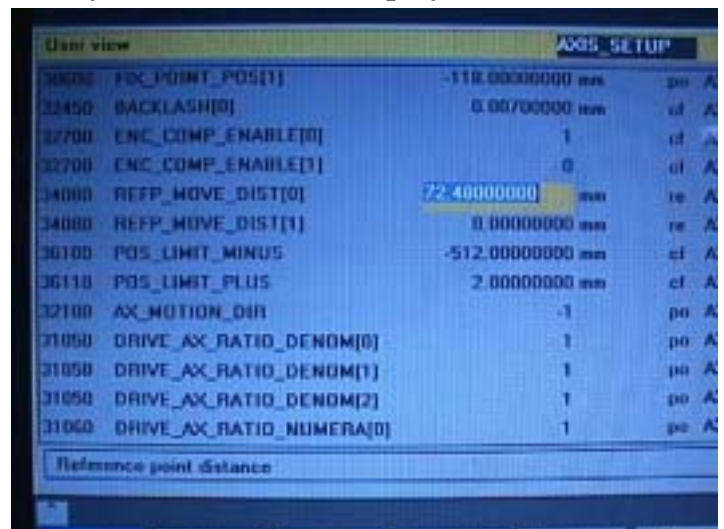


Adjuster Tool Change Position Point Procedure

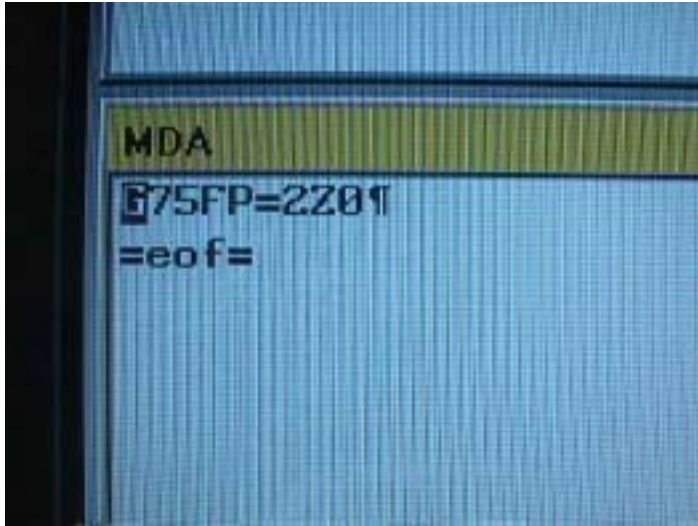
1. Install tool holder into Spindle by Manually.



2. Key in -115. to Axis setup by #30600 location



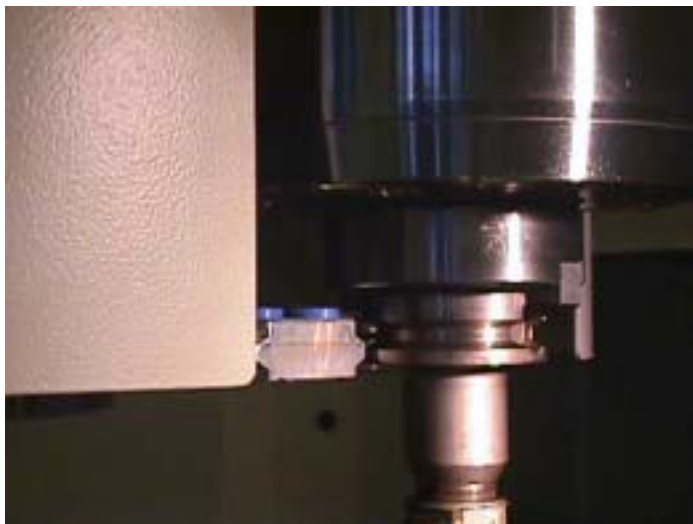
3. Key in G75 FP=2 Z0, to go tool change position by Z axis.



