

CNC SYSTEMS

OSP500L-G
OSP5000L-G

LB Series CNC Lathes

MAINTENANCE MANUAL (3rd Edition)



Publication No. 2805-1
(March 1987)

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Note: To avoid any confusion over the use of the letter "O (oh)" and figure "0 (zero)" in this manual, the numerical value "0 (zero)" is expressed as "Ø" if there is any possibility of misunderstanding.

SECTION 1 SPECIAL FEATURES OF OSP5000/OSP5000 SERIES

Based on the OSP series that has an outstanding production record as a CNC all over the world, the OSP5000/OSP5000 series is a high performance computerized numerical control system that functions as an Intelligent Manufacturing Cell (IMC) forming an operator unattended production system.

(1) A multiprocessor CNC system

The OSP5000L-G/OSP5000L-G is a multiprocessor CNC system using plural high-performance microprocessors, and features architectures capable of coping of high level NC functions.

(2) Versatility

Through distributed processing by the multiprocessor, the OSP5000L-G/OSP5000L-G provides versatile functions not available on existing NCs, such as alarm monitor data processing, link with high level computers, advanced online automatic programming function, and large capacity part program storage. This CNC is complete also with functions such as diagnostics and operation guides, display of alarm data and display of production control information, by means of the CRT.

(3) Tremendously Expandable, Never Obsolete

The computer software is stored in the bubble memory. Therefore, it is easy to change the software, enabling any addition and alteration of functions in the future, and this OSP5000L-G/OSP5000L-G can be used always as a most up-to-date system ready to meet the customer's application needs.

(4) High Reliability

High reliability is ensured by various kinds of functions such as automatic memory error correction, perfect noise isolation by a photocoupler, high integration of hybrid ICs and LSIs, etc., reduced consumption power and thorough monitoring of CPU power supply, and by a simple structure mounted in the totally enclosed cabinet.

(5) Uniquely Designed for Easy Operation

Since a CRT is provided as standard on an operation panel, it is exceedingly easy to operate.

SECTION 2 SUMMARY OF OPERATION

The OSP500L-G/OSP5000L-G employs a closed loop system with absolute position feedback. The following is a brief summary of its operation:

The value (command value) which is read into the CNC in the form of taped commands generates path functions (operation value, RCON) within the CNC to produce a commanded tool path at the commanded feedrate.

Meanwhile, the OSP position encoder detects actual position signals (RAPA) of each axis. This RCON and RAPA are continuously compared, the difference (DIFF) between RCON and RAPA is added to the feedrate command and the result is input to the drive unit as motor drive current command (digital value). The drive unit controls the brushless servo motor so that value DIFF will be zeroed.

For details, refer to Section 4-3, "Operation and Structure of the NC".

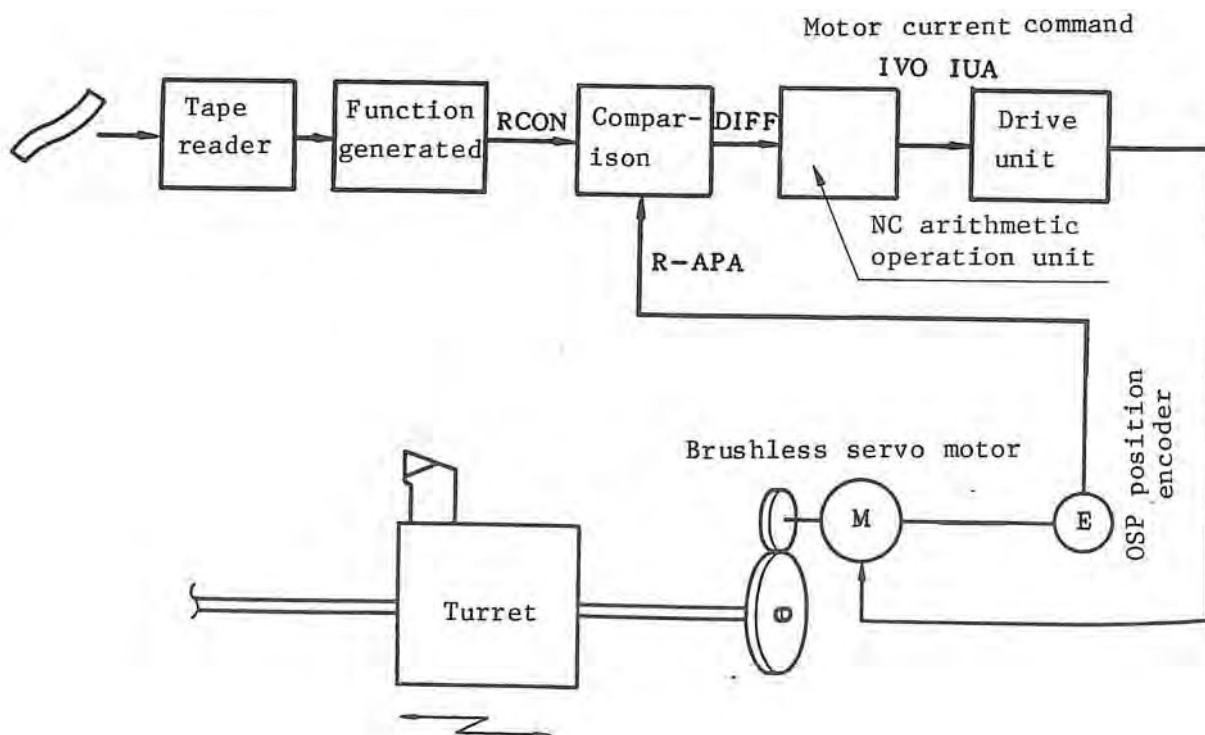


Fig. 2-1 Operation of OSP500L-G/OSP5000L-G

SECTION 3 STRUCTURE OF OSP500L-G/OSP5000L-G

This section outlines the overall structure of the OSP500L-G/OSP5000L-G. For further information, consult the following sections of this manual.

Section 4-3: Operation and Structure of the NC
Section 5 : Trouble and Troubleshooting

3-1. CPU UNIT

This is the heart of the CNC system and consists of the following printed circuit board modules and units:

See Fig. 5-13.

*Printed Circuit Board

MAIN BOARD-II (Note 1)

MAIN CARD 2-II
BUBBLE CARD

CRP BOARD-II (Note 2)

TIMING CONTROL BOARD (Note 3) ... Axis control processor
SERVO PROCESSOR BOARD-II

EC BOARD EC input/output

The parts listed above are for standard system specifications. For optional specifications, printed circuit boards for selected functions will be added.

Standard specification of OSP500L-G:

(Note 1) MAIN BOARD-IIA

(Note 2) CRP 9

(Note 3) TIMING CONTROL BOARD II

Graphic Specification of OSP500L-G:

CRP BOARD-II is used instead of CRP 9.

*Power Supply Unit

This supplies all the power required for CPU operations.

3-2. SERVO DRIVE UNIT

The servo drive unit receives motor current command (digital value) outputted from the CPU to control brushless servo motors which drive X- and Z-axis. This accurately controls movements of the turret in accordance with the programmed commands.

The servo drive unit consists of the following units:

a) DC power supply

Supplies DC power to the brushless motors.

b) Servo amplifier unit

Controls brushless servo motors in response to the command input from the CPU.

3-3. RELAY AND MAGNET SWITCH CIRCUITS

These circuits are used to control machine-mounted solenoids, electric motors, etc., and also conveys signals from machine-mounted pushbutton switches and limit switches to the CPU.

The following panels are provided:

*MS Panel Panel with magnet switches

*Relay Panel ... Panel with control relays

3-4. VAC SPINDLE DRIVE MOTOR CONTROL

LB series CNC lathes use a VAC spindle drive motor.

The control unit receives speed command signals given from the CPU, in the form of analog voltage, and controls the motor speed to the commanded speed.

For details of VAC spindle drive unit maintenance, refer to the separately prepared maintenance manual for VAC Drive Unit (Publication No. 2845-E).

3-5. CONTROL ENCLOSURE

Arranged in a single enclosure are the CPU, drive units, relay and magnet switch circuits, spindle motor drive unit and others.

The totally enclosed construction provides reliable protection against the entry of oil mist, chips, dust and dirt, ensuring stable performance of semiconductors, relays and magnetic switches.

Mounted on the common machine base, this space-saving CNC package forms a compact machine-control combination.

3-6. OPERATION PANEL

All the controls necessary for operating the machine such as operating switches, manual switches and the pulse handle are incorporated into and mounted to this accessible pendant-type operation panel. A large-sized CRT is provided as standard, assuring ease of operation.

3-7. ABSOLUTE POSITION FEEDBACK ENCODERS

To each servomotor for the X- and Z-axis, the absolute position feedback encoder that produces accurate information concerning the instantaneous position of each axis is provided. The output signals from these encoders are fed into the CNC system for accurate positioning of each axis.

Attached to the main spindle is a main spindle pulse generator to detect the spindle speed.

3-8. COOLING UNIT

The cooling unit provided above or at the side of the control box keeps the temperature inside the control enclosure virtually at room temperature level. This provides the CNC system with higher reliability.

SECTION 4 MAINTENANCE AND INSPECTION

Daily checks greatly help to keep your CNC operating properly at all times. When any trouble occurs, integrated testing circuits within the CNC system will help you diagnose most malfunctions and pinpoint their location quickly, thus enabling you to reset to normal operation with little inconvenience.

Consult also the following section:

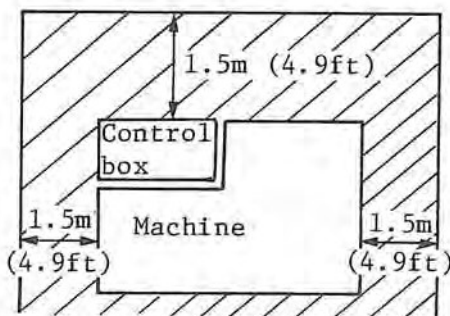
Section 5 Trouble and Troubleshooting

4-1. INSPECTION DURING INSTALLATION

4-1-1. Installation Site

During initial installation, careful consideration should be given to easy access for inspection and maintenance purposes as well as for operation.

Arrange the machine and the machine control unit as shown in the left figure.



Since the machine control unit doors must be opened and some space must be given for maintenance and inspection, install the machine and the machine control unit so that they are not close to a wall.

Fig. 4-1 Layout

4-1-2. Environmental Requirements

Pay attention to the following items:

- (1) Do not install the CNC system in a place exposed to direct sunlight.
- (2) The CNC system should be kept away from chips, coolant, oil, etc.
- (3) The site should be free of excessive vibration.
- (4) Ambient temperature should be between 0°C and 40°C.
- (5) The site should be free of large electrical noise sources such as welding machines. (Power should be preferably drawn from the plant power source.)
- (6) Avoid dirty and dusty areas.

4-1-3. Power Supply Voltage Inspection

The allowable variance in the input voltage for the CNC system is +10% of the available input voltage. An excessive voltage drop because of insufficient power capacity in the plant will cause NC malfunctions. It will also be subject to unavoidable influence from other equipment. In such cases, proper measures should sometimes be taken against those sources.

4-2. PERIODICAL INSPECTION

The CNC system incorporates highly advanced electronic circuits which are susceptible to moisture, oil, dirt, dust, and chips present in machine shops. Elevated temperatures within the enclosure may result from clogging of filters in the cooling unit.

Also, it is necessary to inspect motor brushes and the like which are subject to wear.

(1) Weekly Inspection

Tape Reader Light Receiving Surface:

Keep the light receiving glass surface clean at all times.

Clean carefully with gauze or soft cloth so as not to scratch it.

Perforated Tape Inspection:

Dirty, torn or worn out paper tape from excessive use may lead to NC malfunctions and troubles.

Tape Reader Projector Lens Cleaning:

Remove the front cover of the tape reader, and carefully clean the projector and lens with soft cloth so as not to scratch them.

(2) Every Three Months Inspection

Cooling Unit Cleaning:

Make sure that the cooling unit on the control box operates to blow air hard. If the filter mesh screens are clogged, clean.

4-3. OPERATION AND STRUCTURE OF THE NC

To gain an overall understanding of CNC operations, study the following carefully:

4-3-1. Example of Operation

When G01 X100.000 F0.1 S300 T0101 M03 CR is given as command data, the unit operates as follows:

- (1) Press the CYCLE START button, and the CPU starts running according to the command data stored in memory.
- (2) S, T, and M operation starts.

The S, T, M commands read are transferred to the EC relay circuit via the EC board.

The spindle rotation command is converted into the motor speed command, which is then converted into analog voltage on the TIMING CONTROL board. The analog voltage is outputted to the spindle drive motor control unit.

Thus, the spindle starts rotating in the forward direction at 300 rpm. The turret is indexed to select the #1 tool.

After these S, T and M commands have been executed and the commanded states are established, the execution completion signals are given to the CPU.

- (3) Operation of Interpolator

After the completion of execution of S, T and M commands, cutting can be started. Therefore, axis movement commands now may be started. Pulse signals from the pulse generator coupled with the spindle is read through the TIMING CONTROL board and functions are generated at the feedrate of F0.1 mm/rev (0.004 ipr) from a present coordinate point to the commanded coordinate point (X100.000) along a G01 straight-line path.

- (4) Movement of Axes

R-CON the output from the interpolator is compared with the actual position data R-APA given from the position encoder. The difference DIFF between R-CON and R-APA is converted into the motor current value (digital value) and the result is outputted from the servo processor to the servo drive.

The servo drive unit controls the brushless servo motor so that the DIFF input will be zeroed at all times, and as a result, R-CON and R-APA are matched, and positioning to X100.000 is completed.

4-3-2. Description on Each Major NC Unit

- (1) The Power Supply Unit receives AC 200V supply and supplies all the power required for operation of the CPU. It also controls the sequence for power supply ON/OFF. Press the CONTROL ON button on the operation panel, and the Power Supply Unit supplies first voltage to the CPU and drives the CPU. Press the CONTROL OFF button, and this unit cuts off voltage supply to the CPU after stopping CPU operation. Moreover, this unit detects abnormalities such as abnormal drop and rise of output voltage, abnormal drop of input voltage, and elevated temperature within the unit, etc., causes the CPU to stop the operation, cuts off voltage supply and has a monitor function to display the cause of an abnormality on the monitor display. The monitor display is effective even if supply voltage to the CPU is cut off by pressing the CONTROL OFF button on the operation panel, unless power supply to the CNC system is cut off by turning off the main switch (no-fuse circuit breaker).
- (2) The CPU Unit is the central controller of the OSP500L-G/OSP500L-G and of the multi-processor structure consisting of plural processors.

The standard unit consists of five BOARDS and CARDS annexed to the BOARDS as follows:

a) MAIN BOARD-II: Main Processor Board

This consists of the main processor which controls the IC memories, bubble memory, slave processors and interface circuits, and IC memories which store the control software for controlling the processor. The control software stored in IC memories is transferred to the bubble memory when power is turned on.

BUBBLE CARD: Bubble Memory

This is a memory to store taped commands, and control software when power is switched OFF. The operation of writing the control software into the bubble memory is called "loading". Such control software is supplied in floppy disks with all NC systems.

When loading is carried out according to the "Loading" procedure in Section 5-6-3, if required, the contents of the bubble memory can be rewritten.

MAIN CARD 2-II: PTR

The circuit interfacing the tape reader.

b) CRP BOARD-II: Panel

The circuit interfacing the operation panel.

c) TIMING CONTROL BOARD

The circuit for generating timing signals required for the servo processor, the interface circuit for the spindle drive.

d) SERVO PROCESSOR BOARD-II

The circuits interfacing the position encoder, the sensor input, the servo drive unit and position encoder, and the circuit interfacing the measuring devices.

e) EC BOARD: EC input/output

The circuits interfacing the power relays, magnet switches, solenoid valves and limit switches, etc.

4-4. SELF-DIAGNOSTICS

The OSP500L-G/OSP5000L-G is a sophisticated CNC system that is designed to make the most of its built-in computer capabilities. The self-diagnostic function is one of the advantages a computerized numerical control system can provide. This function is classified into the following two items:

- Check function by alarm display and error display
- Check function by check data display

Check Function by Alarm Display and Error Display:

This function constantly monitors any defect including programming, operational errors and NC malfunctions.

When any defect such as the programming error and NC malfunction requiring stop of the machine operation occurs, the ALARM lamp goes on, the machine is stopped, and the contents of the alarm will be displayed on the CRT. When the defect is an operational error during editing operation, etc. not requiring the machine to be stopped, the ALARM lamp does not go on, but the contents of the error only will be displayed on the CRT. From these displays, the contents of the defect can be judged.

Check Function by Check Data Display:

With check data displayed on the CRT, it is possible to check internal conditions of the CNC, input/output signals of the NC and so on. This is a useful function to adjust and check the CNC.

4-4-1. Alarm Display and Error Display

The CNC constantly monitors the operating conditions of the machine, the program data and the operation of the machine operator. When any problem takes place, it gives the operator a warning by displaying an alarm message or error message.

Alarm Display ... The machine is stopped. The ALARM lamp under NC STATUS goes on. The corresponding alarm message is displayed on the 2nd line of the CRT.

Error Display ... Mainly warning against any of the items input by the operator, and does not cause the machine to be stopped.

The ALARM lamp does not go on and the error message is displayed on the 18th to 22nd line on the CRT.

CPU Alarm This alarm indicates CPU malfunction. When this type of alarm occurs, machine operation cannot be resumed until power supply is turned on again. Naturally, the machine instantly stops.

When the CPU does not function normally, the message is displayed below the central portion on the CRT.

For alarm and error messages, refer to Alarm & Error List for OSP500L-G/OSP5000L-G (Publication No. 2578-E).

4-4-2. Check Data Display

The CNC constantly monitors internal conditions of the CNC and input/output signals of the NC, and the operator can see these data through check data displayed on the CRT.

Check data displayed on the CRT and its contents are shown in the following pages.

(1) Status Display of EC Input Signal (No. 1)

AUTO OPERATION R.M.N. N 0

CHECK DATA UNIT Imm

EC INPUT 01:

no.	data	bit7	bit6	bit5	bit4	bit3	bit2	bit1	bit0
1	11101111	TCLA	CPA/	OPA/	OFA	TLAC	TLAB	TLAA	TLA9
2	00000011	TLA8	TLA7	TLA6	TLA5	TLA4	TLA3	TLA2	TLA1
3	10000010	TCLB	CHP2	CHP1	SPL5	SPL4	SPL3	SPL2	SPL1
4	00000011	TLB8	TLB7	TLB6	TLB5	TLB4	TLB3	TLB2	TLB1
5	11000110	SSP/	TSP/	STR	RST	DR0P	SOA/	BOF	BOL
6	10100000	CCC2	CCC1	TSRT	TSLM	TSOA	TSRF	TSR2	TSR1
7	11011111	IN24	EOF/	SCSF	ALM/	APA/	SEA/	LOA/	LA/
8	11111111	SBA/	SLA/	SA/	TMA/	OHA/	OLA/	CBA/	ECON
9	11101110	OIL/	IILC	TLXF	TLZF	SP2	SPC	CHOP	CHCL
10	00000000								
11	11101000	IDC/	TSP/	DR0P	DRCL	CDA/	CDM	MANS	ESIN
12	00000000			MNIN	EXOR	CTIM	TRST	LOTC	TRTC
									ESUE

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA	TOOL LAYOUT	CHECK DATA	[EXTEND]

F 1
F 2
F 3
F 4
F 5
F 6
F 7
F 8

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
1		Chuck Pres- sure Low	Hydraulic Source Pressure Low/	Alarm - Oil Filter Clogged				
2								
3		Chuck Pedal #2	Chuck Pedal #1					
4								
5	External Cycle Stop/	External Slide Hold/	External Cycle Start	External Reset	Door Open Confirma- tion Switch	Spindle Lubrication Pressure Low/	Slideway Lube Oil Flow	Slideway Lube Oil Level low
6	Chip Cover Close Con- firmation Switch 2	Chip Cover Close Con- firmation Switch 1	Tailstock Quill Re- traction Confirma- tion Switch	Tailstock Quill In- position Confirma- tion Switch	Tailstock Quill Over- advance Confirma- tion Switch	Tailstock Quill Re- traction Foot Switch	Tailstock Quill Advance Foot Switch 2	Tailstock Quill Advance Foot Switch 1
7	External Input 24	Emergency Limit Switch Release	Spindle Orientation Completion	External Alarm/	SMW Chuck Pressure Low/	Alarm - Travel End/	Alarm - LDU Overload/	Alarm - Static Pressure Unit Cooler
8	Alarm - Spindle Brush Wear/	Alarm - Spindle Overload/	Alarm - SDU/	Alarm - CPU Tem- perature/	Alarm - Transformer Overheat/	Alarm - EC Over- load/	Alarm - EC Circuit Breaker/	Emergency Stop
9	External Interlock	Internal Interlock Released	Turret X-axis Free	Turret Z-axis Free	Spindle Zero Speed	Spindle at Constant Speed	Chuck Open Confirma- tion Switch	Chuck Close Confirma- tion Switch
10								
11	Index Chuck Completion Limit/	Sensor Protect Limit/	Door Open	Door Close	Coupling Device Alarm/	Interlock Mode	Answer for Aux. M Code	External Spindle Jog
12		Operation Monitor External Input	External Spindle Orientation	Calender Timer Input	CEJ Transfer Start	Lot Completed	Tool Retraction Cycle Interrupt Input	External Start Disabled

(2) Status Display of EC Input Signal (No. 2)

A U T O O P E R A T I O N A R M I N N 0

CHECK DATA UNIT 1mm

EC INPUT 02:

no.	data	bit7	bit6	bit5	bit4	bit3	bit2	bit1	bit0	
13	01000001	TSUC	TSCL	INOC	M44	M43	M42	M41	M40	
14	00000000	IN18	IN17	IN16	IN15	IN14	IN13	IN12	IN11	
15	00000000	CMPS		CDOP	SHC/SHAD		SHMP	SHSP		
16	00000000	MST1		MDC1	SL14		SL13	SL12	SL11	
17	00000000				OK1	+OK1	-OK1	+NG1	-NG1	
18	00000000	MST2		MD12	SL24		SL23	SL22	SL21	
19	00000000				OK2	+OK2	-OK2	+NG2	-NG2	
20	00000000									
21	00021000	WFAL			RTID	CIL/	CFJ	CHJ	CHJ	
22	00100100	EPSS			PAL/	RTI	RTC	ROL/	M242	M241
23	00000000	PN28	PN24	PN22	PN21	PN18	PN14	PN12	PN11	
24	00020000	CLPP		OPNP	POS5	POS4	POS3	POS2	POS1	CLSP

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA	TOOL LAYOUT	CHECK DATA	[EXTEND]
----------------	--------------	--------------	------------	-------------	------------	----------

F 1
F 2
F 3
F 4
F 5
F 6
F 7
F 8

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
13	Tailstock Joint ON	Tailstock Joint OFF	Spindle Jog Reverse	M44	M43	M42	M41	M40
14	External Input 18	External Input 17	External Input 16	External Input 15	External Input 14	External Input 13	External Input 12	External Input 11
15	UVE Air Chuck Open	UVE Air Chuck Close	Chucking Error Pressure Switch	Coupling Device Retraction Position	Optical Sensor Workpiece Detect	Sensor Head Advance Position	Sensor Head Intermediate Position	Sensor Head Retraction Position
16	Gauging Start	Gauging Data Clear			Switching Signal (Post-process Gauging 1)			
17				OK1	+OK1	-OK1	+NG1	-NG1
18	Gauging Start	Gauging Data Clear			Switching Signal (Post-process Gauging 2)			
19				OK2	+OK2	-OK2	+NG2	-NG2
20								
21	Work Abnormal Runout Input			Revolving Tool Spindle Orientation	Interlock/	C-axis Connect Confirmation	C-axis Connect Start Confirmation	Disengaged Confirmation
22	External Program Selection Start	External Program Selection Parity	Alarm/	Zero Speed	Constant Speed	Overload/	Gear High	Gear Low
23	2nd Digit		External Program Selection			1st Digit		
	PN28	PN24	PN22	PN21	PN18	PN14	PN12	PN11
24	Clamp Confirmation Pressure Switch	Open End	POS 5	POS 4	POS 3	POS 2	POS 1	Close End

(3) Status Display of Extended EC Input Signal (No. 1)

A U T C O P E R A T I O N A . M I N H 0

CHECK DATA UNIT 1mm

E C I N P U T E X T E N D 0 1 :

no.	data	bit7	bit6	bit5	bit4	bit3	bit2	bit1	bit0
1	00000000								
2	00000000								
3	00000000								
4	00000000								
5	00000000								
6	00000000								
7	00000000								
8	00000000								
9	00000000								
10	00000000	PN48	PN44	PN42	PN41	PN38	PN34	PN32	PN31
11	00000000								
12	00000000	IN48	IN47	IN46	IN45	IN44	IN43	IN42	IN41

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA		TOOL LAYOUT	CHECK DATA	[EXTEND]
----------------	--------------	--------------	------------	--	-------------	------------	----------

F 1
F 2
F 3
F 4
F 5
F 6
F 7
F 8

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
1								
2								
3								
4								
5								
6								
7								
8								
9								
10	External Program Selection							
	← 4th Digit			← 3rd Digit				
	PN48	PN44	PN42	PN41	PN38	PN34	PN32	PN31
11								
12	External Input							
	48	47	46	45	44	43	42	41

(4) Status Display of Extended EC Input Signal (No. 2)

```

AUTO OPERATION A.M.M.           H           0
CHECK DATA                       UNIT 1mm
      EC INPUT EXTEND 02:
no.  data      bit7 bit6 bit5 bit4 bit3 bit2 bit1 bit0
13  00000000
14  00000000
15  00000000
16  00000000
17  00000000
18  00000000
19  00000000
20  00000000
21  00000000
22  00000000
23  00000000
24  00000000
    
```

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA		TOOL LAYOUT	CHECK DATA	[EXTEND]
----------------	--------------	--------------	------------	--	-------------	------------	----------

F 1
F 2
F 3
F 4
F 5
F 6
F 7
F 8

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
13								
14								
15								
16								
17								
18								
19								
20								
21								
22								
23								
24								

(5) Status Display of EC Output Signal (No. 1)

AUTO OPERATION A.MIN								N	2
CHECK DATA								UNIT 1mm	
EC OUTPUT 01:									
no.	data	bit7	bit6	bit5	bit4	bit3	bit2	bit1	bit0
1	00000000	TSRS	TSRT	TSAD	TSIN	SMW0	SMWC	CHOP	CHCL
2	00001000	WKL	OT23	INM	SEND	SPSP	SPW	PEND	PSP
3	01000001	PWS	ALM/	SPS7	SPS6	SPS5	SPS4	SPS2	SPS1
4	00000000	SPWB	COOL	TCCB	TCWB	UCLB	TCCA	TCWA	UCLA
5	00001000	BOMT	WKC	SSPP	SCSP	DROP	DRCL	TSHP	TSLP
6	00000000								
7	00001000	SARB	ARB	TSIC	NCAL	AUTO	MAN	NCST	ZLMT
8	00000000					XLMT	NALC	CMAO	CHIC
9	00000000	CHHP	CHLP	TSUC	TSCL	USM4	USM3	USM2	USM1
10	00000000	OT18	OT17	OT16	OT15	OT14	OT13	OT12	OT11
11	01000000	CHCL	CHLO	ATLF	BTLF	USM8	USM7	USM6	USM5
12	00000000								

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	ELCK DATA	TOOL LAYOUT	CHECK DATA	[EXTEND]

F 1 F 2 F 3 F 4 F 5 F 6 F 7 F 8

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
1	Tailstock Quill Advance Reset	Tailstock Quill Retract Reset	Tailstock Quill Advance	Tailstock Quill Advance - inching	SMW Chuck Open	SMW Chuck Close	Chuck Open	Chuck Close
2	Work Lamp	External Output 23	Hour Meter	Schedule End	Spindle in Stop	Spindle Rotation Command	Program End	Program Stop
3	Power Save Command	NC Alarm/	Spindle Gear Selection Solenoid					
4	Spindle CCW Command	Coolant	Turret B Reverse Rotation	Turret B Forward Rotation	Turret B Unclamp	Turret A Reverse Command	Turret A Forward Rotation	Turret A Unclamp
5	Slideway Lubrication Motor	Work Count	Spindle Orientation Pin IN	Spindle Orientation in Execution	Door Open	Door Close	Tailstock Quill Thrust High	Tailstock Quill Thrust Low
6								
7	Spare Air Blower	Air Blower	Tailstock Interlock Neglect	Alarm Lamp	Automatic Mode	Manual Mode	In Operation	Z-axis at Emergency Limit
8			X-axis at Emergency Limit	Alarm Output	Chuck Error Air ON	Chuck Interlock Neglect	Sensor Head Retraction	Sensor Head Advance
9	Chuck High Pressure	Chuck Low Pressure	Tailstock Joint ON (Swing Advance)	Tailstock Joint OFF (Swing Retraction)	M104	M103	M102	M101
10	External Output 18	External Output 17	External Output 16	External Output 15	External Output 14	External Output 13	External Output 12	External Output 11
11	Chuck Clamp	Chuck Unclamp	Life of Tool on Turret A Expired	Life of Tool on Turret B Expired	M108	M107	M106	M105
12								

(6) Status Display of EC Output Signal (No. 2)

AUTO OPERATION ADMIN H 0

CHECK DATA UNIT 1mm

EC OUTPUT 02:

no.	data	bit7	bit6	bit5	bit4	bit3	bit2	bit1	bit0
13	00200000	WFCM	ADCL		RTID	CNT2	CMR2	CNT1	CMR1
14	00200000	PN28	PN24	PN22	PN21	PN18	PN14	PN12	PN11
15	00020000	EPNR		CSTP	CCF	CCP	CJS	CHB	CLJ
15	00030000	LCOC	LCOS		SABB	RPC	FSP	RHS	RLS

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA		TOOL LAYOUT	CHECK DATA	CENTENDJ
-------------------	-----------------	-----------------	---------------	--	----------------	---------------	----------

F 1
F 2
F 3
F 4
F 5
F 6
F 7
F 8

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
13	Workpiece Deflection Detection	Additional Coolant		Revolving Tool Spindle Orientation	CEJ New Tool 2	CEJ Data Transfer Request 2	CEJ New Tool 1	CEJ Data Transfer Request 1
14	External Program Selection							
	2nd Digit					1st Digit		
	PN28	PN24	PN22	PN21	PN18	PN14	PN12	PN11
15	External Program Selection, Number Confirmation Request		C-axis Stop	Positioning Complete	Clamp	Connect	High Pressure Brake	Low Pressure Connect
16	Long Stroke Chuck Un-clamp Stop Release	Long Stroke Chuck Un-clamp Stop		Spare Air Blower	Rotation Command	Revolving Tool Spindle		
						Stop	High Speed	Low Speed

(7) Status Display of Extended EC Output Signal (No. 1)

```

AUTO OPERATION A.MIN          N      0
CHECK DATA                    UNIT 1mm
      EC OUTPUT EXTEND 01:
no.  data      bit7 bit6 bit5 bit4 bit3 bit2 bit1 bit0
  1  00000000
  2  00000000
  3  00000000
  4  00000000
  5  00000000
  6  00000000  PN48 PN44 PN42 PN41 PN38 PN34 PN32 PN31
  7  00000000  USM6 USM5 USM4 USM3 USM2 USM1 USM0
  8  00000000
  9  00000000
 10  00000000
 11  00000000
 12  00000000
    
```

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA		TOOL LAYOUT	CHECK DATA	[EXTEND]
----------------	--------------	--------------	------------	--	-------------	------------	----------

F 1
F 2
F 3
F 4
F 5
F 6
F 7
F 8

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
1								
2								
3								
4								
5								
6	External Program Selection							
	← 4th Digit			3rd Digit →				
	PN48	PN44	PN42	PN41	PN38	PN34	PN32	PN31
7	M237	M236	M235	M234	M233	M232	M231	M230
8								
9								
10								
11								
12								

(8) Status Display of Extended EC Output Signal (No. 2)

AUTO OPERATION A.MIN				N	3				
CHECK DATA				UNIT 1mm					
EC OUTPUT EXTEND 02:									
no.	data	bit7	bit6	bit5	bit4	bit3	bit2	bit1	bit0
13	00000000								
14	00000000								
15	00000000								
16	00000000								

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA		TOOL LAYOUT	CHECK DATA	[EXTEND]
-------------------	-----------------	-----------------	---------------	--	----------------	---------------	----------

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
13								
14								
15								
16								
17								
18								
19								
20								
21								
22								
23								
24								

(9) Status Display of Machine Operation Panel Input Signal (No. 1)

A U T C O P E R A T I O N A . M I N N 0

CHECK DATA UNIT 1mm

PANEL INPUT 01:

no.	data	bit7	bit6	bit5	bit4	bit3	bit2	bit1	bit0
1	10000100	CRTC	PNAE	PNAD	TLRT	RET	TSP/	STR	RST
2	00000000	SPSP	SPCC	SPCW	SPIN	MNNX	MNNZ	MNPX	MNPZ
3	00000000	CLTP	CLON	BDE	PH1	PHX	PHZ	PHS0	PH10
4	00100000	IN22	WKL	SSP/				M4*	M40
5	00000010	SGB	OPSP	BTSN	ATSN	ILOF	MION	MLCK	DRYR
6	00001000	DRIL	ARB	DROP	DRCL	TSSW	SPW	CHIN	CHOT
7	00000000	CHMO	TSUC	TSCL	TSPE	SHRT	SHAD	SARB	INCC
8	00000000	ZAOI	ZBOI	XAOI	XBOI	PON/	ROSP	LOTG	SPRR
9	01011000	S03	S04	S02	S01	F08	F04	F02	F01
10	00000000				IN10	IN10	IN10	IN10	IN10
11	00000000	IN6	IN7	IN6	IN5	IN4	IN3	IN2	IN1
12	00000000	OTBR						TRTC	TSSW

PROGRAM SELECT
ACTUAL POSIT
PART PROGRAM
BLOCK DATA
TOOL LAYOUT
CHECK DATA
[EXTEND]

(F 1) (F 2) (F 3) (F 4) (F 5) (F 6) (F 7) (F 8)

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
1	CRT OFF	NC Panel Limited Use	NC Panel Disabled	Tool Index	Sequence Restart	Slide Hold	Cycle Start	NC Reset
2	Spindle Stop	Spindle CCW	Spindle CW	Spindle Jog	Slide Jog	Slide Jog	Slide Jog	Slide Jog
3	Coolant Auto	Coolant Manual	Block Delete	Pulse Handle 1/1	Pulse Handle X-axis	Pulse Handle Z-axis	Pulse Handle 50/1	Pulse Handle 10/1
4	External Input 22	Work Lamp	Cycle Stop/				Spindle Drive Gear ON Neutral	
5	Single Block	Optional Stop	Individual Operation of Turret B	Individual Operation of Turret A	Interlock	Mid-Auto Manual Operation ON	Machine Lock	Dry Run
6	Door Interlock	Air Blower	Door Open	Door Close	Tailstock Quill, Center Work	SMW Chuck	Chuck ID Gripping	Chuck OD Gripping
7	Chucking Error ON	Tailstock Joint ON	Tailstock Joint OFF	Tailstock Joint Position Return	Sensor Head Retraction	Sensor Head Advance	Spare Air Blower	Spindle Jog Reverse Direction
8	ZA-axis Overload	ZB-axis Overload	XA-axis Overload	XB-axis Overload	Gauging Data Printer ON/	Robot Optional Stop	Lot Completion	Schedule Program Reset
9		Spindle Speed Override				Feedrate	Override	
10						External	Input 10	
11	External Input 38	External Input 37	External Input 36	External Input 35 Broken Tool Detection Cycle	External Input 34 Data Read-out Cycle	External Input 33 First Part Gauging Cycle ON	External Input 32 Work Gauging Cycle ON	External Input 31 Master Ring Gauging Cycle ON
12	External Output 31-38 Reset						Tool Retraction Cycle Interrupt Input	External Program Selection Strobe

(10) Status Display of Machine Operation Panel Input Signal (No. 2)

A U T C O P E R A T I O N A . M I M H 0

CHECK DATA UNIT 1mm

PANEL INPUT 02:

no.	data	bit7	bit6	bit5	bit4	bit3	bit2	bit1	bit0
13	00000000	PN28	PN24	PN22	PN21	PN18	PN14	PN12	PN11
14	00000000	MNPC	MHNC	MNCP	MNUC	MCP	PHC	GSSR	
15	00000000	ACTP	ACON	OMAT	OMON	CSNX	CSNZ	CSPX	CSPZ
16	00000000							RMON	CMOB
17	00000000	PN48	PN44	PN42	PN41	PN38	PN34	PN32	PN31
18	00000000								
19	00000000	NGFN	OKFN	MAFN	FWFN	SCST	INTH	CDCH	CMOC
20	00000000								NCPT
21	00000000								
22	00000000								
23	00000000								
24	00000000								

