

### Loading a Program From Disk or Computer

1. Press **Func** and **Prgm** keys on MDI panel simultaneously to switch to Program screen if needed
2. Press **Edit** key on operators panel
3. Press **Read** softkey
4. Perform necessary steps to send file from computer or external disk

### Loading a Program From Memory

1. Press **Func** and **Prgm** keys on MDI panel simultaneously to switch to Program screen if needed
2. Press **Edit** key on operators panel
3. Type letter **O** and program number desired (Example **O1234**)
4. Press **down cursor** key (Opr Alarm button WITHOUT Func)

### Checking Inputs & Outputs in Diagnostics

1. Press **Func** and **Dgnos** keys on MDI panel simultaneously 3 times (until DIAGNOSTICS is displayed in the lower right window)
2. To find a value, type **N** then the diagnostic number (Ex. **N14**)

**Note:** When searching for values over 1000, add 2000 to the value. Example:  
X1002.1 is actually X3002.1

Common diagnostics to check:

- |     |                 |     |  |
|-----|-----------------|-----|--|
| 6.2 | Stripper Sensor | 6.4 | Die Sensor   |
| 6.3 | Punch Sensor    | 2.4 | Die Successfully Removed (photo switch over bolster plate) |

14.5 Arm 1 Extend

14.6 Arm 2 Extend

17.5 Arm 1 Retract

14.7 Arm 2 Retract

Refer to machine electrical prints for a complete list of diagnostics

### **Changing tools in MDI**

1. Press **Func** and **Prgm** keys on MDI panel simultaneously to switch to Program screen if needed
2. Press **MDI** key on operators panel
3. Press **Next** softkey (MDI screen must be in Next, not Current)
4. Type in **T#** (inserting the desired tool) to fetch the tool **IF** the tool is not already in the standby arm Example **T203**
5. Press **Input** on operators panel
6. Press **Cycle Start**
7. Type in **Y-63.5** on MDI panel
8. Press **Input** on operators panel
9. Press **Cycle Start**
10. Type in **T#** from step 4 on MDI panel
11. Press **Input** on operators panel
12. Type in **M06** on MDI panel
13. Press **Input** on operators panel
14. Press **Cycle Start**

End of Procedure