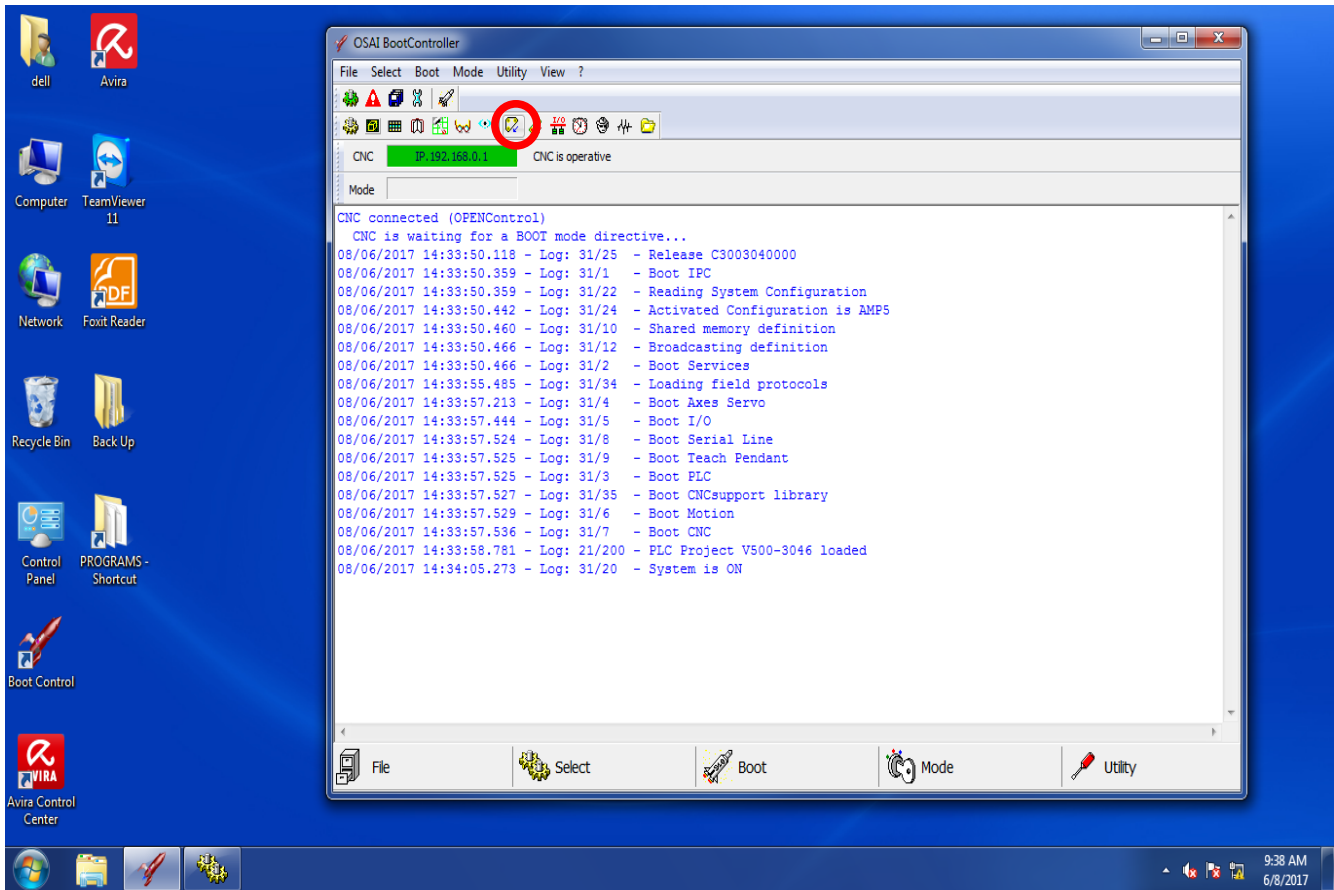