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA		TOOL LAYOUT	CHECK DATA	[EXTEND]
-------------------	-----------------	-----------------	---------------	--	----------------	---------------	----------

F 1
F 2
F 3
F 4
F 5
F 6
F 7
F 8

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0	
13	External Program Selection								
	2nd Digit				1st Digit				
	PN28	PN24	PN22	PN21	PN18	PN14	PN12	PN11	
14	C-axis				MOP OFF	Pulse Handle C-axis			Revolving Tool Spindle Selection
	Manual +C	Manual -C	Manual Clamp	Manual Unclamp					
15	Additional Tape	Coolant ON	Overload Monitor Auto-set	Overload Monitor ON	Cycle Start -X	Touch Setter		Cycle Start +Z	
						Cycle Start -Z	Cycle Start +X		
16							DNC-B Remote Mode ON	DNC-B Communication ON	
17	External Program Selection								
	4th Digit				3rd Digit				
	PN48	PN44	PN42	PN41	PN38	PN34	PN32	PN31	
18									
19	Cycle Completion NG	Cycle Completion OK	Work Setup Complete	First Part Machining Complete	DNC-C		FMS INT.	FMS Auto Start	FMS ON
					Schedule Start				
20							DNC-C Reverse Communication		
21									
22									
23									
24									

(11) Status Display of Machine Operation Panel Input Signal
(No. 3)

```

AUTO OPERATION ADMIN          H      0
CHECK DATA                    UNIT 1mm
                                PANEL INPUT 03:
no.  data  bit7 bit6 bit5 bit4 bit3 bit2 bit1 bit0
25  00000000
26  00000000
27  00000000
28  00000000
29  00000000
30  00000000
31  00000000
32  00000000
33  00000000
34  00000000
35  00000000
36  00000000
37  00000000
    
```

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA		TOOL LAYOUT	CHECK DATA	[EXTEND]
----------------	--------------	--------------	------------	--	-------------	------------	----------

F 1
F 2
F 3
F 4
F 5
F 6
F 7
F 8

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
25								
26								
27								
28								
29								
30								
31								
32								
33								
34								
35								
36								
37								

(12) Status Display of Machine Operation Panel Output Signal
(No. 1)

AUTO OPERATION A.MIN.		N	0
CHECK DATA		UNIT 1mm	
PANEL OUTPUT 01:			
no.	data	bit7	bit6 bit5 bit4 bit3 bit2 bit1 bit0
1	00030000	OT22	OT21 B TSN ATSN M4# M40
2	01000000	CHCL	CHL0 CHAR BOLA BOFA SPPA OPA WKF
3	00100000	ATTL	BTTL TSRT TSFM TSOA CMAL TSUC TSCL
4	00000000	OT8	OT7 OT6 OT5 OT4 OT3 OT2 OT1
5	00000000	TLBC	TLBB TLBA TLB9 TLAC TLAB TLA9 TLA9
6	00000000	TLA8	TLA7 TLA6 TLA5 TLA4 TLA3 TLA2 TLA1
7	00000000	TLB8	TLB7 TLB6 TLB5 TLB4 TLB3 TLB2 TLB1
8	00000000	ZAOL	ZBOL ATOC BTOC SEN3 SEN2 SEN1 SEN0
9	00000000	PN28	PN24 PN22 PN21 PN18 PN14 PN12 PN11
10	00000000	XAOL	XBOL EPRA FNT0 FNCM
11	00000000	WPMA	RMON CMOB CAJC CACP CAJC PHC GSSR
12	00000000		TMT0 MAR0 FWR0 INTM IDMD CDCM CMOB

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA	TOOL LAYOUT	CHECK DATA	EXTEND1
----------------	--------------	--------------	------------	-------------	------------	---------

F1
F2
F3
F4
F5
F6
F7
F8

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
1	Input Touch Setter Sensor Input	Gauging NG Ignore ON	Individual Operation of Turret B	Individual Operation of Turret A			—Spindle Drive Gear— ON Neutral	
2	Chuck Clamp	Chuck Unclamp	Chuck Air Pressure Low	Alarm - Slideway Lube Oil Level	Alarm - Slideway Lube Oil Flow	Alarm - Spindle Lubrication Pressure Low	Alarm - Hydraulic Pressure Low	Operation End Lamp
3	Tool Life A	Tool Life B	Tailstock Quill Retraction	Tailstock Quill In-position	Tailstock Quill Over-advance	Chucking Error Alarm	Tailstock Joint OFF	Tailstock Joint ON
4	External Output 8	External Output 7	External Output 6	-NG	-Gauging Result Output -OK	OK	+OK	+NG
5	Tool Life Turret B 9 - 12				Tool Life Turret A 9- 12			
6	Tool Life Turret A 1 - 8							
7	Tool Life Turret B 1 - 8							
8	ZA-axis Overload	ZB-axis Overload	Turret A Monitoring	Turret B Monitoring	Turret B Tool Gauging Sensor Input	Turret B Touch Sensor Input	Turret A Tool Gauging Sensor Input	Turret A Touch Sensor Input
9	External Program Selection 2nd Digit				External Program Selection 1st Digit			
10	XA-axis Overload	XB-axis Overload				External Program Selection Answer	FMS Cycle Time Over	FMS Data Transfer
11	Work Pushing Error Alarm	DNC-B Remove Mode ON	DNC-B DNC ON	C-axis Unclamp	C-axis Clamp	C-axis Connect	Pulse Handle C-axis	Revolving Tool Spindle Selection
12		Data Transfer	Setup Change Request	First Part Machining	DNC-C FMS INT.	FMS Independent	FMS Automatic	FMS ON

* 1, 11 for flat panel specification

(14) Status Display of Machine Operation Panel Output Signal
(No. 3)

AUTO OPERATION ADMIN N 0

CHECK DATA UNIT 1mm

PANEL OUTPUT 03:

no.	data	bit7	bit6	bit5	bit4	bit3	bit2	bit1	bit0
25	00000000								
26	00000000								
27	00000000								
28	00000000	CTL	P	CLON	BDE	PH1	PH2	PH3	PH10
29	00101010	SSB	OPSP	CRTC	WKL	ILOF	HION	MLCK	DRYR
30	00000000								
31	00000000								
32	00000000								
33	00000000								
34	00000000								
35	00000000								
36	00000000								
37	00000000								

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA		TOOL LAYOUT	CHECK DATA	[EXTEND]
----------------	--------------	--------------	------------	--	-------------	------------	----------

F 1
F 2
F 3
F 4
F 5
F 6
F 7
F 8

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
25								
26								
27								
28	Coolant Auto	Coolant Manual	Block Delete	Pulse Handle 1/1	Pulse Handle X-axis	Pulse Handle Z-axis	Pulse Handle 50/1	Pulse Handle 10/1
29	Single Block	Optional Stop	CRT OFF	Work Lamp	Interlock Release	Manual Int. ON	Machine Lock	Dry Run
30								
31								
32								
33								
34								
35								
36								
37								

(15) Display of Specification Code (No. 1)

AUTO OPERATION A.M.I.N								N	0
CHECK DATA								UNIT Imm	
SPEC CODE 01:									
no.	data	bit7	bit6	bit5	bit4	bit3	bit2	bit1	bit0
1	00000000	IDC	LSCH	2SWC	OLC	ROBT	TATS	SPRH	SPID
2	00000100	OMB1	OMCA	TSC	MSPR	CEJ	XMS	NSMS	TCSN
3	00000000	CNK	SMW	IEC	IECD	DRIB	ECE3	ECE2	ECE1
4	00000001	ACPC	CMTR	ATC	TSS	CCM	MIRR	2S	SC
5	00000000	PBCD	FIBM	CTIM	MOP	SORS	OWKC	TDIO	PRIF
6	00000000	CACB	THDC	CALC	MTCL	B60S	TOF3	TOF2	THSP
7	01000100	OABV	CREP	COCO	AXCM	SHOT	TLFC	RMNI	WKMN
8	01111111	CMVT	IGFC	IGF	CLGR	UTSK	INML	NRC	LAP
9	00000000	CD8	CD7	CD6	CD5	CD4	CD3	CD2	CD1
10	00010000	DRS	UVE	THCR	TLRT	RATC	OMB2	NCLD	TMPS
11	00000000						SRIC	EBCD	ALMC
12	00000000	DNC3	DNC2	DNC1	DNCB	DNCA	BCDO	EBST	EBIT

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA	TOOL LAYOUT	CHECK DATA	[EXTEND]
----------------	--------------	--------------	------------	-------------	------------	----------

F1	F2	F3	F4	F5	F6	F7	F8
----	----	----	----	----	----	----	----

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
1	Index Chuck	Long Stroke Chuck	2-saddle Work Catcher	Overload Detect	Okuma Robot	Program-mable Tail-stock	Orientation (Electric)	Orientation (Pin/Brake)
2	Load Monitor-B1	Load Monitor-A	Touch Setter	Gauging Data Print	CEJ Matic Gauging	Post-process Gauging	Tool Gauging	Touch Sensor Gauging
3	Chucking Error Alarm	Air Chuck	IEC Chuck	IEC Door	Door Interlock B	EC Board (Card) Addition 3	EC Board (Card) Addition 2	EC Board (Card) Addition 1
4	AC Motor Pole Change	Comb-type Turret	ATC	Tailstock Swing	Multi-Machining	Mirror Image	4-axis 2-saddle	Center Work
5	Coupling External Device Program Selection	Floppy Input/Output (IBM)	Calendar Timer	MOP	Edit Interlock	External Work Counter	Tape Data Input/Output	Robot Request (Special)
6	C-axis Connect (high-speed B)	Thread Cutting Phase Matching	C-axis Connect (low-speed)	Cycle Time Calculation	Buffer 60 m	Tool Offset 96 Sets	Tool Offset 64 Sets	G34/G35 Slide Hold
7	Arbitrary Angle Chamfering	Profile Generation	Coordinate System Conversion	Pitch Error Compensation	Operation Hour Reduction Function	Tool Life Management	NC Operation Monitor	NC Work Counter
8	Tape Convert	IGF Convert	IGF	Graphic	User Task 2	Inch/Metric Switchable	Nose R 2B	LAP3
9	Coupling Spec. 8	Coupling Spec. 7	Coupling Spec. 6	Coupling Spec. 5	Coupling Spec. 4	Coupling Spec. 3	Coupling Spec. 2	Coupling Spec. 1
10	Door Open/Close (Special)	Front Drive Air Chuck	Arc Thread Cutting	Tool Retraction Cycle Interrupt Input	LR15M-ATC	Load Monitor-B2	NC Loader	Thermal Displacement Compensation
11						Max. Spindle Speed Interlock Release	External Program Selection C2	Alarm C Output
12	DNC-C3	DNC-C2	DNC-C1	DNC-B	DNC-A	External Program Selection C B A		

(16) Display of Specification Code (No. 2)

```

AUTO OPERATION ADMIN          N      0
CHECK DATA                   UNIT 1mm
SPEC CODE 02:
no.  data      bit7 bit6 bit5 bit4 bit3 bit2 bit1 bit0
13  00001100  DBTL PNL5 SPSS TLSB ECB 1PG VACO 2SP
14  00001011  OMI                      OMCH MCGR 9CRT FLMP NCMS
15  00000000  OMI                      OMCH MCGR 9CRT FLMP NCMS
16  00000000  IDXB IDZB IDXA IDZA INDC
    
```

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA		TOOL LAYOUT	CHECK DATA	[EXTEND]
-------------------	-----------------	-----------------	---------------	--	----------------	---------------	----------

F 1
F 2
F 3
F 4
F 5
F 6
F 7
F 8

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
13	Double Tooling	Operation Panel Position (Special)	Spindle Stop (Special)	Tool Index Type B	EC Bus Spec.	1-phase Pulse Generator	VAC Runout	Z-spindle
14	OMI Message Display			Monochrome Character Display (Current)	Monochrome Graphic Display	OSP500L-G Operation panel	Operation Panel with Flat Key	NC Master
15								Inductosyn Compensation
16	← Inductosyn →							

(17) Display of Machine Code

A U T C O P E R A T I O N A . M I N N G

CHECK DATA UNIT 1mm

MACHINE CODE		bit7	bit6	bit5	bit4	bit3	bit2	bit1	bit0
no.	data								
1	00000010	LH55	LH35	LS30	LC50	LC40	LC30	LC20	LC10
2	00000000	LR40	LR30	LR15	LP15	LB15	LB10	LB8	LB6
3	00000000						LB12	LP6	LPC4
4	00000000								

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA		TOOL LAYOUT	CHECK DATA	[EXTEND]
----------------	--------------	--------------	------------	--	-------------	------------	----------

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
1	LH55	LH35	LS30	LC50	LC40	LC30	LC20	LC10
2	LR40	LR30	LR15	LP15	LB15	LB10	LB8	LB6
3						LB12	LP6	LPC4
4								
5								
6								
7								
8								

(18) Display of Machine Spec Code

```

AUTO OPERATION A.MIN
CHECK DATA
MACHINE SPEC CODE
no. data bit7 bit6 bit5 bit4 bit3 bit2 bit1 bit0
1 00000001 XBR ZBR XAR ZAR PUL LHSR GR4S GR2S
2 00000100 DAIV VAC NS PGR 01MC BLSM MR CAR
3 00000010 MDAI MG2S SMSC
4 00000000

PROGRAM ACTUAL PART BLOCK TOOL CHECK
SELECT POSIT PROGRAM DATA LAYOUT DATA [EXTEND]
    
```

[F 1] [F 2] [F 3] [F 4] [F 5] [F 6] [F 7] [F 8]

bit No.	bit 7	bit 6	bit 5	bit 4	bit 3	bit 2	bit 1	bit 0
1					Pulley Change	LH50 Standard Spindle	Gear 4 steps	Gear 2 steps
2	Spindle DA Output Reversal	VAC Motor	Minor Change	Pulse Generator Reverse Rotation	0.1μ Control	Brushless Servo Motor	ATC Magazine Position Encoder Reverse	C-axis Position Encoder Reverse
3						M-axis DA Output Reversal	Revolving Tool Gear 2 Steps	Slideway Lubrication Motor Soft Control
4								
5								
6								
7								
8								

SECTION 5 TROUBLE AND TROUBLESHOOTING

The purpose of this section is to minimize downtime of the machine through speedy detection and remedies of the cause of any trouble that might occur.

It is extremely important to make detailed checks on the condition of the machine and CNC system when the trouble arose and to carry out various kinds of tests described in this section. Thus, the customer himself will be able to fix the machine in most cases. The test results reported to your local Okuma representative will be a great help in determining the nature and extent of the trouble and the remedies to be applied.

Generally, check the following matters:

- (1) When trouble occurs,
 - o Mode of operation
 - o Current position and command position
 - o What STATUS display lamp is going on?
 - o Is the ALARM lamp on?

When the ALARM lamp is on, the cause of the alarm can be known from the contents of the alarm message given on the CRT.

- (2) After resetting the CNC system,
 - o Does the trouble occur at the same situation repeatedly?
 - o Does the same trouble occur in other modes of operation?
 - o How about frequency of the trouble?
 - o Does the trouble arise regularly in terms of time, temperature, etc.?

This section covers the basic troubleshooting procedures, along with structure, operation and method of inspection for the major CNC component parts such as the CPU, servo drive units, relays in the machine control unit and the spindle control unit.

When any trouble occurs, see Section 4 "Maintenance and Inspection" together with this Section 5 and carry out necessary checks in accordance with the instructions.

5-1. ANALYSIS OF TROUBLE

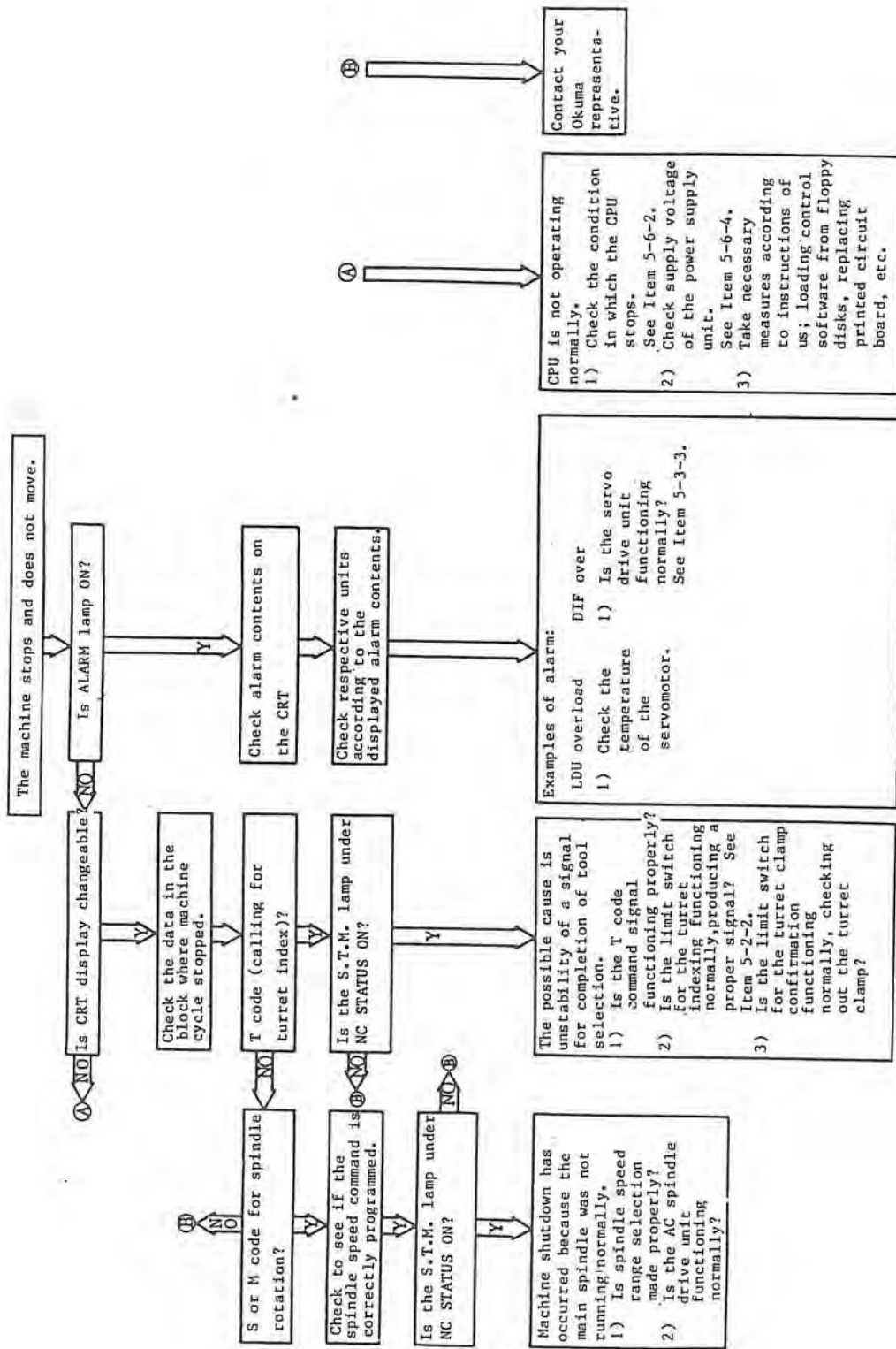


Fig. 5-1 Locating Problems

5-2. MACHINE-MOUNTED ELECTRICALS

Mounted on the machine are limit switches, solenoids, motors and other electro-mechanical components. See Appended Figures (1) & (2) Layout Diagram of Machine-Mounted Electricals for their location. As these machine-mounted electricals are placed in a very severe environment affected by chips, coolant, oil, dirt and dust, careful consideration has been given in design to protect these components from excessive moisture, dirt and dust. Nevertheless, electrical trouble causes a high rate of the NC troubles.

However, most of the electricals are relatively simple in their operation and can be easily checked and repaired if required by the customer's maintenance technicians. The checking procedures given under Section 5-7, "Relays and Magnet Switch Circuits" should be also consulted for solving electrical problems.

This Section describes the practical method to inspect limit switches and rotary switches. For other machine-mounted electricals, check in a similar way.

5-2-1. Inspection of Limit Switches (Check Method by Multi-Meter)

Limit switches are used for detecting travel end signal of individual axes, and clamp confirmation signal of turret.

In order to test a limit switch "LB15 turret clamp" actuation, for example, remove the cover from the turret first, and the terminal box is exposed. Then remove the access cover from the terminal box. As this limit switch is wired to terminals Nos. 54N and 165, make the multi-meter connections as shown in Fig. 5-2.

WARNING: TURN OFF POWER SUPPLY BEFORE ATTEMPTING THIS INSPECTION.

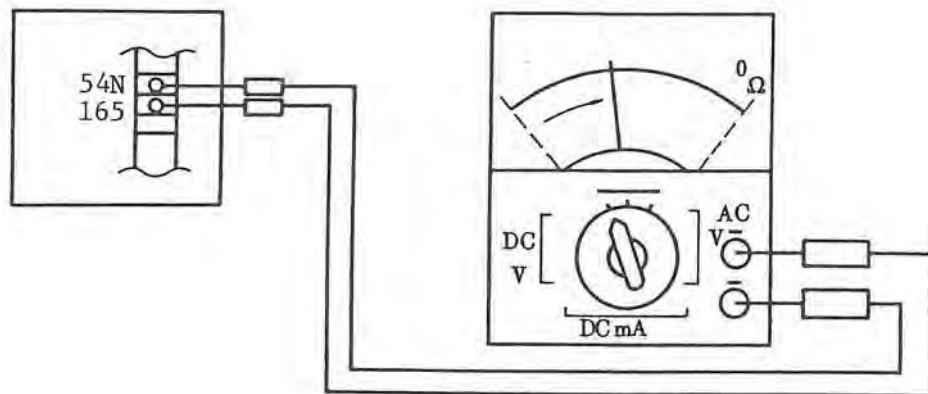


Fig. 5-2 Multi-Meter Connections to Check a Limit Switch

- (1) Set the multi-meter to the resistance range.
- (2) Apply multi-meter probes to the terminals (54N and 165).
- (3) When the multi-meter pointer deflects fully to the right on its scale, this indicates that resistance is zero and there is continuity between Terminals Nos. 54N and 165.
- (4) With the turret clamped in position, the limit switch is ON, with its contacts closed; the limit switch is considered to be normal when resistance between terminals No. 54N and No. 165 is zero.

5-2-2. Inspection of Limit Switches for Turret Indexing or Rotary Switches (Testing by Self-Diagnostic Function)

Limit switches or a rotary switch are installed in the turret and the combination of ON/OFF signals from them is used to identify the selected station (active tool position) by distinguishing the selected tool from other tools mounted on the turret. Failure of the limit switch or the rotary switch may cause a serious trouble since the control fails to identify the number of the tool indexed.

(The testing method mentioned in 5-2-1 can also be used to check the turret indexing limit switches or a rotary switch for their actuating condition.)

The following paragraphs cover the testing method using the self-diagnostic function of the CNC system.

Testing Procedure:

As explained under Section 4-4, "Self-Diagnostics", the CNC system and the NC I/O signals can be checked up through display in the CRT. In this case, output signals of the limit switches or a rotary switch, designated as TLA1, TLA2, TLA3 and so on, in tables of Section 4-4-2 can be checked by reading the bit data on the EC INPUT page.

- (1) Select Tool No. 1 in the manual mode.

If this causes signal TLA1 and TLA2 to be read into the CNC, the limit switches are considered to be in good condition. To check this, proceed further as follows:

- (2) Select "CHECK DATA EC INPUT 01" page of CRT display. This indicates ON/OFF status of the EC input signals.
- (3) Bit data on the No. 2 line on this page shows the input signal status of the turret index position confirmation limit switches or a rotary switch.

LB8 : A rotary switch is used for turret position detection. Bit 0 of input No. 2 corresponds to tool No. 1 (TLA1); check bit status at the data column at the left part of CRT. When it is "1", the rotary switch is normal. If any other bit data of No. 2 is "1", it indicates that the rotary switch is defective.

LB10 : Limit switches are used. Combination of signals from bit 0 to bit 6 of No. 2 are used for representing turret index position. See Fig. 5-3 for the relationship between the turret signal combinations.

LB15 : Limit switches are used. For the combination of signals for representing the turret position, refer to Fig. 5-4.

LB10 & LB15: On these two models, tool number 1 corresponds to bit 0 and bit 1 of No. 1, which are identified by signal names TLA1 and TLA2, respectively. Check the bit data condition at the data column in the left section which should be "1" (for both bit 0 and bit 1) with other bit data "0". If any of other bit data is "1" while the turret is indexed to tool number 1 position, it indicates an abnormal state.

- (4) Repeat the operations above for each of the turret index position to check the signal status from the limit switches or a rotary switch.

The limit switch, explained in the previous section, can be checked in the same manner without using a multi-meter.

Bit in No. 2 Tool No. \ line	bit 7	bit 6 (TLA7)	bit 5 (TLA6)	bit 4 (TLA5)	bit 3 (TLA4)	bit 2 (TLA3)	bit 1 (TLA2)	bit 0 (TLA1)
T1	0	0	0	0	0	0	1	1
T2	0	0	0	0	0	1	0	1
T3	0	0	0	0	1	0	0	1
T4	0	0	0	1	0	0	0	1
T5	0	0	0	1	1	1	0	1
T6	0	0	0	1	1	0	1	1
T7	0	0	0	1	0	1	1	1
T8	0	0	0	0	1	1	1	1
T9	0	1	0	0	1	0	1	1
T10	0	1	0	1	0	1	0	1
T11	0	0	1	1	0	1	0	1
T12	0	0	1	0	1	0	1	1

Fig. 5-3
Combination of Limit Switch Signals for Tool No. Identification
(LB10)

Bit in No. 2 Tool No. \ line	bit 7	bit 6 (TLA7)	bit 5 (TLA6)	bit 4 (TLA5)	bit 3 (TLA4)	bit 2 (TLA3)	bit 1 (TLA2)	bit 0 (TLA1)
T1	0	0	0	0	0	0	1	1
T2	0	0	0	0	0	1	0	1
T3	0	0	0	0	1	0	0	1
T4	0	0	0	1	0	0	0	1
T5	0	0	0	1	1	1	0	1
T6	0	0	0	1	1	0	1	1
T7	0	0	0	1	0	1	1	1
T8	0	0	0	0	1	1	1	1
T9	0	0	1	0	0	0	0	1
T10	0	1	0	0	0	0	0	1
T11	0	1	0	1	0	0	1	1
T12	0	0	1	1	0	0	1	1

Fig. 5-4
Combination of Limit Switch Signals for Tool No. Identification
(LB15, Type A)

Tool No. \ Bit in No. 2 line	bit 7	bit 6 (TLA7)	bit 5 (TLA6)	bit 4 (TLA5)	bit 3 (TLA4)	bit 2 (TLA3)	bit 1 (TLA2)	bit 0 (TLA1)
T1	∅	∅	∅	∅	∅	∅	1	1
T2	∅	∅	∅	∅	1	∅	∅	1
T3	∅	∅	∅	∅	∅	1	∅	1
T4	∅	∅	∅	1	∅	∅	∅	1
T5	∅	∅	∅	1	∅	1	1	1
T6	∅	∅	∅	1	1	1	∅	1
T7	∅	∅	∅	∅	1	1	1	1
T8	∅	∅	∅	1	1	∅	1	1
T9	∅	1	∅	1	∅	∅	1	1
T10	∅	1	∅	∅	1	1	∅	1
T11	∅	∅	1	∅	1	1	∅	1
T12	∅	∅	1	1	∅	∅	1	1

Fig. 5-5

Combination of Limit Switch Signals for Tool No. Identification
(LB12/LB15, Type B)

5-3. BRUSHLESS SERVO MOTOR DRIVE UNIT

The brushless servo motor drive unit BDU-A was developed by Okuma to drive its brushless servo motors, especially those used for machine tool axis drive. The brushless servo motor is another product of Okuma, one of the major suppliers of mechatronics technology in the world. The major features of the BDU-A are listed below:

- (1) The use of a brushless servo motor eliminates the need for inspection and replacement of commutator brushes, which is a must with DC motors.
- (2) The transistor PWM system assures smooth and quick response.
- (3) It promises good acceleration/deceleration characteristics.
- (4) The high-resolution OSP position encoder directly coupled to the motor detects both the motor speed and position. Therefore, control and construction are quite simple.
- (5) Various measures to protect the motor are provided. They include:
 - motor overload detection
 - no-fuse breaker
 - overcurrent alarm
 - input voltage detection
 - circuit failure

5-3-1. Configuration of BDU-A

The BDU-A consists of the DC power supply and the servo amplifier unit. A DC power supply can supply power to multiple servo amplifiers and one brushless servo motor requires one servo amplifier. Fig. 5-6 shows the configuration of the BDU-A.

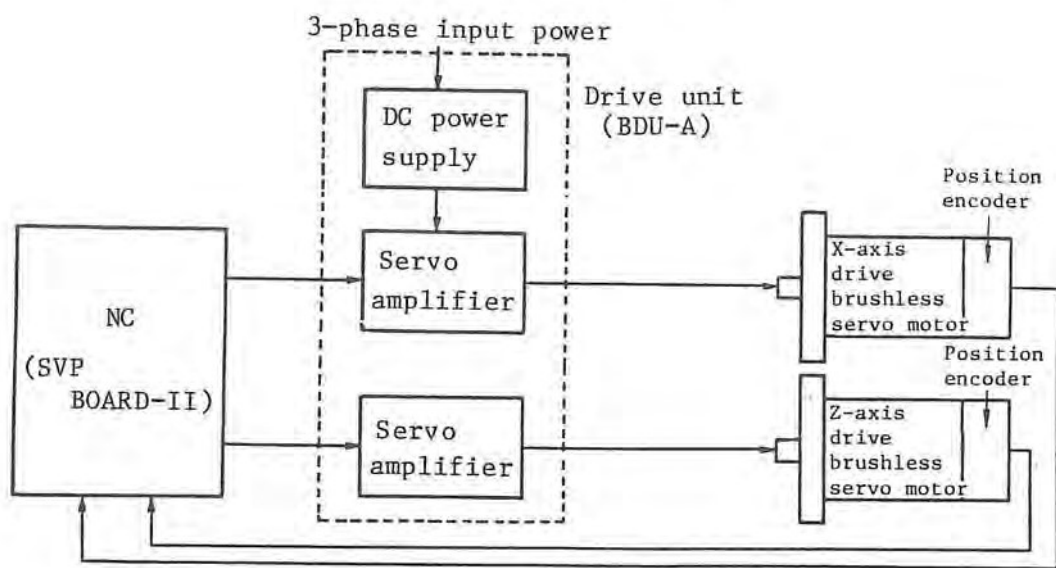


Fig. 5-6 BDU-A Configuration

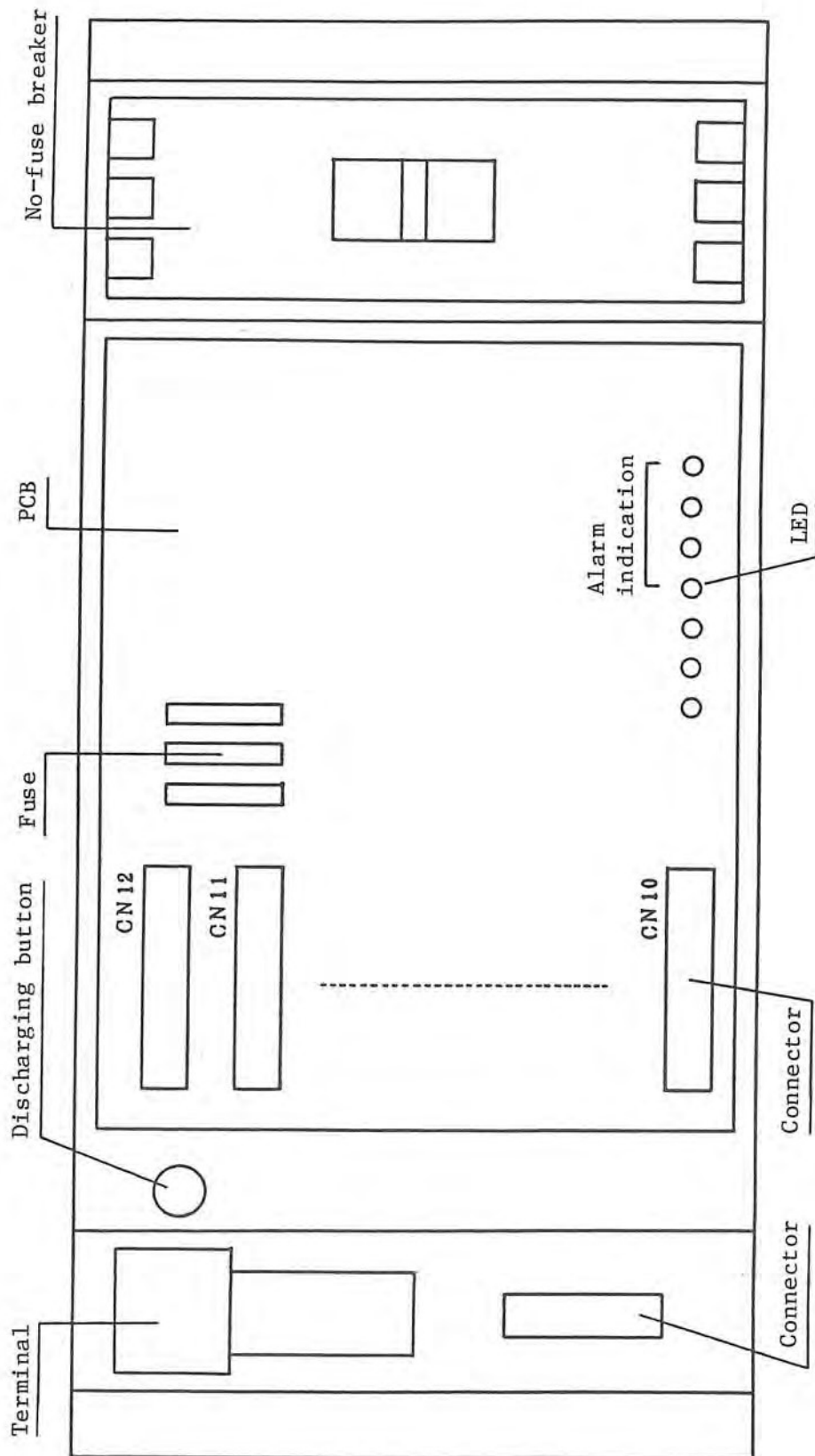


Fig. 5-7 External View of DC Power Supply

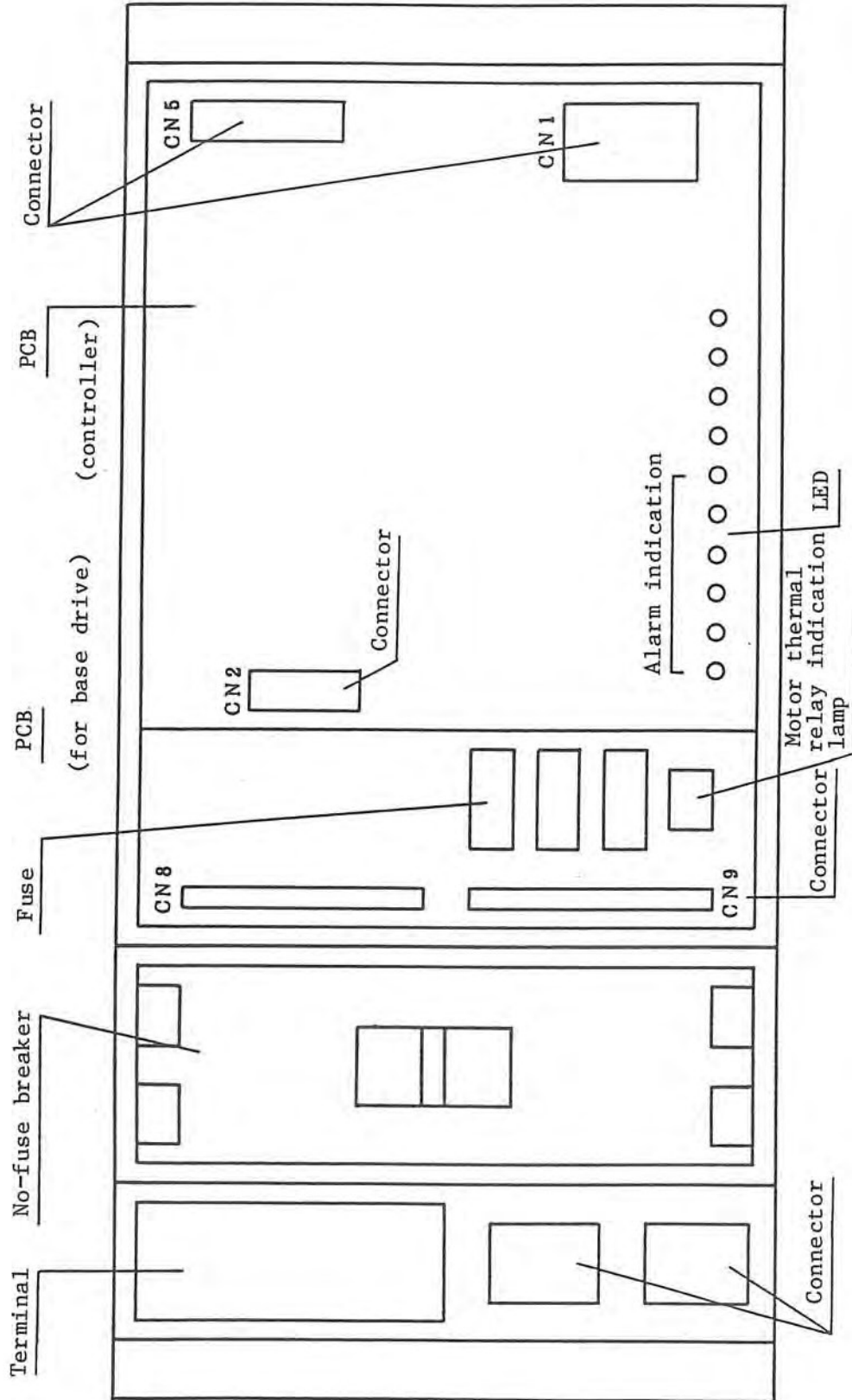


Fig. 5-8 External View of Servo Amplifier

5-3-2. BDU-A Protection Function and Alarm Indication

(1) Protection Function

The BDU-A has protection functions indicated in Table 5-1.

