



TSG Shoda NCV-1 Tool Magazine Gridshift Procedure

This presumes that the ATC Magazine rotates tools correctly and only the home position needs to be shifted so that the tools will line up correctly with the router motor.

1. On the NCV-1 Controller press the “**MODE**” button until the LED changes to PROG.
2. Once the PROG LED is lit, press the “**SET**” button on the controller.
3. Now you should see the first parameter, Auto Speed.
4. Press the “**WRITE STEP**” button and the display should change to the Manual Speed parameter. Keep pressing the “**WRITE STEP**” button until the parameter Origin Over is displayed, usually a total of 4 presses.
5. Type in the new grid shift number. Usually a small change will make a big change to the tool magazine home position. For example a change of 100 will make the tool magazine home position change by 1/8”. Usually if you make the number smaller, the magazine will shift in the CCW direction when viewed from the top side of the tool magazine. So if you need to move the tool CCW by 1/8” and your current setting is 19800, then you would type in 19700.
6. Press the “**WRITE STEP**” button to set the information.
7. Press the “**WRITE STEP**” button until the display shows the Auto Speed parameter again.
8. Press the “**MODE**” button until the TEST LED is lit.
9. Once the TEST LED is lit, press the “**SET**” button on the controller.
10. Press the “**RTN**” button and the ATC tool magazine will Zero Return.
11. Verify the ATC tool magazine lines up with the router motor.
12. If it correctly lines up then press the “**MODE**” button until the EXT LED is lit and press the “**SET**” button. If it does not, return to step 1.

If you have any questions at all, don't hesitate to give us a call.