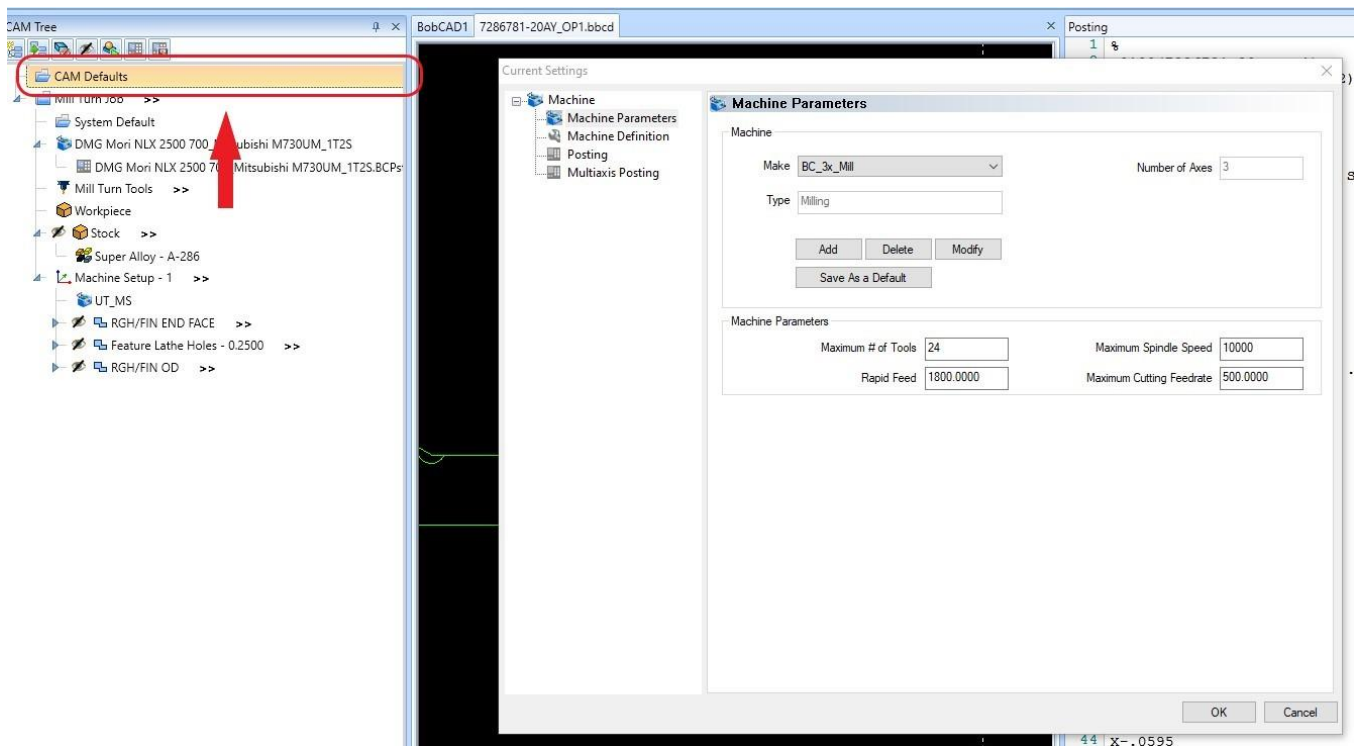


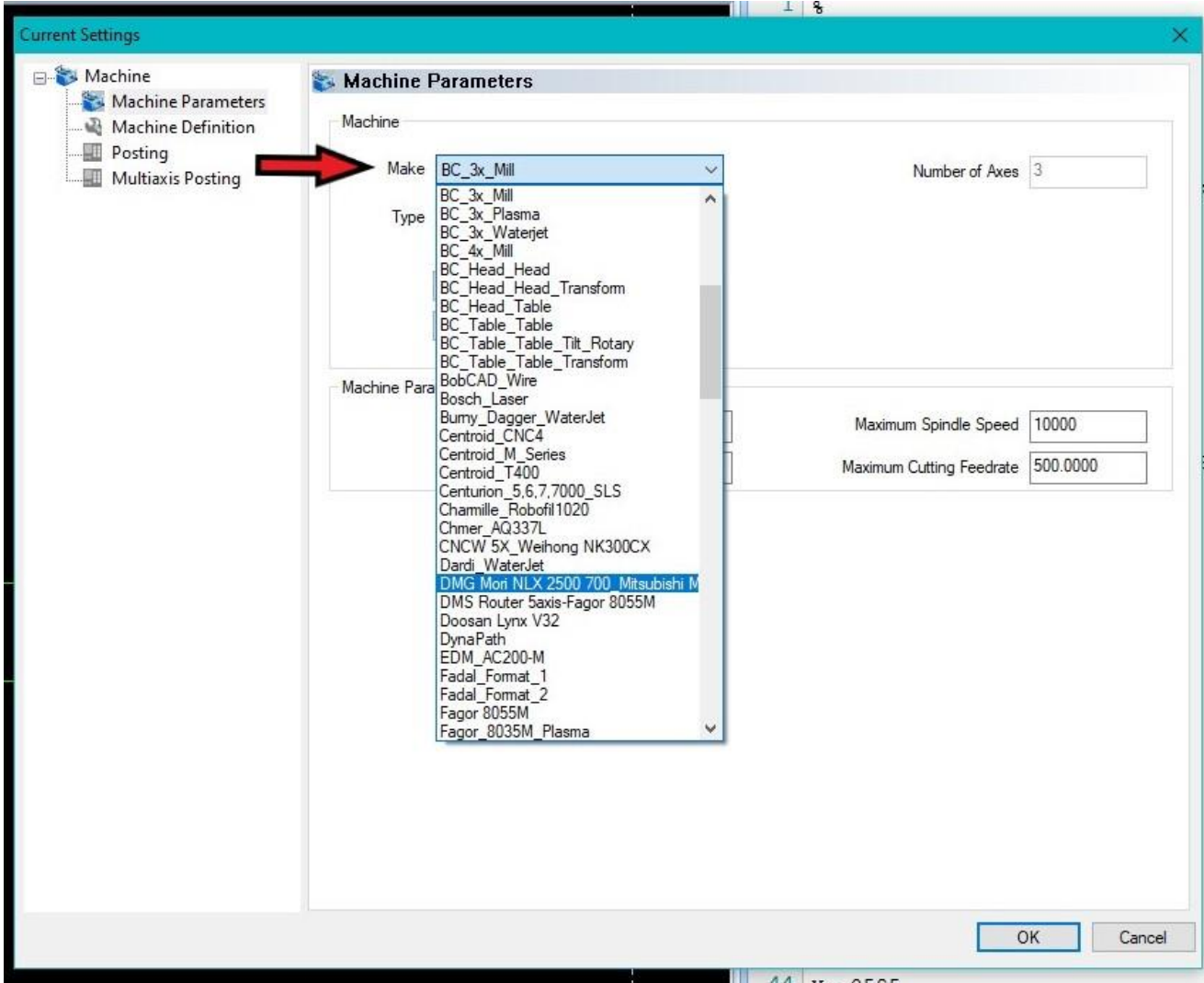
Reversing the Mill-Turn Machine Spindle Rotation Directions

In the following pages of this document, steps are listed to reverse the main-spindle rotation directions for the Mill-Turn machines. The same steps apply to reverse the Sub-Spindle rotation direction.

