All controller
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A.T.C. error

DESCRIPTION	A.T.C. error
	There are 2 situations that tool arm stops disorderly. 1. Press "emergency" button "reset" key or turn off power During tools exchanging. the arm will stoped immediately. The arm return to original posmon, the steps as following: 1)Press "reset" key. 2)In MDI mode, set PMC software switch: K5.4=1,K5.5=1 3)Press "cycle start" key step by step in manual mode. The arm will be moved forward to the original postition. 4)Be sure arm is in original position under auto mode. The "ATC NOT READY" alarm message will display if arm is not in original position. Be sure spindle is at clamp tool position. 5)Check tool, tool size, and tool no. of both side of tool arm from "mag tool no. setting of oversize tool from screen if arm is with oversize tools. 6)In MDI mode, set PMC software switches: K5.4=0 K5.5=0. *This situation is 95% rate of arm troubling.

OVERHAUL

OF

PROCESS

2. As soon tool arm can not be moved forward during tools change.
   The arm will be moved backward till tool the original position.
   For example:Z Axis position is wrong during arm running,
   The arm will not move forward.
   The arm return to original position. The steps as following:
   If arm is stopped position isn't between original and Z home.
   It is important that user must take off both side of tools firstly.

IT IS IMPORTANT THAT USER MUST TAKE OFF BOTH SIDE OF TOOLS FIRSTLY.
1) Press "reset" key
2) In MDI mode, set PMC software switches: K5.4=1 K5.5=1 K6.0=1
3) Press "cycle start" key step by step in manual mode.
   The arm will be moved backward till to the original position.
4) Be sure arm is in original position under auto mode.
   The "ATC not ready" alarm message will display if arm is not
   in original position.
   Be sure spindle is at clamp tool position.
5) Check tool, tool size and tool no. of both side of tool arm from
   "mage tool no. display "screen
   Check the tool no. setting of oversize tool from screen if arm is with oversize tools.
6) Set PMC software switches:K5.4=0, K5.5=0, K6.0=0 in MDI mode.
* This situation is 5% rate of arm troubling.