

Accessory Installation Guide

12-station Automatic Tool Changer

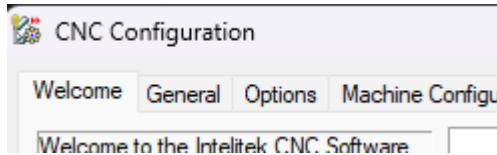
Accessory Name	Column Mounted 12-station Automatic Tool Changer
Applicable to	ProMill 8000

1 Configure the Software

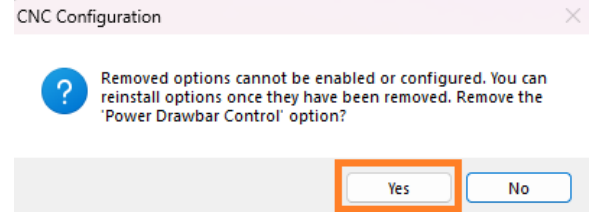
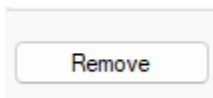
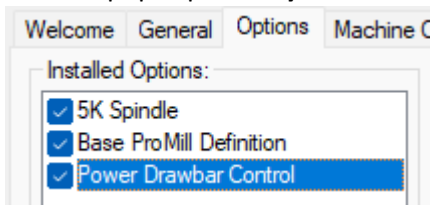
1. Click **Start** → **All Programs** → **CNCBase for Intelitek CNC** → **CNC Configuration**.



2. Click the **Options** tab.



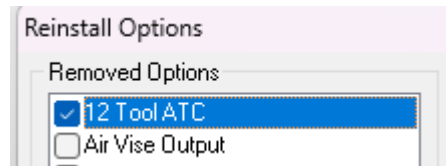
3. Select **Power Drawbar Control** and select **Remove** and when the confirmation window pops up select **yes**.



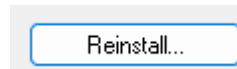
4. Click **Reinstall**.



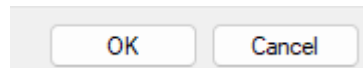
5. Select **12 Tool ATC**.



6. Click **Reinstall**.

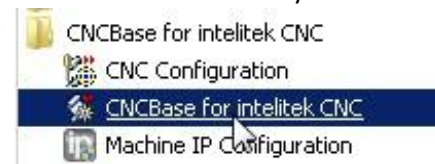


7. Click **OK** to close CNCBase



2 Initialize Tool Station 1

1. Home the machine
2. Place up to 12 tool holders in the ATC carousel.
3. Remove any tool holder from the spindle.
4. Launch CNCBase from your Start menu.



5. Jog the Z-Axis above the tool holders in the ATC.

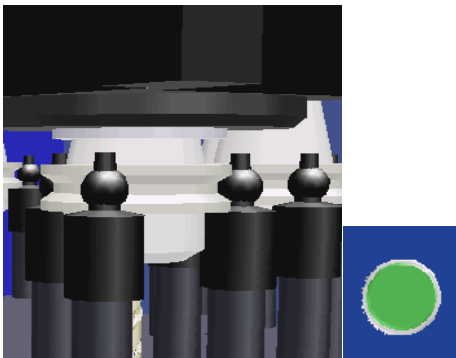
6. Goto **Tools** → **Operate ATC...** or click the **Red Wrench**.



7. Click **Platter Out**, the platter should extend under the spindle.

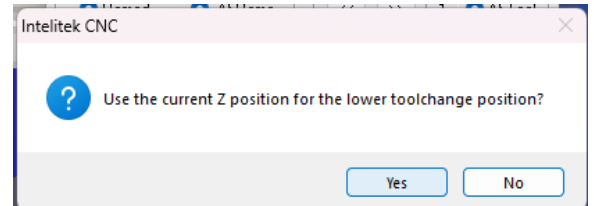
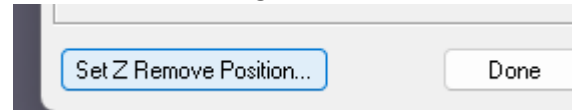


8. **Click Done**
9. Slowly lower the spindle over the tool holder for Station 1. The tool holder should be centered in the spindle. Watch the gap between the spindle and the tool holder. positioning accordingly.
10. When the spindle is $\frac{3}{4}$ of the way down over the tool holder, open the drawbar by pressing the green button.



11. Release the **green button** and the tool should “**jump**” up into the spindle. If it does not, hold the green button and lower the Z a little more and try again.

