

04:21:05

# KEEP RELAY(Operator)

1.Grinding wheel spindle is completed whether to stop (0:YES,1:NO)

0

2.Y-axis motor excitation relieves (0:NO,1:YES)

0

3.Man-machine screen capture to USB function (0:Cancel,1: enabled)

0

4.Rotating magnetic disk grinding function (0:Cancel,1: enabled)

0

5.Y-axis operation jog down feed (0: Auto, 1: Manual / Auto)

0

6.Rotating magnetic disk grinding Y-axis feed (0:Forw,1: Back)

0

8.CE,Safety door automation complete ,wheel motor power off

0

HOME

Y ↑ ↓

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I/O

SET

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04:21:19

# KEEP RELAY (USER)

	0
	1
11.Handwheel of panel enable button(0:touch on,1:keeping)	<input type="radio"/>
12.Z axis reversal point boot is not clear(0:Cancel , 1:Enable)	<input type="radio"/>
13.Z-axis step feed determined by(0:VR , 1:HMI)	<input type="radio"/>
14.Z-axis step feed parameter(0:mm 1:inch)	<input checked="" type="radio"/>
15.surface mode down-feed side choice( 0 : double , 1 : single)	<input type="radio"/>
16.surface mode down-feed side choice when single is choosed( 0 : inside , 1 : outside )	<input type="radio"/>
	<input type="radio"/>
	<input type="radio"/>
18.Wheel motor don't automatically stop(0 : Cancel,1 : Enable)	<input type="radio"/>

< HOME Y↑ MSG I/O SET >

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# KEEP RELAY(Optional)(Operator)

0

0

0

0

1

Handwheel type  
(choose one)

a. Handwheel on panel (Y axis)

b. Y axis handwheel

c. Z axis handwheel

d. Y.Z axes handwheel

0



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04:21:59

# TIMER(Maintenance)

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
	0
	0

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04:22:16

## KEEP RELAY(Maintenace)

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



HOME

Y  $\updownarrow$

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