

KEY OPERATING

⚠️ BEEN MADE ON THE BASIS OF X-AXIS,
UES (Y, Z) KEY INSTEAD OF X KEY IN THE
CASES OF Y, Z

WORKS	OPERATING PROCEDURES
• PRESET	☞ X PRE SET Input Figures ENT Or X PRE SET Input Figures +/- ENT
• PRESET RECALL	☞ X PRE RCL
• DISPLAY ZERO	☞ X X Or X ZERO F 0
• INITIALIZING	☞ F 5 0 1 ENT
• ADDITION (Adding up)	☞ X + Input Figures ENT
• REDUCTION (Subtraction)	☞ X - Input Figures ENT
• 1/2 DIVISION	☞ X 1/2
• CONVERTING INCH/MM	☞ INCH
• INPUT ABSOLUTE ZERO POINT	☞ { ABS F X Input Numbers X X (As absolute position is "0.000" basis) ABS F X Input Numbers PRE SET Input Figures ENT (As absolute position is NOT "0.000" basis)
• RECALLING OFF ABSOLUTE ZERO POINT	☞ ABS F X Input Numbers ↪ MAXIMUM INPUT IS 10
• SET AND RECALL MEMORY	☞ F X 1 0 0 ENT Input Memory Address ENT Input Figures ENT (As Maximum memory is 50 per a Axis)
• DELET MEMORY	☞ F X 2 0 0 ENT (As Delet all Axis - 50)
• ADDING Y AND Z AXIS (FOR LATHE)	☞ F 3 0 0 NEXT ENT
• DOUBLE COUNTING (FOR LATHE)	☞ F X 4 0 0 ENT NEXT ENT
• DIVIDING A CIRCLE	☞ CIRCLE Input Radial (r) or Diameter (d) ENT ↓ Input number of dividing (d-no) ENT ↓ Input Start angle (Sph) ENT ↓ Input Ending angle (Eph) ENT (REF.: The setting of Dividing Circle is as follows when it comes from factory. • Radia(r) • X, Y Axis)
• SETTING TO X,Y AXIS	☞ F 6 0 0 ENT
• SETTING TO X,Z AXIS	☞ F 6 0 1 ENT
• SETTING TO Y,Z AXIS	☞ F 6 0 2 ENT
• SETTING TO DIA/RAD	☞ F 6 0 3 ENT
• CHANGING AXIS DIRECTION	☞ F X 8 0 0 ENT NEXT ENT



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WORKS	OPERATING PROCEDURES
• COMPENSATION RATIOS	<p> F X 9 0 0 ENT Input Figures for compensating ratio: ENT</p> <p>Figures for compensation ratios = $\frac{RD}{MD}$ RD : Distance of check master(real distance) MD: Measured Distance of digital counter</p>
• EDM	<p> EDM AUTO Input Figures ENT NEXT (As input only one digit , STEP1 Lamp goes on)</p> <p>EDM AUTO Input Figures NEXT ENT NEXT</p> <p>(As input over one digit, over one STEP Lamps go on)</p>
• SET DIRECTION " UP "	<p> F 5 0 2 NEXT ENT (Shows "dir up-" on Z-axis of display)</p> <p>F Z 8 0 0 ENT NEXT ENT (Z-Axis down, (+)value)</p>
• SET DIRECTION " DN "	<p> F 5 0 2 NEXT ENT (Shows "dir dn-" on Z-axis of display)</p> <p>F Z 8 0 0 ENT NEXT ENT (Z-Axis down, (-)value)</p>
• REVEAL X,Y VALUE OF NORMAL STATE	<p> F (Push, in the EDM mode - displaying X,Y value of normal state)</p>

SYMPTOMS	SOLUTIONS
▶ Counter is not energized. (No-power)	<ul style="list-style-type: none"> • Check power supply cord. • Confirm fuse blown off. • Check if the power cord connection loose.
▶ Fuse is blown off so often.	<ul style="list-style-type: none"> • Check inflow of fluid into keyboard. • Disconnect scale connector from counter and check. • Apply for A/S if there is no problem regardless of the above.
▶ Power ON but displays are blanks.	<ul style="list-style-type: none"> • Check inflow of fluid into keyboard. • Disconnect scale connector from counter and check. • Confirm if the connection is OK..
▶ Poor accuracy.	<ul style="list-style-type: none"> • Check connection between scale and counter. • Check if the mounting bolts are loosened. • Compare checking result after changing defected scale to normal scale. • Check if dirt, cutting fluids or others be stick into scale. Prevent them from getting into so that accuracy can be as usual. • Check if machine has backlash. • Check if scale is damaged from impact or twist.
▶ Numbers are not changed even after moving scale.	<ul style="list-style-type: none"> • Check the rate. • Rate should be "1000000". • Check the connection between conter and scale. <p>F X 9 0 0 ENT 1 . 0 ENT</p>
▶ One axis among three axis doesn't working.	<ul style="list-style-type: none"> • Change defected scale to normal scale and then check.
▶ On displays, "DIA" lamp is ON.	<ul style="list-style-type: none"> • Using lathe function, change it to "RAD" function. <p>F X 4 0 0 ENT NEXT NEXT NEXT ENT</p>
▶ Doubled number is showing on display..	<ul style="list-style-type: none"> • Check "RATE" • Rate should be "1000000". <p>F X 9 0 0 ENT 1 . 0 ENT</p> <ul style="list-style-type: none"> • Check the lamp of "DIA" and change it as follows : <p>F X 4 0 0 ENT NEXT NEXT NEXT ENT</p>
▶ Error used to occur with no matter of machine.	<ul style="list-style-type: none"> • Compensate with "RATE" function. <div style="border: 1px solid black; padding: 5px; margin: 5px 0;"> $FCR = \frac{RD}{MD}$ <p style="font-size: small; margin: 0;">FCR : Figures for compensation ratios RD : Distance of check master MD : Measured Distance of digital counter</p> </div> <p>EX 1) $\frac{20}{19.1000} = 1.047120$ EX 2) $\frac{20}{20.0500} = 0.997506$</p>
▶ Remarks.	<ul style="list-style-type: none"> • Prevent cutting fluids from getting into keyboard to avoid errors. • Be careful not to inflow cutting oil and dirt into the scales.