

#### 4.3.8 INTERNAL TOGGLE SWITCHES (CONT'D)

If the machine control station is provided with the switches that turn on and off the above functions, the state of a switch on the machine's control station is ORed with that of the NC operator's panel to determine the state finally.

| Setting data | Machine's switch | Result on/off |
|--------------|------------------|---------------|
| "0" = OFF    | OFF              | OFF           |
| "0" = OFF    | ON               | ON            |
| "1" = ON     | OFF              | ON            |
| "1" = ON     | ON               | ON            |

The functions of the internal toggle switches work only when parameter #6006D3 = 1 (internal toggle switch function on). If it is off, only the switches of the machine control station work.

#### 4.3.9 OPERATION TIME DISPLAY

The system counts the duration of automatic operation and it may be displayed. This function permits the display of the time it has been taken for a piece of work or the total operational time of the system.

##### 1. Procedure of display

Depress the ALM key, then select a screen of running time with the PAGE  
↓ key as shown below.

Three kinds of operation time will be displayed in hours, minutes, and seconds.

Top: Total operating time after POWER ON

Middle: Total operating time of CYCLE START

Bottom: Total operating time of FEED

##### 2. Resetting display

Each time of operational time may be reset independently by the following procedure.

When operating times are displayed:

- A. "1" "ORG" POWER ON time at the top will be reset.
- B. "2" "ORG" CYCLE START time in the middle will be reset.
- C. "3" "ORG" FEED time at the bottom will be reset

The timers of operation time preserve data unless they are reset, even after power is turned off.

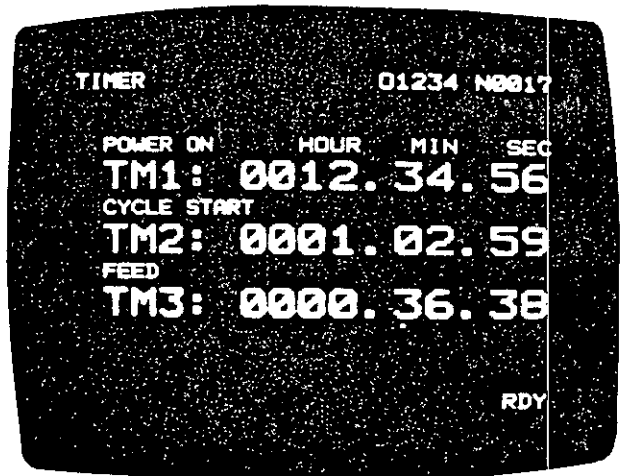


Fig. 4.29

#### 4.3.10 ADDRESS SEARCH

Search continues until a data (character string) held on tape or in the memory which coincides with the data (character string) entered through the NC operator's panel is found. The contents of tape will be searched in TAPE mode and those of the part program memory in MEM or EDIT mode.

##### 1. Operation

- A. Select TAPE, MEM, or EDIT mode.
- B. Depress the PROG function key.
- C. Depress the RESET key. "LSK" appears and the pointer returns to the top of the program number in MEM mode.
- D. Enter the data (string of not more than 10 characters headed by address) to be searched.
- E. Depress the CURSOR  
↓ key. Search starts. "AS" blinks during search.

##### 2. End of search

- A. "AS" disappears when search is completed.
- (1) In TAPE mode, the tape pointer points to the character that immediately follows the data found and the tape stops.

