

## CHECKING SWITCH SELECTIONS ON OGM" MACHINES

- 1) Press both arrow keys below the CRT at the same time.
- 2) Press soft key labeled [system] **Note:** if [system] is not a choice, press left arrow key
- 3) Press soft key labeled [CHAP] THEN PRESS SOFT KEY labeled [PMC]
- 4) Press soft key labeled [PM C DGN] Then press soft key labeled [STATUS]
- 5) Key in switch's I/O address check schematics for address as example in Figure 1

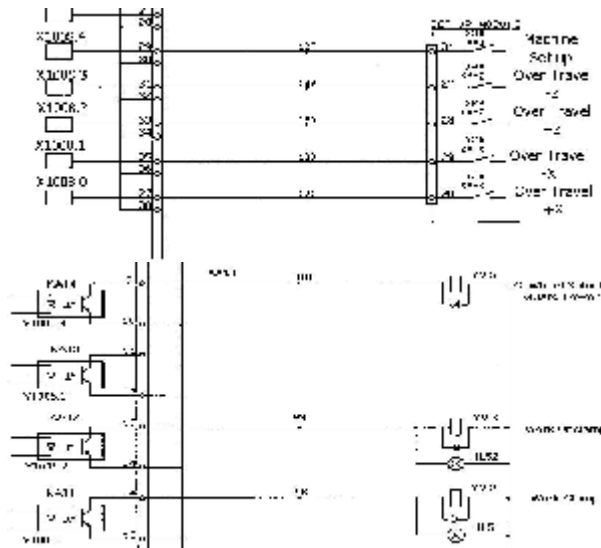


Figure 1

### EXAMPLE: MODE SELECT FOR OGMIS AT ADDRESS X1008 BITS 2,1,&0 PMC DATA KEY FUNCTIONS FOR "OGM" MACHINES

TOTAL STOCK REMOVAL	X	Press to display "X" on CRT
TOTAL FINE FEED AMT	Y	Press to display "Y" on CRT
ROUGH AIR CUT AMT	R	Press to display "R" on CRT
FINE AIR CUT AMT	F	Press to display "F" on CRT
ROUGH INFEEED SPEED	G	Press to display "G" on CRT
FINE INFEEED SPEED	G	Press to display " " on CRT
BLANK KEY		PAGE DOWN

- 6) Type in the I/O address the Press soft key labeled [SEARCH]

ADDRESS	7	6	5	4	3	2	1	0
X1006		{		}				
			<i>TEACH</i>					
X1007	{			}	{			}
		<i>FINE INFEEED</i>			<i>ROUGH INFEEED</i>			
X1008	{			}	{			}
		<i>FEEDRATE OVERRIDE</i>			<i>MODE SELECT</i>			
X1009	{			}	{			}
		<i>GRIND MODE</i>			<i>SPARK OUT</i>			

**TEACH SWITCH (SA15) [0=OFF/1=ON] FINE INFEED SWITCH (SA6)**

<i>[X1006 BITS 6,5,&amp;4]</i>	6	5	4
DRESS (X)	0	0	0
DRESS RIGHT	0	0	1
DRESS LEFT	0	1	1
TABLE RIGHT	0	1	0
TABLE LEFT	1	1	0
GRIND START	1	1	1
SIZE	1	0	1
CLEAR O. D.	1	0	0

<i>[X1007 BITS 7,6,5,&amp;4]</i>	inch	(metric)	7	6	5	4
.1	(.1)	0	0	0	0	0
.2	(.2)	0	0	0	1	
.3	(.5)	0	0	1	1	
.4	(1)	0	0	1	0	
.5	(2)	0	1	1	0	
.6	(3)	0	1	1	1	
1	(4)	0	1	0	1	
2	(5)	0	1	0	0	
3	(6)	1	1	0	0	
4	(8)	1	1	0	1	
5	(10)	1	1	1	1	

**ROUGH INFEED SWITCH (SA5) [0=OFF/1=ON]**

<i>[X1007 BITS 3,2,1,&amp;0]</i>	inch	(metric)	3	2	1	0
.2	(1)	0	0	0	0	0
.5	(2)	0	0	0	1	
1	(3)	0	0	1	1	
2	(4)	0	0	1	0	
3	(5)	0	1	1	0	
4	(6)	0	1	1	1	
5	(8)	0	1	0	1	
6	(10)	0	1	0	0	
7	(15)	1	1	0	0	
8	(20)	1	1	0	1	
9	(25)	1	1	1	1	
10	(30)	1	1	1	0	
12	(35)	1	0	1	0	
15	(40)	1	0	1	1	
20	(50)	1	0	0	1	

**MODE SELECT SWITCH (SA7) [0=OFF/1=ON]**

<i>X1008 BITS 2,1,&amp;0]</i>	2	1	0
AUTO	0	0	0
MAN.	0	0	1
MDI	0	1	1

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TEACH                   0 1 0  
AUTO REF RETURN   1 1 0

## GRIND MODE SWITCH (SA10) [0=OFF/1=ON]

[X1009 BITS 6,5,&4]   6 5 4

MAN. TRAVERSE       0 0 0  
PLUNGE               0 0 1  
BOTH                  0 1 1  
RIGHT                 0 1 0  
LEFT                  1 1 0

## SPARK OUT SWITCH (SA9) [0=OFF/1=ON]

[X1009 BITS 3,2,1,&0]   3 2 1 0

0                   0 0 0 0  
  
1                   0 0 0 1  
2                   0 0 1 1  
3                   0 0 1 0  
4                   0 1 1 0  
5                   0 1 1 1  
6                   0 1 0 1  
7                   0 1 0 0  
8                   1 1 0 0  
9                   1 1 0 1  
10                  1 1 1 1

## FEEDRATE OVERRIDE SWITCH (SA8) [0=OFF/1=ON]

[X1008 BITS 7,6,5,4,&3]   7 6 5 4 3

0                   0 0 0 0 0  
10                  0 0 0 0 1  
20                  0 0 0 1 1  
30                  0 0 0 1 0  
40                  0 0 1 1 0  
50                  0 0 1 1 1  
60                  0 0 1 0 1  
70                  0 0 1 0 0  
80                  0 1 1 0 0  
90                  0 1 1 0 1  
100                 0 1 1 1 1  
110                 0 1 1 1 0  
120                 0 1 0 1 0  
130                 0 1 0 1 1  
140                 0 1 0 0 1  
150                 0 1 0 0 0  
160                 1 1 0 0 0  
170                 1 1 0 0 1  
180                 1 1 0 1 1  
190                 1 1 0 1 0

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1 1 1 1 0

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CHECKING I/O SWITCHES IN FANUC STATUS SCREEN

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