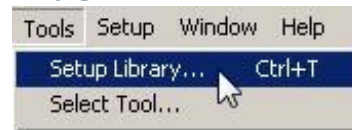
12. Once the tool is in the spindle, open the **Configure ATC** dialog. (Step 6) Then click **Set Z Remove Position** and select Yes in the confirmation dialog. Then click **Done**.



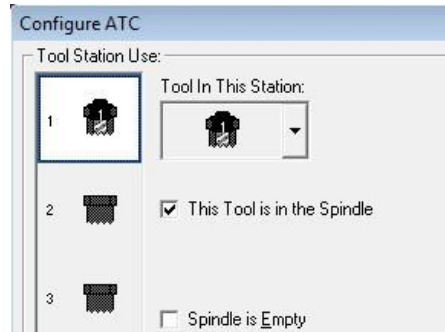
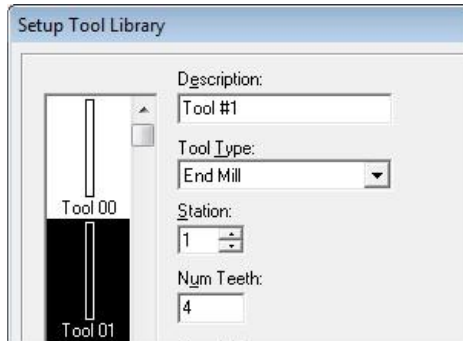
13. Move the Z Up until the tool holder clears the holding pins. Go back into **Operate ATC** (Step 6) and select **Platter In** and **Done**.



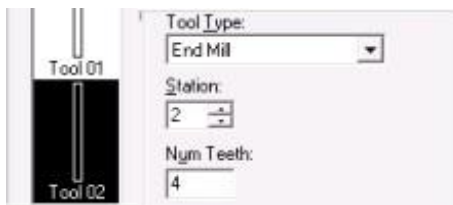
3 Configure the Tool Library



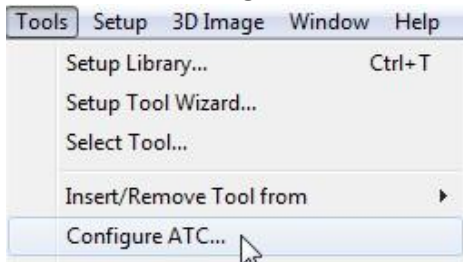
1. Select **Tool 01** from the list at the right.
2. Set **Tool Type** to **End Mill**. Set **Station** to **1**.



3. Select **Tool 02** from the list on the right.
4. Set *Tool Type* to **End Mill**.
5. Continue this process for each tool making sure the Tool and Station number match.

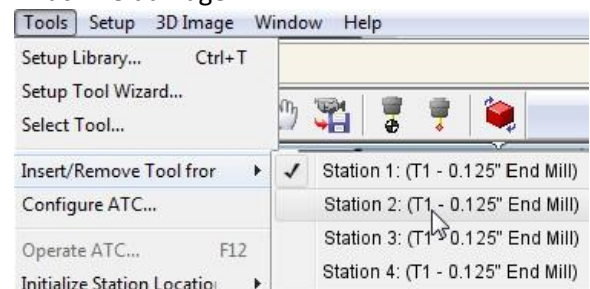


6. Click **Tools → Configure ATC**.



7. Select station **1** from the *Tool Station Use* drop-down menu.
8. From the *Tool in This Station* drop-down menu, select tool **1**. Check *This Tool is in the Spindle*.

9. Select station **2** from the *Tool Station Use* drop-down menu.
10. From the *Tool in This Station* drop-down menu, select tool **2**.
11. Do not check *This Tool is in the Spindle*.
12. Repeat steps 12- 14 for stations 3 through 12.
13. Click **OK**.
14. Place tool holders in stations 2, 3 and 4 in the ATC.
15. Click **Tools → Insert/Remove Tool from**.
16. Click **Station 2**. This will start machine movement to insert tool 1 in the ATC and remove tool 2 from the ATC. Keep your hand on the E-stop button so that you can stop the machine to prevent crashes and machine damage.



17. Click **Tools → Insert/Remove Tool from**.
18. Click **Station 3**. This will start machine movement to insert tool 2 in the ATC and remove tool 3 from the ATC. Keep your hand on the E-stop button so that you can

stop the machine to prevent crashes and machine damage.

19. Repeat these steps for each station that has a tool.

Installation complete.