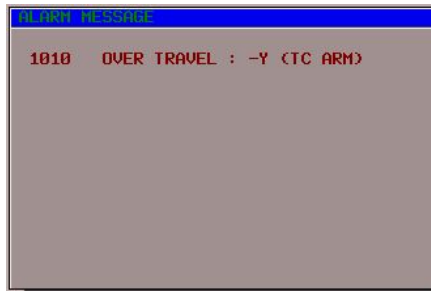




Instruction:	Rev Date:
Issued Date: 5/11/01	Rev Num: Draft #1
Issuer: Customer Service	
Approved By:	

TC Reference -TG Solution / M1 SHO (Touchscreen) for Logic TGT3-4 / M1ST8-4 and later.

1. Place a tool holder in the spindle and call the spindle down into the active position.
2. Make sure Tool Changer is in manual mode (TC Auto/Man should not be lit).
3. Jog Y axis towards carousel until this message is displayed:



4. Touch the **OT Bypass** button on the Touchscreen. Then press and hold **Cycle Stop** for about 15 seconds until you should see this message:



5. Carousel pocket 1 should be lined up with tool in spindle. If not, align pocket by turning the carousel slowly by hand.
6. Turn off the **OT Bypass** on the Touchscreen. Using the MPG, move the toolholder into the # 1 pocket – centering it up as close as possible.





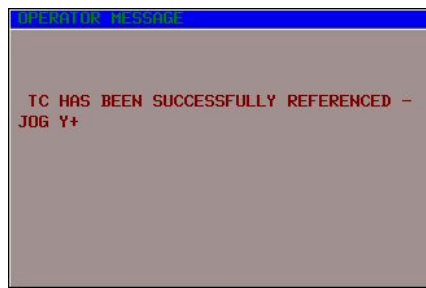
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7. Press the Home push-button to complete the reference sequence. You should see this message:



8. Touch Toolchange button and you should see this message:



This step will 'grab' the current Z & Y positions and insert them into macro variables (#500-#505)

9. Move the spindle away from the carousel in the positive Y direction.
10. Cycle the power. (Properly shut down Windows and press power off – wait for 10 seconds and then turn power back on).
11. Upon power up, home X axis as required (TG Models only). If not a TG Model, then continue with next step.
12. Enable keep relay for ATC102 (K12.1) – this is only necessary for factory start-up or if the tool changer was intentionally disabled.
13. Home the ATC (Select **Home** mode then press & hold **Cycle Stop** and then touch **Tool Change** button while holding **Cycle Stop**). Empty the spindle as required (even if the spindle is empty the Drawbar push-button must be pressed).
14. Turn Rapid Override Knob to 25%. Command a tool change to empty pocket to verify carousel position. (Example: T2001 M06 ;)
15. If successful, home the ATC and load a tool into pocket 1 of carousel. Command a toolchange for pocket 1 (T2001 M06 ;).
16. If tool change is successful and alignment looks OK, home the ATC - load the carousel and run the TC test program for approx. 15 minutes (so at least every pocket is tested).
17. Sample program for TC test program
Example: T2001M6;G4 X4.; T2002M6;G4X4.; T2003M6;G4 X4.; T2004M6;G4X4.;M99;