

Support Bulletin: RASD-SB00045

Model: Roland MDX-540 w/ Automatic Tool Changer

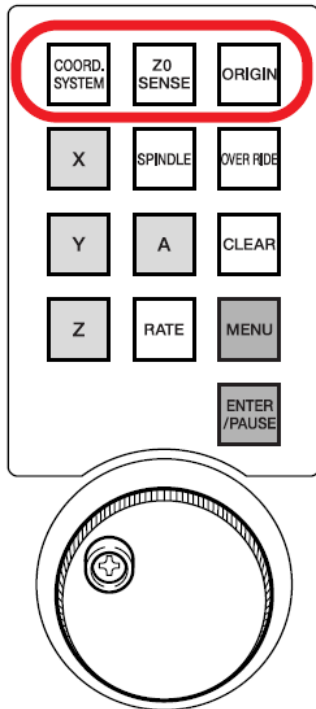
Subject: Removing Tool Lodged in Material or Z-Sensor

Date: 10/26/2007

Author: PG

The following document demonstrates how to recover from a tool that is lodged in material or stuck on top of the Z Origin Sensor when equipped with the Automatic Tool Changer. If the machine enters an emergency stop condition and needs to be restarted, the tool will need to be released. If the tool is lodged in material or sitting on top of the Z-0 Sensor when it tries to release the tool, it will not function as the tool needs a little clearance to be safely removed from the ATC Spindle. Please follow the below instructions to recover.

1. Enter the machines service mode by pressing all top 3 keys on the Handy Panel as you turn the machine on.



2. Select Z-Brake Check and press Enter. Once the Z-Brake is released, the Z-Axis will be free to be moved by hand as the X&Y axis are normally when the power is turned off.



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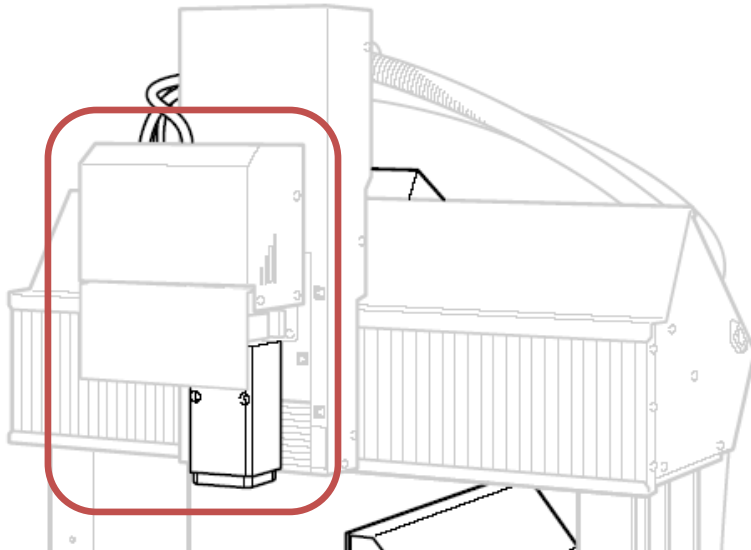
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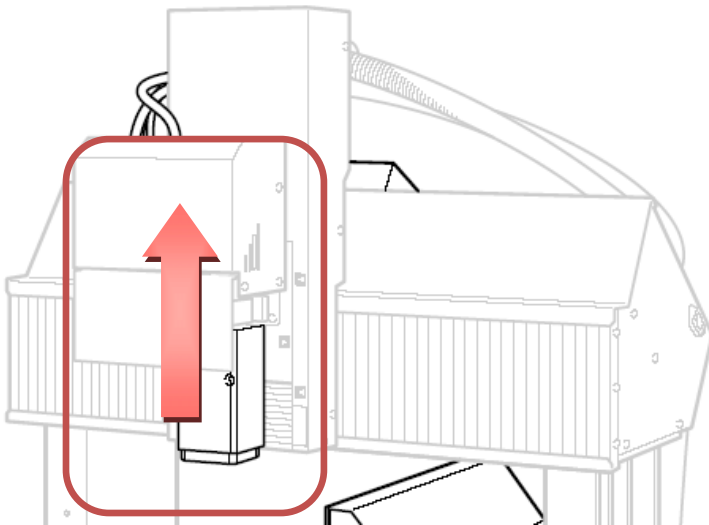
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- Support the Z-Axis Carriage either with a block of material or with hand.



- Press the Enter button on the Handy Panel. The Z-Axis can now freely move up or down.



- Move the Z-Axis up a couple of inches.



- Press the Enter button to lock it in place.





Advanced Solutions Division

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7. Press the Clear button to exit Z-Brake Mode.



8. Restart the machine and follow the Handy Panel to remove the tool holder.