



POU YUEN TECHNOLOGY

LNC-M500 SERIES

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1

LNC- M500 -

POU YUEN

TECHNOLOGY Ltd.,

LNC-500

LNC-M500.

1.1

LNC 500	
	5.7" STN LCD
SDRAM	64
CF card	32
	3.5"1.44 ; 5 /12
	(with DA out)
-	128 /128 -
-	16 /16 -
	RS232 19200
MPG ()	3- -1
	3
	1
	1 24V(4A) 2AC115-

1.3 G- ()

G-		
G00	()	01
G01	()	01
G02 - G03	(CW/CCW)	01
G04		00
G09		00
G10		00
G15		17
G16		17
G17	XY	02
G18	ZX	02
G19	XZ	02
G20		06
G21		06
G22		00
G23		00
G27		00
G28	1	00
G29	1	00
G30	2, 3, 4	00
G31		00
G40		07
G41		07
G42		07
G43		08
G44	+	08
G49	-	08
G50		11
G51		11
G52		00

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G-		
G53		00
G54 ~ G59		14
G61		15
G64		15
G65		12
G66		12
G67		12
G68		16
G69		16
G73		09
G74		09
G76		09
G80		09
G81		09
G82		09
G83		09
G84		09
G85		09
G86		09
G87		09
G88		09
G89		09
G90		03
G91		03
G92		00
G94	(/ .)	05
G95	(/rev.)	05
G98		10
G99	R	10
G100		MACRO
G101		
G102		

G103		
G104		
G105		
G111		X

1-4

G-		
G112		Y
G113		X
G114		Y
G121		
G122		
G123		
G131		
G132		
G133		

1.4

M-		
MOO		
M01		
M02		
M03	CW ()	
M04	CCW ()	
M05		
M06		
M08		
M09		
M28		
M29		
M30		
M98		
M99		

2

2.1

) OP () . – MDI (MDI :
OP
– , .
, ,
(. ,) . .
. Pou Yuen Tech OP MDI
LNC-500.

2.1.1

- MDI 3 :
- (1) :
- 6
- (2) :
- 5 , :
- POS, PROG, OFFSET, DGNOS PARAM.
- <POS> :
 - <PROG> :
 - <OFFSET> :
 - <DGNOS> :
 - <PARAM> :

(3)

:

SHIFT,

.

,

"+".

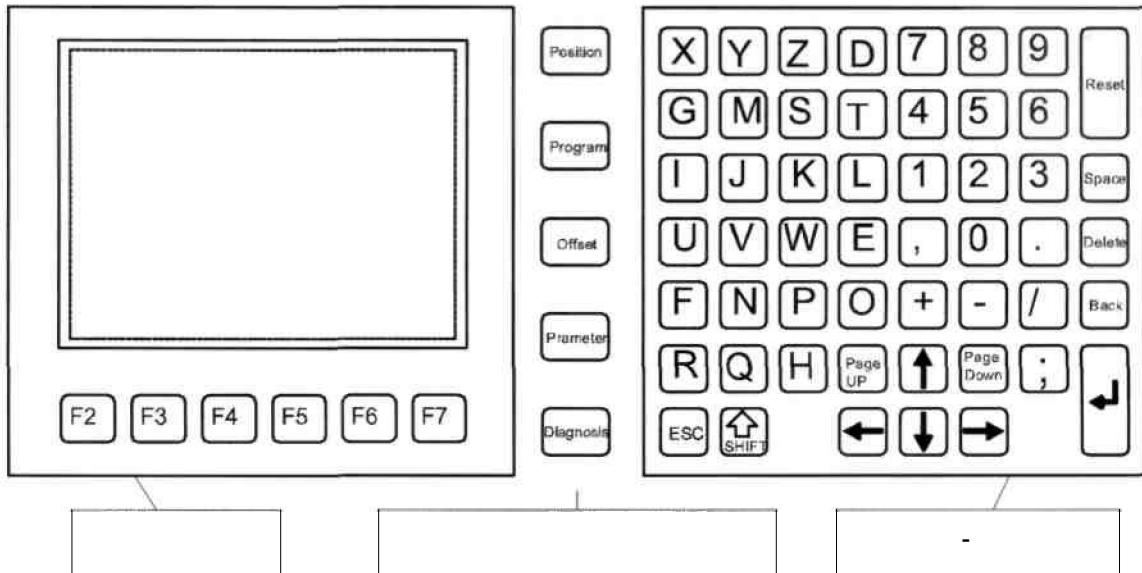
,

,

,

SHIFT.

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2.2

PARAM. : POS, PROG, OFFSET, DGNOS
 [...] :
 <...> MDI

2.2.1

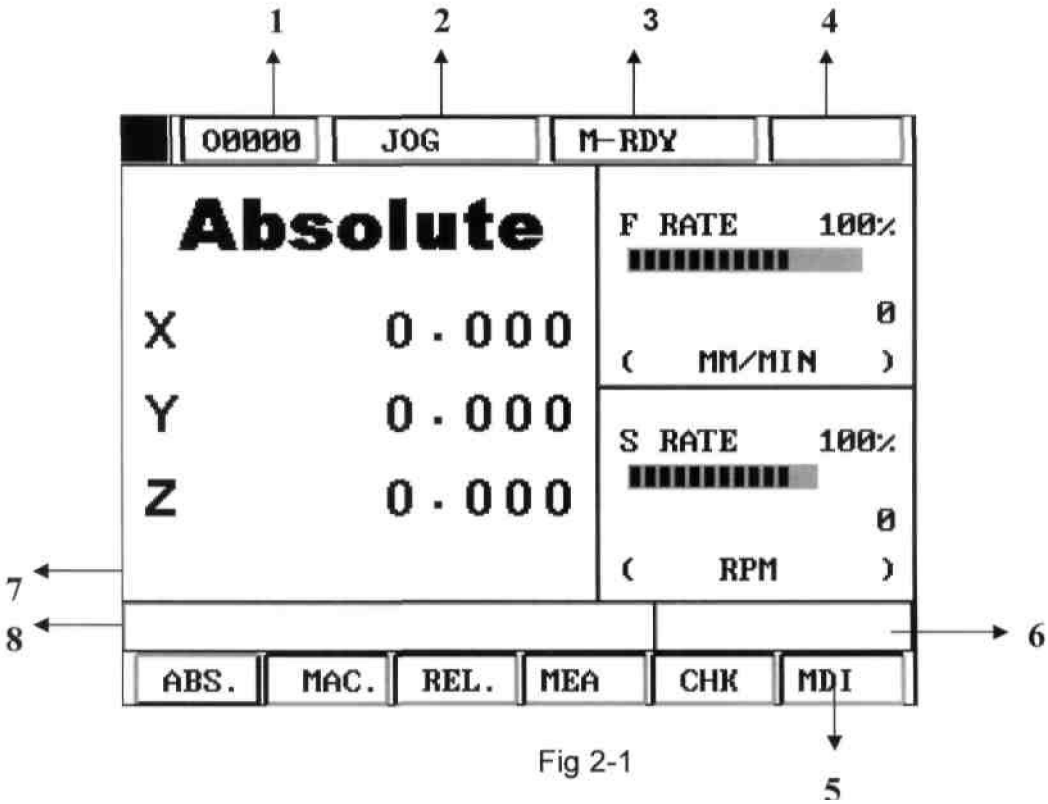
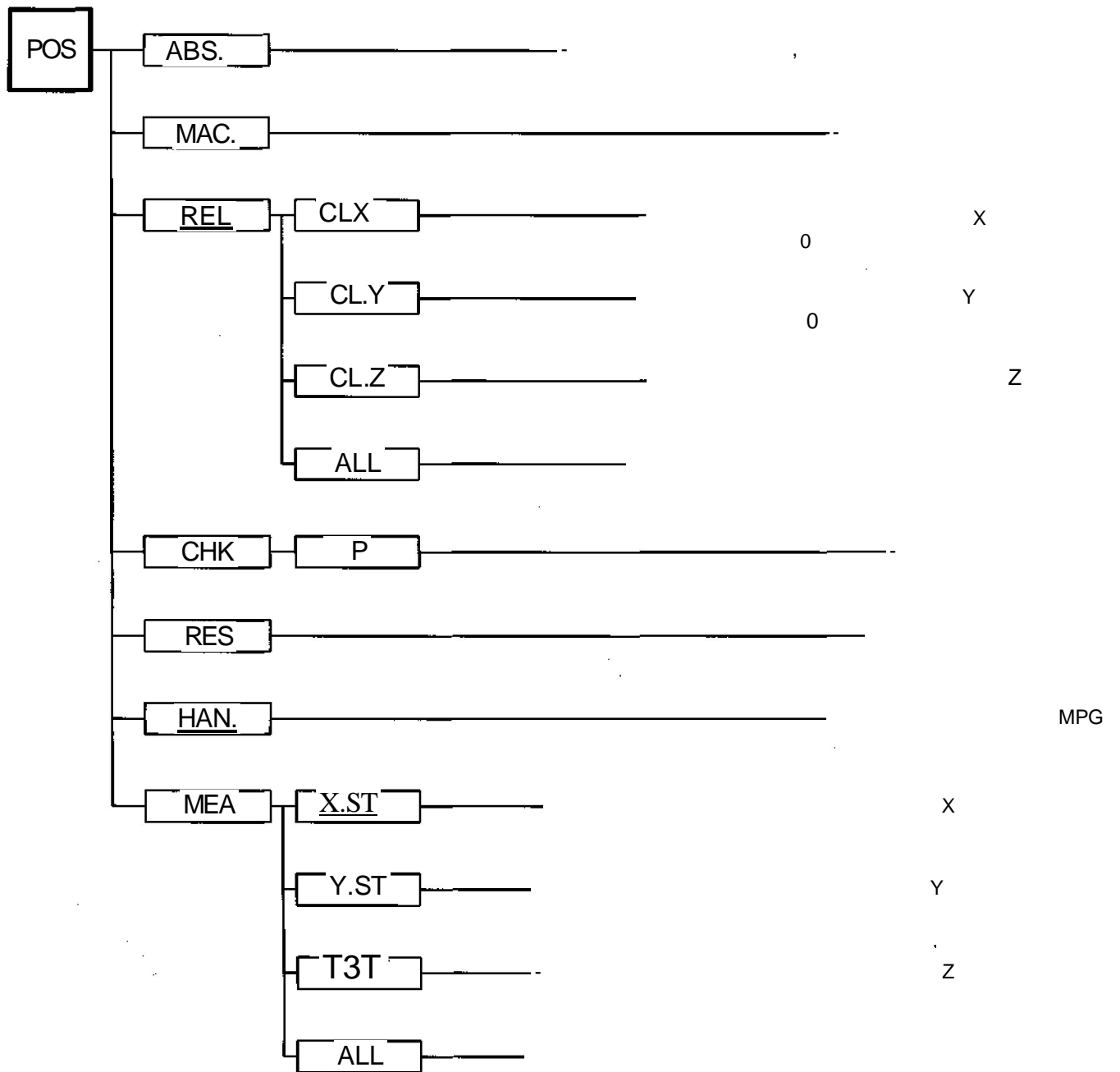
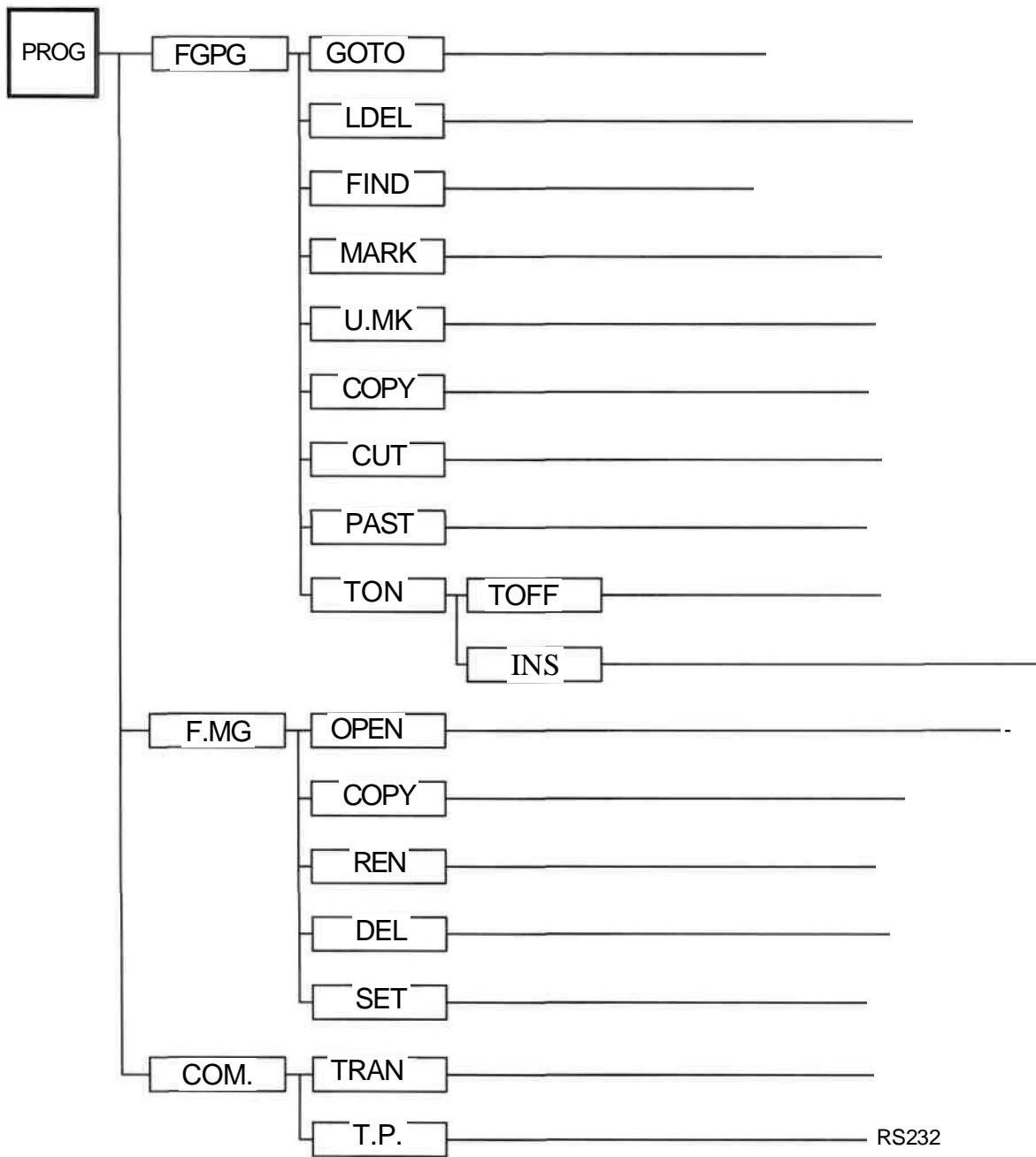


