SWITCH DISPLAY DESCRIPTION

ATCXTNDD: Switch closes when the ATC slide is under the spindle (Hall Effect Switch PN: ELE-2064).

ATCTURET: Switch closes momentarily when the ATC turret motion is finished (ELE-2064). May not be seen because closure may occur between screen updates.

ORIENSP: Switch closes when the spindle is at orientation position. Spindle magnet directly under Hall switch sensor (ELE-2064).

ATCHOME: Switch closes when the ATC slide is fully retracted and settled (ELE-2064).

ATCFAULT: Switch closes when the ATC is subjected to excessive up or down forces. This switch is located on top half of turret spindle above turret plate (ELE-0385).

DRAWBAR: Switch closes when the drawbar cylinder is pressurized and down far enough to make the drawbar down Hall Effect Switch (ELE-2064).

OIL LEVEL: Switch closes when the oil level is low in way lube and spindle lube reservoir (LUB-0036).

HIGH IDLER: Switch closes when the idler wheel is retracted (ELE-1202). (Low range engaged).

LOW IDLER: Switch closes when the idler wheel is retracted (ELE-2064). (High range engaged).

PROBE: Switch is open when probe switch is engaged.

SLIDE HOLD: Switch is open when doors are closed (external slide hold).

COMMAND1

Refer to Hex to Binary table. Each binary bit commands one solid state relay. A value of 0 turns the relay on. B0 is the rightmost bit.

B0= M68/M69

B1= High range idler

B2= Unused

B3= Drawbar/Geneva/Slide Enable

B4= Drawbar

B5= Air indexer

B6= Coolant 1 ON

B7= Coolant 2 ON