



漢廷股份有限公司

HARDINGE TAIWAN PRECISION MACHINERY LTD

### Sing Arm Adjustment Procedure For Siemens

User Tools

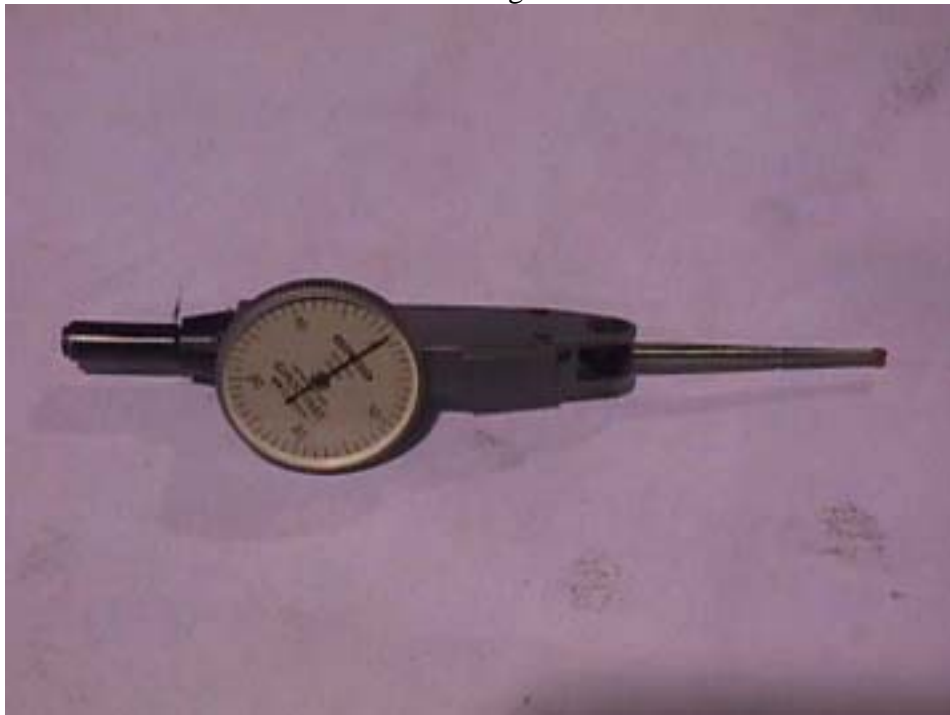
1. Center Gauge



2. Taper Shaft



3. Gauge

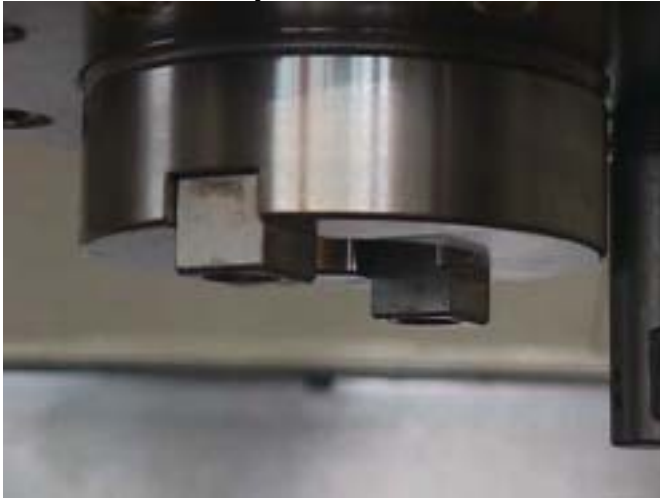




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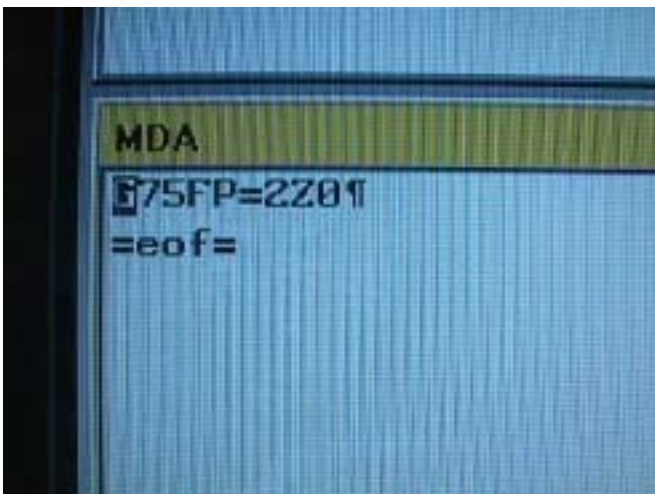
1. Take Out Two Key