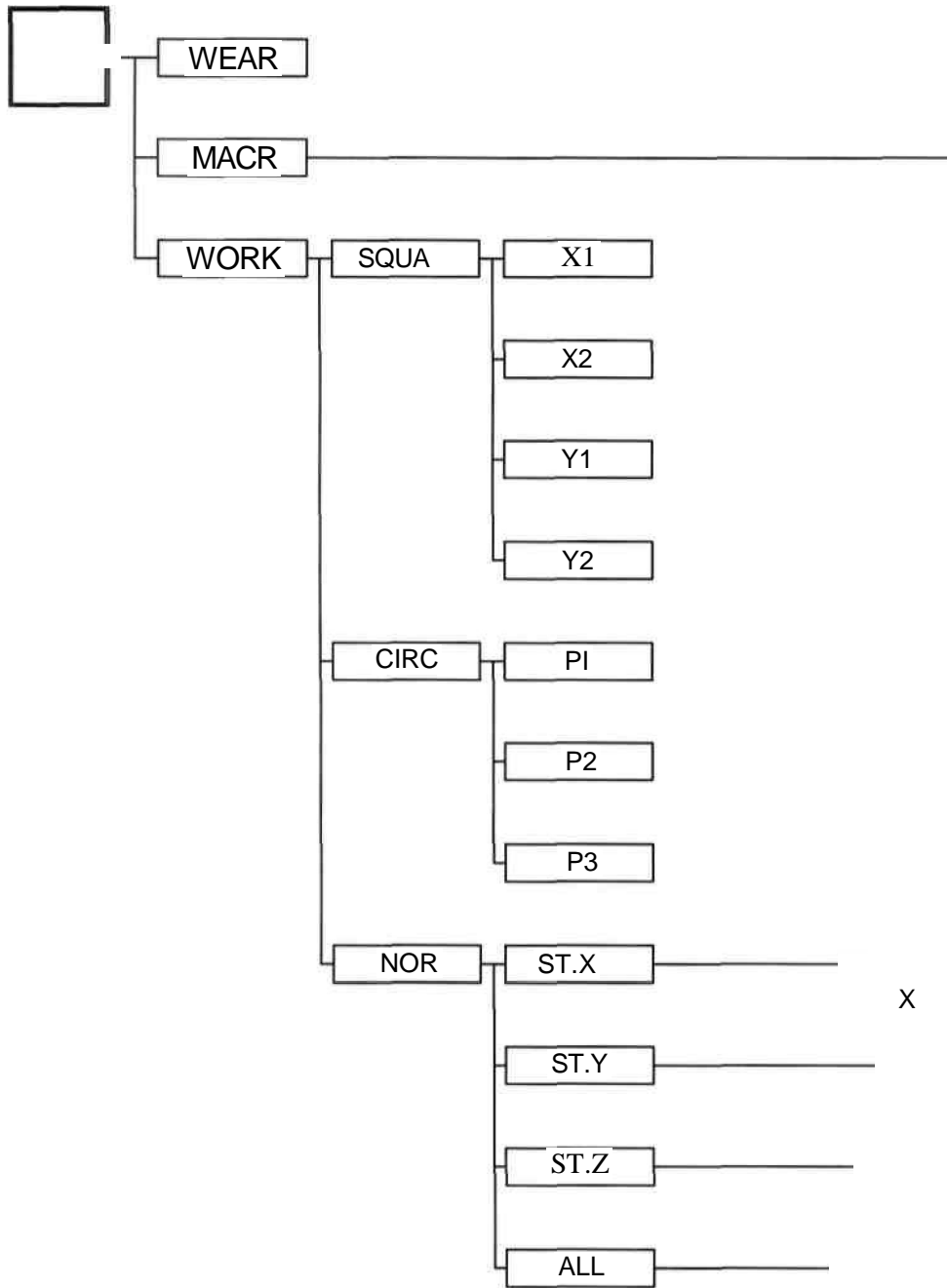
Fig 2-1

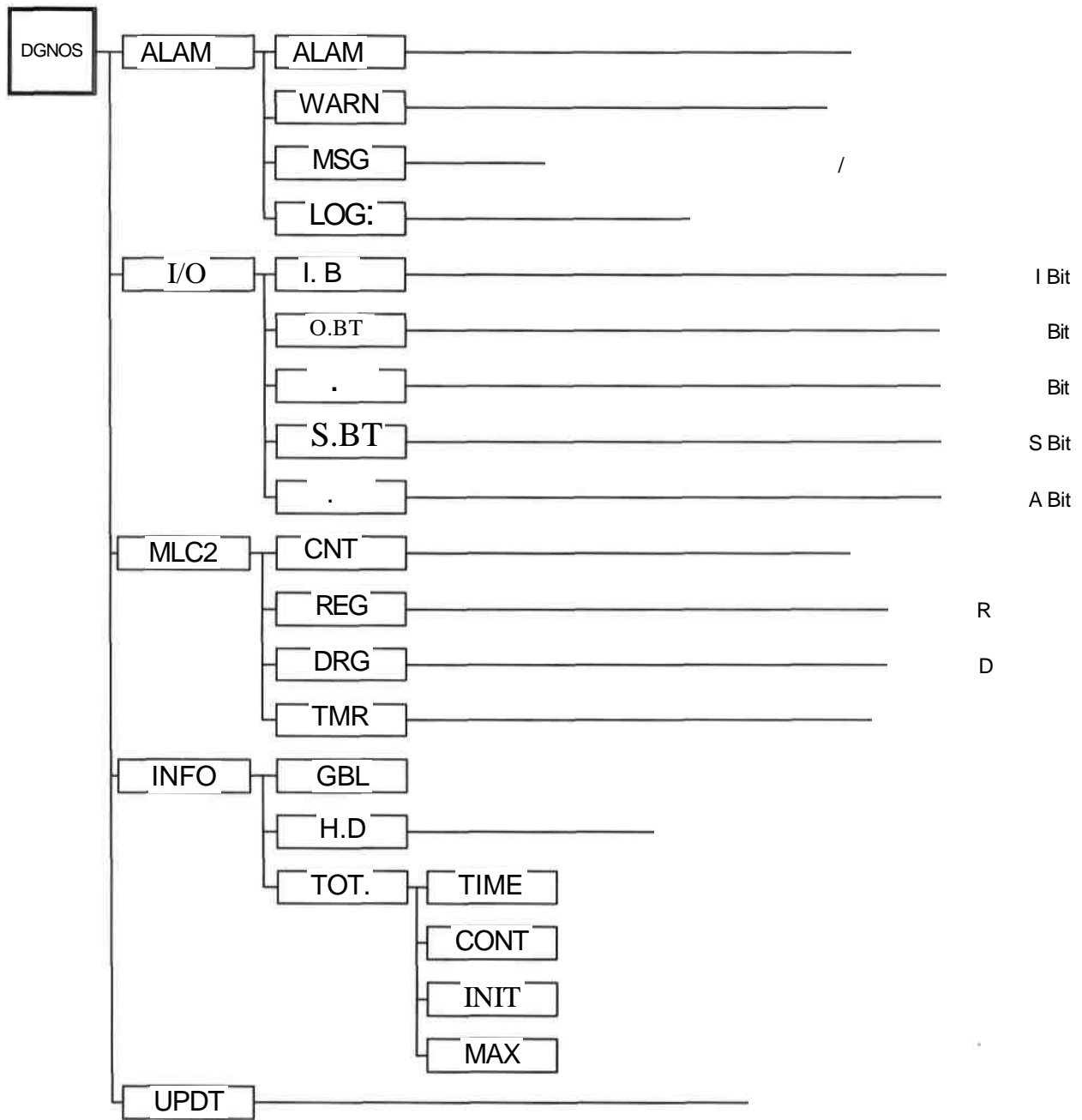
- 1:
- 2:
- 3:
- 4:
- 5:
- 6:
- 7:
- 8:

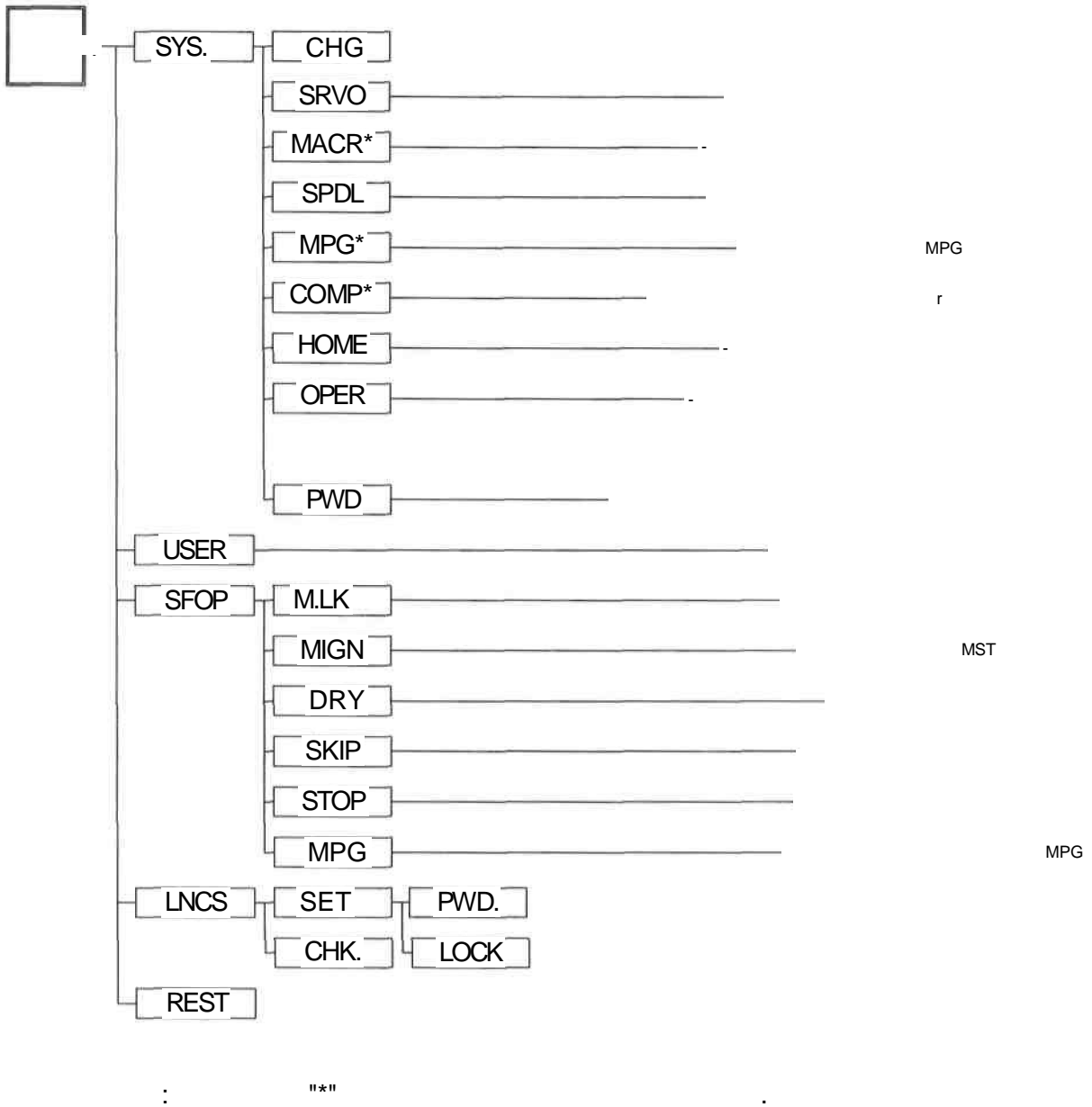
2.2.2





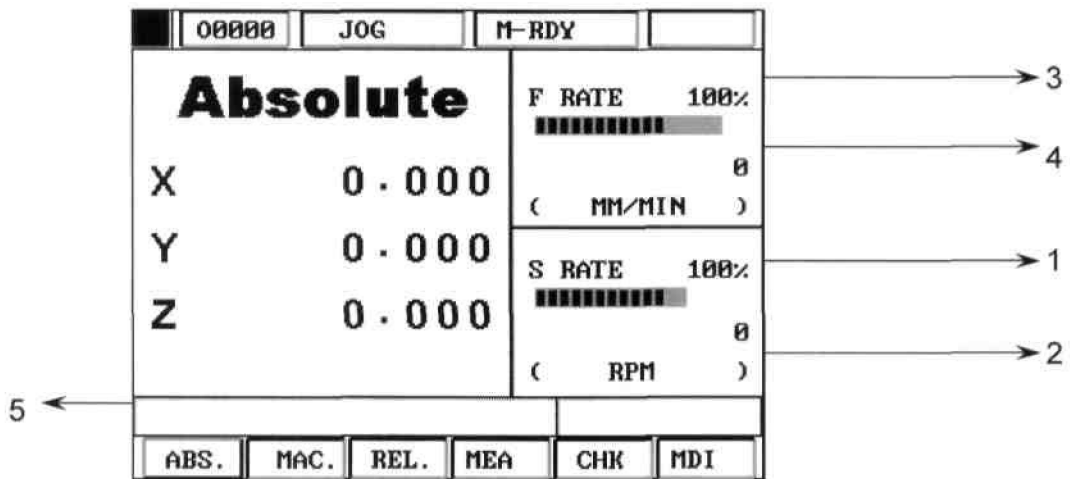






2.3 POS ()

<POS>
 6
 [ABS], [MAC], [REL],
 [MEA], [CHK] [MDI].



.2-2

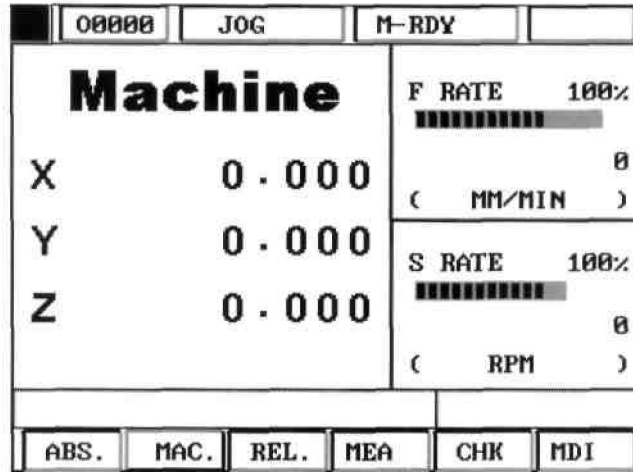
1. :
- 2.
- 3.
