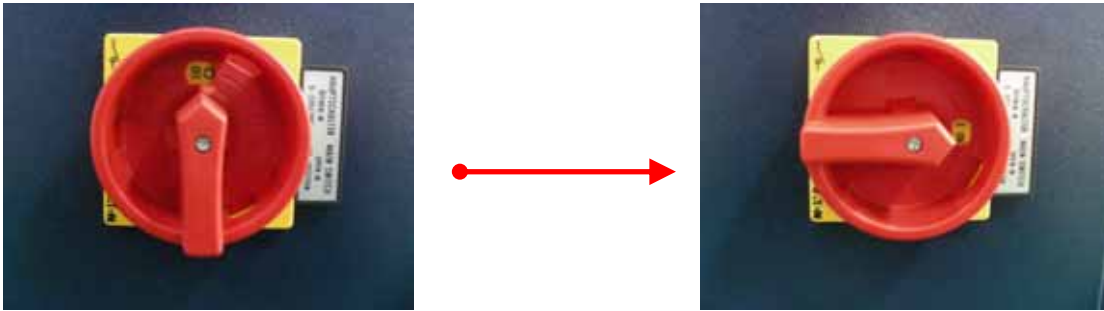


Operation for YY machine type

1. Turning on machine steps:

(1.) Turn the red main power to “ON”.



(2.) Press green button “POWER ON”



(3.) It will show above screen after 1 minute (in gray word).

(4.) Press red emergency switch.

(5.) Press “POWER START” button for more than one second and machine will be turned on (voltage will show 10V-12V).



(6.) Press “HOME” button and then press any one direction button (X+ X- Y+ Y- Z+ Z-).

(7.) It will start to search home point (start from W- AXIS & Z-AXIS and then X-AXIS & Y-AXIS).

(8.) Each axis words will become pink and it means turning up machine successfully.

2. Set the working home point (TOUCH) <JOG or MPG >

A. Searching edge by manual (JOG or MPG)



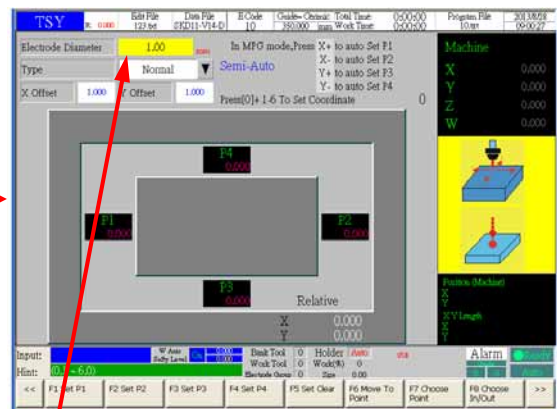
(1) : Press F1 Position button



(2) : Press F3 Find Zero



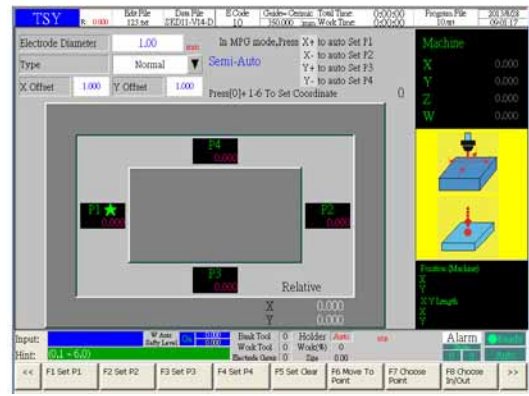
(3) : Press F2 Block button



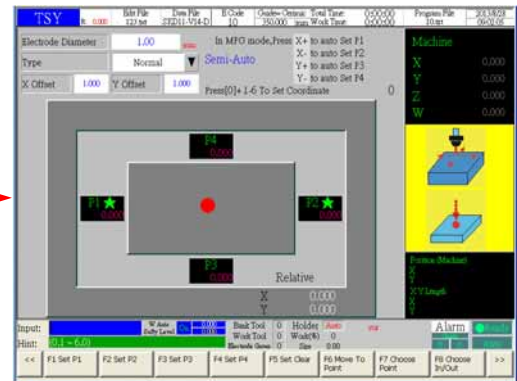
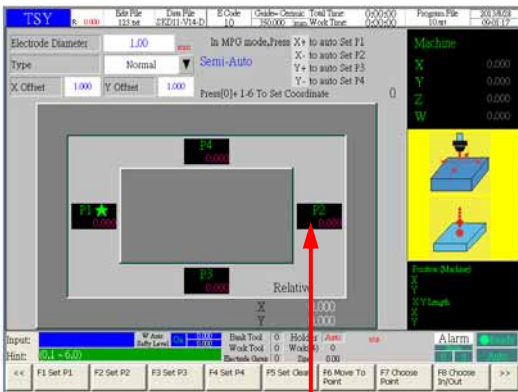
(4.1) : Input electrode size

