

PMC PRM (KEEP RELAY)

	#7	#6	#5	#4	#3	#2	#1	#0
K000	COOL			DIL		SSTP		

SSTP (Panel spindle stop button under MDI mode)

0: (Invalid)

1: (Valid)

DIL (Interlock)

0: (Invalid)

1: (Valid. Hardware requested)

COOL (Cut vent fluid to start with the spindle rotation)

0: (Invalid)

1: (Valid)

	#7	#6	#5	#4	#3	#2	#1	#0
K001	ABS			LEVL	COLR	LUBE	ATLM	

ATLM (Auto tool length measurement)

0: (Cancel)

1: (Valid. Hardware requested)

LUBE (Slide oil alarm in the automatic program execution)

0: (Program execution is completed)

1: (Program execution when the single finished)

COLR (Spindle oil cooler)

0: (Cancel)

1: (Valid. Hardware requested)

LEVL (Connection for Slide oil alarm)

0: (A Connection)

1: (B Connection)

ABS (Manual absolute value)

0: (Uncontrollable)

1: (Controlled by ABS ON/OFF in PN of screen)

	#7	#6	#5	#4	#3	#2	#1	#0
K002			5TH		4TH			

4TH (Select the 4th axis control mode)

0: (Air pressure)

1: (Air pressure switch to hydraulic)

5TH (Select the 5th axis is valid or not)

0: (Cancel)

1: (Valid)

	#7	#6	#5	#4	#3	#2	#1	#0
K003					EXMP			

EXMP (Choose to install an external MPG)

0: (Cancel)

1: (Valid)

	#7	#6	#5	#4	#3	#2	#1	#0
K004	4TH						FLAS	POT

POT (Position of preparative tools)

0: (Pocket is on)

1: (Pocket is off)

FLAS (Alarm lamp)

0: (Flicker)

1: (No flicker)

4TH (Display for the 4th axis open) (Non setting)

0: (Closed)

1: (Opened)

	#7	#6	#5	#4	#3	#2	#1	#0
K005							FSTP	COLF

COLF (Button for Cut vent fluid auto)

0: (M08 CODE FIN directly no waited for COOLANT AUTO Button)

1: (M08 CODE NO waited for COOLANT AUTO)

FSTP (Spindle suspended under the program FEED HOLD or not)

0: (Spindle suspended under the program FEED HOLD)

1: (Spindle not suspended under the program FEED HOLD)

	#7	#6	#5	#4	#3	#2	#1	#0
K006	KEY						TFIN	

TFIN (Finished condition for T code)

0: (Judgment)

1: (Non judgment)

KEY (Selection for program protection)

0: (By key of panel)

1: (By KEY ON/OFF controlled from PN in panel)

#7	#6	#5	#4	#3	#2	#1	#0
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K011	ARM						SERV
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SERV (Mode of tool correction)
 0: (Normal mode)
 1: (Mode of tool correction)

ARM (Use the buttons on the panel to control the arm reversible)
 0: (No)
 1: (Yes)

PMC PRM (TIMER)

NO.	ADDRESS	DATA
001	T000	900000 (Slide oil intermittent starting time) (Unit: ms)
002	T002	300000 (Excretion device starting time) (Unit: ms)
003	T004	300000 (Excretion device stopping time) (Unit: ms)
004	T006	60000 (Pressure has not yet arrived the ALARM show time after the starting
005	T008	0 of the detected LUBE) (Unit: ms)
006	T010	0
007	T012	0
008	T014	0
009	T016	0
010	T018	0

PMC PRM TBL CONTROL

NO.	ADDRESS	PARAMETER	TYPE	NO. OF DATA
001	D0000	00000001	0	10000
002				
003				
004				
005				
006				
007				
008				
009				
010				

PMC PRM (DATA)

NO.	ADDRESS	DATA
000	D000	99 (PLC setting automatically)
001	D001	(No.1 pocket)
002	D002	(No.2 pocket)
003	D003	(No.3 pocket)
004	D004	(No.4 pocket)
005	D005	(No.5 pocket)
006	D006	(No.6 pocket)
007	D007	(No.7 pocket)
008	D008	(No.8 pocket)

009	D009	(No.9 pocket)
010	D010	(No.10 pocket)
011	D011	(No.11 pocket)
012	D012	(No.12 pocket)
013	D013	(No.13 pocket)
014	D014	(No.14 pocket)
015	D015	(No.15 pocket)
016	D016	(No.16 pocket)
017	D017	(No.17 pocket)
018	D018	(No.18 pocket)
019	D019	(No.19 pocket)
020	D020	(No.20 pocket)
046	D046	(No. for Preparative tools)
047	D047	(No. for spindle)

PMC PRM (COUNTER)

NO.	ADDRESS	PRESET	CURRENT
001	C000	20 (Total tools)	1 (Current pocket no.)
002	C004		
003	C008		
004	C012		
005	C016		
006	C020		
007	C024		
008	C028		
009	C032		
010	C036		