

# **TB121 (Rev1) - Lathe Setting Up The T400 For Front or Rear Mounted Tooling**

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## **Overview**

This document details the procedure used to configure the T400 control for either front or rear mounted tooling. This is a three-step process. The first step determines if you have the correct jog panel overlay. The second step configures direction reversal for the X-axis. The third step configures the display orientation for the back plot, part and tool graphics to reflect either front or rear mounted tooling.

**IMPORTANT: This procedure does NOT apply to the T15.** The procedure for the T15 control is covered in TB122

## **Procedure**

1. Jog Panel Overlay Selection:

- a.) If you are using rear mounted tooling, the upward facing arrow should be labeled as "X+"
- b.) If you are using front mounted tooling, The upward facing arrow should be labeled as "X-"

**Note: If these labels are incorrect, contact Centroid to purchase the correct overlay.**

2. X Axis Direction Reversal Configuration:

- 1. Standing in front of the lathe, set the jog speed to slow and push the jog key with the upward facing arrow. The table should move away from you, **if this is correct go to Step #3**
- 2. From the main screen, press **F1 - Setup**, **F3 - Config**, **F2 - Mach.**, and **F2 - Motor**. Use the arrow keys to select the column for dir rev (direction reversal) for the X-axis and press the space key to toggle the selection from "N" to "Y" or vice versa. Press **F10 - Save**. Repeat Step #2

3. Display Configuration:

From the main screen, press **F1 - Setup**, **F3 - Config**, and **F3 - Parm.**

- 1. If you are using rear mounted tooling, Parameter #1 should be set to **0**
- 2. If you are using front mounted tooling, Parameter #1 should be set to **1**
- 3. Press **F10 - Save** to save changes.

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## **Document History**

Rev1 Created on **2001-04-03**