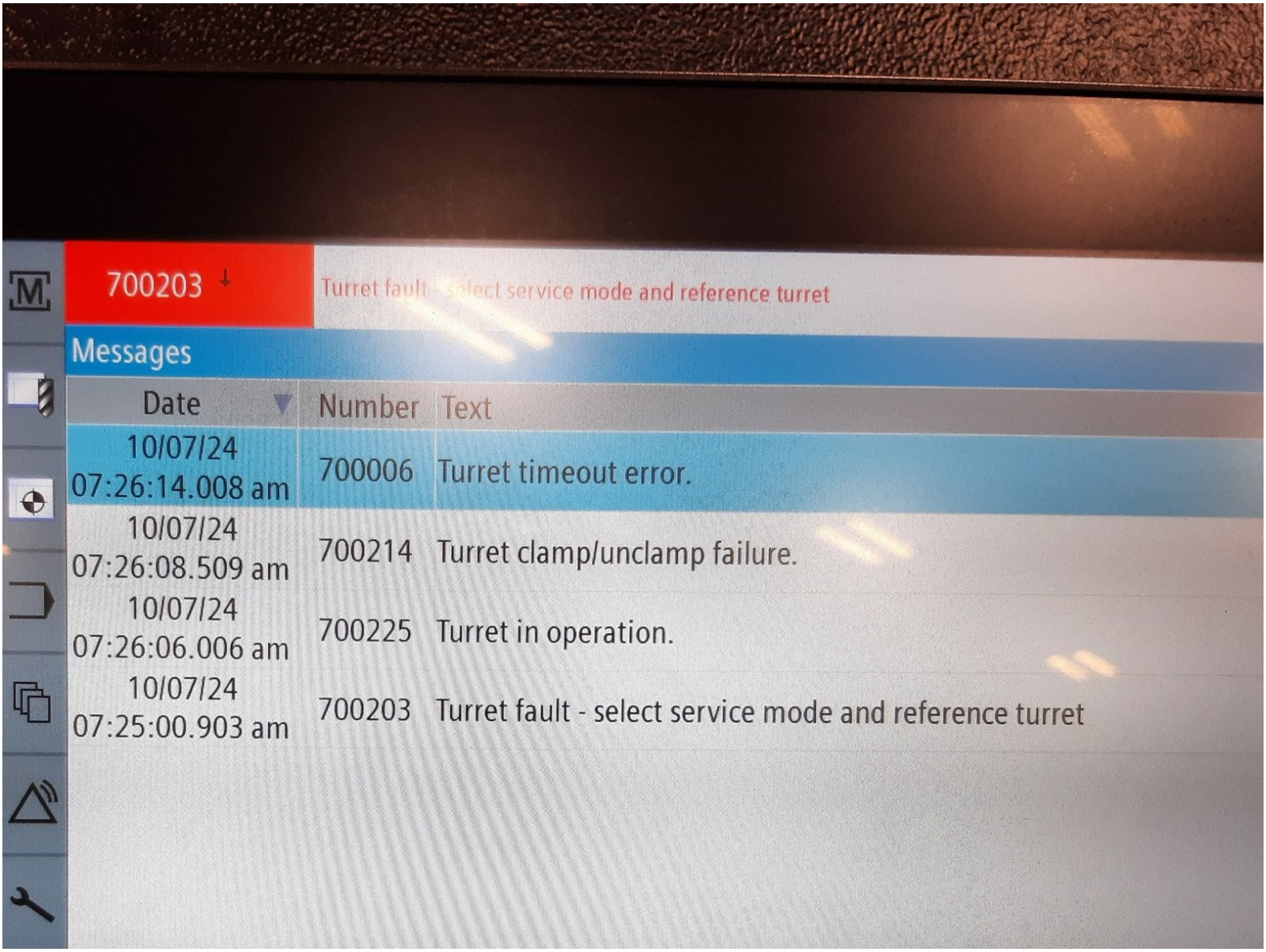
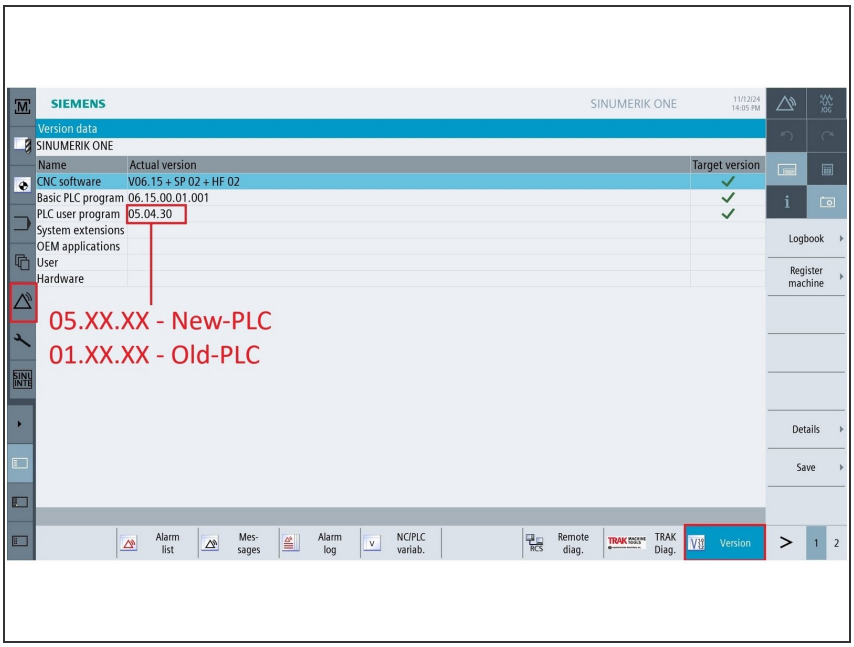
TCsi - Reference Turret