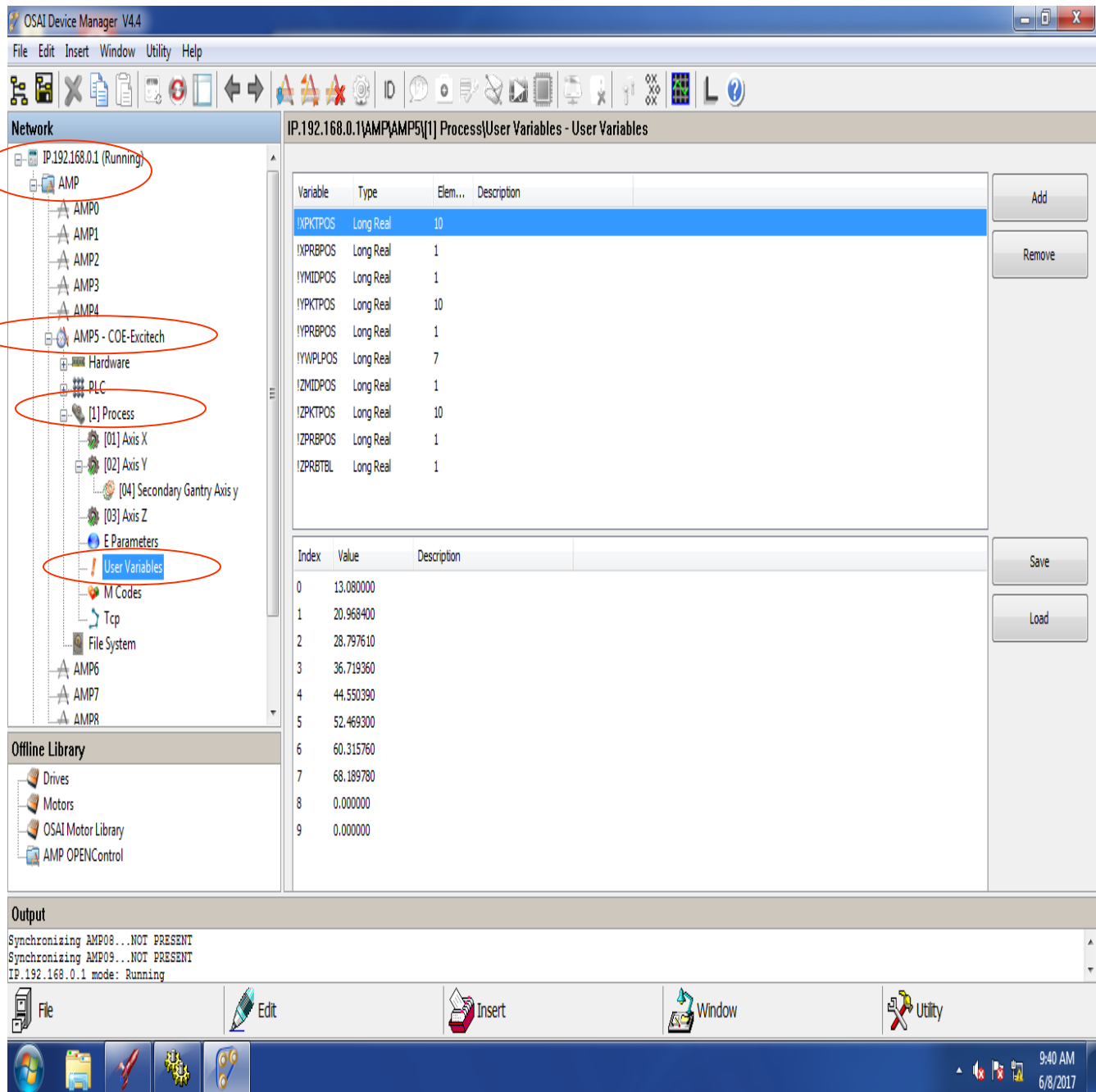