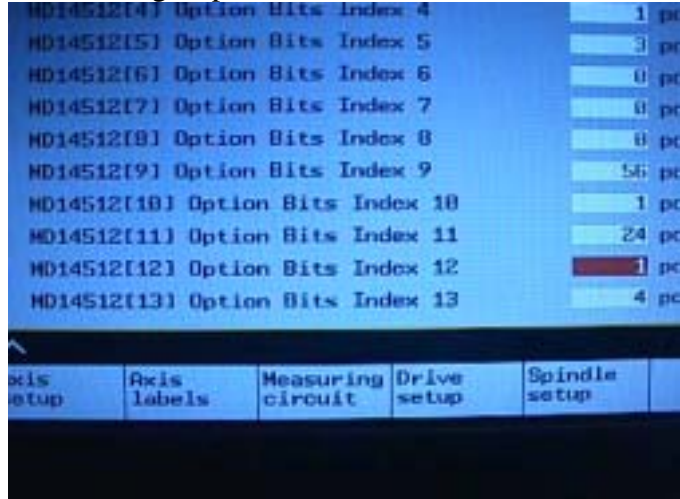
2. Select MDA Mold



3. Key In G75 FP=2 Z0 For Z Axis Home



4. To Change Option=14512 Bit12.0=1



5. Select Menu Mold



6. Press Rapid Button For Arm 60 Degree

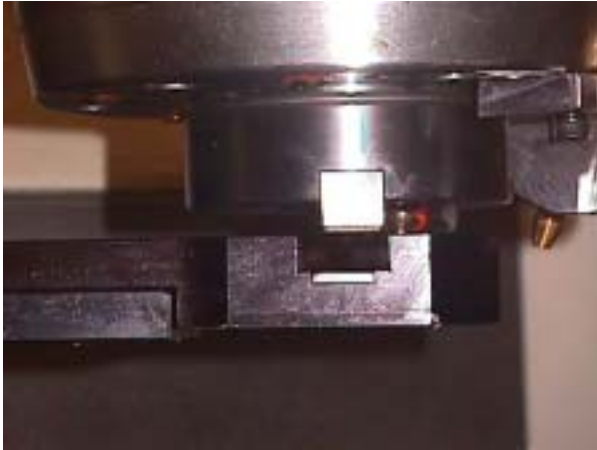




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7. The Arm To 60 Degree Position



8. Put Center Gauge In To Arm



9. Put Taper In To Spindle



10 To Rotation Spindle For Arm With Spindle Concentric By Manu

11. Adjustment For X Way



12. Adjustment For Y Way



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13. Must Adjustment In 0.03mm



14. Press +X Button For Arm Go Back Home Position



15. Adjustment Arm With Spindle Height After Center

16. To Measure Arm With Spindle Plane



17. To Measure Again After Put Tool In To Spindle



18. The Arm With Spindle Height Position Parameter By #30600

User view		AXIS_SETUP	
30600	FX_POINT_POS[1]	-118.0000000 mm	po A
32450	BACKLASH[0]	0.00700000 mm	cf A
32700	ENC_COMP_ENABLE[0]	1	cf A
32700	ENC_COMP_ENABLE[1]	0	cf A
34000	REFP_MOVE_DIST[0]	72.4000000 mm	re A
34000	REFP_MOVE_DIST[1]	0.00000000 mm	re A
36100	POS_LIMIT_MINUS	-512.00000000 mm	cf A
36110	POS_LIMIT_PLUS	2.00000000 mm	cf A
32100	AX_MOTION_DIR	-1	po A
31050	DRIVE_AX_RATIO_DENOM[0]	1	po A
31050	DRIVE_AX_RATIO_DENOM[1]	1	po A
31050	DRIVE_AX_RATIO_DENOM[2]	1	po A
31060	DRIVE_AX_RATIO_NUMERA[0]	1	po A

