

➤ **Remove the Capto spindle.**

1. Ensure that the tool conventional clamp is active.
 - a) Machine.
 - b) Menu Select.
 - c) T.B.T.
 - d) Auto.
 - e) Semi-functions.
 - f) OK.
 - g) Jog.
 - h) Unlock safety doors. (P.B.)
 - i) Open doors.
2. Unscrew 14-off cap screws stamped 12.9. and remove.



1. Close doors.
2. Machine.
3. Menu Select.
4. T.B.T.
5. Auto.
6. Semi-functions.
7. Release.
8. – Action. (Unlocks tool).
9. Leave the control on this screen.
10. Jog.
11. Unlock safety doors. (P.B.)
12. Open doors.

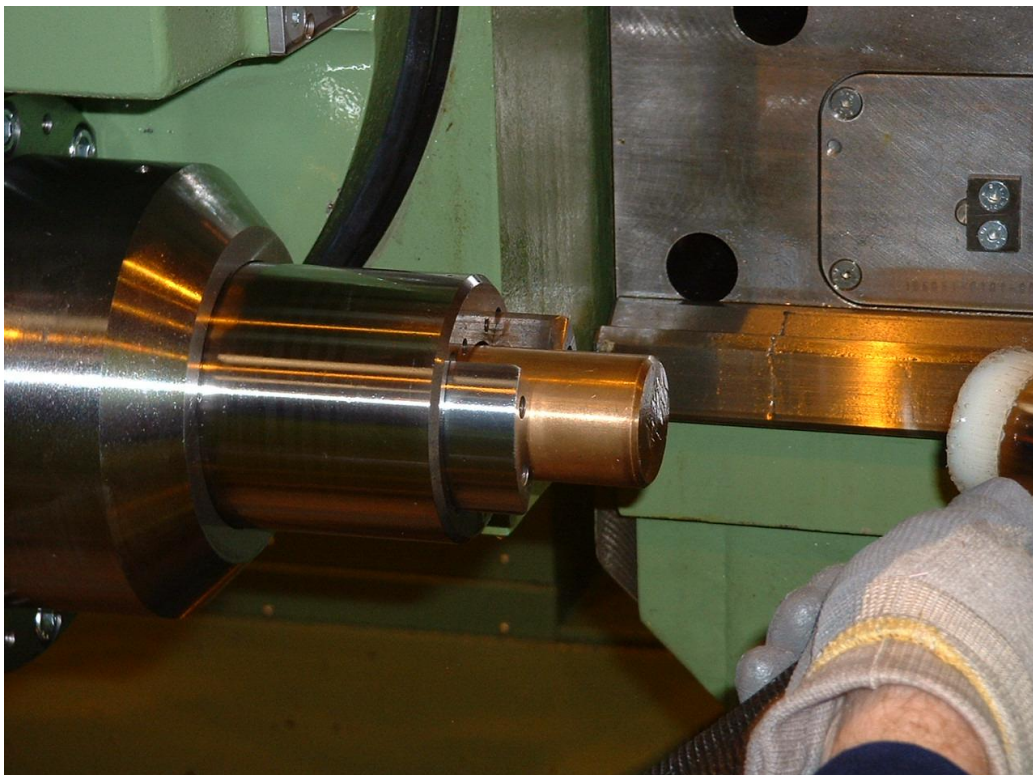


➤ **Remove Capto end.**



1. Close doors.
2. Auto.
3. Tool conventional clamp.
4. + Action
5. 'W' axis docking position.
6. – Action
7. W' axis re-tooling position.
8. + Auto action.
9. Jog.
10. Unlock safety doors. (P.B.)
11. Open doors.

