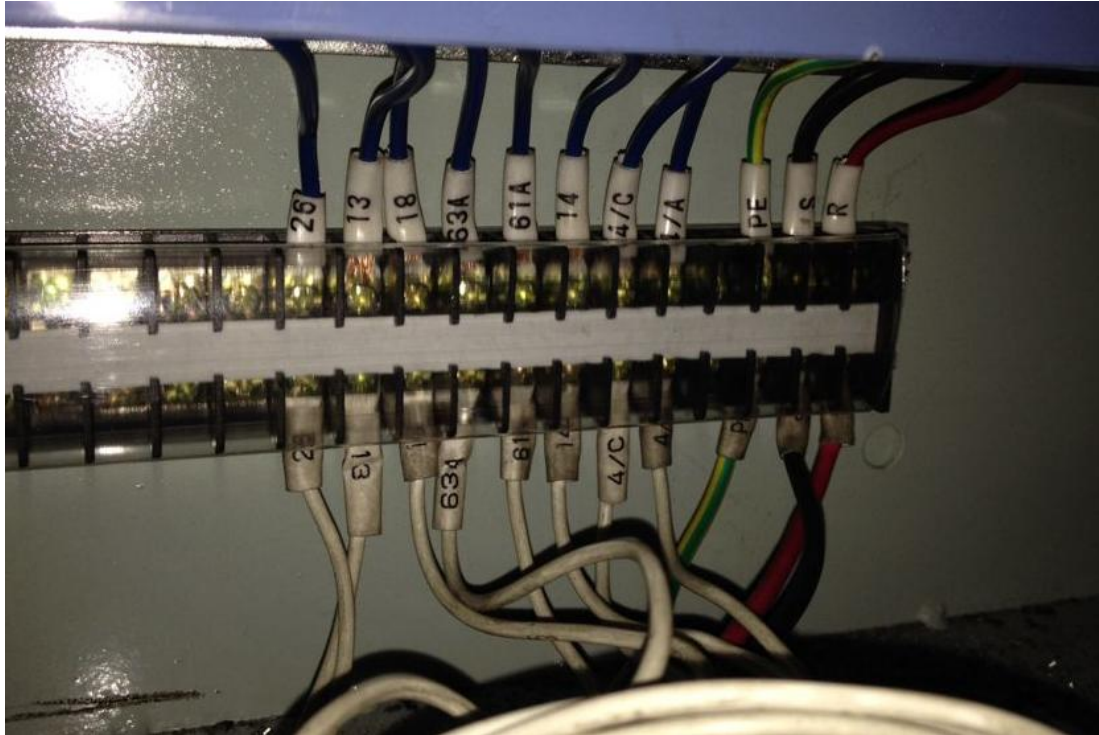


Easy-operation manual for auto bar

1 Connecting the wires according to marked numbers in the electrical cabinet

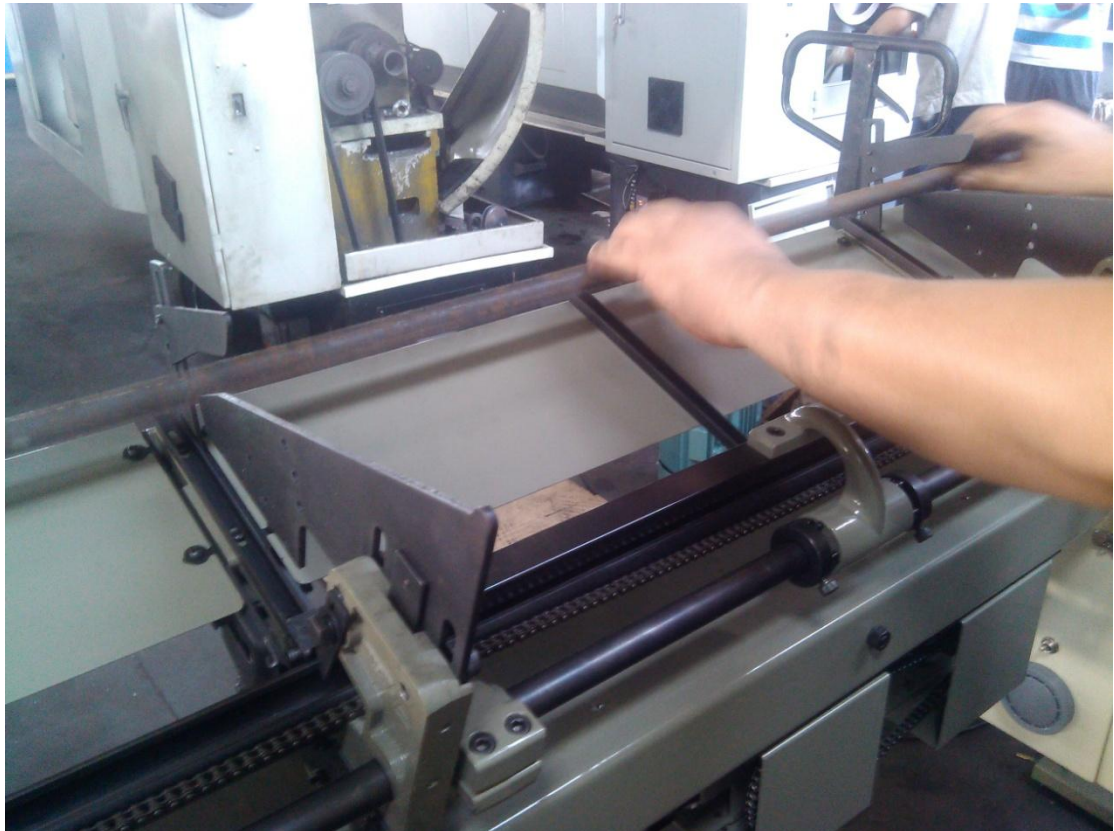


2. Start the machine,operate M13 on MDI mode.

3. Adjust the auto bar centering from the operation manual and also assembly the lock mouth.Then start the auto bar feeding as below picture:

