

## Measurement To Tool Jam Of Drum Type

1. Auto tool change stop when tool changing to press reset push button, Press ATC Cycles button Again For finish Tool change cycle.



2. Auto tool change stop when tool changing to press EM push button, Press ATC Cycles button Again For finish tool Change cycles.



3. Auto tool change stop when tool changing power shut down , The ATC Cycle light could instruct flash, Must Be carry out steps below.



3-1. Select MDA mode.



3-2. Press SBL button.



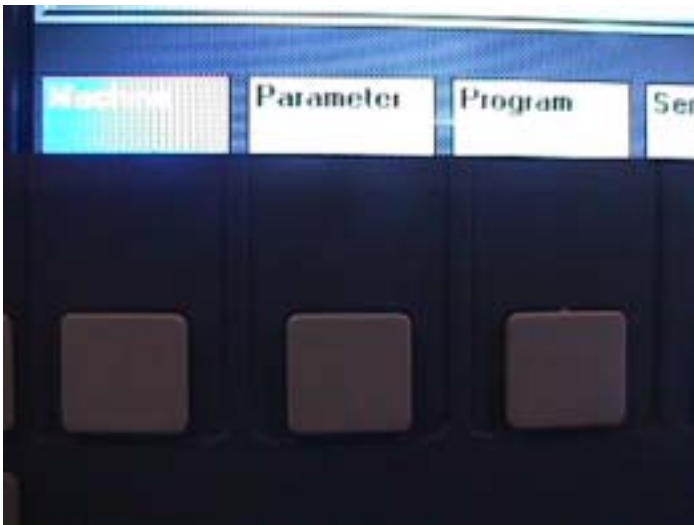
3-3. Press menu select key.



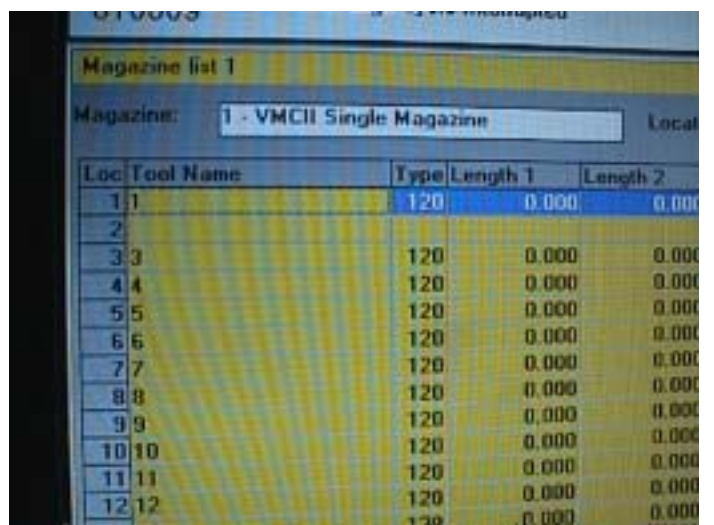
3-4 Show this page on Monitor.



3-4 Press parameter key.



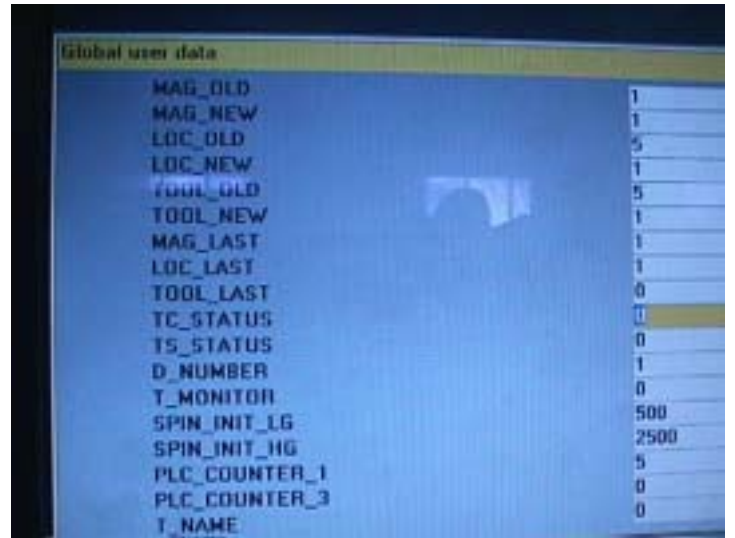
3-5. Show Magazine list 1 on Monitor.



