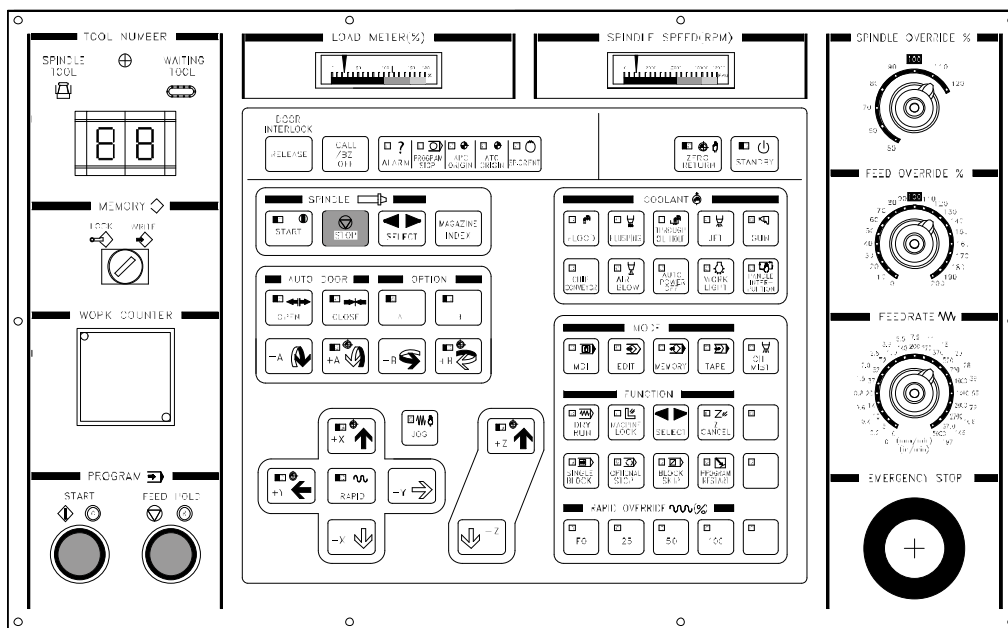




1.8.10 ATC Return

If ATC movement is interfered by Emergency Stop, return it as the following order.

1.Operational Key on Operating Panel



2. ATC Single Operation

- 1) Press **RESET** button.
- 2) Carry out M31, **EOB**, M35, **EOB** and **INSERT** in sequence and press the **CYCLE START** button in the MDI mode. (The feed hold lamp will be on, and then off after around one second.)
※ If the **CYCLE START** is not executed, press the **CYCLE START** button and the **MAG. SELECT** button at the same time.
- 3) If the pot is down, execute the clause 7), and execute clause 4) if the pot is up.
- 4) Select the empty pot by pressing the **MAGAZINE INDEX** button in the handle mode.



- 5) Place the Z axis at the reference point.
Ex) Carry out G91, G28, Z0, EOB and INSERT in sequence, and press the CYCLE START button.
- 6) Check the followings by pressing the Y axis jog feed switch.
In case of pressing +Y: Pot Down Operation
In case of Pressing -Y: Pot Up Operation
- 7) Check the followings by pressing the X axis jog feed switch.
In case of pressing +X: Arm CW Cycle Operation
In case of Pressing -X: Arm CCW Cycle Operation
- 8) Check the followings by pressing the Z axis jog feed switch
In case of pressing +Z: Tool Clamping Operation
In case of Pressing -Z: Tool Unclamping Operation
- 9) Have the pot up by pressing the Y axis jog feed switch.
- 10) Carry out M32, **EOB** and **INSERT** in sequence, and press the **CYCLE START** button.
- 11) Press **RESERT** button.

