



Modified 5/03 by V. B.

1. Copy all PMC, variable and turret tool setup data before performing this procedure. Reinitializing the macro cassette will delete the aforementioned data. Thus, it will be necessary to re-enter said data.
2. Remove the punch from station #1. Later we will use station #1 (under ram) to calibrate RCM.
3. View hand entered data on your machine parameter list sheets. To check that the hand written values.
4. Set PMC parameter #610 bits 0, 1 and 7 to the value 1 (one).
 - a. Press diagnostics button <DGN>.
 - b. Press the letter "N".
 - c. Key in "610", then press <INPUT>.
 - d. Press the letter "P".
 - e. Key in "1000011", then press <INPUT>.
5. Set P-CODE variable #514 to 0 (zero).
 - a. Press the <MDI> key.
 - b. Press the <SET> key three times to display "P-Code variable" on the CRT.
 - c. Press <PAGE-DN> key until P-CODE #500 is displayed.
 - d. Press the letter "P".
 - e. Key in "0", the press <INPUT>.

6. Power off the control, leave off for approximately 30 seconds, then turn control back on.

Note: Upon control power up, the RCM initialization will commence. This takes about 4 minutes to complete. The CRT will display "Software Revision" and the feed override light will blink. The blinking light indicates that the Fanuc control is communicating with the RCM while parameters are loading. Wait until the blinking light stops blinking and the RCM parameters have loaded.

7. Power off the control, wait 30 seconds, and power back on.
8. Press the "turret override" button to load the pumps.
9. Ram Calibration (Automatic Cal) with station #1 under ram & no tool in station
 - a. Press the <MDI> button.
 - b. Press the <AUX 2> button. This will display the RAM CONTROL screen.
 - c. Key in "6", then press <INPUT>. This selects the RCM maintenance screen.
 - d. Key in "6", then press <INPUT>. This selects the RCM parameters.
 - e. Press the "CALIB" soft key.
 - f. Press the "yes" soft key.

Note: Upon pressing the "yes" soft key, the screen will display "ram calibration in progress. The ram will move slowly down to the bottom of it's stroke, and then move up to it's normal up position. It is imperative that the ram extend fully before the "ram calibration complete" message it displayed. It is therefore suggested that one person watch the ram while another person watches the screen to insure that the ram indeed reaches the bottom of stroke before the message is displayed. If the aforementioned does not occur, then the ram calibration process will not be accurate. This then may necessitate adjusting the "NULL BIAS" located on the servo valve body. This procedure however, is not within the scope of the document.

10. Set PMC parameter #610 bits 0,1 and 7 back to 0 (zero)
 - a. Press diagnostics button <DGN>.
 - b. Press the letter "N".
 - c. Key in "610", then press <INPUT>.
 - d. Press the letter "P".
 - e. Key in "0000000", then press <INPUT>.
 - f. Depress "turret override" button... Run machine and check die pen.