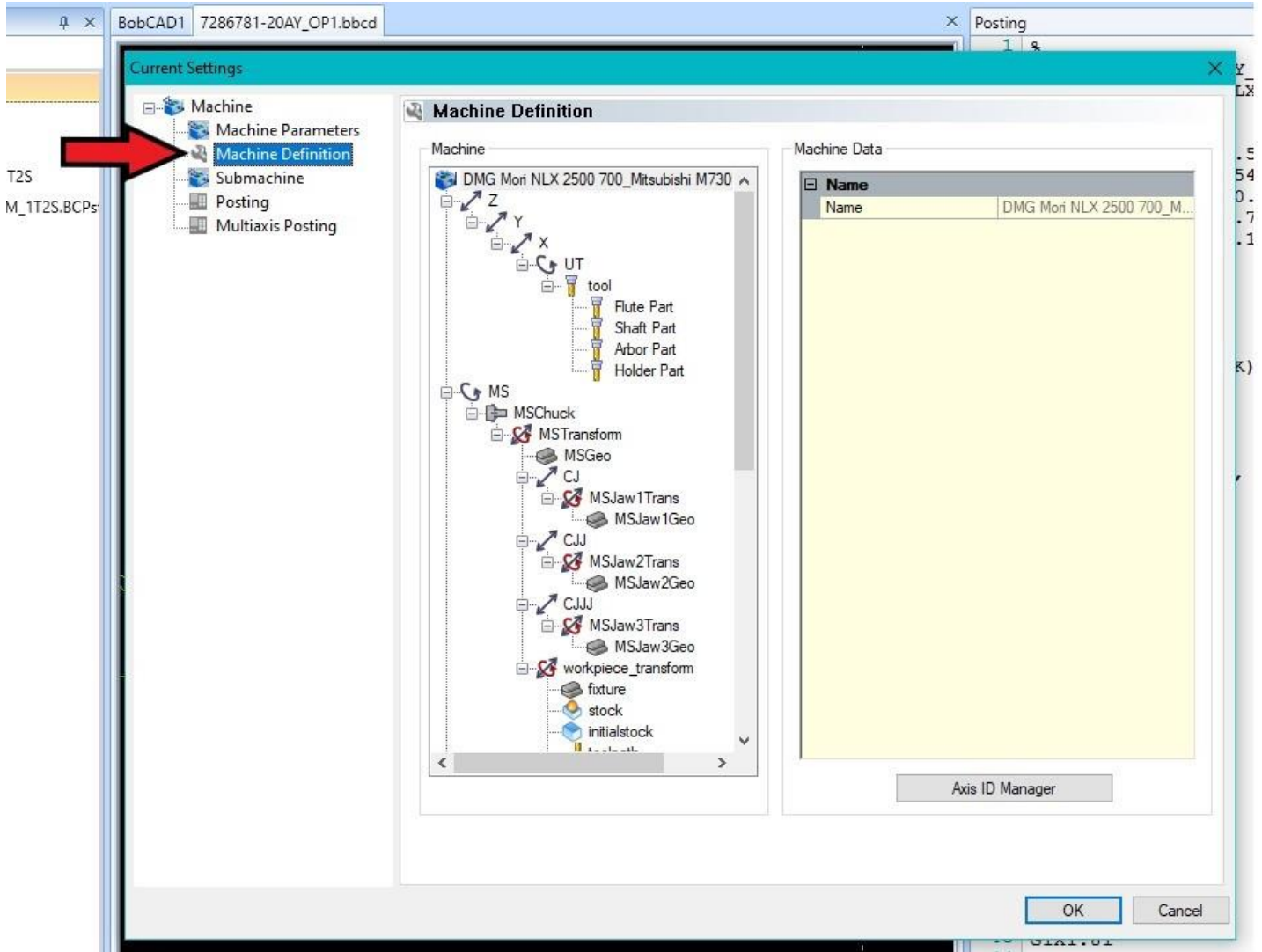
1. Right-click on the 'CAM defaults' in the CAM tree and select the 'Current Settings'. The Current Settings dialog appears with the 'Machine Parameters' page as the first page.



