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PROCEDURE TO SETUP ATM-1054 W/ ATC W/ FAGOR 8055i/FL-MC CONTROL

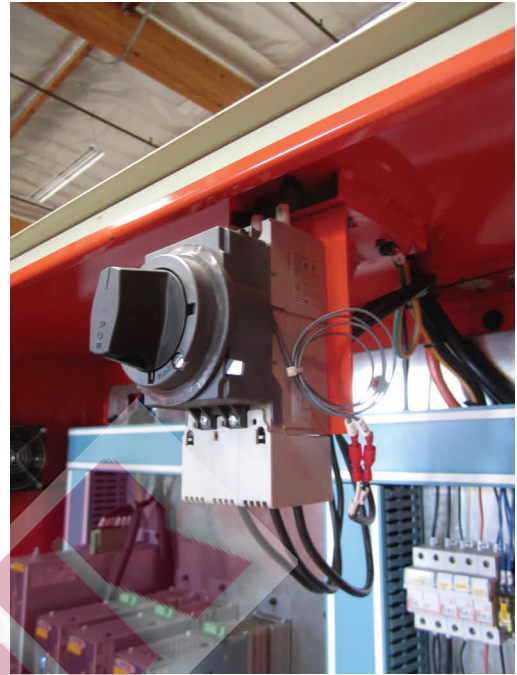
1. Set up leveling pad, screws (total 6 pieces), and leveling machine.



2. Put the control console on the arm.



3. Hook up power 230V or 460V as pre-wired by customer request.



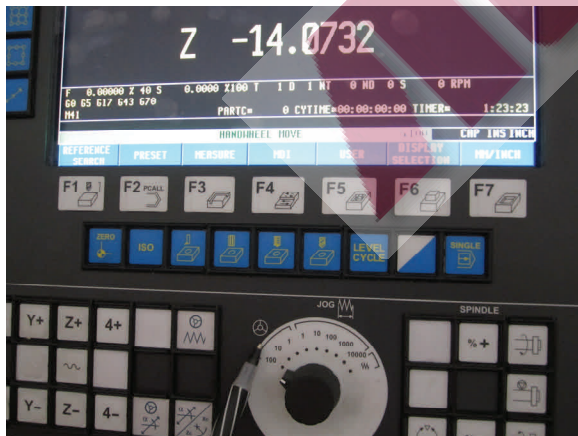
4. Hook up Air, 96 PSI.



Turn on machine. Wait 30 sec. for machine to boot up. Release Emergency button.



5. Press Jog F4, select Handwheel select one thousands (10) in incremental selector. Using the MPG and Z on axes selector. Slowly move the Z up. Remove the Spindle head support. Move the Z down. The counterbalancing weight should be up. Remove the bar.



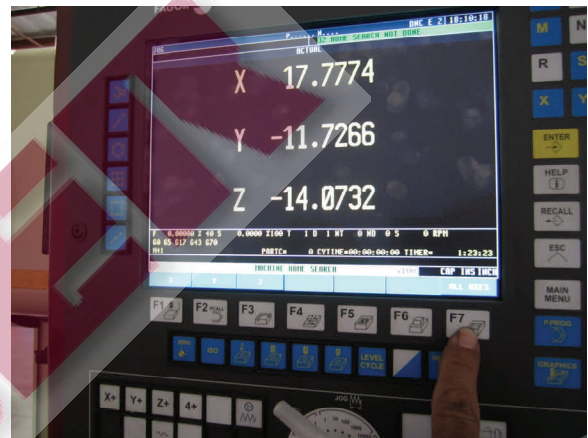
Remove Spindle Head Support



Remove Balancing Weight Supporting Bar

6. Press “Jog” (F4), then press “MDI”, (F4), then enter “M53”. Press the execute button. Watch to see if the numbers increase by one. If so, it is the correct direction. If not, shut down machine and change power source direction by swapping any of the two of the three power wires.

7. Press “ESC”. Press “Reference Search” (F1), Home, then press “All Axes” (F7). Press the execute button. **IMPORTANT: Before pressing the execute button, make sure everything is clear.** It will first home Z, Y, X, 4th Axis, then the magazine last. It will home Tool Changer to tool change to 1 position.



8. If you ordered a coolant system, assemble the coolant pipe.

