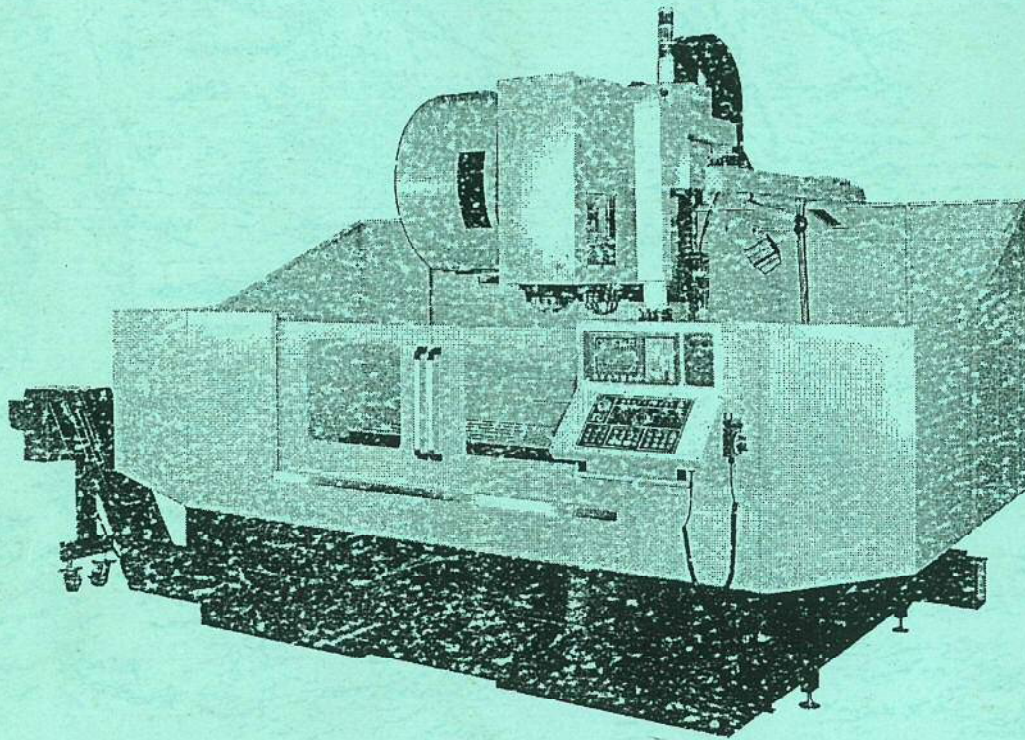


JIUH-YEH PRECISION
MACHINERY Co., Ltd.

MILLSTAR
JIUH-YEH

(Electrical Operation Manual)



Version: First

Date: 2012.07

ADDRESS: 195, Industrial 11th Rd, Tali, Taichung, Taiwan, R.O.C.

TEL : 886-4-24915298

FAX: 886-4-24915301

CONTENTS

1. Notes before Operation and Procedures of Turning ON/OFF the Power...	1-1
1.1 Notes for Operation.....	1-1
1.2 Special Notes before Booting.....	1-1
1.3 Operation Procedures of Turning ON/OFF the Power.....	1-2
2. Instruction of FANUC monitor and OP (Operation Panel).....	2-1
2.1.1 FANUC 0i-MD Controller.....	2-1
2.1.2 OP (Operation Panel).....	2-1
2.2 Main Operation Panel & Function Description.....	2-2
2.3 Description of Electronic Hand Wheel & Other Features.....	2-15
2.3.1 Drawing of Electronic Hand Wheel.....	2-15
2.3.2 Description of Other Features.....	2-16
2.3.3 The 4-th Axis ON/OFF.....	2-17
3. Manual Instruction.....	3-1
3.1 Zero Return (ZRN).....	3-1
3.2. Jog Feed.....	3-3
3.3 Handle Feed.....	3-4
3.4. Rapid Feed.....	3-5
3.5. Manual Tool Clamp and Unclamp Operation.....	3-6
3.5.1 Manual Tool Unclamp Operation.....	3-6
3.5.2 Manual Clamp Operation.....	3-7
3.6. Manual Spindle Rotation.....	3-8
4. Automatic Operation.....	4-1
4.1 Program Execution.....	4-1
4.1.1 Program Startup (MEM、MDI).....	4-1
4.1.2 Program Halt.....	4-1
4.2 Instructions of Machining Program.....	4-2
4.2.1 Instructions.....	4-2
4.2.2 Program Search.....	4-3
4.2.3 Editing a New Program.....	4-3

CONTENTS

4.2.4 Program Modification.....	4-5
4.2.5 Delete a Program.....	4-6
4.3 Manual program execution (MDI).....	4-13
4.3.1. Program input.....	4-13
4.3.2. Login Tool number.....	4-16
5. M Code List and Instruction for Functions.....	5-1
6. Alert/Operation Instruction.....	6-1
6.1. Controller Alarm.....	6-1
6.2. Alarm List.....	6-2
6.3. Operation Message List.....	6-4
6.4. External Alert and Troubleshooting.....	6-5
6.5. External Operation Instruction.....	6-29
Appendix 1: Security Gate Function Flow Diagram.....	6-32
Appendix 2: Macro Program.....	6-34