

Tool Change File calls

- 1) Custom1 (manual tool change from input box)
 - a) ATC_change.SBP
 - i) ATC_Load_All_Values.sbp
 - (1) Custom 90
 - (a) my_variables.sbc
 - (2) Custom 89
 - (a) ATC_Local_Data\ATC_Variables.sbc
 - (b) ATC_Local_Data\ATC_Tool_Variables.sbc
 - ii) ATC_restore_settings.sbp
- 2) Custom 9 (used with-in a file)
 - i) ATC.sbp
 - (1) ATC_Load_All_Values.sbp
 - (a) Custom 90
 - (i) my_variables.sbc
 - (b) Custom 89
 - (i) ATC_Local_Data\ATC_Variables.sbc
 - (ii) ATC_Local_Data\ATC_Tool_Variables.sbc
 - (2) ATC_check_statUS.sbp
 - (a) ATC_restore_settings.sbp
 - (3) ATC_Write_Tool_Variables.sbp
 - (4) ATC_restore_settings.sbp
 - (5) Custom 88

Files used

- 1) Custom1------(manual tool change from input box)
- 2) Custom 9 ----- (Tool change from with-in a file)
- 3) Custom 90 ----- (loads the my_variables file)
- 4) Custom 89 ----- (loads ATC variables)
- 5) Custom 88 ----- (Sets speed variables)
- 6) Custom 6 ----- (Spindle On)
- 7) Custom 7------(Spindle Off)
- 8) ATC_Load_All_Values.sbp ----- (Calls CN,90 and CN,89)
- 9) ATC_change.SBP----- (Called from CN1 for manual tool change)
- 10) ATC_Local_Data\ATC_Variables.sbc ----- (Variables for clip locations)
- 11) ATC_Local_Data\ATC_Tool_Variables.sbc -(variables used to set X,Y and Zero)
- 12) ATC_restore_settings.sbp ----- (Turns file limit Checking on)
- 13) ATC.sbp ----- (Main file for tool change)
- 14) ATC_check_statUS.sbp----- (Checks Status of ATC example: is tool in spindle)
- 15) ATC_Write_Tool_Variables.sbp (Writes Variables to ATC_Tool_Variables.sbc file)
- 16) my_variables.sbc (All user variables)
- 17) ZzeroATC ----- (used with movable Z plate does not update table base)

Files Used For Setup

- 1) Custom 72 -----calls ATC_Zzero
- 2) Custom 74-----calls ATC_calibrate
- 3) ATC_calibrate -----Calibrates clip locations
- 4) ATC_FixZ_Plate-----Sets location of fixed Z plate
- 5) ATC_Zzero -----Zero tools in clips