Step 1: From the Boot Control screen, click on the ODM button.



Step 2: Click the “+” option for the following variables – IP.192.168.0.1, AMP, AMP 5 (only amp depicted with a blue clock), Process. Then click on the variable labeled “User Variable”. A new screen will appear to the right of the menu displaying the tool stand locations for each tool as well as the tool touch off location (Touch pad).

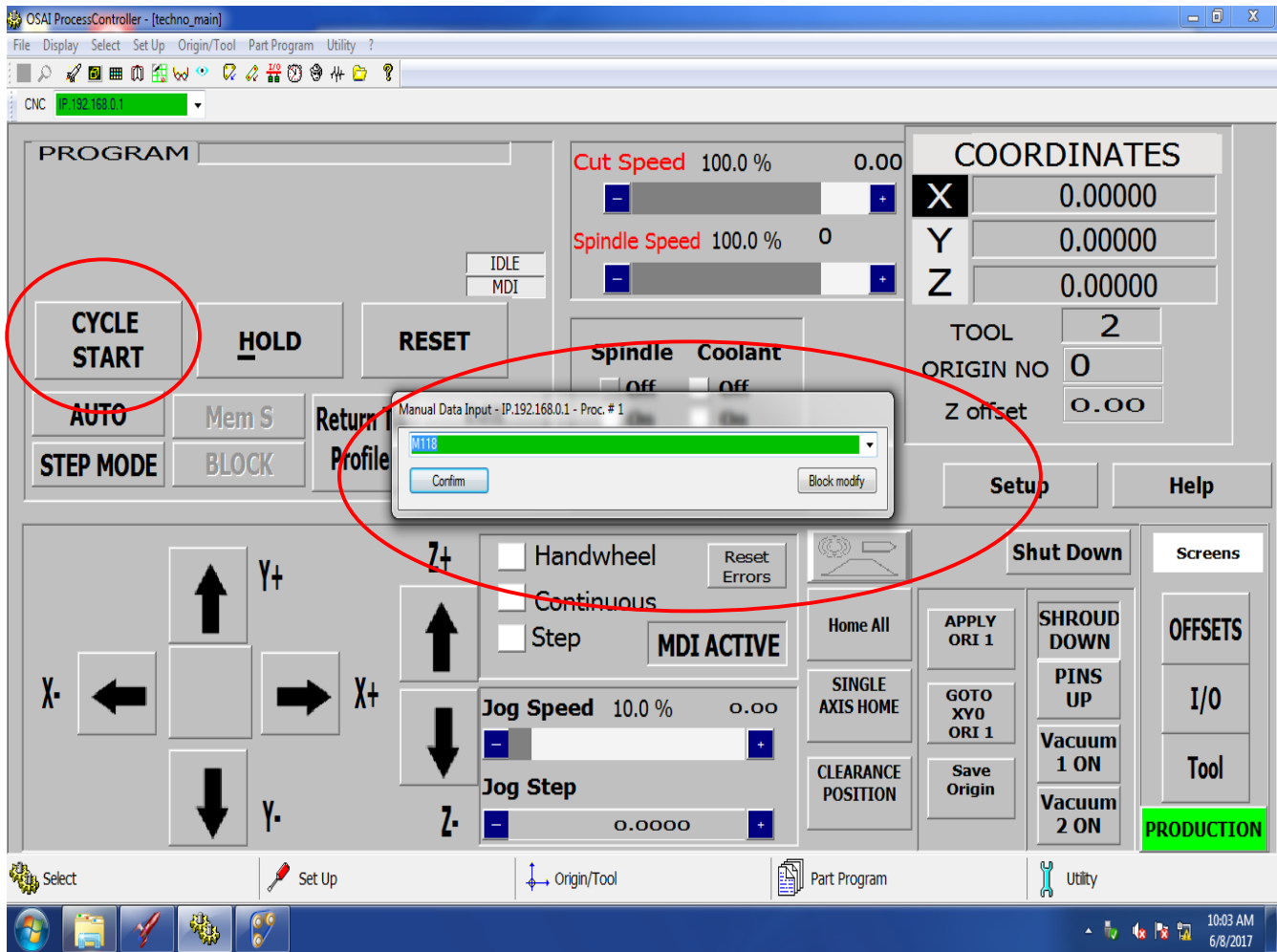


Step 3: The variables labeled !XPKTPOS, !YPKTPOS, !ZPKTPOS are the variables that will be changed in order to set new tool stand locations.

Step 4: Depending on which model machine you have will dictate how you set these new tool stand locations.