- 4.
5. FO : FO, "FO". MEM, MDI JOG, RAPID , . FO N 40. SBK : MEM SBK ("ON"), STL "OFF", BSTOP. (ST) (ON). BDT : MEM (ON).

2.3.1 [ABS.] ()
 [ABS]

00000	JOG	M-RDY	
Absolute		F RATE 100%	
X	0.000	██████████	0
Y	0.000	(MM/MIN)	
Z	0.000	S RATE 100%	
		██████████	0
		(RPM)	
ABS.	MAC.	REL.	MEA
		CHK	MDI

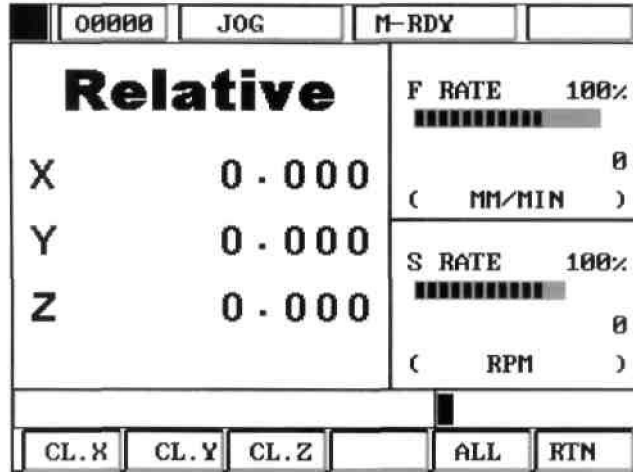
2-3 ABS.
 = (
).