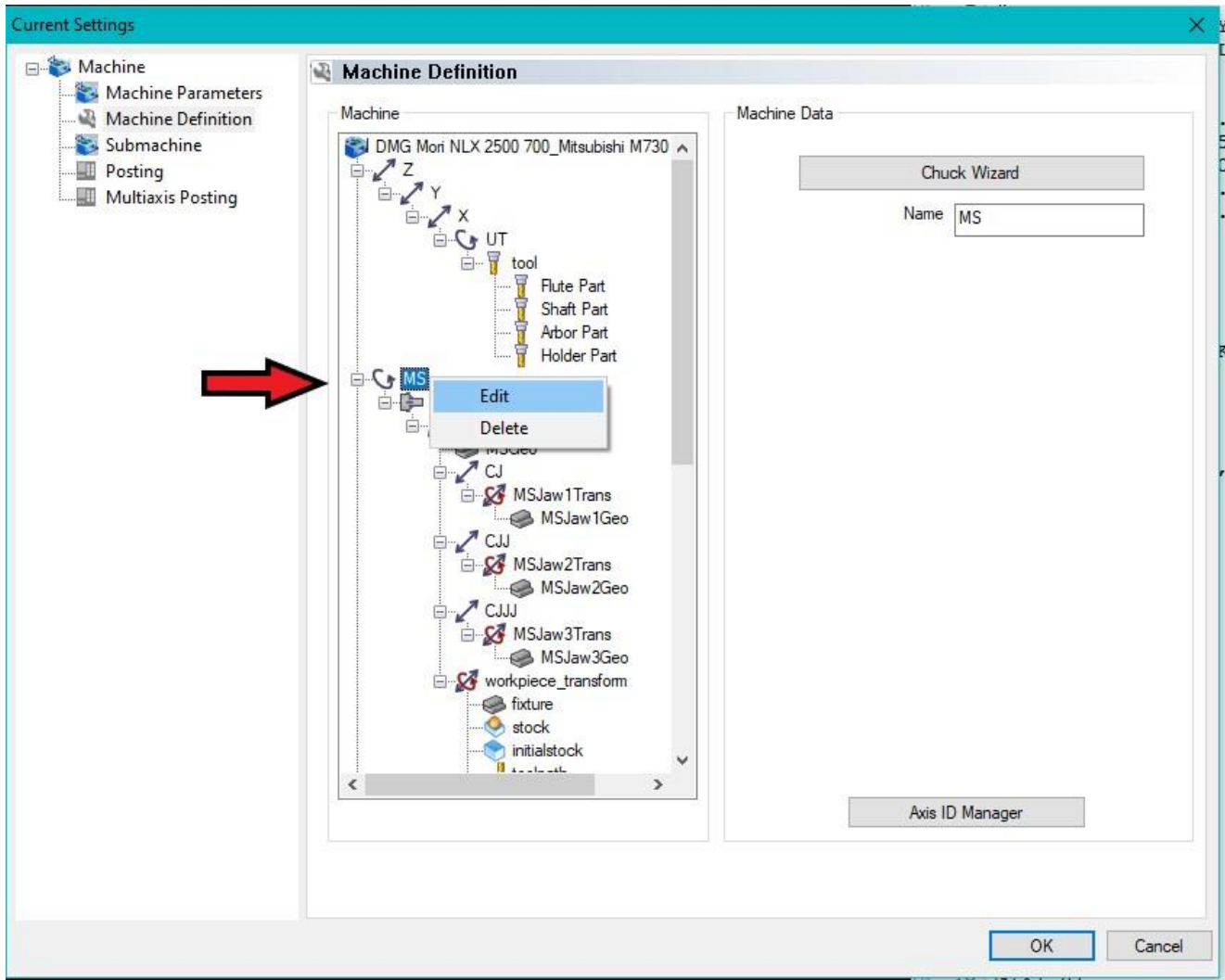
2. In the machine parameters page, under the 'machine group', click the arrow of the 'Make' option, and select the Mill-Turn machine.