3-6. Press User data key



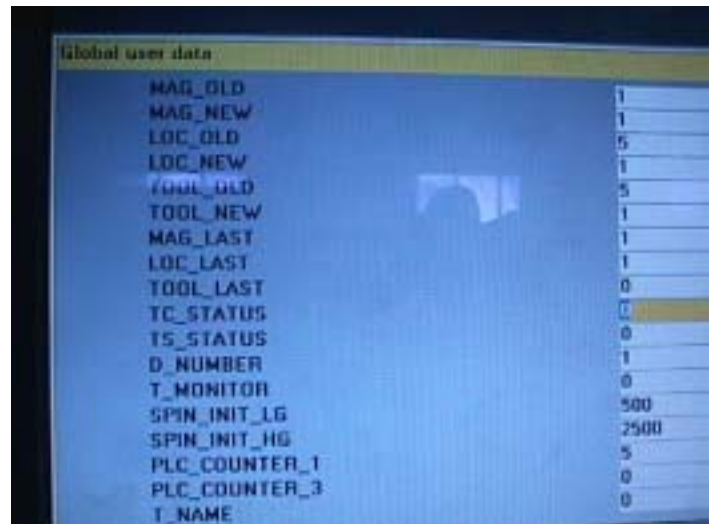
3-7. Show Global user Data on monitor.



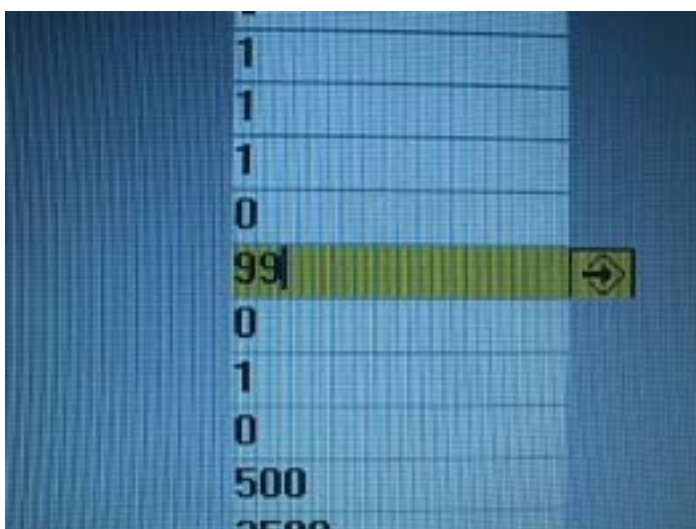
3-8. Press select down or up key.



3-9. To Choose T.C-Status location .



