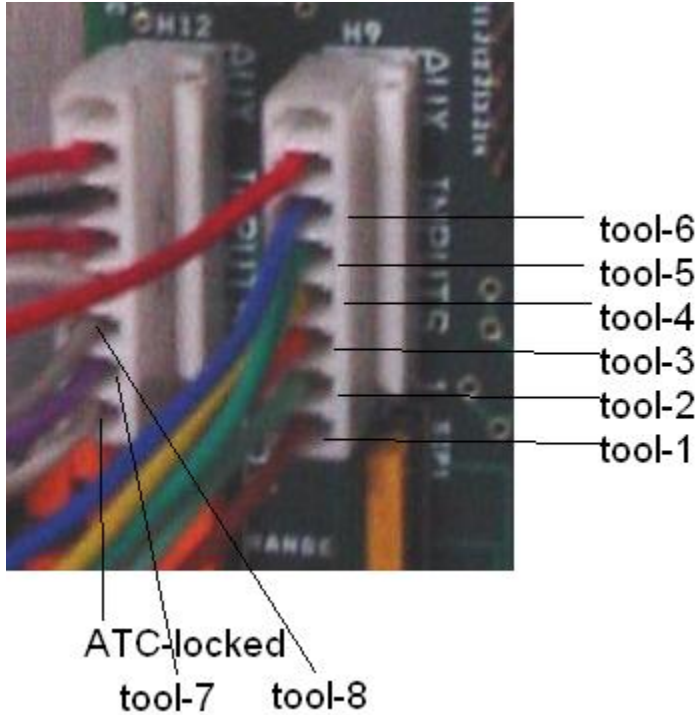


Install 8 position turret

0 V (black -wire 802) connects to TB3-4B.

24 V (red -wire 801) connects to TB3-5B.

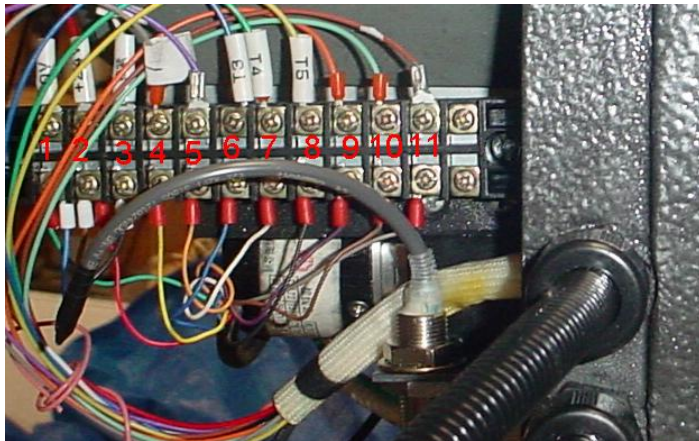
This is a picture below showing wires inside electrical cabinet.



Wires from dc3io to turret: Depends on turret mounting at rear or front.

1. Rear mounting

Inside turret terminal from left to right : 0v ,24v, atc locked and tool 1, 2,3,...to 8



2. Front mounting

If the turret is front mounting, the wires connect different.

Terminal #	1	2	3	4	5
Description	0v	24v	atc locked	5	6

Terminal #	6	7	8	9	10	11
Description	7	8	1	2	3	4

3. Parameter

Parameter 6 changes to 1.

Parameter 1 set 1 or 0 (front or rear mounting).

Parameter 170 change to 4 for KL-21xx and KL-30xx series.

Parameter 170 change to 12 for KL16xx series.

File "CNC10.tch.bak" should be renamed to "cnc10.tch" you can rename a file name by going to F7 <utility> -> F5 <file OP.> -> highlight the file you wish you change its name. -> F7 <Rename>.