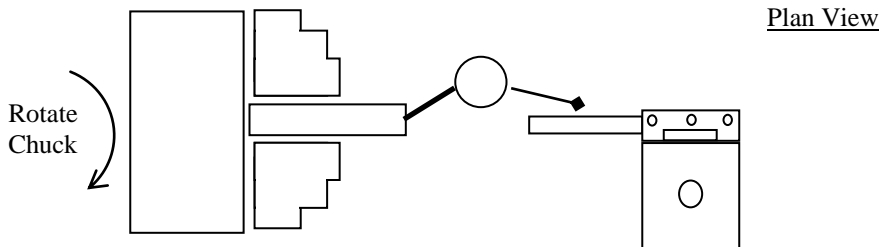


ALPHA PROCEDURE TO RE-REFERENCE X AXIS (after collision)

PLEASE MAKE SURE YOU ARE IN CNC MODE

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 a P/S 100 alarm condition).
 7. Press the System key.
 8. Type in 1240, then press the Number Search Softkey, make a note of the X axis value.
- (Note 1)**
9. Type in 1815, then press the Number Search Softkey. Use the Arrow keys to illuminate the X axis APZ column.
 10. Change the value shown to zero.
 11. Press the Input key.
 12. Cycle the power of the control (At this point the alarm 300 APC Alarm X axis needs ZRN should be displayed).
 13. Now Clock the X axis and manually move the machine to x zero position (spindle centreline).



14. Move the clock away from the bar in the Z axis direction only.
15. Press the POS key and then the REL Softkey. Press the U key and then the ORIGIN softkey, the screen should now read U 0.000.
16. Using the X axis handwheel wind the X axis slide until the U value displayed equals the figure recorded in parameter 1240.
17. Press the MDI and SYSTEM key.
18. Type in 1815, then press the Number Search Softkey.
19. Use the arrow keys to illuminate the X axis APZ column.
20. Change the value shown to 1.
21. Press the emergency stop button.

22. Cycle the power of the control.
23. In MDI press the Offset Setting Key.
24. Press the Setting Softkey.
25. Change PWE back to zero.
26. Type in 0 and then press the Input Key.
27. Release the Emergency Stop.
28. Press the green power "on" button.
29. Press the Reset button.

Note 1 : On later models this value may be set at 0.000, in this instance the reference position will be set on the centre line of the machine. Therefore ignore points 14, 15 and 16.