

# KIRA TECH TIP

## Special Tool Select (KN-40Hb/KN-40Vb)

- These machines are capable of selecting a special tool. A special tool is defined as a larger diameter tool that interferes with an adjacent pocket, such as a large face mill.
- The control will recognize this tool by always putting that tool in the same pocket. This way a tool cannot be put in the pocket through the random tool changer that may cause tool interference.
- Set Keep Relay for special tool select. See Keep Relay description in Kira manual.
- In MDI, program M80, M81, cycle start. This will assign tool 1 to pocket 1, tool 2 to pocket 2 . . . . This can be monitored in data tables D400=. The special tool data in data table D450+ will be cleared. Clear current random tool table. In MDI, program M80; M81; cycle start.
- Select tool that are special. Example: Tool 8
- MDI program: M80; M88T8; cycle start
- Look at Data Table D450+. The special tool pocket number and the adjacent tool pots will be assigned a number. Example: D046 = 3, D0406=3, D0407 = 1, D0408 =2.
- When doing a tool change under normal conditions, the tool in the spindle will be exchanged with the tool in the carousel.
- When selecting the special too, two-tool changes will occur. The first tool change will put the tool from the spindle into the pot with no tool (Tool #=0). The carousel will rotate to the special tool and put it n the spindle.
- Since this tool is most likely oversized and heavy, the tool change arm changes at a lower speed.
- When selecting another tool, the tool change arm will put the tool from the spindle into its original pot and then rotate the carousel to the next tool selected.
- If one of the adjacent tool pockets are called up, the pockets will be treated as special tools.