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Change Z axis tool change position

DESCRIPTION	Change Z axis tool change position
<p>OVERHAUL OF PROCESS</p>	<p>Step 1 : Select MDA mode , input L75 and press NC start to move Z- axis to home position and orient the spindle to zero position .</p> <p>Step 2 : Select JOG MODE.</p> <p>Step 3 : Press the key combination POCKET + CW/DOWN to pocket down status.</p> <p>Step 4 : Press the key combination ARM+CW/DOWN or ARM+CCW/UP on the operation panel to rotate the arm to spindle tool-change position.</p> <p>PS. When the arm is at spindle tool-change position , the arm can't rotate.</p> <p>Press manual tool unclamp button(tool unclamp status) , then press key combination ARM+CW/DOWN or ARM+CCW/UP to rotate the arm again.</p> <p>Until the arm is in pocket-change position , the arm can't rotate.</p> <p>Press manual tool unclamp button again (tool clamp status), then press key combination ARM+CW/DOWN or ARM+CCW/UP to rotate the arm again to change the arm in origin position.</p> <p>Step 5 : Measure the distance between arm and spindle.</p> <p>Change the parameter MD34090(\$MA_REFP_MOVE_DIST_CORR). Press Refresh button or restart the machine to update the tool-change position.</p>