

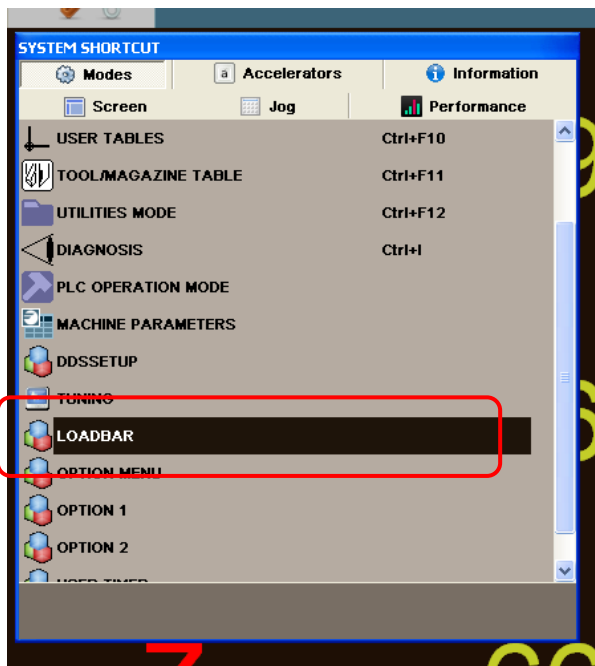
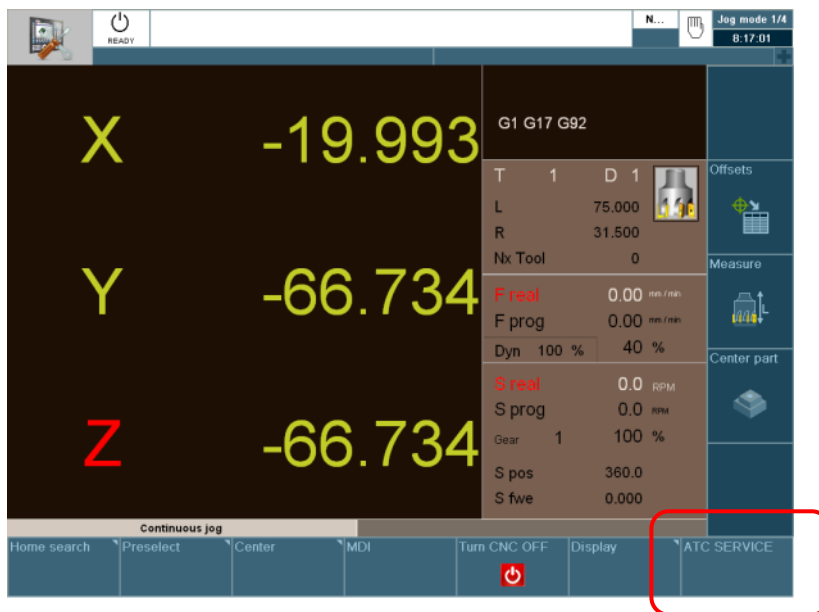
# A2 operation procedure

