MAINTENANCE INSTRUCTION

Desc: Procedure   Rev.: A 5-9-11

Step #	Description of work steps (What)	Key points (How)	Reason (Why)
		Maintenance Procedure	
1	Cycle Power: Power the machine down all the way than back on.	Turn power off on the controller then turn power off to the machine. **ON** **OFF** Reverse this process to turn the machine back on.	To reset the machine.
2	Input Bypass: 1-)Select the Parameters Soft Key		To allow I/O Write access
	2-) Right Arrow Soft Key.		To allow you to input commands into the controller.
	3-) Type 1131 then select Input.		Allows I/O Write access.

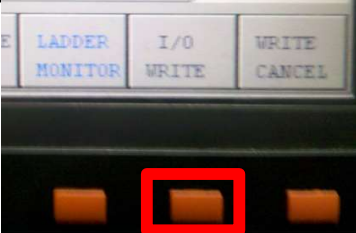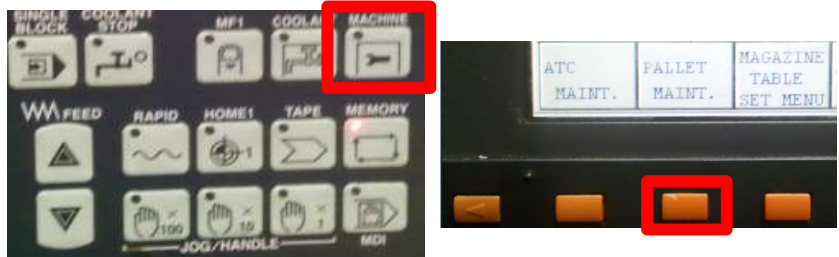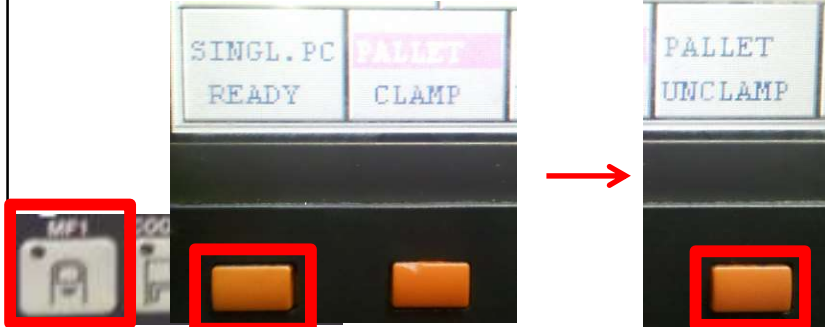Desc: Procedure   Rev.: A 5-9-11

Step #	Description of work steps (What)	Key points (How)	Reason (Why)
		Maintenance Procedure	
3	I/O Write: 1-) Select Diagnos 2-) Select PLC Signal		
	3-) Select Version 4-) Select Diagnos Monitor		
	5-) Select I/O Write Type M6810-1 Then Input		To Override all alarms and Manually adjust Pallet Changer
4	Pallet Unclamp: 1-) Select Machine Button 2-) Pallet Maintenance		

Desc: Procedure   Rev.: A 5-9-11

Step #	Description of work steps (What)	Key points (How)	Reason (Why)
		Maintenance Procedure	
	3-) Hold MF1 and press Select signal ready. 4-) Select Pallet Unclamp		Unclamping the pallet will allow the MJR-2 Controller to move the pallet changer.
5	Open MRJ-2 Program: 1-) Open MR-J2 Program by using the cursor. 2-) Select Set-Up Axis drop down 3-) Select 2 Pallet Changer(2)		

