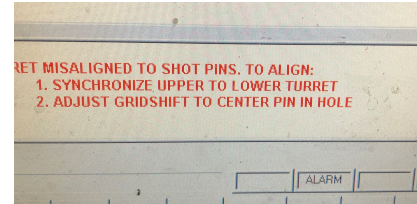


Turret alignment Global, M series, SIENNA, ST

This alarm usually follows a crash involving the turret.
It is simple to fix.



Warning hazardous conditions exist, if you are not comfortable with mechanical adjustments and the inherent dangers please call for help. CNC Machinery will not be responsible for any injury, or damage caused by this procedure. Please call if you are unsure! 888-879-5906

1. Press and lock Emergency Stop
2. Disengage Shot Pins
3. Remove rear machine cover
4. Using the proper METRIC Allen wrench loosen the 8 bolts on top turret pulley (see picture)
5. Insert Shot Pins, you will notice the turrets jumping as the pins go in. If they do not engage fully offset top or bottom turret using the belt.
6. Remove Shot Pins again, then offset top and bottom turrets slightly and reinsert Shot Pins. This step should mechanically pull both turrets into place in the SAME direction.
7. Tighten bolts from step 4, in a star pattern. Do this evenly and torque bolts to 12Nm. If you don't own a torque wrench go get one! They must be tight however over tightening will cause the bolts to break.
8. Now start machine normally and move turret to station 1. If you still have an error that won't allow movement you may be forced to move the turret manually to station 1.
9. Now we must reset the zero on the turret electrically.
 - A. Unlock Parameters as follows
 - B. Press MDI
 - C. Press Offset/Settings Key
 - D. Select SETTINGS from soft key
 - E. Change Parameter write enable to a 1 by typing P1 INPUT
 - F. You will get a parameter alarm, clear by pressing RESET
 - G. Press SYSTEM key



- H. Type N1815 NO SEARCH (careful not to hit the INPUT button here to avoid changing parameter zero to 1815)
- I. Use cursor down to go to T, then cursor right to select APZ for the Turret
- J. Type 0 (zero) INPUT. You will get an alarm, ignore it for now and press SYSTEM key.
- K. Change Turret APZ back to a 1 by typing 1 INPUT.
- L. Cycle Power
- M. Reference and verify turret moves smoothly
- N. Reset Parameter lock by pressing OFFSET/SETTING, then change the write enable back to a 0 (zero).