## FAGOR 8065 machine center, ATC service mode

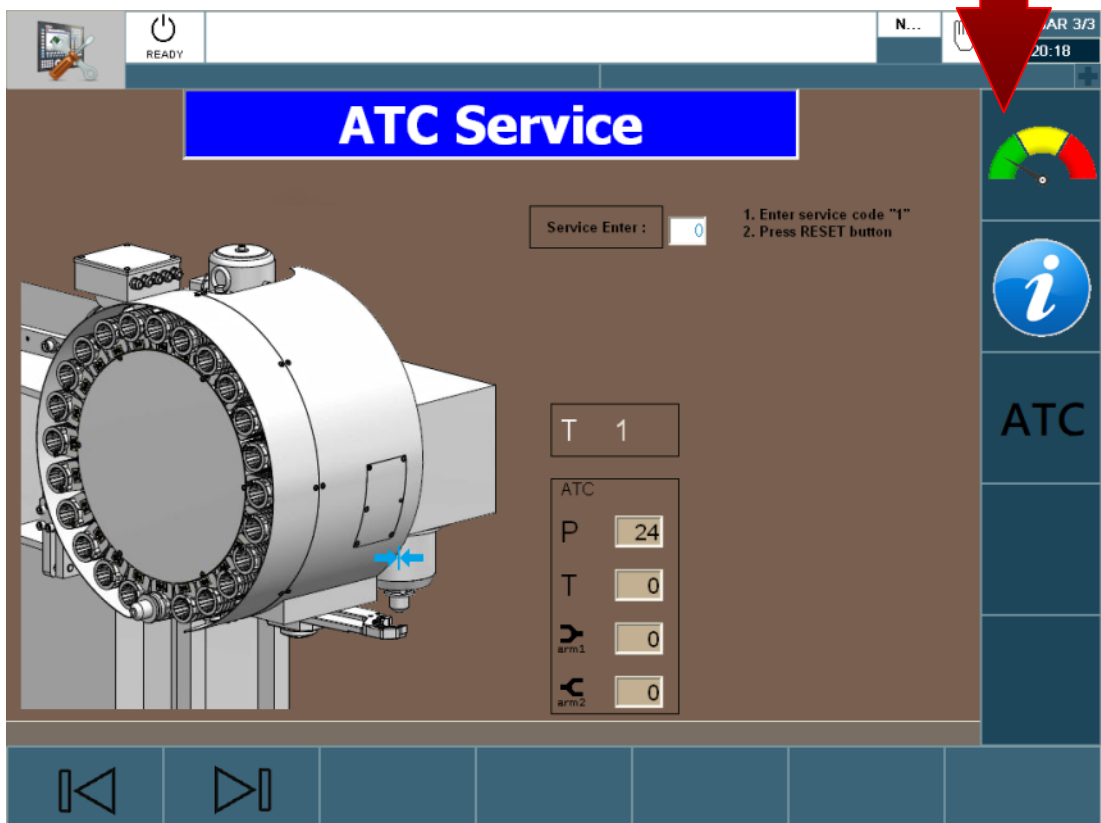
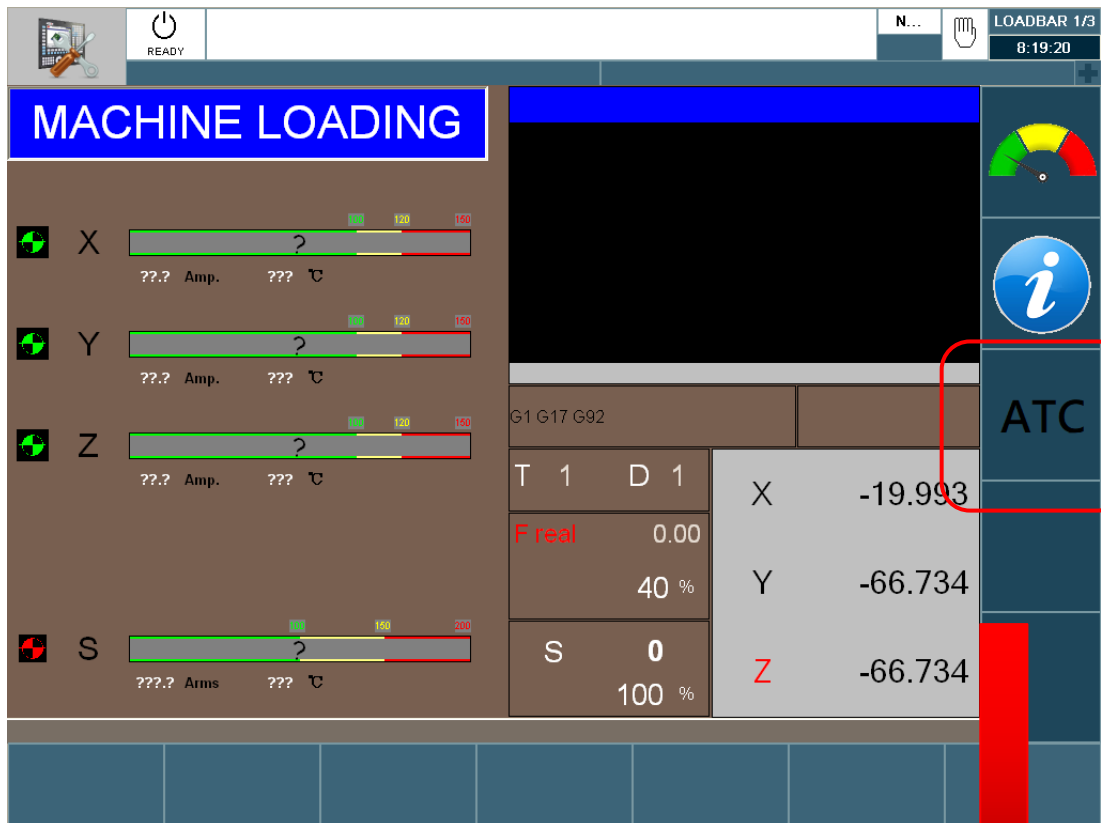
There are 2 kinds of mode you may using, one is “service mode” which is for ATC recovering while the tool change progress been interrupted for some reason. The other is “calibration mode” which is for calibrating the tool change position (you could move the Z axis manually).

