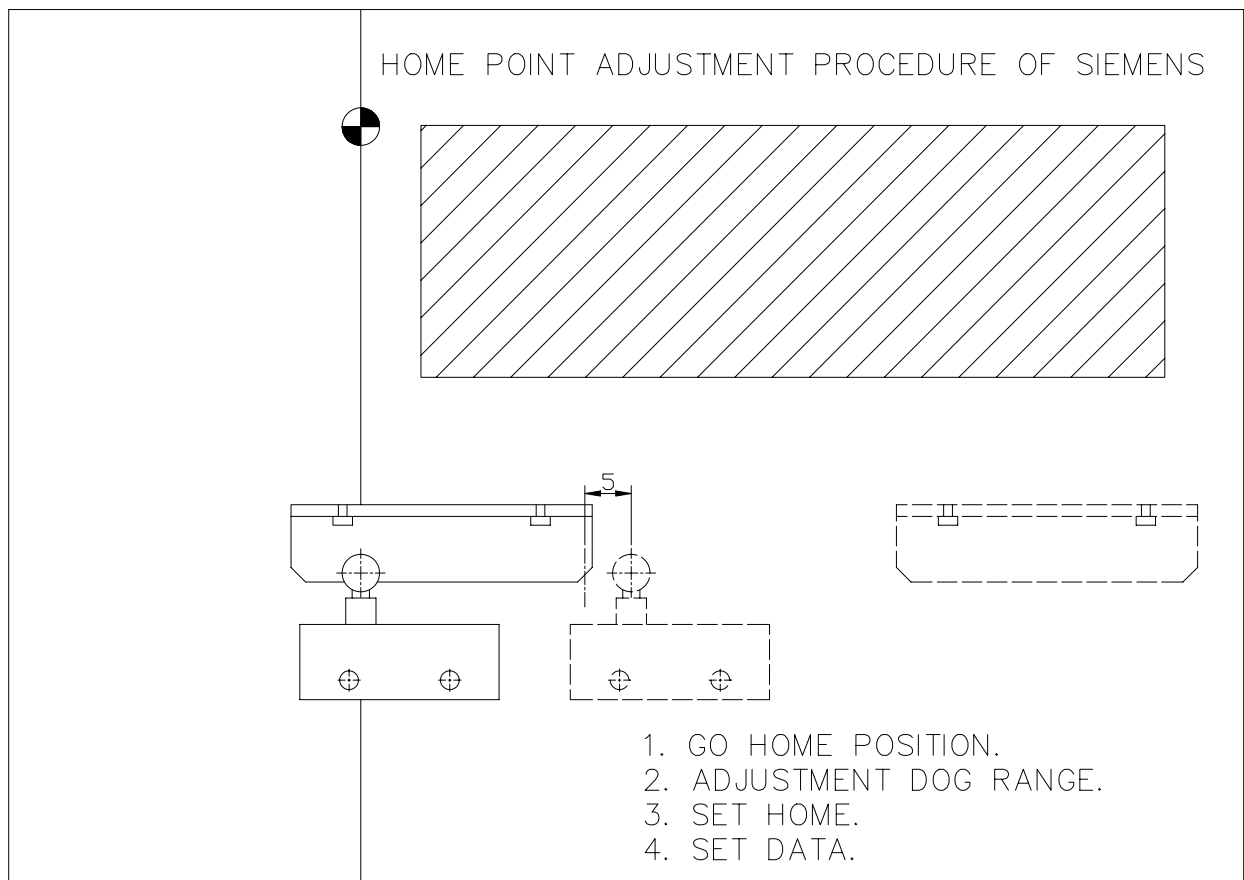




## The Home Point Setting And Signal Display Of Siemens Controller

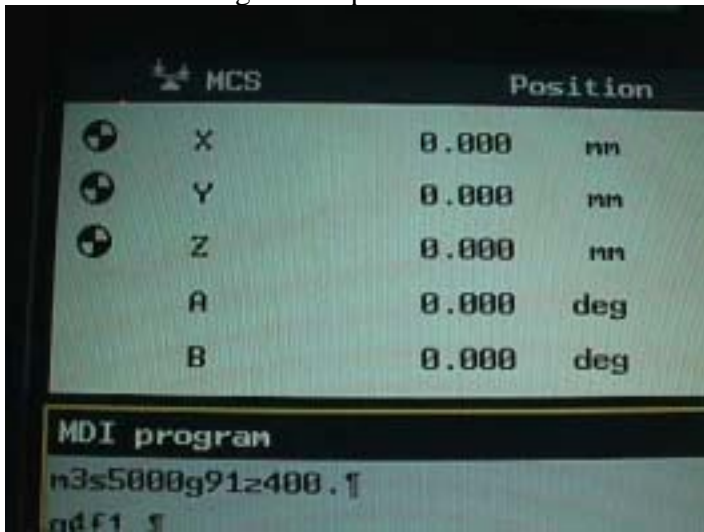
1. The Z axis go to home position
2. After machine home the detect switch stopping on the detect dog
3. To adjustment the detect dog with switch 5mm range
4. To put instruments gage on the table
5. The move Z axis for setting instrument range
6. The Z axis go to home position
7. To count 510mm of Z axis
8. To setting home with detect switch range point
9. Set finish