Written By: Ryan Levrini



© 2026

Step 1 — Old-PLC vs New-PLC

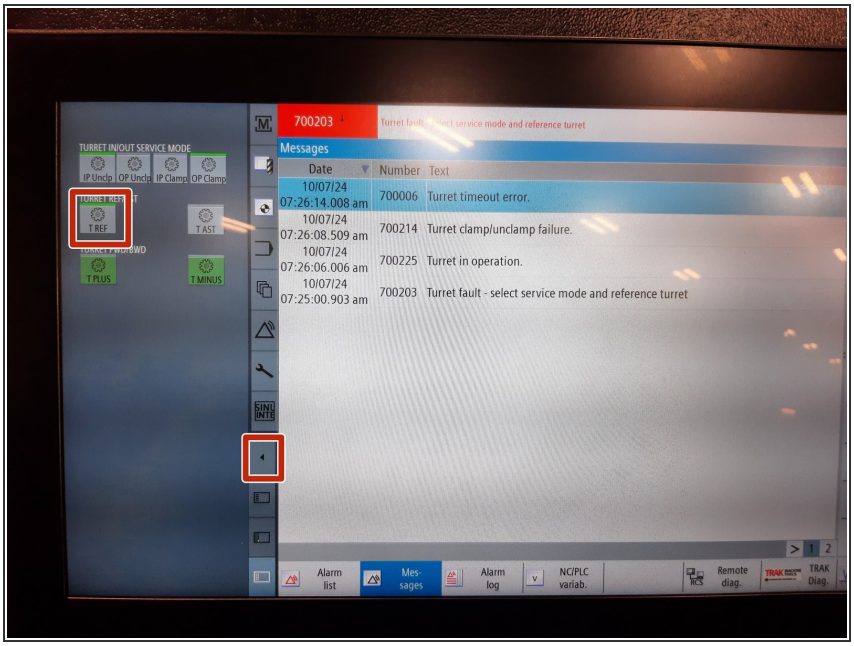


ⓘ All TC820LTYsi are on the New-PLC

ⓘ Go to last step.

- For TC820si:
- Go to **[Diagnostics]** → **[Version]**
  - If PLC user program version is **01.XX.XX**, the machine has **Old-PLC.**
  - If PLC user program version is **05.XX.XX**, the machine has **New-PLC**.

Step 2 — Old-PLC Turret Reference Steps

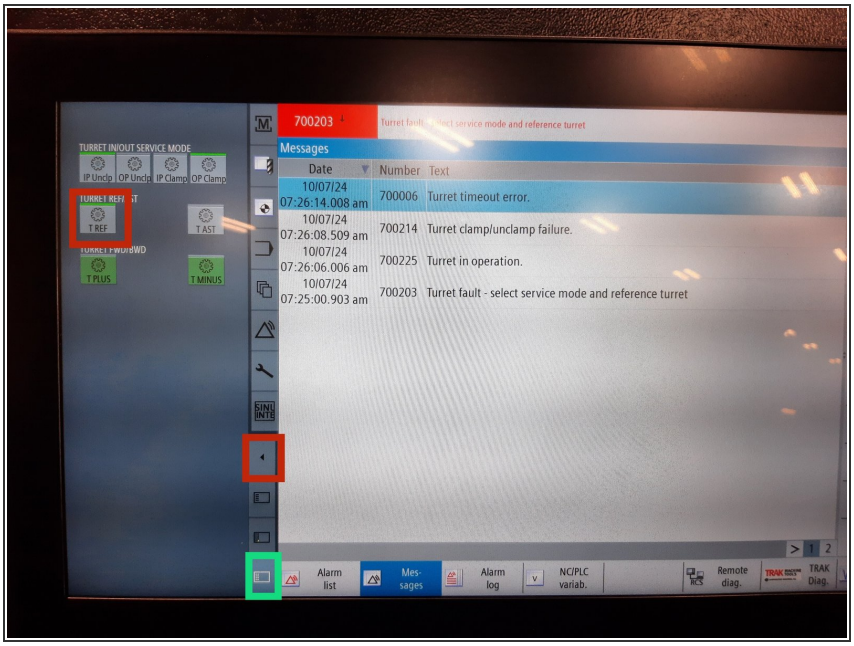


ⓘ **Old-PLC:**

- Enter service mode by pressing **[Feed Start]** on the MCP **three times** within **one second**. If service mode is successfully activated, Alarm 700062 will appear.
- Once in service mode, press **[Jog]** and **[Ref. Point]** on the MCP.
- On the left-hand side, press the **[◀]** key to reveal more options.
- Press **[T Ref]** to reference the turret.

© 2026

Step 3 — New-PLC Turret Reference Steps



New-PLC:

- Enter service mode by holding **[Spindle Stop]** and pressing **[Feed Stop]** three times within one second. Ensure that **Feed Start** is active.
  - On older versions of the New PLC, Feed Start is not activated automatically, so you may need to press the **[Feed Start]** button manually.
- Once in service mode, press **[Jog]** and **[Ref. Point]** on the MCP.
- On the left-hand side, press the **[◀]** key to reveal more options.
- Press the bottom vertical button.
- Press **[T Ref]** to reference the turret.