Table 5-1

Protection Function	Indication	Contents
Fuse	Fuse element is blown out. See item (3) in 5-3-2.	It protects the BDU-A from short of load connected to the control circuit of DC power supply and servo amplifier.
No fuse breaker	The no-fuse breaker lever is turned to the OFF position.	It protects the BDU-A from short of load connected to the power line or grounding of power line of DC power supply and servo amplifier.
Overload	Indication lamp	This detects the overload of motor.
Alarm of: overcurrent over voltage low voltage phase loss circuit alarm	LED	Refer to item (2) of 5-3-2.

(2) Alarm Indication and Alarm Contents

a) DC power supply

The printed circuit board in the DC power supply has light emitting diodes to indicate alarm occurrence as summarized in Table 5-2. If one of these red LEDs is illuminated, the magnet switch in the DC power supply is turned off, thus disabling the control of the brushless servo motor.

Table 5-2

LED	Alarm Name	Contents of Alarm and Points to Check
LV	Low voltage	DC output voltage has dropped excessively. Check the servo amplifier.
HV	High voltage	DC output voltage has risen excessively. Check the DC power supply or servo amplifier.
PH	Phase loss	Phase loss in 3-phase input. Check fuses for blown out.
OVER DIS	Overdischarging	The discharging circuit for the regenerating voltage worked for a duration longer than the specified length. Check the DC power supply.

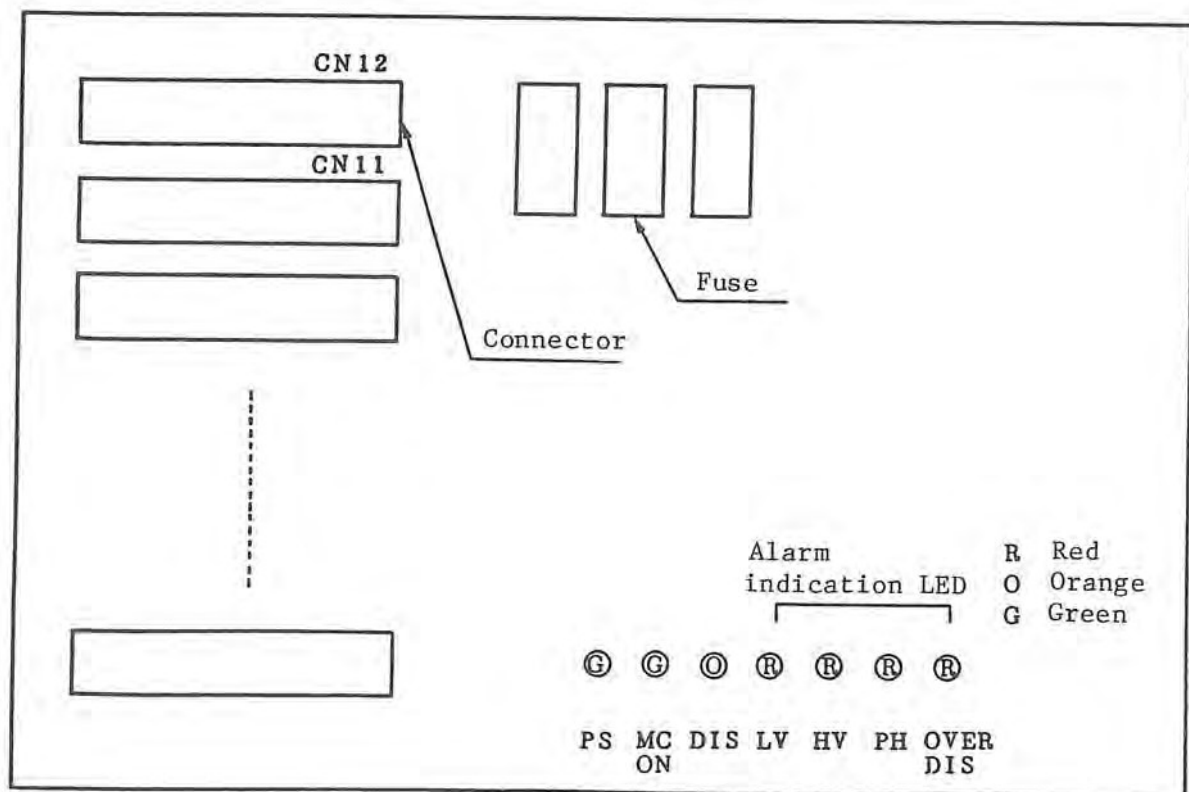


Fig. 5-9 Printed Circuit Board in DC Power Supply

b) Servo amplifier

The printed circuit board in the servo amplifier has light emitting diodes to indicate alarm occurrence as summarized in Table 5-3. If one of these red LEDs is illuminated, the base signal of a transistor in the servo amplifier is blocked and the alarm signal is outputted to the OSP at the same time.

Table 5-3

LED	Alarm Name	Contents of Alarm and Points to Check
PH	Phase loss	Phase loss in 3-phase input. Check fuses for blown out.
VR	Control power alarm	+12 V power in the control circuit has dropped below the specified level. Check the printed circuit board in the servo amplifier.
IOC-M	Instantaneous over current	Overcurrent flowing through the motor. Check the brushless servo motor for burning and insulation. Check the servo amplifier.
IOC-S	Short	Excessive current flowing through the transistor bridge. Check the servo amplifier.
LV	Low voltage	DC power supply voltage has dropped excessively. Check the no-fuse breaker of the servo amplifier for tripping. Check the servo amplifier.
HV	High voltage	DC power supply voltage has risen excessively. Check the DC power supply or the servo amplifier.

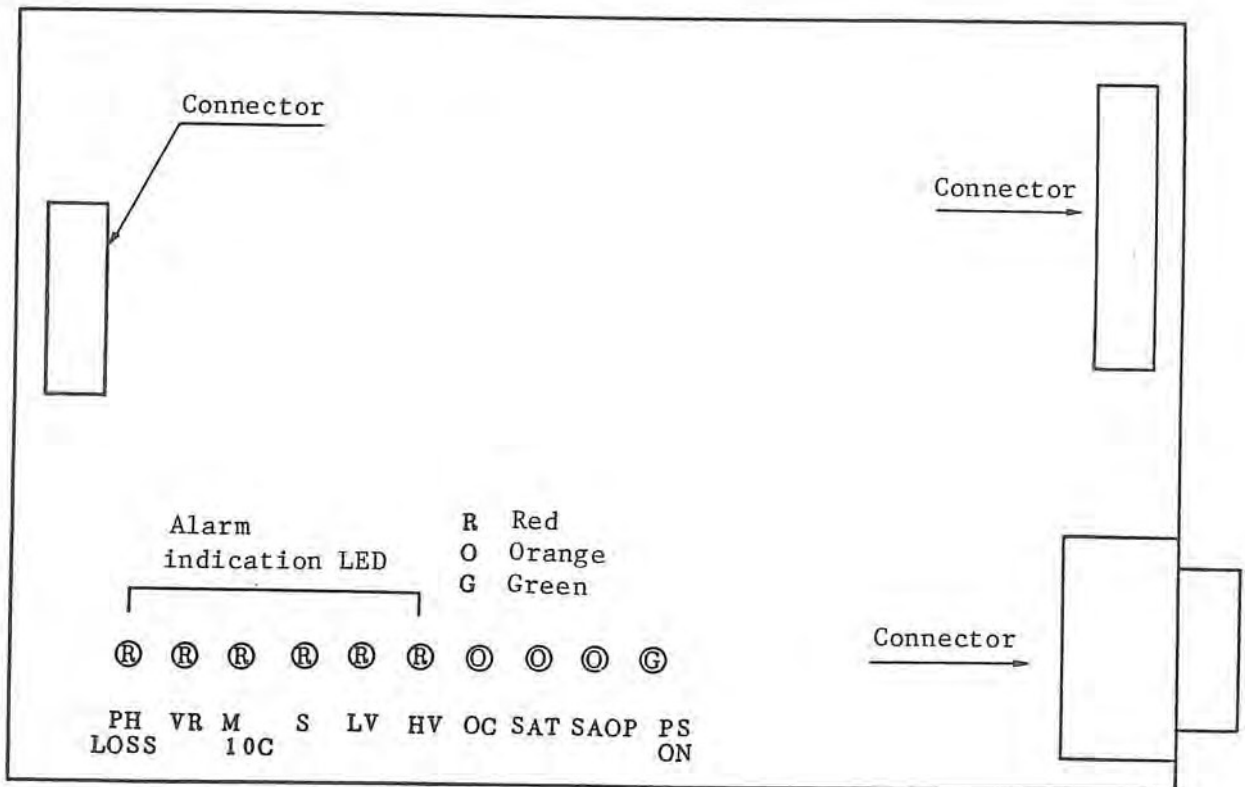


Fig. 5-10 Printed Circuit Board in Servo Amplifier

(3) Resetting Alarm and Replacing Fuse

When any of the alarm indicated above has occurred, first turn off the no-fuse breaker on the EC panel.

Glass-tube filled fuses are as illustrated in Fig. 5-11 and blowing out of the fuse element can be visually checked.

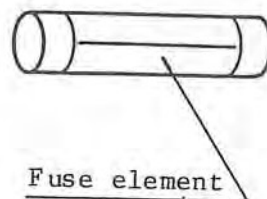


Fig. 5-11 Glass-tube Filled Fuse Element

5-3-3. Trouble and Troubleshooting

(1) Checkups after occurrence of a problem

If a problem occurs with the BDU-A, carry out checkups referring to Table 5-4 below.

Table 5-4

Item	Phenomenon	Checkups
1	The BL motor fails to rotate even when axis movement commands are given.	<p>Is the no-fuse breaker of the DC power supply tripped?</p> <p>Is the no-fuse breaker of the servo amplifier tripped?</p> <p>Is any of the alarm indicating LEDs on the printed circuit board of the DC power supply or the servo amplifier illuminated?</p>
2	An alarm state occurs when the BL motor starts.	Check load current. Is it too large?
3	The PH lamp comes on.	Is a fuse blown?

(2) Precautions for maintenance

If the no-fuse breaker of the DC power supply or the servo amplifier has tripped, turn off the no-fuse breaker on the EC box before re-setting the tripped no-fuse breaker.

Before replacing printed circuit boards and fuses, and checking looseness of the terminals, turn the no-fuse breaker on the control box and hold down the discharging button for about 10 seconds. See Fig. 5-12.

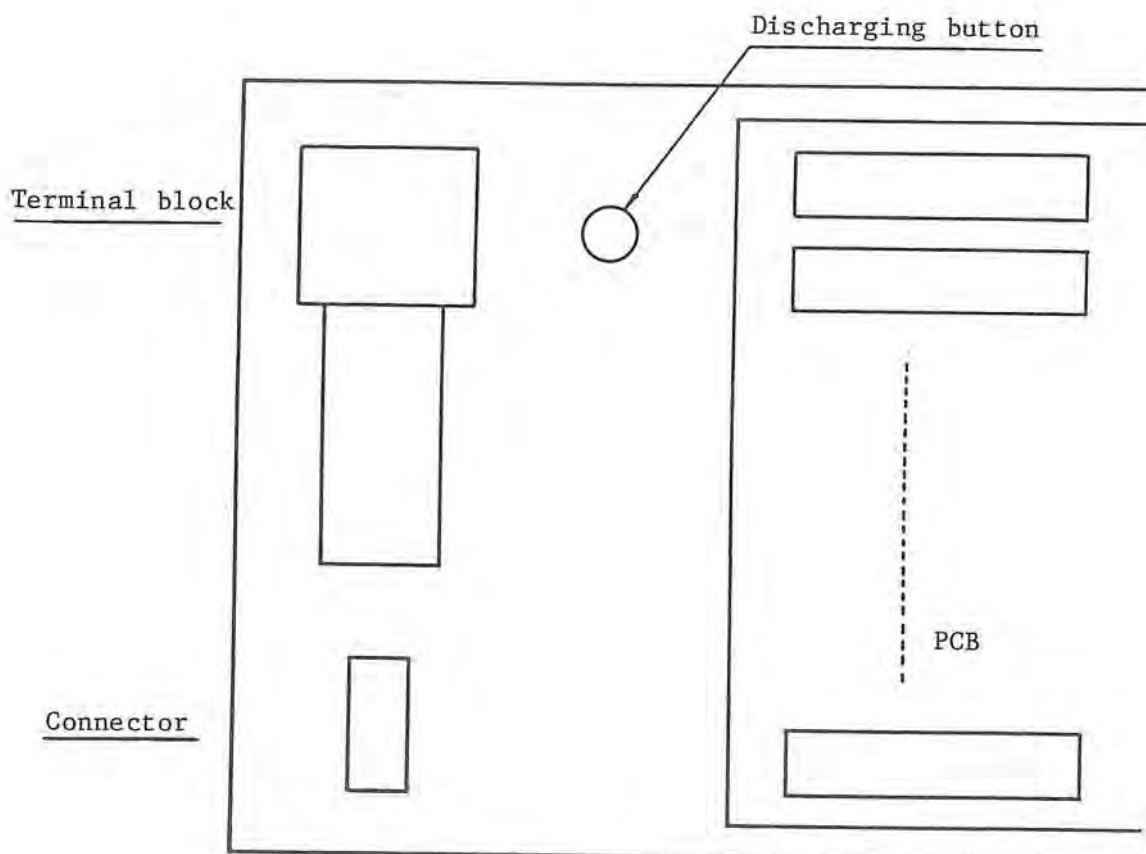


Fig. 5-12 Discharging Button on DC Power Supply

5-3-4. Spare Parts of BDU-A

Fuses indicated in Table 5-5 are supplied as spare parts of the BDU-A.

Table 5-5

Unit Name	Part Name	Q'ty	Maker	Okuma Part No.
DC Power Supply	Fuse No.1065 AC 200V 2A	3	Satoh Parts	E2442-290-106
Servo Amp.	Fuse No.1065 AC 200V 2A	3	Satoh Parts	E2442-290-106

5-4. INSPECTION OF POSITION ENCODER

The position encoder detects the present position of each axis accurately. Any fault in this encoder prevents the present position from being found easily, which will result in any of the following troubles.

- o Rough cut surface
- o Hunting
- o APA pattern data alarm, APA speed alarm and APA check data alarm

Checking The Position Encoder:

While moving each axis slowly with the pulse handle, check that the output value from the position encoder changes smoothly by the following procedures.

- (1) Obtain the CHECK DATA *NC AXIS DATA* page on the CRT.
- (2) Then, the position detected value of each axis, R-APA, operational value R-CON, and the difference R-DIF can be monitored. Here, note the R-APA, the position detection value of the axis to be checked.
- (3) Switch the mode to MANUAL, and move the axis slowly with the pulse handle.
 - o Check that the value changes from the smaller digit slowly.
 - o Check that no value is omitted and that no value repeats.
 - o Check that the digit carry is done properly.

Normal case:

18 → 19 → 20 → 21 → 22

Abnormal case:

18 → 20 → 21 → 22

18 → 19 → 21 → 20

If the value and change are not normal, it can be assumed that there is a fault in the encoder. In addition, there is a possibility that there is a fault in the connector contact or the SVP BOARD-II of the CPU printed circuit boards.

5-5. CHECK PANEL (FOR LB15)

Open the tape reader door, and the check panel will be found above the tape reader.

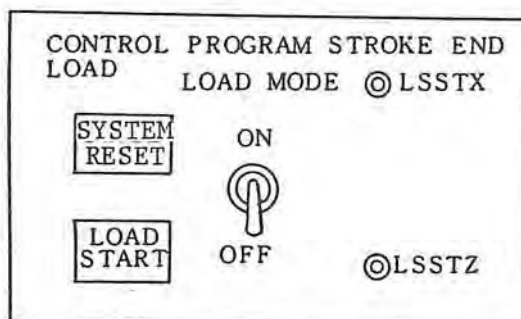


Fig. 5-13 Check Panel

When the emergency limit switch at each end of the X- and Z-axis is tripped, the corresponding check lamp (LSRTX for X-axis and LSRTZ for Z-axis) lights up.

5-6. CPU

This section describes matters related to the CPU. The complete operation of the NC machine is described in 4-3, "Operation and Structure of the NC", and should be referred to.

5-6-1. Operation and Structure of the CPU

Refer to Fig. 4-2.

As described in 4-3, the main component of the OSP5000/OSP5000 is the CPU, which consists of five BOARDS and CARDS added to the BOARD. The CPU employs "Multi-processing system" in which the brushless servo motor control processor and other interfaces on the SVP BOARD II function under the control of the main processor on the MAIN BOARD II. For each processor, a high performance microprocessor is used and for the IC memory, a high-speed very large scale IC memory is used in order to accomplish high-grade NC functions. In addition to the IC memory, a bubble memory for storing machining programs and control program (control software) storage is provided. The bubble memory is a read/write memory, allowing stored data to be altered as needed. Its memory capacity is up to 4 M byte.

Signals are communicated between each processor and external equipment (tape reader, position encoder, operation panel, servo drive, etc.) through the interface circuit contained in the BOARD.

The OSP5000/OSP5000 is a computer NC with control programs (control software) designed specially to each user's specifications, and delivered as control tapes with each NC system. The operation to store control software into the bubble memory is called software loading.

When the specifications are changed or a bubble memory is replaced, loading is required.

The power supply unit supplies all power required for the CPU. An 200 VAC input direct switching method is employed because it gives high efficiency and causes less heat generation.

Refer to Fig. 5-14 for CPU and Power Supply Unit.

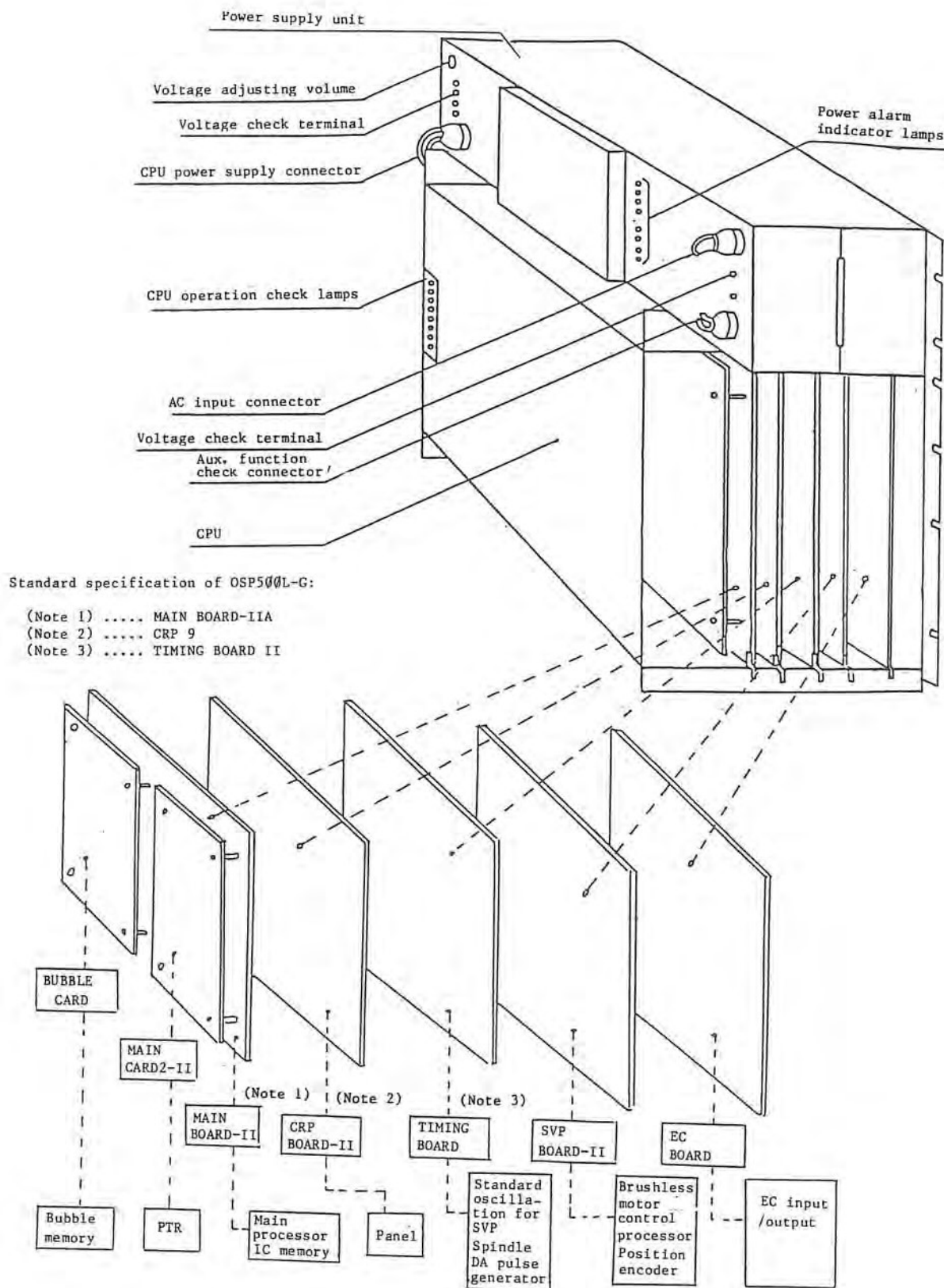


Fig. 5-14 CPU and Power Supply Unit

5-6-2. Checking CPU Operations

Simple checking for proper computer functioning can be carried out by checking if the indication on the CRT screen operates properly. For example, try to change the page indicated on the CRT screen. If the page is actually changed, it can be assumed that the computer works well. In order to check what condition the computer remains in, make a check by the CPU operation check indication on the CPU unit. Refer to Figs. 5-14 and 5-15.

Indication Contents

- POWER Power supplied to CPU
- RUN CPU running.
- BUS ERROR More than two errors occur at same time.
CPU stops running.
- ECC ERROR Error in more than two bits are caused in the
main memory.
- DIA ERROR Errors occur in self diagnostics.
- LOOP ERROR Errors occur when the control software execu-
tion is looped.
- CYCLE ERROR Errors occur if the control command of the
control software is not completed within a
specified time.
- WPRT ERROR Errors occur if the control software enters
memory address area not yet defined.

Fig. 5-15 CPU Operation Check Indication

- Two lamps, POWER and RUN, light in normal condition.
- When errors occur

For any error except BUS ERROR:

The CPU continues running and processes errors, and the CRT screen on the operation panel indicates the contents of the errors.

For BUS ERROR:

The RUN lamp goes off and CPU operation stops.

- Error indication means abnormality in the computer and will not go off when the OSP500/OSP5000 is reset.
- To start NC operation again, switch OFF the power and then switch ON again. The computer starts RUN automatically and goes into NC operation several tens of seconds later.
- If the abnormality is continuous, the error occurs again and the computer stops. When the computer carries out normal NC operation, continue using it and observe the operation.

5-6-3. Loading Control Software through Floppy Disk

Loading the control software through the floppy disk can store the necessary information for controlling the OSP500L-G/OSP5000L-G in the bubble memory. This loading operation is required when changing the control specifications or after replacing bubble memory due to an occurrence of problems with the bubble memory.

The floppy disk storing the control software (to be referred to as the control floppy disk, hereafter) is supplied with the control system in a case.

The control floppy disk stores information necessary for initializing bubble memory, the NC control programs, and the data required for executing the NC control programs.

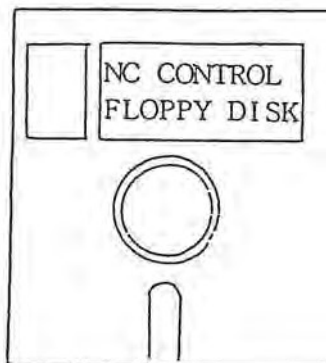


Fig. 5-16 Control Floppy Disk

Loading Procedure:

For LB10 and LB12:

- 1) Turn off power supply and connect the portable floppy disk drive to the OSP500L-G/OSP500L-G as shown in Fig. 5-17.

Insert the floppy disk drive control PCB (FDC) into any slot available and connect the portable floppy disk drive to this PCB using a special cable. Note that the power must be turned off before connecting the portable floppy disk drive unit.

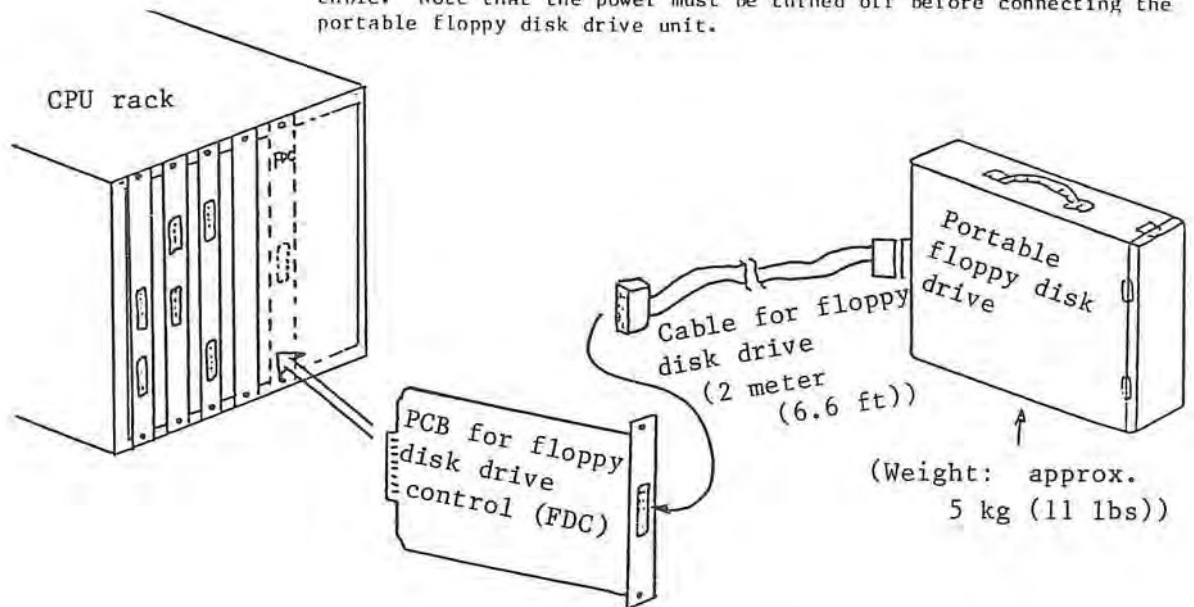


Fig. 5-17 Connection of Portable Floppy Disk Drive

Remark: When there is no empty slot for inserting the FDC, remove any board such as EC board, except the main board to insert the FDC.

- 2) Connect the portable tape reader.
- 3) Turn on power.
- 4) Turn the CONTROL PROGRAM LOAD ON/OFF switch on the portable tape reader to the ON position.
- 5) Press the SYSTEM RESET button. The OSP500L-G/OSP500L-G is placed in the loading wait condition and the CRT will display the message "control floppy loading wait".

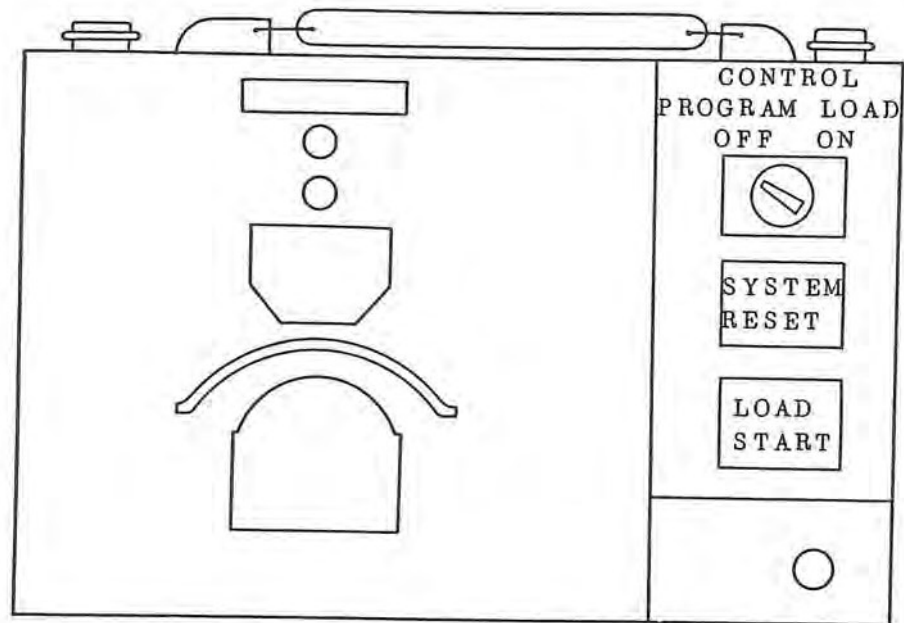


Fig. 5-18 Portable Tape Reader

- 6) After making sure the display on the CRT, insert the control floppy disk into the portable floppy disk drive.
- 7) Press the LOAD START button.

The floppy disk drive starts and the control software on the floppy disk is read into the OSP500L-G/OSP5000L-G. The CRT will first display the message "control floppy loading start" and then the program name being read.

After all programs on the control floppy disk have been loaded, the message "control floppy loading end" appears and the message "control floppy loading wait" will be displayed below it.

- 8) After all control software programs have been loaded, turn the LOAD switch OFF and press the CONTROL ON button after turning off power by pressing the CONTROL OFF button. The OSP500L-G/OSP5000L-G will start operation automatically and after an elapse of about several tens of seconds it starts the NC control in accordance with the loaded control software.

For LB15:

- 1) Connect the portable floppy disk drive in the same manner as with the LB10 and LB12.
- 2) Turn on power.
- 3) Turn the PROGRAM LOAD MODE switch on the check panel (Fig. 5-13) in the ON position.
- 4) Perform steps 5), 6) and 7) explained for LB10 and LB12.
- 5) After the completion of the loading, turn OFF the PROGRAM LOAD MODE switch and press the SYSTEM RESET button. The OSP500L-G/OSP5000L-G will start operation automatically and after an elapse of about several tens of seconds it starts the NC control in accordance with the loaded control software.

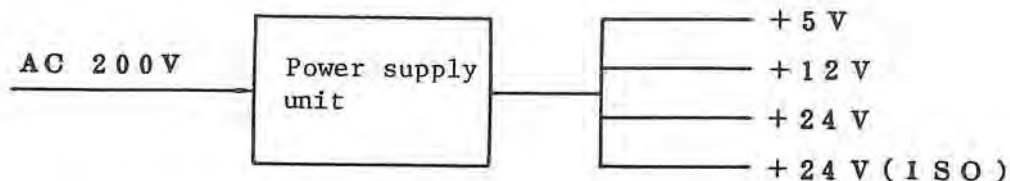
Warning:

1. Never turn on and off power with the control floppy disk set in the floppy disk drive. The information on the floppy disk will become unreliable.
2. After the completion of the loading be sure to keep the control floppy disk in the floppy disk case after removing it from the floppy disk drive.

5-6-4. CPU Power Supply

The power supply for the CPU has the arrangement shown here.

VAC 200 is input into the power supply unit and this supplies the voltage required for the CPU. This unit is mounted on the CPU unit as shown in Fig. 5-14. For the connection with the CPU unit, input of AC 200V, and for connection with other devices, dedicated cables and connectors are used. Each output voltage is supplied for the following destinations.



- +5V : Power supply for IC's in CPU unit
- +12V : Bubble memory, position encoder, main spindle pulse generator, manual pulse generator
- +24V : Bubble memory, tape reader
- ISO+24V: Power supply for EC input/output isolator

Voltage check terminals for each output are provided to check these output voltages. A variable resistor to adjust the voltage is provided for +5V. Refer to Fig. 5-14.

This power supply has the function that continuously monitors input/output voltage and temperature. When an abnormality occurs, the cause is indicated by the power supply alarm indicating lamps shown in figure below, and CPU operation stops.

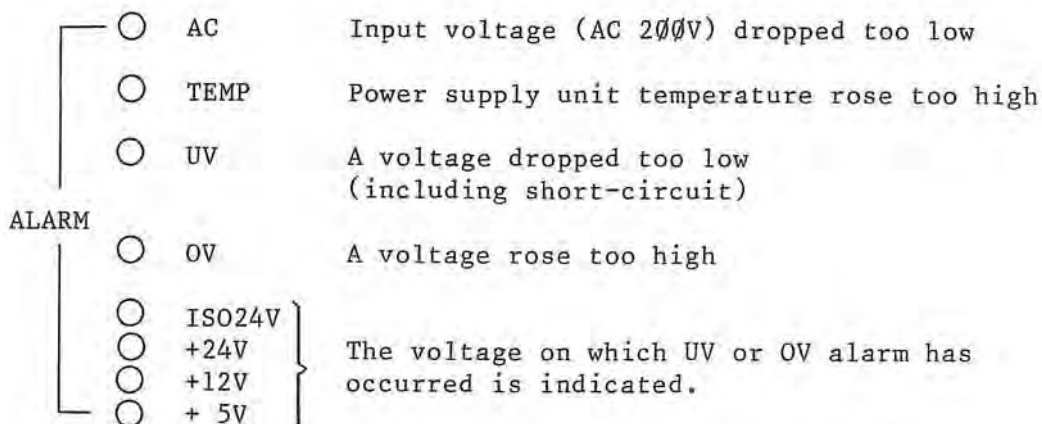


Fig. 5-19 Power Supply Alarm Indication

- When any of these alarm lamps lights, power supply to the CPU is turned OFF and the CPU stops running.
- This alarm indicates an abnormality in the power supply unit or in the input and output parts. In this case, all power supplies in the NC system, including the operation panel, are cut off.
- To start the NC operation again, turn OFF the AC input to the NC system once (switch OFF the main breaker), and turn back ON the main breaker after confirming that the alarm indication disappears several tens of seconds later. Then press the POWER ON button. The CPU starts running automatically and the OSP500L-G/OSP500L-G starts operation.
- If the abnormality is continuous, the power supply alarm comes on again, but if the CPU runs normally, continue using it and observe the operation.

5-7. RELAY AND MAGNET SWITCH CIRCUITS

The relay and magnet switch circuits control devices requiring high voltage which cannot be controlled by semiconductors, such as motors, clutches, and solenoids. Since the relays and magnet switches can be checked visually, the operation check is relatively easy. Check according to the relay circuit diagrams provided for each machine.

5-7-1. Operation and Structure of a Relay and Magnet Switch Circuit

The same operation principle applies to all magnet relays.

When an energizing voltage is charged at both ends of the coil (a) and (b), an attractive force is generated in the coil and turns ON contact point A which is normally open (NO contact), and turns OFF contact point B which is normally closed (NC contact).