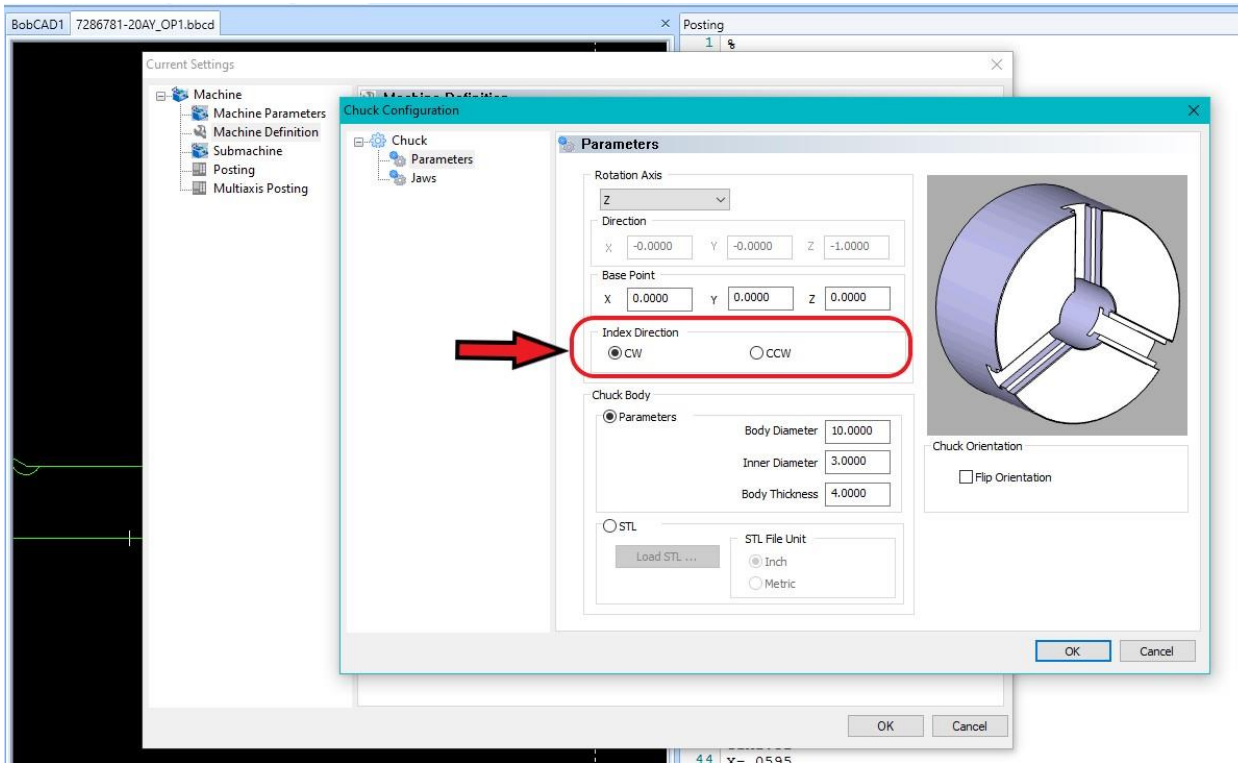
3. Under the tree on the left of the 'Current setting' dialog box, select the 'Machine Definition' page to access the machine tree structure (defined parts/elements).



4. Right-click the 'Chuck item'(MS- Main Spindle) in the machine tree and click 'Edit' to access the 'Chuck Configuration' dialog from the Machine Definition.



5. In the 'Parameters' page of the 'Chuck configuration' dialog, choose the Index direction as 'CW' to set the direction for positive rotation to a clockwise rotation. Click Ok to save the changes.



(Note that changing from CCW to CW automatically adjusts the Rotation Axis Direction (XYZ) vectors to negative.)

6. Reselect the 'Machine Make' under the Mill Turn Job and then Post the Gcode program to verify the Spindle rotation directions looking at the Miscellaneous codes (M-codes).

