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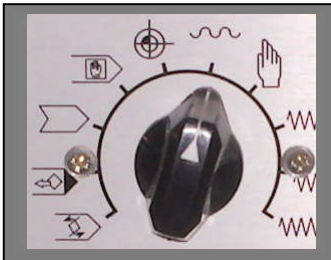
Technical Subject: Recovering from a Tool Jamb (TM1 Backward Sensor)



Why did this happen?

Low Air Pressure!
Dirty HSK Tool Holders!
Dirty Dust shroud!

The number cause of this is dirty tool holders. The tool holders should be inspected and cleaned daily. The dust shroud should also be cleaned daily. When a tool change takes place the ATC travels under the brushes and dust is allowed to drop down on the tool holders.



Step 1: Place Machine in JOG Mode

Step 2: Press the GEAR GOG Button

The ATC should now be retracted

Step 3: Press the BLUE Reset button

All alarms should now be cleared.



After clearing the TM1 Backward alarm you may need to PRESET the tool changer or ATC.

Place Machine in MDI mode, at this point you will want to make a note of what tool is loaded in the spindle and what tool position is directly in front of the spindle. If T101 or T11 is loaded in the spindle and position T101 or T11 is directly in front of the spindle the code would be entered as follows:

If you have a 10 position ATC use these codes:

M94 T110; (enter) (references the tool changer)

M97 T110; (enter) (references the spindle)

If no tool is in spindle use T100

Press CYCLE START, if everything checks out you will not get any alarms and you will not see any movement. Your machine should be ready to run.

If you have a 8 position ATC use these codes:

M94 T11; (enter) (references the tool changer)

M97 T11; (enter) (references the spindle)

If no tool is in spindle use T10

Press CYCLE START, if everything checks out you will not get any alarms and you will not see any movement. Your machine should be ready to run