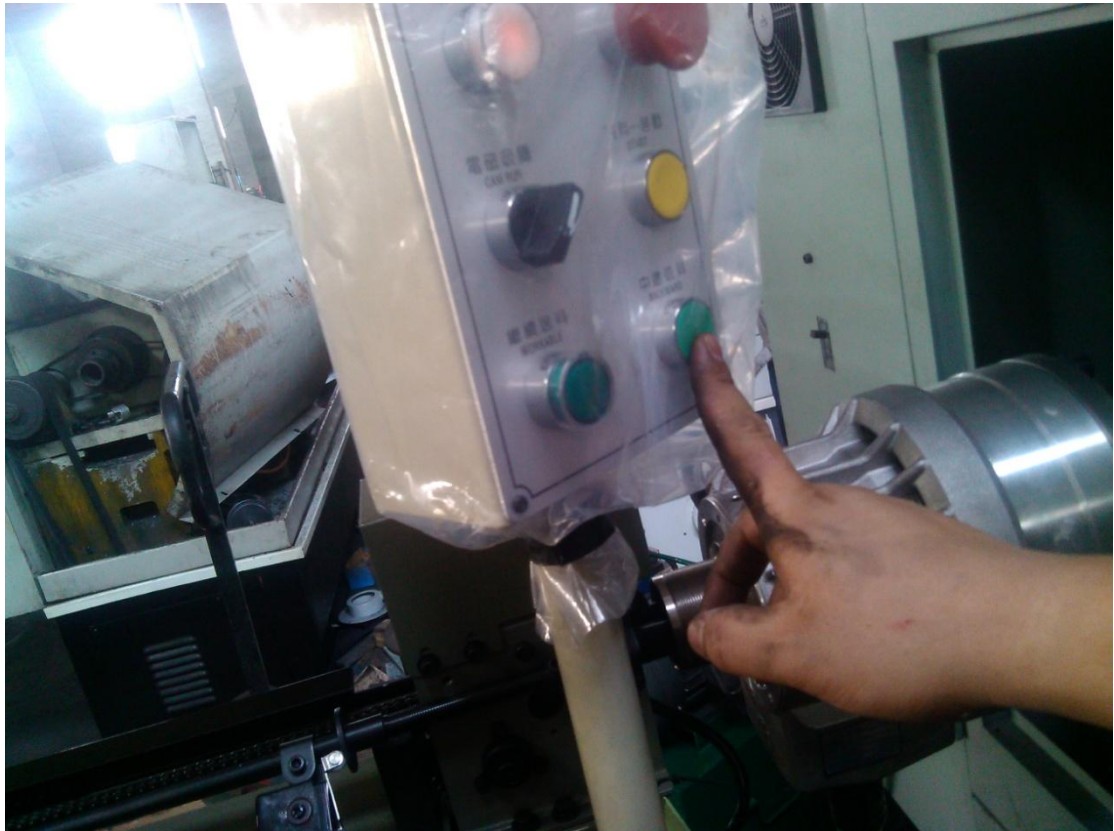


4. Put in the workpiece (Several pieces is available)

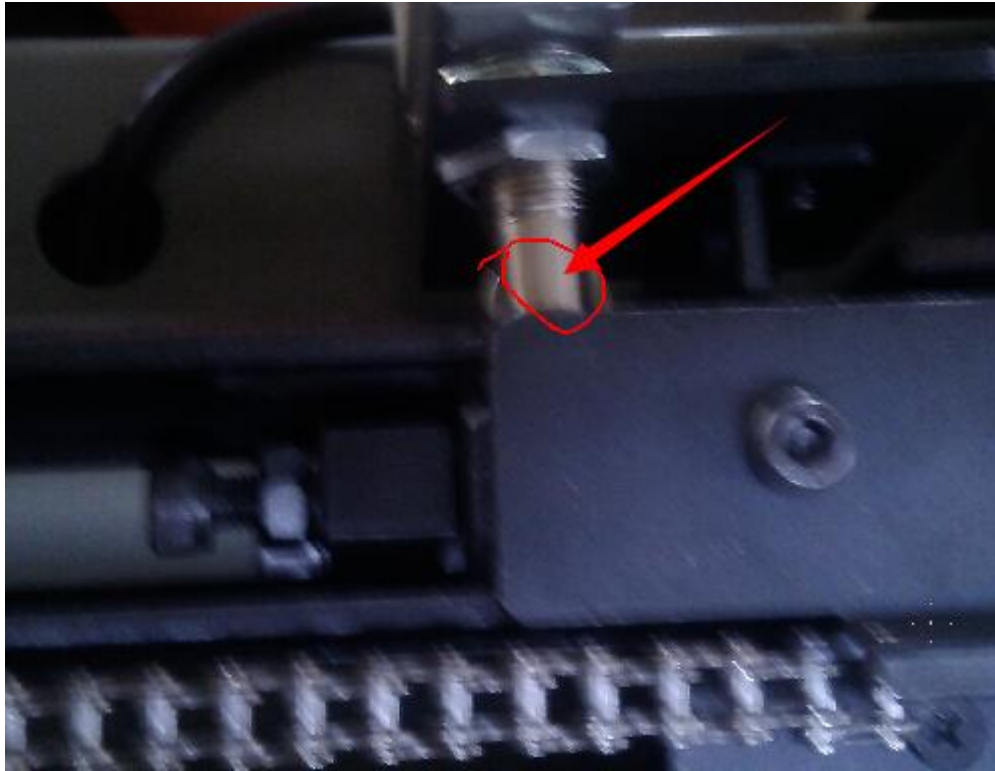




5. Press the green button for mid-return



6. Check the last switch on auto bar as below picture to make pressure to the last switch



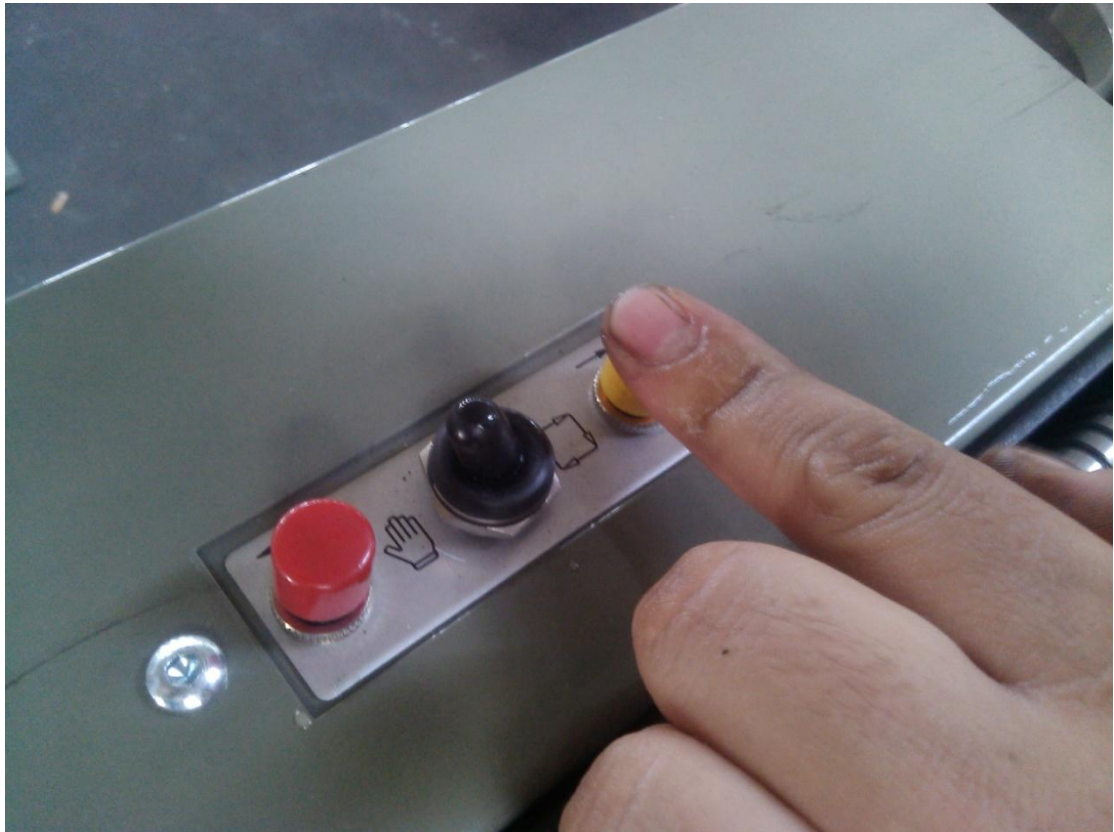
7. Choose the manual mod



8 .Press the red button for back



9 .Press the yellow button for go forward when the material was came back.At the meantime,the the lock mouth can be gone forward to clamping the workpiece.



10 .Choose the auto mode,the auto bar can be auto feeding



There is some seconds delay when auto bar is working.If the workpiece can not go through the

part as below.It will be warning.



