

To Replacement Drum Procedure For Siemens Control.

1. Take out cover below Drum.



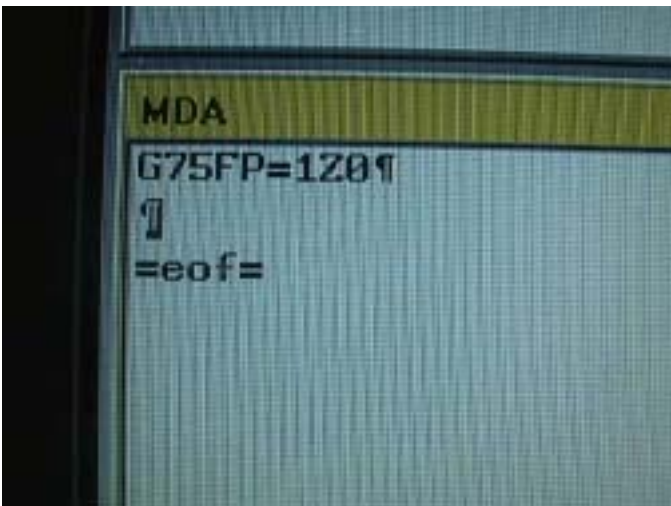
2. Take loose 6 screws, And take down the Drum.



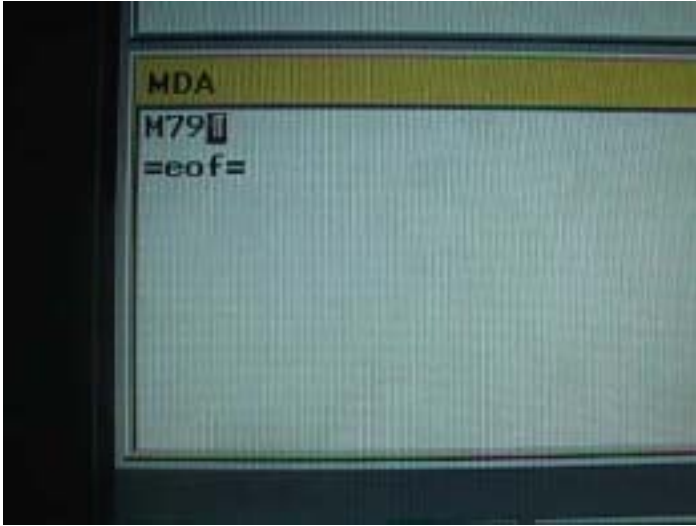
3. The 6 screws don't do to tight after assembly new Drum. 4. Select MDA mode.



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.



8. Press RESET key for cancel spindle orientation.



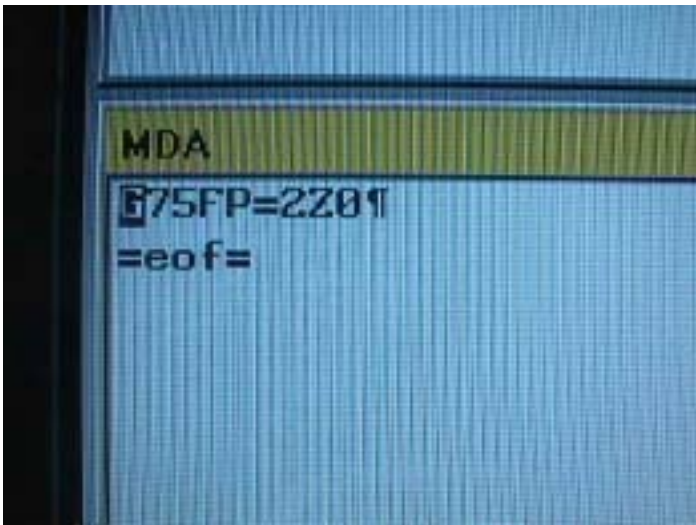
9. Take out left keyway of spindle.