2.3.2 [MAC] ()
 [MAC]



. 2-4 MAC.

2.3.3 [REL] ()
 [REL.]



. 2-5 REL.

0

100.00, X
 Y 200.000 Z 300.000,
 X100, Y200, Z300. <INPUT>

2.3.4 [MAC] ()

2

[MAC]

G92

G92,

00000	JOG	M-RDY	
G92 Set		Absolute	
X:	0.000	X	0.000
Y:	0.000	Y	0.000
Z:	0.000	Z	0.000
X.ST	Y.ST	Z.ST	ALL RTN

.2-6 MAC.

:

[X SET] : X G92
 [Y SET] : Y G92
 [Z SET] : Z G92
 [ALL SET] : X, Y Z G92

: MDI

1. "10"
2. 10 X G92 <INPUT>
3. [X SET] X
- 10.

2.3.5 CHK. ()

[CHK]

[ABS] [DIST TO GO]

F: ()

S: ()

:

S Rate:

00000	MEM	M-RDY	
/*LAYSER MEA. MOVEMENT*/		ABSOLUTE	
G65 P9951 A2 E2 K25 Q20.		X	0.000
M30;		Y	0.000
; /* argument descri		Z	0.000
; /*A(#1)=1 X-axis activ		DIST TO GO	
; /* 2 Y-axis activ		X	0.000
; /* 3 Z-axis activ		Y	0.000
; /*E(#5) Length of 0v		Z	0.000
F	1000 F Rate 100%		
S	0 S Rate 100%		
ABS.	MAC.	REL.	MEA
		CHK	MDI

.2-7 PRO.

2.3.6 MDI ()
 [MDI]

00000	MEM	M-RDY	
(MDI)		(MODAL)	
	G01	G17	G90
	G23	G94	G40
	G49	G80	G98
	G50	G67	G97
	G64	G69	
ABS.	MAC.	REL.	MEA
CHK	MDI		

. 2-8 MDI

MDI,

[MDI]

<INPUT>

"CYCLE

START"

(MODAL): G-

2.4 PROG ()

<PROG>

"EDIT",

00000	EDIT	M-RDY			
/*LAYSER MEA. MOVEMENT*/					
G65 P9951 A2 E2 K25 Q20.000 R0.000 T1					
M30;					
;/*----- argument description -----*/					
;/*A(#1)=1 X-axis active */					
;/* 2 Y-axis active */					
;/* 3 Z-axis active */					
;/*E(#5) Length of OverRun */					
;/*K(#11) No of segment */					
;/*Q(#17) Unists of Vector */					
FGPG	F.MG	COM.			

.2-9

2.4.1

EDIT.

[PREN]

online

[INPUT]

(O0001, 01234...).

<INPUT>

[COMM]

[COMM]

RS232

2.4.2 FGPG ()

[FGPG]

[GOTO], [LDEL], [MARK], [U.MK], [COPY], [CUT] [PAST]

00000	EDIT	M-RDY			
/*LAYSER MEA. MOVEMENT*/					
G65 P9951 A2 E2 K25 Q20.000 R0.000 T1					
M30;					
;/*----- argument description -----*/					
;/*A(#1)=1 X-axis active */					
;/* 2 Y-axis active */					
;/* 3 Z-axis active */					
;/*E(#5) Length of OverRun */					
;/*K(#11) No of segment */					
;/*Q(#17) Unists of Vector */					
GOTO	LDEL	MARK	U.MK	DOWN	RTN

. 2-10 FGPG -1

00000	EDIT	M-RDY			
/*LAYSER MEA. MOVEMENT*/					
G65 P9951 A2 E2 K25 Q20.000 R0.000 T1					
M30;					
;/*----- argument description -----*/					
;/*A(#1)=1 X-axis active */					
;/* 2 Y-axis active */					
;/* 3 Z-axis active */					
;/*E(#5) Length of OverRun */					
;/*K(#11) No of segment */					
;/*Q(#17) Unists of Vector */					
COPY	CUT	PAST		UP	RTN

. 2-11 FGPG -2

[GOTO]

[GOTO]

[INPUT]

(. 2.2.4-3).

[LDEL]

[MARK]

[MARK]

/

[MARK]

(. 2.2.4-4).

[UNMARK]

[COPY]

[CUT]

[PASTE]

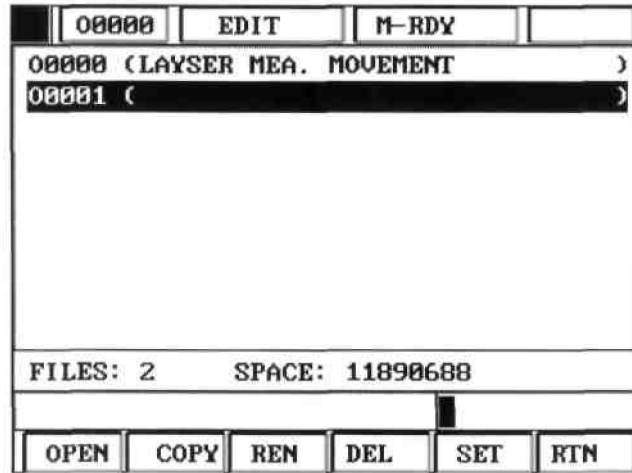
00000	EDIT	M-RDY	
/*LAYSER MEA. MOVEMENT*/			
G65 P9951 A2 E2 K25 Q20.000 R0.000 T1			
M30;			
; /*----- argument description -----*/			
; /*A(#1)=1 */			
; /* 2 LN : <input type="text"/> */			
; /* 3 */			
; /*E(#5) Length of OverRun */			
; /*K(#11) No of segment */			
; /*Q(#17) Unists of Vector */			
YES		NO	

00000	EDIT	M-RDY			
/*LAYSER MEA. MOVEMENT*/					
G65 P9951 A2 E2 K25 Q20.000 R0.000 T1					
M30;					
;/*----- argument description -----*/					
;/*A(#1)=1 X-axis active */					
;/* 2 Y-axis active */					
;/* 3 Z-axis active */					
;/*E(#5) Length of OverRun */					
;/*K(#11) No of segment */					
;/*Q(#17) Unists of Vector */					
GOTO	LDEL	MARK	U.MK	DOWN	RTN

. 2-13 FGPG -4

2.4.3 F. MG ()

[F. MG]



. 2-14 F. MG

[OPEN]

« »

[OPEN].

[COPY]

« »

[COPY] .

" "

(C:),

(A:).

2-22

[DEL]

[REN]

[SET]

[SET] ,

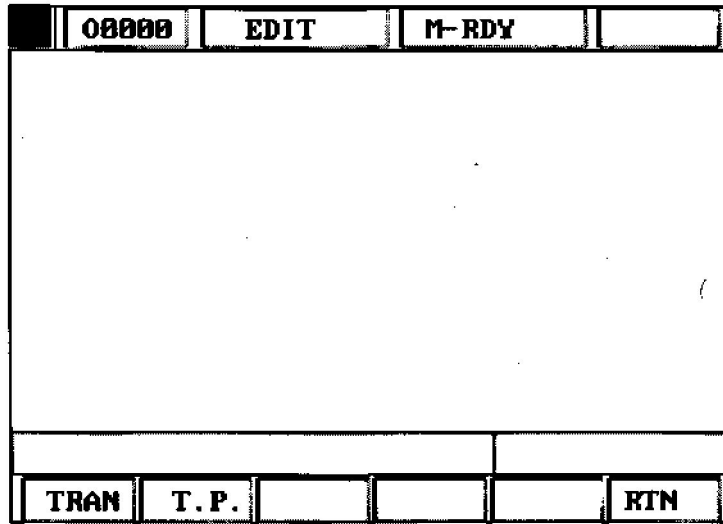
OK.

2.4.4 Com. (RS232)

[COM.]

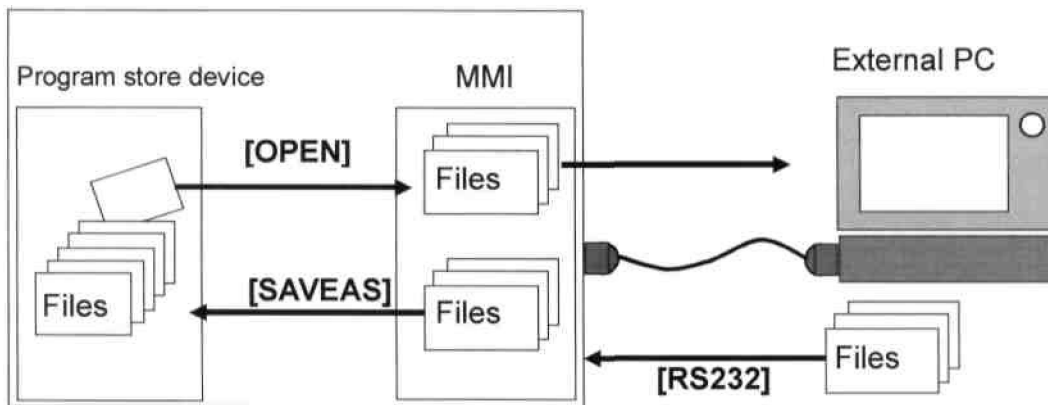
RS232

(COM.).



-15 [COM.]

