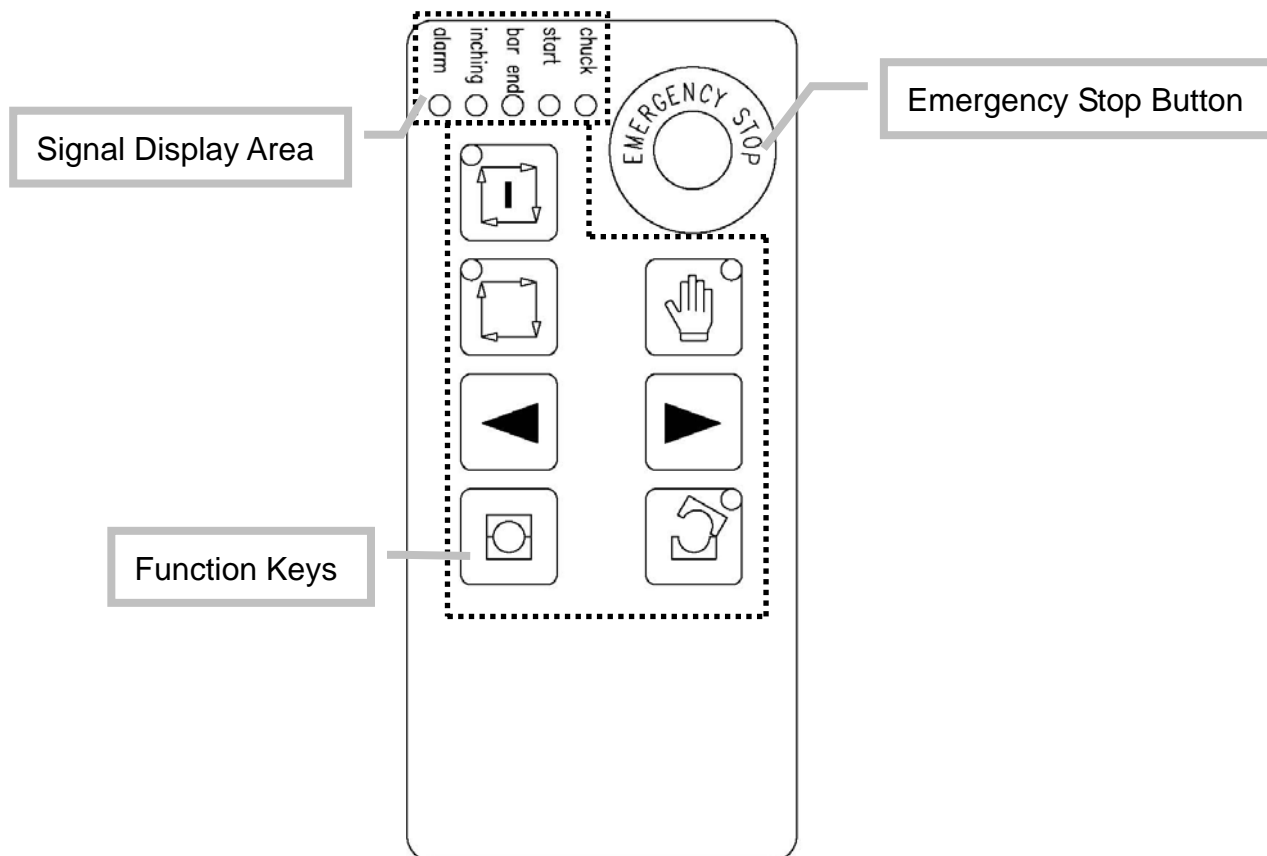


## 8 OPERATIONS

### 8.1 REMOTE CONTROL OPERATION

The remote control offers interface signal indicating LEDs and buttons for operating the bar feed system when it's in MANUAL mode.



#### 8.1.1 Signal display area

**CHUCK:** Indicates the lathe chuck is open/closed when the LED is ON/OFF.


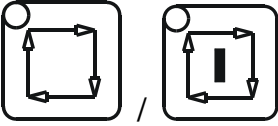




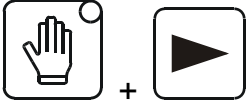
**START:** Indicates the START signal is ON/OFF when the LED is ON/OFF.