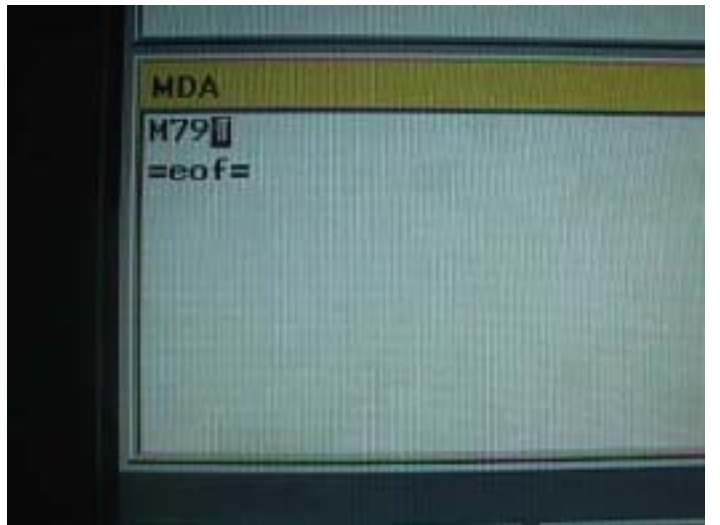
10. Take out keyway of U form by Drum.



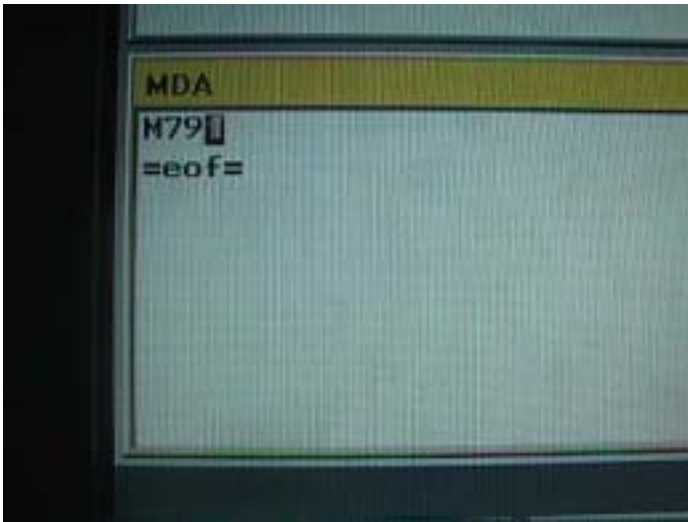
11. Key in G75 FP=2 Z0 for Z axis home position.



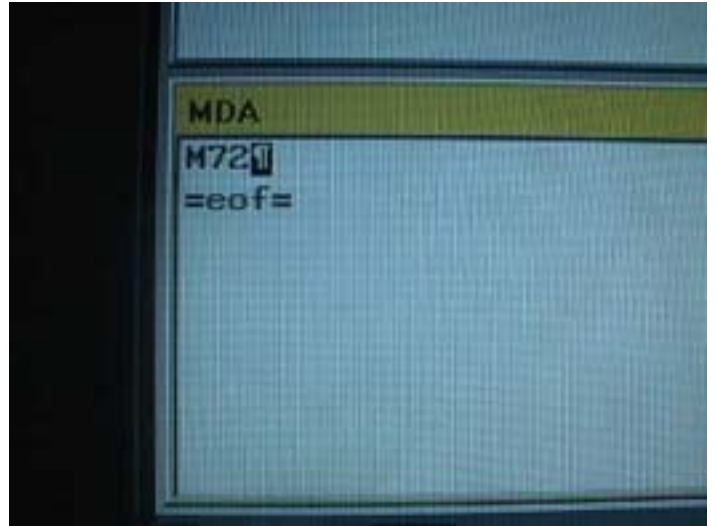
12. Key in M79 for tool change mode by MDA.



13. Key in M19 for spindle orientation by MDA mode.



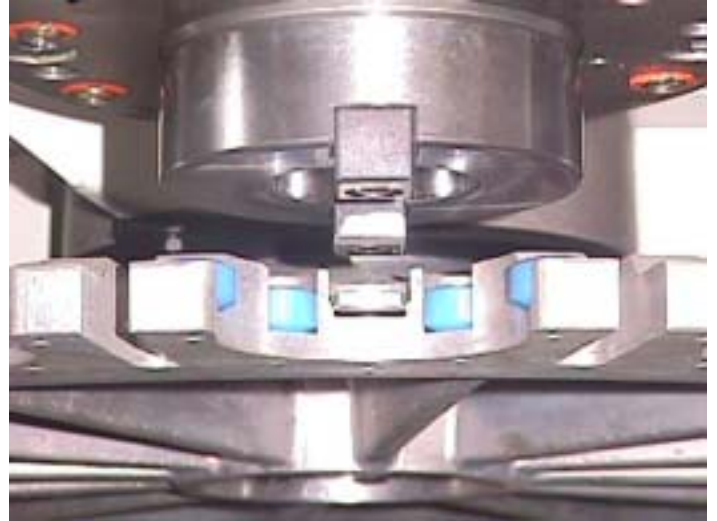
14. Key in M72 for Drum go in to tool change position.