3-10. Key in 99



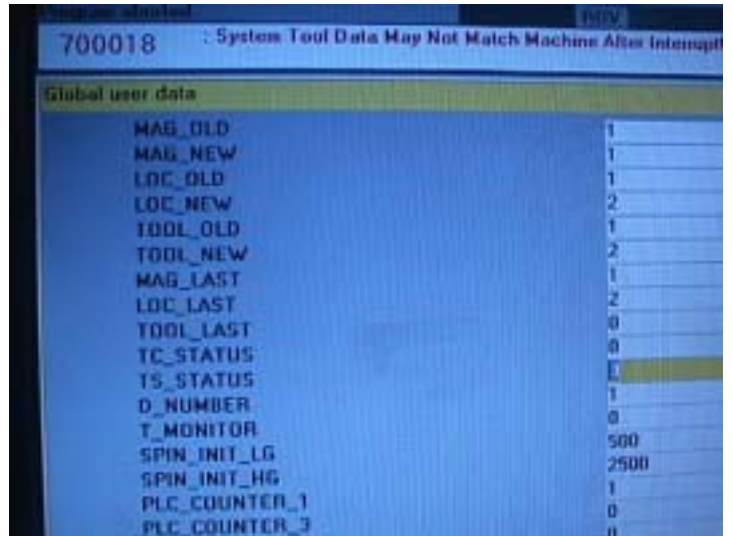
3-11. And press input key.



3-12. Press ATC cycles button.



3-13. Show this Global user Data On monitor.



3-14. Press reset button



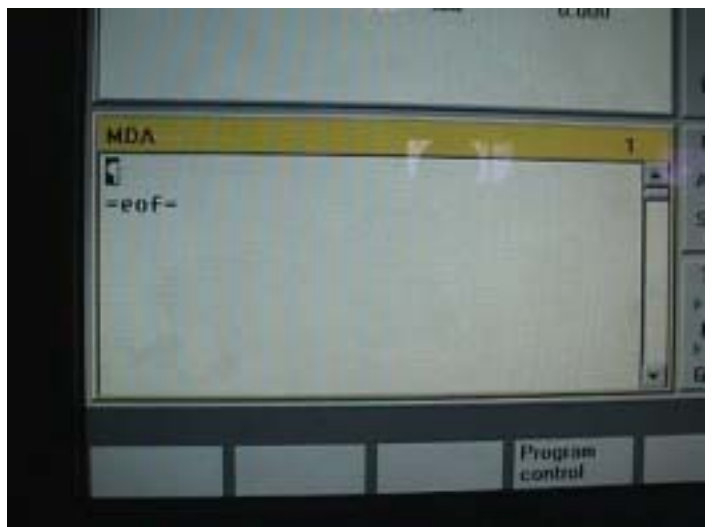
3-15. The ATC cycles instruct Light could stop flash.



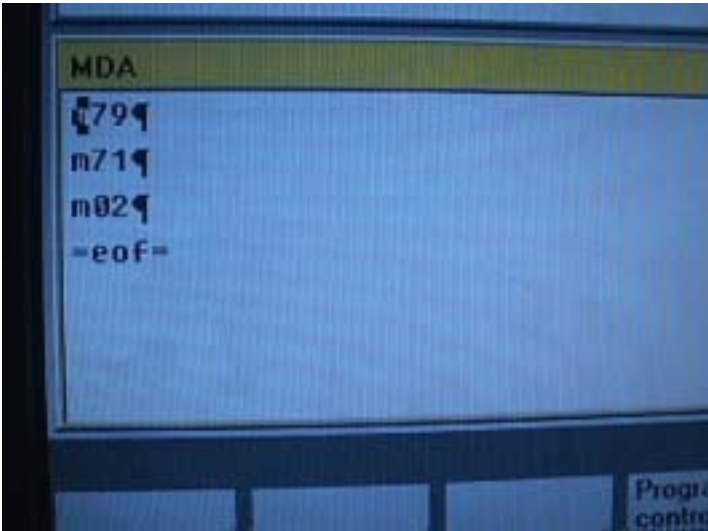
3-16. Press M machine button.



3-17. Show M.D.A page on Monitor.



3-18. Key in M79 For into MDA mode and key in M71 command



3-19. Press cycles button for Drum back Position.



3-20. Press MDA delete key.



3-21 Tool change program explain

3-21-1 M79 Command MDA mode

3-21-2 M71 Drum go back side command

3-21-3 M72 Drum go in spindle side command

3-21-4 M73 For spindle clamp command

3-21-5 M74 For spindle unclamp command

3-22 Finish