Tecno Wasino JJ-1 Turret Zero Point Setting Procedure - FANUC 18i-TB

Procedure Overview

This procedure will guide you through resetting the zero point on the Tecno Wasino JJ-1's servo-controlled turret using the FANUC 18i-TB controller. Follow each step precisely to avoid errors and ensure correct turret operation.

Steps

1. **Do a full shutdown at control and main PWR and wait 30sec to boot again.**

2. **Select the Turret Side:**
   Use the L/R select switch to choose the side you're working on:
   L-side for the left turret
   R-side for the right turret

3. **Switch to MDI Mode**

4. **Enable Parameter Writing:**
   Press the OFFSET/SETTING key, then press [SETTING].
   Set PARAMETER WRITE to 1 to enable parameter changes.

5. **Clear the Alarm:**
   Press RESET and CAN at the same time to clear it.

6. **Set the Turret Station Number:**
   In system goto the pmc/counter area
   Set according to LeftHand Or RightHand Side:
   LH: C40
   RH: C80
   Ensure that the preset counter is set to the amount of total stations on the turret (typically 8)
   Also ensure that the current tool counter is set to 0

7. **Enter Maintenance Mode for the Selected Turret:**
   Goto KeepRelays
   Set according to LeftHand Or RightHand Side:
   LH: K16.0=1
   RH: K16.1=1

8. **Unclamp the Turret Head:**
   Press the Reference Point Return button to allow unclamping
   Use the +Z jog button to fully unclamp the turret head.

9. **Adjust the Turret Position:**
   Use the +X or -X jog button to rotate at least 1 revolution at first
   Turn Down The Feed Rate to lowest increment above 0
   Continue using +X & -X to align T1 into position
   Clamp the Turret Head Using -Z
   Verify Clamping:
   Check that the turret head is securely clamped.
   If the turret does not clamp correctly, unclamp and keep trying until we get T1 properly re-clamped

10. **Power Cycle the CNC @ controller (off for at least 3 sec):**

11. **Select the Turret Side:**
    Use the L/R select switch to choose the side you're working on:
    L-side for the left turret
    R-side for the right turret

12. **Switch to MDI Mode**

13. **Enable Parameter Writing:**
    Press the OFFSET/SETTING key, then press [SETTING].
    Set PARAMETER WRITE to 1 to enable parameter changes.

14. **Clear the Alarm:**
    Press RESET and CAN at the same time to clear it.

15. **Enter Maintenance Mode for the Selected Turret:**
    Goto KeepRelays
    Set according to LeftHand Or RightHand Side:
    LH: K16.0=1
    RH: K16.1=1

16. **Final Zero Point Confirmation:**
    Press the Reference Point Return button to allow unclamping
    Use the +Z jog button to fully unclamp the turret head.
    Use the -Z jog buttons to reclamp it now.
    Now hold down [-Z | REF | Turret(LH -OR- RH)] for about 2s to set the zero point for station T1.

17. **Final Power Cycle:**
    Do a full shutdown at control and main PWR and wait 30sec to boot again.
    Hold in [Reset | CAN] while booting up until fully booted
    Home All Axis's
    Put Machine In RH or LH (whichever you have been working on)

18. **Test Turret Indexing:**
    Test manual indexing by pressing the Turret(LH -OR- RH) button.
    Now Test automatic indexing, use a T-code command in MDI mode to confirm correct movement.
    Example MDI Command= T0808
    Test both clockwise and counterclockwise indexing to ensure smooth movement and secure clamping at each position.
    Example MDI Command= T0202

    When operating correctly, PMC COUNTERs c40/c80 "Current" should change as you index manually.