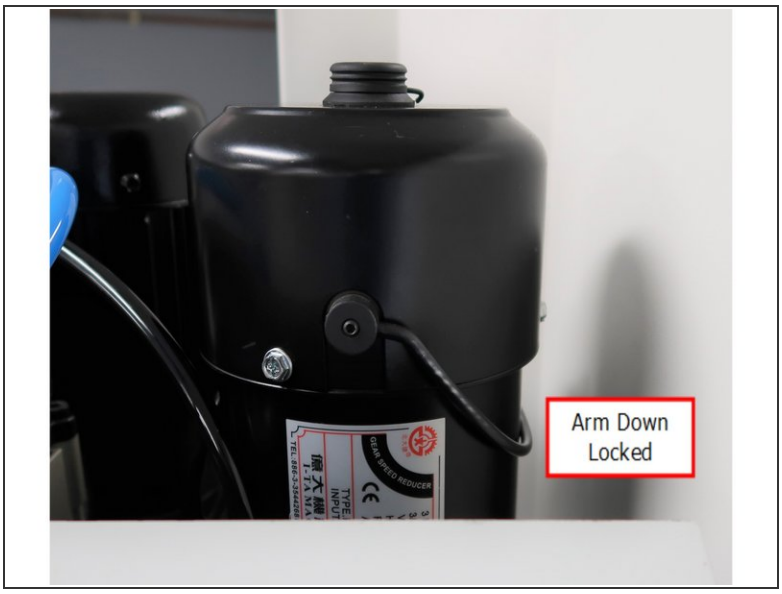
VMCsi ATC Arm Manual Movement

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Step 1 — Unlock Tool Change Motor for Manual Movement



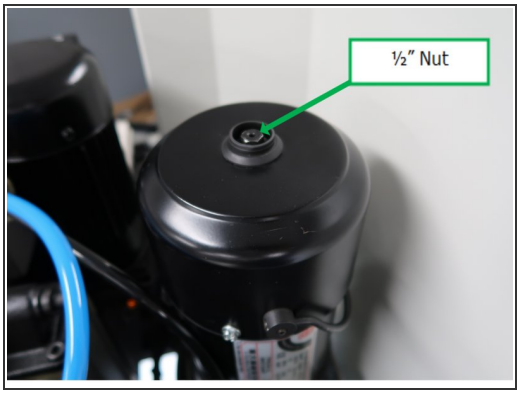


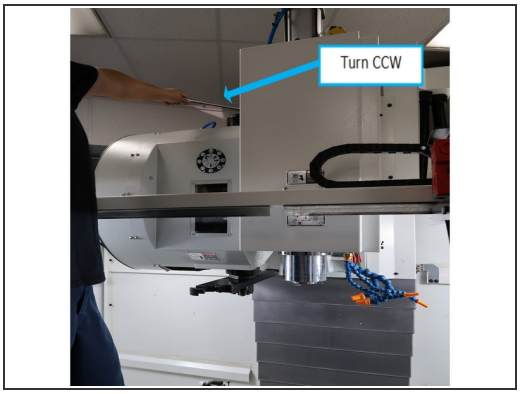
⚠ E-Stop Mill

- The arm is down in the normal position. The tool change motor is locked from movement except through the control.
- Lift the arm up as shown to enable manual movement of the tool change motor.

Step 2 — Remove Cap and Move Motor







- On the top of the tool change motor, remove the cover.
- Use a **1/2" socket** on the nut below the cover to manually crank the arm **CCW**. Select a longer socket wrench handle because it takes some effort to turn the motor and ATC arm.
- Turning **CCW** will move the ATC arm closer to the spindle.

ⓘ Completing the tool change cycle will require many manual cranks of the tool change motor. At times, it may be difficult to see any movement. During the cycle, the arm will drop down from the tool changer, rotate **180 degrees**, and then return to the normal position.

Step 3 — Finish Arm Adjustment





- If you have made any changes, remember to put the arm back to the **locked position** and replace the **cap**.