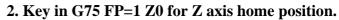
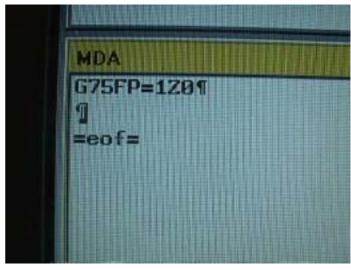
## Adjuster Tool Change Position Point.

1. Select MDA Mode.







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

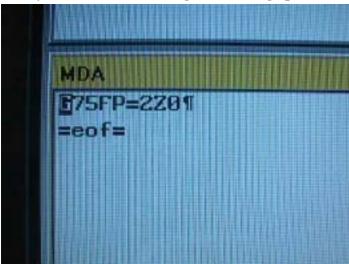
1. Install tool holder into Spindle by Manually.



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

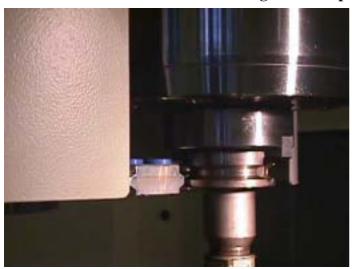
	FOC POINT POSITI	-118.00000000 mm	700	,
	BACKLASHIDI:	8.00700000 mm		þ
	ENC COMP_ENABLE[0]		of	ĕ
12700	ENC_COMP_ENABLED	0	- 60	V
3400D	REFP_MOVE_DIST[0]	72.40000000 mm	10	V
34080	REFP_MOVE_DIST[1]	0.00000000 mm	100	ì
30100	POS_LINIT_MINUS	-512.00000000 mm	el.	ì
36110	POS_LIMIT_PLUS	2.00000000 mm	et	ě
12100	AX_MUTION_DIR	4	po	ø
21050	DRIVE AX RATIO_DENOM[0]	1	po	ä
31050	DRIVE_AX_RATIO_DENUM[1]	1	100	Ų
31050	DRIVE_AX_RATIO_DENOM[2]		po	Ŗ
31060	DRIVE_AX_RATIO_NUMERA[0]		pe	7
Refer	unce point distance			

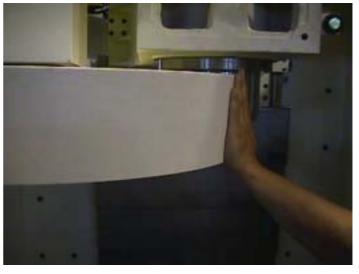
3. Key in G75 FP=2 Z0, to go tool change position by Z axis. 4.To push the Drum into Spindle side





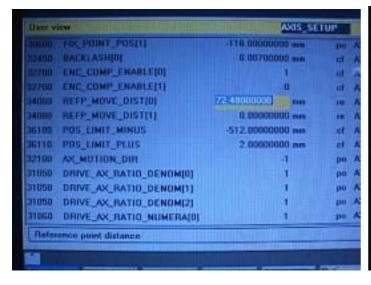
5. Check the tool holder with Drum high and low position. 6. To push Drum go back home position

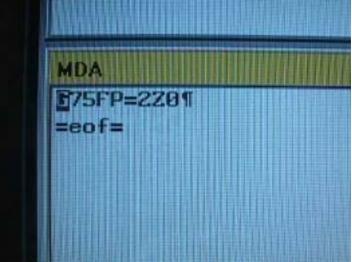




7. Key in -118. to Axis setup by #30600 location.

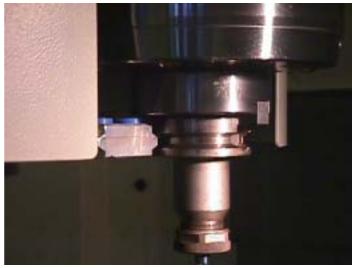
8.Key in G75 FP=2 Z0 to go tool change position by Z Axis.





