

HYUNDAI-KIA VX400/500 START UP

(3/11/2010)

Application Notes

Based on our findings with current installed VX400/VX500 machines, we revise the start up procedure as follows. This would address some of the confusions associated with the tool height setup when using INP.C soft key. The Note area also includes the keep relay information to shut spindle when operator hit [RESET] button. Please go over and leave this bulletin with customer during initial machine installation.

1. Main Cabinet Power Switch On.
2. Push [ON] button on the machine control panel, wait until CNC monitor comes online.
3. Pull out the [EMERGENCY STOP], push [SATNDBY] key to bring machine servo online.
4. Go to JOG mode, jog XYZ away from the travel limits.
5. Push [ZERO RETURN] key, then X, Y and Z reference key, then cycle [START] key, machine should reference itself and park at machine zero position.
6. Go to [POS] key on the FANUC panel, and find display of relative position [REL], find soft key (the rubber keys under the LCD screen)[OPRT] then [ORGIN] then [ALLAXE], this will set all relative position to zero.
7. Machine is ready for operation.

Note:

1. During machine shut down, operator can park spindle anywhere.
2. When use INP.C to set tool height, it grabs the value from relative position. Typically relative position is left alone, therefore remains the same as machine position, but if operator used relative position and set it something different, beware to recover it to match the machine position when set tool height using INP.C. **Otherwise the tool height would be WRONG.**
3. The machine default leaves spindle running when operator hit [RESET] button, inconsistent with most of FANUC based VMC, to alter this setting. Change parameter D109 bit 6 from 0 to 1, (same as add 64 to D109). Please have certified service personnel do this, this only need to be done once in the initial machine setup.