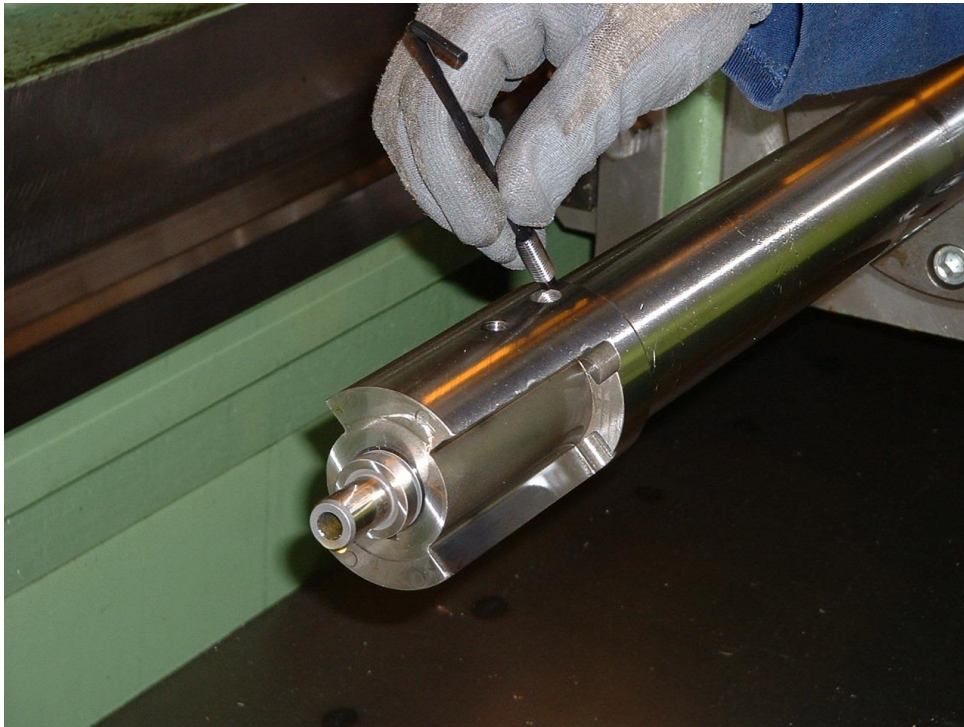
- Use the brass tool to knock out the Capto spindle.





➤ **Remove the Capto drive shaft from the driver.**

1. Take both grub screws fully out and remove.



➤ **Clean the spindle and the I.T.S. shaft.**

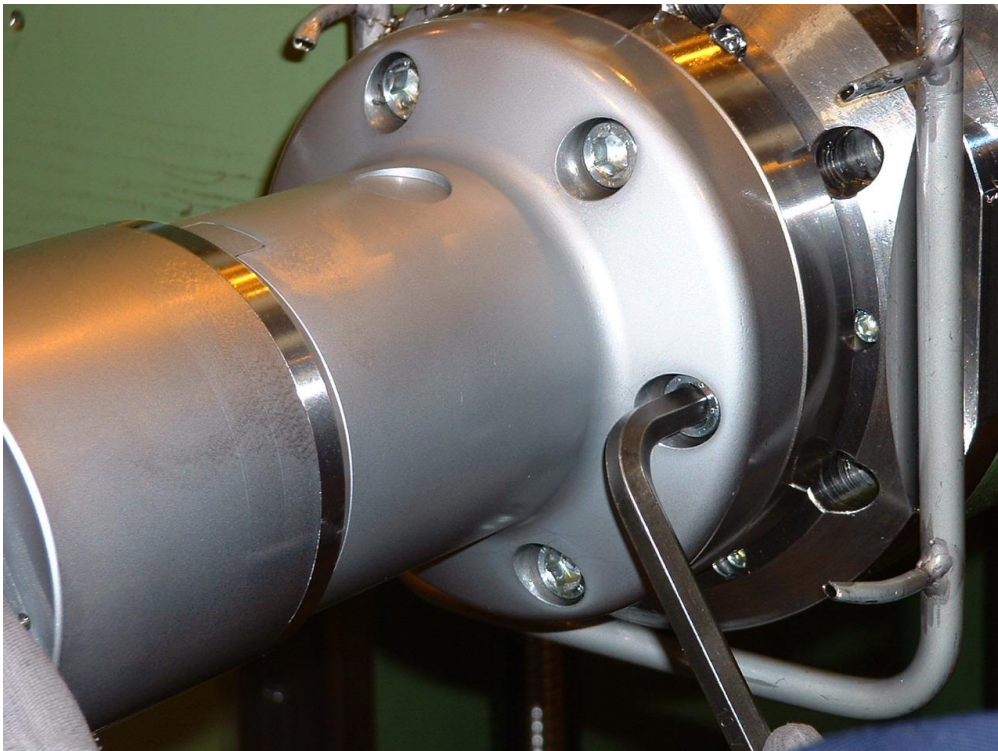
1. Load the I.T.S. bar to the spindle.