(4.2) : Press F5 Set Clear

(P1 P2 P3 P4 without red star)

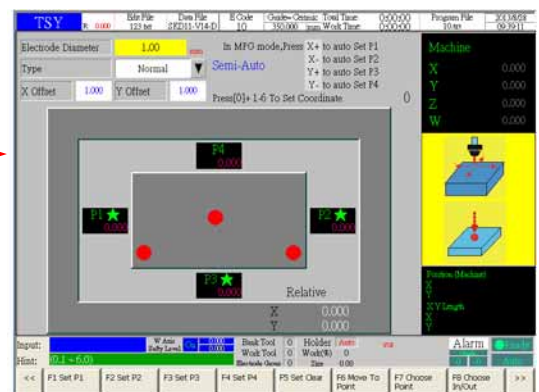
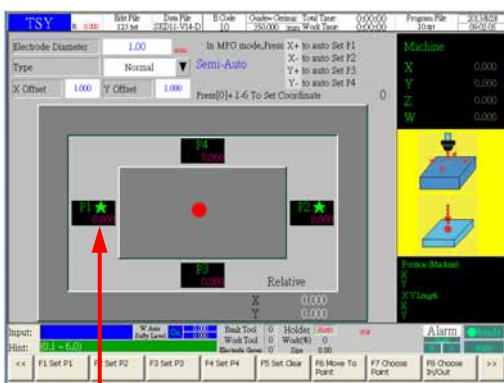


(4.3) : Move guide outside workpiece to P1 position and then press X+ button and machine will start to search X-AXIS edge.



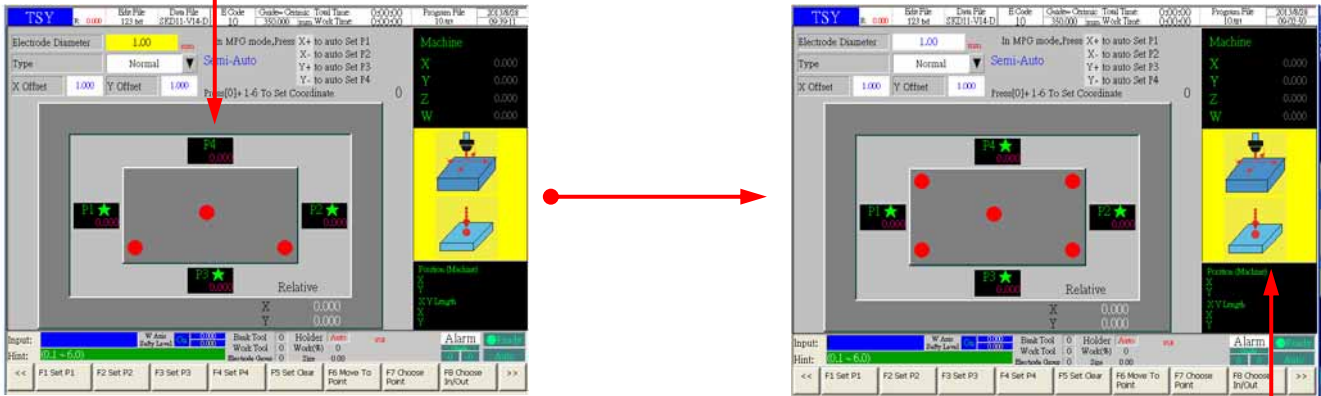
(4.4) : Move guide outside workpiece to P2 position and then press X- button and machine will start to search X-AXIS edge.

After completing searching X+ and X- edge, it will show X-AXIS center. And then Press F6 to Y center point.



(4.5) : Move guide outside workpiece to P3 position and press Y+ button and machine will start to search Y-AXIS edge.

(4.6) : Move guide outside workpiece to P4 position and press Y- button and machine will start to search Y-AXIS edge.



