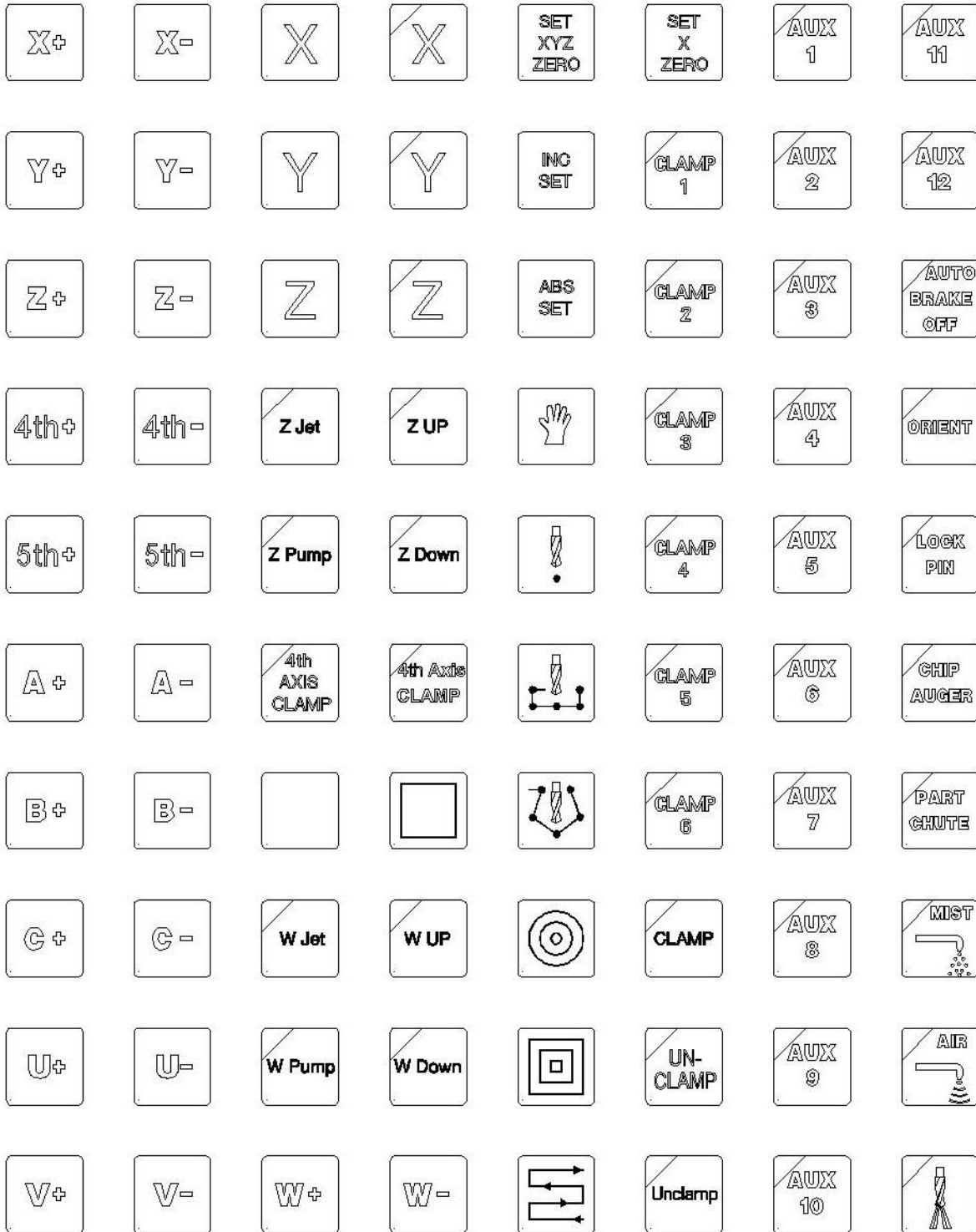



# TB198 (Rev1) - Available Overlay Inserts

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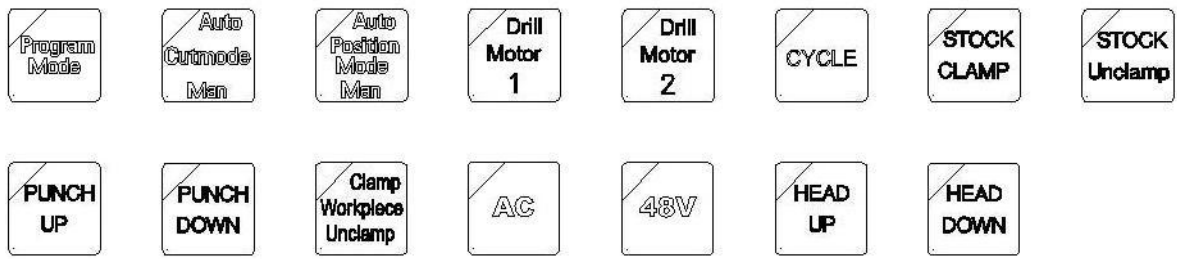
These are all of our available overlay inserts. You can set up standard 1 shot aux key as described in TB194 or set up your own custom aux key. You can even customize your own insert if you dont see one here!



Horiz Spindle	Spindle #1	TORCH DOWN	GEAR 1	Up Quill Down	OD ID	TAIL-STOCK IN	TAIL-STOCK OUT
Vertical Spindle	Spindle #2	TORCH UP	GEAR 2	Chuck Clamp	Open CHUCK Close	CHUCK	CHUCK
Spindle UP	SPINDLE JOG	INDEX	GEAR 3	ID Clamp	OD Clamp	QUILL IN	QUILL OUT
Spindle DOWN	Spindle Neutral	INDEXER	LOW RANGE	Hydraulic Pump	Chuck LOW Pressure	OPEN COLLET	CLOSE COLLET
Spindle Increase	Spindle Brake	INDEX +	LOW RANGE HIGH	Manual Unclamp	Manual Rotate	TOOL INDEX +	TOOL INDEX -
Spindle Decrease	Left SPIN START	INDEX -	HIGH RANGE	HIGH GEAR	T-stock UP	TURRET INDEX +	TURRET INDEX -
SPEED UP	Left SPIN STOP	TOOL IN	MED LOW GEAR	LOW GEAR	T-stock DOWN	Turret INDEX	TURRET INDEX
SPEED DOWN	Right SPIN START	TOOL OUT	MED HIGH GEAR	Neutral	T-stock Advance	Unlock Turret	Turret Clamp
