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To Temporarily Remove A 4th Axis From a Vertical Machining Center

Never disconnect or reconnect the 4th axis cabling with the machine power on. The main disconnect on the electrical cabinet should be OFF.

For this function to work NC parameter #1005 Bit 7 (Far Left) must equal a 1. Once this is changed to a 1 it can remain so.

To Disconnect the 4th Axis

1. Change NC parameter #12 Bit 7 (Far Left) to a 1.
2. Completely power down the machine and remove the 4th axis.

To Reconnect the 4th Axis

1. Change NC parameter #12 Bit 7 (Far Left) to a 0.
2. Completely power down the machine and reconnect the 4th axis.