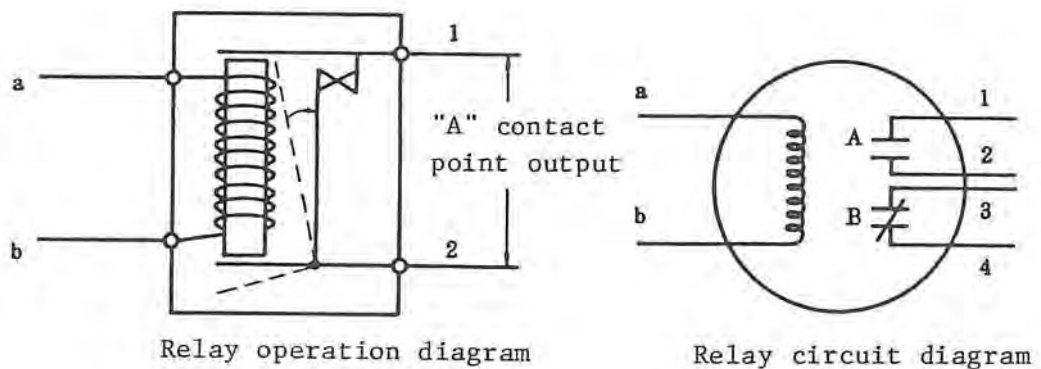


Fig. 5-20 Relay Operation

When the coil is energized, NO contact is closed and NC contact is opened.

On the other hand, when the coil de-energized, NO contact is opened and NC contact is closed. The coil will be energized by either DC voltage or AC voltage. Generally, most small relays are energized by direct current, while most large relays by alternating current.

With the LB series CNC lathes, most of the relay control circuits are replaced by computer software, and only the absolutely necessary number of relays are used. For arrangement of the relays, consult the Appended Figures (6), (7) and (8) Internal Layout of OSP500L-G/OSP500L-G CNC Unit.

5-7-2. Inspection of a Relays and Magnet Switches

Large relays are called magnet switches. They are mainly used to control motors.

(1) Operation check of a magnet switch (MS)

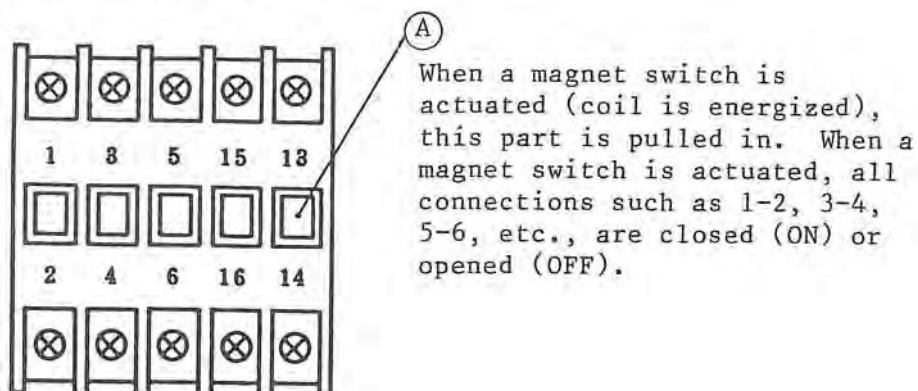


Fig. 5-21 Magnet Switch

When the magnet switch is actuated:

If the connection between 1-2 is closed, it is called contact point "A", and indicated in a circuit diagram by the symbol (1).



If the connection between 1-2 is opened, it is called contact point "B", and in a circuit diagram by the symbol (2).



Sometimes troubles of a relay are caused. When the coil is energized, a contact point may fail to open and close (due to poor contact or foreign matter clogging), or the Part A may occasionally remain pulled in (fused, etc) even when the coil is not energized.

The LB series CNC lathes use two type of miniature relays: G2A relays for controlling relay logic and LY relays for controlling low level of power.

(2) Operation check of relay (CR)

The operation and work of the relay is the same as for the magnet switch. For contact point (A) and (B), it is also the same.

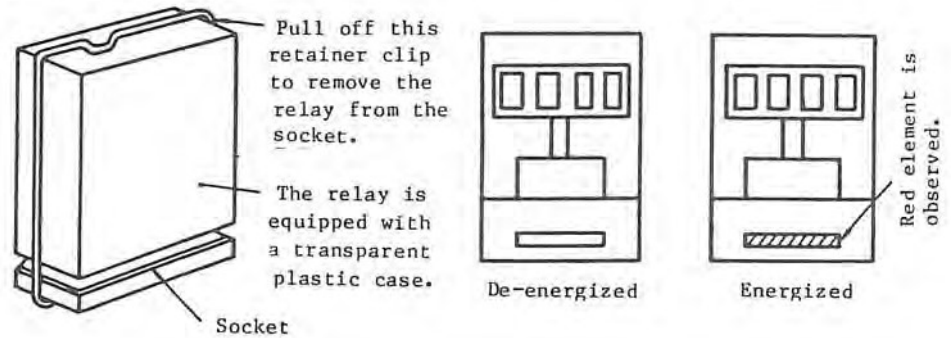
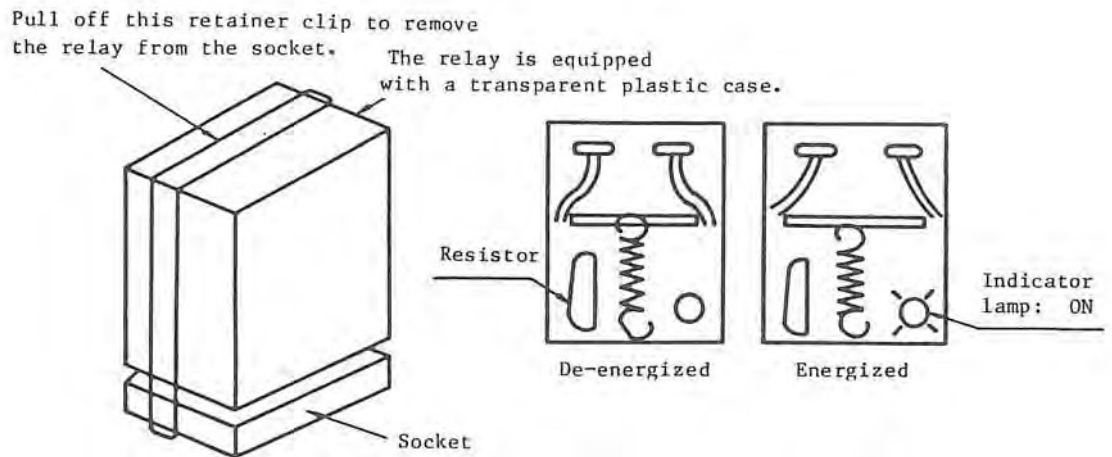
G2A RelayLY Relay

Fig. 5-22 Relay Switch

(3) Inspection of overload protection relays and fuses

For protecting motors and solenoids, etc., from overcurrent and overload, an overload relay is used.

To reset the tripped relay, push in the reset rod. Note that pushing in the reset rod right after the relay has been tripped, cannot reset the relay. Allow the switch to cool before resetting it.

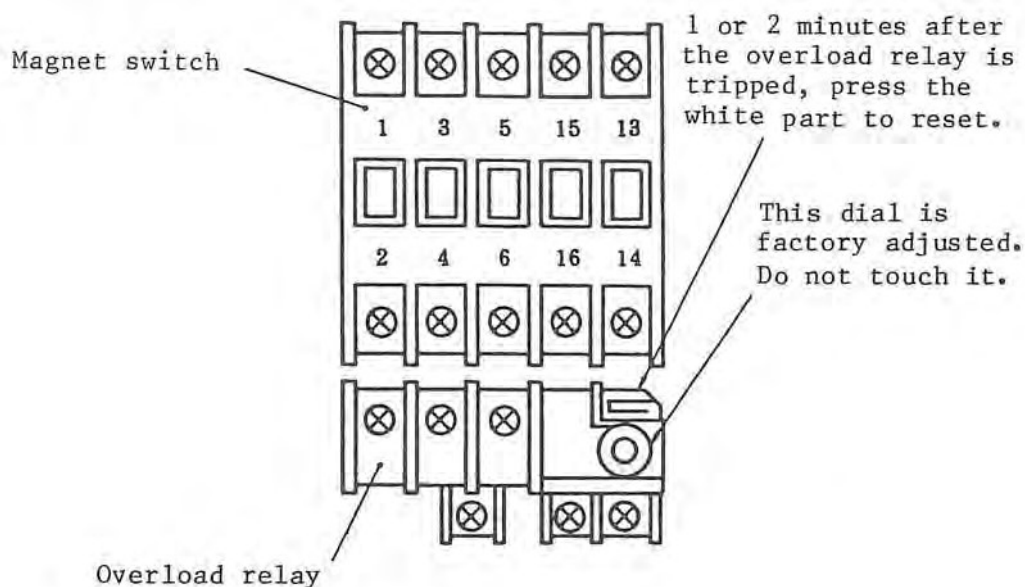


Fig. 5-23 Overload Relay

The circuit breaker and fuses prevent overcurrents from surging through the control circuit.

With circuit breakers, functions of the circuit can be recovered by simply resetting the tripped breaker. With cartridge type fuses, it is necessary to replace fuse elements if blown.

SECTION 6 SPINDLE DRIVE UNIT FOR VAC MOTOR (FANNC MAKE)

6-1. GENERAL

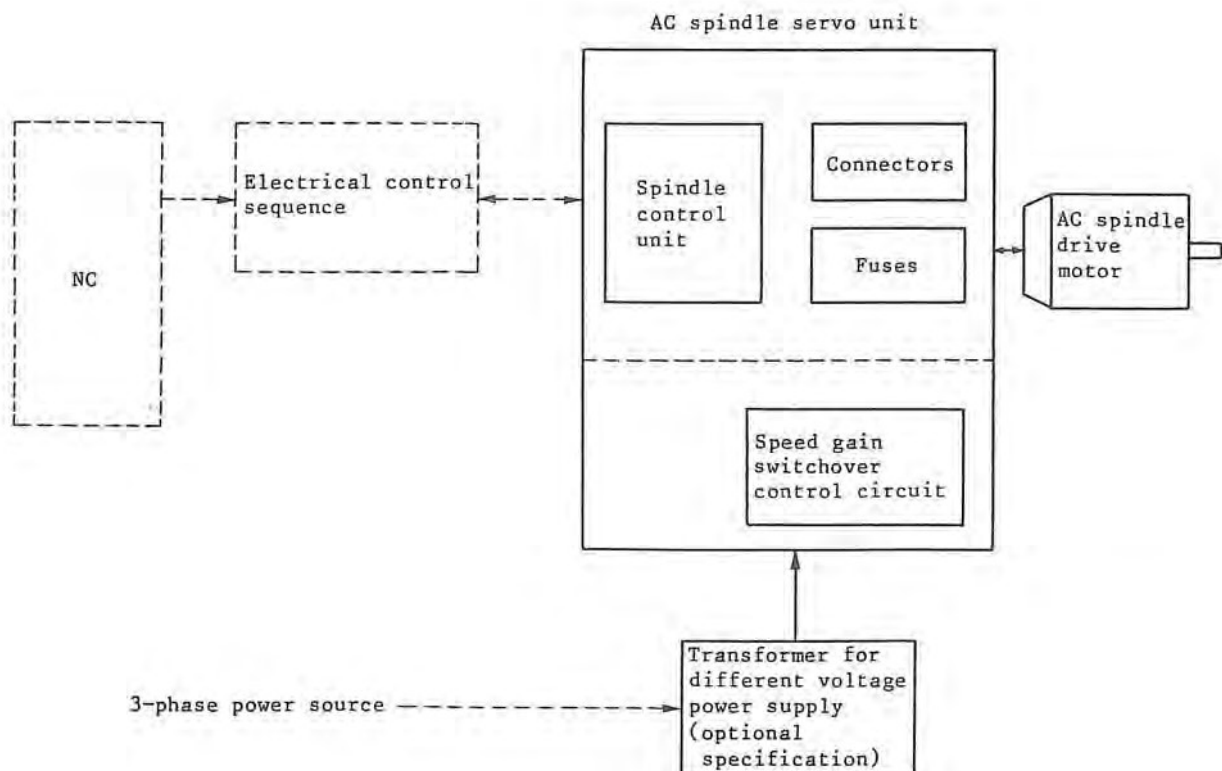
This Instruction Manual covers AC Spindle Servo Unit Models A06B-6044-H007 to A06B-6044-H011 and the related optional components.

This AC Spindle Servo Unit adopting microcomputers can drive the spindle smoothly, quietly and stably by means of our unique spindle drive system. In addition, our own regenerative control system can save power consumption by returning the regenerated energy to the power supply while AC spindle drive motor speed is decelerated.

6-1-1. Construction

The AC Spindle Servo Unit consists of the following unit and components.

- | | |
|--|-----------------------------|
| (1) Spindle control unit | (1.1) Power unit |
| | (1.2) Printed circuit board |
| | (1.3) ROM |
| (2) Fuses (for spare) | |
| (3) Connectors (for connection) | |
| (4) Transformer for different voltage supply
(optional specification) | |
| (5) Speed gain switchover control circuit | |



6-2. SETTING AND ADJUSTMENT

6-2-1. Setting of Units and Printed Circuit Board











For layout of the component parts and devices on the servo unit and the printed circuit board, refer to the layout diagrams (Appendix 1 and 2).

Make sure to confirm the following setting before turning on the power.

Table 6-1 Setting of Toggle Switch for Voltage Selection

AC Power Voltage	Nominal Voltage	Setting
170 to 220 V	200 V	Set the toggle switch to 200 V position
210 to 242 V	220 V	Set the toggle switch to 220 V position

Table 6-2 Confirmation of Setting Terminal (Short Bar)

Setting Terminal No.	Item	Setting	Factory Setting	
S1	Machine Ready Signal [MRDY]	USED	OFF  ON	OFF
		NOT USED	ON  ON	
S2	Analog Override	USED	OFF  ON	ON
		NOT USED	ON  ON	
S3	Analog Override	USED	ON  ON	OFF
		NOT USED	OFF  ON	
S4	Speed Command Signal	External analog command voltage is used.	OFF  ON	OFF
		R01 to R012 commands are used.	ON  ON	
S5	Setting speed feedback amount with respect to rated command	4500 rpm	Short circuit at B terminal 	Set to motor rating
		6000 rpm	Short circuit at A terminal 	

Setting Terminal No.	Item	Setting					Factory Setting	
		Motor Model	3	6	8	12		15
S6 S7	Speed control phase compensation	S6	OFF				<input type="checkbox"/> ON	OFF
		S7	ON				<input type="checkbox"/> ON	ON

Since the variable resistors RV1 to RV19 are all factory-set, it is not necessary to adjust them after installation.

6-3. MAINTENANCE

To maintain the designed performance of the spindle drive AC motor and the servo unit, check and clean them periodically - every six months desirable - according to the instructions below. However, if they are contaminated heavily when checked, it will be necessary to check them more frequently than specified.

(1) Spindle Drive AC Motor

Dust and dirt accumulated on the ventilation holes, cooling fan, or fanguard (screen) of the spindle drive AC motor deteriorates the radiation efficiency of the motor. In this case, clean them using compressed air or a vacuum cleaner.

(2) Servo Unit

Since the cooling fan is located on the upper side of the servo unit, nearby components such as resistors will be contaminated by dust and dirt after a long time of operation. If the servo unit is contaminated heavily, clean it using a vacuum cleaner.

6-4. TROUBLESHOOTING

If a trouble occurs, locate the possible cause and take necessary measures, referring to the instructions in 6-4-1, "Classification of Troubles". BEFORE STARTING INSPECTION, CHECK AC POWER SUPPLY VOLTAGE AND DC POWER SUPPLY VOLTAGE ON PCB AS INDICATED IN TABLE 6-3.

Table 6-3

Confirmation of AC Power Voltage	Confirm between Input Terminals R, S, T, and G		
Confirmation of DC Power Voltage on the Printed Circuit Board	Voltage	Check Terminals (across)	Rated Value
	+24 V	+24 and \emptyset V	Approx. 25 V \pm 10% Approx. 0.5 V of ripple
	+15 V	+15 and \emptyset V	+15 V \pm 4% (not adjustable)
	+ 5 V	+ 5 and \emptyset V	+5 V \pm 1% (adjust by RV15)
	-15 V	-15 and \emptyset V	-15 V \pm 4% (not adjustable)

6-4-1. Classification of Troubles

Table 6-4

No.	Trouble	Reference Item
1	POWER ON indicator (PIL) does not turn on.	(1)
2	Alarm indicator on the printed circuit board is on.	(2)
3	Motor does not rotate, or its speed is not as commanded.	(3)
4	Excessive vibration and noise while motor runs.	(4)
5	Noise during deceleration.	(5)
6	Motor speed overshoots or hunts.	(6)
7	Low cutting performance.	(7)
8	Spindle orientation cannot be correctly performed.	(8)
9	Long acceleration and deceleration time.	(9)

(1) POWER ON INDICATOR "PIL" DOES NOT TURN ON.

Table 6-5

No.	Problem	Inspection	Remedy
1	No AC power supply	Check supply voltage between terminals R, S and T.	
2	Fuse F4 is blown.	See Appendix 1.	Replace F4 (5 A).
3	Any of fuses AF1, AF2 and AF3 is blown.	Check if warning indication of fuse AF1, AF2 or AF3 is visible. Refer to Appendix 1.	Replace the blown fuse, AF1, AF2, or AF3. If the new fuse is blown, replace the printed circuit board.
4	Connectors CN6 and CN7 for the printed circuit board are not inserted properly.	Check to be sure that the recess on the connector guide can be seen at the surface of the connector on the printed circuit board.	Insert them properly.
5	No output voltage at terminals 19A and 19B due to faulty transformer.	Measure the voltage across the following check terminals on the printed circuit board: 19A and CT 19B and CT Normal voltage across the terminals 19A and CT, and 19B and CT is approx. 19 V AC.	Replace transformer TF.
6	Power supply circuit on the printed circuit board is defective.	Since the indicator PIL is lighted by the voltages, +5 V and -15 V, check the power supply voltage referring to Table 6-3.	Replace the printed circuit board.

(2) ALARM INDICATOR ON THE PRINTED CIRCUIT BOARD IS ON

Alarm indication is made by four LEDs (Light Emitting Diodes) on the printed circuit board in hexadecimal coded numbers as indicated in Table 6-6.

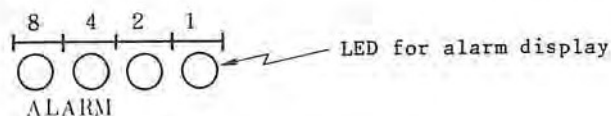


Table 6-6 Contents of Alarm

No.	Alarm Display (o: lights up)				Contents of Alarm
	8	4	2	1	
1				o	Motor has overheated. (Termostat has activated.)
2			o		Excessive servo error
3			o	o	Fuse F7 in the DC line has blown.
4		o			Any of fuses F1, F2 and F3 in the AC line has blown.
5		o		o	Fuse AF1, AF2 or AF3 on the printed circuit board has blown.
6		o	o		Motor speed exceeded the rated max. speed. (Analog system detection: 13% TYP)
7		o	o	o	Motor speed exceeded the rated max. speed. (Digital system detection: 11%)
8	o				Power voltage (+24 V) is too high.
9	o			o	Radiator for power semiconductor has overheated.
10	o		o		Power supply voltage of +15 V has dropped abnormally.
11	o		o	o	Voltage at the DC capacitor has risen abnormally.
12	o	o			Over current at DC capacitor
13	o	o		o	CPU alarm
14	o	o	o		ROM is not mounted properly.

a) Alarm No. 1: Motor Overheat

No.	Problem	Inspection	Remedy
1	Failure of the fan motor in the motor.	Check if the fan motor rotates.	Replace the fan motor.
2	Overload	Confirm the reading of the load meter.	Examine the cutting conditions or tools.
3	Contaminated motor cooling system		Clean it by the compressed air or vacuum cleaner.
4	Wrong connection	Check the connection between the motor and the servo unit.	

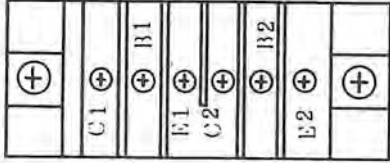
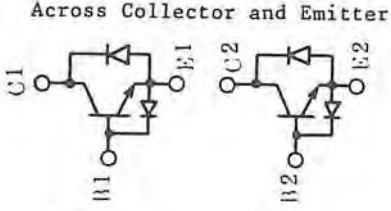
b) Alarm No. 2: Excessive Servo Error

No.	Problem	Inspection	Remedy
1	Overload	Confirm the reading of the load meter.	Examine the cutting conditions or tools.
2	Poor contact of the connector	Check the connection between CN2 and motor connector.	
3	Malfunction of torque limiter	Confirm the reading of the load meter.	Replace the printed circuit board.
4	Failed speed feedback signal		Replace the printed circuit board.

c) Alarm No. 3: Fuse (F7) in the DC line has blown.

If the fuse (F7) in the DC line has blown, the power transistor module may be faulty. Check the faulty element and replace it with new one according to the following procedure. If the power transistor module is damaged possibly, caused by a problem in the control printed circuit board, it is also recommended to replace the printed circuit board.

Step	Procedure
1	After turning the AC power supply OFF (i.e., turn the main circuit breaker OFF), disconnect the power line to the motor.

Step	Procedure				
2	<p>Measure the resistance between the collector and emitter, and collector and base of the transistor module using a multitester (setting: $\times 10 \Omega$ range).</p> <div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="text-align: center;"> <p>Across Collector and Base</p>  </div> <div style="text-align: center;"> <p>Across Collector and Emitter</p>  </div> </div> <div style="text-align: center; margin-top: 10px;"> <p>Terminals of Transistor Module</p> <table border="1" style="margin-left: auto; margin-right: auto;"> <tr> <td style="padding: 5px;">Acceptable</td> <td style="padding: 5px;">Unacceptable</td> </tr> <tr> <td style="padding: 5px;">Several hundred ohms</td> <td style="padding: 5px;">$0 \Omega - 10 \Omega$</td> </tr> </table> </div> <div style="text-align: right; margin-top: 10px;"> <p>C1, C2: Collector B1, B2: Base E1, E2: Emitter</p> </div>	Acceptable	Unacceptable	Several hundred ohms	$0 \Omega - 10 \Omega$
Acceptable	Unacceptable				
Several hundred ohms	$0 \Omega - 10 \Omega$				
3	<p>Replace the defective element. Be sure to apply silicon grease to the new one when replacing.</p>				
4	<p>After completing replacement, measure the resistance as per step 2.</p>				
5	<p>If the printed circuit board is possibly faulty, replace the printed circuit board.</p>				
6	<p>Connect the power line to the motor and replace Fuse F7; operation can be resumed now.</p>				

d) Alarm No. 4: Fuses (F1, F2 and F3) in the AC line have blown.

No.	Problem	Inspection	Remedy
1	<p>High impedance of the AC power supply (for example, two transformers are connected in series or a variable auto-transformer is connected.)</p>	<p>Alarm No. 4 takes place only while the motor is decelerating from high speed.</p> <p>Alarm No. 4 may take place although F1 to F3 are not blown.</p>	<p>Change to low impedance AC power supply.</p> <p>Tighten the connection of the input wire.</p> <p>Example: Phase loss due to loose connection</p>
2	<p>Defective power transistor module</p>	<p>Refer to c) Alarm No. 3.</p>	<p>Refer to c) Alarm No. 3.</p> <p>Replace the transistor module and fuse.</p>

No.	Problem	Inspection	Remedy
3	Defective diode module and/or thyristor module	Remove the connection from the diode modules DM1 to DM3 and thyristor modules SM1 to SM3, check the resistance between terminals A and K using the tester. (Defective elements are usually short circuited.)	Replace the defective elements. Replace the fuses.
4	Defective surge absorbers and capacitors	Check the surge absorbers Z1 to Z3 and the capacitors C4 to C6.	Replace the defective elements. Replace the fuses.

e) Alarm No. 5: Fuses AF1, AF2 and AF3 on the printed circuit board have blown.

No.	Problem	Inspection	Remedy
1	Defective printed circuit board	Check the AB input voltage. Refer to 6-5.	Replace the printed circuit board.
2	Supply voltage is not within the rated range.		

f) Alarm No. 6: Overspeed (Analog Detection System)

No.	Problem	Inspection	Remedy
1	Improper setting and adjustment of the printed circuit board	Check the setting and adjustment of the printed circuit board.	Check the setting of S5.
2	Defective ROM (Memory IC)		Replace ROM.
3	Defective printed circuit board		Replace the printed circuit board.

g) Alarm No. 7: Overspeed (Digital Detection System)

Inspect in the same manner as Alarm No. 6.

h) Alarm No. 8: Overvoltage at +24 V Terminal

No.	Problem	Inspection	Remedy
1	AC supply voltage is higher than the rated voltage by +10% or more.	Check the supply voltage.	Replace the printed circuit board.
2	Wrong setting of the toggle switch for voltage selection	Check the supply voltage.	Refer to Table 6-1 and confirm the proper voltage, either 200 V or 220 V.

i) Alarm No. 9: Radiator Overheat

No.	Problem	Inspection	Remedy
1	Defective cooling fan	Check if the cooling fan is not rotating.	Replace the cooling fan.
2	Overload	Confirm the reading of the load meter.	Examine the cutting conditions.
3	Radiator is contaminated by dust and dirt.		Remove dust and dirt off by compressed air or vacuum cleaner.

j) Alarm No. 10: Voltage Drop at +15 V Terminal

This alarm indicates large drop in AC supply voltage. (dropped by 15% or more with respect to the rated voltage)

k) Alarm No. 11: Overvoltage in the DC Line

No.	Problem	Inspection	Remedy
1	Fuse F5 or F6 has blown.	Check fuses F5 and F6 using a tester. If fuse F5 or F6 has blown, it is also recommended to examine the transistor module in the same manner as applied to Alarm No. 3.	Replace the blown fuse.
2	Large power source impedance		Examine the specification of AC power source. Refer to Table 6-1.
3	Defective printed circuit board		Replace the printed circuit board.

l) Alarm No. 12: Overcurrent in the DC Line

No.	Problem	Inspection	Remedy
1	Short-circuit at the output terminal or inside the motor	Check the connections.	
2	Defective power transistor module	If Alarm No. 12 persists right after it is reset, check the transistor module in the same manner as detailed in c) Alarm No. 3.	Replace the defective element.
3	Defective printed circuit board		Replace the printed circuit board.

m) Alarm No. 13: CPU Alarm

Replacement of the printed circuit board

n) Alarm No. 14: ROM Mounting Failure

(3) MOTOR DOES NOT ROTATE, OR ITS SPEED IS NOT AS COMMANDED.

No.	Problem	Inspection	Remedy
1	Examine the problem according to each condition	When rotation command is provided, alarm display on the printed circuit board of the spindle drive servo unit lights up. Alarm does not occur.	Refer to 6-6. To No. 2 and No. 3 below.
2	Faulty connection of the signal circuit	Check the connection of the signal line.	
3	Defective printed circuit board		Replace the printed circuit board.

(4) EXCESSIVE VIBRATION AND NOISE WHILE MOTOR RUNS

No.	Problem	Inspection	Remedy
1	Faulty motor		Replace the motor.
2	Defective printed circuit board		Replace the printed circuit board.

(5) NOISE DURING DECELERATION

Regenerative energy is returned to the power source through the regenerative circuit while motor is decelerating, but regenerative limit circuit is activated when the regenerative energy becomes too high, causing the waveform to be changed. This sometimes causes the noise of the motor.

Setting the variable resistor RV6 to the position smaller than the standard setting "3" by turning it counterclockwise can eliminate the noise. However, such setting results in a larger deceleration time.

(6) MOTOR SPEED OVERSHOTS OR HUNTS

No.	Problem	Inspection	Remedy
1	Faulty setting and adjustment of the printed circuit board	Turn RV12 (standard setting: "5") clockwise to increase the gain.	Readjust.
2	Spindle hunts.	Turn RV12 counterclockwise to decrease the gain.	Readjust.

(7) LOW CUTTING PERFORMANCE

No.	Problem	Inspection	Remedy
1	Torque limit command is provided.	Check the pertaining signal.	
2	Loose drive belts	Check the tension of the belts.	

(8) SPINDLE ORIENTATION CANNOT BE CORRECTLY PERFORMED.

No.	Problem	Inspection	Remedy
1	Defective printed circuit board of the speed gain switchover control circuit		Replace the printed circuit board.
2	Faulty adjustment of the spindle control circuit		Adjust the printed circuit board.

(9) LONG ACCELERATION AND DECELERATION TIME

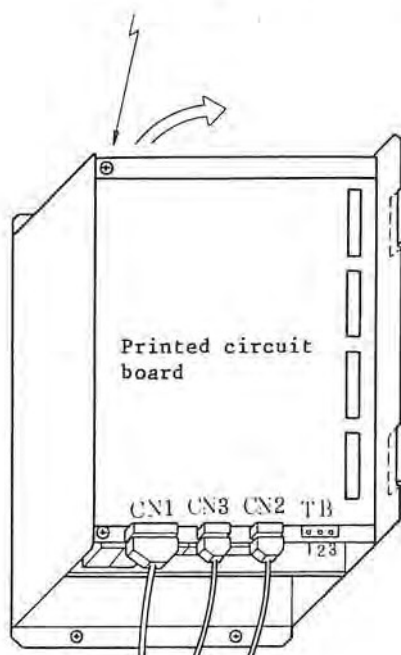
No.	Problem	Inspection	Remedy
1	Torque limit command is provided.	Check the pertaining signal.	
2	Faulty adjustment of the printed circuit board	Check the setting value of RV6. If it is set too small, longer decelerating time is required.	Readjust RV6.

6-5. FUSE REPLACEMENT

To replace fuses F2, F3, F4, F5, F6 and F7 inside the unit, it is necessary to open the cover plate of the unit, as shown in Fig. 6-1 below.

For Unit Models 3 and 6

Remove the two screws (upper and lower) and then open the cover plate by pulling the left side of it.



For Unit Models 8, 12 and 15

Remove the two screws (upper and lower) and then open the cover plate by pulling the left side of it.

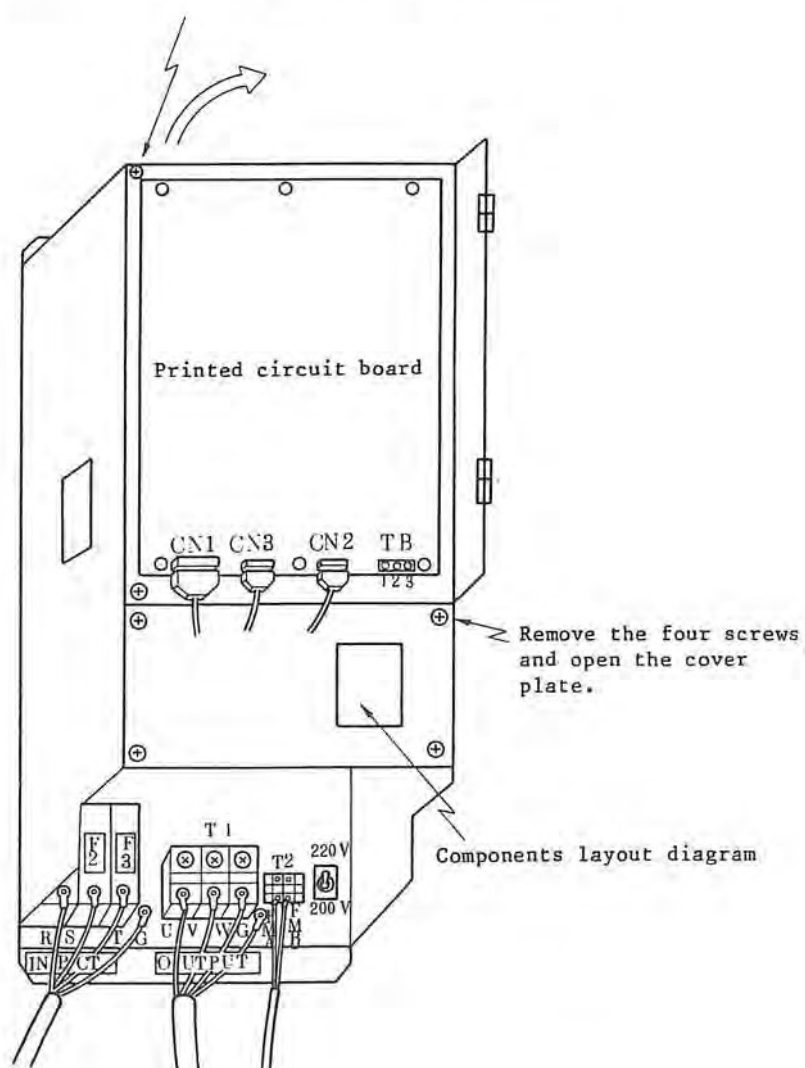


Fig. 6-1

6-6. SPARE PARTS

The following spare parts are attached to each model of the AC spindle drive unit.