4. To push the Drum into Spindle side



5. Check the tool holder with Drum high and low position.



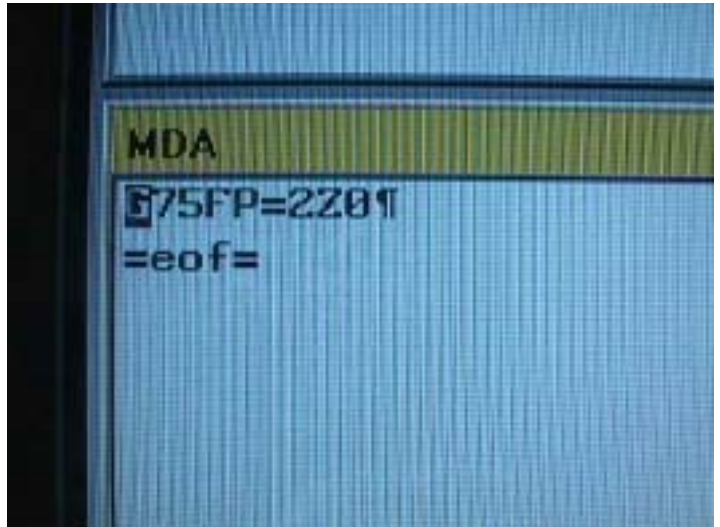
6. To push Drum go back home position



7. Key in -118. to Axis setup by #30600 location.

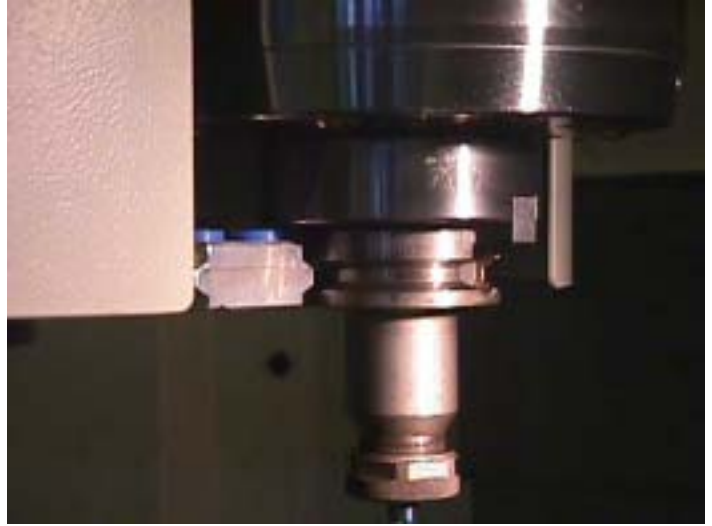


8. Key in G75 FP=2 Z0 to go tool change position by Z Axis.



9. To push the Drum into Spindle side.

10. Check the tool holder with Drum high and low position.



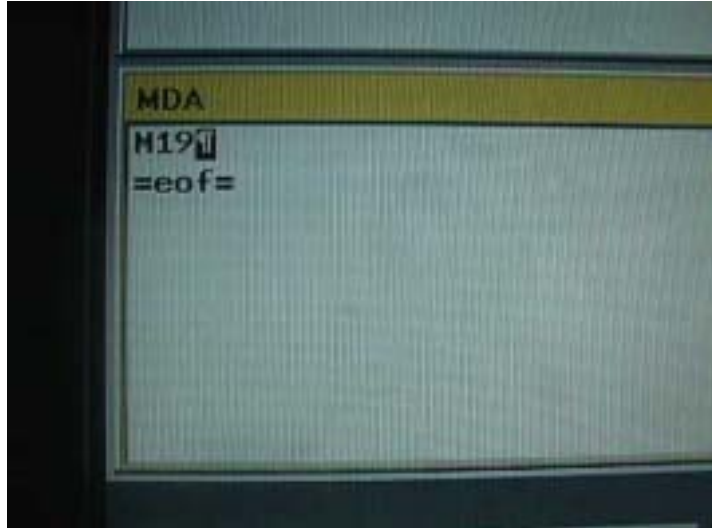
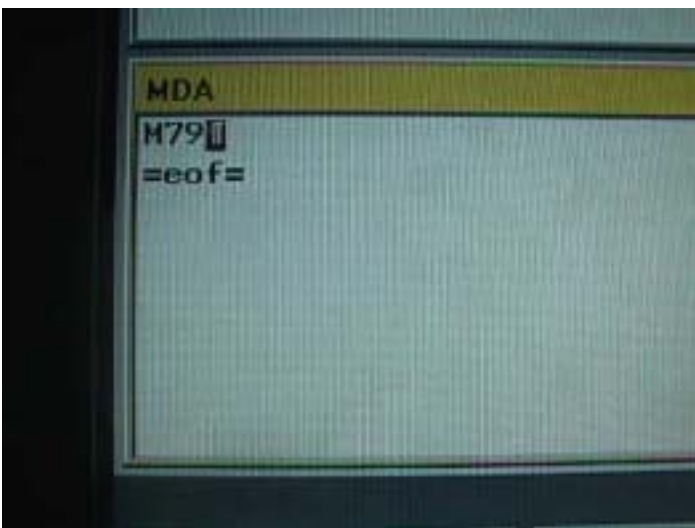
11. To push Drum go back home position