RPM UP	Right SPIN STOP	TOOL Unclamp	TOOL EJECT	Clamp Workpiece Unclamp	T-stock Retract	JOG FWD	JOG REV
RPM DOWN	TOOL INDEX	TOOL Release		LOW RPM HIGH	In Tailstock Out	Extend Tailstock	Retract Tailstock

GRIP	Loader IN	#1 ACTIVE	#2 ACTIVE	#1 PUMP	LOAD POSITION	STACK FWD	IN LOADER OUT
Release	Loader OUT	#1 UP	#2 UP	#2 PUMP	ADV CATCHER RET	STACK REV	OPEN COLLET CLOSE
OPEN	Part Catcher IN	#1 DOWN	#2 DOWN	HIGH Pressure LOW	READY	Revolver	MDI FEED
CLOSE	Part Catcher OUT	Unlock Bridge	Collet Dir Rev	RACK UP	RACK DOWN	Outer VICE OPEN	QUILL UP
SETUP	PART CW	PART CHUTE	PART CHUTE IN	PARK	DUST	Outer VICE CLOSE	QUILL DOWN
DIAG Mode	PART CCW	PART CHUTE OUT	IN Part Catch OUT	SKIM NEW	SKIM OLD	Inner VICE OPEN	HD UP
Conveyor Forward	Continuous	VAC ON/OFF	AUX	VAC 1	VAC 2	Inner VICE CLOSE	HD DOWN
Conveyor Reverse	Segment	Air-Slide 1	Air-Slide 4	STOPS UP	STOPS DOWN	Fuller Clamp	HD CLAMP
PUNCH	SHOT PINS	Air-Slide 2	Air-Slide 5	HOME	Groove Depth	Open Pusher	HD UN-CLAMP
Abrasive	*	Air-Slide 3	Air-Slide 6	CLUTCH	Groove Position	Close Pusher	BRAKE

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## Document History

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