At the meantime,press the emergency button.The alarm can be disappeared.The alarm also appeared on the controller,please press the reset to cancel the alarm.

If you continue to feed the workpiece,please move up the part we pointed on the picture by



hand. Then press the button on the auto bar panel to finish the feeding workpiece.

Please read the operation manual carefully before operation!

Example program

O0123

M12 ----- First workpiece was sent in place and clamping workpiece

T0101

G0X20Z5

M3S600

G1X15F100

Z-30

X17

G0X100Z100

T0202

M3S400

G0X20Z1

G1Z-29

X-1.5F30

X17F100

G0Z0.2

X-50

M5-----It is for workpiece operating program in read character, There is some difference when the workpiece shape is different.

G4X3 ----- Pause for 3 seconds

M13-----Loosen the chuck,send the signal for sending the workpiece to start feeding.

G4X3-----Pause for 3 seconds(The time is up to you.)Waiting for the expected work length to be stopped by No.2 tool.

M12 -----Clamping the chuck

G4X3-----Pause for 3 seconds

G0X100Z100-----Put the tools far away from the workpiece

IF[#1010==1]GOTO 10----- #1010 is for short workpiece signal.When #1001==1,please use the program O2000,it can be returned the workpiece automatically, restart the new workpiece,the system will be in pause to waiting for restart feeding.

M99

N10 M98P2000

M99

O2000

M13 ----- Loosen the chuck and send the feeding signal

M00-----PAUSE

M12-----Clamping the chuck

M99