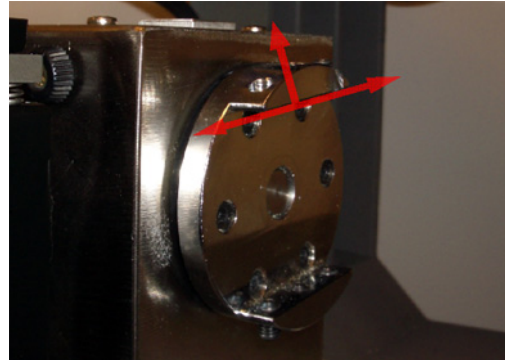
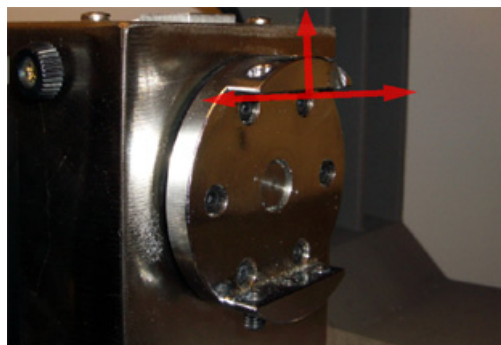
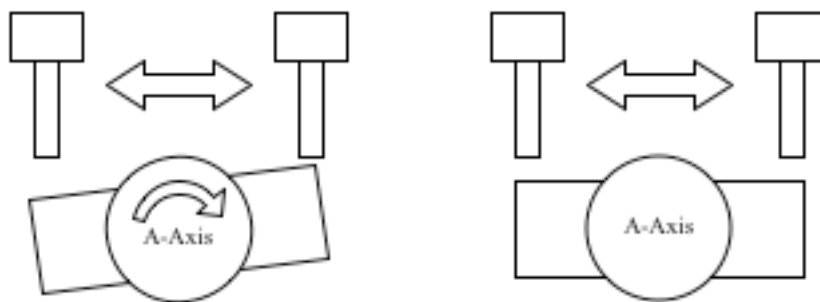


After the ZCL-650 Rotary Axis is installed and initialized, the rotary angle is not horizontal with the table even though the display reads [A 0]. The angle will be similar to Picture 1. This is normal and there is nothing wrong with the ZCL-650 Rotary Axis.



You must follow the instructions listed in section “3-2 Setting the A-Axis Origin Point” of the ZCL-650 User’s Manual to properly set the origin of the rotary unit.

Note: When setting the A-Axis Origin, please ensure that [*A] is selected before pressing [XY/A] origin button.
 Tips: Manually rotate the A-Axis to approximately 53500, level to the table, and set the A-Axis Origin point here. To level, either use a bubble level, a T-Square, or use the following method. Place material in the A-Axis Clamps, lower the spindle with a mill close to the middle edge, and run the A-Axis forward and backward checking the difference in height and adjust the A-Axis angle accordingly.



Note: Upon restarting after the Emergency Stop button is pressed or the machine is powered down, the unit will initialize to the position shown in Picture 1. Follow these steps to rotate the A-Axis back to 0 degrees.

1. Press [EXIT] or [ENTER] to display the main menu:

2. Use the rotary dial to select:

>12	ROTARY CONTROL
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3. Press [ENTER]

12> 1	ROTATE
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4. Rotate will be selected, Press [ENTER]

12-1	ROTATE	0 deg
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5. You want to rotate the axis to 0 deg, so just press [ENTER]

This will rotate the rotary axis to the origin point selected earlier.