

Accessory Installation Guide Table-Mounted 4-station Automatic Tool Changer

Accessory Name	Table Mounted 4-station Automatic Tool Changer
Accessory P/N	011131
Applicable to	BenchMill 6000 ProMill 8000

1 Additional Requirements

To complete this installation you will require:

- 17mm wrench

2 Unpacking Instructions

1. Remove the automatic tool changer (ATC) assembly from the packaging.

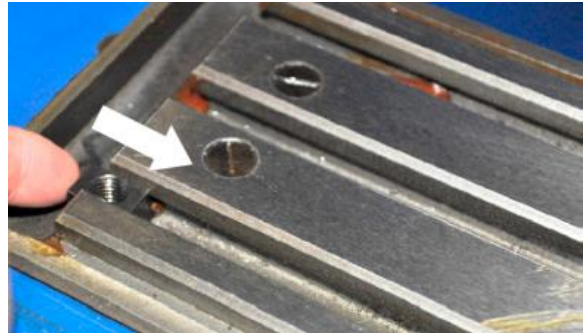


2. Remove the two bolts, two T-nuts, and two washers from the assembly.



3 Mounting the ATC on the Cross-slide

1. Slide one T-nut into the cross-slide along the front slot.



2. Slide the second T-nut down the rear slot of the cross-slide.
3. Line up both T-nuts.
4. Place the ATC on the table such that its mounting holes line up with the two T-nuts.
5. Place the washers over the mounting holes.
6. Loosely screw the bolts through the mounting holes into the T-nuts.



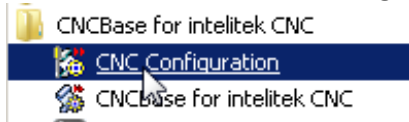
7. To ensure that the ATC is located within the machine's work envelope, carefully jog the table to its limit at the side on which the ATC is being mounted.
8. Ensure that the spindle is able to reach the outer edge of the ATC.
9. Tighten the ATC bolts using the 17mm wrench.

The picture below shows the ATC installed on the BenchMill 6000.

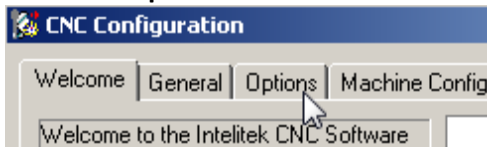


4 Configure the Software

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



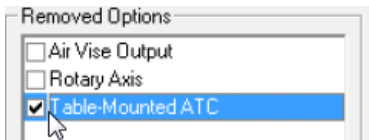
2. Click the **Options** tab.



3. Click **Reinstall**.



4. Select **Table-Mounted ATC**.



5. Click **Reinstall**.

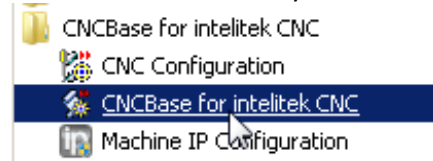


6. Click **OK** to close CNCBase

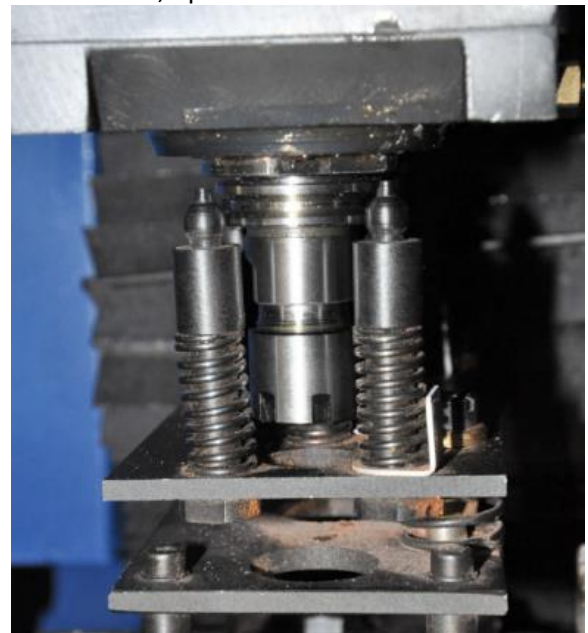


5 Initialize Tool Stations

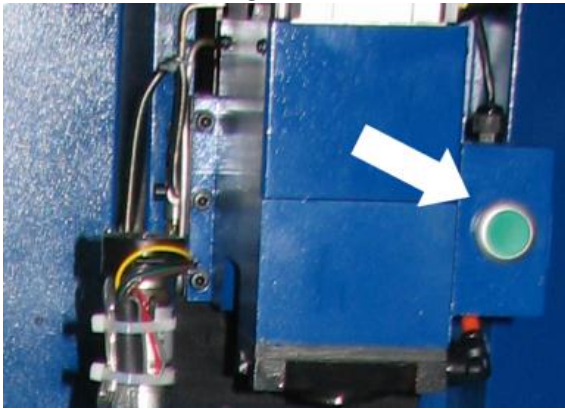
1. Home the machine
2. Place four tool holders in the ATC.
3. Remove any tool holder from the spindle.
4. Launch CNCBase from your Start menu.