12. Take out tool from the Spindle by manual



13. Key in M79 for Drum go to tool change mode by MDA.

14. Key in M19 for spindle orientation.

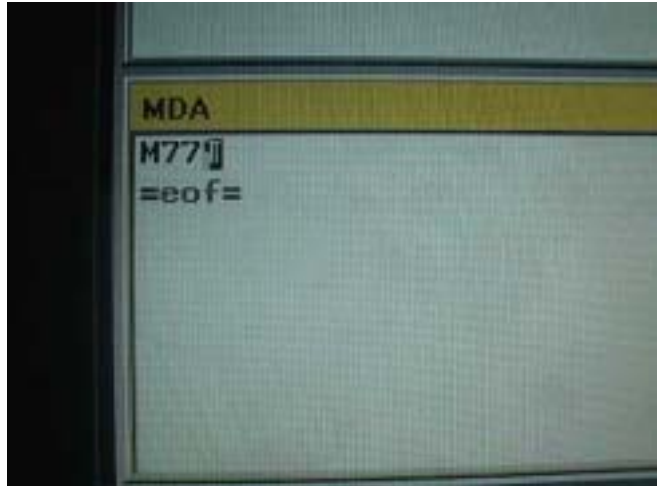
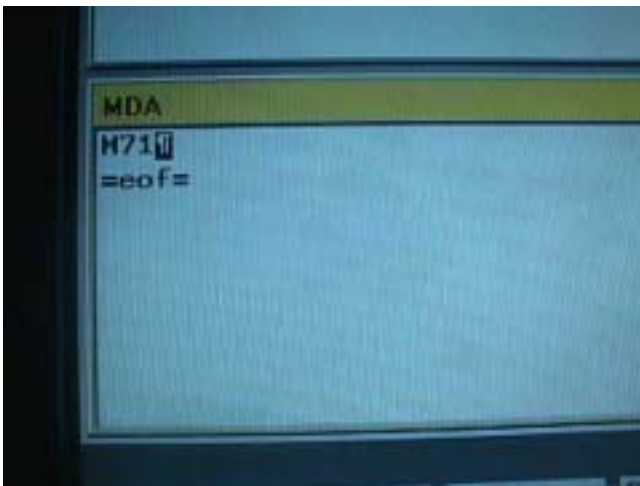


15. Key In M72 for Drum go in to tool change position side. 16. To measure below spindle to bottom Drum and make a record.



