

# Global / Siena / ST Series with H&L Hydraulics Revised 8/20/04

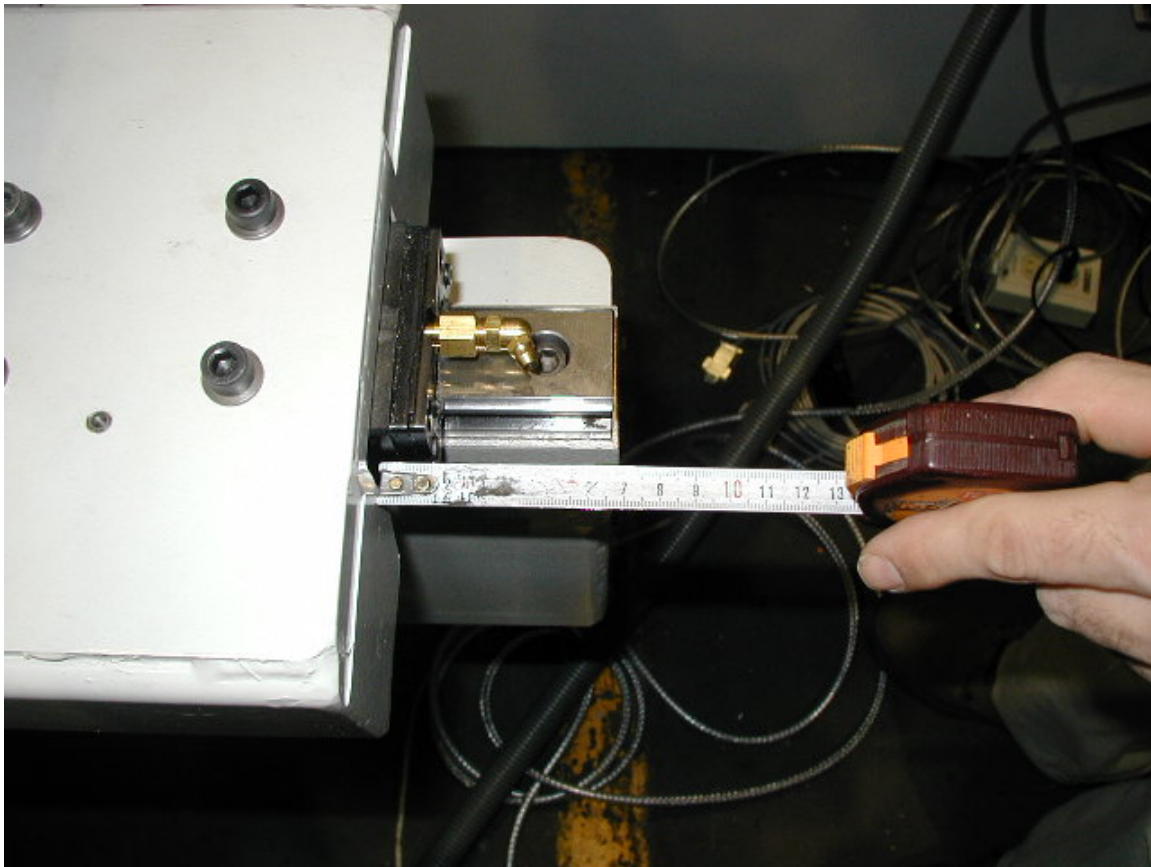
## Procedure to Initially Set or Reset Y Axis Zero Position

**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 has been 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, "Quotation Marks" indicate input from Operator Panel.

1. Jog or manually move Y to approximate home position, the distance between end of carriage (not bearing assy.) and the end of the THK bar should be **70mm** on the **Global**, & **80mm** on the **Siena / ST**. This is measured on the inner rail. (See Global Picture below).



2. Place control in "E-Stop".
3. 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.

4. Enter Parameter 1815 bit #4 =**0 [APZ]** for Y 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 Y Axis

5. Enter Parameter 1815 bit #4 =**1 [APZ]** for Y Axis. (A message / alarm will appear requiring the control to be turned off).
6. Turn control **OFF**, then back **ON** and clear "**E-Stop**".
7. Press **(Reset)** to clear alarms.
8. Press the "**Home**" Push Button to zero the axis.
9. Punch a hole to determine how much the Y Axis reference point must be changed. **Note: After you punch a hole, return the Turret to Station #1 with MDI Mode to remove the Y Axis offset before going to step 10.**
10. After punching a hole, reference the axis. The amount the punched hole must be adjusted is commanded in MDI for the Y-axis (home position +/- error). If the hole needs to be moved in the plus direction on the sheet, then a plus number is put into the commanded position (home position + error), and if the hole needs to be moved in the minus direction on the sheet, then a minus number is put into the commanded position (home position - error). Execute this correction move.  
Note: To MDI an Axis Move precede as follows:  
Press **(RESET)** button to clear any alarm.  
Select "**MDI**" mode on the Operator Panel.  
Press function key for **(PROG)** on the keypad of the MDI Panel  
Enter the **Y commanded move** for correction on the keyboard of the MDI Panel.  
Press **(EOB)**. End of block  
Press **(INSERT)** key on MDI Panel.  
Press soft key **[REWIND]** on the Display screen.  
Press "**CYCLE START**" push button on the Operator Panel.  
The Y Axis will now move to the corrected position.
11. Place control in "**E-Stop**".
12. Enter Parameter 1815 bit #4 =**0 [APZ]** for Y Axis. (A message / alarm will appear requiring the control to be turned off do **NOT** shut down at this time).
13. Enter Parameter 1815 bit #4 =**1 [APZ]** for Y Axis.
14. Turn control **OFF**, then back **ON** and clear "**E-Stop**".
15. Press **(Reset)** to clear alarms.
16. Press the "**Home**" Push Button to zero the axis.
17. Punch a hole to verify the correct Y Axis measurement.

18. After you complete the procedure, turn "Parameter Write Enable" back to **ZERO**. See step 3.