

1. Enable Swivel with Toolcarrier MD52212.0=1

- Grinding wheel as T number or as name
T1-T32000 free assignable to Toolcarrier 1-4 (swivel data record TC1-TC4)
 - Toolchange in Jog and Automatic mode
 - With or without active magazine management
 - Dresser will be recognized and can be activated as T1-T32000
 - In case permanently assignment swivel data set to the tool (SD55221.9) use only T number 1 to 4 for grinding wheels. Otherwise cycle800 set alarm 61019 in case T number >4.
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2. Disable Swivel with Toolcarrier MD52212.0=0

- All T number can be used for grinding wheels or dresser
- With or without active magazine management
- Call of Cycle400 will generate an alarm in Cycle800 and will not run