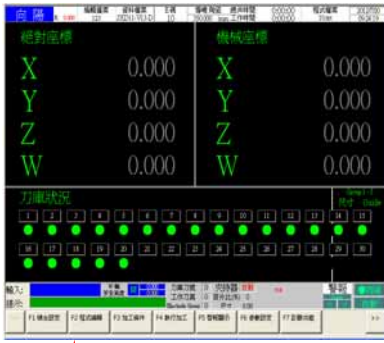
(4.7) : After completing searching Y+ and Y- edge, it will show four corner points and center point.

Press F7 Choose Point button to move it and press F6 Move to Point to move it of the center point.

(4.8) : Press << to go back to former page to (3) screen.

(4.9) : Press F8 Coordinate to set coordinate. Complete workpiece zero point setting.

B. Program Find (JOG or MPG)



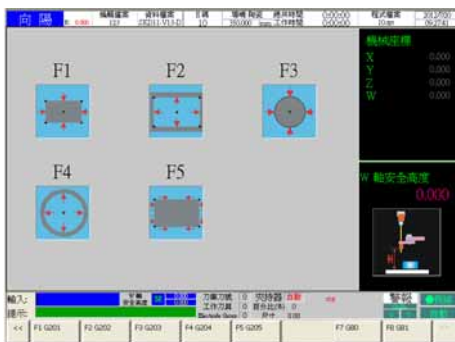
(1) : Press F1 Position



(2) : Press F3 Find Zero



(3) : Press F4 Program Find



(4) : Press F1 G201



(4.5): Move guide to 1 position on the left side of workpiece

(4.6): Press F1 start

(4.7): Press << go back to (3) screen

(4.8): Press << again to (2) screen

(4.1): Input X axis width

(4.2): Input Y axis width

(4.3): Input electrode size D

(4.4): Input mode C

0 : workpiece center

1 : workpiece left down corner

2 : workpiece right down corner

3 : workpiece right up corner

4 : workpiece left up corner

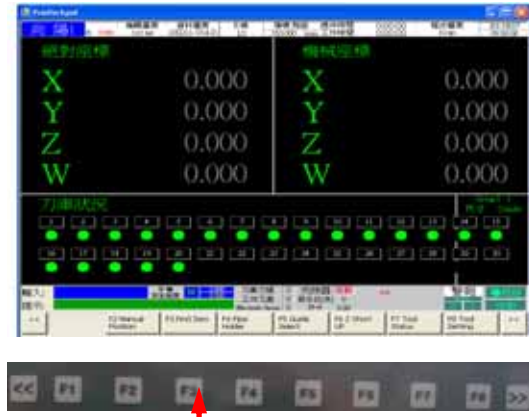


(5): Press F8 Set Coordinate. Complete coordinate zero point setting.

