

## Set spindle orientation for swing arm atc

1. Open electrical cabinet.
2. Turn on power. No tool in the spindle
3. Home machine (press **Cycle Start** for machine home)
4. Come back electrical cabinet. At Delta inverter VE, press **MODE** twice (LED "U" is on). You will see the number; this number is for spindle encoder count.
5. Press **Emergency Stop**



6. Now, we need two people  
 Person A climbs up to magazine. Pull the release brake motor arm to the left, one hand uses 12mm socket on the motor shaft to turn clockwise until the arm rotates toward to the spindle.



Person B rotates the spindle by hand until the "spindle key" is lined up in the key slot of the tool. (Mark spindle at this position)



7. At inverter, record this number and enter it in **parameter 10-19** and press **Prog/Data** to save.
8. Person A; Turn counter clockwise until the arm returns to original position. (The middle light on).  
Remove the socket out and pull the brake motor back to right side.
9. Release **Emergency Stop**
10. Check "Spindle orientation" M19.  
Press "F3 –MDI " type M19 under auto spindle select. Press **Cycle start** checks spindle orientation same position that you marked.

### **How to set Delta inverter**

Each Delta inverter parameter has 2 set of numbers.? Example: 01-02? We will call 01 "Group Parameter, and 02 "Parameter Number.

1. Press "PROG"
2. Press the up or down arrow key to select the group parameter.
3. Press "PROG"
4. Press the up or down arrow key to select the parameter number.
5. Press "PROG" At this time parameter value should be blinking. Use arrow key to change the value.
6. Press "PROG" again to save parameter values or "MODE" to discard  
Press "Prog/Data" → group 00 → use arrow key UP → 10- → enter "Prog/Data" → 10-00 → arrow key UP → 10-19 enter "Prog/Data" → use arrow key to change the value, and then press "Prog/Data" to save.  
Press "MODE" to come back Frequency command (F led is on)