

CNC MILLING MACHINE TROUBLE SHOOTING**1. Trouble Shooting**

| No | Trouble | | Solution |
|----|-------------------------------|---------------------------------|--|
| 1 | Tool magazine(Umbrella type) | Noise for tool changing | 1. Check the air pressure 2. Check the milling chuck pull stud model 3. Check the cylindrical travel 4. Check the oil input. |
| | | Can't change the tool | 1. Check the air pressure 2. Check the tool magazine manually, if can't move, check the circuit breaker 3. Check if tool magazine motor phase is right or not 4. Check if the limit switch of tool loosening is in right position 5. Check if the sensor switch is right or not 6. Check if the tools is hit or the reference point is changing, adjust 3-axis parameter according to P 2038(MITSUBISHI) or P1241(FANUC). |
| | | Tool number in chaos | 1. Check if the motor phase 2. Reset the tool magazine, and re-perform the procedure. |
| | | Tool magazine keep rotation | 1. Adjust the tool counter |
| | | Tool magazine not drawing back. | 1.Set Feed Rate knob as 0 under HANDWHEEL model, press RESET to get the tool magazine back. |
| 2 | Trouble Shoot (Arm type) | Noise for tool changing | 1. Check the air pressure 2. Check the milling chuck pull stud model 3. Check the cylindrical travel 4. Adjust the second reference position, spindle positioning angle, spindle tool positioning, spindle tool switch positioning etc. |
| | | Can't change the tool | 1.Check the air pressure 2.Check the tool magazine manually, if can't move, check the circuit breaker 3.Check if tool magazine motor phase is right or not 4. Check if the brake is too tight or too loosen 5.Check the tool sleeve's tolerance 6.Arm not back to zero, adjust the arm screw to ZERO point, when the power on is ok. |
| | | Tool magazine not | 1.Set Feed Rate knob as 0 under HANDWHEEL model, press |