()

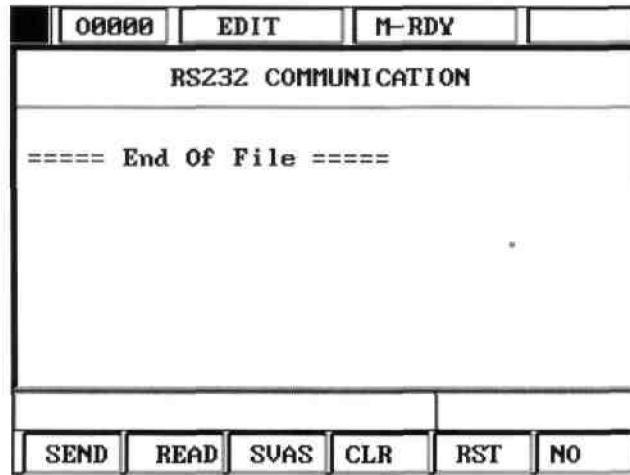


.2-16

/

2 , [TRAN] [T.P] .

[TRAN].



. 2-17 Com.

[COM.],

6

: [SEND] , [READ] , [SVAS] , [CLR] , [RST] [NO] .

RS232,

/

[SEND]

RS232 ().

[READ]

RS232

[SAVE AS]

RS232

[CLEAR]

RS232.

[RESET]

RS232

00000	EDIT	M-RDY	
SELECT FILE			
=====	FILE NAME :	00000	
	C:\LNCM500\NCFILES		
00000	[-A-]		
00001	[-B-]		
	[-C-]		
YES	NO		

Fig. 2-18

RS232
RS232 DNC . [SETT]
RS232.

00000	EDIT	M-RDY	
RS232 SETTING			
Port		COM1	
Data Bit		8_Bits	
Stop Bit		2_Bits	
Parity Check		Even	
Baud Rate		9600	
Mode		Te	
Codes		ASCII	
(1) COM1 (2) COM2			
YES		NO	

. 2-19 SETT

	COM1
	8_
-	2_
	"Even"
	9600
	Terminal
	ASCII

2.4.5 DNC ()

DNC ()

/

Pou Yuen
M500

(

).

1.

RS232

2.

3.

<PROG>

RS232

<INPUT>

RS232.

MEM

"CYCLE START"

4.

5.

2-28

2.5 OFFSET

<OFFSET>

[MACRO]

[WEAR],

[WORK].

MDI M-READY.

NO.	LENGTH	RADIUS
01	0.000	0.000
02	0.000	0.000
03	0.000	0.000
04	0.000	0.000
05	0.000	0.000
INPUT: ABS		ABSOLUTE
UNIT: MM	X	0.000
	Y	0.000
-- WEAR: 1/6 --	Z	0.000

WEAR MACR WORK

. 2-20

2.5.1 WEAR (WEAR OFFSET)

[WEAR]

00000	JOG	M-RDY	
NO.	LENGTH	RADIUS	
01	0.000	0.000	
02	0.000	0.000	
03	0.000	0.000	
04	0.000	0.000	
05	0.000	0.000	
INPUT:	ABS	ABSOLUTE	
UNIT:	MM	X	0.000
		Y	0.000
-- WEAR: 1/6 --		Z	0.000
WEAR MACR WORK			

. 2-21 WEAR Offset

G54~G59 – (= (: - + -) . , <INPUT> MDI M-READY.

2-30

2.5.2 MACR (BACRO)

[MACR]

MACRO

<INPUT>

L

00000	JOG	M-RDY	
NUM	VALUE	NUM	VALUE
L001	VACANT	L011	VACANT
L002	VACANT	L012	VACANT
L003	VACANT	L013	VACANT
L004	VACANT	L014	VACANT
L005	VACANT	L015	VACANT
L006	VACANT	L016	VACANT
L007	VACANT	L017	VACANT
L008	VACANT	L018	VACANT
L009	VACANT	L019	VACANT
L010	VACANT	L020	VACANT
WEAR	MACR	WORK	

2-22

2.5.3 WORK ()

[WORK]

: G54, G55, G56, G57, G58 G59.

7

MDI.

(X100. Y200. Z300.)

<INPUT>

, G54, G55, G56

G57, G58 G59

00000	JOG	M-RDY	
01	G54 Set		Machine
X	0.000	X	0.000
Y	0.000	Y	0.000
Z	0.000	Z	0.000
-- PAGE: 2/7 --			
X. ST	Y. ST	Z. ST	
			ALL RTN

. 2-23

6

. G54 ~ G59

1.

2.

Z300."

3.

<INPUT>

" X100. Y200.

G54~G59,

: [X

SET] :

X [Y SET] :

Y [Z SET] :

Z [ALL SET] :

X, Y, Z.

2.6 DGNOS ()
 <DGNOS> 5 : [ALAM], [I/O],
 [MLC2], [INFO] [UPDT]. HMI
 DGNOS

00006	RAPID	NO-RDY	WARN			
OP 1017: 19:02:33 05/19/2003						
LNC SYSTEM EXPIRED						
OP 1003: 19:02:33 05/19/2003						
Z SERVO ALARM						
OP 1001: 19:02:33 05/19/2003						
X SERVO ALARM						
ALAM			I/O	MLC2	INFO	UPDT

. 2-24

DIAGNOSIS

2.6.1 ALAM ()

[ALAM]

:

00006	RAPID	NO-RDY	ALARM
OP 1017: 19:02:33 05/19/2003			
LNC SYSTEM EXPIRED			
OP 1003: 19:02:33 05/19/2003			
Z SERVO ALARM			
OP 1001: 19:02:33 05/19/2003			
X SERVO ALARM			
ALAM		WARN	MSG
LOG.		RTN	

. 2-25

[ALAM]

[ALAM], [WARN], [MSG] [LOG.].

<RESET>

MLC LADDER.

LADDER

«

».

«

».

LADDER

(

).

MLC LADDER

00006	RAPID	NO-RDY	WARN
VER 01.03.013:Tue Feb 18 14:16:22 2003			
VER 01.03.013:Tue Feb 18 14:16:22 2003			
ALAM	WARN	MSG	LOG.
			RTN

. 2-26 Message Function Screen

2.6.2 IOCSA ([I/O]

	00006	EDIT	M-RDY			
I	000	0 0 0 0 0	C	000 0 0 0 0 0		
	005	0 0 0 0 0		005 0 0 0 0 0		
	010	0 0 0 0 0		010 0 0 0 0 0		
	015	0 0 0 0 0	S	000 0 0 0 0 0		
	020	0 0 0 0 0		005 0 0 0 0 0		
O	000	0 0 0 0 0	A	010 0 0 0 0 0		
	005	0 0 0 0 0		000 0 0 0 0 0		
	010	0 0 0 0 0		005 0 0 0 0 0		
	015	0 0 0 0 0	RIN	000 0 0 0 0 0		
	020	0 0 0 0 0		010 0 0 0 0 0		
I . BT		O . BT	C . BT	S . BT	A . BT	RIN

.2-27

5

(. 2-27).

PAGE I >

[I. BT]
 < PAGE / > <
 [I. BT]

2.6.3 MLC2 ()

[MLC2]

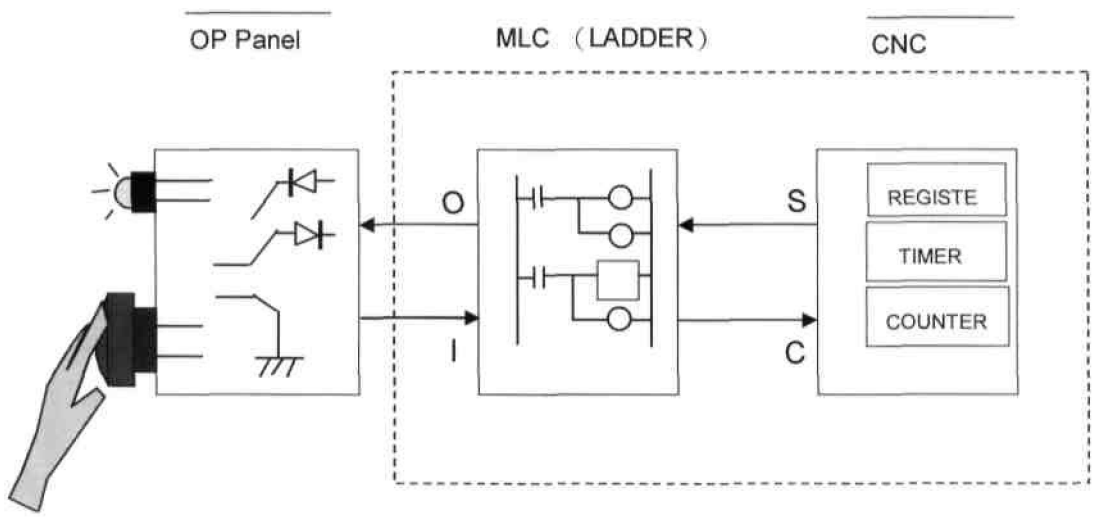
[CNT] , [REG], [DRG] [TMR]

MLC.

00006	EDIT	M-RDY	
NUM	CUR. VAL	SET. VAL	
000	0	0	
001	0	0	
002	0	0	
003	0	0	
004	0	0	
005	0	0	
006	0	0	
007	0	0	
-- PAGE: 1/8 --			
CNT	REG	DRG	TMR
			RTN

.. 2-28 MLC2

[MLC2] [IOCSA] I, , S, A,
 COUNTER, TIMER, REG, DREG.



. 2-29

2.6.4 INFO ()

[INFO]

().

