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## HOMING A TOOLCHANGER WITH SERVO MOTOR ON A INNOVA (210mb with Beta Drive)

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1. Using the rotate mag. Push button on the tool changer rotate the tool changer until pocket one is facing the spindle. If it will not rotate with the button, it will need to be aligned manually to line up with pocket #1.
  - a. To line it up manually insert a toolholder into the spindle. Shut the air supply off to the machine and you will be able to push the toolchanger in by hand to line it up with pocket #1.
2. Hit e-stop with toolholder pocket #1 aligned. **(REMAIN IN E-STOP UNTIL DONE)**
3. Click on System (center)
4. Chapter (left)
5. Click Next
6. Relay (center) (handy page on some models)
7. Turn Parameter write on . (put checks in the box) (must be in MDI)
8. Go to the keep relay screen.
9. Turn K0.2 and K0.3 on. (put checks in the box)
10. Example K000 o o o o \ \ o o
11. Shut down computer, turn it off and back on.
12. Repeat steps 3 and 4.
13. Data (center)
14. Opr (right)
15. Group Data (left)
16. Group Count (pulldown and pick 2)
17. Set #1 (D14) data to 11 and hit TAB, Set #2 (D16) data to 128 and hit TAB, and hit cycle stop. (It should flash to clear home.)
18. Set #1 (D14) data to 11 and hit TAB, Set #2 (D16) data to 129 and hit TAB, and hit cycle stop. (It should flash to set home.)
19. Go back to RELAY screen
20. Fct (left)
21. Repeat steps 3-4-5
22. Turn K0.2 and K0.3 or (K0.4 and K0.5) off (un-check the box.)
23. Turn Parameter write off (un-check the box)
24. Power off. (off/on) **Pull E-Stop back out.**
25. Turn air back on to the machine.
26. Try to home toolchanger if the error still there, rotate magazine and power off. (you must take toolchanger out of auto mode)

