

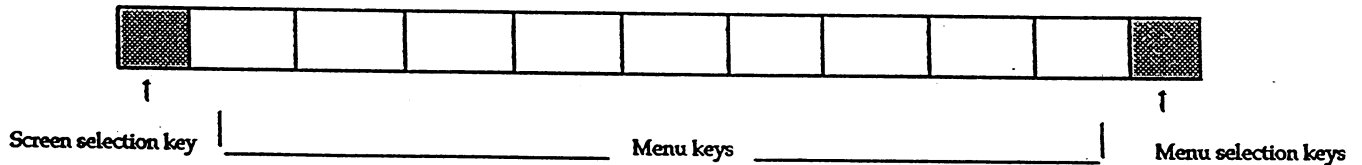
PLUS CODED KEY LOCK/UNLOCK

PROHIBITED OPERATIONS AND SCREENS

- Rewriting of system parameters
- Reading and writing parameters from/to EEROM
- Display of various diagnosis screens
 - option parameters
 - pitch error comp
 - servo parameters
 - spindle parameters
 - cutting parameters

RELEASING OF KEY LOCK

- Select PARAMETER
- Press the menu selector key and input 1131. Press INPUT



- OR -

- Select DIAGNOS screen
- Select VERSION screen
- Menu Select
- 1131 → Input

T-Plus Re-initialization Procedure

(WARNING: RE-INITIALIZATION IS A LAST RESORT WHEN THE SYSTEM IS NOT PREFORMING, AS IT SHOULD. RE-INITIALIZING WILL CLEAR ALL DATA IN S-RAM. All data in the S-RAM (USER PARAMETERS, MACHINE PARAMETERS, TOOL DATA, TOOL OFFSET, TOOL FILE, CUTTING COND., WORK OFFSET, CHUCK JAW DATA, PROGRAM, MACRO VARIABLE and MAINTEN CHECK) should be backed up before continuing.)

1. Put the machine in EMERGENCY STOP with the E-STOP button.
2. Power the NC UNIT off.
3. Set the dip switches (1 & 3 to the right) on the QX141 card found in the NC UNIT.
Note: Make sure all other switches are to the left.
4. Power the NC UNIT on.
Note: The two LED's on QX141 will flash one time indicating completion.
5. Power the NC UNIT off.
6. Set the dip switches (1 & 3 back to the left) on the QX141 card.
7. Power on the NC UNIT.
8. Load Parameters and power NC UNIT off and back on.
9. Re-format the data storage areas by doing the following steps while in the privilege mode (1131):
 - A. Select **DIAGNOS** menu key
 - B. Select **DATA ERASE** menu key.
 - C. Select the following menu keys: (**TOOL DATA, TOOL OFFSET, TOOL FILE, CUTTING COND., WORK OFFSET, CHUCK JAW DATA, >>>, PROGRAM, MACRO VARIABLE, ALARM HISTORY, MAINTEN CHECK** and **SYSTEM PROGRAM**) until all items in the **DATA FORMAT** window are highlighted.
 - D. Input -9999 while in the program enabled mode.
 - E. Power the NC UNIT off.
 - F. Power the NC UNIT on.
 - G. Reload the data back in to the NC UNIT (**TOOL DATA, TOOL OFFSET, TOOL FILE, CUTTING COND., WORK OFFSET, CHUCK JAW DATA, PROGRAM, MACRO VARIABLE, and MAINTEN CHECK**)