

Setting spindle orientation for carousel ATC with Delta VE

1. Open electrical cabinet.
2. Turn on power. No tool in the spindle
3. Home machine (press **Cycle Start** for machine home)
4. Come back electrical cabinet. At Delta inverter VE, press **MODE** twice (LED “U” is on). You will see the number; this number is for spindle encoder count.



Jog Panel showing location of Aux 12.

5. Bring the carouse in with M80, while holding **Aux 12**. (MDI type M80 and hold **Aux12** on the top of MPG key, and press **cycle start**)
6. Removed retention knob of the tool, and put it in carousel.
7. Slowly jog the Z axis down and rotate the spindle by hand until the “spindle key” is lined up in the key slot of the tool. Using incremental 0.0010 jog Z down to position that spindle touch slightly the tool.
8. At inverter, record this number and enter it in parameter 10-19 for Delta VE.
9. Set Z -axis position value into Work Coordinate System (G30).