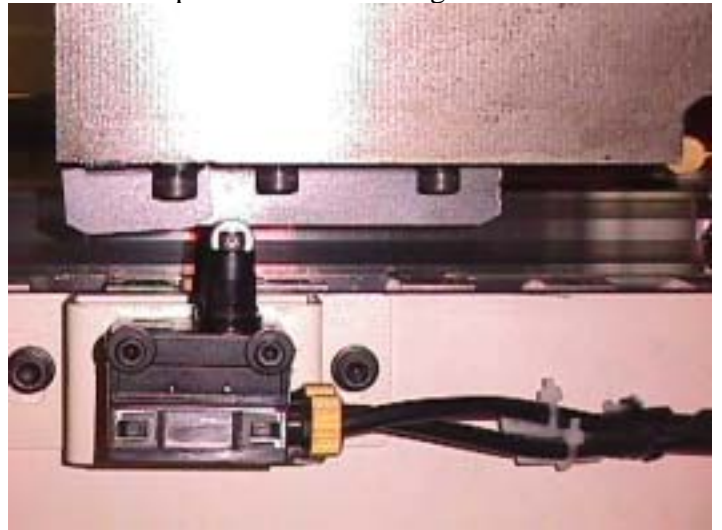


# HARDINGE TAIWAN PRECISION MACHINERY LTD

1. For Machine go home point



2. The home point switch with dog



3. Adjust dog with switch range



4. User by MPG mode



5. Press MENU SELECT Key



6. Press Diagnosis Key





# HARDINGE TAIWAN PRECISION MACHINERY LTD

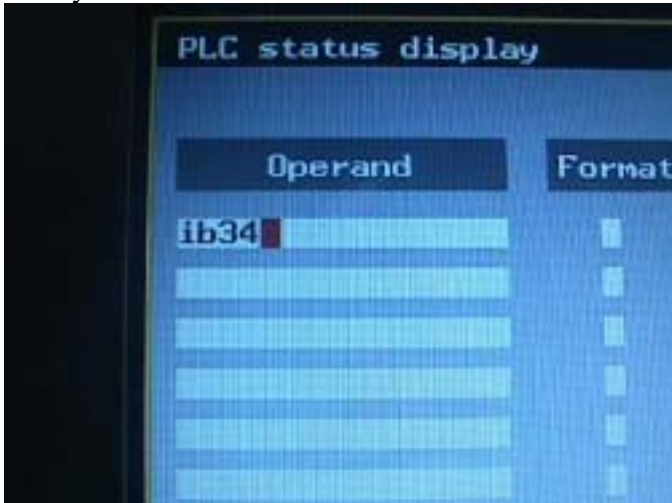
7. Press PLC Key



8. Show PLC Status Display



9. Key In IB34



10. Press Input Key



11. Show IB34 Signal



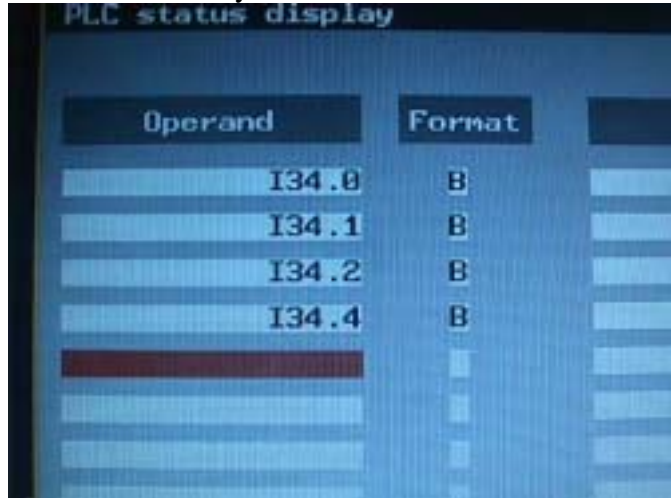
12. Press Delete (Importance)