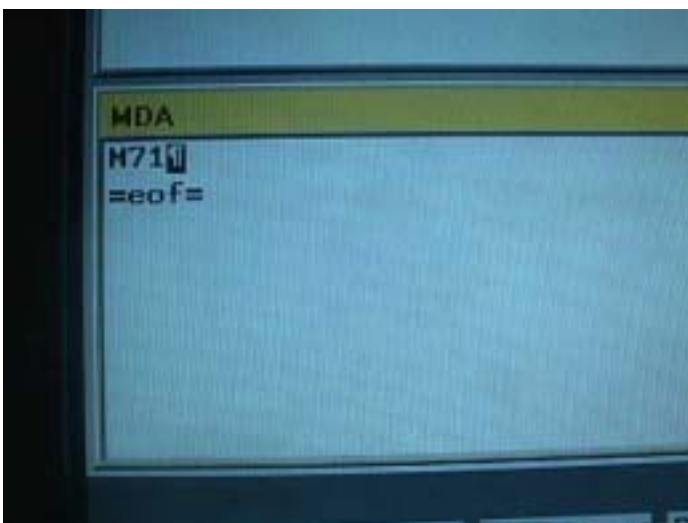
15. The Drum go in to tool change position.



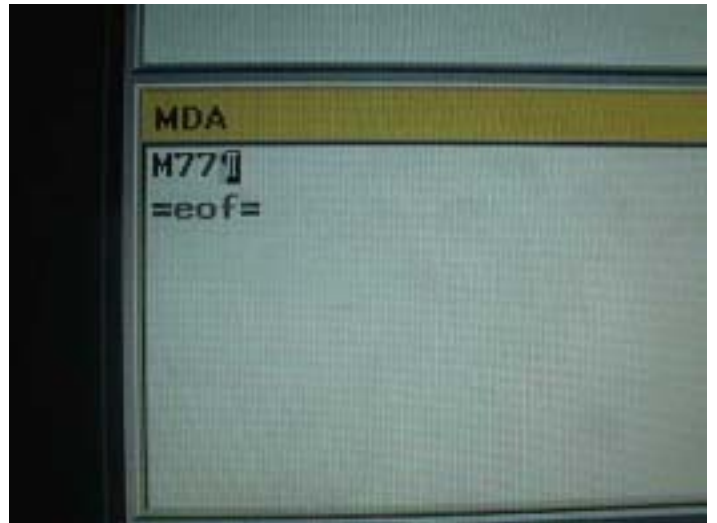
16. Adjust Drum with Spindle keyway on same position.



17. Key M71 for Drum go back stand by.



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



19. Select Manual mode.



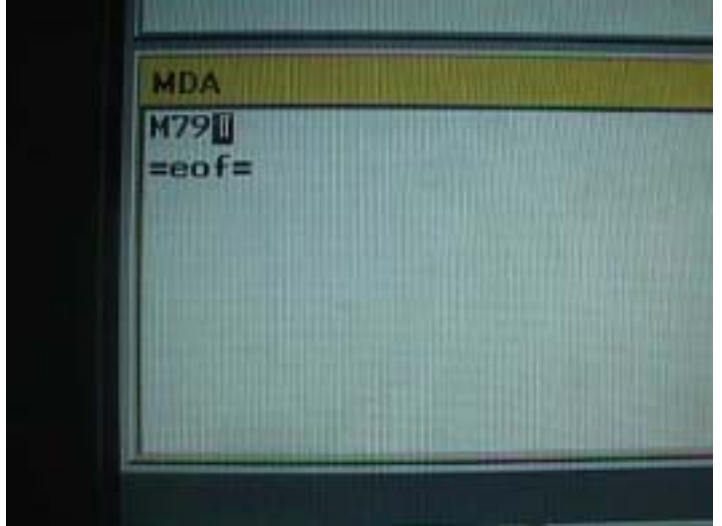
20. Take out tool by manual from spindle side.