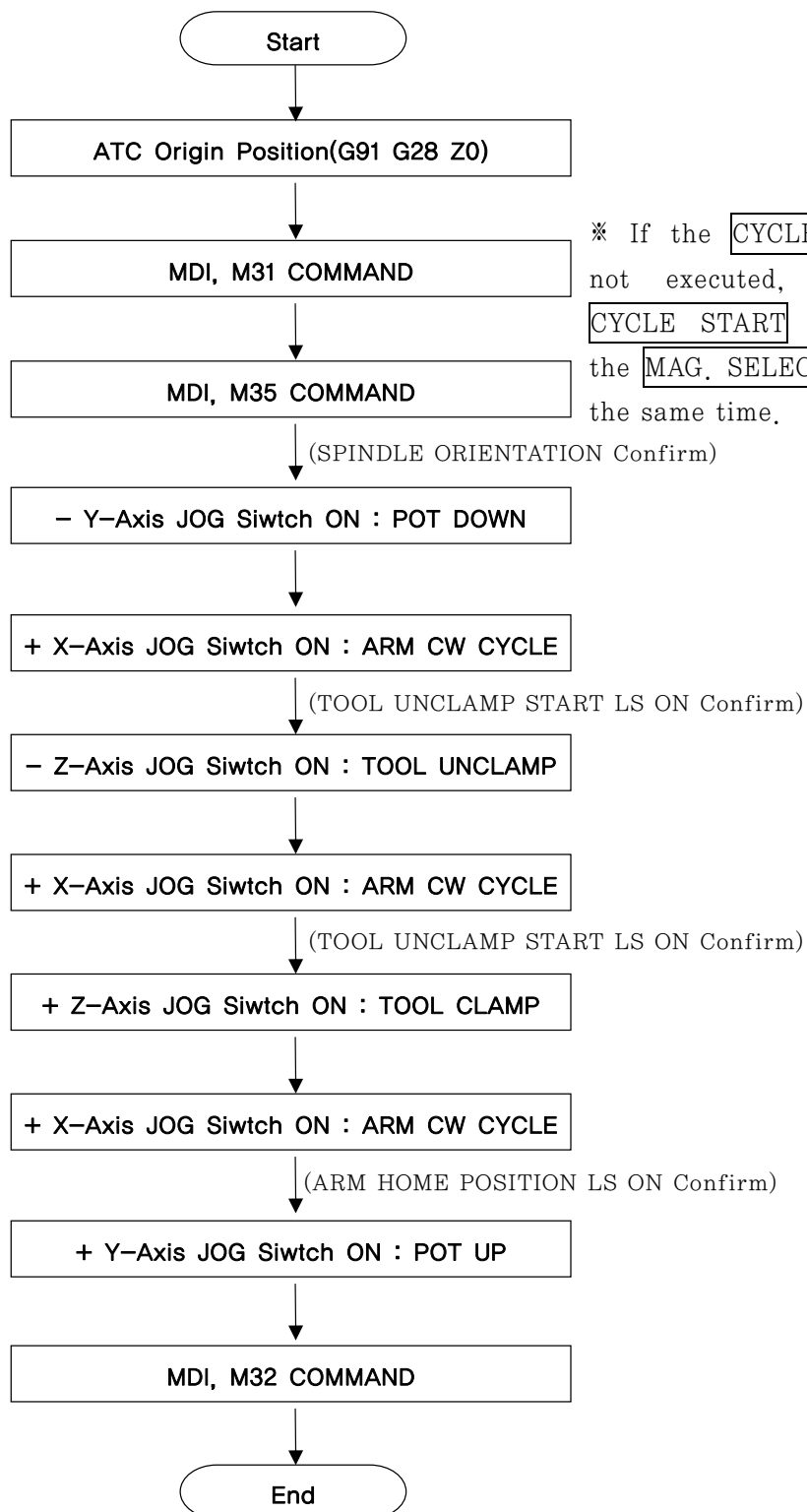
M6 COMMAND

M6(Tool Change) command releases interlock when the following requirements are satisfied:

- ① Z-axis shall be on the position of Zero Return.
- ② When pressing Magazine Index button at the manual mode, magazine shall rotate.
- ③ Twin arm shall be on Home Position.
(Check the ATC home position with lighting of the lamp.)
- ④ Alarm lamp shall be off.



1.8.11 Maintenance Operation of ATC



※ If the **CYCLE START** is not executed, press the **CYCLE START** button and the **MAG. SELECT** button at the same time.