Item	Type	Model 3	Model 6	Model 8	Model 12	Model 15	Model 18	Model 22
	Dwg. No.	A06B-6044 -K010	A06B-6044 -K011	A06B-6044 -K012	A06B-6044 -K013	A06B-6044 -K014	A06B-6044 -K015	A06B-6044 -K016
Fuse (50A)	A60L-0001-0147 (25FH50)	1	1					
Fuse (75A)	A60L-0001-0127 /25FH75	3	3					
Fuse (100A)	A60L-0001-0145 (25SH100)			4	1			
Fuse (140A)	A60L-0001-0149 (25SH140)				3	4	4	
Fuse (150A)	A60L-0001-0163 (25SH150)							4
Fuse (20A)	A60L-0001-0036 /PC1-20	2	2					
Fuse (30A)	A60L-0001-0036 /PC1-30			2	2	2		
Fuse (40A)	A60L-0001-0036 /PC2-40						2	2
Warning fuse S3.2A	A60L-0001-0075 /3.2	2	2	2	2	2	2	2
Warning fuse 3.2A	A60L-0001-0046 /3.2	1	1	1	1	1	1	1
Fuse (5A)	A60L-0001-0031 /5A	1	1	1	1	1	1	1
Surge absorber	A50L-2001-0062 /441-12	4	4	4	4	4		
Surge absorber	A60L-2001-0155 /20D431						5	5

6-7. COMPONENT LAYOUT ON SERVO UNIT

(1) Unit for models 3 and 6 (A06B-6044-C008)

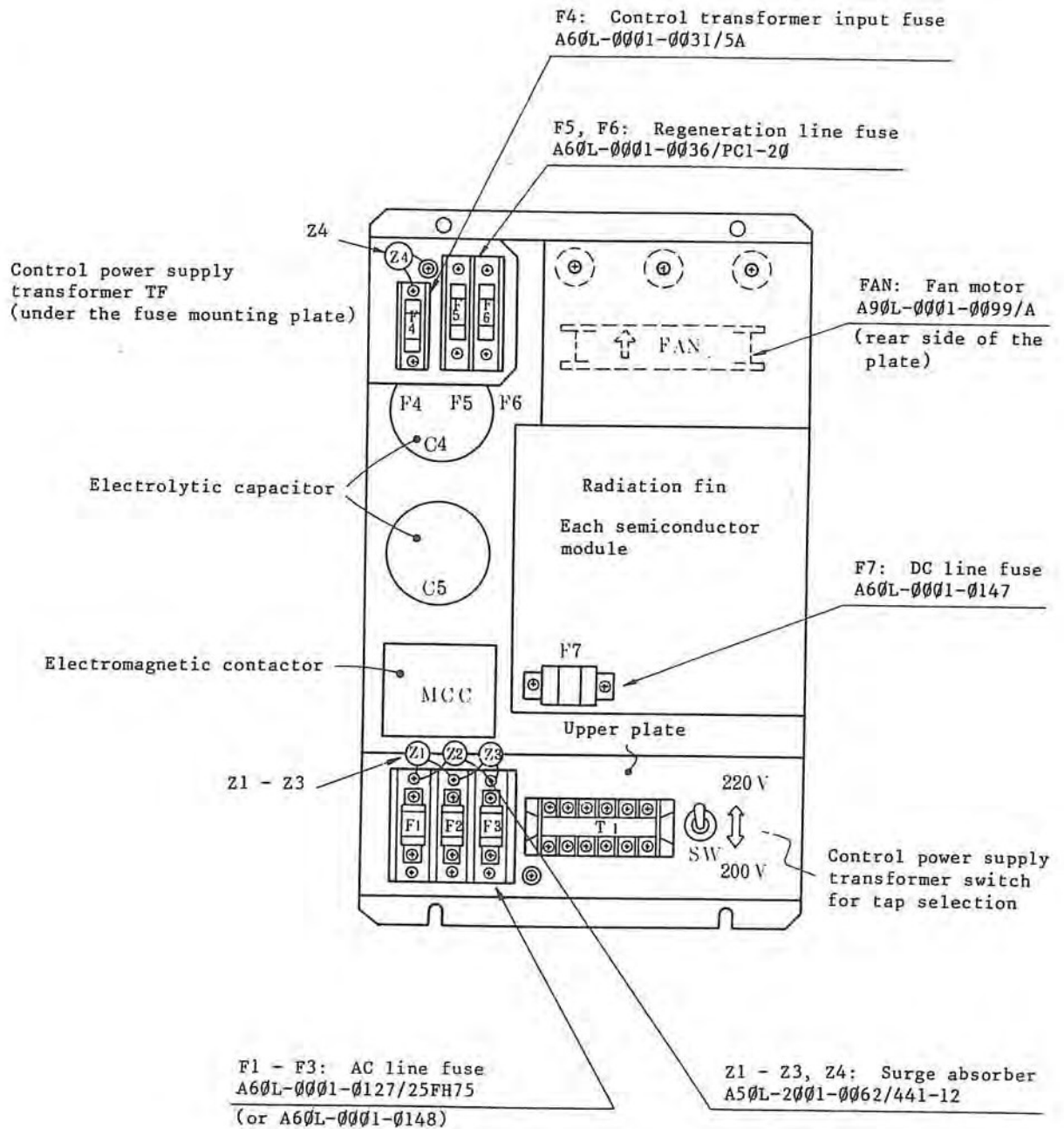


Fig. 6-2

(2) Unit for models 8 and 12 (6044-C009, C010)

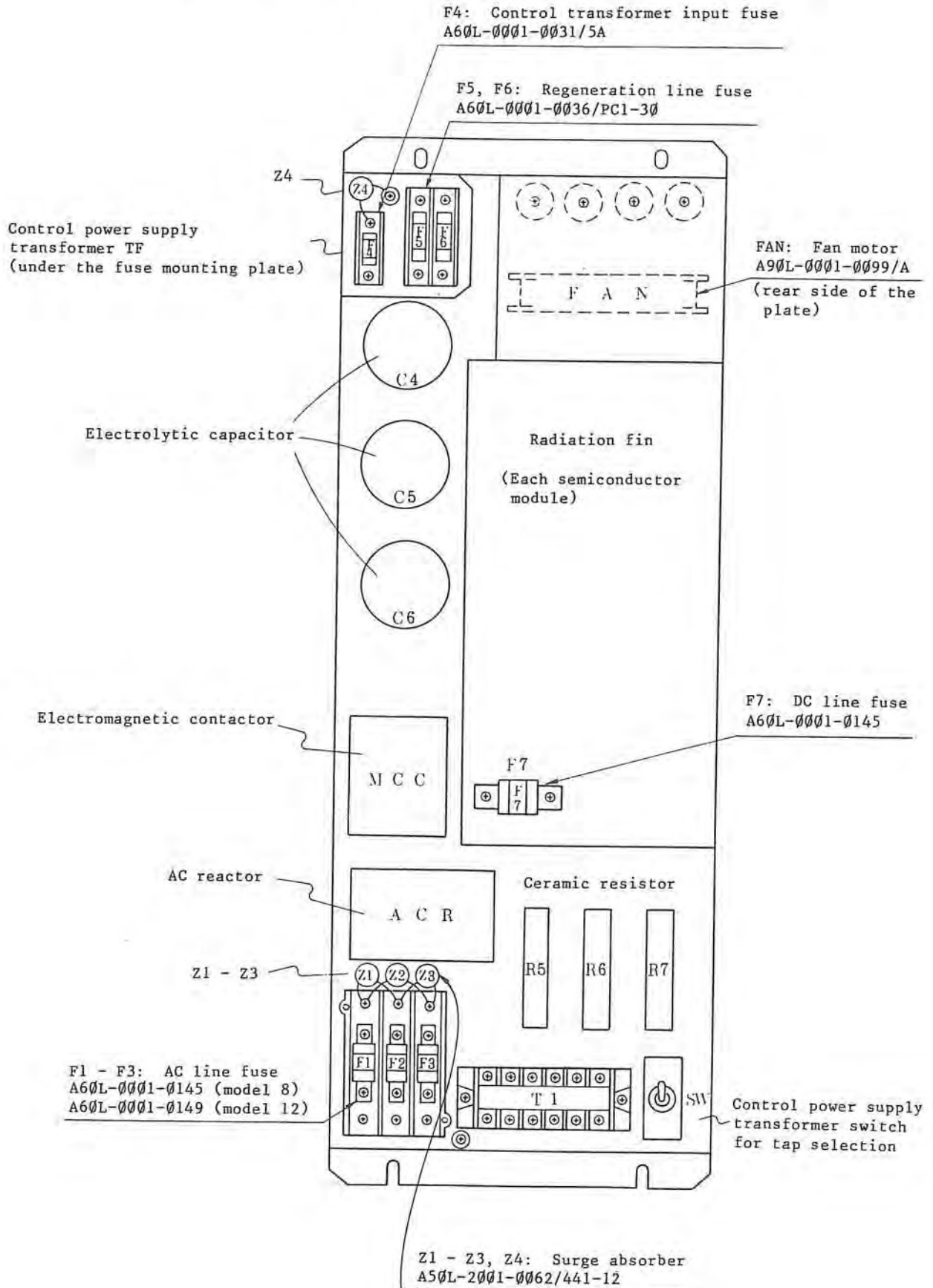


Fig. 6-3

(3) Unit for models 15 (A06B-6044-C011)

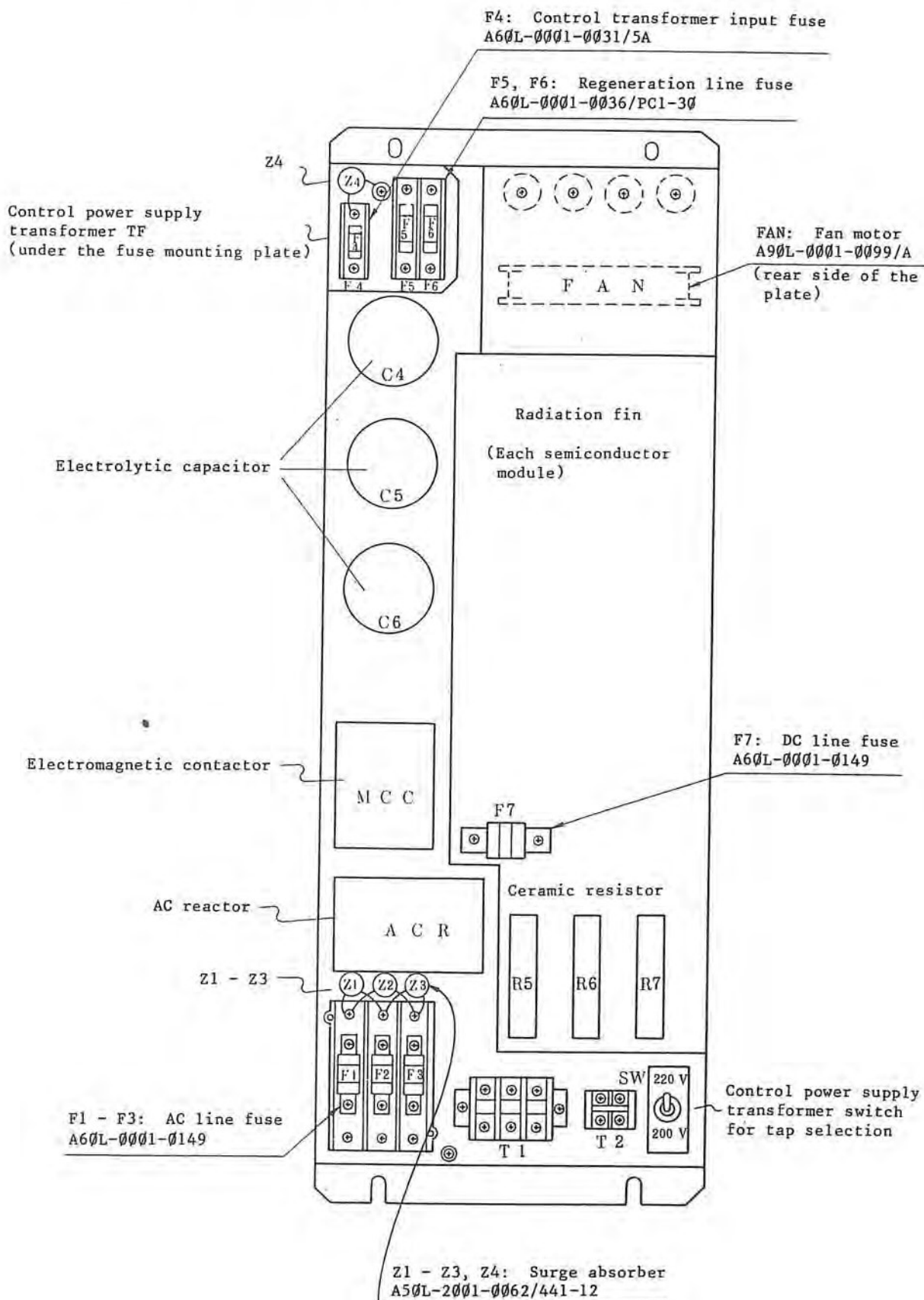


Fig. 6-4

6-9. PARTS LIST

(1) Fuses and Surge Absorbers

No.	Symbol	Item	Model				
			Model 3	Model 6	Model 8	Model 12	Model 15
1	F1 - 3	Fuse	A60L-0001-0127/25FH75		A60L-0001-0145	A60L-0001-0149	
2	F4	Fuse	A60L-0001-0031/5A				
3	F5, 6	Fuse	A60L-0001-0036/PC1-20		A60L-0001-0036/PC1-30		
4	F7	Fuse	A60L-0001-0147		A60L-0001-0145		A60L-0001-0149
5	Z1 - 4	Surge absorber	A50L-2001-0062/441-12				
6	AF1	Fuse protecting PCB	A50L-0001-0046/3.2 (3.2A)				
7	AF2, 3	Fuse protecting PCB	A60L-0001-0075/3.2 (3.2AS)				

(2) Other Main Parts

No.	Symbol	Item	Model				
			Model 3	Model 6	Model 8	Model 12	Model 15
1	P.C.B.	Printed circuit board	A20B-0009-0530	A20B-0009-0531	A20B-0009-0532	A20B-0009-0533	A20B-0009-0534
2	OM	Memory IC	J10	J11	J02	J03	J04
3	TM1 - 11	Transistor module	A50L-0001-0096				
4	SM1 - 3	Thyristor module	A50L-5000-0029/30		A50L-5000-0029/50		
5	DM1 - 3	Diode module	A50L-2001-0138		A50L-2001-0146		
6	D1 - 3	Diode	A50L-2001-0103/12JH11				
7	D4 - 6	Diode	A50L-2001-0103/12JG11				
8	D7	Diode	A50L-2001-0081/60				
9	D8	Diode	A50L-2001-0097/U06G				
10	C1 - 3	Capacitor	A42L-0001-0103				
11	MCC	Contacto	A58L-0001-0094/200V1A1B		A58L-0001-0092/A		
12	TF	Transformer	A80L-0001-0276				
13	FAM	Fan	A90L-0001-0099/A				
14	TH	Thermostat	A57L-0001-0028				
15	SW	Switch	A57L-0001-0030/2				

SECTION 7 SPINDLE DRIVE UNIT FOR VAC MOTOR (OKUMA MAKE)

7-1. OUTLINE

This manual is prepared for Okuma's VAC motors and VAC drive units. Okuma's VAC motors are built especially for driving machine tool spindles and feature high reliability, wide constant output range and compact construction.

Okuma's VAC drive units adopt the vector control method using a 16 bit microprocessor to promise excellent response and stable control.

7-2. MAINTENANCE AND INSPECTION

VAC motors and VAC drive units do not require special regular inspection. However, inspection and cleaning on the following points in every six months are recommended to maintain their designed performance.

However, if they are contaminated heavily, check them more frequently than specified.

Table 7-1 Inspection Items

Inspection Point	Inspection Procedure	Measures
VAC motor VAC drive unit Cooling fan Fan guard (screen) Ventilation holes	Check for dust and dirt accumulation.	Remove dust and dirt by compressed air or vacuum cleaner.

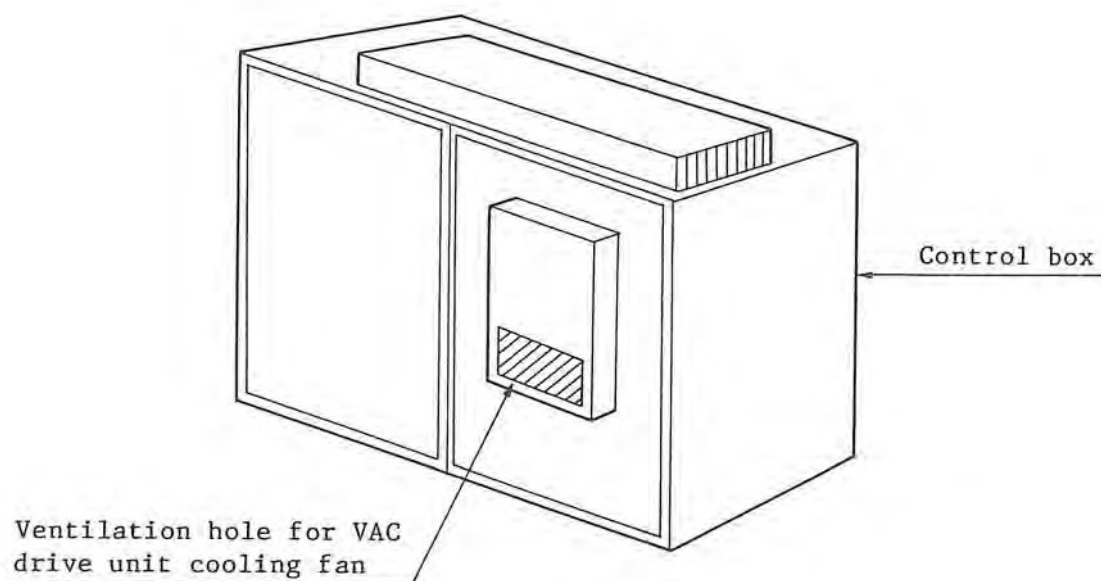


Fig. 7-1 VAC Drive Unit

7-3. TROUBLES AND TROUBLESHOOTING

7-3-1. VAC DRIVE UNIT CONSTRUCTION

Arrangement of parts which will require checkup when a problem has occurred is shown in Figs. 7-2, 7-3, 7-4 and 7-5.

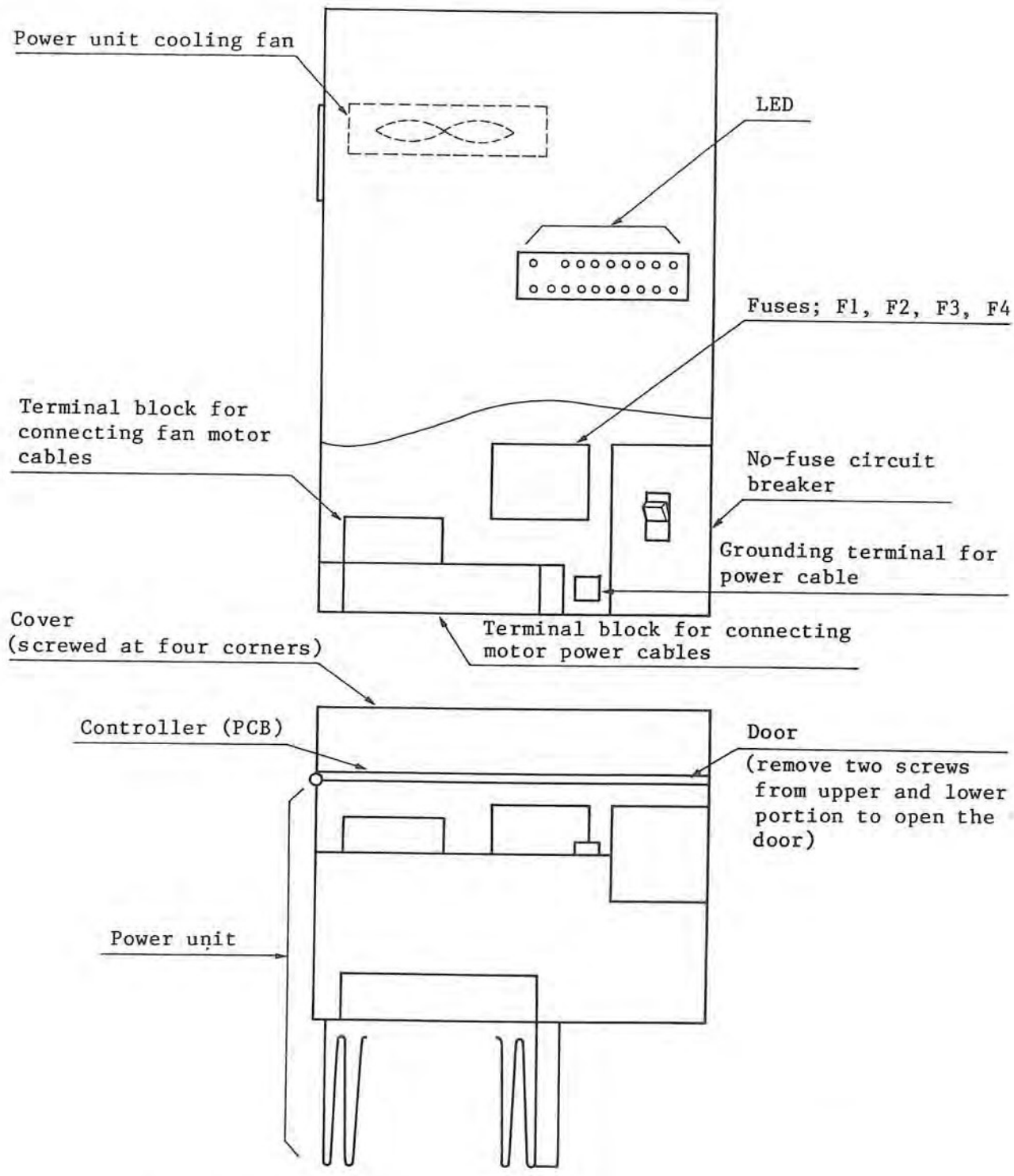


Fig. 7-2 Arrangement of Major Component Parts of D3/D6

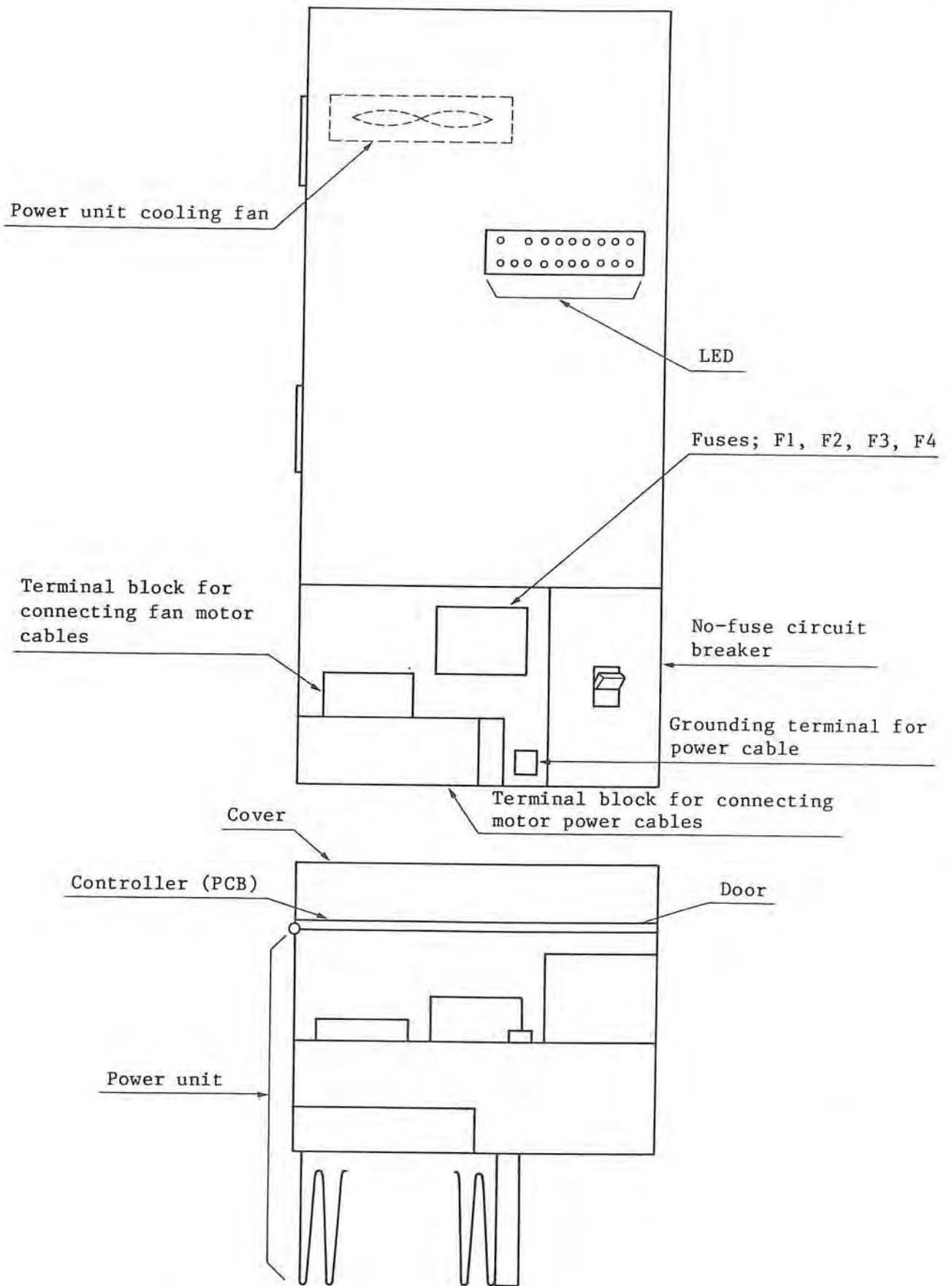


Fig. 7-3 Arrangement of Major Component Parts of D11

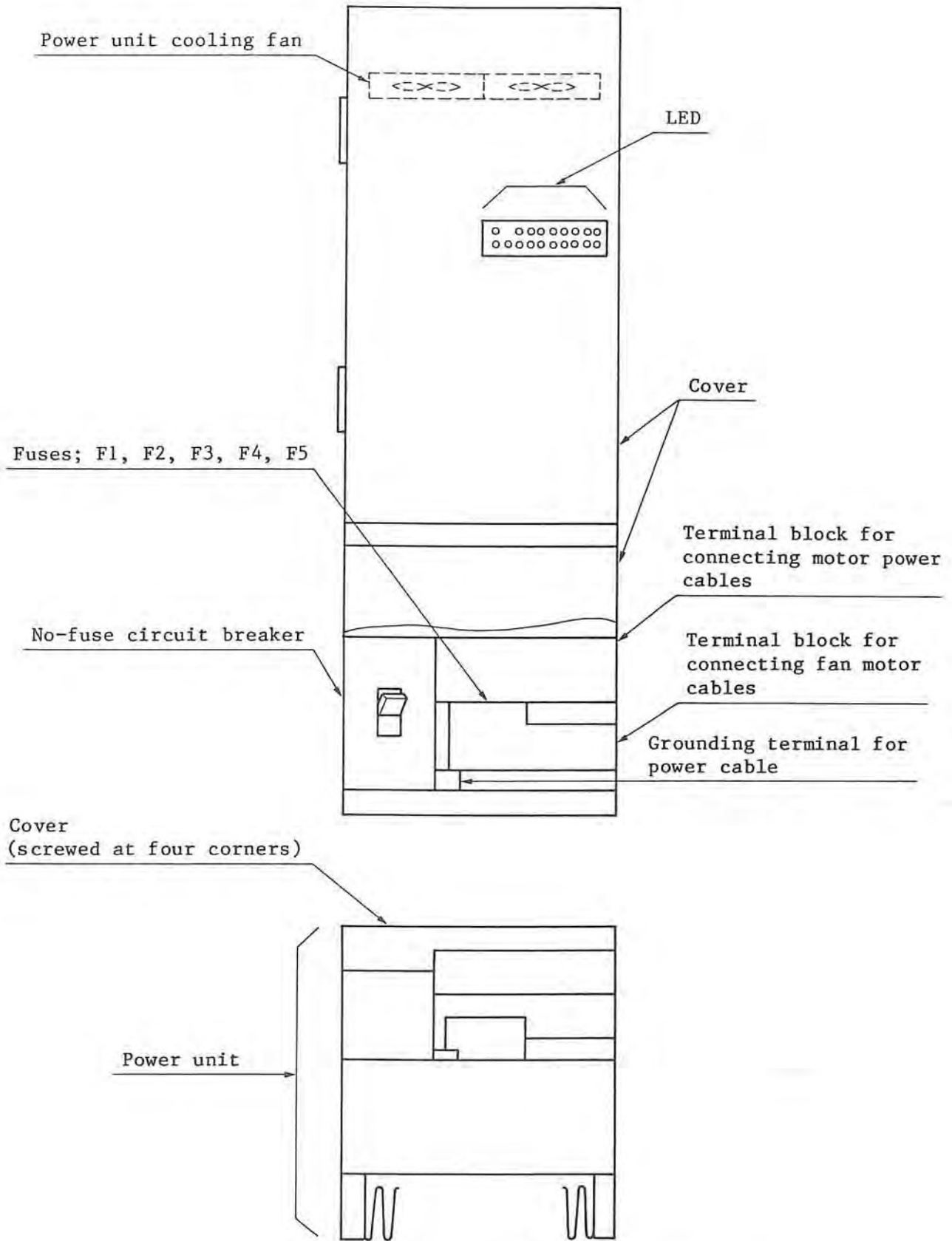


Fig. 7-4 Arrangement of Major Component Parts of D22

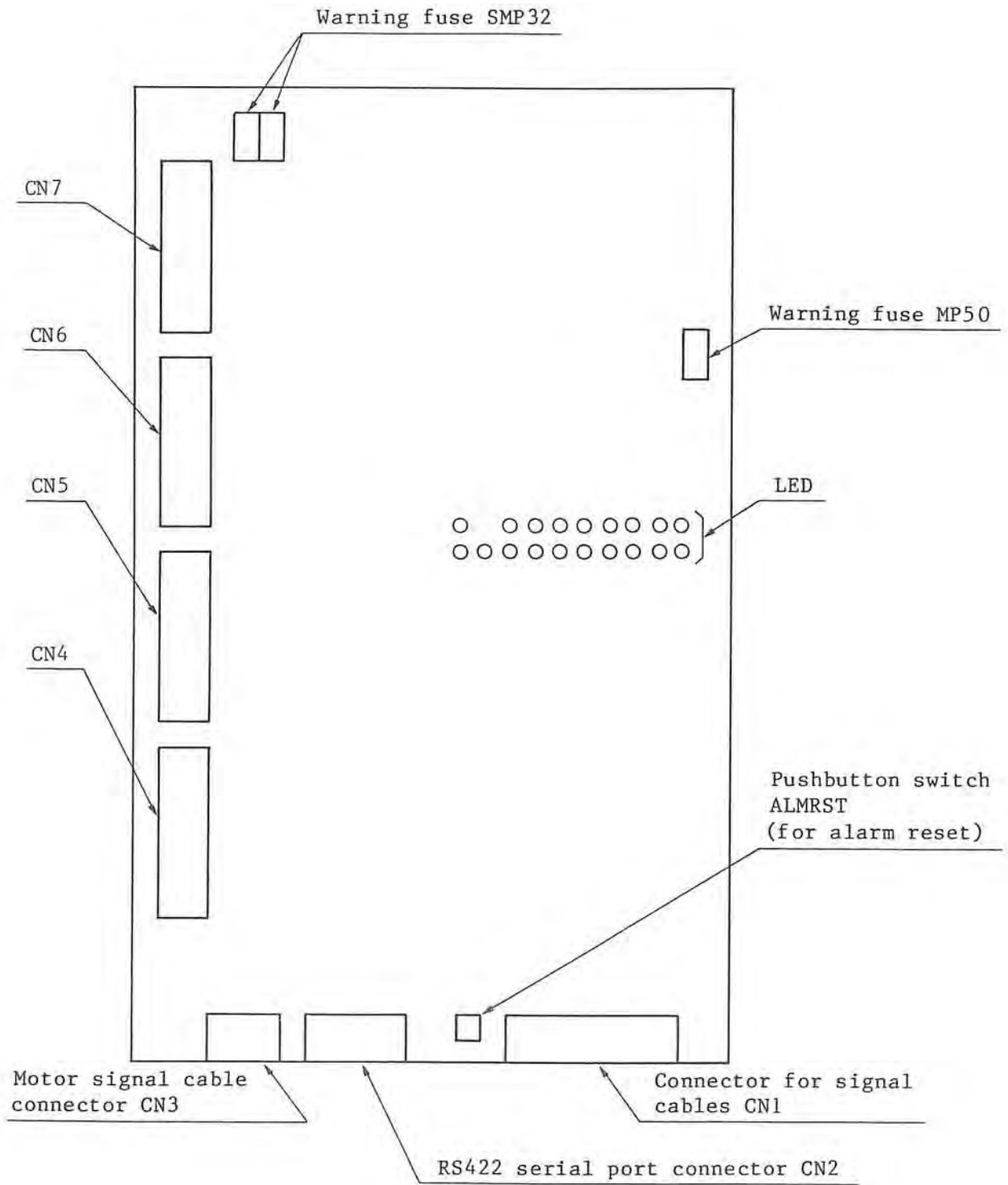


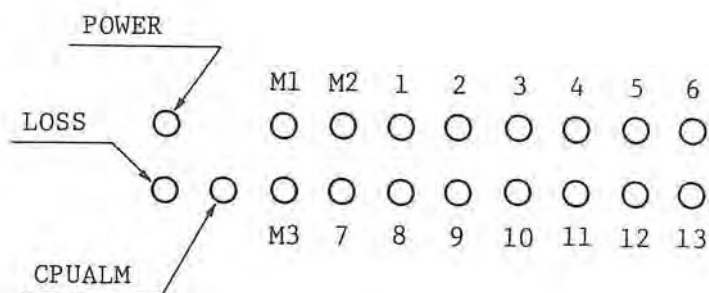
Fig. 7-5 Arrangement of Major Component Parts on Printed Circuit Board

7-3-2. OPERATION STATUS DISPLAY

Operation status of the VAC drive unit is indicated with the LED's at the PCB.

The LED's illuminating conditions can be observed through the hole in the cover (See Figs. 7-2, 7-3 and 7-4.).

LED's nomenclature is shown in Fig. 7-6.



Operation Indicating
LED's

Operation Status
Indicating LED's

Fig. 7-6 LED's Nomenclature

7-3-2-1. Operation Indicating LED's

These three LED's indicate the operation condition of the VAC drive unit. Functions of them are summarized in Table 3-1.

Table 7-2 Function of Operation Indicating LED's

LED Name	Color	Function	Remark
POWER	Green	Indicates that power supply for control circuit of the VAC drive unit is being supplied.	If this LED is OFF while power supply to the VAC drive unit is ON, it indicates failure of the unit.
LOSS	Red	Indicates that voltage being applied to the operation circuit in the VAC drive unit is outside the specification.	If this LED lights up, it indicates that the operation circuit is not functioning correctly.
CPUALM	Red	Indicates that the operation circuit in the VAC drive unit is faulty.	Contents of failure are indicated by the operation status indicating LED's.

7-3-2-2. Operation Status Indicating LED's

A total of 16 LED's are used to indicate the operation status of the VAC drive unit and the VAC motor. There are two operation status indication modes such as "failure operation status indication" and "normal operation status indication".

Under the failure operation status:

- a) LED's M1 and M2 flash at the same time
- b) LED M1 lights up
- c) LED M2 lights up

Other LED's light up corresponding to the failure conditions to indicate the contents of failure.

In any of these cases, normal operation of the VAC drive unit and the VAC motor is impossible.

Table of failure operation status indications is given in Table 7-3.

Figs. 7-7, 7-8 and 7-9 indicate the contents of failure.

Under the normal operation status:

The LED's indicate the input/output conditions of the input/output signals.

Fig. 7-10 shows the contents of indication. Input/output signals are explained in Section 7-6.

