KEEP RELAY(Operator) 04:21:05 1. Grinding wheel spindle is completed whether to stop (0:YES,1:NO) 2.Y-axis motor excitation relieves (0:NO,1:YES) 3.Man-machine screen capture to USB function (0:Cancel,1: enabled) 4. Rotating magnetic disk grinding function (0: Cancel, 1: enabled) 5. Y-axis operation jog down feed (0: Auto, 1: Manual / Auto) 6. Rotating magnetic disk grinding Y-axis feed (0:Forw,1: Back) 8.CE, Safety door automation complete, wheel motor power off

MSG

HOME

SET

I/O

KEEP RELAY (USER) 04:21:19 11. Handwheel of panel enable button(0:touch on,1:keeping) 12.Z axis reversal point boot is not clear(0:Cancel , 1:Enable) 13.Z-axis step feed determined by(0:VR, 1:HMI) 14.Z-axis step feed parameter(0:mm 1:inch) 15.surface mode down-feed side choice(0 : double > 1 : single) 16.surface mode down-feed side choice when single is choosed(0 : inside , 1 : outside) (1) 18. Wheel motor don't automatically stop(0 : Cancel,1 : Enable) SET 1/0 MSG HOME

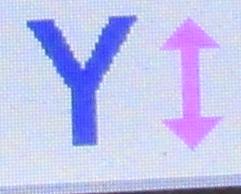
KEEP RELAY(Optional)(Oerator) 04:21:32 a. Handwheel on panel (Y axis) b. Y axis handwheel Handwheel type (choose one) c. Z axis handwheel d. Y.Z axes handwheel SET 1/0 MSG HOME

04:21:59

TIMER(Maintenace)

1.Oil Pressure,Oil level is alarm,detection time(Sec)Min:0.1	10.0
2.X-axis about reversing solenoid valve delay time(Sec)Min:0.0	0.0
3.X-axis grinding is complete,back to the time(Sec)Min:0.0	0.1
4.Z-axis forward,backward changing of time(Sec)Min:0.1	0.2
5.Z-axis forced to change,button press delay time(Sec)Min:0.0	0.0
6.Y=0 start button and press the delay time (0.1Sec) Min: 0.0	0.2
7.Z-axis automatic feed Volume max (mm) Max: 35	25.0
(_Z-axis automatic room room)	0

HOME



MSG

WO.

SET



KEEP RELAY(Maintenace) 04:22:16 1.Lubricants level Signal is (0: LOW = ON, 1: LOW = OFF) 2.wheel motor start must be hydraulic motor running, CE (0: NO, 1: YES) 3.X-axis grinding halt after the completion position (0: right, 1: left) 4.Z-axis forced to change direction, Y-axis is the feed (0: NO,1: YES) 5.Y-axis to reach the target point, 1µ of feed (0: Allow, 1: not allowed) 6.Intermittent zero-grinding, Y-axis feed (0: Allow, 1: not allowed) 7.No spark grinding, Y-axis feed (0: Allow, 1: not allowed) 8.Z-axis Grinding the completion, to stop in front (0: Allow, 1: not allowed) 9. Automatic start, Wheel motor is running (0: YES, 1: NO) SET WO MSG HOME