C. Searching one single edge (JOG or MPG)



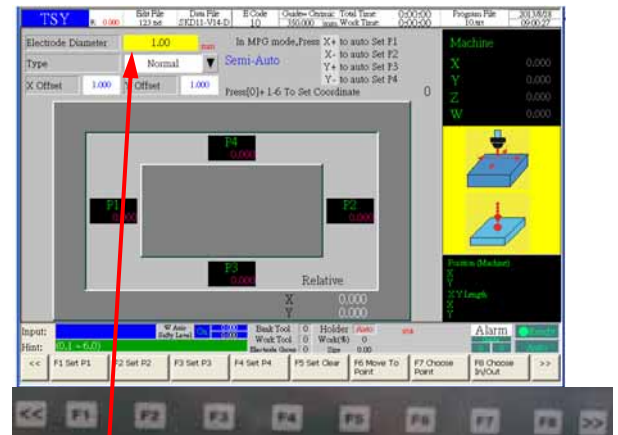
(1) : Press F1 Position



(2) : Press F3 Find Zero



(3) : Press F2 Block

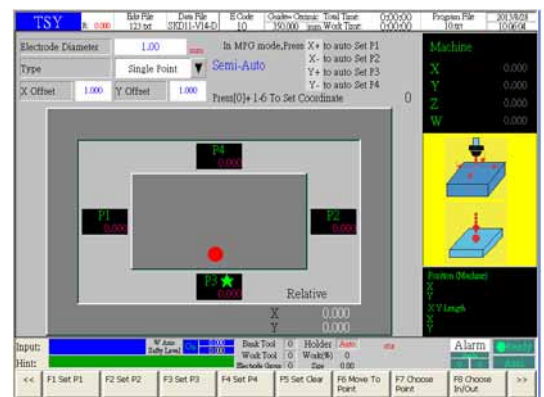
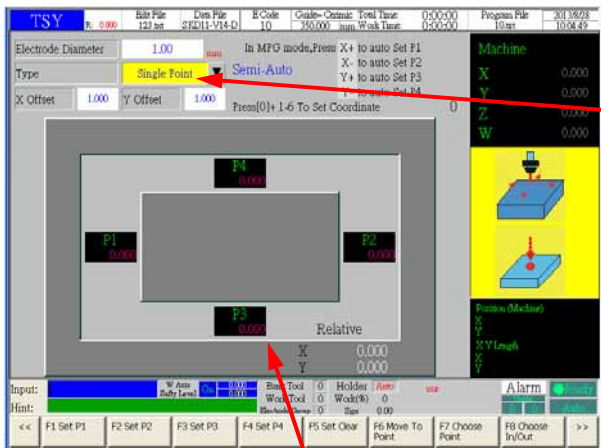


(4.1) : Input electrode size

(4.2) : Press F5 Set Clear

(P1 P2 P3 P4 without red star)

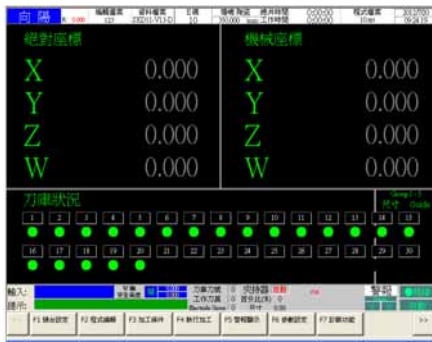
(4.3) : Press direction button to setting single point.



(4.4) : Move guide to P3 on the left side of workpiece and then press Y+ button and machine will start to find Y-AXIS edge.

(4.5) : Press F6 button move to machining assigned point. (already deduct electrode semi-diameter)

3. Machining by manual (JOG or MPG)



(1) : Press F1 Position



(2) : Press F2 Manual Position



(3) : Move to machining coordinate



(3) : or input machining coordinate and then press F1 to carry out movement.

(4) : Input machining data parameter (input by hand or E code)



(5) : Press SPARK button to carry out machining.

(6) : After machining is through hole, press HOLD button to stop it.

4. Machining parameter E code (machining in manual mode and input parameter)



(1) : Press WORK DATA button to go to machining data list.

Workpiece material

File name

Parameter E code number

Electrode size

No	電壓	電流	ON	OFF	電容	伺服	極間	尺寸(mm)	厚度	消耗
1	1	3	8	75	2	16	16	0.15	1.000	5.000
2	1	5	10	60	3	30	50	0.20	12.000	30.000
3	1	6	12	40	4	20	45	0.30	50.000	100.000
4	2	3	20	40	4	25	40	0.30	50.000	130.000
5	1	9	25	35	5	40	45	0.40	95.000	160.000
6	2	4	25	40	5	35	45	0.40	75.000	170.000
7	1	9	25	30	4	30	60	0.50	100.000	140.000
8	2	4	25	30	3	30	45	0.50	95.000	185.000
9	2	5	30	25	4	40	50	0.70	100.000	135.000
10	2	7	35	30	5	40	55	1.00	100.000	140.000

(2) : Input E code number and press F3 to load machining condition (in JOG & MPG)

(P) : If it needs to change material, press F3 and will show below material list file.

(P1) Move to material file name by using up and down button.

