

## Referencing the Tool Rack home position

If the tool rack is moved either for maintenance reasons or due to a crash, the tool-rack's home position needs to be set. The home position is measured from the center of the position of T1. Please follow the procedure to ensure proper alignment of the tool rack.

- 1) Attach an indicator the spindle head/Z-axis linear guide ways (if using a magnetic base)
- 2) Measure the right side of the tool rack and adjust its position until there is less than 0.1 mm (0.004") of error between T1 and the last tool on the same row.
- 3) Tighten the screws of the tool rack and re-measure.
- 4) Remove the indicator and place a tool holder inside the spindle.
- 5) Manually move the machine to center the tool holder with the position of T1 in the X and Y axis.
- 6) Move down in increments of 0.1 mm (0.01") on the Z axis until the tool holder begins to push down on the tool rack, then move up 0.5 mm or 0.01"
- 7) Go to the parameters window located under the Set-up tab.
- 8) Input the password 1588 in the right side of the parameters window.
- 9) Press the Home Tool Measure button located on the lower left side of the parameters window. The new position can be read next to Tool 1 Machine Position and it is denoted by X\_\_\_\_\_ Y\_\_\_\_\_ Z\_\_\_\_\_.
- 10) You can manually make changes to each position. Note that the position numbers are read in mm.
- 11) Perform numerous tool changes with different tool positions to make sure that the tool rack is aligned.