9. To push the Drum into Spindle side. 10. Check the tool holder with Drum high and low position.





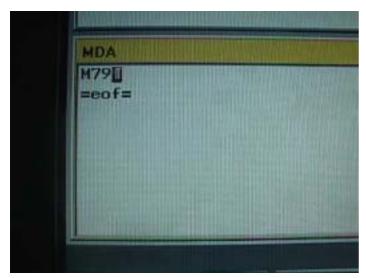
11. To push Drum go back home position

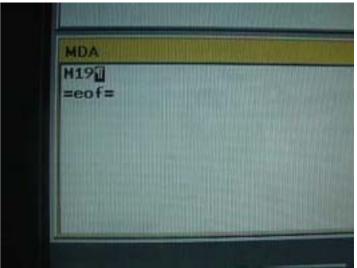


12. Take out tool from the Spindle by manual

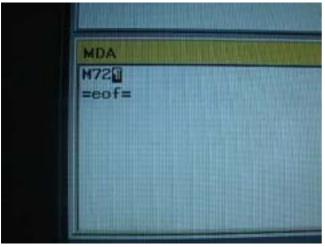


13. Key in M79 for Drum go to tool change mode by MDA. 14. Key in M19 for spindle orientation.





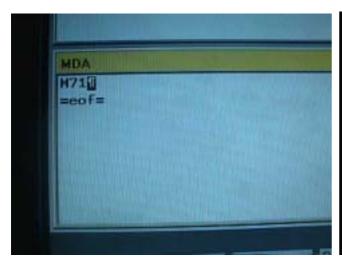
15.Key In M72 for Drum go in to tool change position side. 16.To measure below spindle to bottom Drum and make a record.

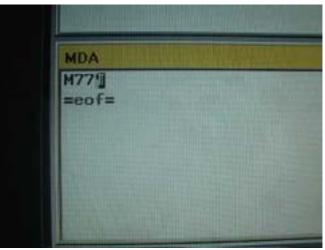




17. Key in M71 for Drum go back position

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

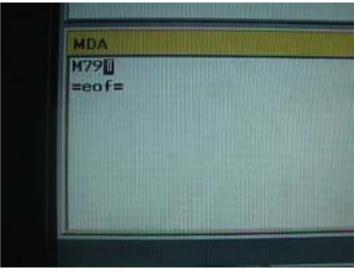




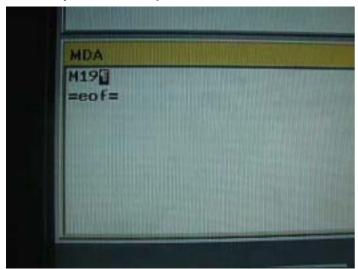
## 21 To select MDA mode



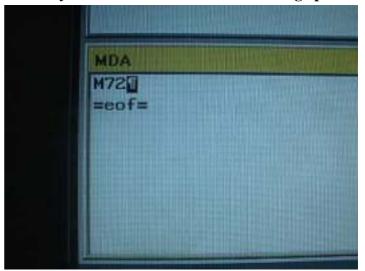
22. Key in M79 for in to tool change mode



23. Key in M19 for Spindle orientation.

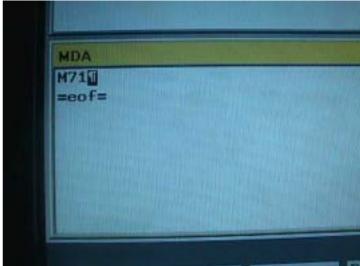


24. Key in M72 for Drum in to tool change position

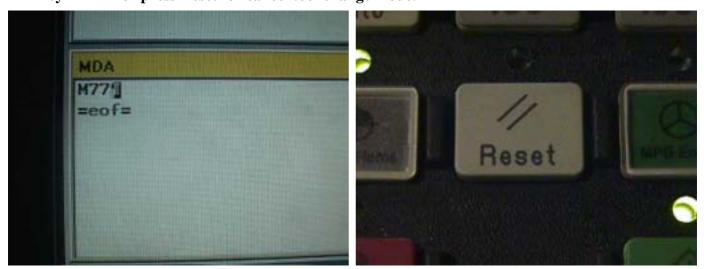


25.To measure below spindle to bottom drum and make a record. 26.Key-in M71 for Drum back position

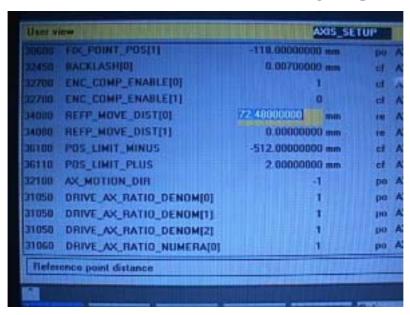




27 Key-in M77 or press Reset for cancel tool change mode.



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