## A. Service mode

- 1) Press F7 “ATC SERVICE” key on the first page of Jog mode ( in M mode) or press “CTRL” + “A” key to open the task window then select “LOADBAR”

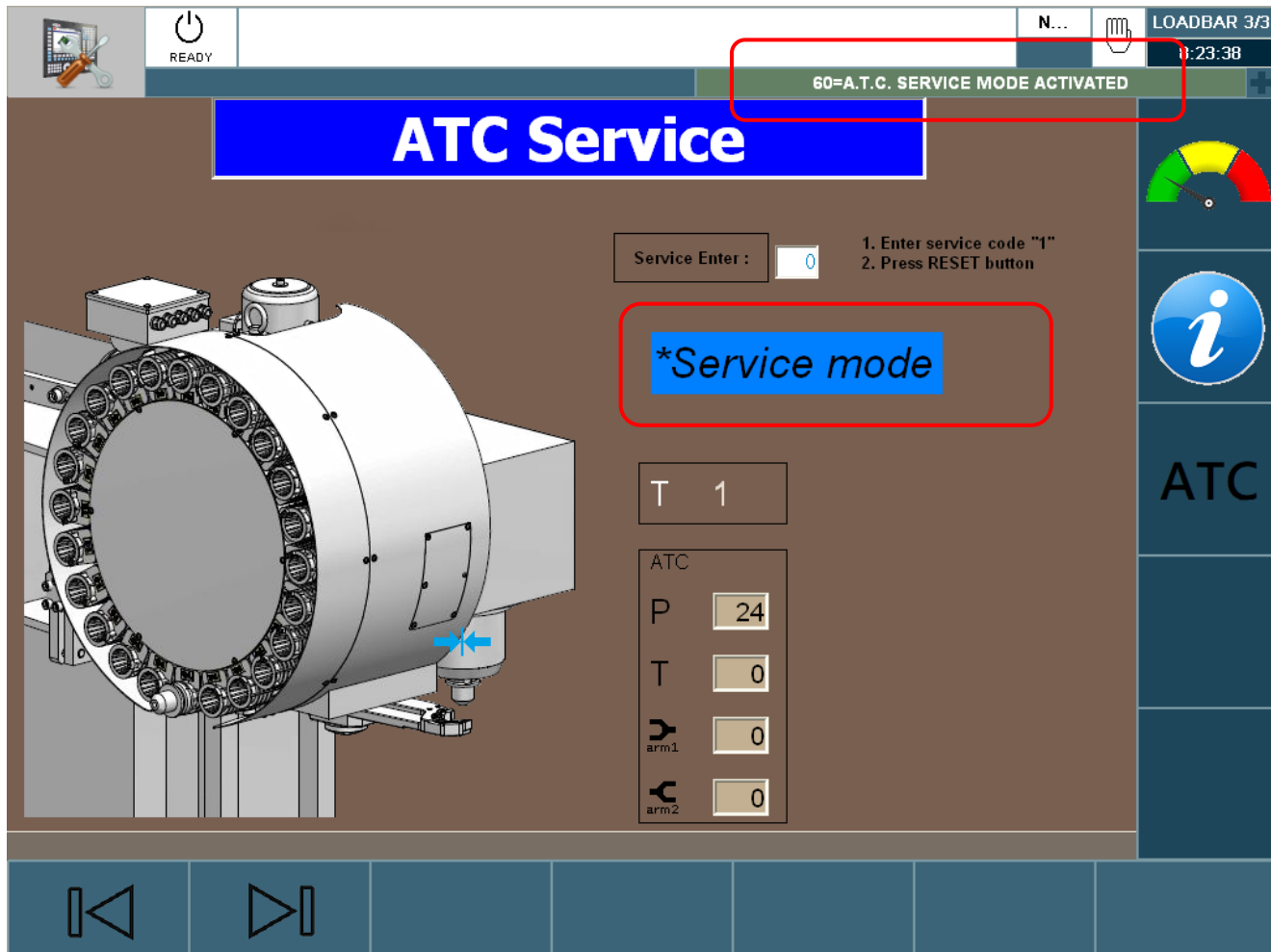


2) Press F10 "ATC" into the ATC service screen.





- 3) Key-in “1” on the field (a “TAB” key may help for field selection) then press “RESET” button to active service mode.

The field will back to “0” after pressing the RESET key and service mode is activated.






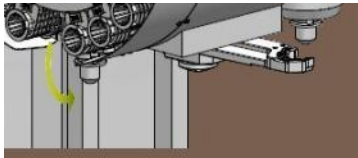
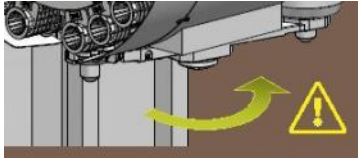
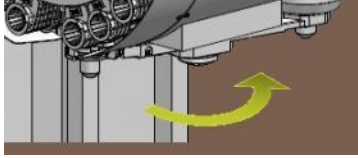
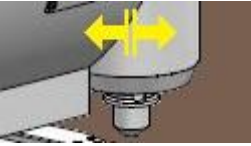
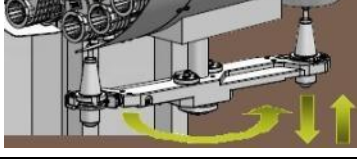


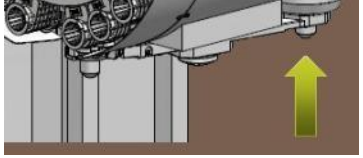
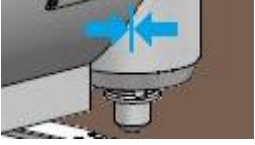
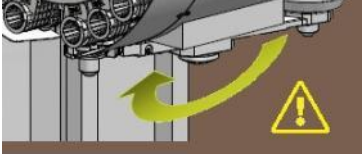
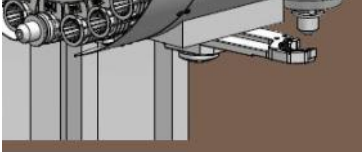
Note : The service mode will be de-activated automatically while magazine pocket swing to upright position or exit this ATC screen. You have to repeat this step to reactive the service mode function.

- 4) Press F1  (reverse step) or F2  (next step) the ATC would follow the tool change progress to recover the status of ATC.

The F1 (reverse step) may work in some condition only and F2 (next step) could work in any condition.

The image on the screen would show you the current status of tool change progress. You may double check with real situation to prevent other issues. The description of the images as table below.