00006		EDIT	M-RDY	
NUM	VALUE	NUM	VALUE	
000	0	008	8	
001	1	009	9	
002	2	010	10	
003	3	011	11	
004	4	012	12	
005	5	013	13	
006	6	014	14	
007	7	015	15	
-- PAGE: 1/3 --				
X AXIS SERVO LAG VALUE				
GBL	H.D	TOT.		RTN

.2-30

[MSG]

00006		EDIT	M-RDY	
NUM	VALUE	NUM	VALUE	
000	0	008	8	
001	1	009	9	
002	2	010	10	
003	3	011	11	
004	4	012	12	
005	5	013	13	
006	6	014	14	
007	7	015	15	
-- PAGE: 1/3 --				
X AXIS SERVO LAG VALUE				
GBL	H.D	TOT.		RTN

.2-31 MSG

MSG:

No.		No.	
0	X-axis servo lag counting value	26	OFFSET of rigid tapping hole position
1	Y-axis servo lag counting value	27	Motion card #
2	Z-axis servo lag counting value	28	DA value of 2 ^{na} spindle
3	4 th -axis servo lag counting value	29	DA value of 3 ^{ra} spindle
4	Waiting MST to be ready signal	30	
5	Flag of waiting to reach actual position	31	
6	Actual spindle rotational speed	32	Actual X-axis machine coordinate value
7	Spindle servo lag counting value	33	Actual Y-axis machine coordinate value
8	Spindle DA output value	34	Actual Z-axis machine coordinate value
9		35	Actual 4th axes machine coordinate value
10	Distance between current spindle to Index or Sensor (Unit: 0.001 degree)	36	Number of rotation of spindle CW
11		37	
12		38	Disable trigger counter
13		39	Distance between current spindle position to Index
14		40	
15		41	Reading value of X axis absolute encoder
16	X-axis MPG command counting value	42	Reading value of Y axis absolute encoder
17	Y-axis MPG command counting value	43	Reading value of Z axis absolute encoder
18	Z-axis MPG command counting value	44	Reading value of axis absolute encoder
19	4th-axis MPG command counting value	45	
20		46	
21	Max. following error of rigid tapping	47	
22	Acceleration estimation value of rigid tapping. (Using on Para. # 1065)	48	
23	Acceleration estimation value of rigid tapping. (Using on Para. # 1064)	49	
24		50	
25			

[DGNOS]

8

(X)

00000	JOG	M-RDY	
DOG:	X=1	Y=1	Z=1
INDEX:	X=1	Y=1	Z=1
ITEMS:	1)SET1 REMOTE I/O MASTER		0
	2)SET1 REMOTE I/O SLAVE0		0
	3)SET1 REMOTE I/O SLAVE1		0
	4)SET2 REMOTE I/O MASTER		0
	5)SET2 REMOTE I/O SLAVE0		0
	6)SET2 REMOTE I/O SLAVE1		0
ANSWER:	CHK I/O SET1 CONNECTOR		
-- PAGE: 1/2 --			
GBL	H.D	TOT.	RTN

. 2-32

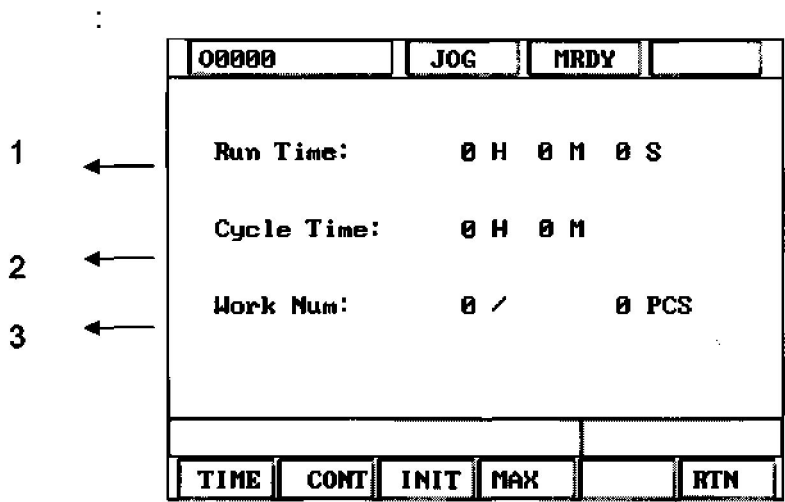
HOME DOG

1,

HOME DOG.

[]

[TIME]



.2-33

1. : "Cycle Start"
2. : 0
3. : M02, M03 M ,

1. :

00000	JOG	MRDY		
Run Time: 0 H 0 M 0 S				
Cycle Ti	Action Confirm			
Work Num	CLEAR TIME?		0 PCS	
YES	NO			

.2-34

2. :

00000	JOG	MRDY		
Run Time: 0 H 0 M 0 S				
Cycle Ti	Action Confirm			
Work Num	CLREA COUNT?		0 PCS	
YES	NO			

.2-35

3. Initial :

(. 2.2.6~13)

00000	JOG	MRDY		
Run Time: 0 H 0 M 0 S				
Cycle				
INPUT INI CNT 100				
Work Num: 0 / 0 PCS				
YES	NO			

. 2-36

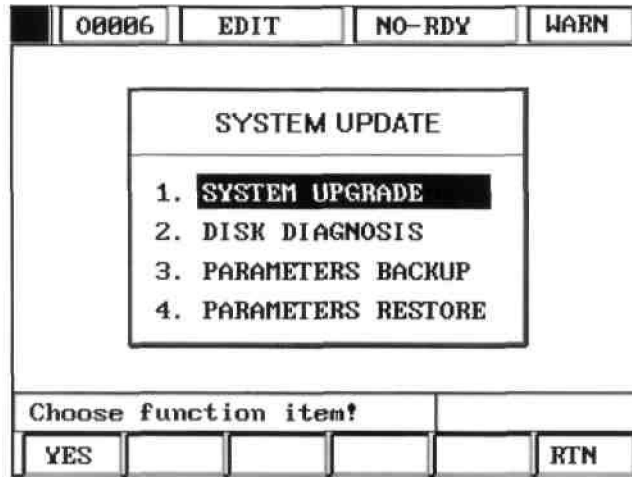
4. Maximum :

00000	JOG	MRDY		
Run Time: 0 H 0 M 0 S				
Cycle				
INPUT MAX CNT 500				
Work Num: 0 / 0 PCS				
YES	NO			

. 2-37

2.6.5 UPDT ()

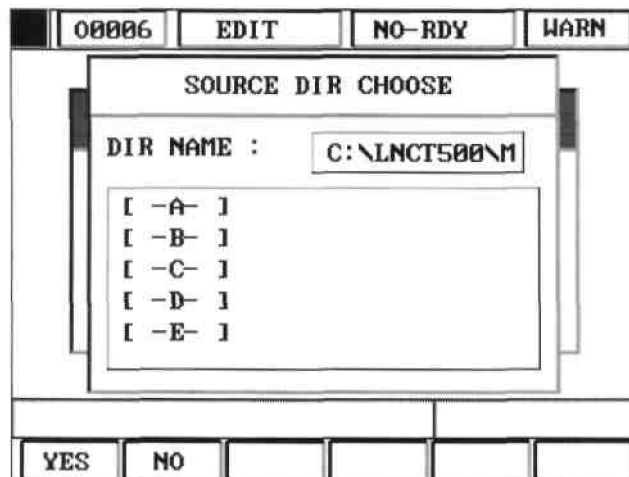
[UPDT] EMG-STOP.
(. 2.23-1).



. 2-38

1.

Pou Yuen. [YES],



"OK";

"OK"

"OK"

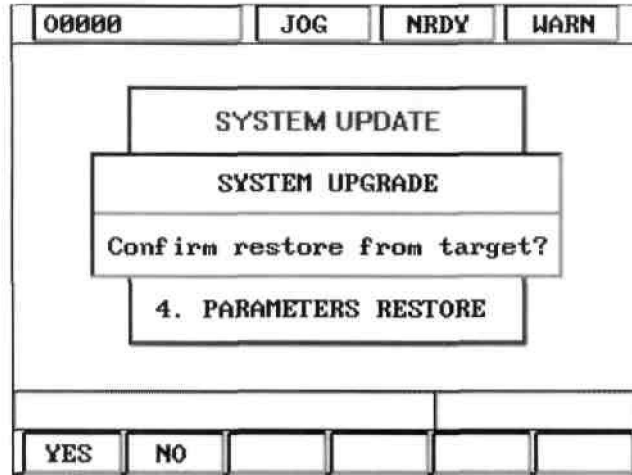


Fig. 2-39

"OK"



"1". (.).

```
=====
LNC-M500 INSTALL UTILITY V1.20
Copyright (C) POU CHEN 2002 05/07/2001
=====

1.Install
2.Maintain
3.Quit and Restart

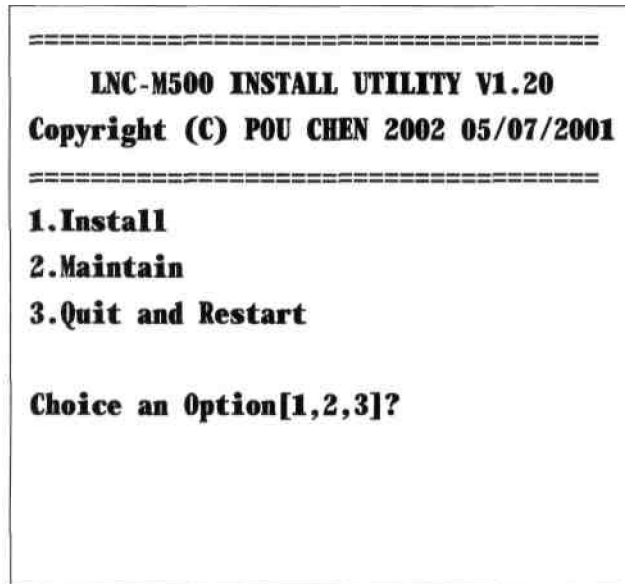
Choice an Option[1,2,3]?
```

"Y".

```
Previous system of [C:\LNCM500] found.
It will be moved to [C:\LNCM500.BAK]!

Previous Backup of [C:\LNCM500.BAK]
Found, it will be DELETED!

Make sure for INSTALL[Y,N]?
```



2.

:

(.2.2.6-

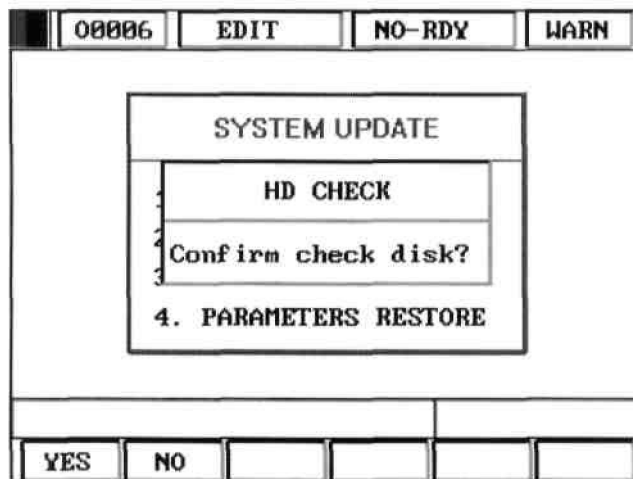
12).