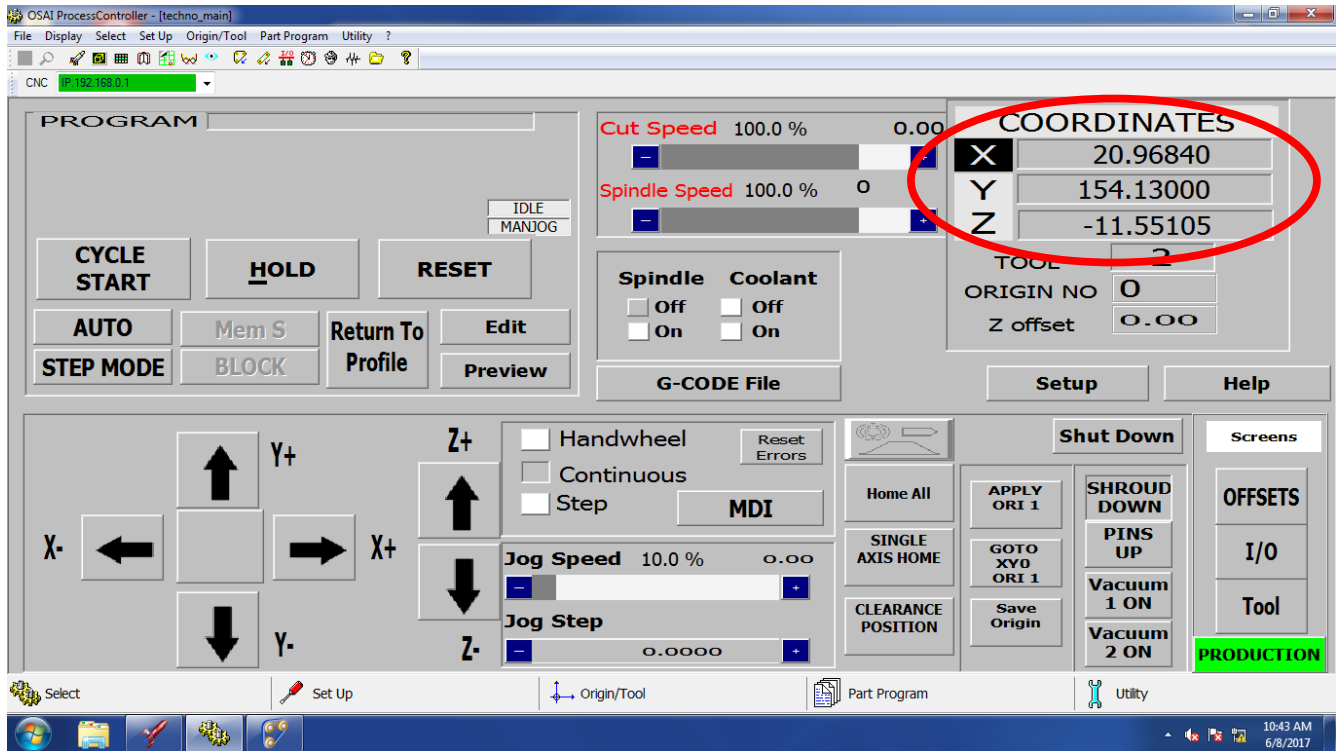
FOR HDS AND VENTURE MODEL MACHINES (Not Venture +)-

1.) Enter M118 into the MDI screen. Press “enter” on the keyboard, or “Confirm” on the screen. When the MDI screen illuminates green, click “Cycle Start”. This disables any soft limits on the machine and allows you manually jog the tool into the tool holder using the hand wheel function.



2.) Using the hand wheel function, slowly and safely jog the tool into the tool stand. Once you have the tool holder in the desired position in the tool stand, record the x,y, and z coordinates displayed at the top right hand corner of the interface.

HOW TO CHANGE TOOL STAND LOCATIONS – OPEN SERIES



3.) Once you have recorded the coordinates you must enter said coordinates into the correct !PKTPOS variables shown on step 4 of this document.

