

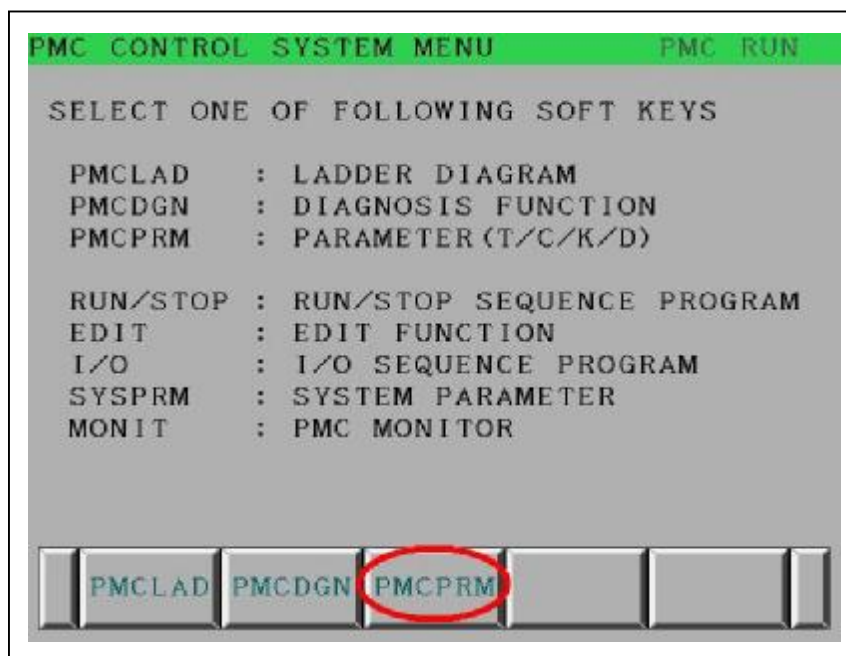
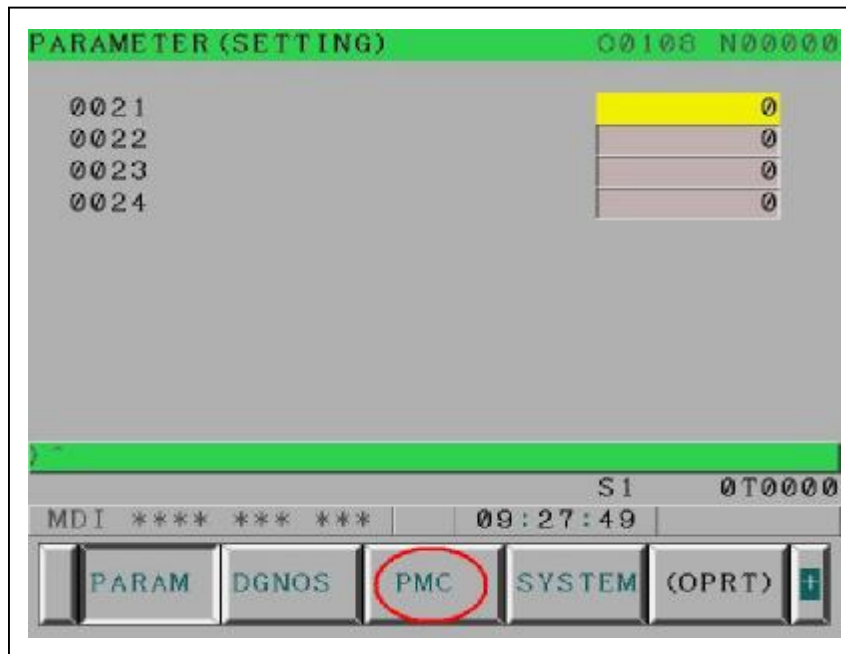
## I/O LINK turret resetting procedure

### Turret reference position resetting procedure.

(If the turret can't make indexing or can't clamp well, the indexing button light is off, please run this procedure)

1. Set K07 Bit 5 = 1 (to be able to move the turret under Jog Mode)

Push [System] on the Keypad, then [PMC] on the soft-key



| PMC PRM (TIMER) #001 |         |        | PMC RUN |         |       |
|----------------------|---------|--------|---------|---------|-------|
| NO.                  | ADDRESS | DATA   | NO.     | ADDRESS | DATA  |
| 001                  | T000    | 9984   | 011     | T020    | 1000  |
| 002                  | T002    | 480    | 012     | T022    | 1000  |
| 003                  | T004    | 960    | 013     | T024    | 1000  |
| 004                  | T006    | 2976   | 014     | T026    | 1000  |
| 005                  | T008    | 4992   | 015     | T028    | 10000 |
| 006                  | T010    | 480    | 016     | T030    | 10000 |
| 007                  | T012    | 480    | 017     | T032    | 4000  |
| 008                  | T014    | 300000 | 018     | T034    | 4000  |
| 009                  | T016    | 28000  | 019     | T036    | 0     |
| 010                  | T018    | 26000  | 020     | T038    | 0     |

|       |        |        |      |        |
|-------|--------|--------|------|--------|
| TIMER | COUNTR | KEEPRL | DATA | SETING |
|-------|--------|--------|------|--------|

| PMC PRM (KEEP RELAY) #001 |          | PMC RUN |          |
|---------------------------|----------|---------|----------|
| ADDRESS                   | DATA     | ADDRESS | DATA     |
| K00                       | 01000011 | K10     | 00000000 |
| K01                       | 10000000 | K11     | 00000000 |
| K02                       | 00000000 | K12     | 00000000 |
| K03                       | 00000000 | K13     | 00000000 |
| K04                       | 00000110 | K14     | 00000000 |
| K05                       | 00000010 | K15     | 00000000 |
| K06                       | 01000000 | K16     | 00000000 |
| K07                       | 00100000 | K17     | 00000010 |
| K08                       | 00000000 | K18     | 00000000 |
| K09                       | 00000000 | K19     | 00000000 |

|       |        |        |      |        |
|-------|--------|--------|------|--------|
| TIMER | COUNTR | KEEPRL | DATA | SETING |
|-------|--------|--------|------|--------|

2. PMM No.11 Set to 10000000

(System->"+", "+", "+"->"PMM"->"System"->"PARAM" )

3. Restart Machine (Power off machine totally from back main switch, wait 30 sec. then power on again)
4. Switch to **HANDLE** mode  
Press “FEED HOLD” and “SPINDLE STOP.” At the same time.(the turret head will unclamp now)



5. Switch to “JOG mode”  
press “-X”(forward direction) or “+X”(reverse direction) button to rotate the turret head.
6. Rotate the turret head to tool #1 by pressing -X or +X;  
After move to tool#1, press NC “RESET” key to clamp the turret head.
7. Set No.11 in PMM to “10000001”
8. Set K07 bit5 back to 0 (switch the turret into normal operation mode).
9. Turn off the power.
10. Turn the power on again. The procedure is finished.