- **Orientate using the dowel hole and pin.**



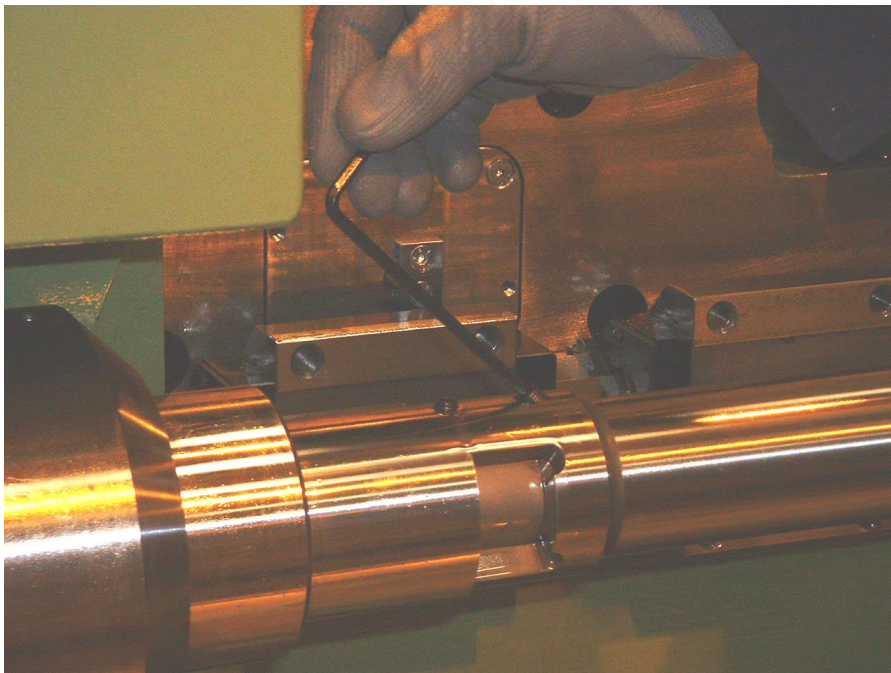
- **Tighten the 6-off cap screws.**



1. Close doors.
2. Machine.
3. Menu Select.
4. T.B.T.
5. Machine Setup.
6. Auto.
7. 'W' axis docking position.
8. – Action.
9. I.T.S. base position.
10. Start.
11. + Action.
12. Jog.
13. Select 'U' axis.
14. Manually jog until 'U' axis at the tool holder begins to move.
15. Jog 'U' in a – direction.
16. Unlock safety doors. (P.B.)
17. Open doors.