Table 7-3 LED Lighting Conditions when Failure Occurs

LED Lighting Conditions				Contents of Failure		
M1	M2	M3	Failure Cause Indicating LED			
Flash	Flash	OFF	1	RES	Resolver faulty	
			2	AD	A/D access error	
			3	PAR	RAM parity error	
			4	ACC	Microcomputer access error	
			5	LOOP	INT6 loop error	
			6	WDOG	Watch dog error	
		ON	ON	7	IOCM	Overcurrent of power transistor
				8	IOCS	Short of power transistor
				9	IOCR	Short of power transistor at regeneration unit
				10	OV	Over-voltage
				11	UV	Under-voltage
				12	PH	Phase loss
				13	LOSS	Loss of power supply at operation circuit
ON	OFF	OFF	1	OS	Over-speed	
			2	READ	Speed command read error	
			3	UVP	Power circuit under-voltage	
			4	RAER	RAM faulty	
			5	DSE	DIP switch setting error	
			7	LOOP4	INT4 loop error	
			8	LOOP1	INT1 loop error	
OFF	ON		1	OH	Heat sink over-heat	
			2	OL	Motor over-load	

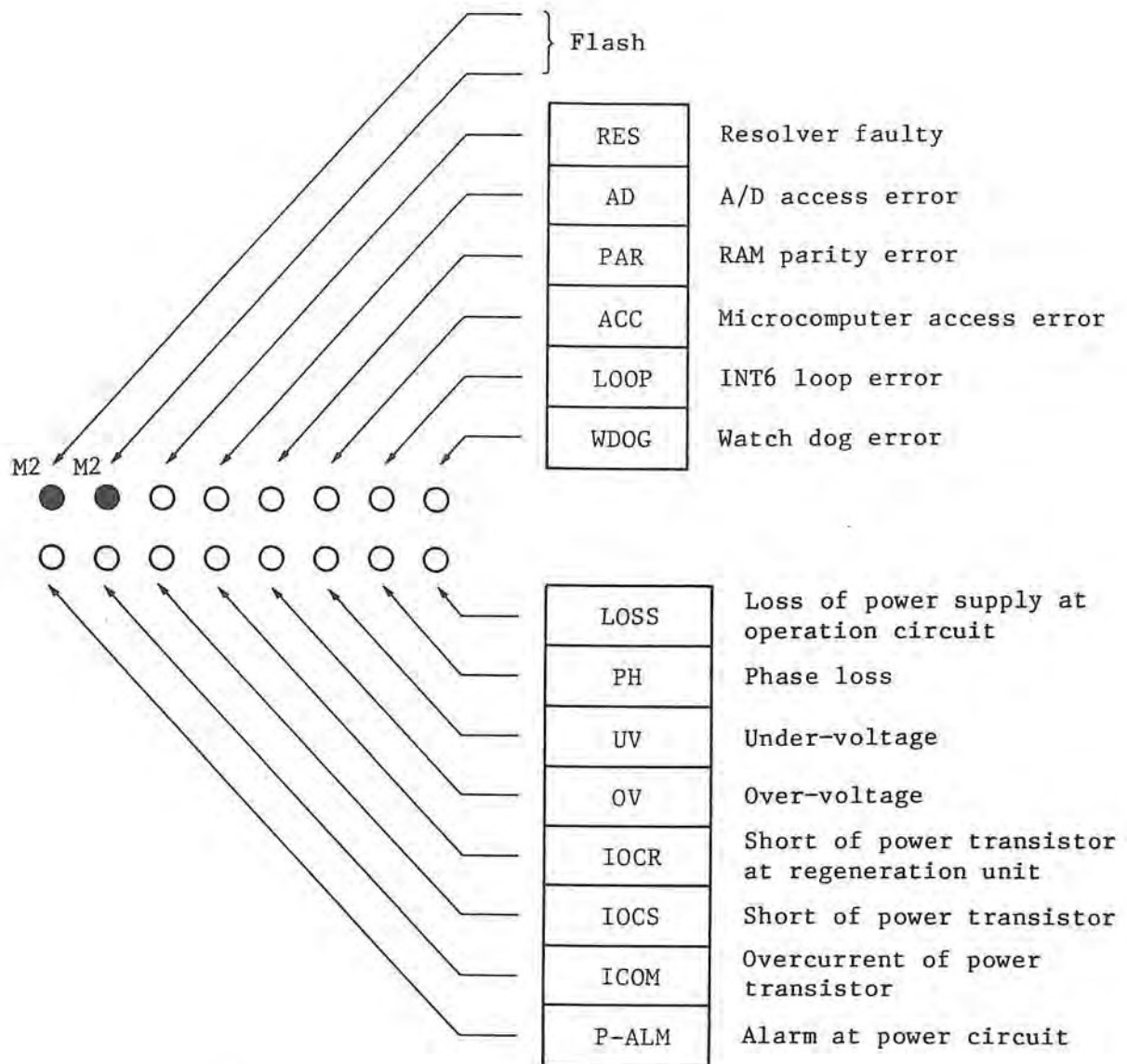


Fig. 7-7 Failure Indication by LED
(with M1 and M2 LED's flashing)

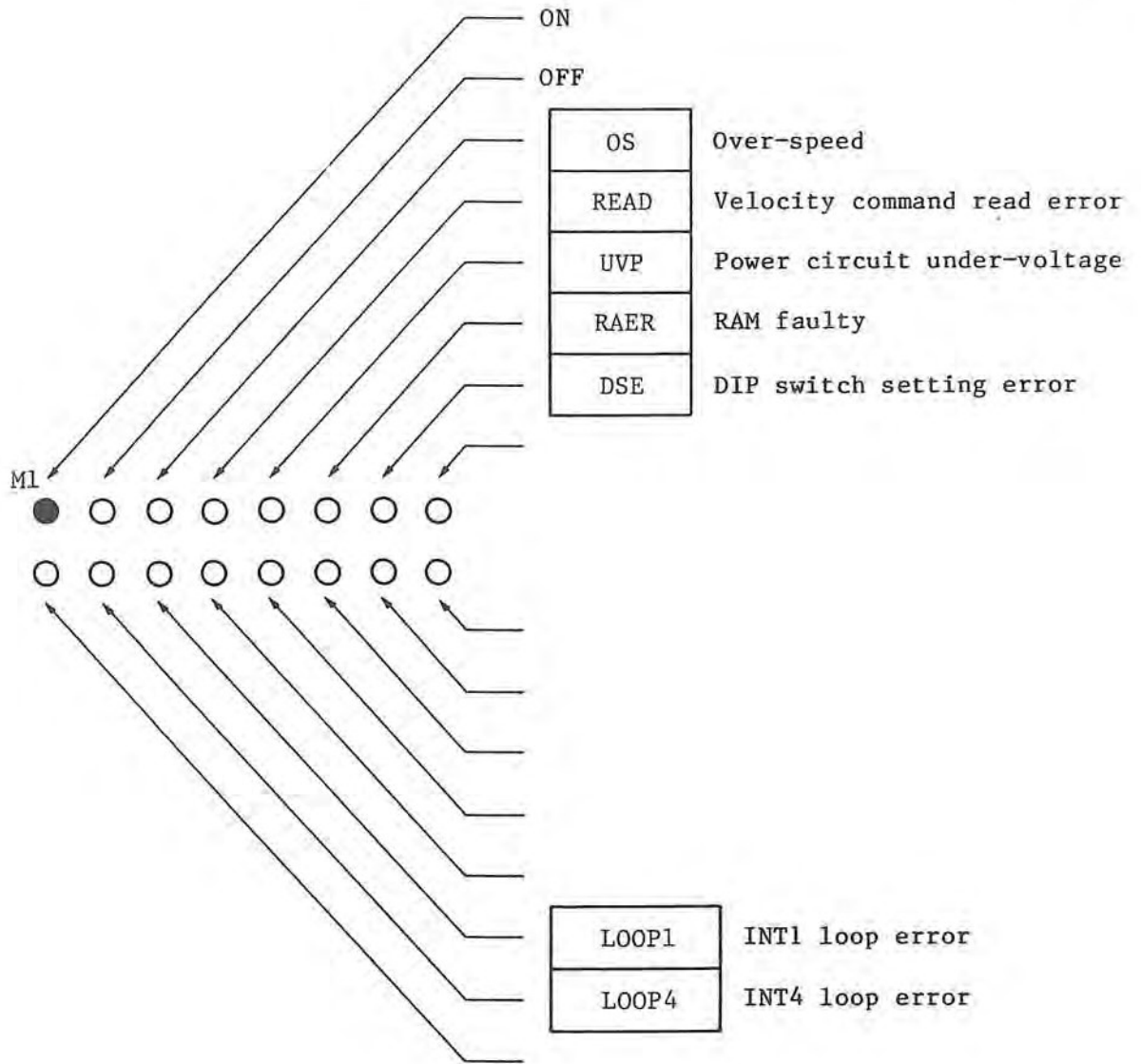


Fig. 7-8 Failure Indication by LED (with M1 ON)

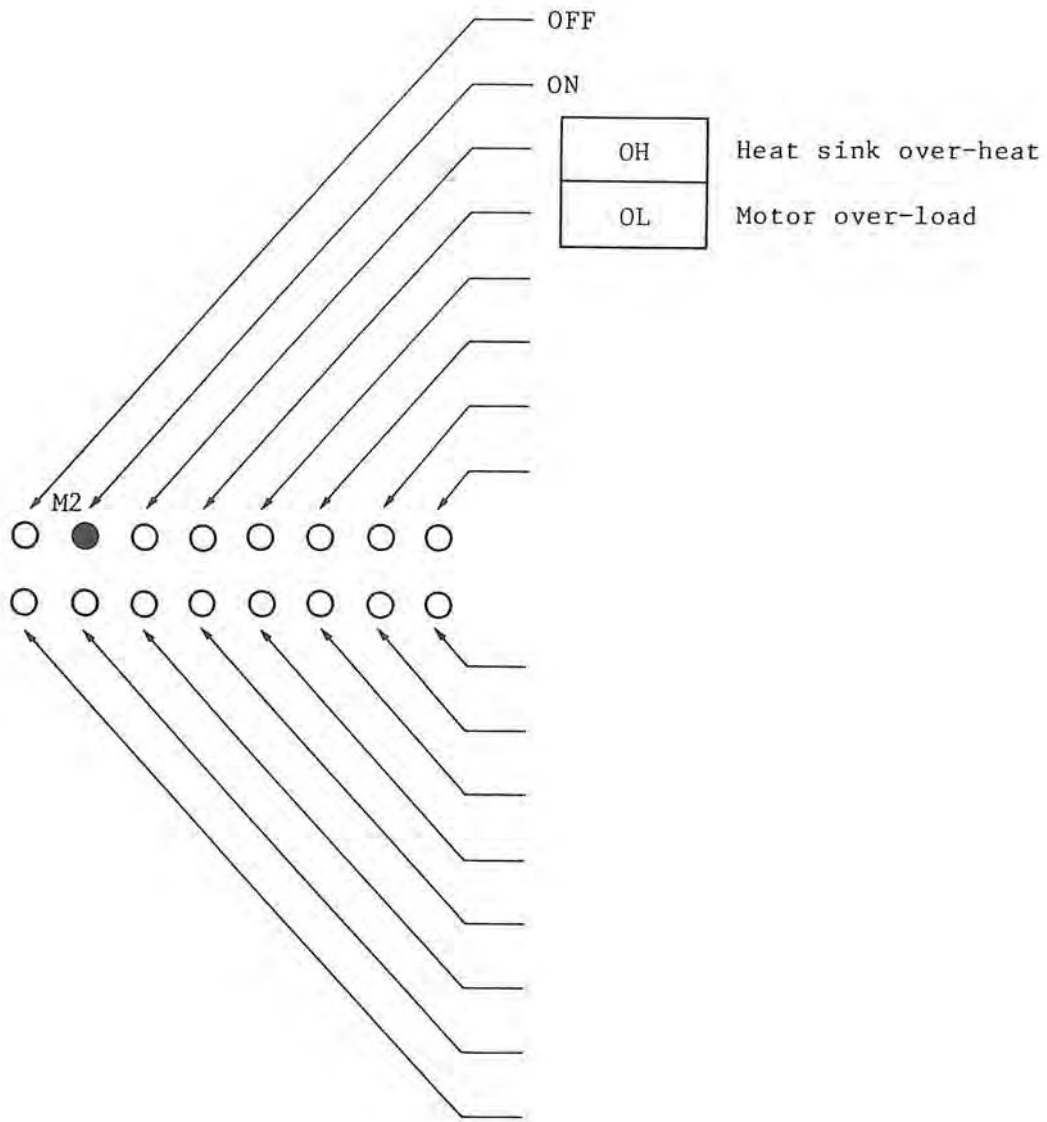


Fig. 7-9 Failure Indication by LED (with M2 ON)

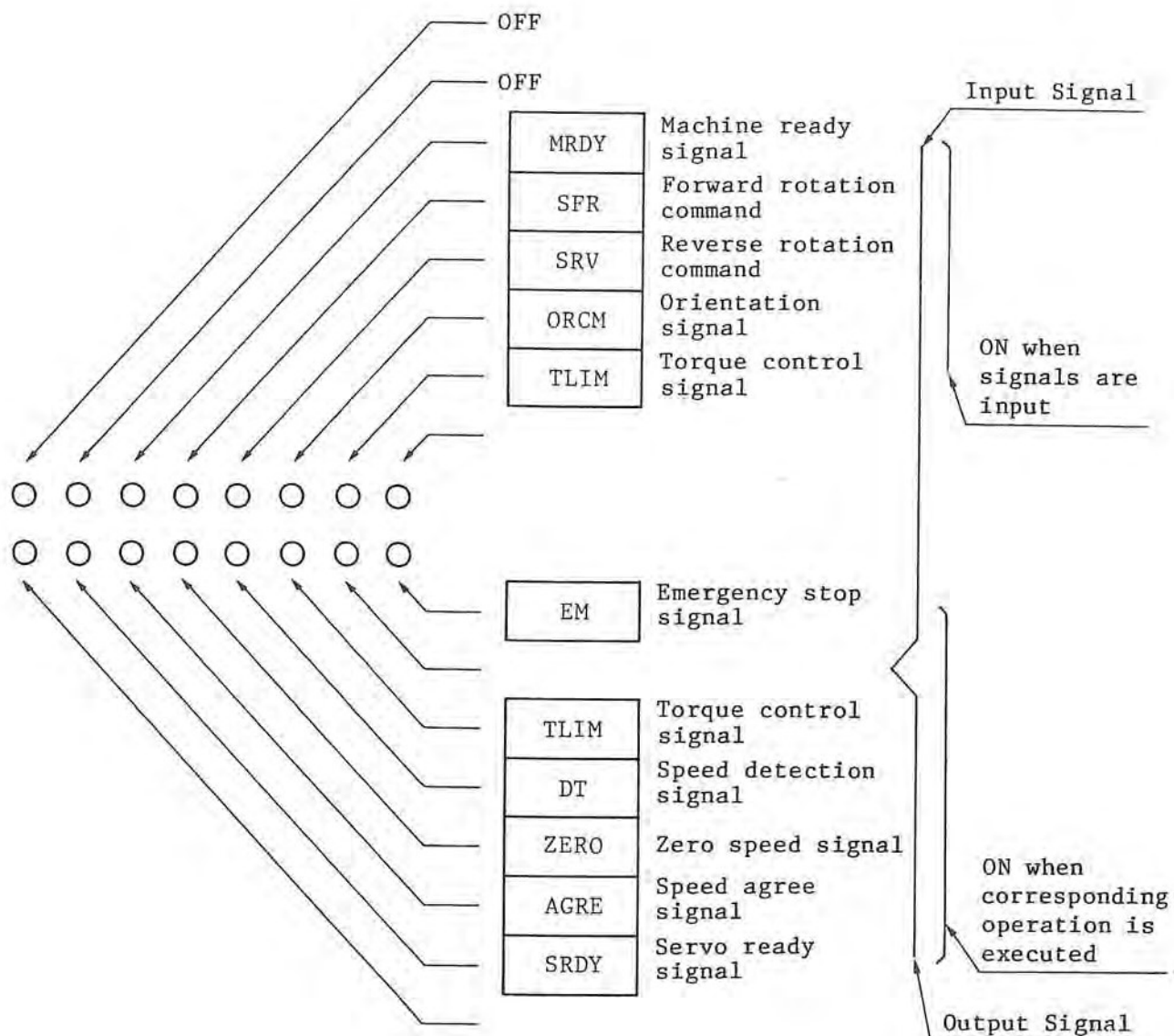


Fig. 7-10 Signal Indicated by LED during Normal Operation Status

7-3-3. MEASURES TO TAKE

Measures to take after an occurrence of failure are explained in 7-3-3-1 and 7-3-3-2. Arrangement of component parts is shown in Section 7-3-1.

Since high voltage is applied to the VAC drive unit, first record the number of LED illuminating and turn off power supply to the VAC drive unit before attempting to touch inside the unit.

7-3-3-1. Confirmation of Power Supply, Connectors and Signals

Before proceeding to checkups and taking necessary measures as explained in 7-3-3-2, check power supply, connectors and signals in accordance with Table 7-4.

Table 7-4 Confirmation of Power supply, Connectors and Signals

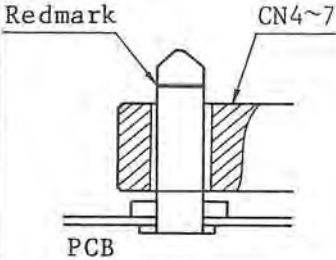
Item	Confirmation	Measures
Power supply	Measure input voltage at input terminals R, S and T of no-fuse breaker to make sure that input voltage is within the allowable range. Allowable input voltage range: AC 3-phase, 170 - 240V 50/60 Hz 1%	Make necessary adjustments so that input voltage is within the specified range.
Connectors	Make sure that MR connectors (CN1 through CN3) are securely clamped in place with screws. Make sure that red mark of the connector guide is at the front side of the PCB side connector (for PCB connectors CN4 through CN7).	Correct connection. 
Signal	When the LED's are indicating normal operation conditions, make sure that the LED's light up corresponding to the input signals.	Refer to Table 7-5.

Table 7-5 Measures to Take when LED Fails to Turn ON
in Response to Input Signals

Cause of Failure	How to Check	Measures
Open of control signal circuit	Disconnect the signal cables and carry out continuity check.	Replace the control signal cable.
Cause of failure lies at the machine side	Refer to the operation manual for the machine.	Refer to the operation manual for the machine.
Others	Make sure that all items above are correct.	Contact your local Okuma service representative.

7-3-3-2. Classification of Failure Occurrence Conditions and Measures

When a failure occurs, take measures following the steps indicated in Table 7-6.

For the confirmation of fuses, refer to Section 7-4, "Fuse Replacement".

Note that locations and the number of fuses used in type D22 VAC drive unit differ from other types of VAC drive units. Therefore, for type D22, change the information related with the fuse numbers as indicated below:

Fuses F1 and F2	—————>	Fuses F1, F2 and F3
Fuses F3 and F4 (D3, D6, D11)	—————>	Fuses F4 and F5 (D22)

Table 7-6 Classification of Failures

Failure	Reference Item
POWER LED does not light up.	(1)
LOSS LED lights up.	(1)
LED's show failure occurrence condition.	(2)
Commanded motor speed cannot be obtained.	(3)
Motor does not rotate.	(3)
Low cutting performance	(4)
Long acceleration and deceleration time	(5)
Spindle orientation cannot be correctly performed.	(6)
Excessive vibration and noise while the motor is rotating	(6)
Others	(6)

(1) POWER LED does not light up.

LOSS LED lights up.

Table 7-7

Cause of Failure	How to Check	Measures
Input power supply is abnormal.	Refer to Table 7-4.	Refer to Table 7-4.
Fuse F3 or F4 is blown.	Check the fuses whether they have been blown or not.	Replace blown fuse, F3 or F4. (Refer to Figs. 7-2, 7-3, 7-4 and 7-5.)
Warning fuse SMP32 or MP50 is blown.		
Connector CN7 for the printed circuit board is not inserted properly.	Check to be sure that the red mark on the connector guide can be seen at the surface of the connector on the printed circuit board.	Insert the connector properly.
Others	Make sure that all the items above are correct.	Contact your local Okuma service representative.

(2) LED's show failure occurrence condition.

If the LED's are indicating the failure occurrence status, first check the contents of failure and follow the measures as indicated in Table 7-8.

Table 7-8

Contents of Failure	Reference Item	Contents of Failure	Reference Item
RES	(a)	PH	(e)
AD	(b)	LOSS	(f)
PAR		OS	(g)
ACC		READ	
LOOP		UVP	(h)
WDOG		RAER	(i)
IOCM	(c)	DSE	
IOCS	(d)	LOOP4	
IOCR		LOOP1	
OV		OH	(j)
UV	(e)	OL	(k)

Remarks: If the LED which does not correspond to the failure content indicated lights up, follow the steps indicated in (1).

a) **RES** lamp is ON.

Table 7-9

Cause of Failure	How to Check	Measures
Loose connection of the connectors of motor signal cables.	Check whether connector CN3 and the connector in the VAC motor terminal block are inserted properly.	Insert them properly.
Open of motor signal circuit	Disconnect the signal cables and carry out continuity check.	Replace the control signal cable.
Others	Make sure that all items above are correct.	Contact your local Okuma service representative.

b) **AD**, **PAR**, **ACC**, **LOOP** or **WDOG** lamp is ON.

Contact your local Okuma service representative.

c) **IOCM** lamp is ON.

Table 7-10

Cause of Failure	How to Check	Measures
Loose connection of motor power cables at terminal block	Check motor power cable connection at the terminal block of the motor and the VAC drive unit.	Connect the cables correctly.
Motor power cables are broken.	Check continuity.	Replace the cables.
Others	Make sure that all items above are correct.	Contact your local Okuma service representative.

d) **IOCS**, **IOCR** or **OV** lamp is ON.

Contact your local Okuma service representative.

e) **UV** or **PH** lamp is ON.

Table 7-11

Cause of Failure	How to Check	Measures
Input power supply is abnormal.	Refer to Table 7-4.	Refer to Table 7-4.
No-fuse breaker is in the OFF position.	Check the no-fuse breaker.	Turn the no-fuse breaker ON.
Connector CN6 for the printed circuit board is not inserted properly.	Refer to Table 7-4.	Insert them properly.
Others	Make sure that all the items above are correct.	Contact your local Okuma service representative.

f) **LOSS** lamp is ON.

Follow the measures as indicated in Table 7-7.

g) **OS** or **READ** lamp is ON.

Contact your local Okuma service representative.

h) **UVP** lamp is ON.

Follow the measures as indicated in Table 7-11.

i) **REAR**, **DSE**, **LOOP4** or **LOOP1** lamp is ON.

Contact your local Okuma service representative.

j) OH lamp is ON.

Table 7-12

Cause of Failure	How to Check	Measures
Fuse F1 or F2 is blown.	Check the fuses whether they have been blown or not.	Replace the blown fuse, F1 or F2.
Cooling fan and heat sink are contaminated by dust and dirt.	Check contamination of the coolant fan, heat sink, etc.	Remove dust and dirt by compressed air or vacuum cleaner.
Overload	Confirm the reading of the load meter.	Examine the cutting conditions.
Connector CN5 for the printed circuit board is not inserted properly.	Refer to Table 7-4.	Insert the connector properly.
Input power supply is abnormal.	Refer to Table 7-4.	Refer to Table 7-4.
Others	Make sure that all the items above are correct.	Contact your local Okuma service representative.

k) OL lamp is ON.

Table 7-13

Cause of Failure	How to Check	Measures
Overload	Confirm the reading of the load meter.	Examine the cutting conditions.
Cooling fan, fan guard, and ventilating holes are contaminated by dust and dirt.	Check contamination of the cooling fan, fan guard, ventilating holes, etc.	Remove dust and dirt by compressed air or vacuum cleaner.
Loose connection of fan motor cables at terminal block.	Check fan motor cable connection at the terminal block of the motor and the VAC drive unit.	Connect the cables correctly.
Fan motor cables are broken.	Check continuity.	Follow the measures as indicated in Table 7-9.
Others	Make sure that all the items above are correct.	Contact your local Okuma service representative.

- 1) The LED which does not correspond to the failure content indicated lights up.

Contact your local Okuma service representative.

- (3) Commanded motor speed cannot be obtained, motor does not rotate.

Motor does not rotate.

Table 7-14

Cause of Failure	How to Check	Measures
Drive unit and motor are faulty.	When rotation command is issued, the LED's at the printed circuit board light up indicating the failure status.	Refer to item (2).
Failure with the control signal cables or with the machine	Check whether the LED's at the printed circuit board light up in response to the input contact signal when rotation command is issued.	Refer to Table 7-5.
Others	Make sure that all items above are correct.	Contact your local Okuma service representative.

- (4) Low cutting performance

Table 7-15

Cause of Failure	How to Check	Measures
Torque limit command is provided.	Check the pertaining signal. TLIM lamp lights up. (Fig. 7-10)	
Loose drive belts	Check the tension of the belts.	Replace the belt.

(5) Long acceleration and deceleration time

Table 7-16

Cause of Failure	How to Check	Measures
Torque limit command is provided.	Check the pertaining signal.	
Others	TLIM lamp lights up. (Fig. 7-10)	Contact your local Okuma service representative.

(6) Spindle orientation cannot be correctly performed.

Excessive vibration and noise while the motor is rotating

Others

Contact your local Okuma service representative.

7-3-4. RECOVERY FROM FAILURS STATUS

When LED's indicate the failure status, it is necessary to remove the cause of failure first and then reset the alarm state to recover the operations of the VAC drive unit.

To reset the alarm,

- 1) Turn off power supply to the VAC drive unit, or
- 2) Press the ALMRST button at the printed circuit board.

Note that correct operations are impossible unless the cause of the failure has been removed.

If the cause of the failure is 1) blown fuse, or 2) tripping of the no-fuse breaker, other causes must also be checked since such abnormal status is caused by some types of malfunctions of the VAC drive unit.



If the same failure recurs due to the same cause, contact your local Okuma service representative.

7-4. FUSE REPLACEMENT

7-4-1. FUSE BLOWN STATE

Blown state of the fuses used in the VAC drive unit is indicated in Table 7-17.

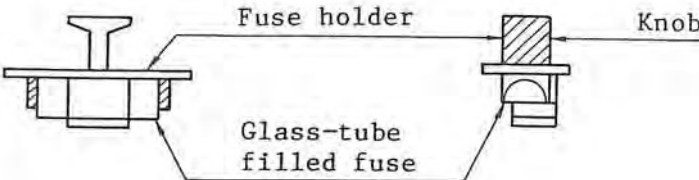
Table 7-17 Fuse Blown State

Name	Blown State
Fuses F1, F2, F3, F4 (F5 only for type D22)	 <p data-bbox="805 600 1150 629">Neon tube lighting up</p> <p data-bbox="858 712 1382 801">Viewing from the front, the neon tube lights up as illustrated at the left.</p>
Warning fuse SMP32 MP50	 <p data-bbox="817 902 903 931">White</p> <p data-bbox="858 969 1426 1093">Viewing from the front, white fuse blown indication is observed at the upper part of fuse holder as illustrated at the left.</p>

7-4-2. FUSE REPLACEMENT

The procedure to replace the fuses used in the VAC drive unit are indicated in Table 7-18 below.

Table 7-18 Fuse Replacement

Name	Replacement Procedure
<p>Fuses</p> <p>F1, F2, F3, F4 (F5 only for type D22)</p>	 <ol style="list-style-type: none"> 1) Pull out the fuse holder with the fuse by holding the knob. 2) Remove the glass-tube filled fuse from the fuse holder. 3) Set a new glass-tube filled fuse to the fuse holder. 4) Set the fuse holder to the VAC drive unit. <p>For types D3 and D6, replace the fuses with the door open.</p> <p>For type D22, replace the fuse with the lower cover of the drive unit removed.</p>
<p>Warning fuse</p> <p>SMP32 MP50</p>	<ol style="list-style-type: none"> 1) Remove the drive unit cover. 2) Pull the fuse out of the fuse holder. 3) Set a new fuse in the holder. 4) Replace the cover.

7-5. SPARE PARTS LIST

The VAC drive units have the following spare parts as indicated in Table 7-19.

Table 7-19 Spare Parts List

Part Name	Type	Okuma Part No.	Qty
Fuse (F1, F2, F3, F4, F5)	200V 5A F7161	E2442-290-124	2
Warning fuse (SMP32)	SMP32 3.2A Daito Tsushin	E2445-392-228	2
Warning fuse (MP50)	MP50 5A Daito Tsushin	E2445-392-215	1

7-6. INPUT/OUTPUT SIGNALS

(1) INPUT SIGNALS

Signal Name	Connector Pin No.	When Activated	Contents
Machine Ready Signal MRDY	CN1 [43] [27]	Close	When this signal is input after power supply to the VAC drive unit has been turned on, spindle speed command can be received.
Forward Rotation Command SFR	CN1 [44] [28]	Close	The SFR and SRV commands can be received after the output contact point signal SRDY is closed (ON).
Reverse Rotation Command SRV	[45] [29]		After the SFR and SRV commands are received with the corresponding contact point closed (ON), the motor begins rotating in accordance with the spindle speed command.
Orientation Signal ORCM	CN1 [47] [31]	Close	When the orientation signal ORCM is turned on (contact point closed), the spindle speed control loop gain, controlled by the controller, is increased establishing the spindle orientation enabled condition.
Torque Control Signal TLIM	CN1 [46] [30]	Close	When the torque control signal TLIM is turned on (contact point closed), the motor is placed in the torque limited state.
Emergency Stop Signal EM	CN1 [41] [25]	Open	When the emergency stop signal EM is turned on (contact point opened), the motor is braked (regeneration braking) and stopped. Then, current to the motor is interrupted to stop power supply to the motor.

(2) Output Signals

Signal Name	Connector Pin No.	When Activated	Contents
Torque Limit Signal TLIM	CN1 [7] [8]		This signal is output when the motor shaft output torque is limited with the torque limit signal input.
Speed Detection Signal DT	CN1 [9] [10]	Close	This signal is output when the motor output shaft speed has dropped below the preset value.
Zero Speed Signal ZERO	CN1 [5] [6]	Close	This signal is output when the spindle speed is lowered to zero speed conditions (below 30 rpm).
Speed Agree Signal AGRE	CN1 [3] [4]	Close	This signal is output when the motor output shaft speed falls within the predetermined range with respect to the commanded speed.
Servo Ready Signal SRDY	CN1 [15] [16]	Close	This signal is output when the status in which the speed command signal may be received after the reception of the MRDY signal.

SECTION 8 COOLING UNIT

The cooling unit is provided on the top of or at the side of the control unit box to prevent the temperature rise in the control box, thus improving the reliability of the CNC system.

8-1. MAINTENANCE AND INSPECTION

Check the following items at least once every three months to keep the cooling unit functioning normally.

- (1) Check for clogging in the air suction opening. Clogging will raise the temperature in the control box to degrade the reliability of the CNC system. Always make sure there is good ventilation.
- (2) Check that the cooling fan is rotating normally.

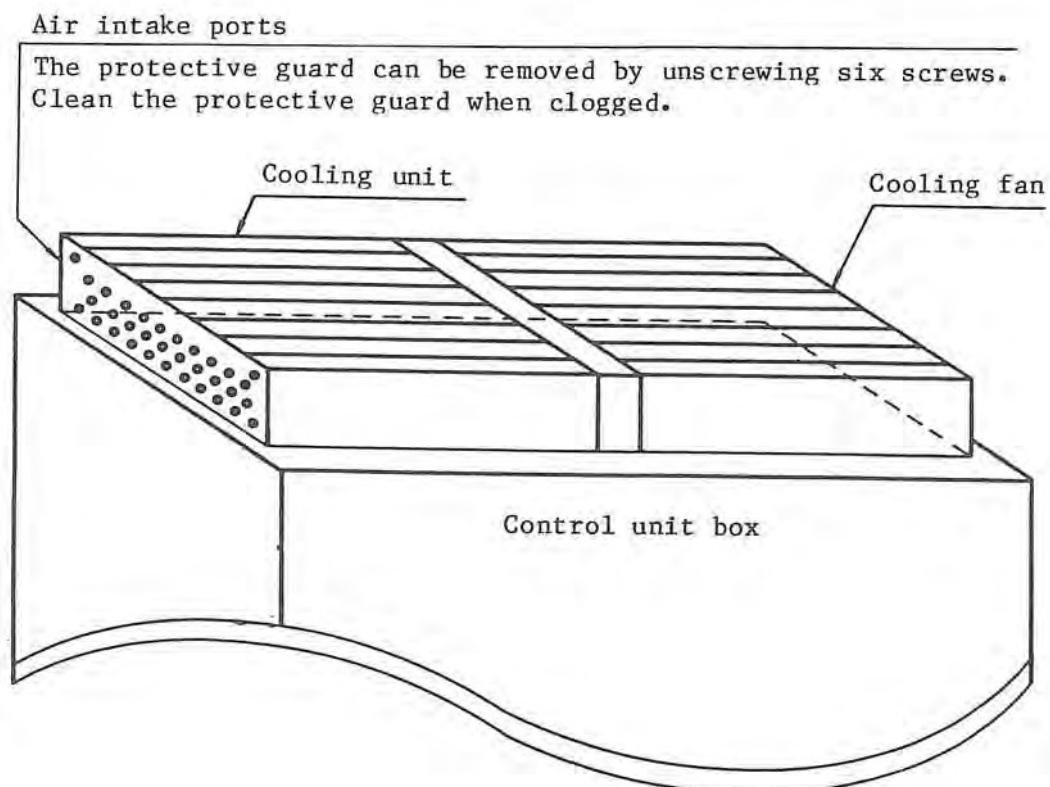


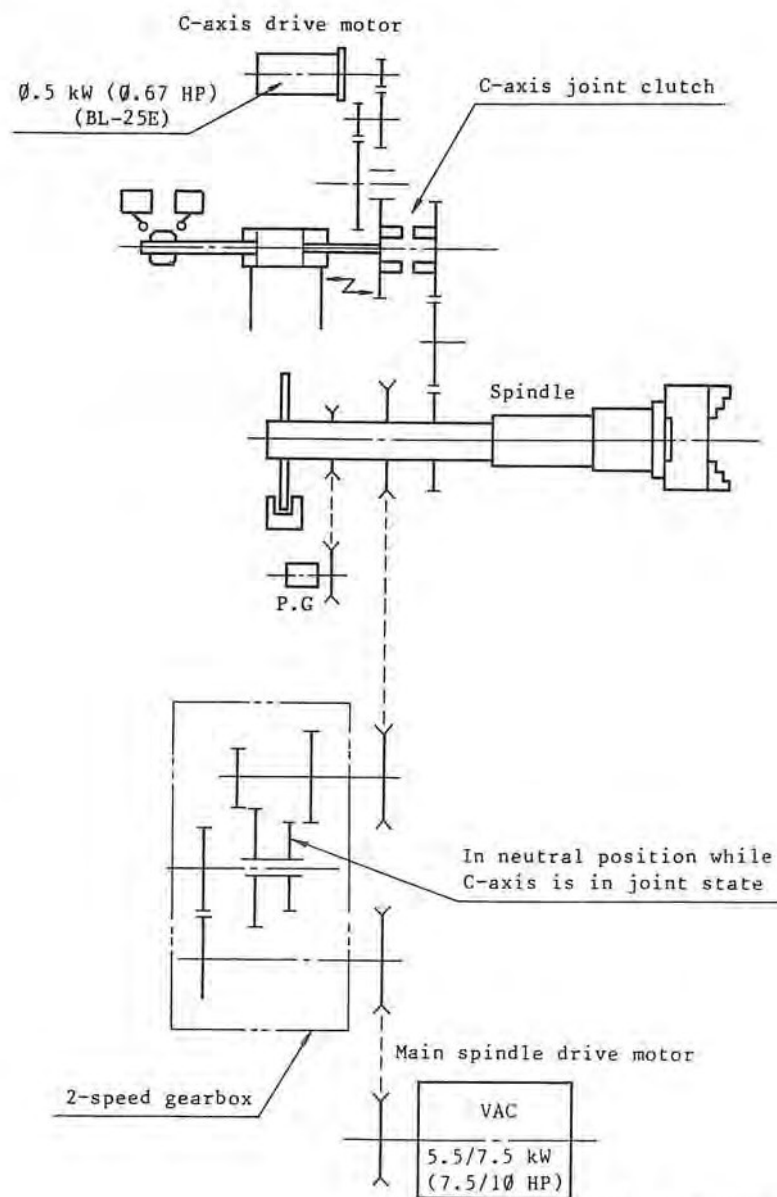
Fig. 8-1 Cooling Unit

SECTION 9 C-AXIS OF MULTIPLE-MACHINING MODEL

A rotary axis defined on the plane established in right angles to Z-axis is called C-axis. On multiple-machining models, spindle rotation is controlled as C-axis. Different motors are used to drive the spindle for conventional turning operations and to drive the C-axis spindle for multiple-machining. This means that selection of the motor meeting the machining requirements becomes necessary.

9-1. C-AXIS JOINT MECHANISM

The operation to switch the spindle drive motor from conventional spindle drive motor for turning to C-axis drive motor is called C-axis joint, which is executed by M110 command.



* This diagram shows LB10M

Fig. 9-1 C-axis Joint Mechanism

9-2. C-AXIS JOINT METHODS

For all LB series models, C-axis joint is executed by M110 command. However, joint operations differ depending on models due to difference in mechanism and control software.

These include the following three methods:

- a) Spindle driven by C-axis during C-axis joint
- b) High speed C-axis joint A
- c) High speed C-axis joint B

As stated above, the same command (M110) is used to execute C-axis joint for any C-axis joint method. However, preparations for C-axis joint and troubleshooting process for a problem arising during C-axis joint differ in each joint method.

This section covers the method to check the C-axis joint method used on your model, and joint processes of each joint method. In the next section, preparations for C-axis joint and troubleshooting procedure are discussed.

9-2-1. Checking C-axis Joint Method

To check the C-axis joint method used on your model, display the SPECIFICATION CODE screen of the CHECK DATA display screens.

The procedure to display the required SPECIFICATION CODE screen is explained in detail in 4-1-7, "CRT Display while in operation" in the Operation Manuals for OSP5000L-G (Publication No. 2446-E).

MDI OPERATION				N	0				
CHECK DATA				UNIT 1mm					
SPEC CODE 01:									
no.	data	bit7	bit6	bit5	bit4	bit3	bit2	bit1	bit0
1	00000010	IDC	LSCH	2SWC	OLC	ROBT	TATS	SPRH	SPID
2	00000000	OMB1	OMCA	TSC	MSPR	CEJ	XMS	NSMS	TCSN
3	00000000	CMK	SMW	IEC	IECD	DRIB	ECE3	ECE2	ECE1
4	00001000	ACPC	CMTR	ATC	TSS	CCM	MIRR	2S	SC
5	00000000	PBCD	FIBM	CTIM	MOP	SORS	ONKC	TDIO	PRIF
6	00010000	CACB	THDC	CALC	MTCL	B60S	TOF3	TOF2	THSP
7	11111111	OABV	CREF	COCO	AXCM	SHOT	TLFC	RMNI	WKMN
8	00111111	CHVT	IGFC	IGF	CLGR	UTSK	INML	NRC	LAP
9	00000000	CD8	CD7	CD6	CD5	CD4	CD3	CD2	CD1
10	00000000						OMB2		TMPS
11	00000000								
12	00000000	DNC3	DNC2	DNC1	DNCB	DNCA	EBCD	EBST	EBIT

DATA INPUT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA			CHECK DATA	[EXTEND]
------------	--------------	--------------	------------	--	--	------------	----------

F 1	F 2	F 3	F 4	F 5	F 6	F 7	F 8
-----	-----	-----	-----	-----	-----	-----	-----

Check bit data of No. 6 at SPECIFICATION CODE 01 screen:

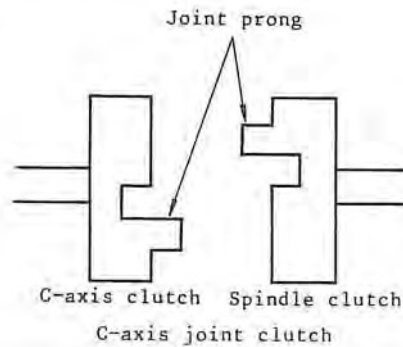
No. 6	bit 5	CALC	bit 7	CHCB	
	1		0		Spindle driven by C-axis during C-axis joint
	0		1		C-axis high speed joint B
	0		0		C-axis high speed joint A

The example CRT display above indicates that the C-axis high speed joint A is used.

9-2-2. Spindle Driven by C-axis During C-axis Joint

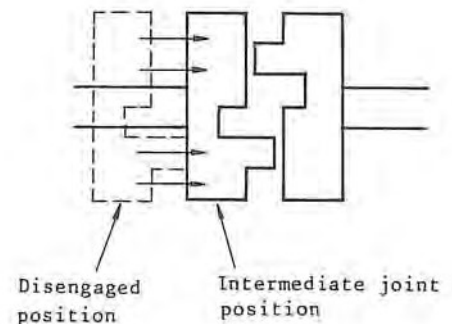
(1) Outline

The C-axis clutch moves forward to the intermediate point for joint, where C-axis rotates to find the joint prong with the spindle clutch.

