



Next Generation Control - Reverse Rotary Direction Setup

Scan code to get the latest version of this document



Translation Available

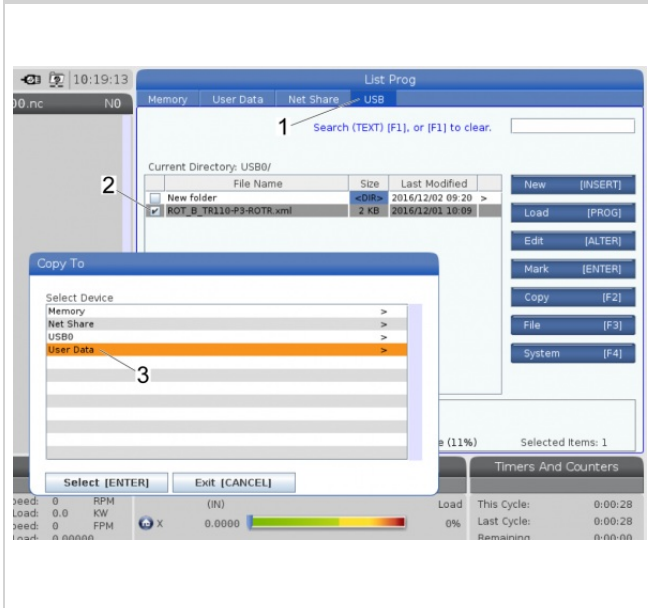


Next Generation Control - Reverse Rotary Direction Setup

This procedure tells you how to load rotary files to reverse the rotary direction of your Haas rotary configuration. The files supplied only apply to available Haas rotaries.

This procedure is applicable only to Haas rotaries on machines with software version 100.16.000.1030 and higher.

STEP 1



Download and extract the reverse rotary direction files. Refer to [Next Generation Control - Reverse Rotary Direction Files](#).

Find your rotary model in the extracted folder and copy it to a USB memory device.

Insert the USB memory device with the rotary configuration file into the USB port on the control pendant.



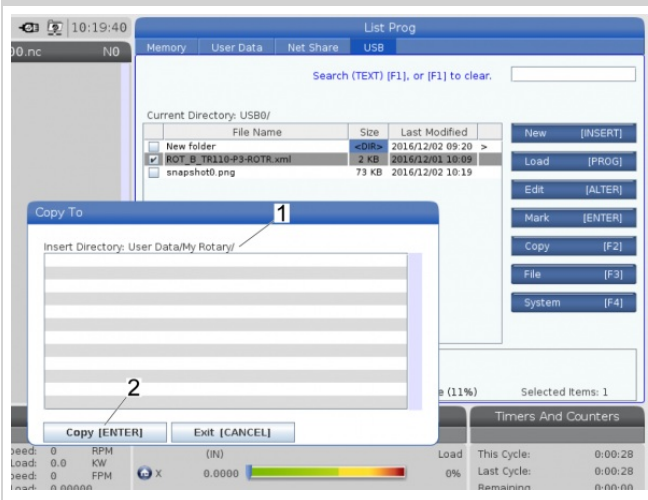
Press **[LIST PROGRAM]** and navigate to the **USB** tab [1].

Select your reverse rotary file [2]. Press **[ENTER]**. The reverse rotary files have an **R** at the end of the file name.

Press **[F2]** to copy the reverse rotary file.

Navigate to **User Data** [3] on the **Copy To** screen.

STEP 2



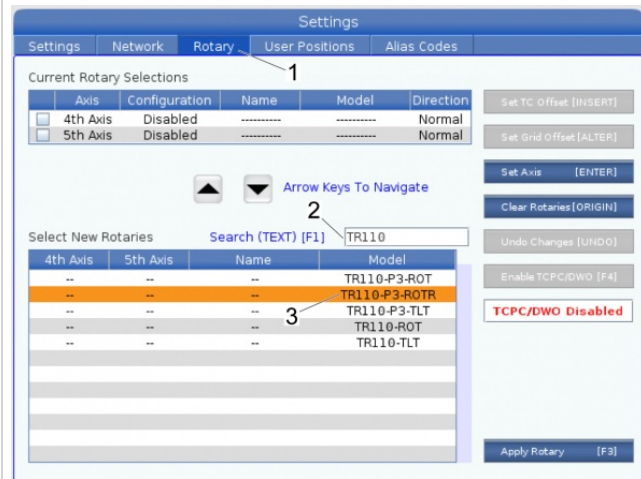
Press the **[RIGHT] CURSOR** arrow to enter the **User Data** directory.

Navigate to the **My Rotary** directory.

Press the **[RIGHT] CURSOR** arrow to enter the **My Rotary** directory [1].

Press **[ENTER]** [2] to copy the rotary configuration file to this location.

STEP 3



Press **[SETTING]**.

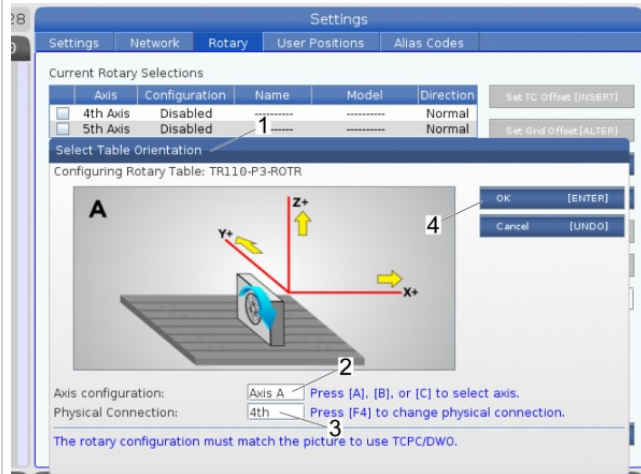
Navigate to the **Rotary** tab [1].

Type the model of your rotary and press **[F1]** to search. This example uses TR110 [2]. The reverse rotary files have an **R** at the end of the file name.

Your reverse rotary file [3] is in the **Select New Rotaries** page.

Press **[ENTER]** to **Set Axis**.

STEP 4



The **Select Table Orientation** [1] screen shows.



Press **[A]**, **[B]**, or **[C]** to select the **Axis Configuration** [2].

Press **[F4]** to change the physical connection [3].

For this example the **Axis Configuration** is **Axis A** [2] and the **Physical Connection** is the **4th** axis [3].



Note: The rotary direction must match the rotary direction on the image to use Tool Center Point Control (TCPC, G234) or Dynamic Work Offset (DWO, G254).



Press **[ENTER]** [4].

Press **[F3]** to **Apply Rotary**.

Cycle the power on the machine when you are prompted.

[HANDLE JOG] the axis to make sure it operates correctly.