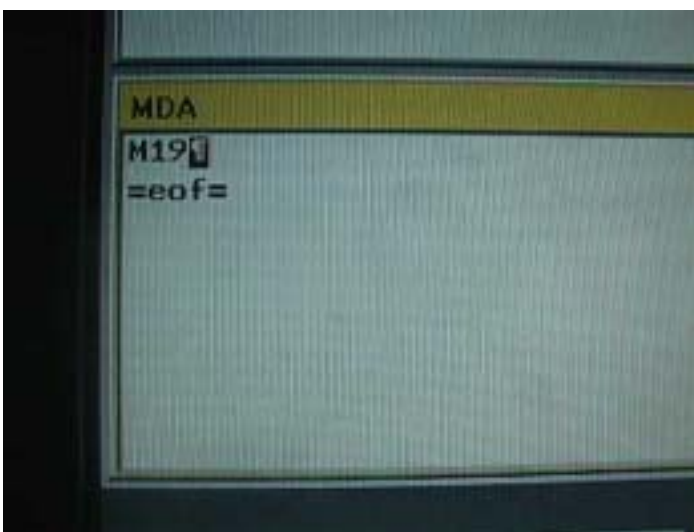
21. Select MDA mode.



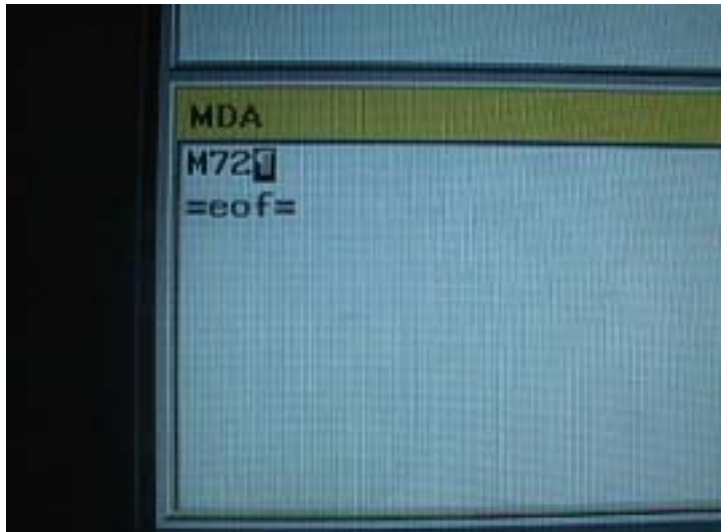
22. Key in M79 for go in to tool change mode.



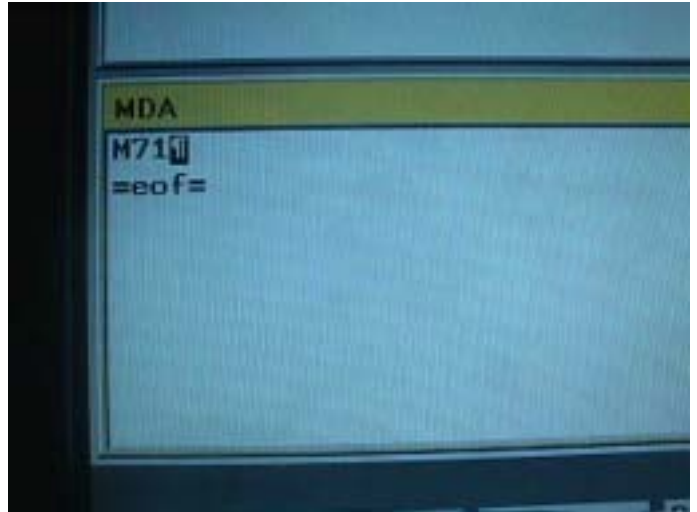
23. Key M19 for spindle orientation.



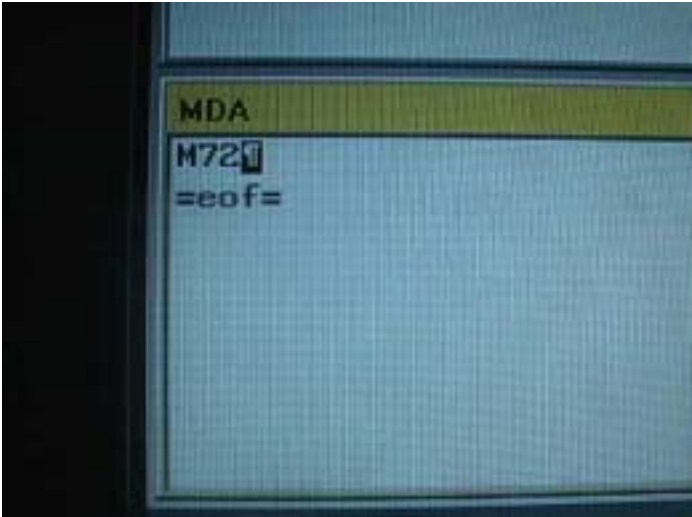
24. Key in M72 for Drum go in to tool change position.



