

MAIN MENU



MACHINE PARAMETERS



PLC PARAMETERS



PLC PARAMETER 11 = LUBE. TIMER UNIT IN SEC.

PLC PARAMETER 12 = LUBE. PERIOD UNIT IN MIN.

The CNC PLC Parameters: **P11, P12**

The two PLC timers to control axes lubricated pump function.

P11 = 15 (Seconds): The Lubricated Pump Turning Period.

P12 = 30 (Minutes): Deactivate The Lubricated Pump Turning Period.

For examples:

While the machine is executing part-program, you can control axes lubricated pump function by the PLC timers. While the machines go into AUTO mode, the lubricated pump would be automatic turning 15 seconds (**P11**) per 30 minutes (**P12**).