

Tool-Changer-Magazine

These setting options are only visible subject to activation of the automatic tool changer in *Basic Settings-Accessories*.

	X	Y	Z
1	+ 1.00	+ 1.00	+ 0.00
2	+ 5.00	+ 1.00	+ 0.00
3	+ 9.00	+ 1.00	+ 0.00
4	+ 13.00	+ 1.00	+ 0.00
5	+ 17.00	+ 1.00	+ 0.00
6	+ 0.00	+ 0.00	+ 0.00
7	+ 0.00	+ 0.00	+ 0.00
8	+ 0.00	+ 0.00	+ 0.00
9	+ 0.00	+ 0.00	+ 0.00
10	+ 0.00	+ 0.00	+ 0.00

☐ No Z lift at ATC ☐ No move back to last pos.

OK Abort Save...

Parameter-Tools-Changer-Magazine

Controlling the automatic changer

WinPC-NC can control an automatic tool changer with 10 magazine positions. The exact magazine positions of the magazine locations are defined in this parameter window.

It is recommended to define the changing positions with short distance to the actual pick up and the remaining distance with simple moving commands in the macros for putting down and picking up.

An electrically or pneumatically operated collect chuck is required in order for tools to be changed automatically. This chuck must be switched using a defined output. Macros can be used to define the exact sequence of releasing and picking up tools as well as movements, waiting times and switching outputs.

The procedure is described in a subsequent chapter.

Parameters for the automatic tool changer ATC are only available if the function is enabled..

Moved tool magazines, for instance retractable cabinets or circular magazines, can be controlled via 4th axes only by **WinPC-NC Professional**.

No Z lift at ATC

Movements in the tool changer normally cause a move all the way up to the zero position. If you think that these moves are too high or too long in time, you have the option to suppress it by this parameter switch.

Please take greatest care that there is no collision with the components of the tool changer by suppressed Z zero move.

No move back to last position

Approaching to the last park position or tool changer **WinPC-NC** always remembers the previous position and moves to it again. This often results in unnecessary movements and is not desirable. This switch prevents a move to the last position.