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.



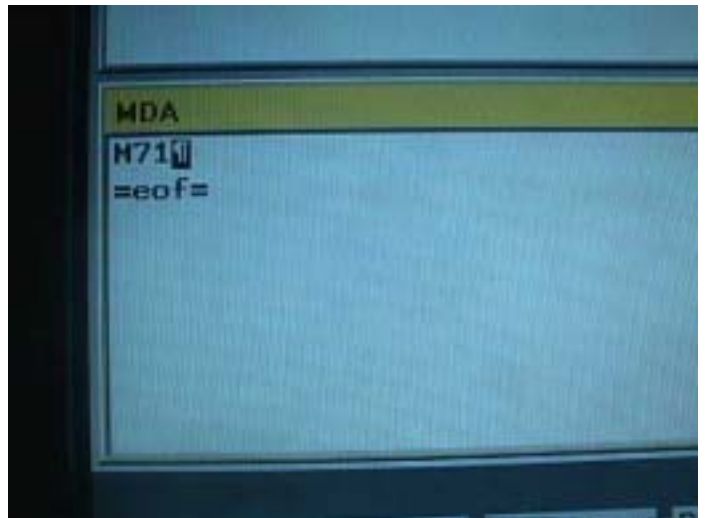
28. To make tight screws by torque wrench 35/Nm.



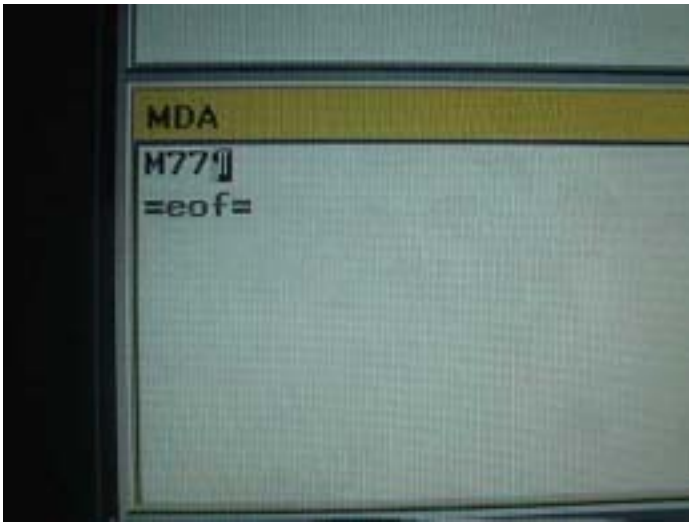
29. To measurement under Drum to spindle nose.



30. Key in M71 for Drum go back stand by position.



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



32. Select manual mode.



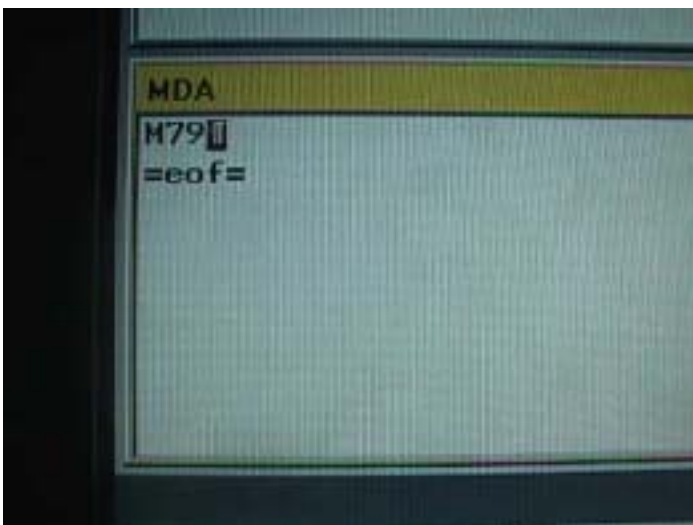
33. To take out tool from spindle side.



