

TSG The Service Group



Here is the procedure for adjusting the ATC grid shift with a Mitsubishi Driver.

Read all the way through before performing ANY changes!

1. Plug the CT-200 Programmer in to the Mitsubishi ATC Driver that needs to be grid shifted.
2. Note the current grid shift parameter (#340) setting. (You will see it after step 3. n.)

The following are the steps needed to change the grid shift of the ATC Magazine.

3. Press the **ALM/DGN** key until you see I/F at the top left of the screen.
 - a. Type in **1001**.
 - b. Press the **Shift** key.
 - c. Press the (▲) “up arrow” key once. (Flashing block moves right one set)
 - d. Press the **Shift** key.
 - e. Press the (▲) “up arrow” key once. (Flashing block moves right to the last block section.)
 - f. Press the **Shift** key once. (Your display should look at the top right corner like, ◀ **STP**. The ◀ means the character in the left side of the button you are about to push will be the letter or symbol that will be displayed, i.e. the letter M instead of the number 4.)
 - g. Press the “**M**” key. (Button number 4)(Now the bottom right should look like;1001: :M)
 - h. Press the (↵) “enter” key. (Now parameters 300 and above can be viewed.)
 - i. Press the **Param** key.
 - j. Press the **Shift** key.
 - k. Press the “#” key. (Button number 9)
 - l. Type in “**340**”.
 - m. Press the (↵) “enter” key. (Now parameter #340 is displayed with the current grid shift setting.)
 - n. Insert a new grid shift number, i.e. “**10000**”. (A change of 2000, i.e. from 12000 to 10000, will move the magazine approximately 1/8” in rotation.)

- o. Press the (↵) “enter” key. (Now parameter #340 is displayed with the new grid shift setting.)
4. Select Jog on the Mode Switch. Press the “1 Step/Zero Return” button once. The ATC will either rotate or the Magazine Reference light will begin blinking. Select Zero Return on the Mode Switch. Zero Return the ATC Magazine.
5. Check the alignment of the Spindle Tab and the ATC Magazine Tab.
6. If the alignment is not correct, repeat steps 3.n. through 5. above. If it is correct then unplug the CT-200 and run the machine.

If you have any questions, please don't hesitate to call.