17. Key in M71 for Drum go back position

18. Key in M77 or press Reset key to cancel tool change Mode.



If push Reset key after key in M79, Then must key in M79 again for in to tool change mode

19. Select Manual mode

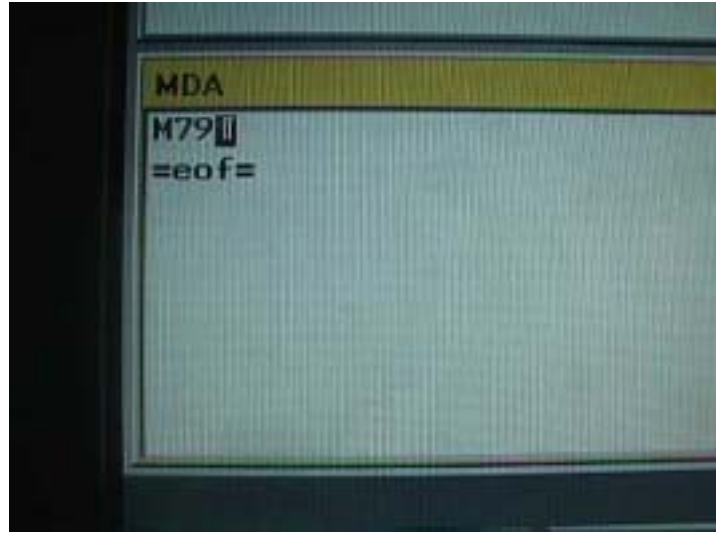
20. Install tool holder into the Spindle by manual



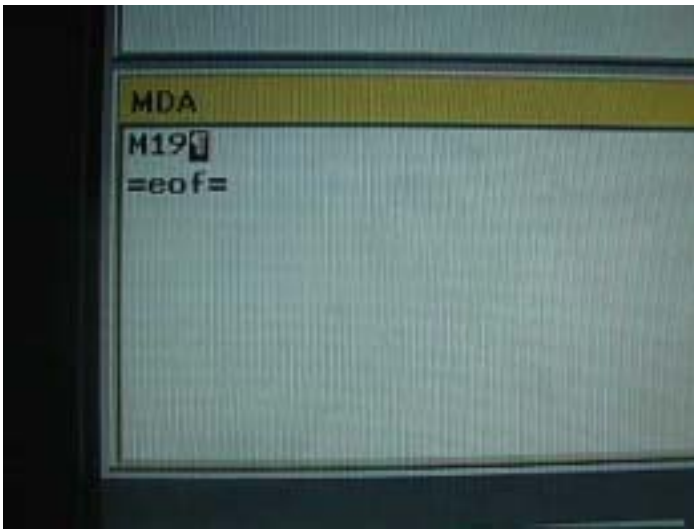
21 To select MDA mode



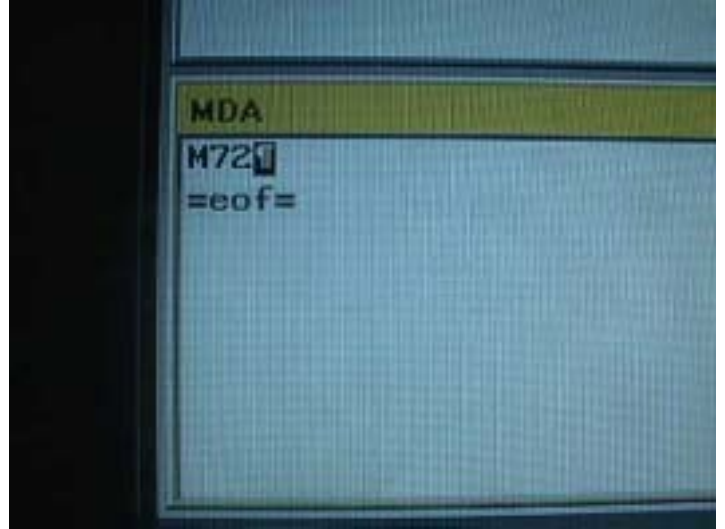
22. Key in M79 for in to tool change mode



