

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

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.

Document History

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