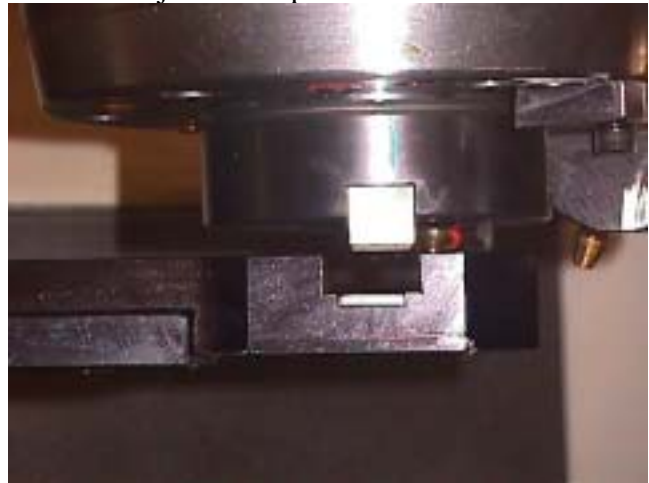
Reference point distance



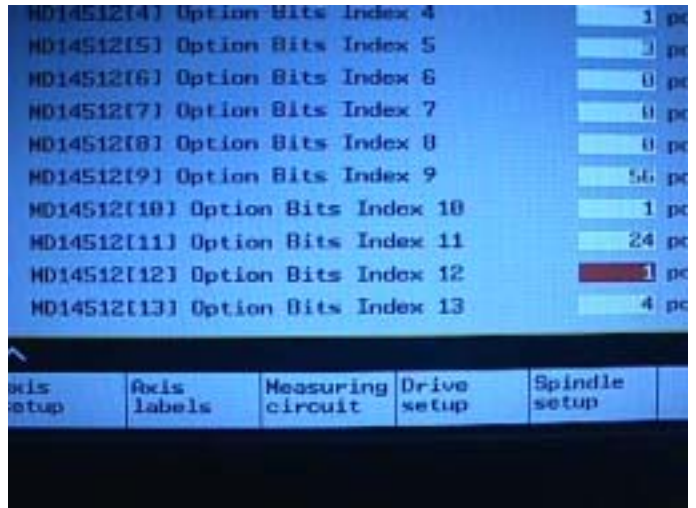
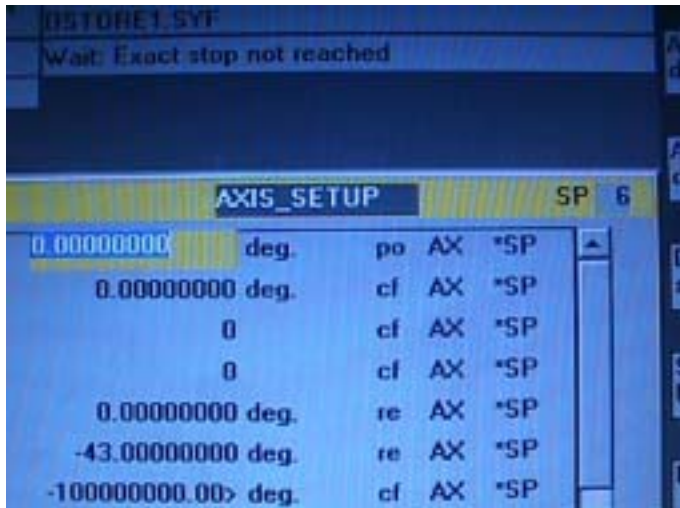
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## HARDINGE TAIWAN PRECISION MACHINERY LTD

19. Press +X Button For Arm Go Back Home Position. 20. To Adjustment Spindle Orientation



21. The Axis Setup SP 6 #30600 For Spindle Orientation 22. After Arm Adjustment Procedure Must Change Back 14512.12=0



23. Press Reset Button For Finish

