



Rotary - TR/TRT/T5C - Platter Parameter 212 - Horizontal Adjustment

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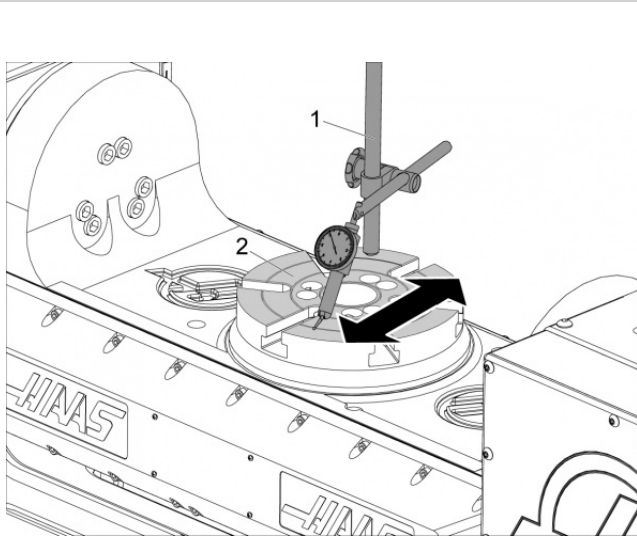


Translation Available

Rotary - TR/TRT/T5C - Platter Parameter 212 - Horizontal Adjustment

This procedure tells you how to make the platter parallel to the Y-Axis movement. You change Parameter 212 to make the platter parallel.

STEP 1



Push **ZERO RETURN**. Push **A**.

Put the magnetic base of a dial indicator on the spindle head.



Jog the X axis to center the platter on the spindle. Jog the Y and Z axis until the indicator is above the platter edge. Make sure you can indicate the full diameter from front to back.

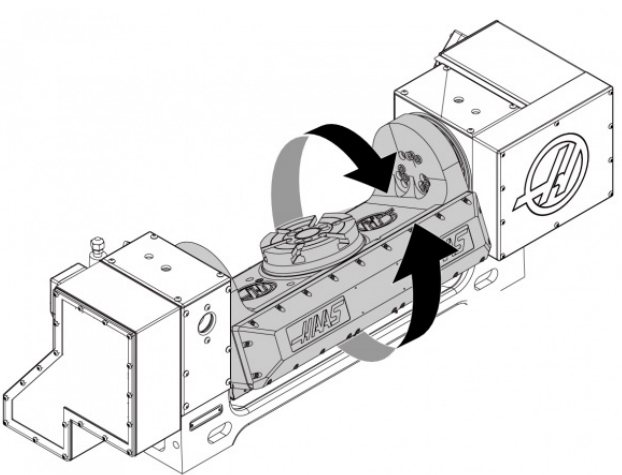
Set the indicator to zero. Indicate the platter or collet face along the Y Axis. If the error is more than 0.0003" (0.008mm) adjust Parameter 212 in small increments in the positive (+) or negative (-) direction to adjust the flatness.



Push **ZERO RETURN**. Push **A**.

Do this step again until the error is less than 0.0003" (0.008mm).

STEP 2



Release **[EMERGENCY STOP]**.

To make sure the travel limits of the A axis are correct **[HANDLE JOG]** in the positive and the negative direction. Make sure the movement stops at 120 degrees in each direction.



Caution: Stop jogging the axis if the A axis (tilt) moves more than 120 degrees. Make sure that Setting **30 4TH AXIS ENABLE** and Setting **78 5TH AXIS ENABLE** are correct. If the settings are correct and the A axis (tilt) still moves more than 120 degrees, speak to your Haas Factory Outlet (HFO).