

		drawing back.	RESET to get the tool magazine back.
3	Axis Trouble	Over limited	1. Press "O.T.REL" key, use the handwheel rotate the axis to reverse direction. 2. Check if the limit switch is broken.
		Can't back to zero	1. Check the limit switch is right set in the software or not 1、 Adjust or replace the ZERO block or SWITCH
		Noise for Axis	1.Clean the axis cover, 2.Change the bearing 3.If it is from Z axis, check it is loosen for the hammer and guide way is loosen or not. Check if the hammer chain and guide wheel is wearing or not.
4	Spindle Trouble	Spindle Noise	1. Lubricate the spindle belt 2. Adjust the belt tension 3. Replace the spindle belt or spindle.
5	Coolant pump trouble	Can't drain	1. Check if the coolant liquid is enough or not. 2. Input water to exclude the air inside the coolan tank 3. Check the power sequence. 4. Check the thermal relay 5. Replace the coolant
6	Lubrication pump Trouble		1. Check if the lubrication oil is enough or not. 2. Check the oil filter 3. Check if the oil is SHELL TONA68 or equal one 4. Adjust or replace the valve. 5. Replace the pump.

**2. PLC Alarm**

AlarM Code	Explnation	Solution
1000. EMG STOP OR OVERTRAVE	Emergency stop	Check if X8.4 is written or not.
1001. AXIS NOT HOME	Axis not home	Use handwheel move axis back home.
1002. MC OL	Machine Alarm	System alarming, check manual for FANUC/MITSUBISHI
1003. LUBE LEVLE LOW	Lubrication oil alarm	Input the oil or replace the pump
1004. AIR PRESSURE LOW	Low air pressure	Check air pressure
1005. SP COOLER ALARM	Spindle oil Coolant	Input spindle coolant oil or replace the oil.
1006. HYDRAULIC PUMP PRESSURE LOW	Oil pressure Low-Chose function	Input oil
1007. WORN GEAR	Choose the high/Low speed incorrectly	Adjust the sensor switch.
1008. AXIS OT	Axis limit over	Press "O.T.REL" and make the axis rever
1009. BATTERY ALARM	Battery alarm	Replace battery
1010. MAG NOT BACK	ToolMagazine back home signal cannot be found---Choose function	Check the sensor switch
1011. ATC MOTOR OL	Tool magazine motor is over loaded	Check the thermal relay inside the electric cabinet
1012. COOLANT MOTOR OL	Coolant motor over loaded	Check the thermal relay inside the electric cabinet
1013. CHIP CONVEYOR OL	Check chip conveyor motor over loaded	Check the thermal relay inside the electric cabinet
1016. T CODE ERROR	T code error	Check T code
1017. SPINDLE NOT ORIENTATION	Spindle is not positioned	Move Z axis downward manually until the alarm disappear
1018. ARM NOT IN ORIGIN	The arm is NOT in middle position	Move the arm manually
1018. ARM NOT IN ORIGIN	No signal for the arm	Check if the sensors are broken or not
1019. Z AXIS NOT IN ATC POSITION	Z axis can't reach ATC	Check if the 2 <sup>nd</sup> home point of Z axis signal F96.2 is right or not