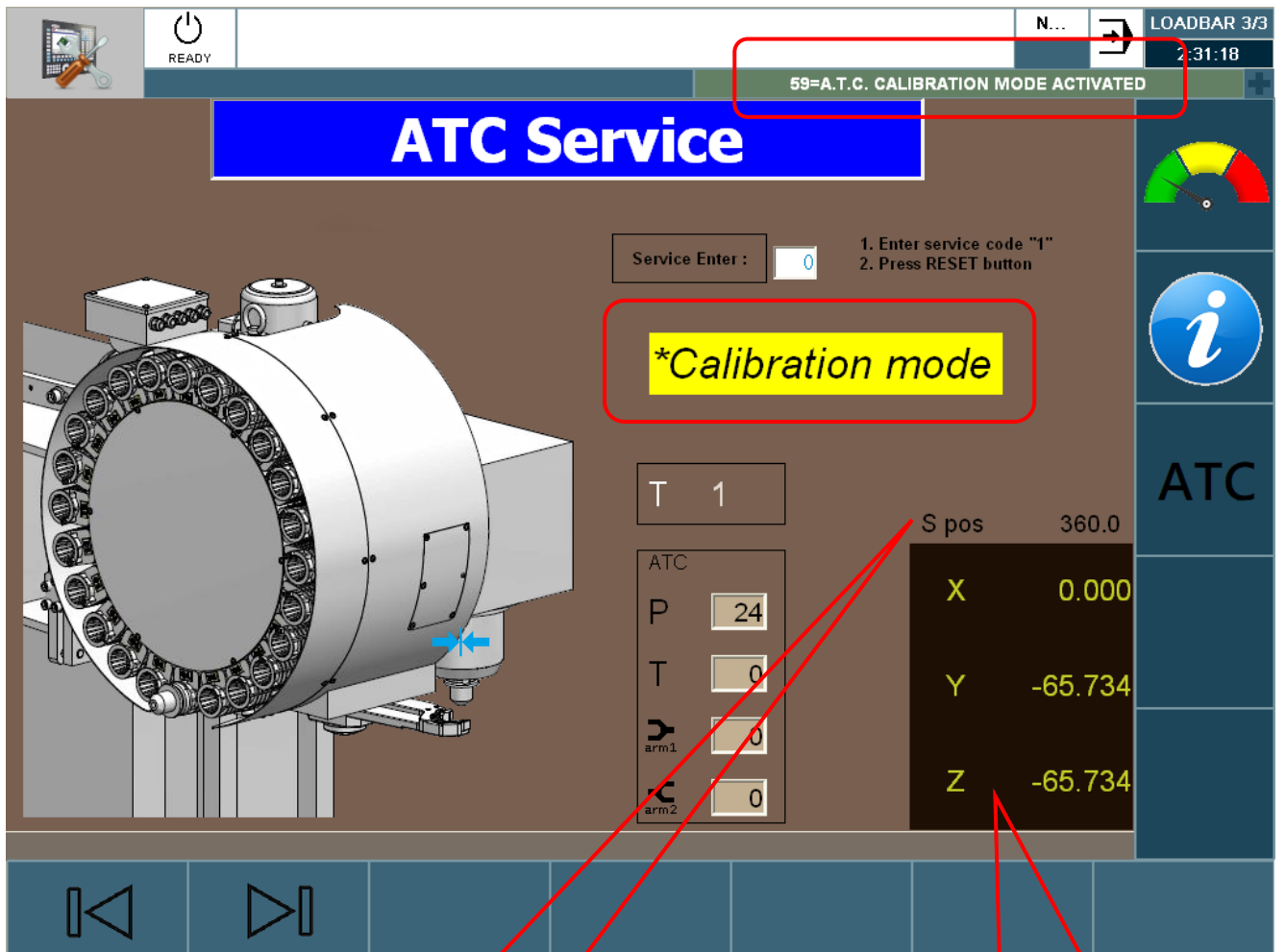
	Description	Note
	Tool no. on spindle.	
	Current pocket no. of magazine for tool change.	
	Tool no. on the pocket which been ready for tool change.	
	Tool no. on arm1 (gripper 1 of arm).	
	Tool no. on arm2 (gripper 2 of arm).	
	Magazine pocket on swing down position.	ATC arm on home position.
	ATC arm swing into spindle (not in position).	Arm step 1
	ATC arm swing into spindle (in position, ready for unclamping tool).	Arm step 2
	Spindle tool unclamping.	
	ATC arm pull down and swing over to change tool.	Arm step 3

	<p>ATC arm swing over and new tool insert to spindle (in position)</p>	<p>Arm step 4</p>
	<p>Spindle tool clamping.</p>	
	<p>ATC arm swing back to home position (not in position).</p>	<p>Arm step 5</p>
	<p>Magazine pocket on upright position.</p>	<p>Service mode deactivated.</p>

## B. Calibration mode

While this mode been activated you could move the Z axis when the arm not on home position and check the angle of the spindle at the same time.

Put "9" instead of "1" on the "Service Enter" to activate the calibration mode.



The angle position of spindle

The current machine coordinate in G53