ALPHA PROCEDURE TO REFERENCE Z AXIS (after collision)

PLEASE MAKE SURE YOU ARE IN CNC MODE

1. Set any Workshift values to ZERO.
2. Select MDI and push in the Emergency Stop button.
3. Press the Offset/Setting Key.
4. Press the Offset 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 Number Search Softkey, make a note of the Z axis value.
9. Type in 1815, then press the Number Search Softkey. Use the Arrow keys to illuminate the Z axis APZ column.
10. Change the value to zero.
11. Press the Input key.
12. Cycle the power of the control (At this point the alarm 300 APC Alarm Z axis needs ZRN should be displayed).
13. 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.
14. In MDI press the SYSTEM key.

15. Type in 1815, then press the Number Search Softkey.
16. Use the arrow keys to illuminate the Z axis APZ column.
17. Change the value shown to 1.
18. Press the emergency stop button.
19. Cycle the power of the control.
20. In MDI mode press the Offset Setting Key.
21. Press the Setting Softkey.
22. Change PWE back to zero.
23. Press the Input Key.
24. Release the Emergency Stop.
25. Press the green power "on" button.
26. Press the Reset button.