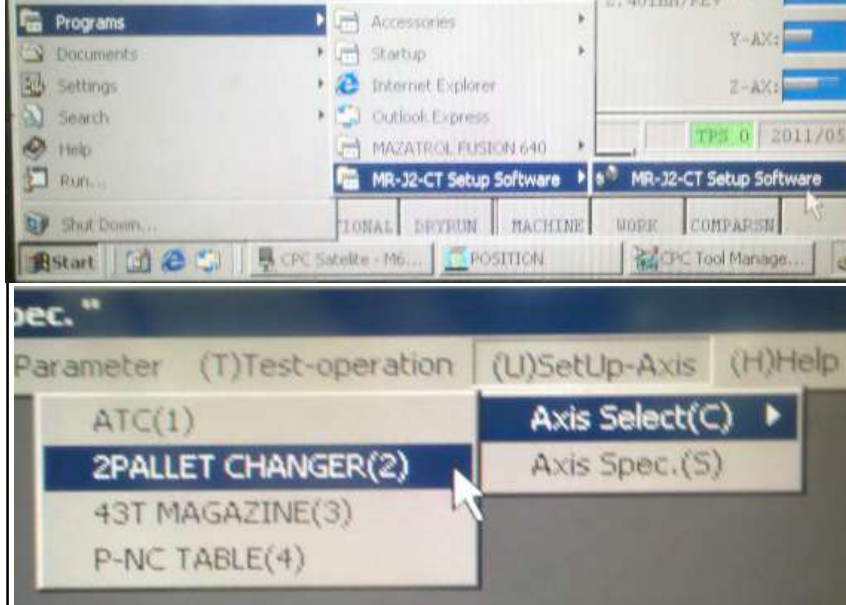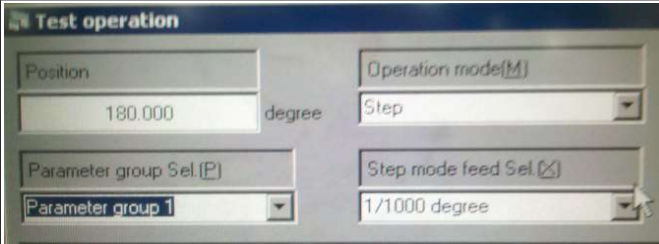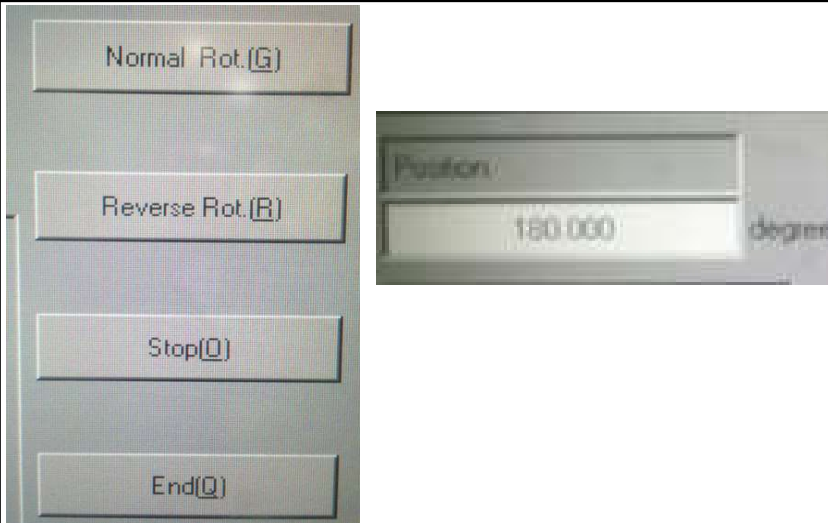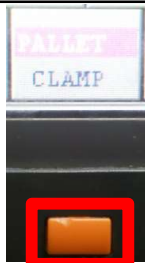Desc: Procedure   Rev.: A 5-9-11

Step #	Description of work steps (What)	Key points (How)	Reason (Why)
		Maintenance Procedure	
	3-) Select Test Operation 4-) Select OK on the pop-up window 5-) Select STEP in Operation Mode 6-) Select the appropriate Step Mode Feed		
	Moving Pallet: 7-) Click on the "Normal Rot" button until the Position reads: **180° for Pallet #2 0°/360° for Pallet #1** **NOTE: Adjust Step Mode Appropriately to seed this process up.** 8-) Select "Stop" Button once the display reads 180° / 0° 9-) Select "End" then exit the MRJ-2 Program.		
7	Clamp Pallet: 1-) Select the Pallet Clamp 2-) Repeat Step #1 (Cycle Power) 3-) Restart machine cycle		Clear out all Overrides