DOS (.2.2.6-13).

A

4

: (1) VTSCAN, (2) DISK doctor, (3) DEFRAG, (4) QUIT.



. 2-40 H.D.

Welcome maintenance utility ...
What DRIVE to DIAG[A,C]?C

1.PCscan

Virus checking

2.DISK doctor

Disk diagnostic and error-fix

3.DEFRAG

Disk access performance enhancement

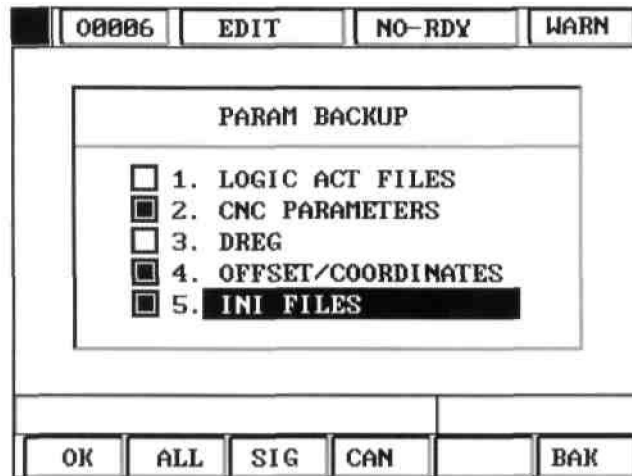
0.Quit

Choise an Option[0,1,2,3]?

. 2-41

3.

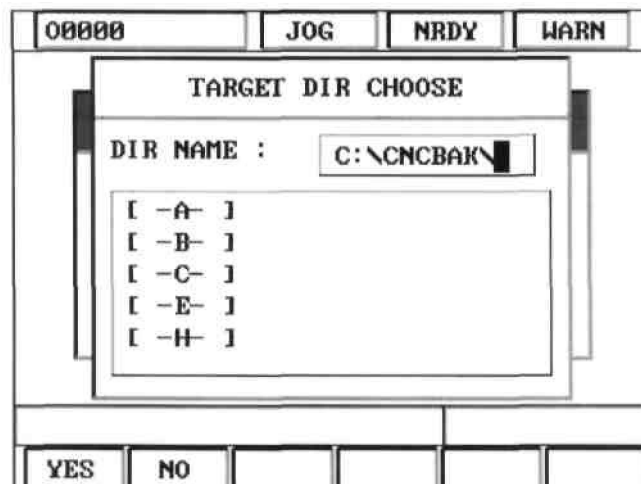
:



. 2-42

"OK"

"OK".



4.

00006	EDIT	NO-RDY	WARN
SYSTEM UPDATE			
ATTENTION			
AFTER FINISHED, IT WILL RESTART SYSTEM			
4. PARAMETERS RESTORE			
YES			

. 2-43

"YES"

"SIG"

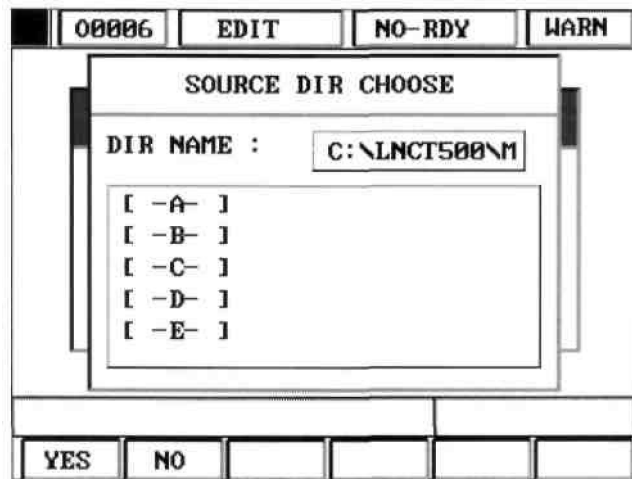
;
"ALL".

00006	EDIT	NO-RDY	WARN
PARAM RESTORE			
<input checked="" type="checkbox"/> 1. LOGIC ACT FILES			
<input type="checkbox"/> 2. CNC PARAMETERS			
<input checked="" type="checkbox"/> 3. DREG			
<input checked="" type="checkbox"/> 4. OFFSET/COORDINATES			
<input type="checkbox"/> 5. INI FILES			
OK	ALL	SIG	CAN
			BAK

. 2-44

"OK"

"OK".



2-52

Pou Yuen Technology Corp.

2.7 PARAM

<PARAM>

5

: [SYS.], [USER], [SFOP], [LNCS] [REST].

00006	EDIT	CSTART	
0002	30000	0013	230
0004	30000	0014	100
0005	30000	0018	50
0006	50	0022	1
0008	50	0024	1
0009	50	0026	3
0010	230	0027	0
0012	230	0040	10
-- PAGE: 1/3 --			
MAX FOLLOWING ERR X AXIS			
SYS.	USER	SFOP	LNCS
			REST

. 2-46

(1)

(2)

(3)

[PGDM] [PGUP]

Pxxx.

<INPUT>.

#

xxxx.

<INPUT>

(4)

MDI.

(5)

2.7.1 SYS. ()

[SYS] . 8
 : [SEVO], [MACR], [SPDL], [MPG],[COMP], [HOME], [OPER] [OTR]

00006	EDIT	M-RDY	
0002	30000	0013	230
0004	30000	0014	100
0005	30000	0018	50
0006	50	0022	1
0008	50	0024	1
0009	50	0026	3
0010	230	0027	0
0012	230	0040	10
--- PAGE: 1/3 ---			
MAX FOLLOWING ERR X AXIS			
SRVO	MACR	SPDL	MPG
PGDN	RTN		

. 2-47 1

00006	EDIT	M-RDY	
0038	16	0118	0
0044	0	0119	0
0046	0	1018	30000
0047	0	1020	30000
0112	20	1021	30000
0114	20	1046	0
0115	20	1048	0
0117	0	1049	0
--- PAGE: 1/12 ---			
BACKLASH/PITCH COMP UNITS			
COMP	HOME	OPER	OTR
PGUP	RTN		

. 2-48 2

2.7.2 USER ()

[USER]

00006	EDIT	M-RDY	
01.Prg Prtct		0	
02.ZRN RQUIRE		0	
03.HOME 1ST		0	
04.RPD 50%		0	
05.TOOL NO		0	
06.DR INTRLCK		0	
07.LUB. MTHD		0	
08.LUB. ON		0	
09.LUB. OFF		0	
10.POWER OFF		0	
-- PAGE: 1/2 --			
0: EDITABLE		1: PROTECT	
			RTN

.2-49

"MDI".

0

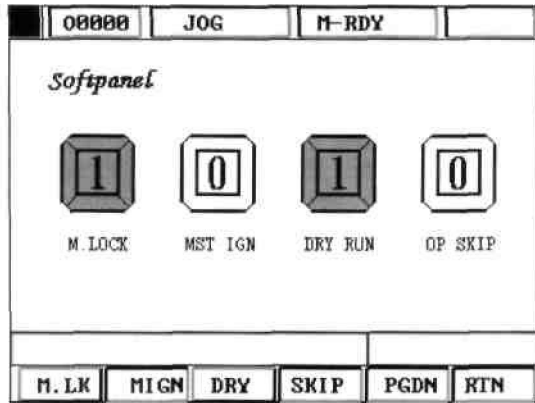
2.7.3 SOFTPL

[SOFTPL]

5

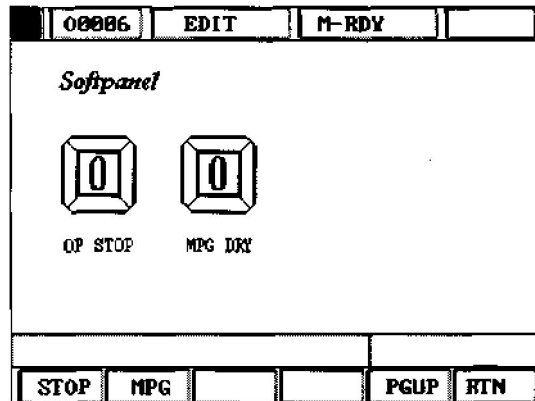
5
[M.

LK), [MIGN], [DRY], [SKIP], [STOP], [MPG].



. 2-50

-1



. 2-51

-2

0 1

:
"1":
"0":

ON ()
OFF ()

:

	ON	OFF
(M. LK) Machine Lock		
(IGN) MST Ignore	M, S, T	M, S, T
(DRY) Dry Run	(GOO),	
(SKIP)	7"	7"
(STOP) Optional Stop	M01. "CYCLE START".	M01
(MPG) Hand Wheel Dry Run		

2.7.4 LNCS

[, 2 :

[[/ .

:

? .

? + .

"CYCLE START" - , , [Unlock

Code] (). , 'Y'

[CHK] (: , "CYCLE START").

[] [].

: [2002/7/11].

, : :: :

. .,17:54:58 (.).

00006	EDIT	M-RDY	
DESC.: POU-YUEN TECH CORP.LTD			
DATE: 2003/05/19		TIME: 19:48:59	
MKR.: 2002/12/30		ACC.: 001512:02	
LOTS: 5			
NO.	DEADLINE	CHK	NO. DEADLINE CHK
1	2002/12/30	Y	6 ----/--/-- -
2	2003/01/31	Y	7 ----/--/-- -
3	2003/02/31	N	8 ----/--/-- -
4	2003/03/31	N	9 ----/--/-- -
5	2003/04/31	N	A ----/--/-- -
NOI31EXPIRE ERR			
SET	CHK.		RTN

. 2-52

[]

(, 000000:00, 6)

, 2

[]

[Setting Complete],

(,)

00006	EDIT	M-RDY	
DESC.: POI-YUEN TECH CORP. LTD			
DATE: 2003/05/20		TIME: 09:33:36	
MKR.: 2002/12/30		ACC.: 001512:02	
LOTS: 5			
NO.	DEADLINE	CHK	NO. DEADLINE CHK
1	2002/12/30	Y	6 ---/--/-- -
2	2003/01/31	Y	7 ---/--/-- -
3	2003/02/31	N	8 ---/--/-- -
4	2003/03/31	N	9 ---/--/-- -
5	2003/04/31	N	A ---/--/-- -
PRIVILEGE MODE			
		PWD.	ID.S
			RTN

. 2-53

DESC: (: 30
/).

