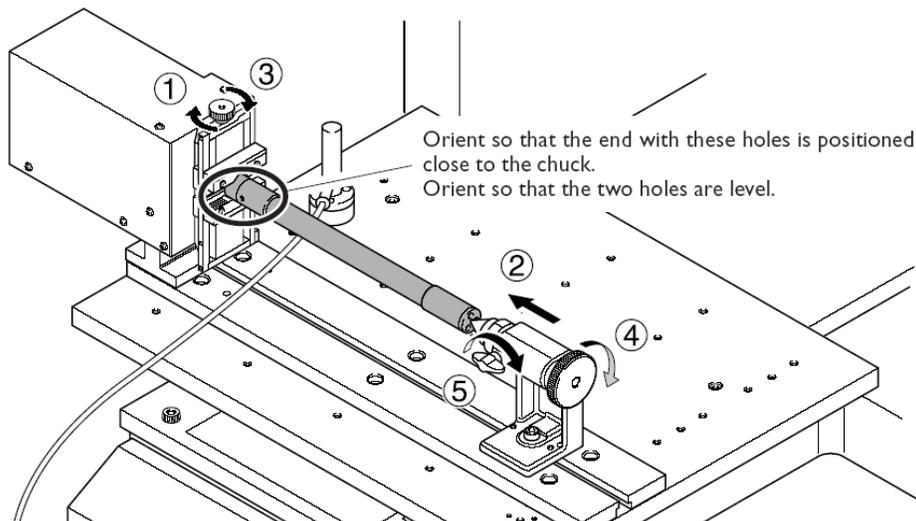


Support Bulletin: RASD-SB00045  
Model: Roland MDX-540 & ZCL-540 Rotary Axis Unit  
Subject: Setting up Rotary Axis Unit on MDX-540  
Date: 12/4/2007  
Author: PG

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The following document demonstrates how to properly set up the ZCL-540 Rotary Axis unit on the MDX-540 series machine. If the machine is cutting above the material, then please follow the below steps in the order shown.

1. Set Y-Axis Origin of ZCL-540 unit. (ZCL-540 User's Manual section 4-2)



2. **If ATC unit is attached, load at least one tool into magazine and measure length of tools.** (ZAT-540 User's Manual section 4-2)
3. Set Z-Axis Origin of ZCL-540 unit. (ZCL-540 User's Manual section 4-3) Setting the Z-Origin at center of rotation will center the Z-Axis to the center of the rotary axis unit.