5. Jog the spindle over station 1 (front location) on the ATC.
6. 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. Adjust the cross-slide's x and y positioning accordingly.
7. When the spindle is half way down the tool holder, open the drawbar.



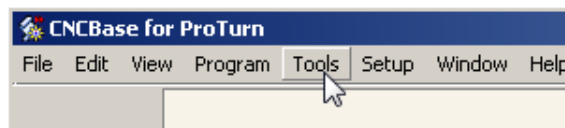
- Press and hold the green drawbar button.



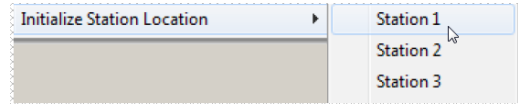
With the drawbar button being pushed to hold the drawbar open, continue to lower the spindle over the tool holder. Continue to make X and Y axis adjustments keeping the spindle centered on the tool holder. When the springs just start to collapse, stop movement of the Z axis. Release the drawbar button to clamp the tool.



- In CNCBase click **Tools** in the main menu.



- Click **Initialize Station Location**, and select **Station 1**.



- You will be asked to confirm initialization. Click **Yes**.
- Repeat the process for the other three stations.

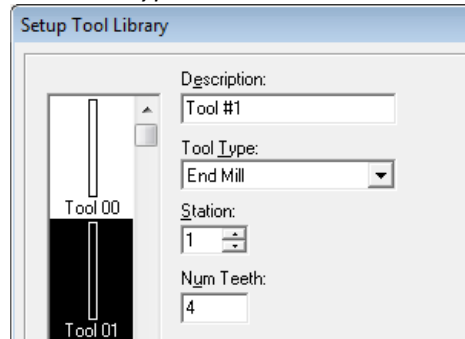
6 Testing ATC Configuration

Start this process with tool holder 1 in the spindle. Make sure that pocket 1 in the ATC is empty.

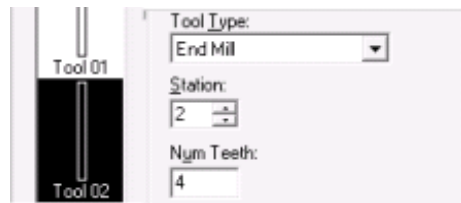
- In CNCBase click **Tools** → **Setup Library**.



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

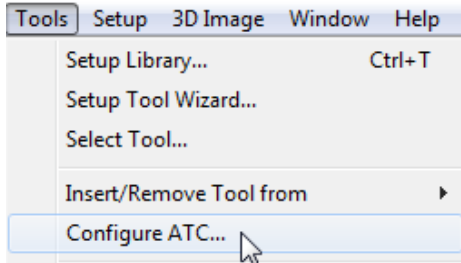


- Select **Tool 02** from the list at the right.
- Set **Tool Type** to **End Mill**.
- Set **Station** to **2**.

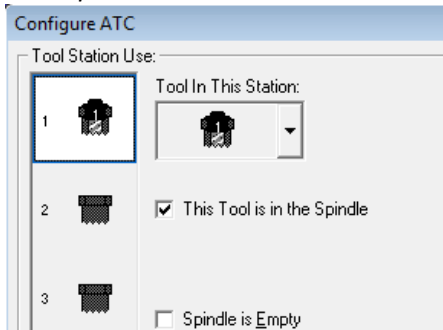


- Repeat for Tool 03.

8. Repeat for Tool 04.
9. Click **Tools** → **Configure ATC**.

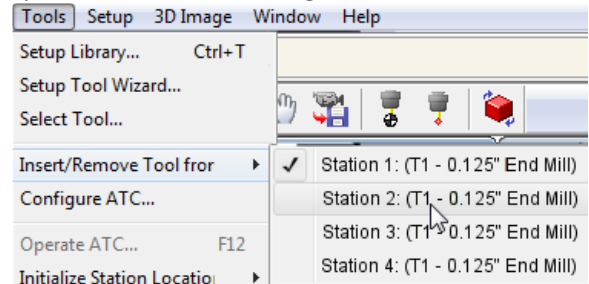


10. Select station **1** from the *Tool Station Use* drop-down menu.
11. From the *Tool in This Station* drop-down menu, select tool **1**. Check *This Tool is in the Spindle*.



12. Select station **2** from the *Tool Station Use* drop-down menu.
13. From the *Tool in This Station* drop-down menu, select tool **2**.
14. Do not check *This Tool is in the Spindle*.
15. Repeat steps 12- 14 for stations 3 and 4.
16. Click **OK**.
17. Place tool holders in stations 2, 3 and 4 in the ATC.
18. Click **Tools** → **Insert/Remove Tool from**.

19. 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 possible machine damage.



20. Click **Tools** → **Insert/Remove Tool from**.
21. 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 possible machine damage.
22. Click **Tools** → **Insert/Remove Tool from**.
23. Click **Station 4**. This will start machine movement to insert tool 3 in the ATC and remove tool 4 from the ATC. Keep your hand on the E-stop button so that you can stop the machine to prevent crashes and possible machine damage.

Installation complete.