

Operation	Mode	Function (Screen)	Memory Protect	Procedure [Text] = Hard Key, (Text) = Soft Key, {Text} = Oper Panel Pushbutton
Basic Operation				
Power Up	-	-	+	Power On, clear E-stops, {OPER ACK}, {HYD ON}, consult messages
Move Axis	Jog	-	+	{JOG}, {DIRECTIONAL KEY} Example {X-}, {Y+}
Move Ram	Jog	-	+	{RAM UP} or {RAM DOWN} or {MANUAL PUNCH}
Machine Status	-	Message	+	Displays Clamp Locations and Active Tool
Check and Clear Messages	-	Message	+	Remedy problem displayed on screen, (Oper Ack)
Check and Clear Alarms	Mem	Message	+	(Alarm), Remedy problem displayed on , (Reset)
Operator Functions				
Load Programs from Disk	Edit	Prog	-	(→), (FLOPPY), [PAGE UP], (OPRT), (READ), Input File #, (F SET), (EXEC)
Load Programs from Computer	Edit	Prog	-	(OPRT), (→), (READ),(EXEC), Upload Program from computer using customer supplied software
Load Programs From Memory	Edit Mem	Prog	+	Input O _ _ _ _ , (O SRH). Examples O9100, O4283, O2375. Note: Use letter O, not number 0.
View Programs In Memory	Edit	Prog	+	(LIB)
Send Programs to Disk	Edit	Prog	-	O _ _ _ _ , (→), (PUNCH), (EXEC)
Send Programs to Computer	Edit	Prog	-	Setup customer supplied software on computer to Receive Files, O _ _ _ _ , (→), (PUNCH), (EXEC)
Send All Programs	Edit	Prog	-	Use O-9999 in place of O _ _ _ _
Delete Program From Memory	Edit	Prog	-	O _ _ _ _ , [Delete] Note: Results are immediate and irreversible.
Delete All Programs	Edit	Prog	-	O-9999, [Delete] Note: Results are immediate and irreversible.
Create New Program	Edit	Prog	-	O _ _ _ _ , [Insert]
Change a Word	Edit	Prog	-	Place cursor on word to be changed, input new word, [ALTER]
Add (Insert) Word	Edit	Prog	-	Place cursor on Word to the left of Word to be added, input new Word, [Insert]. Note: Insert is always to the right of cursor.
Delete Word	Edit	Prog	-	Place cursor on Word to be deleted, [Delete]
Delete Block	Edit	Prog	-	Place cursor at beginning of block, [EOB], [Delete]
Delete Many Blocks	Edit	Prog	-	Place cursor at beginning of first block to delete, input N _ _ _ _ , for last block to delete, [Delete]
Search for Block Number	Edit Mem	Prog	+	Input N _ _ _ _ ,(Srh ↑) or (Srh ↓) Input N _ _ _ _ ,(N Srh)
Search for Word	Edit	Prog	+	Input word,(Srh ↑) or (Srh ↓)
Diameter (Kerf) Offset	MDI	Offset Setting	-	(Setting) Note: Value set by D code in G55 block.
Torch (Fixture) Offset	MDI	Offset Setting	-	Move cursor to G55 (02) settings, modify as required
Change Macro Variable Setting	MDI	Offset Setting	-	(→), (Macro), input variable # _ _ _ , (No. Srh)

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Maintenance Functions																																		
Message History	_	Message	_	(→), (Histry), [Page ↑] or [Page ↓]																														
Alarm History	_	Message	_	(Histry), [Page ↑] or [Page ↓]																														
Parameter Write Enable/Disable	MDI	Offset Setting	_	(Setting) Note: This will generate a 000 Parameter Write Enable alarm																														
Set & Search Parameters	MDI	System	_	(Param), input address _____, (No. Srh) Use [←] and [→] to select bits as necessary																														
Monitor&Search Diagnostics	_	System	_	(Dgnos), [Page ↑] or [Page ↓] or input diagnostic _____, (No. Srh)																														
PMC Signal Status	_	System	_	(PMC), (PMCDGN),(Status), input address _____, (No. Srh) X=External Input, Y=Ext. Output, F=Internal Input, G=Int. Output																														
PMC Signal Trace	_	System	_	(PMC), (PMCDGN), (Trace) Input address _____, input (Mask Hex) data _____, (T.Disp), (Exec) Note: 0-9=0-9, 10-15=A-F. FF=Trace all bits. Use below chart: <table style="margin-left: 40px; border-collapse: collapse;"> <tr> <td style="padding-right: 10px;">Bit</td> <td style="padding-right: 10px;">7</td> <td style="padding-right: 10px;">6</td> <td style="padding-right: 10px;">5</td> <td style="padding-right: 10px;">4</td> <td style="padding-right: 10px;">3</td> <td style="padding-right: 10px;">2</td> <td style="padding-right: 10px;">1</td> <td style="padding-right: 10px;">0</td> </tr> <tr> <td>Equals</td> <td>8</td> <td>4</td> <td>2</td> <td>1</td> <td>8</td> <td>4</td> <td>2</td> <td>1</td> </tr> </table> <p>Examples:Bits 7,6=12=C0, Bits 6,4,2,0=5&5=55,Bits7,3,2,1=8&14=8E</p> <table style="margin-left: 40px; border-collapse: collapse;"> <tr> <td style="padding-right: 20px;">X < 100</td> <td style="padding-right: 20px;">Input Module</td> <td style="padding-right: 20px;">Y < 100</td> <td>Output Modules</td> </tr> <tr> <td>X 100 _ 110</td> <td>Push Buttons</td> <td>Y 100 – 110</td> <td>Push Button Lights</td> </tr> <tr> <td>X > 1000</td> <td>I/O Card Inputs</td> <td>Y > 1000</td> <td>I/O Card Outputs</td> </tr> </table>	Bit	7	6	5	4	3	2	1	0	Equals	8	4	2	1	8	4	2	1	X < 100	Input Module	Y < 100	Output Modules	X 100 _ 110	Push Buttons	Y 100 – 110	Push Button Lights	X > 1000	I/O Card Inputs	Y > 1000	I/O Card Outputs
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PMC I/O Link	_	System	_	(PMC),(PMCDGN),(I/OCHK),(I/OLINK)																														
Output Offset Data	Edit	Offset	_	(Offset), (Oprt), (→), (Punch), (Exec)																														
Output Parameters	Edit	System	_	(Param), (Oprt), (→), (Punch), (Exec)																														
Output Pitch Compensation	Edit	System	_	(→), (Pitch), (Oprt), (→), (Punch), (Exec)																														
View Servo Conditions	_	System	_	(→),(Sv.Prm), [Page ↑] or [Page ↓]																														
Servo Drive Load Meter	_	Pos	_	(→), (Moni)																														