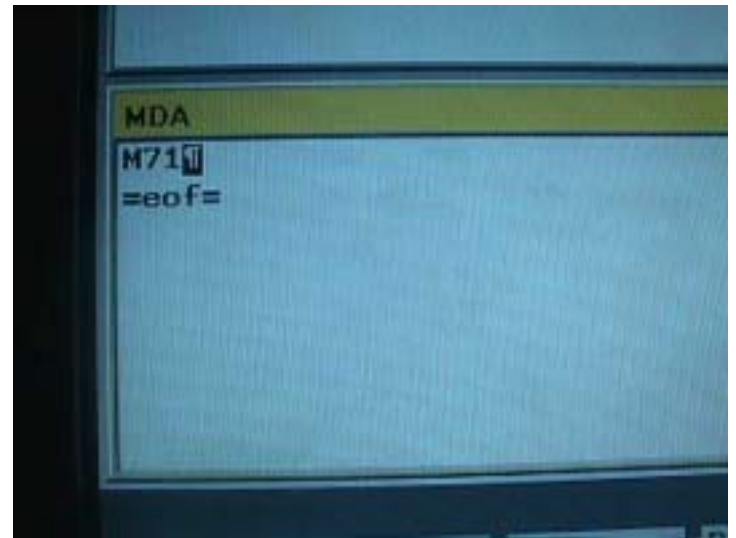
23. Key in M19 for Spindle orientation.



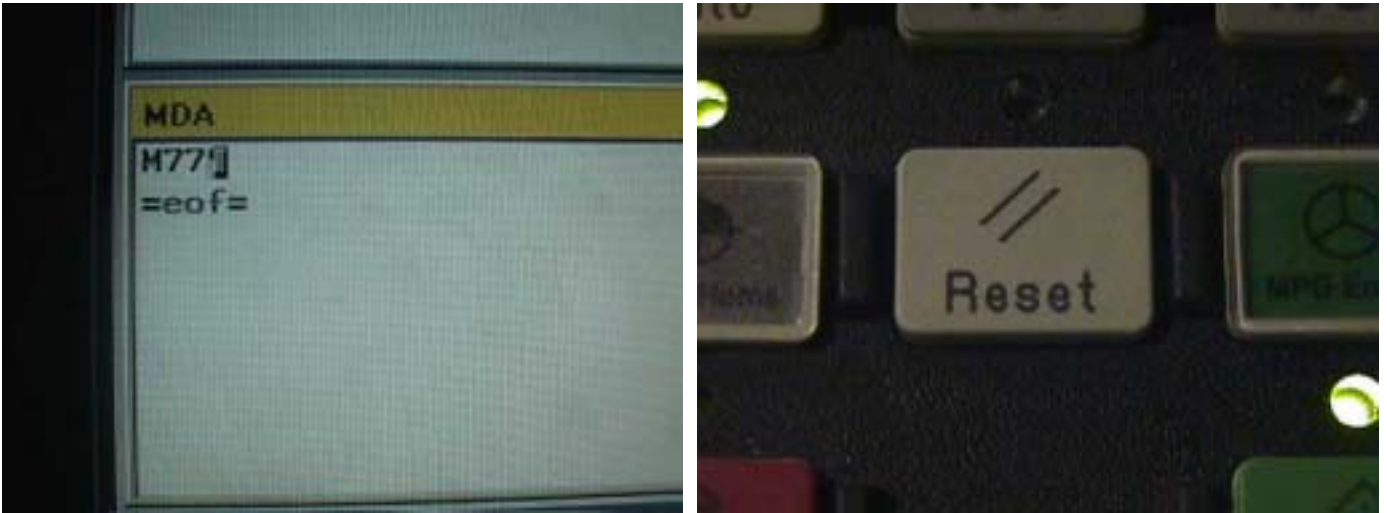
24. Key in M72 for Drum in to tool change position



25.To measure below spindle to bottom drum and make a record. 26.Key-in M71 for Drum back position



27 Key-in M77 or press Reset for cancel tool change mode.



28. The difference with tool holder and without tool holder measurements number 25 and step 16, Max. Allowance is 0.1mm, if the difference over 0.1mm, then change the parameter #30600



29. Press Reset push button for finish Procedure