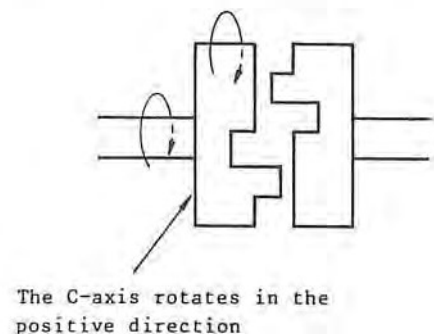


(2) Axis joint process

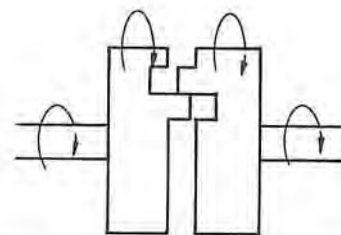
- a) When the C-axis joint command (M110) is executed, the C-axis clutch advances to the joint intermediate position from the clutch disengaged position.



- b) The C-axis rotates to find the joint prong of the spindle clutch; the C-axis always rotates in the positive direction.

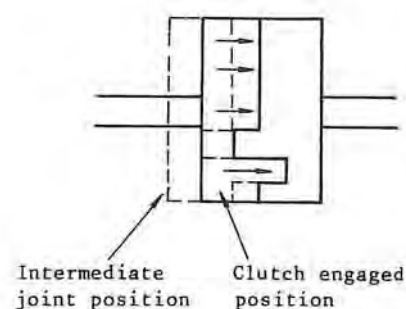


- c) From the point where the joint prong of the C-axis clutch contacts the joint prong of the spindle clutch, the C-axis rotates 90° further. This condition is called "spindle driven by C-axis during C-axis joint".

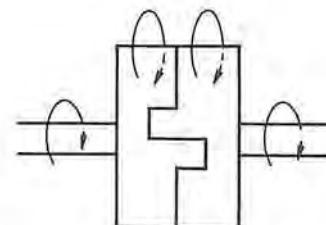


The spindle is driven by C-axis by more than 90° during C-axis joint.

- d) After the spindle is driven by C-axis by 90° during C-axis joint, the C-axis clutch moves forward to the clutch engaged position.



- e) After the confirmation of C-axis joint, C-axis rotates to the programming zero (position where actual position display is 0), then C-axis joint is completed. Note that C-axis always rotates in the positive direction during C-axis joint operation.



(3) Supplements

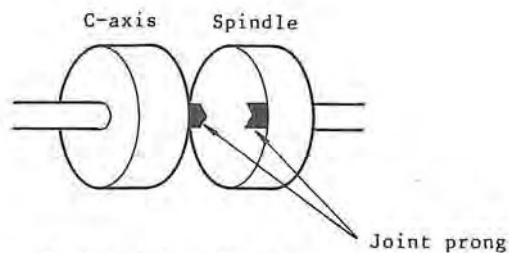
Spindle driven by C-axis during C-axis joint is possible only while the spindle drive gears are in the neutral position. If the gear range is not neutral when the C-axis joint command (M110) is executed, the gear range is automatically placed in the neutral position.

9-2-3. High Speed C-axis Joint A

(1) Outline

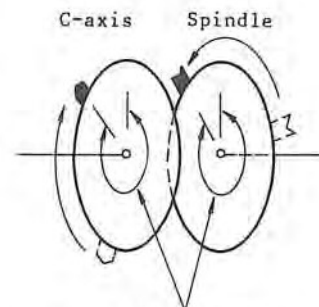
In this joint method, C-axis and the spindle are both positioned at the predetermined position to joint the C-axis. The C-axis joint position is 330° position of C-axis (on program coordinate system).

(2) Joint Process



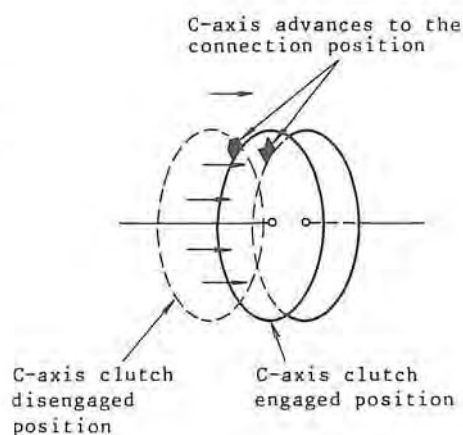
C-axis joint clutch
(mechanical construction is the same as high speed C-axis joint B)

- a) When the C-axis joint command (M110) is executed, the C-axis and the spindle are located at the joint position (330° position of C-axis on the program coordinate system): C-axis at a rapid rotation speed and the spindle by spindle orientation.



Joint angle (330° on the C-axis program coordinate system)

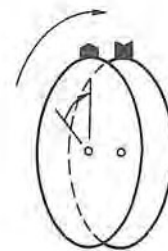
- b) The C-axis clutch advances to the clutch connection position. After the completion of advancement, the spindle drive gear is placed in the neutral position.



- c) The spindle is disconnected from the drive mechanism for turning operation and controlled as the C-axis.

After the joint, the C-axis carries out positioning at the programming zero (actual position display of C-axis 0), then C-axis joint process completes.

In this zero return operation of the C-axis, the C-axis rotates from 330° position to 0° position in the positive direction.



Zero return of C-axis by the C-axis positive direction rotation

(3) Supplements

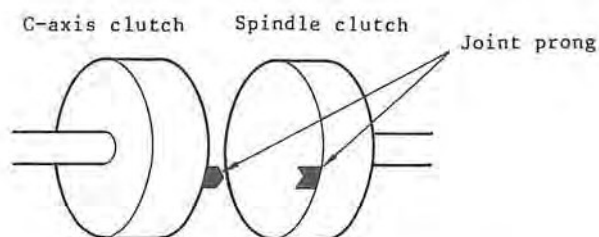
In step a) above, the spindle is positioned at the joint position by the spindle orientation operation. This spindle orientation is conducted in the gear range selected when the C-axis joint command (M11 0) is executed. However, if the spindle drive gear range is neutral at this time, M41 range is automatically selected to carry out spindle orientation.

9-2-4. High Speed C-axis Joint B

(1) Outline

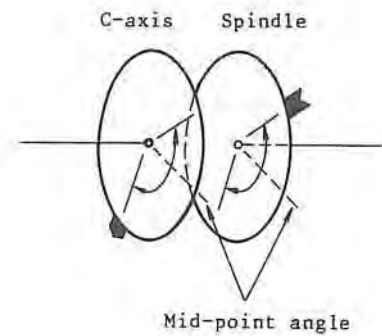
Both the C-axis and the spindle carry out positioning at the position closest to both of them, i.e., at the mid-point between them when the C-axis joint command is executed.

(2) Joint process

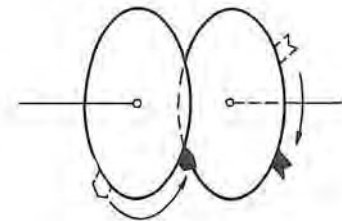


C-axis joint clutch
(mechanical construction is the same as high speed C-axis joint A)

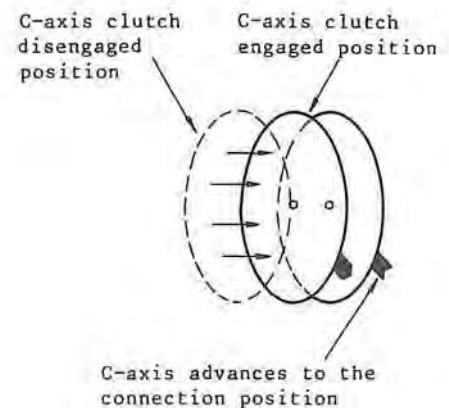
- a) The mid-point angle of the C-axis and the spindle actual angular positions is calculated when the C-axis joint command (M110) is executed. This joint position varies depending on the positions of the C-axis and the spindle when the C-axis joint command is executed.



- b) Positioning of the C-axis and the spindle occurs at the calculated mid-point; C-axis at a rapid rotation speed and the spindle by the spindle orientation.



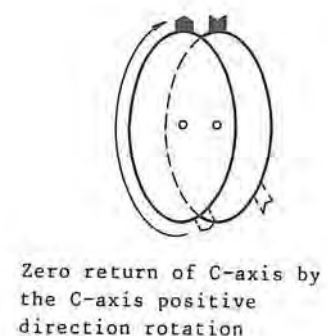
- c) The C-axis clutch advances to the clutch connection position. After the completion of advancement, the spindle drive gear is placed in the neutral position.



- d) The spindle is disconnected from the drive mechanism for turning operation and controlled as the C-axis.

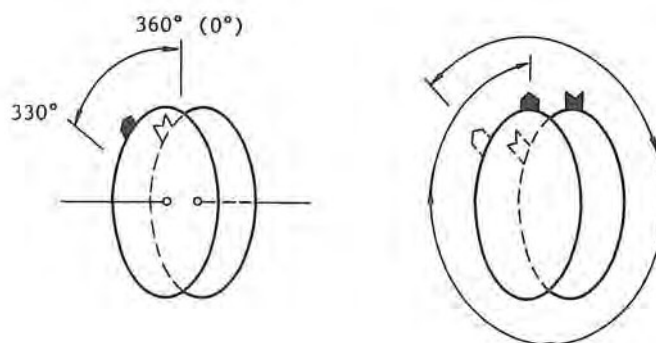
After the joint, the C-axis carries out positioning at the programming zero (actual position display of C-axis 0), then C-axis joint process completes.

In this zero return operation of the C-axis, it rotates from 330° position to 0° position in the positive direction.



(3) Supplements

- a) To calculate the mid-point in process a) above, the C-axis position is calculated from the position encoder output and the spindle position from the feed pulse value.
- b) The feed pulse value is not reliable under the condition that the spindle has not been rotated after power ON. If C-axis joint is commanded in such a state, the spindle position is assumed to be at feed pulse 0 position for the calculation of the mid-point.
- c) In step b) above, the spindle is positioned at the joint position by the spindle orientation operation. This spindle orientation is conducted in the gear range selected when the C-axis joint command (M110) is executed. However, if the spindle drive gear range is neutral at this time, M41 range is automatically selected to carry out spindle orientation.
- d) If the mid-point value calculated is within a range of 330° to 360° (0°) on the C-axis programming coordinate system, zero return in step d) above is carried out after one full turn of the C-axis.



If the calculated mid-point is within a range of 330° to 360° , C-axis first carries out one full turn before carrying out spindle orientation.

9-2-5. Supplements to Joint Method Explanations

Operations common to the three C-axis joint methods are explained below.

- (1) After the completion of C-axis joint (M110), the spindle drive gear range is placed in the neutral position. However, the range previously selected is registered in memory and after the completion of C-axis release command (M109), the spindle speed range previously selected is recovered.
- (2) After the completion of C-axis joint, backlash in C-axis movement is zero for positive direction movements. Backlash is zeroed by the following operations in each of the joint methods.
 - a) Spindle driven by C-axis during C-axis joint
Spindle driven by C-axis by more than 90° during C-axis joint in step c)
 - b) C-axis high speed joint A
Zero return rotation from 330° to 360° (0°) position on the C-axis program coordinate system in step c)
 - c) C-axis high speed joint B
Zero return rotation over 30° from the mid-point (joint angle) in step d)

If angular distance from the mid-point to the zero position is less than 30° , the C-axis rotates additional one full turn.
- (3) If control power is turned off with C-axis in the joint state, the C-axis joint control is cleared and is placed in the joint release state.

9-3. C-AXIS JOINT PARAMETERS

Parameters related with C-axis joint operation are indicated below:

- a) Spindle orientation position parameter
- b) Spindle orientation zero point in C-axis joint

These parameters are factory-set to the optimum values before shipment. However, since it will become necessary to change them during a long term operation of the machine, parameter setting methods are explained below.

Note that for the models using the spindle driven by C-axis during C-axis joint method, setting of parameters is not necessary.

9-3-1. Spindle Orientation Position Parameter

The spindle orientation position parameter is set for individual models at the optimum value when the control software is loaded from the floppy disk. However, it might be necessary to change the set value before starting machining operation, meeting the workpiece shape, chuck shape, etc.

Allowance in spindle orientation is $+4^\circ$, and if spindle orientation is not accomplished within this allowable range, C-axis joint might not be carried out correctly. Therefore, after the change of setup, it is necessary to check the orient stop position of the spindle by executing the M19 command.

For the parameter setting procedure, refer to the Special Functions Manuals for OSP500L-G/OSP5000L-G (Publication No. 2465-E).

Accuracy in spindle orientation operation can be checked on the actual position display screen on which program is also displayed.

AUTO OPERATION A.MIN				N	Ø
X	299.990	PROGRAM			
Xd	0.000	N0001 G00 X 500 Z 800			
Z	364.310	N0002 G50			
Zd	0.000	& S4200			
Fx	0.000	N0100 G97			
Fz	0.000	& S 405 M41 M03 M08			
N	T000000	N0101 G00 X 110 Z 103			
S	Ø CA***.*	& T010101			
		N0102 G96			
		& S 140			
		N0103 G85 N0104 D Ø F 0.35			
		EU 0.2 W 0.1			
		N0104 G91			
		N0105 G00 X 80			

PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA	CHECK DATA	[EXTEND]

[F1] [F2] [F3] [F4] [F5] [F6] [F7] [F8]

For the procedure to display the screen above, refer to 4-1-7, "CRT Display while in Operation" in the Operation Manuals for OSP5000L-G (Publication No. 2446-E).

Carry out the spindle orientation command M19 in the MDI mode. In this spindle orientation, the target is 0° position.

The angular position data of the orient stop position is displayed at parameter CA on the screen above. Check if accuracy $\pm 4^\circ$ is secured.

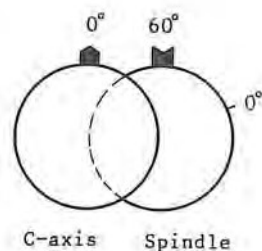
9-3-2. Zero Position in Spindle Orientation for C-axis Joint

(1) Zero position in spindle orientation for C-axis joint

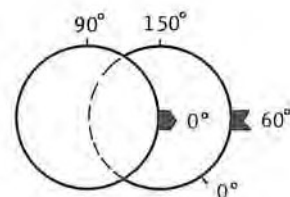
This position is calculated in a relative value in reference to the target position of C-axis* for C-axis joint operation carried out in C-axis high speed joint method A or B.

* 330° position on the program coordinate system for method A, mid-point for method B

Once this value is calculated, the target position of the spindle can be calculated wherever the positioning point for C-axis is taken.



Assume that when the C-axis is at the 0° position on the machine coordinate system, joint is possible by positioning the spindle at 60° position on the machine coordinate system.



If C-axis joint is attempted at 90° position of the C-axis on the machine coordinate system, C-axis joint is possible by positioning the spindle at 150° position ($60^\circ + 90^\circ$).

The relative angular position of the spindle in reference to the C-axis is "the zero position in spindle orientation for C-axis joint".

- (2) Cases which require the setting of zero position in spindle orientation for C-axis

The parameter data is factory-set before shipment and thus it is not necessary to re-set them after machine installation.

However, the setting becomes necessary in the following case:

- a) When control software is loaded from floppy disk

In this case, write down the data before loading the software and set it after the software loading.

- b) When spindle pulse generator or C-axis position encoder is replaced

In this case the data previously set becomes ineffective and setting new data after adjustments will be necessary.

For the procedure to set the new data, refer to 9-3-3, "How to Set Zero Position of Spindle Orientation for C-axis Joint".

Zero position data:

The zero position data is set at optional parameter (word) No. 52.

Parameter (word) No. 52 Spindle orientation angle for C-axis connection

Unit : 0.1°
 Initial value: 0
 Minimum value: 0
 Maximum value: 3,599

For the procedure to set the parameter (word), refer to 4-3-5, "Optional Parameter (word)" in the Operation Manuals for OSP5000L-G (Publication No. 2446-E).

9-3-3. How to Set Zero Position of Spindle Orientation for C-axis Joint

When software is loaded from the floppy disks, the zero position data is initialized to zero (0). However, the data set before shipment is recorded on the management card and thus setting the same data restores the original state as set at the time of delivery.

If a C-axis position encoder or a spindle pulse generator is replaced, the data set at shipping becomes invalid and it becomes necessary to calculate the required setting data.

The procedure to calculate it is explained below:

- 1) Remove the top cover at the C-axis clutch so that the joint portion between the C-axis and the spindle will be exposed.
- 2) Place the spindle drive gears in the neutral position to release* the spindle.
 - * Spindle can be rotated by hand.
- 3) Clear the C-axis zero offset to 0.
- 4) Turn the spindle slowly by hand so that the spindle clutch is brought to the joint position.
- 5) Read the C-axis actual position data and the number of spindle feed pulses when the joint portion of the spindle is brought to the joint portion of the spindle.

For the spindle feed pulse value, use the QSPPC data which is displayed at the check data display, AXIS DATA screen. For QSPPC, the identical data is displayed for X, and Z, or for XA, XB, ZA and ZB.

- 6) Use the following equation to calculate the set value.

$$A = \frac{4096 - (\text{spindle feed pulses})}{4096} \times 360 + 30$$

+ (C-axis actual position data)

Setting value = A x 10 Set only integer by rounding decimal fraction

If value A is greater than 360°, subtract 360° from A so that value A is smaller than 360°. Note that value A must be positive.

9-4. TROUBLE AND TROUBLESHOOTING FOR C-AXIS JOINT OPERATION

If a problem arises during C-axis joint or release operation (M110, M109), an alarm occurs and C-axis joint cannot be performed.

If an alarm occurs, refer to the alarm chart using the alarm message or alarm code number. Although the chart provides the contents of the trouble, it is sometimes necessary to check the machine conditions.

The procedure to check the machine conditions and the measures to take are explained in what follows.

For the EC INPUT/OUTPUT screens, refer to the screens provided in 4-2-2, (1) - (18).

9-4-1. Machine Condition Checking Procedure

The CHECK DATA screens provide the machine operation conditions.

- a) Has the spindle orientation been completed?
- b) What commands have been and are commanded?
- c) Actual machine status for individual commands

For the items above, they are explained below one by one.

For the procedure to display the screens, refer to 4-1-7, "CRT Display while in Operation" in the Operation Manuals for OSP500L-G /OSP500L-G (Publication No. 2446-E).

(1) Has the spindle orientation been completed?

With the spindle driven by C-axis during C-axis joint method, spindle orientation is not carried out. But, spindle orientation is the first operation to be carried out when the C-axis joint is commanded by C-axis high speed joint method A or B.

Unless the spindle orientation has not been completed, the control is placed in the response waiting condition without generating an alarm. In this case, C-axis joint operation does not complete.

Check No. 5 bit 4 (spindle orientation in Execution (SCSP)) of EC OUTPUT signal state display (No. 1) in 4-4-2, (1). If this signal is ON, it indicates that the spindle orientation has not been completed.

(2) What commands have been and are commanded?

The status which has been commanded can be known from the EC output bits for C-axis.

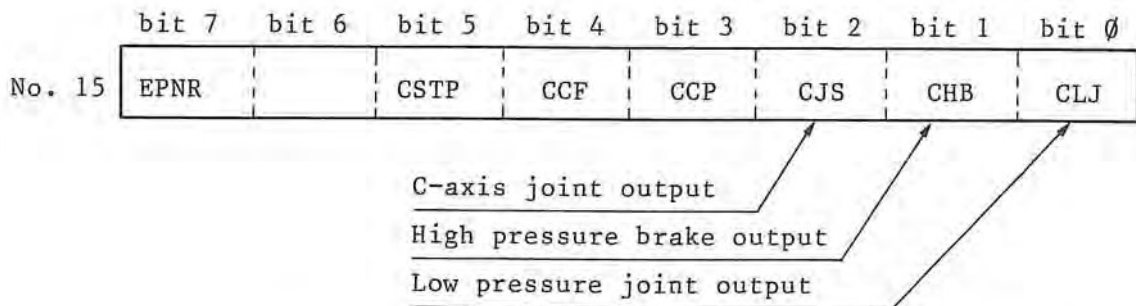
Bit 0 through bit 5 of No. 15 of EC OUTPUT signal status display (No. 2) (4-4-2, (6)) are the EC output bits for C-axis. Among these output bits, bit 0 through bit 2 indicate the command output at the time of C-axis joint.

Bit 0 Low pressure joint
 Bit 1 High pressure brake
 Bit 2 Joint only

Output bits for commands:

Output bits for commands vary depending on joint methods.

a) Spindle driven by C-axis during C-axis joint method

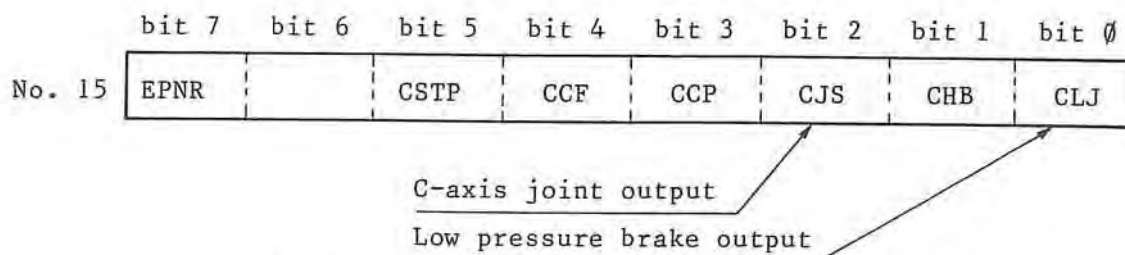


By the combination of these outputs, the following operation conditions are indicated.

CJS	CHB	CLJ	Output
			Operation command output
OFF	OFF	OFF	Retraction to C-axis release position, or C-axis release
OFF	ON	ON	C-axis advance to intermediate position
ON	ON	ON	C-axis advance to joint position
ON	OFF	ON	C-axis joint completion

Output patterns other than those indicated above are not provided.

b) C-axis high speed joint method A, B



By the combination of these outputs, the following operation conditions are indicated.

CJS	CLJ	Output
		Operation command
OFF	OFF	Retraction to C-axis release position, or C-axis release
ON	OFF	C-axis advance to joint position
ON	ON	C-axis joint completion

(3) Actual machine status for individual commands

The actual machine status can be known from the EC input bits for C-axis.

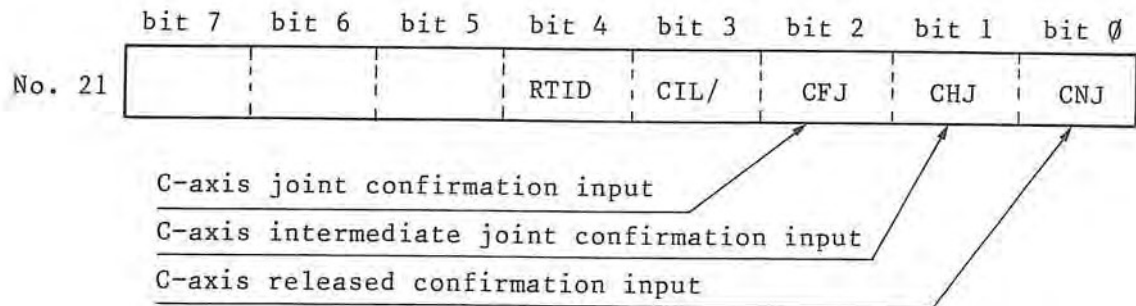
Bit 0 through bit 4 of No. 21 of EC INPUT signal status display (No. 2) (4-4-2, (2)) are the EC input bits for C-axis. Among these input bits, bit 0 through bit 2 indicate the status input at the time of C-axis joint.

Bit 0 C-axis released confirmation
 Bit 1 C-axis intermediate connection confirmation
 Bit 2 C-axis joint confirmation

Status indicating input bits:

Status indicating input bits vary depending on joint methods.

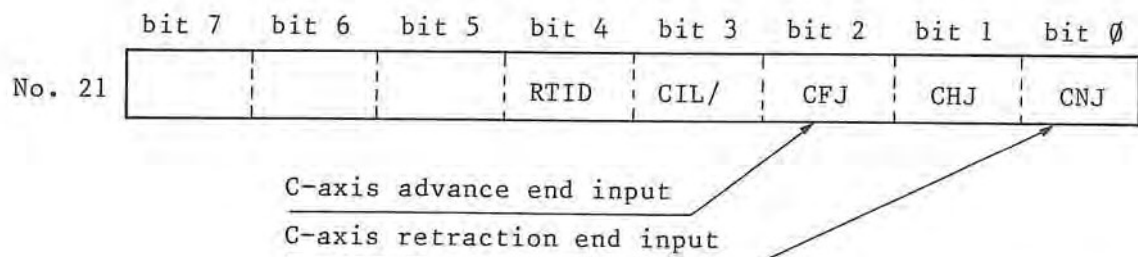
a) Spindle driven by C-axis during C-axis joint



The C-axis status is indicated by the following LS input patterns.

Status	LS		
	CFJ	CHJ	CNJ
C-axis released (retraction end)	ON	ON	ON
C-axis at intermediate position	ON	OFF	OFF
C-axis joint (advance end)	OFF	OFF	OFF

b) C-axis high speed joint method A, B



The C-axis status is indicated by the following LS input patterns.

Status	LS	
	CFJ	CNJ
C-axis released (retraction end)	OFF	ON
C-axis joint (advance end)	ON	OFF

9-4-2. Troubles and Troubleshooting

Causes, examples and measures to take for alarms which occur during the execution of C-axis joint are explained below.

(1) Cause of troubles and troubleshooting

The alarm message which is displayed at an occurrence of a problem during C-axis joint process is

Alarm A 160 C-axis connect command

The code numbers under this alarm state, causes and measures to take are explained below.

a) Code numbers

- 1 The command (M110, M109) is designated while the spindle is not at zero speed.
- 2 The command (M110, M109) is designated while the spindle is not at a still.
- 3 The command (M110, M109) is designated while the spindle rotation command is active.

This alarm occurs when C-axis joint (M110) or C-axis release (M109) is commanded while the spindle is rotating. If the spindle is rotating (forward or reverse), be sure to stop the spindle before carrying out the C-axis joint. There are examples of alarm occurrence causes as explained below:

Example 1: M109 or M110 is specified while the spindle is rotating due to inertia after turning off spindle inching while the spindle was being rotated at a relatively high inching speed.

:		
M89		}
G04 F1		
M88		
M110		
:		

Air blower (inching) for one second

C-axis joint designation

The spindle might be rotating even after the air blower (inching) has been turned off if inching speed is set at a high speed. If such a problem occurs, lower the inching speed.

Example 2: When an irregular shape workpiece is clamped in the chuck, the spindle might rotate if range is set at neutral. If M101 is programmed under such a condition, an alarm occurs.

```

:
M40
M110
:

```

The spindle might rotate due to imbalance of the workpiece. In this case, it is necessary to orient-stop the spindle at a position where the spindle will not rotate if imbalance exists.

Example 3: This alarm will occur if M109 and M110 are specified in succession.

```

:
M110
M109
M110
M109
:

```

The final operation step of M110 is the zero return of C-axis as stated before. In the final zero return operation, the C-axis will be moving even after the function generation has finished because actual axis movement has a delay due to presence of DIFF. An alarm occurs if M109 is programmed under such situation.

Do not program M110 and M109 in succession.

- b) Code number 4 The command (M110, M109) is designated while C-axis is clamped.

While the C-axis is being clamped, C-axis feed is impossible. Always place the C-axis in the unclamp state before programming M109 and M110.

- c) Code number 5 The command (M110, M109) is designated while C-axis is interlock input is OFF.

The C-axis interlock input is turned off when external conditions are not satisfied. For instance, input signals are forcibly turned off if the loader is working inside the lathe so that the C-axis joint and release commands will not be executed.

d) Code number none ... C-axis clutch fails to advance.

An alarm occurs if the C-axis clutch fails to advance to the intermediate joint position for spindle driven by C-axis during C-axis specification or to the the joint position for C-axis high speed joint method A or B.

Whether or not the C-axis clutch has advanced is checked by the status of EC input bits.

The cause of this alarm is that the joint portions are not in engaged condition when the C-axis has advanced.

Possible reasons of faulty engagement of C-axis and spindle clutches are poor spindle orientation accuracy or wrong spindle orientation stop zero position data in C-axis joint.

If accuracy of spindle orientation position for C-axis joint is poor, this problem can be easily confirmed by simply commanding the spindle orientation command (M19). An error within $\pm 4^\circ$ is allowed for C-axis joint operation. Re-set the spindle orientation stop position parameter data so that orient stop position falls within $\pm 4^\circ$ range from the commanded position.

If zero position for C-axis joint has been offset, make adjustment if offset amount is small. In case it is too large and adjustment is impossible, then set the zero position again.

(2) Processing after occurrence of alarm

If an alarm occurs, the C-axis clutch retracts to the retraction end and the C-axis is in the released condition. The alarm indication will be cleared by the reset operation. However, the internal condition of the NC is neither C-axis joint nor C-axis release, and it is in the joint operation in progress state (C-axis joint lamp on the operation panel flickering). Under such conditions, neither spindle operation nor C-axis operation is possible. To escape such conditions, it is necessary to specify the C-axis release command (M109). When M109 command is designated the status indicating lamp is turned off, allowing the spindle operation.

(3) Other trouble

If any trouble not covered by this manual occurs, contact your local Okuma service representative.

ELECTRICAL SPARE PARTS LIST (1/9)

(1) LB10 (OSP500/5000L-G) - Spindle Drive Motor 5.5/7.5 kW

TLB-038 SPL-001A-5

Name of Part	Part No.	Rated	Q'ty	Maker	Remarks
Control relay	E3202-397-006 (A112-7111)	G2A-432A DC24V 4T	2	Tateishi	For relay unit
Power relay	E3212-397-003 (A112-7111)	LY2N DC24V 2T	2	Tateishi	For relay unit
Reten- tive relay	E3231-397-003 (A112-7111)	G2AK-232A DC24V	1	Tateishi	For relay unit
Fuse	E2442-190-015	25FH50 250V 50A	3	Kyosan	For AC spindle servo drive unit
Fuse	E2442-190-014	25FH75 250V 75A	1	Kyosan	For AC spindle servo drive unit
Fuse	E2444-075-010	PCIF-20	2	Utsuno- miya	For AC spindle servo drive unit
Alarm fuse	E2445-392-208	3.2A MP32	1	Daito	For AC spindle servo drive unit
Alarm fuse	E2445-715-013	1.0A	1	Daito	For AC spindle servo drive unit
Fuse	E2442-290-124	F7161 5A 125V	2	Satoh Parts	For AC spindle servo drive unit
Fuse	E2445-392-213	HM03 0.3A 250V	2	Daito	For AC spindle servo drive unit
Surge absor- bers	E4434-800-001	ERZ-C20DK-431	4	Matsu- shita	For AC spindle servo drive unit
Fuse	E2442-290-106	No. 1065 2A Glass tube fuse element	9	Satoh Parts	For X-, Z-axis drive motor unit

An accessory of Tape Reader

Lens cleaner	PTR accessory		1		For PTR cleaning
Operation Manual			1	Sanyo	Paper tape reader

ELECTRICAL SPARE PARTS LIST (2/9)

(2) LB10 (OSP500/5000L-G) - Spindle Drive Motor 7.5/11 kW

T100-153-011 SPL-001B-1

Name of Part	Part No.	Rated	Q'ty	Maker	Remarks
Control relay	E3202-397-006 (A112-7111)	G2A-432A DC24V 4T	2	Tateishi	For relay unit
Power relay	E3212-397-003 (A112-7111)	LY2N DC24V 2T	2	Tateishi	For relay unit
Retentive relay	E3231-397-003 (A112-7111)	G2AK-232A DC24V	1	Tateishi	For relay unit
Fuse	E2442-190-016	25SH100 250V 100A	4	Kyosan	For AC spindle servo drive unit
Fuse	E2444-075-009	PC1-30 AC500V 30A DC250V	2	Utsunomiya	For AC spindle servo drive unit
Alarm fuse	E2445-392-208	3.2A MP32	1	Daito	For AC spindle servo drive unit
Alarm fuse	E2445-715-013	1.0A	1	Daito	For AC spindle servo drive unit
Fuse	E2442-290-124	F7161 5A 125V	2	Satoh Parts	For AC spindle servo drive unit
Fuse	E2445-392-213	HM03 0.3A 125V	2	Daito	For AC spindle servo drive unit
Surge absorbers	E4434-800-001	ERZ-C20DK-431	4	Matsushita	For AC spindle servo drive unit
Fuse	E2442-290-106	No. 1065 2A Glass tube fuse element	9	Satoh Parts	For X-, Z-axis drive motor unit

An accessory of Tape Reader

Lens cleaner	PTR accessory		1		For PTR cleaning
Operation Manual			1	Sanyo	Paper tape reader

ELECTRICAL SPARE PARTS LIST (3/9)

(3) LB10-M (OSP5000L-G) - Spindle Drive Motor 5.5/7.5 kW

T100-153-011 SPL-001D-1

Name of Part	Part No.	Rated	Q'ty	Maker	Remarks
Control relay	E3202-397-006 (A112-7111)	G2A-432A DC24V 4T	2	Tateishi	For relay unit
Power relay	E3212-397-003 (A112-7111)	LY2N DC24V 2T	2	Tateishi	For relay unit
Retentive relay	E3231-397-003 (A112-7111)	G2AK-232A DC24V	1	Tateishi	For relay unit
Fuse	E2442-190-014	No. 1065 2A Glass tube fuse element	3	Kyosan	For AC spindle servo drive unit
Fuse	E2442-190-015	25SH100 250V 100A	1	Kyosan	For AC spindle servo drive unit
Fuse	E2444-075-005	PC1-30 AC500V 30A DC250V	2	Utsuno- miya	For AC spindle servo drive unit
Alarm fuse	E2445-392-208	3.2A MP32	1	Daito	For AC spindle servo drive unit
Alarm fuse	E2445-392-209	S3.2A SMP32	2	Daito	For AC spindle servo drive unit
Fuse	E2442-290-124	F7161 5A 250V	2	Satoh Parts	For AC spindle servo drive unit
Fuse	E2445-392-213	HM03 0.3A 250V	4	Daito	For AC spindle servo drive unit
Surge absorbers	E4434-722-002	ENA 441 15	4	Fuji	For AC spindle servo drive unit
Fuse	E2442-290-106	No. 1065 2A Glass tube fuse element	12	Satoh Parts	For X-, Z-, C-axis drive motor unit

An accessory of Tape Reader

Lens cleaner	PTR accessory		1		For PTR cleaning
Operation Manual			1	Sanyo	Paper tape reader

ELECTRICAL SPARE PARTS LIST (4/9)

(4) LB10-M (OSP5000L-G) - Spindle Drive Motor 7.5/11 kW

T100-153-011 SPL-001E-2

Name of Part	Part No.	Rated	Q'ty	Maker	Remarks
Control relay	E3202-397-006 (A112-7111)	G2A-432A DC24V 4T	2	Tateishi	For relay unit
Power relay	E3212-397-003 (A112-7111)	LY2N DC24V 2T	2	Tateishi	For relay unit
Retentive relay	E3231-397-003 (A112-7111)	G2AK-232A DC24V	1	Tateishi	For relay unit
Fuse	E2444-190-016	25SH100 250V 100A	4	Kyosan	For AC spindle servo drive unit
Fuse	E2444-075-009	PC1-30 AC500V 30A DC250V	2	Utsunomiya	For AC spindle servo drive unit
Alarm fuse	E2445-392-208	3.2A MP32	1	Daito	For AC spindle servo drive unit
Alarm fuse	E2445-715-013	1.0A	1	Daito	For AC spindle servo drive unit
Fuse	E2442-290-124	F7161 5A 250V	2	Satoh Parts	For AC spindle servo drive unit
Fuse	E2445-392-213	HM03 0.3A 250V	4	Daito	For AC spindle servo drive unit
Surge absorbers	E4434-800-001	ERZ-C20DK-431	4	Matsushita	For AC spindle servo drive unit
Fuse	E2442-290-106	No. 1065 2A Glass tube fuse element	12	Satoh Parts	For X-, Z-, C-axis drive motor unit

An accessory of Tape Reader

Lens cleaner	PTR accessory		1		For PTR cleaning
Operation Manual			1	Sanyo	Paper tape reader

ELECTRICAL SPARE PARTS LIST (5/9)

(5) LB12 - Spindle Drive Motor 5.5/7.5 kW

(BL-ACT) T100-153-014 SPL-001A-3

Name of Part	Part No.	Rated	Q'ty	Maker	Remarks
Control relay	E3202-397-006	G2A-432A DC24V 4T	2	Tateishi	For relay unit
Power relay	E3212-397-003	LY2N DC24V 2T	2	Tateishi	For relay unit
Reten- tive relay	E3231-397-003	G2AK-232A DC24V	1	Tateishi	For relay unit
Fuse	E2442-290-106	No. 1065 2A Glass tube fuse element	9	Satoh Parts	For X-, Z-axis drive motor unit
Fuse	E2445-392-228	SMP32 3.2A Fuse element	2	Daito	AC spindle servo unit
Fuse	E2445-392-215	MP50 5A Fuse element	1	Daito	AC spindle servo unit
Fuse	E2442-290-124	F7161 AC125V 5A Glass tube fuse element	2	Daito	AC spindle servo unit
Terminal	E5521-082-078	170330-1	10	AMP	Terminal
Terminal	E5521-082-079	170332-1	10	AMP	Terminal
Terminal	E5521-082-080	172074-1	20	AMP	Terminal