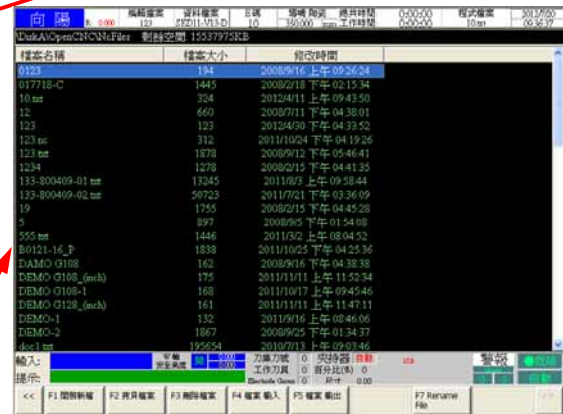
(P2) Press F2 Open File

檔案名稱	檔案大小	修改時間
AL	33	2007/11/9 上午 09:21:35
2424		2008/1/16 下午 03:08:08
CU	2433	2008/1/16 下午 03:15:32
NAK80	1444	2007/8/30 下午 04:33:18
NEW-SKD-11	3445	2009/7/30 上午 09:47:38
SDI WU	2008	2006/3/8 下午 04:16:26
SKD	4319	2009/7/20 下午 05:00:46
SKD-11-02	3186	2008/1/16 下午 04:57:35
SKD11-V13	4124	2009/6/22 下午 03:35:30
SKD11-v13_d	4121	2011/7/20 上午 08:57:52
SKD11-V13-D	4125	2012/6/15 下午 01:44:03
SKD11-V14	3900	2012/4/19 上午 08:49:26
STAVAX	1440	2011/1/20 下午 09:43:54
TDAC	1442	2007/8/30 下午 02:12:58
TEST	3179	2006/10/25 下午 02:41:54
TEST1	481	2007/11/21 上午 08:15:26
v13	3959	2009/7/30 下午 03:31:34
WC(OIL)	3179	2006/10/25 下午 02:41:54
WC	1194	2006/3/8 下午 05:08:52
WC_V1	2927	2008/12/16 下午 06:12:40
WC_V1	2436	2009/12/16 下午 02:26:10

5. Program edit

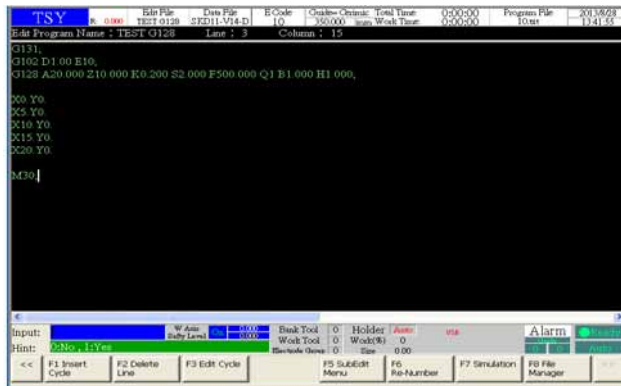


(1) : Press EDIT button to go to edit screen and will show last time edit file.



(2) Press F8 File Manager to get file name screen.

(3) Press up and down to move to wanted file name and then press Enter to get it.

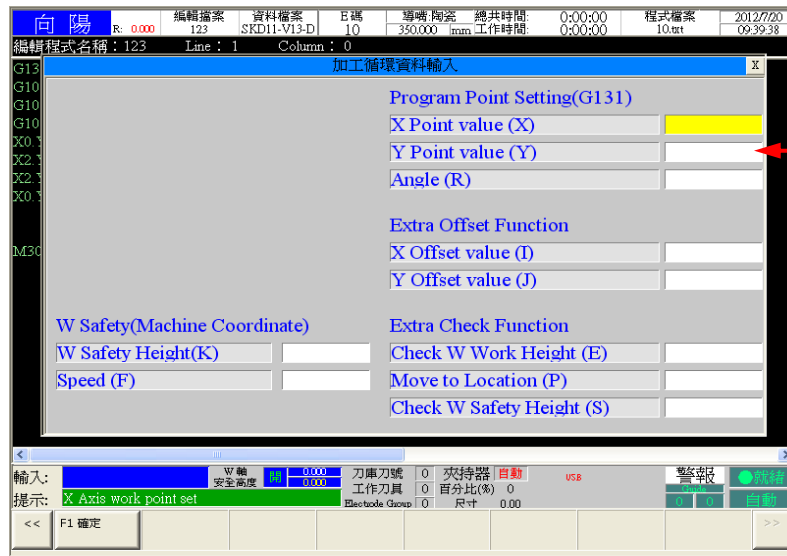


G131	coordinate
G102	electrode and machining condition
G128	through hole workpiece thickness
X0.Y0.	machining coordinate
.....
M30	program finish

G131;
 G102 D1.00 E1;
 G128 A20.000 Z10.000 K0.200 S2.000 F500 Q1 B1.000 H1.000
 X0. Y0.;;
 X5. Y0.
 X10. Y0.;;
 X15. Y0.;;
 X20. Y0.;;
 M30;

(3) Press up and down button to which you want to edit it and press F3 Edit Cycle button to show the content.

