

# KIRA TECH TIP

## Tool Magazine Zero Position Setting Procedure (Alarm #2007)

- Turn on “Parameter Write Enable” (PWE)
- Move “Z” axis to tool change position (may need to adjust parameter #1320)
- Turn on Keep Relay K16.5 (cycle stop button should blink)
- Edit Mode
- Edit key off
- SYSTEM / right ARROW key 2x’s / PMM / POS
- Use Jog button & Feed switch to jog Magazine (must jog until ATC button lights)
- Indicate #1 tool pocket if necessary
- Turn on Edit key
- Press ATC button
- Lower “Z” axis (from over travel condition)
- Turn off NC power
- Turn on NC power
- SYSTEM / right ARROW key 2x’s / PMM / SYSTEM / PARAM
- Change Parameter 11.0 = 1
- Turn off Main power
- Turn on Machine
- Return parameter #1320 to original number (if used)
- Turn off (PWE)