



ALPHA PROCEDURE TO REFERENCE Z AXIS

**PLEASE MAKE SURE YOU ARE IN CNC MODE
(PLEASE NOTE THAT THIS PROCEDURE IS ONLY TO BE USED WHEN
ALARM 300 APC Z AXIS NEEDS ZRN IS DISPLAYED)**

1. Set any Workshift values to ZERO.
2. Push in the Emergency Stop button.
3. Press the Offset/Setting Key.
4. Press the Setting Softkey displayed on the screen and cursor to the PWE option.
5. Change the "0" setting to "1".
6. Press the "Input" key (This should display P/S 100 alarm).
7. Press the System key.
8. Type in 1240 then press the No. Search soft key and make a note of the Z axis value.
9. Release the E-stop press the green controls.
10. Using a RULE or TAPE MEASURE, measure from the SPINDLE NOSE (this is the point at which the chuck mounts to the Spindle) to the left hand face of the cross-slide and using the Z axis handwheel, wind the Z axis until the measured distance equals the figure recorded in parameter 1240.
11. Press the SYSTEM key.
12. In MDI type in 1815, then press the Number Search Softkey.
13. Use the arrow keys to illuminate the Z axis APZ column.
14. Change the value shown to 1.
15. Press the emergency stop button.
16. Cycle the power of the control.
17. In MDI press the Offset Setting Key.
18. Press the Setting Softkey.
19. Change PWE back to zero.
20. Type in 0 and then press the Input Key.
21. Release the Emergency Stop.
22. Press the green power "on" button.
23. Press the Reset button.

