

ADJUSTING THE HOME POSITION ON THE TURRET

To adjust the home position on the turret follow these steps.

Main Menu

F7 - F4 – F2 – B

Change 2 parameters:

P000 from 3 to 2, P001 from 4 to 3

Change parameter P034 to 1500 & parameter P035 to 500

After they are changed press SHIFT then RESET to reboot the control

Press these keys

Main menu – F4 – F6 - F3

You will see that the B axis is now visible and that you can see the following error display.

Using MDI enter G74 B to home the turret. If it locks look at the following error. This is the amount the turret is off in home position.

If it does not lock, you can adjust the position of the turret by entering B and then a value 1 degree different to the position shown, do this until the turret locks in place.

Write down the following error value.

PRESS THESE KEYS

Main Menu – F7- F4 – F2 – B

Cursor down to parameter P047 (REFSHIFT)

This is the parameter that sets the home position.

Adjust this parameter by the error amount.

Press RESET 3 times after each change

In MDI mode use G74B to retest the position.

When the turret locks into place look at the B Following error.

Adjust the P047 by the amount of following error.

Then run G74 B if the turret locks, check the following error.

A value of less than 0.5 should allow the turret to lock.

If it does not lock add the value to the P047.

Then run G74 B if the turret locks, check the following error.

When updating to the new sensor it is necessary to change the parameter related to home switch sensing P32 is + change to – press RESET 3 times after changing this parameter.