JULY 1994 VER 1.0

FX650 PROFESSIONAL 3

OPERATION MANUAL

(MOFX650PRO-01)

CONTENTS

PAGE

CHAPTER 1. UNIT IDENTIFICATION.

1.1 MTC Cabinet 1-1
1.2 Operator Station 1-3
1.3 Manual Pulse Generator (MPG) 1-5

CHAPTER 2. OPERATION OPERATOR STATION

2.1 Operation of Operator Station 2-1
2.2 Power ON/OFF and Emergency Stop 2-1
2.3 Cycle Start/stop and Spindle Operation 2-2
2.4 NC Mode 2-4
2.5 NC Functions 2-6
2.6 Auxiliary Functions 2-9
2.7 Selector Switches and Rotary Switches 2-11
2.8 Indicators 2-13
2.9 Main Control Panel Flexible Switches 2-15
2.10 Manual Pulse Generator (MPG) 2-17

CHAPTER 3. EMERGENCY STOP AND ALARM

3.1 Emergency Stop Operation 3-1
3.2 Alarm Operation 3-3

CHAPTER 4. PROCEDURE FOR START-UP AND POWER OFF

4.1 Turning On Power 4-1
4.2 Turning On Air Supply. 4-2
4.3 Turning Off Power 4-2

CHAPTER 5 MANUAL MODE

5.1 Introduction 5-1
5.2 Manual Axis Feed 5-1
5.3 Manual Reference (Zero Point) Point Return 5-3
5.4 Axis Overtravel 5-3
5.5 Starting & Stopping Spindle 5-4
5.6 Spindle Fixed Angle Positioning (Orientation) 5-4
5.7 Spindle Tool Loading/Unloading 5-5
5.8 Automatic Tool Changer (ATC) 5-5
5.9 Nozzle Coolant 5-5

CHAPTER 6 MDI MODE

6.1 MDI Mode 6-1

CHAPTER 7 EDIT MODE

7.1 Introduction 7-1
7.2 Part Program Storage and Editing Screens 7-1
7.3 Part Program Library Management Screens 7-4

CHAPTER 8 MEMORY MODE

8.1 Power On and Memory Mode Selection 8-1
8.2 Machine Reference 8-2
8.3 Display of Axes Position 8-3
8.4 Tool Offset 8-7
8.5 Work Coordinate System 8-12
8.6 Set up For Memory Operation 8-14
8.7 Program Run In Memory Mode 8-17
8.8 Program Re-start 8-24

CHAPTER 9 DNC/TAPE MODE

9.1 Introduction 9-1
9.2 DNC Operation From A Computer 9-1
9.3 Tape Operation 9-2

CHAPTER 10 ATC OPERATION.

10.1 Control Panel 10-1
10.2 Tool Loading and Unloading 10-2
10.3 Set up For ATC Operation 10-5
10.4 ATC Operation 10-10
10.5 Restoration of ATC From Hang up 10-14
10.6 Additional Features in ATC For Heavy Tool 10-16

CHAPTER 11 PC SCREEN

11.1 PC Screen Type 11-1
11.2 PC Initial Screen (Primary Operation Screen) 11-2
11.3 Tool Detail Screen 11-5
11.4 Tool Monitor Screen 11-8
11.5 Help Screen 11-12
11.6 Alarm Screen 11-13
11.7 Diagnose Screen 11-16
11.8 Maintenance Screen 11-18
11.9 Parameter Screen 11-23
11.10 Regular Maintenance Screen 11-27

CHAPTER 12 TOOL MONITORING FUNCTION

12.1	Tool Monitoring Functions	12-1
12.2	Adaptive Control Function	12-1
12.2	Study Function	12-1
12.3	SL Function	12-3
12.4	AC Function	12-4
12.5	Program Example	12-5
12.6	Tool Life Monitoring Function	12-6
12.7	Tool Monitor Alarm	12-6
12.8	Tool Monitor Mode Selection	12-7
12.9	M Codes For Tool Monitoring Functions	12-7

CHAPTER 13 SPARE TOOL SELECTION (STS)

13.1	Spare Tool Selection (STS)	13-1
13.2	Registration Of Spare Tool	13-1
13.3	Tool Length and Cutter Compensation For Spare Tool	13-2
13.4	Program Example	13-2

CHAPTER 14 DIRECT SPARE TOOL CHANGE

14.1	Direct Spare Tool Change	14-1
14.2	DNC Operation Program	14-3
14.3	Restriction Of Direct Spare Tool Change	14-3

CHAPTER 15

15.1	One Touch Function	15-1
15.2	Functional Details	15-2

APPENDIX A1 M-CODE LIST A1-1

APPENDIX A2 ALARM MESSAGES A2-1