4.) Though we refer to the tool stand as 1-8 from left to right, the machine refers to them as 0-7:

0 = tool 1,

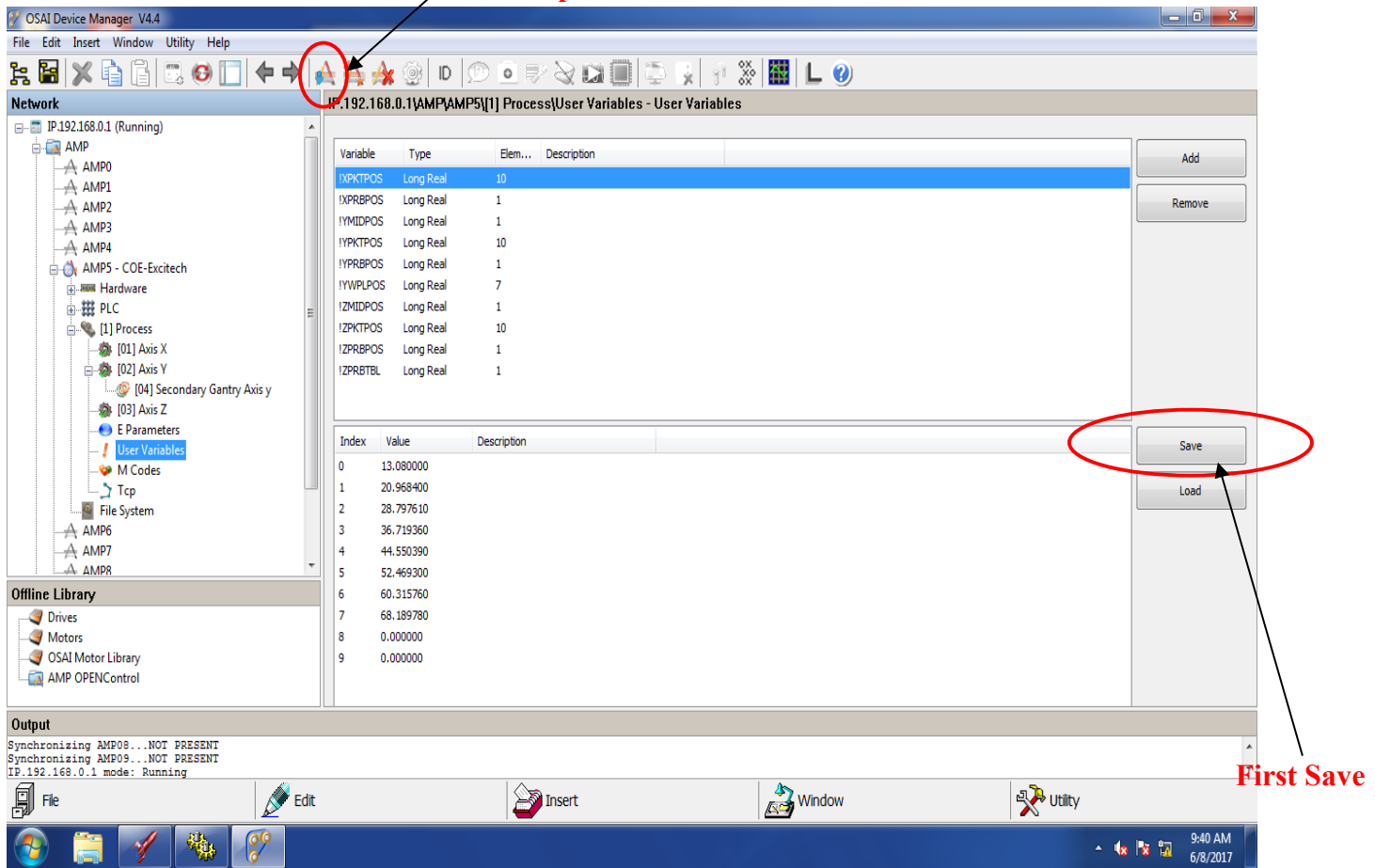
1 = tool 2

2 = tool 3

etc...

5.) Once you have recorded and entered the desired coordinate values, you must click “save” and then “compile AMP” on the screen.