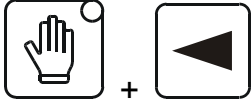

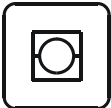
**BAR END:** Indicates the BAR END signal is ON/OFF when the LED is ON/OFF.

**INCHING:** Indicates the INCHING signal is ON/OFF when the LED is ON/OFF.

**ALARM:** Indicates the ALARM signal is ON/OFF when the LED is ON/OFF.

## 8.1.2 Buttons

	<p><b>Emergency stop</b></p> <p>When a dangerous situation arises, pressing the emergency stop button immediately interrupts the bar feeder. The bar feeder will send alarm signal to the lathe and interrupt the lathe if interface is wired accordingly. Error message e01 will be shown on the HMI display.</p> <p>To cancel the alarm, release the button by rotating it clockwise and pressing the <b>MANUAL</b> mode key.</p>
	<p><b>Auto ready/ Auto start</b></p> <p>To switch the bar feeder to <b>AUTOMATIC</b> mode, please press "Auto ready  (PLC X17)" then "Auto start  (PLC X20)" button in 3 seconds, the key LED are ON. The bar feeder will be switched to <b>AUTOMATIC</b> mode.</p> <p>To switch to <b>AUTOMATIC</b> mode, one of the following conditions must be fulfilled :</p> <ul style="list-style-type: none"> <li>• The channel is closed and the pusher is NOT at home position.</li> <li>- OR -</li> <li>• The channel is open and the pusher is at home position and the measurement device in upper position (sensor SQ1 ON).</li> </ul>
	<p><b>Manual</b></p> <p>This button offers two functions :</p> <ul style="list-style-type: none"> <li>• Switch the bar feeder to <b>MANUAL</b> mode. When the bar feeder is in <b>MANUAL</b> mode, the key LED is ON and the user could operate the bar by function keys.</li> <li>• Reset the bar feeder from an emergency stop.</li> </ul>
	<p><b>Rightward</b></p> <p>Move pusher rightward. Only available when the bar feeder is in <b>MANUAL</b> mode.</p>
	<p><b>Slow Rightward</b></p> <p>Move the pusher rightward with 10% of the general forward speed. Only available when the bar feeder is in <b>MANUAL</b> mode.</p>

	<p><b>Leftward</b> Move the pusher leftward. Only available when bar feeder is in <b>MANUAL</b> mode.</p>
	<p><b>Slow Leftward</b> Move the pusher leftward with 10% of the general forward speed. Only available when the bar feeder is in <b>MANUAL</b> mode.</p>
	<p><b>Open Channel</b> This button offers three functions :</p> <ol style="list-style-type: none"> <li>1. When pusher is at home position and bar feeder is in <b>MANUAL</b> mode, press this button and channel will open by proceeding sequence below automatically : <ul style="list-style-type: none"> <li>• The long pusher moves forward to P08 extract setup position.</li> <li>• Vice clamps to check for removing remnant from finger chuck. Then pusher returns to home position.</li> <li>• The channel opens.</li> </ul> </li> <li>2. If pusher is not at home position, it should reach at FIRST FEED +150mm to open channel.</li> <li>3. Load bar</li> </ol> <p>When the channel is open, press the button again to load a bar and reset the measurement device.</p>
	<p><b>Close Channel</b> This button offers two functions :</p> <ol style="list-style-type: none"> <li>1. When pusher is less than First feed position and bar feeder is in <b>MANUAL</b> mode, press this button and channel will close by proceeding sequence below automatically: <ul style="list-style-type: none"> <li>• The short pusher moves forward to exceed First feed position.</li> <li>• Then the short pusher returns to home position.</li> <li>• Channel close and the pusher charges forward for insertion.</li> </ul> </li> <li>2. If pusher is already exceeds First feed position, it should reach at FIRST FEED +150mm to close channel.</li> </ol>