An accessory of Tape Reader

Lens cleaner	PTR accessory		1		For PTR cleaning
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ELECTRICAL SPARE PARTS LIST (6/9)

(6) LB15 - Spindle Drive Motor 5.5/7.5 kW

(BL-ACT) Standard TLB-Ø18 SPL-ØØ1A-4

Name of Part	Part No.	Rated	Q'ty	Maker	Remarks
Control relay	E32Ø2-397-ØØ6 (A118-7111)	G2A-432A DC24V 4T	2	Tateishi	For relay unit
Power relay	E3212-397-ØØ3 (A118-7111)	LY2N DC24V 2T	2	Tateishi	For relay unit
Reten- tive relay	E3231-397-ØØ3 (A118-7111)	G2AK-232A DC24V	1	Tateishi	For relay unit
Lamp	E358Ø-Ø31-ØØ2 (A118-7111)	LE8 18V 2W E12	1	Izumi	For EC operation panel ON/OFF switch
Lens cleaner	PTR accessory		1		For PTR cleaning
Fuse	E2442-29Ø-1Ø6	No. 1Ø65 2A Glass tube fuse element	9	Satoh parts	For X-, Z-axis drive motor unit
Fuse	E2444-19Ø-Ø14 (A118-Ø9Ø3)	25FH75 25ØV 75A	3	Kyosan	For AC spindle servo drive unit
Fuse	E2444-19Ø-Ø15 (A118-Ø9Ø3)	25FH5Ø 25ØV 5ØA	1	Kyosan	For AC spindle servo drive unit
Fuse	E2444-Ø75-ØØ5 (A118-Ø9Ø3)	PC1-2Ø AC5ØØV DC25ØV 2ØA	2	Utsuno- miya	For AC spindle servo drive unit
Alarm fuse	E2445-392-2Ø8 (A118-Ø9Ø3)	3.2A MP32	1	Daito	For AC spindle servo drive unit
Alarm fuse	E2445-392-2Ø9 (A118-Ø9Ø3)	S3.2A SMP32	2	Daito	For AC spindle servo drive unit
Alarm fuse	E2445-392-213 (A118-Ø9Ø3)	HMØ3 Ø.3A 25ØV	4	Daito	For AC spindle servo drive unit
Fuse	E2442-29Ø-124 (A118-Ø9Ø3)	F-7161 5A 125V	1	Satoh Parts	For AC spindle servo drive unit
Surge absor- bers	E4434-722-ØØ2 (A118-Ø9Ø3)	ENA 441 15	4	Fuji	For AC spindle servo drive unit

ELECTRICAL SPARE PARTS LIST (7/9)

(7) LB15 - Spindle Drive Motor 7.5/11 kW

(BL-ACT) Special TLB-018 SPL-001B-4

Name of Part	Part No.	Rated	Q'ty	Maker	Remarks
Control relay	E3202-397-006 (A118-7111)	G2A-432A DC24V 4T	2	Tateishi	For relay unit
Power relay	E3212-397-003 (A118-7111)	LY2N DC24V 2T	2	Tateishi	For relay unit
Retentive relay	E3231-397-003 (A118-7111)	G2AK-232A DC24V	1	Tateishi	For relay unit
Lamp	E3580-031-002 (A118-7111)	LE8 18V 2W E12	1	Izumi	For EC operation panel ON/OFF switch
Lens cleaner	PTR accessory		1		For PTR cleaning
Fuse	E2442-290-106	No. 1065 2A Glass tube fuse element	9	Satoh parts	For X-, Z-axis drive motor unit
Fuse	E2444-190-016 (A118-0902)	25SH100 250SH 100A	4	Kyosan	For AC spindle servo drive unit
Fuse	E2444-075-007 (A118-0902)	PC1-30 AC500V DC250V 30A	2	Utsunomiya	For AC spindle servo drive unit
Alarm fuse	E2445-392-209 (A118-0902)	S3.2A SMP32	2	Daito	For AC spindle servo drive unit
Alarm fuse	E2445-392-208 (A118-0902)	3.2A MP32	1	Daito	For AC spindle servo drive unit
Alarm fuse	E2445-392-213 (A118-0802)	HM03 0.3A 250V	4	Daito	For AC spindle servo drive unit
Fuse	E2442-290-124 (A118-0902)	F-7161 5A 125V	1	Satoh Parts	For AC spindle servo drive unit
Surge absorbers	E4434-722-002 (A118-0902)	ENA 441 15	4	Fuji	For AC spindle servo drive unit

ELECTRICAL SPARE PARTS LIST (8/9)

(8) LB15/1S (OSP5000L-G) - Spindle Drive Motor 5.5/7.5 kW

(BL-ACT) Standard TLB-018 SPL-001A-9

(Flat Panel Model)

Name of Part	Part No.	Rated	Q'ty	Maker	Remarks
Control relay	E3202-397-006	G2A-432A DC24V 4T	2	Tateishi	For relay unit
Power relay	E3212-397-003	LY2N DC24V 2T	2	Tateishi	For relay unit
Retentive relay	E3231-397-003	G2AK-232A DC24V	1	Tateishi	For relay unit
Terminal	E5521-082-078	170330-1	10	AMP	Terminal
Terminal	E5521-082-079	170332-1	10	AMP	Terminal
Terminal	E5521-082-080	172074-1	20	AMP	Terminal
Lens cleaner	PTR accessory		1		For PTR cleaning
Fuse	E2444-190-014	25FH75 250V 75A	1	Kyosan	For AC spindle servo drive unit
Fuse	E2444-190-015	25FH50 250V 50A	3	Kyosan	For AC spindle servo drive unit
Fuse	E2444-075-010	PC1F-20	2	Utsunomiya	For AC spindle servo drive unit
Fuse	E2445-392-208	3.2A SMP32	1	Daito	For AC spindle servo drive unit
Fuse	E2445-715-013	1.0A	1	Daito	For AC spindle servo drive unit
Fuse	E2445-392-213	HM03 0.3A 250V	2	Daito	For AC spindle servo drive unit
Fuse	E2442-290-124	F-7161 5A 125V	2	Satoh Parts	For AC spindle servo drive unit
Surge absorbers	E4434-800-002	ERZ-C20DK-431	4	Mastushita	For AC spindle servo drive unit
Fuse	E2442-290-106	No. 1065 2A Glass tube fuse element	9	Satoh Parts	For X-, Z-axis drive motor unit
Operation Manual			1		Paper tape reader

ELECTRICAL SPARE PARTS LIST (9/9)

(9) LB15/1S (OSP5000L-G) - Spindle Drive Motor 7.5/11 kW

(BL-ACT) Special TLB-018 SPL-001B-9

(Flat Panel Model)

Name of Part	Part No.	Rated	Q'ty	Maker	Remarks
Control relay	E3202-397-006	G2A-432A DC24V 4T	2	Tateishi	For relay unit
Power relay	E3212-397-003	LY2N DC24V 2T	2	Tateishi	For relay unit
Reten- tive relay	E3231-397-003	G2AK-232A DC24V	1	Tateishi	For relay unit
Terminal	E5521-082-078	170330-1	10	AMP	Terminal
Terminal	E5521-082-079	170332-1	10	AMP	Terminal
Terminal	E5521-082-080	172074-1	20	AMP	Terminal
Lens cleaner	PTR accessory		1	Sanyo	For PTR cleaning
Fuse	E2442-290-106	No. 1065 2A Glass tube fuse element	9	Satoh parts	For X-, Z-axis drive motor unit
Fuse	E2444-190-016	25SH100 250V 100A	4	Kyosan	For AC spindle servo drive unit
Fuse	E2444-075-009	PC1F-30 AC500V DC250V 30A	2	Utsuno- miya	For AC spindle servo drive unit
Alarm fuse	E2445-715-013	1.0A	1	Daito	For AC spindle servo drive unit
Alarm fuse	E2445-392-208	3.2A MP32	1	Daito	For AC spindle servo drive unit
Alarm fuse	E2445-392-213	HN03 0.3A 250V	2	Daito	For AC spindle servo drive unit
Fuse	E2442-290-124	F-7161 5A 125V	2	Satoh Parts	For AC spindle servo drive unit
Surge absor- bers	E4434-800-001	ERZ-C20DK-431	4	Matsu- shita	For AC spindle servo drive unit
Operation Manual			1		Paper tape reader

RATED POWER DATA (1/4)

(1) Table of Power Requirements for LB10 (220/440V, 380V, 415V, 600V)

Model	Power required by main motor kW (hp)	Power required by auxiliary equipment drive motor kW (hp)	Axis drive motor kW (hp)	NC unit	Apparent power KVA	Rated power (Note 5) kW (hp)	Rated current of main circuit breaker Amp.	Facility to be prepared by user (Note 1)		
								Branch circuit breaker or fuse Amp.	Cable size mm ²	
LB10	VAC 7.5/5.5 (10/7.5) (8.8KVA)	Oil hydraulic motor 0.75 (1)	XA-axis 1.0 (1.3)	14.8	14.8	11.9 (15.9)	75	(220V)	75	16 - 22
	VAC 11/7.5 (15/10)	Coolant 0.18 (0.24)	ZA-axis 1.5 (2)					(380V)	50	10 or more
		Lubrication 0.025 (0.033)	Total 2.5 (3.3) KVA					(415V)	50	8 or more
		Spindle lubrication 0.075 (0.1)						(600V)	25	more
12 KVA	Total 1.03 (1.37) 1.24 KVA		18.0	18.0	14.4 (19.2)	100	(220V)	100	22 - 30	
								(380V)	50	
								(415V)	50	10 or more
								(440V)	50	
								(600V)	35	8 or more

Note:

- Facilities to be prepared by user should conform to the applicable regulations, and this only indicates the values for reference.
- VA = 1.4 x kW (for DC motor) and VA = 1.3 kW (for axis drive motor BL-ACT)
- VA = 1.2 x kW (for AC motor)
- VA = 1.6 x Continuous rated power (kW) (for spindle drive motor (VAC))
- Rated power = Apparent power x power-factor cosφ where, cosφ = 0.8

RATED POWER DATA (3/4)

(3) Table of Power Requirements for LB12 (220/440V, 380V, 415, 600V)

Model	Power Required by Main Motor kW (hp)	Power Required by Auxiliary Equipment Drive Motor kW (hp)	Axis Drive Motor (BL-ACT) kW (hp)	NC Unit	Apparent Power kVA	Required Power (Note 5) kW (hp)	Rated Current of Main Circuit Breaker A	Facility to be Prepared by User (Note 1)			
								Branch Circuit Breaker or Fuse A	Cable Size mm ²		
LB12	VAC 7.5/5.5 (10/7.5) kW [15/11 (20/15) kW] (Note 6)	Oil hydraulic motor 1.5 (2) Coolant 0.25 (0.33) Lubrication 0.025 (0.033)	X-axis 1.5 (2) Z-axis 2.4 (3.2)		26.3	21 (28)	220 V: 75	75	22 or more		
										380 V: 50	50
										415 V: 50	
										440 V: 50	
	17.6 kVA (Note 6)	Total 1.77 (2.36) 2.1 kVA	Total 3.9 (5.2) 5.1 kVA	1.5 kVA			600 V: 30	30	8 or more		

Note 1: Facilities to be prepared by user should conform to the applicable regulations, and this only indicates the values for reference.

Note 2: VA = 1.4 x kW (for DC motor) and VA = 1.3 x kW (for axis feed motor BL-ACT)

Note 3: VA = 1.2 x kW (for AC motor)

Note 4: VA = 1.6 x Continuous rated power (kW) (for spindle motor (VAC))

Note 5: Required power = Apparent power x Power-factor cosφ where, cosφ = 0.8

Note 6: Continuous rated power is 11 kW using a special wide range VAC motor.

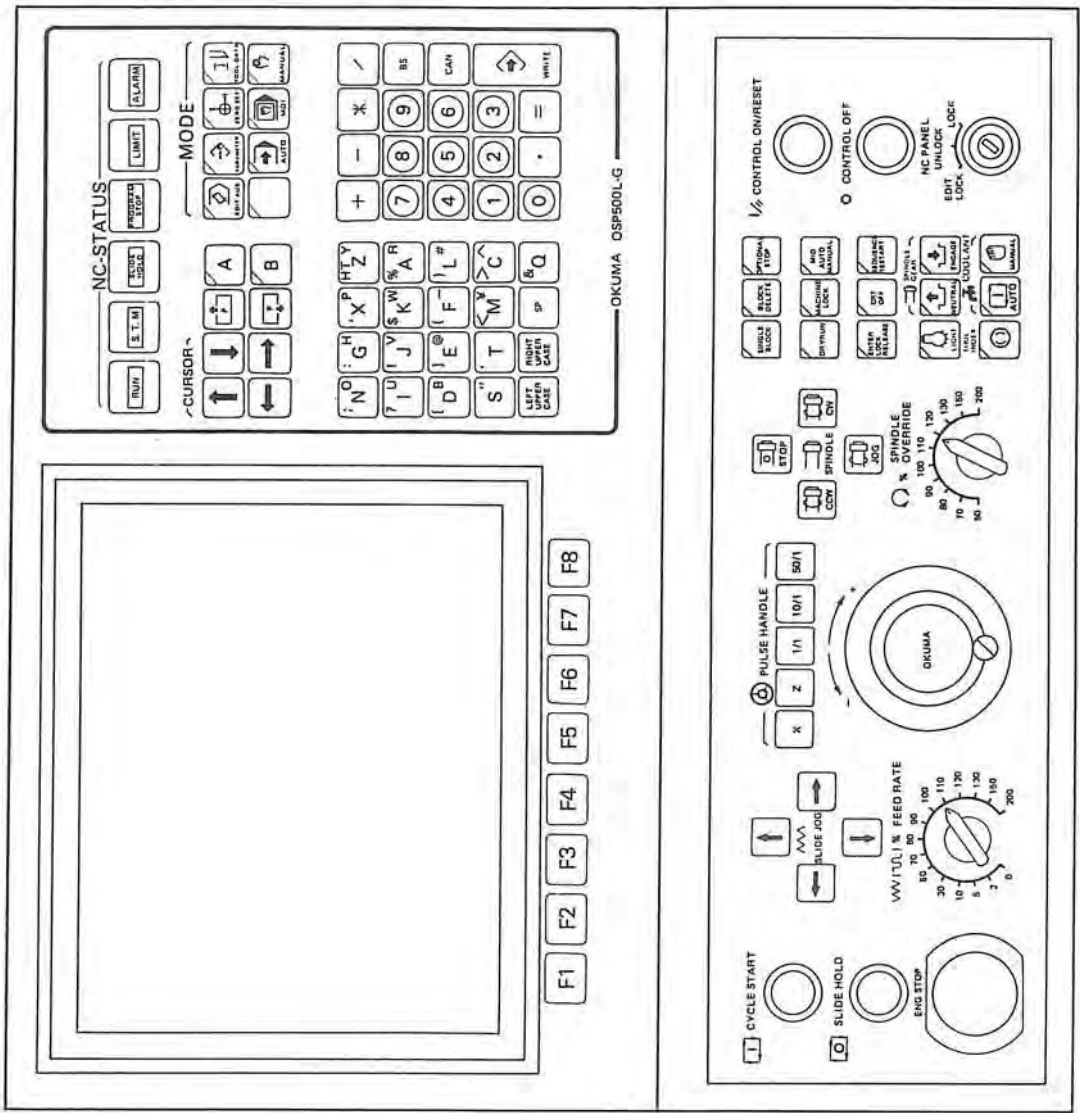
RATED POWER DATA (4/4)

(4) Table of Power Requirements for LB15 (220/440V, 380V, 415V, 600V)

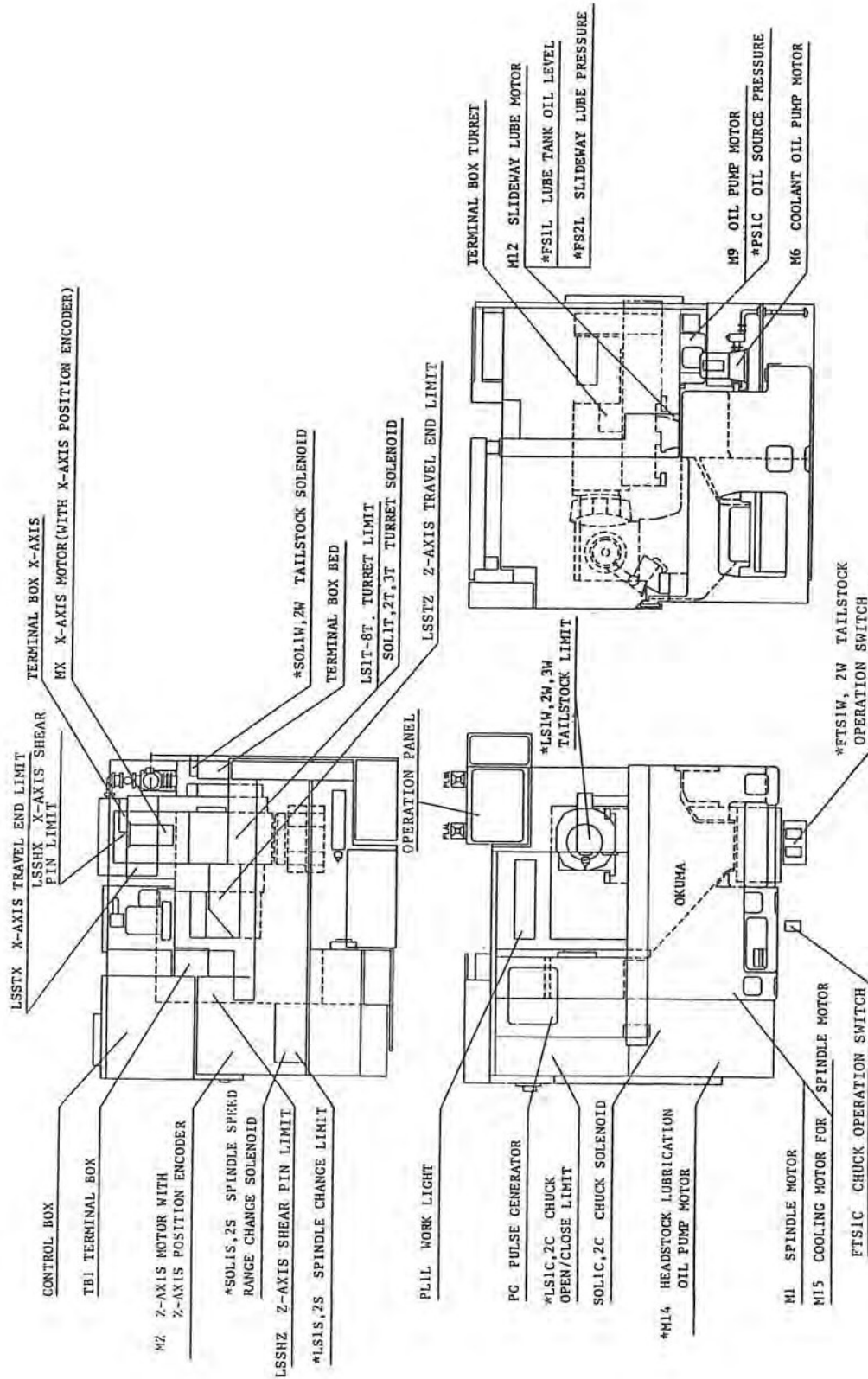
Model	Power required by main motor kW (hp)	Power required by auxiliary equipment drive motor kW (hp)	Axis drive motor kW (hp)	NC unit	Apparent power KVA	Rated power kW (hp)	Rated current of main circuit breaker Amp.	Facility to be prepared by user (Note 1)		
								Branch circuit breaker or fuse Amp.	Cable size mm ²	
LB15	VAC 7.5/5.5 (10/7.5) (8.8 KVA)	Oil hydraulic motor	XA-axis 1.5 (2)		17.6	14.1 (18.8)	100	(220V)	22 - 30	
		Coolant	ZA-axis 2.4 (3.2)					(380V)	50	
		Lubrication						(415V)	50	
								(440V)	50	
								(600V)	35	
		Spindle lubrication						(220V)	100	22 - 30
	VAC 11/7.5 (15/10) (12 KVA)	Total	Total 3.9 (5.2) (5.07 KVA)	1.5 KVA	20.8	16.7 (22.3)	100	(380V)	75	16 or more
								(415V)	75	
								(440V)	50	10 or more
								(600V)	35	8 or more

Note:

- Facilities to be prepared by user should conform to the applicable regulations, and this only indicates the values for reference.
- $VA = 1.4 \times kW$ (for DC motor) and $VA = 1.3 \text{ kW}$ (for axis drive motor BL-ACT)
- $VA = 1.2 \times kW$ (for AC motor)
- $VA = 1.6 \times \text{Continuous rated power (kW)}$ (for spindle drive motor (VAC))
- Rated power = Apparent power \times power-factor $\cos\phi$ where, $\cos\phi = 0.8$

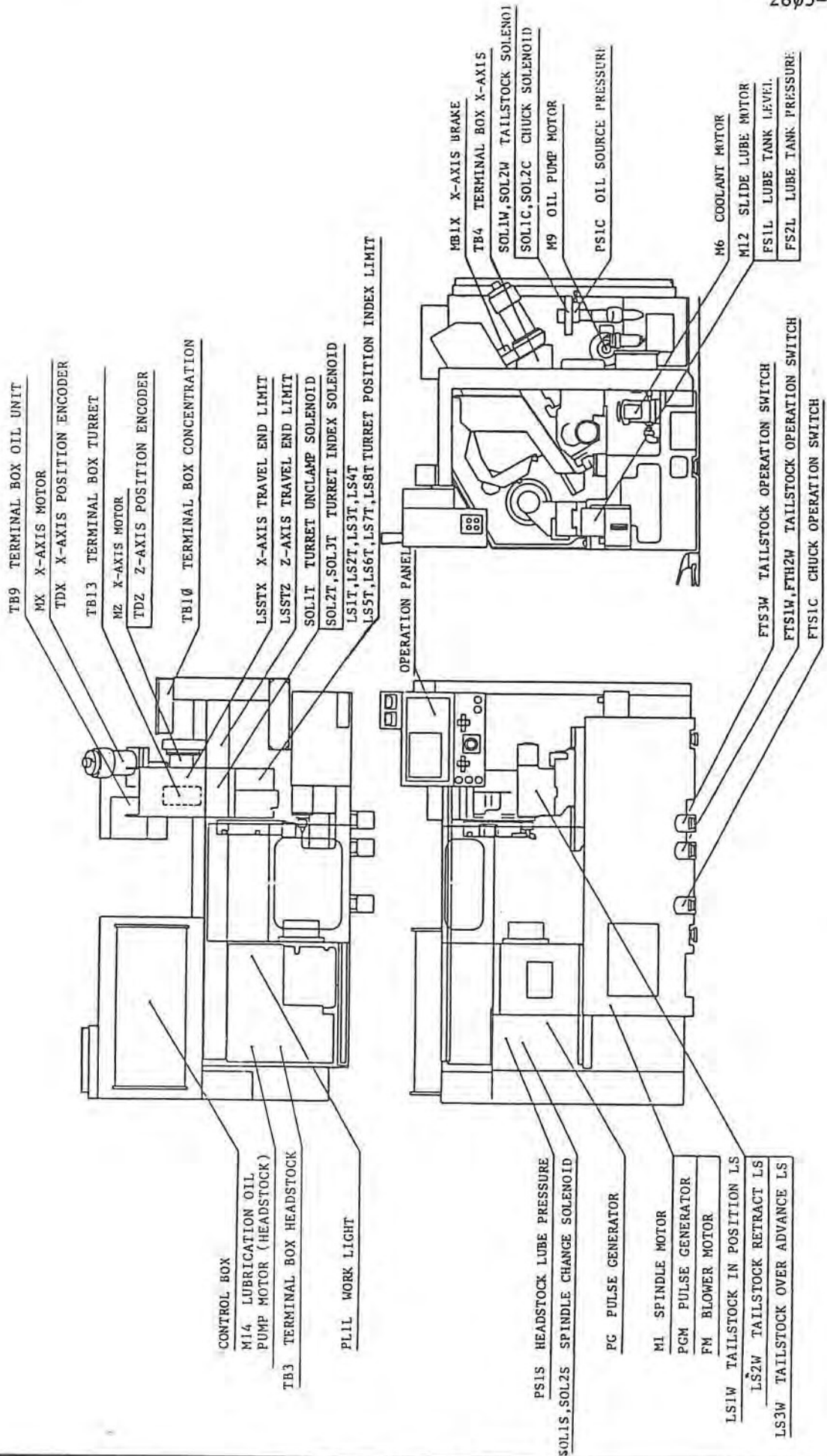


Appended Fig. 1 Operation Panel (OSP500L-G)



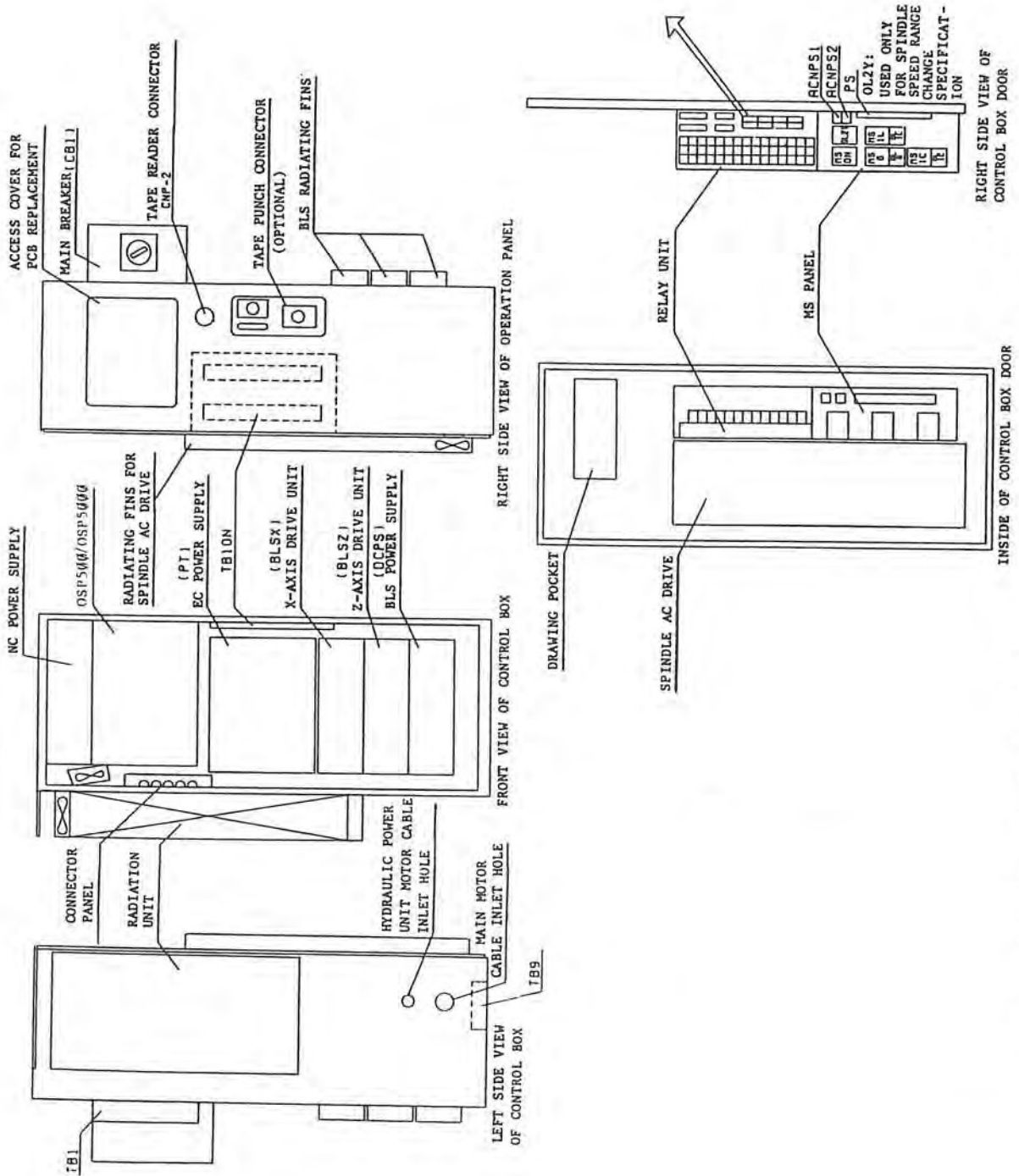
Note:
*: Optional

Appended Fig. 3 Layout Diagram of Machine-mounted Electricals (LB10)

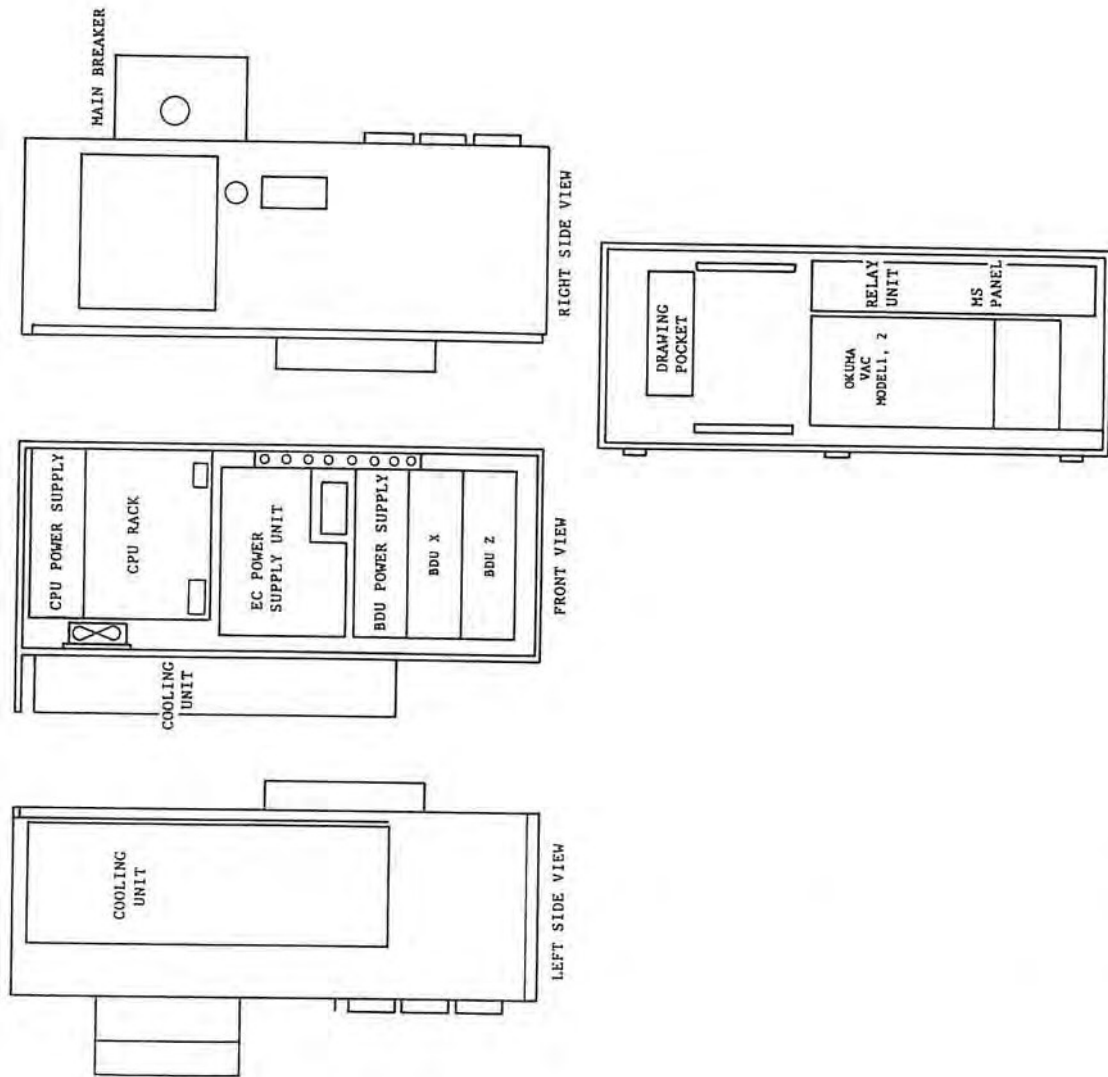


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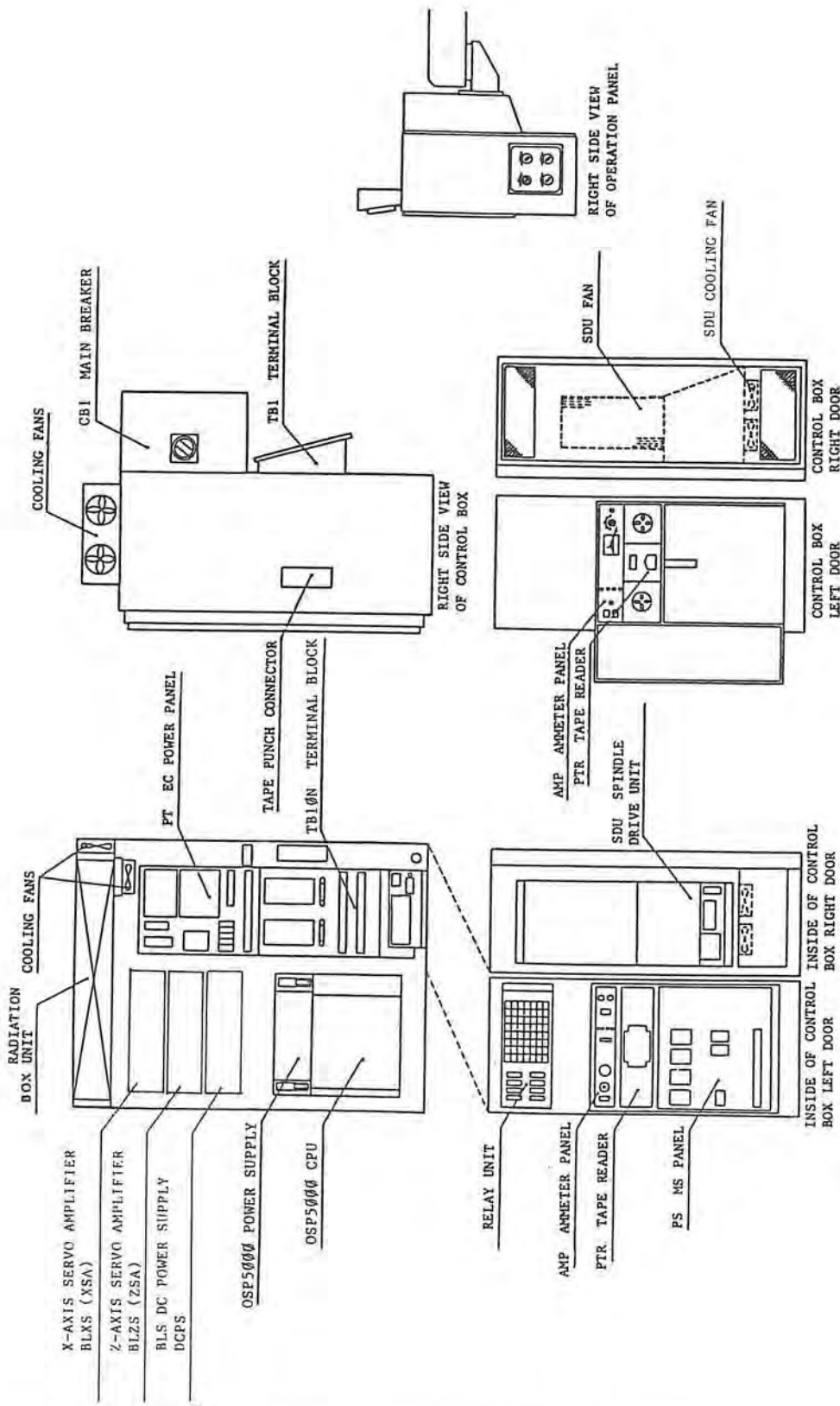
Appended Fig. 5 Layout Diagram of Machine-mounted Electricals (LB15)



Appended Fig. 6 Internal Layout of OSP500L-G/OSP500L-G CNC Unit (LB10)



Appended Fig. 7 Internal Layout of OSP500L-G/OSP5000L-G CNC Unit (LB12)



Appended Fig. 8 Internal Layout of OSP5000L-G/OSP5000L-G CNC Unit (LB15)