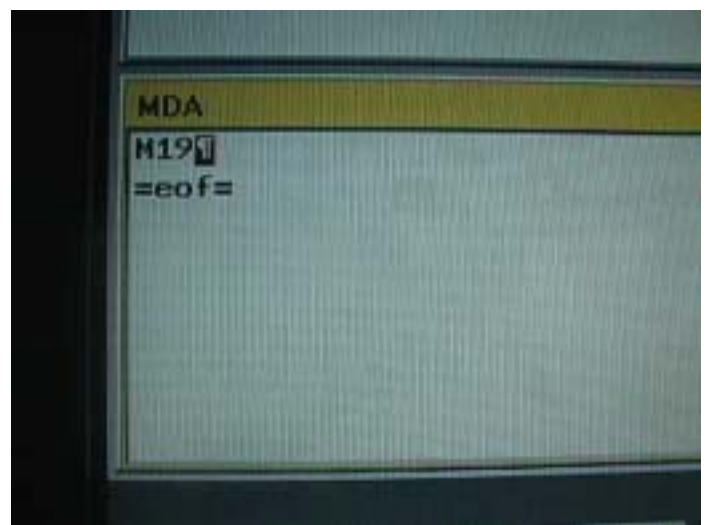
34. Select MDA mode.



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



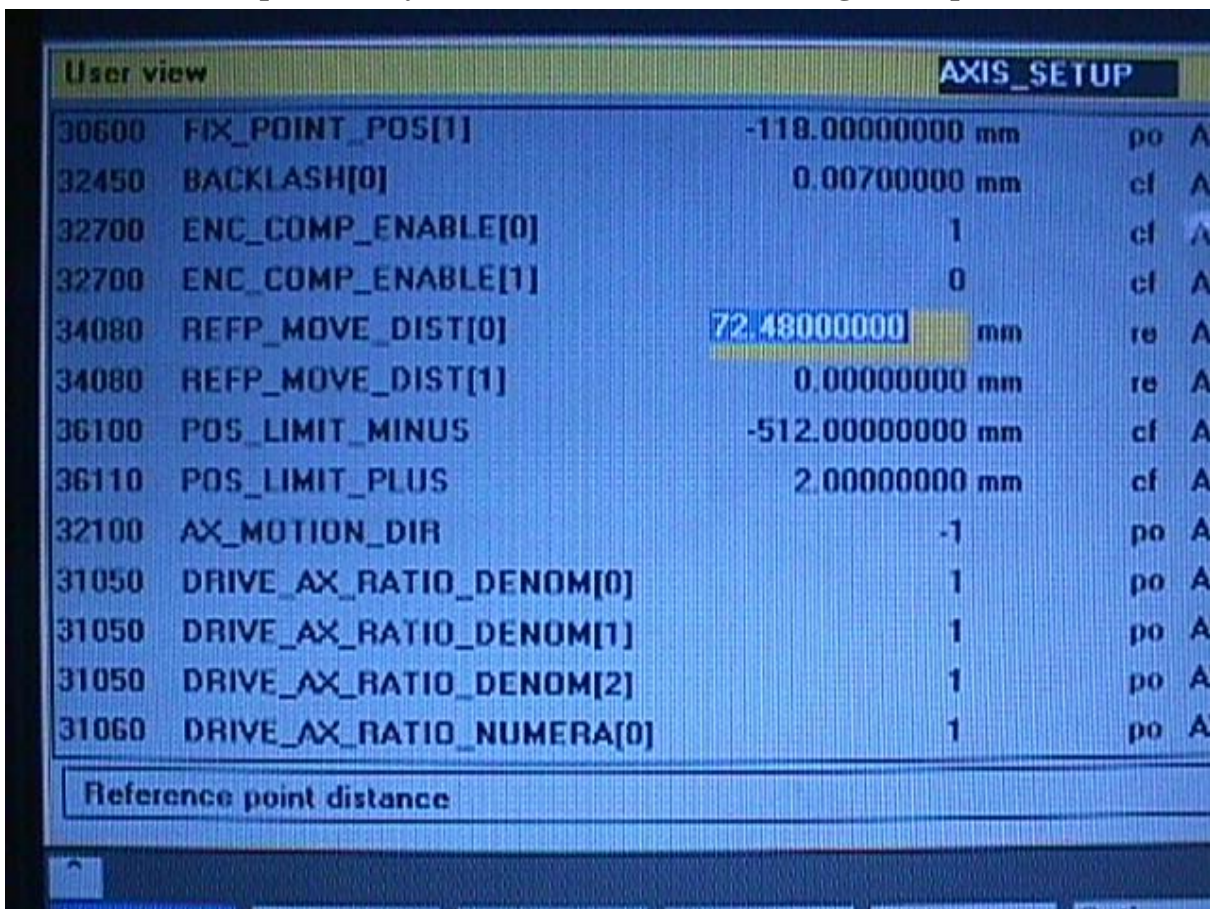
36. Key M19 for spindle orientation.



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.



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



40. Press RESET key to finish adjustment procedure.

