



The Next Generation in High Speed Production Centers

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TRIWAY / MERIDIAN
E-STOP RECOVERY FROM TOOL CHANGER

Tool Change Stops in Mid-Cycle for E-Stop

- 1. Restart Machine, Remove tools from the change arm**
- 2. MDI Mode**
- 3. Turn On <Parameter Write Enable>**
- 4. Go to Keep Relay 16**
- 5. Enter <1111> <Input>**
- 6. Press <Cycle Start> and Coolant Buttons Simultaneously**
- 7. Both Lights will blink**
- 8. Press either button to move arm**
- 9. <Cycle Start> is CCW – Coolant is CW**
- 10. Press <Cycle Start> until the arm stops moving**
- 11. Alarm will go away with reset**
- 12. Zero Return Machine**
- 13. Call up the selected tools that were removed from the machine.**
- 14. Insert the proper tool into the spindle**

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