LOTS: # (. 10).
DEADLINE of Each Term:

PWD. of Each Term: ,
[Unlock]
[PWD.]

. (, , ,
: "168168".)
[ID.S] ()
[Lock
Mode] (: , , ,

(ENTER.)

2.7.5

[REBOOT]

).

DOS.

00006	EDIT	M-RDY	
0002	30000	0013	230
0004	30000	0014	100
0005	30000	0018	50
000	RESET SYSTEM		1
000			1
000	Do you want to reboot system?		3
0010	230	0027	0
0012	230	0040	10
-- PAGE: 1/3 --			
YES	NO		

.2-54

2.8

<RESET> 3 :

a.

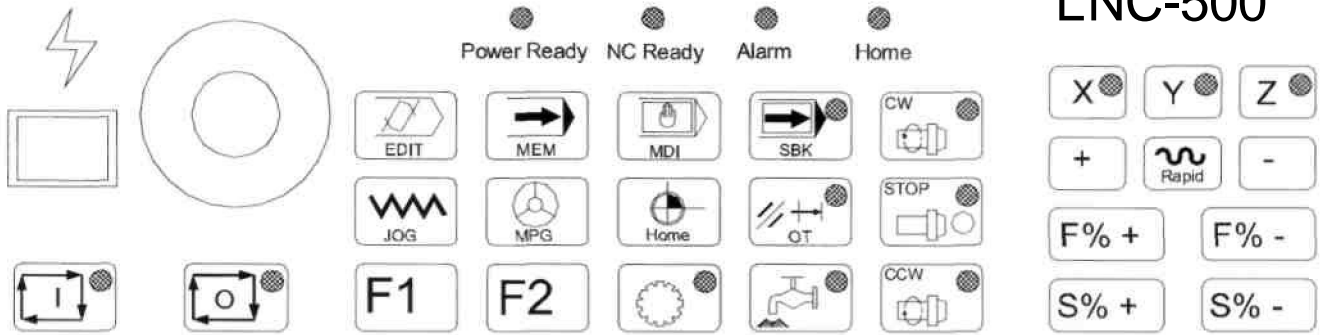
, ,
, <RESET> ,
.

b.

, -
, <RESET>
, .

c.

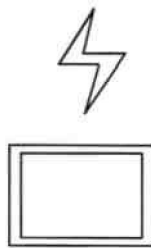
, <RESET>
, .



. 3-1

3.1

(ON/OFF)

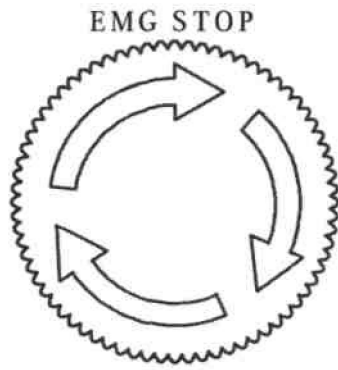


. 3-2

"ON"

"OFF",

3.2 EMG-STOP ()

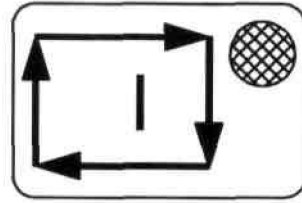


. 3-3

"Not Ready" (

Not Ready).

3.3



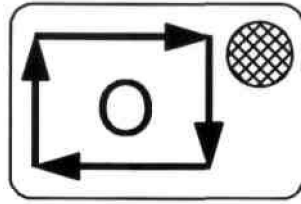
. 3-4

START" , MEM MDI "CYCLE
ON. "CYCLE START" :

(1) - MEM: MEM, "CYCLE
START" ON
, 3 Reference
Need to OFF

(2) - MDI: , G91 G01
X100. Z100 MDI. "CYCLE START"
MEM, -
ON

3.4



.3-5

FEED HOLD (ON). M, S T
(S), (T) (M),
"CYCLE START",

3.5



. 3-6

PWR RDY :

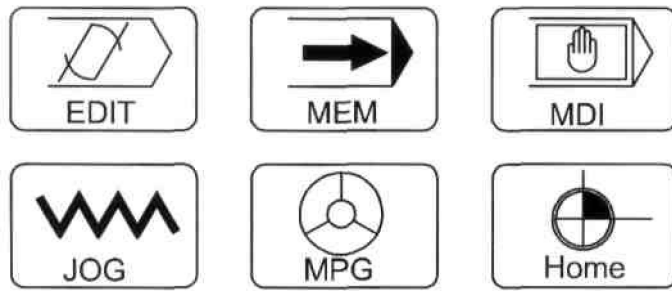
NC RDY :

ALARM :

HOME:

HOME.

3.6



.3-7

7 : MDI, MEM, EDIT, JOG,

HOME MPG.

(1)

(2) MEM

(3) MDI

(4) JOG

MPG

, 1 , 10 , 100 ,
(0.001 0.0001).



.3-8

5) MPG

MPG

, 1 , 10 , 100 ,
(0.001 0.0001).

(6) HOME

, JOG).

DOG.

HOME,

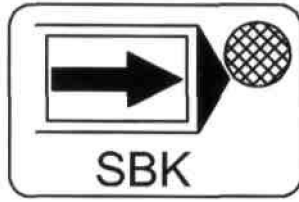
ON.

ON

HOME.

Home

3.7

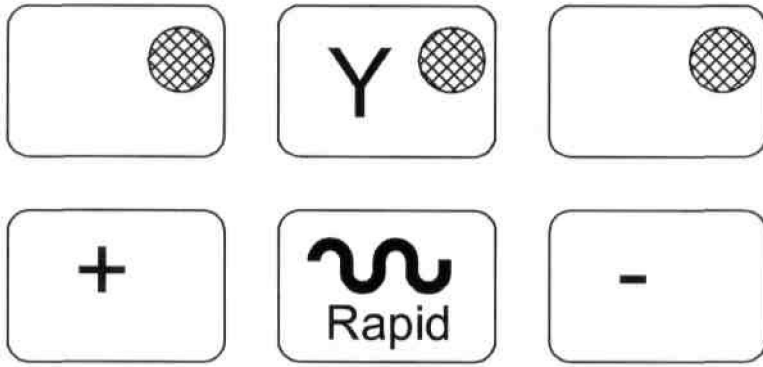


. 3-9

MEM,

SBK,
"CYCLE START"
"OFF",

3.8



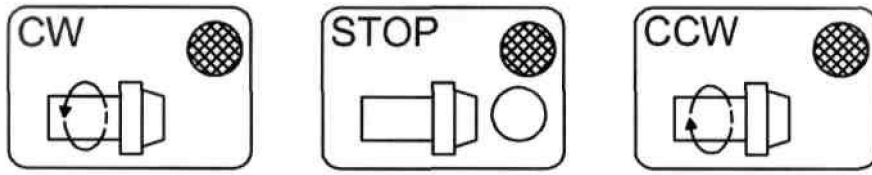
. 3-10

JOG, RAPID, HOME). , "+X" (JOG , X ,

"Rapid"

+/-

3.9



.3-11

JOG RAPID,

3

:

:

:

0% ~ 120%

(

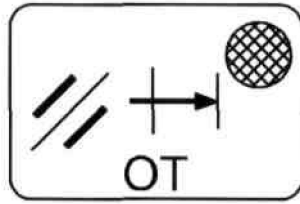
)

MPG.

STOP,

,

3.10



.3-12

REL

Over Travel RELease.

TRAVEL"

"EMERGENCY STOP OR OVER

MPG

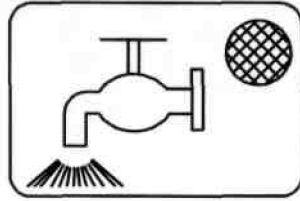
JOG.

ON),

REL)

[RESET]

3.11



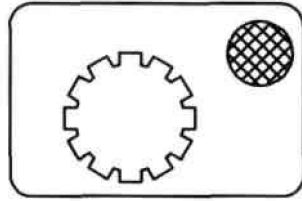
. 3-13

ON:

ON

OFF:

3-12
3.12

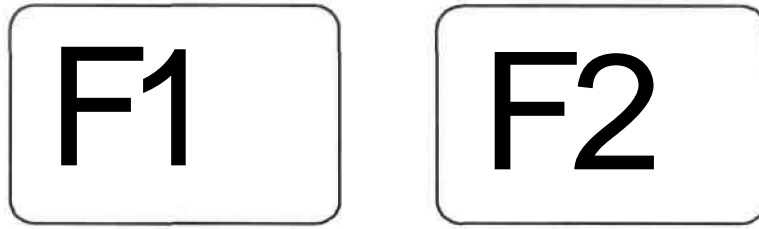


ON:

ON

OFF:

3.13



.3-15

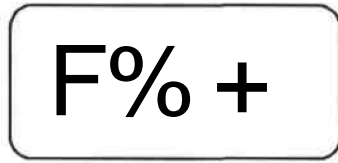
F1 :

.. F2 :

..

3.14

. 3-16



(1)

:

(MEM MDI),

G01.

"F100"

100 / .

0 - 150%.

50%,

50 / .

JOG

LADDER

(2)

:

Jog.

4

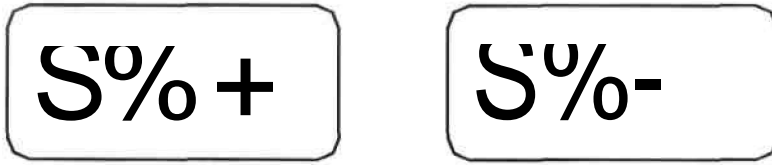
: F0,

25%, 50%, 100%

F0

No.40.

3.15



. 3-17

MEM MDI,

. 0% - 120%. , M03 S1000,
120%,

1200 / .