## **To Replacement Drum Procedure For Siemens Control**

1. Take out cover below Drum.

2. Take loose 6 screws, And take down the Drum.



3. The 6 screws don't do to tight after assembly new Drum. 4. Select MDA mode.



5. Key in G75 FP=1 Z0 for Z home position by MDA. 6. The arrow sign for Z axis home position.



7. Key in M19 for spindle orientation by MDA.



9. Take out left keyway of spindle.



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

5FP=2201

MDA

=eof=

1

10. Take out keyway of U form by Drum.



8. Press RESET key for cancel spindle orientation.



12. Key in M79 for tool change mode by MDA.

13. Key in M19 for spindle orientation by MDA mode. 14. Key in M72 for Drum go in to tool change



**15.** The Drum go in to tool change position.





16. Adjust Drum with Spindle keyway on same position.



18. Key M77 for cancel M79 mode or press Reset.



position.

## 19. Select Manual mode.

- 20. Take out tool by manual from spindle side.
- 21. Select MDA mode.



23. Key M19 for spindle orientation.

22. Key in M79 for go in to tool change mode.





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



25.To make 6 screws tight after Drum at change position. 26. Key in M71 for Drum go back stand by position.



27. Key M72 for Drum go in to tool change position.



29. To measurement under Drum to spindle nose. 30. Key in M71 for Drum go back stand by position.



31. Key in M77 for cancel M79 or press Reset.



**33.** To take out tool from spindle side.



35. Key in M79 for go in to tool change mode.



32. Select manual mode.



34. Select MDA mode.



**36.** Key M19 for spindle orientation.



**37.** Key in M72 for Drum go in to tool change position and to measurement under Drum to spindle

nose.



38. If data outstrip 0.1mm by number 29 and 37, Must change from parameter 30600.

User view AXIS_SETUP				
30600	FIX_POINT_POS[1]	-118.00000000 mm	po	-
32450	BACKLASH[0]	0.00700000 mm	cl	^
32700	ENC_COMP_ENABLE[0]	1	cl	1
32700	ENC_COMP_ENABLE[1]	0	cf	1
34080	REFP_MOVE_DIST[0]	72.48000000 mm	re	4
34080	REFP_MOVE_DIST[1]	0.00000000 mm	re	^
36100	POS_LIMIT_MINUS	-512.00000000 mm	cf	
36110	POS_LIMIT_PLUS	2.00000000 mm	cf	A
32100	AX_MOTION_DIR	-1	po	4
31050	DRIVE_AX_BATIO_DENOM[0]	1	po	A
31050	DRIVE_AX_RATIO_DENOM[1]	1	ро	A
31050	DRIVE_AX_RATIO_DENOM[2]	1	ро	A
31060	DRIVE_AX_RATIO_NUMERA[0]	1	ро	A
Refer	ence point distance			
Dennennen er Vicene				
Contraction of the second				

**39.** Back to assembly the drum and spindle keyway after adjustment procedure.



40. Press RESET key to finish adjustment procedure.