Then Compile AMP

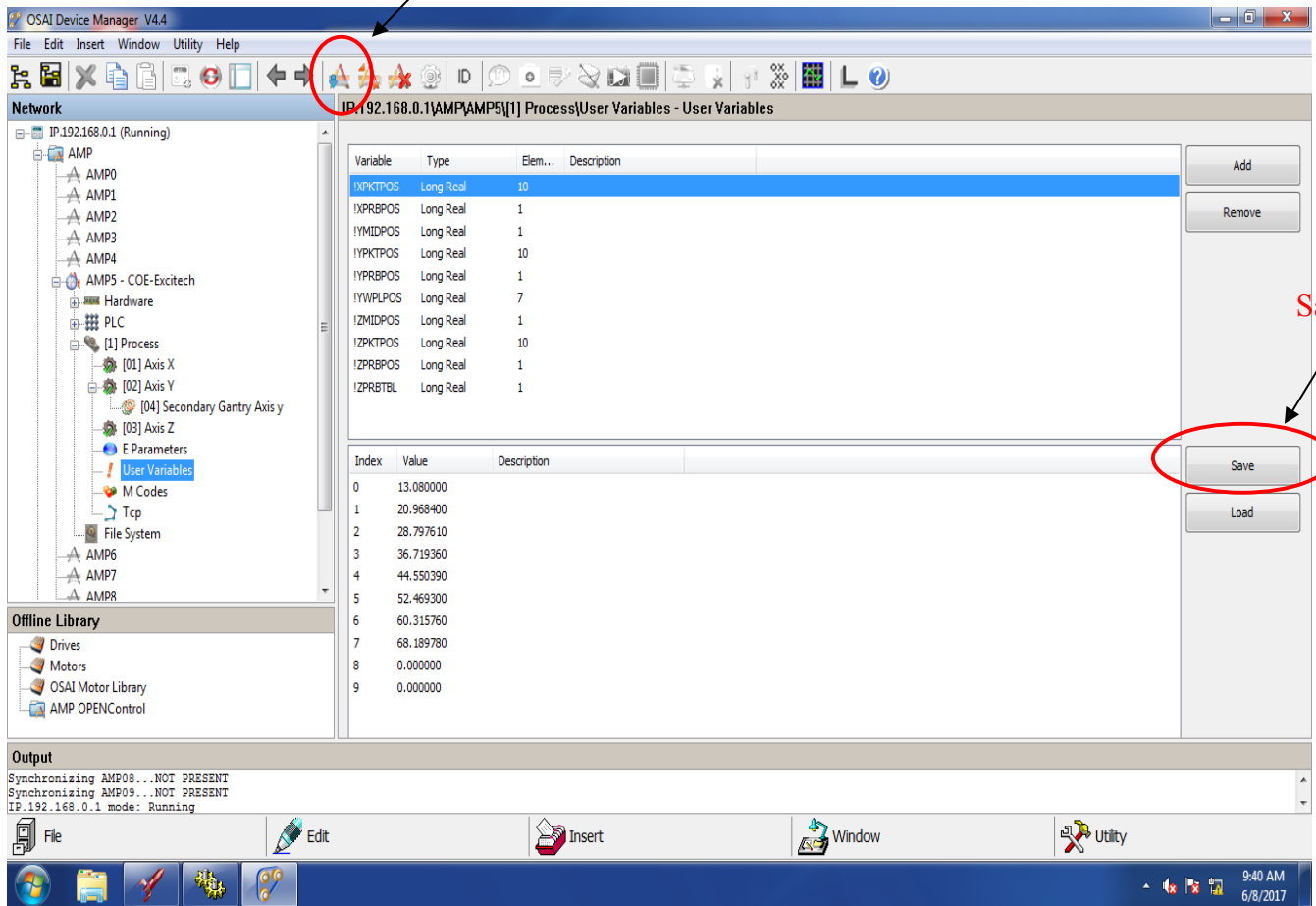


6.) Once the information has been compiled, the machine needs to be rebooted, You can do this from the boot control screen by pressing the “rocket ship” icon and then restarting, or just by simply going through the proper shut down procedure and then the proper start up procedure.

FOR VENTURE + MODEL -

- 1.) First measure how off the tool is during a tool change. The only changes we need to make are to the z-axis since the Venture + does not use x or y axes to perform tool changes.
- 2.) After measuring, you can change the value for the z-axis (!ZPKTPOS) for all 8 tools (0 – 7 on User Variable screen).
- 3.) Once you have made your changes to the tool stand positions, click “save” and then “compile AMP”.

Compile AMP



6.) Once you have successfully saved and compiled your new values, you must restart the OSAI controller. In order to do so, you can click on the rocket ship icon on the boot control screen and select to restart, or you can simply go through the proper shut down procedure for the machine followed by the proper start up procedure.