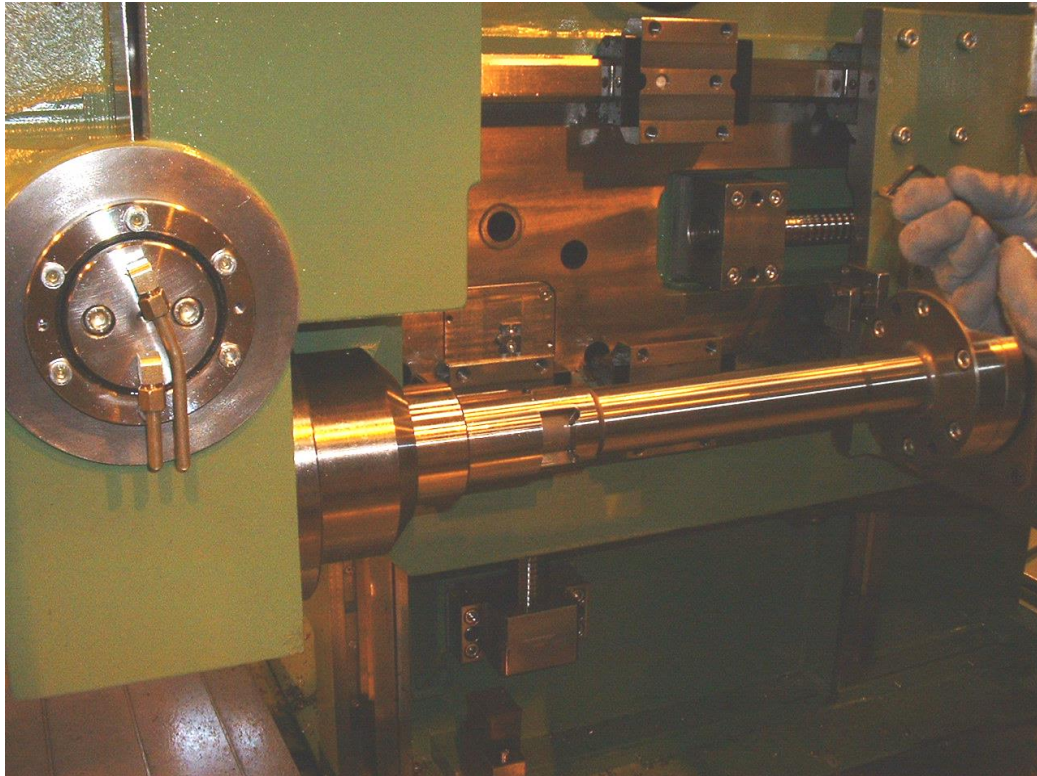
➤ **Lock in place the 2-off grub screws affixing the driver to the I.T.S. bar.**

1. Fully tighten the right hand grub screw, then the left hand one.



2. Close doors.
3. Manually jog the 'U' axis +, until the 'W' soft limit appears.
4. Press reset (P.B.) to clear fault.

- **The I.T.S. bar is now in the starting position.**



- **Activating the I.T.S. bar as the spindle tool.**

1. Machine.
2. Menu Select.
3. Parameter.
4. Tool Management.
5. Tool list.
6. Cursor to I.T.S. tool required.
 - a) The following letter suffixed instructions are only necessary if the required tool is not loaded to the magazine.
 - b) Load.
 - c) Find empty location.
 - d) Start.
7. Relocate.
8. Magazine number 9998.
9. Input location 1.
10. Start.

➤ **Input tool information when using the I.T.S. bar.**

1. Machine.
2. Menu Select.
3. Parameter.
4. Tool management.
5. Tool List.
6. New tool.
7. Name the tool.
8. Duplo 1.
9. End mill.
10. Cursor through to enable.
11. Input to enable.
12. Select. (Blue button).
13. Cutting edge data.
14. Enter tool offset data. (estimate if required)

➤ **De-activating the I.T.S. bar as the spindle tool.**

1. Machine.
2. Menu Select.
3. Parameter.
4. Magazine list.
5. Tab button.
6. Relocate to empty location.
7. Tool now unloaded.
8. Tool list.
9. Cursor to next tool.
10. Load.
11. Find empty location.
12. Start.
13. Tool now loaded to magazine.
14. Relocate.
15. Magazine number 9998.
16. Input location number 1.
17. Start.
18. Tool is now active in the spindle.

➤ **I.T.S. zero position (docking position):- W1 = -88.868.**