

## SECTION 2 POWER ON/OFF OPERATION

This section describes the basic power ON/OFF operation procedures.

### 1. Turning on the Power

Procedure:

- (1) Press the CONTROL ON switch to turn it ON.

Power is turned on to the NC and the system software, resident in the memory is loaded to the RAM area. While the software is being loaded, the file names are displayed on the screen. After the completion of loading of the system software, initial setting is made for the peripherals. Upon completion of initial setting of the peripherals, the screen as indicated below is displayed. The NC can now operate correctly.

CONTROL ON



AUTO OPERATION				N	10	
				97/07/15 14:10:00		
X	2299.582	O				
Y	3385.812	N	CO 3			
Z	-1883.255	F	0.0 H	O		
		S	0 D	O		
=						
PROGRAM SELECT	ACTUAL POSIT.	PART PROGRAM	BLOCK DATA	SEARCH	CHECK DATA	[EXTEND]
F1	F2	F3	F4	F5	F6	F7 F8

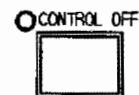
[Supplement] If an alarm or error occurs instead of the display of the screen as indicated to the right, take proper corrective measures by referring to the separately prepared manual, "ALARM & ERROR LIST".

## 2. Turning off the Power

Procedure:

- (1) Make sure that all machine actuators have been stopped.
- (2) Press the CONTROL OFF switch to turn it OFF.

If peripherals are connected to the NC, turn off power to these peripherals.



: The NC backs up the data such as tool length offset data, cutter radius compensation data, work coordinate system offset data, and parameter data (excluding the system parameters) in predetermined intervals. Therefore, if power is turned off just after changing such data, the new data may not be backed up and the previous data might remain unchanged.

In such a case, execute the backup command before turning off the power to ensure that the data is changed without fail.

For backup operation, refer to III. DATA OPERATION, Section 1, 3-4-1. "Back Up Command".

## 3. Emergency Stop

If it becomes necessary to stop the operation immediately, press the EMG. STOP switch. The machine stops immediately when the EMG. STOP switch is pressed.

The push-to-lock type switch is locked if the switch is pressed; to unlock the switch, turn it in the direction indicated by the arrow symbol. After unlocking the emergency stop switch, reset the NC and the NC is placed in the operation ready state.

