THE EXCELLENT MACHINE
ATRUMP

ATC changes to manual tool change

Machine ATC has encoder, cable encoder, pg card…if one of them is bad, it could not do ATC. You want to run program while you are waiting for the new part to replace. Here are some steps to do let machine run with manual tool change.

1. Parameter #6 changes 1 to 0.
2. Rename file [cnc10.m6] to another name like as [***cnc10.m6].
   F7 [Utility] → F5 [File Opt] → go to directory C:\cnc10 or [..] Enter. Highlight cnc10.m6, press F7 [Rename] change to the new name and Enter.
3. Delta Inverter VFD-VE.
   Parameter 00-10 changes 3 to 0
   (3 : FOC Vector control + Encoder)
   (0 : V/F control)