13. Press OK key For Cancel (Importance)



14. IB34.2 Key In I 34.2



15. I 34 Signal For All Axes



16. To adjust detect dog range



17. To put height gage on the table and length toolholder in to the spindle



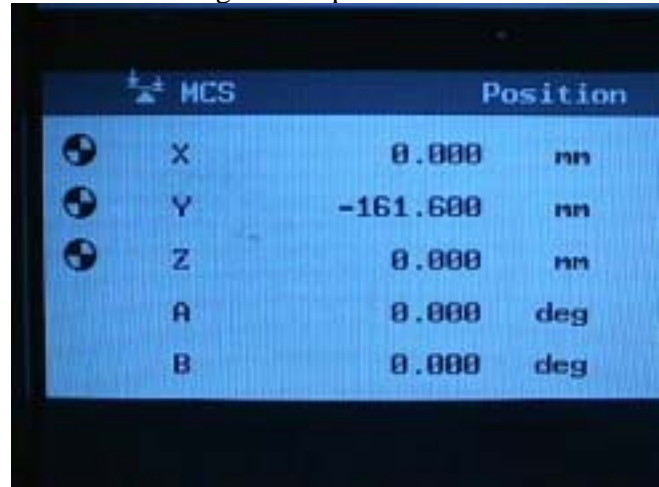


# HARDINGE TAIWAN PRECISION MACHINERY LTD

18. To setting table with spindle point



19. The Z axis go home position



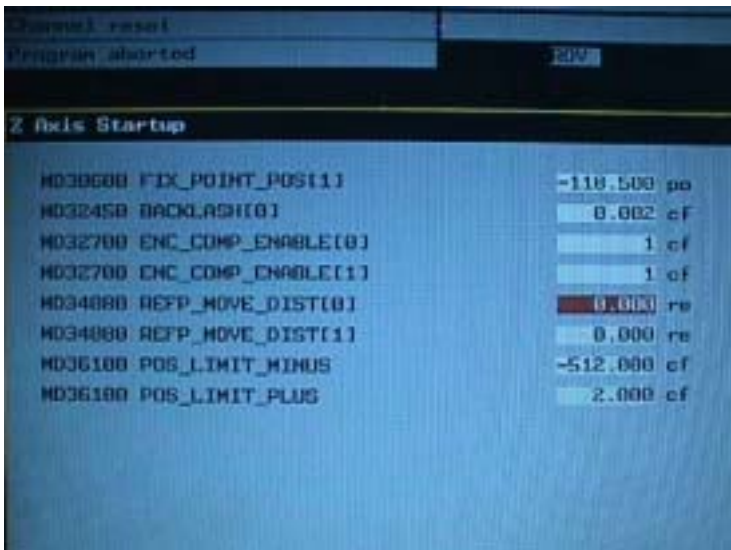
21. Press MENU SELECT Key



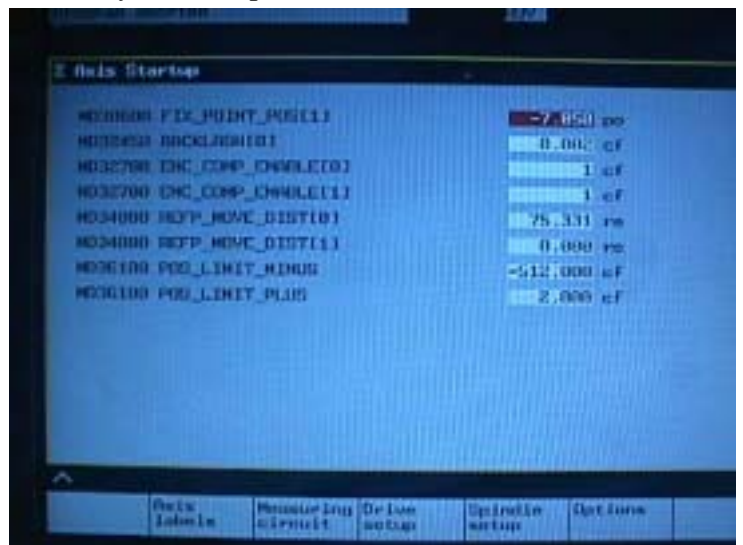
20 Press VMC II Start Up Key



22. Z Axis Stork



23 Key in home point data





## HARDINGE TAIWAN PRECISION MACHINERY LTD

23. Press reset key for finish

