

Using tool number more than 16 tools in the magazine

The Magazine has 16 bins for 16 tools. You use auto tool change to change the tool between T1 and T16. If you want to use Tool #17, 18 ..., you have to change it manually.

1. Offset tool all the tools that you use. (Height offset “H” and diameter “D”).
2. You are using tool #16 and want to change tool #17.

Under G code of the program, after tool #16 finishes its job, we add some lines.

Example:

M6 T16

Z4 (move the head up)

M5

M00 (stop for operator)

Press **Tool check** button

Press **Unclamp/clamp** to change the tool #16 to tool #17

Press **Cycle start** to continuous

G43 H17 (the control is still using T 16 with tool offset is T17 (H17, D 17)

G41/42 D17

Z4

M5

M00

Change back to T16.

M6 T1

M30