

Global / Siena / ST Series with H&L Hydraulics Revised 04/19/04

Procedure to Initially Set or Reset X Axis Zero Position

NOTE #1: At this point the following conditions are assumed to be true:

- Parameter #1815 Bit #5 = 1 (Absolute Pulse Coders - Each Axis is listed in this parameter)
 - **If this is an initial power-up, after setting this bit to 1, you must cycle power before proceeding!**
- Parameter #1815 Bit #4 = 1. (Absolute Pulse Coder Zero)
- The Axis Motor has rotated one revolution with the Absolute Pulse Coder connected, and the Main Power was cycled Off and On.

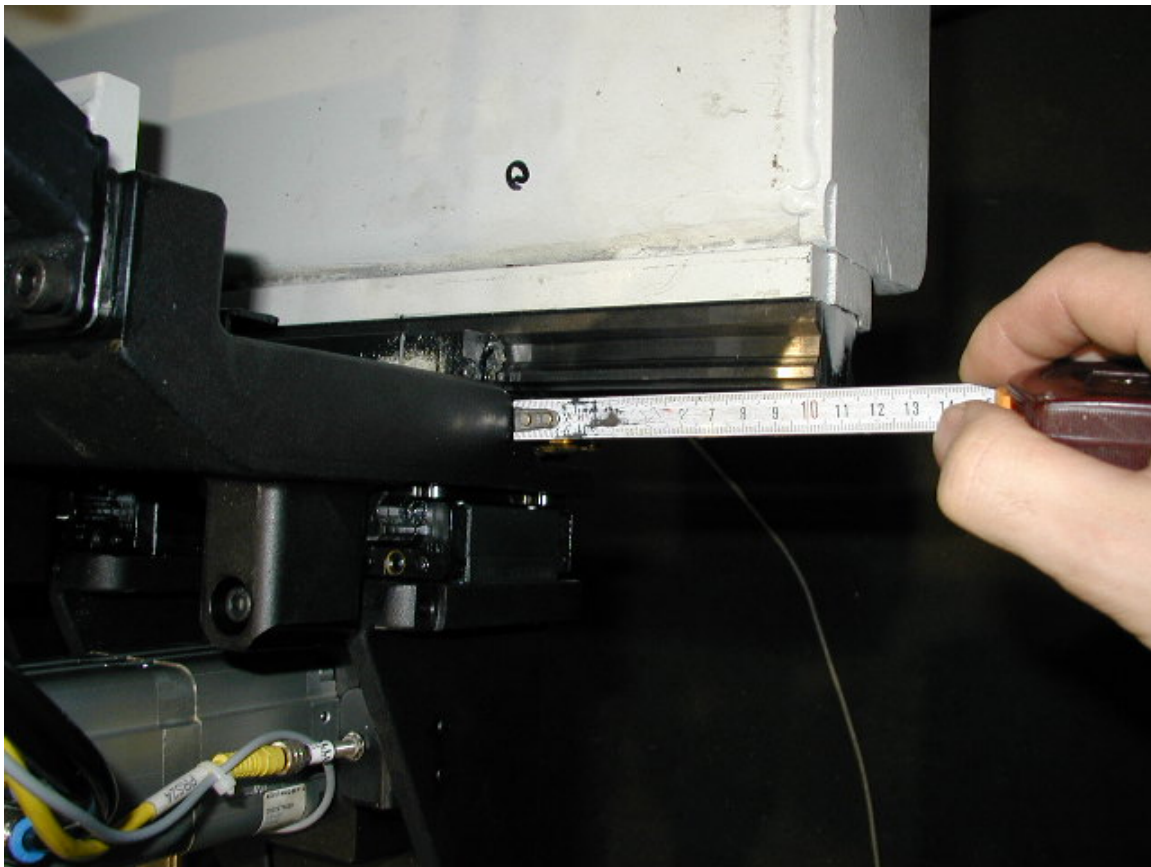
NOTE #2: Keystrokes in this procedure are indicated as follows: [Brackets] indicate a soft key, (Parentheses) indicate input from MDI Panel, "Quotations Marks" indicate input from Operator Panel.

1. Global Machines:

- a) Manually locate work clamp #1 in the first hole of carriage. (Near the side gage)
- b) Then jog or manually move the X Axis to the approximate home position, the distance between edge of clamp body and the end of the THK bar should be **100mm**. (See Picture below)

2. Siena / ST Machines:

- Jog or manually move the X Axis to the approximate home position, the distance between end of bearing block (on the side gage end) and the end of the THK bar should be **95 mm on the 1212**, and **95 mm on the 1225** model machine.



3. Place control in “**E-Stop**”.
4. Turn on the Control and set "Parameter Write Enable" parameter to ONE.
Press function key for (**OFFSET SETTING**) on the keypad of the MDI panel.
Press soft key [**SETTING**] for chapter selection, on the Display screen.
Enter "1" on the keypad, then press (**INPUT**) on the MDI panel.
Alarm P/S 100 "PARAMETER WRITE ENABLE" appears.
Press (**RESET**) to clear the 100 Alarm.
5. Enter Parameter 1815 bit #4 =0 [**APZ**] for X Axis. (**A message / alarm will appear requiring the control to be turned off ignore this alarm**).
Note: To enter a Parameter:
Select “**MDI**” Mode on the operator panel.
Press function key for (**SYSTEM**) on the keypad of the MDI panel.
Press soft key [**PARAM**] for chapter selection, on the Display screen.
Enter "1815" on the keyboard.
Press [**NO. SRH**] The display will now show Parameter “1815”
Use cursor key to select “Bit #4” [**APZ**] for X Axis
6. Enter Parameter 1815 bit #4 =1 [**APZ**] for X Axis. (A message / alarm will appear requiring the control to be turned off).
7. Turn control **OFF**, then back **ON** and clear “**E-Stop**”.
8. Press (**Reset**) to clear alarms.
9. Press the “**Home**” Push Button to zero the axis.
10. Punch a hole to determine how much the X Axis reference point must be changed via the side gauge.
11. Note: If the End Gage was moved, the correct 100mm on Global or 125 mm on Siena / ST 1212 or 300mm on the Siena / ST 1225 from the center of the first clamp to the side gauge needs to be reestablished. Go to Step 12. If the End Gage is not moved then this Axis Zero procedure is complete, move to Step 20.
12. Place control in “**E-Stop**”.
13. Enter Parameter 1815 bit #4 =0 [**APZ**] for X Axis. (A message / alarm will appear requiring the control to be turned off **DO NOT** shut down at this time).
14. Manually turn the X-axis lead screw to re-establish the correct distance from the center of the first clamp to the side gauge. See Step 1 & 2.
15. Enter Parameter 1815 bit #4 =1 [**APZ**] for X Axis.
16. Turn control **OFF**, then back **ON** and clear “**E-Stop**”.
17. Press (**Reset**) to clear alarms.
18. Press the “**Home**” Push Button
19. Punch hole to verify the correct measurement.
20. After you complete the procedure, turn “Parameter Write Enable” back to **ZERO**. See step 4.