(3-1) Move to G131 and press F3 Edit Cycl to show the content



X Axis value
Y Axis value
Tilt angle

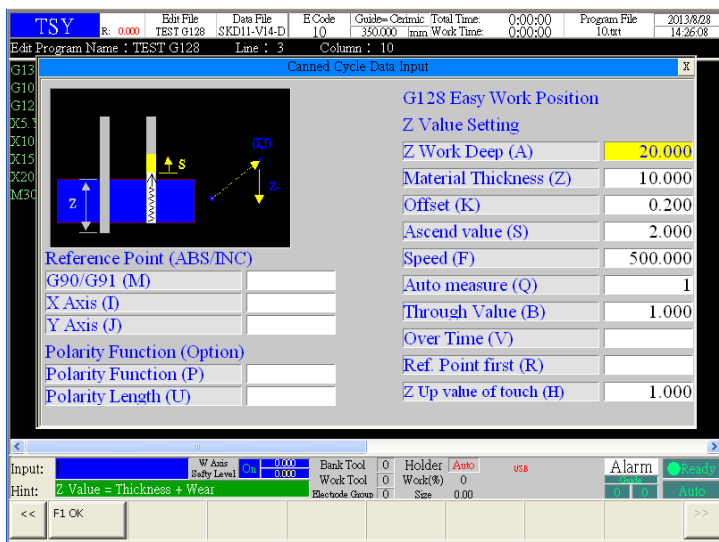
Please don't input it if you don't want to change. Just keep it blank.

(3-2) Move to G102 and press F3 Edit Cycle.



Electrode diameter D
Machining data E Code

(3-3) Move to G128 and press F3 Edit Cycle.

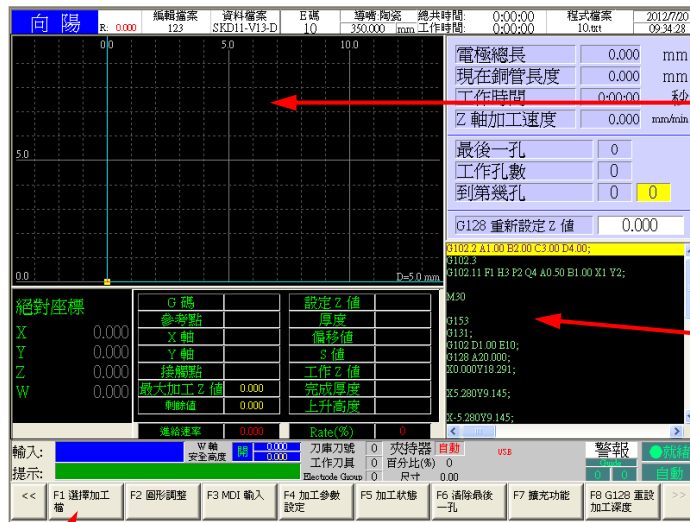


(A) 1st machining depth of Z axis
(Z) Material thickness
(K) The offset distance as electrode going up.
(S) The height as electrode leave workpiece surface.
(F) Electrode goes up speed.
(Q) If test machining thickness
(B) Additional machining depth after machining through hole.
(V)
(R)
(H) The Z axis up distance after finding edge.

6. Program machining



(1) : Press AUTO button and then press MONITOR button.



Show machining figure

Show machining program

(2) : Press F1 Select File to load file

檔案名稱	檔案大小	修改時間
0123	194	2008/9/16 上午 09:26:24
017718-C	1445	2008/2/13 下午 02:15:24
10.txt	324	2012/4/11 上午 09:43:50
12	660	2008/7/11 下午 04:38:01
123	123	2012/4/30 下午 04:33:52
123.nc	312	2011/10/24 下午 04:19:26
123.txt	1878	2008/9/12 下午 05:46:41
1234	1278	2008/2/15 下午 04:41:35
133-800409-01.txt	13245	2011/8/3 上午 09:58:44
133-800409-02.txt	50723	2011/7/21 下午 03:36:09
19	1755	2008/2/15 下午 04:45:28
5	397	2008/9/5 下午 01:54:08
555.txt	1446	2011/3/2 上午 08:04:52
B0121-16_P	1838	2011/10/25 下午 04:25:36
DAMO G108	162	2008/9/16 下午 04:38:38
DEMO G108_(mch)	175	2011/11/11 上午 11:52:34
DEMO G108-1	168	2011/10/17 上午 09:45:46
DEMO G128_(mch)	161	2011/11/11 上午 11:47:11
DEMO-1	132	2011/9/16 上午 08:46:06
DEMO-2	1867	2008/9/25 下午 01:34:37
doc1.txt	195654	2010/7/13 上午 09:03:46

(3) Press up and down button to choose wanted file and press Enter to get it.



(4) Press START to carry out it. W-Axis security check will appear.

If guide go down height is no problem, press START again to continue.