



ALARMS	CAUSE	RECTIFICATION
A012 Chuck control no switch	Chucking limit switch incorrectly set or faulty	Check setting and/or function
A013 Chuck control two switches	ditto A012	ditto A012
A014 Chuck open spindle rotating	Chucking not closed after spindle speed call-up	Close chucking or M77 and key AUTORUN. Press key PC RESET or RESET
A015 No gear speed selected	No gear speed selected M03/04 Without gear speed	Select transmission stage prior to M03/04
A016 Main drive trouble	Minimum field current not reached or main spindle not ENABLED (ready)	Check fuses, main spindle unit. Press key DRIVES OFF
A017 Lubrication level	Oil level too low	Top up oil
A018 Lubrication pressure	No pressure build-up or pressure drop	Check oil level, check pressure switch
A019 Tool life/ piece counter	Preset number of pieces reached	Reset piece counter or counter resets to zero when restarting
A020 Cover is open	Guard open in automatic mode with SINGLE BLOCK not selected	Close guard or select single block or setting mode
A021 Turret 1 error limit switch	Limit switch locked/unlocked, incorrectly set or faulty	Check setting and/or function. Press PC RESET or RESET key
A022 Turret 1 tool changing time	Tool changing time exceeded	Check speed, limit switches, angle coding. Press RESET key



Alarms	Cause	Rectification
A023 TURRET 1 NOT LOCKED	Turret not in locked position	Lock turret (setting mode); check limit switch.
A024 TURRET 1 INCORRECT T NUMBER	Unacceptable tool number programmed	Modify program. Press RESET key.
A025 TURRET 1 PARITY ERROR	Parity error of angle encoder	Check angle encoder.
A026 QUILL STROKE TOO LONG	Quill advanced beyond working range	Bring tailstock closer to workpiece.
A027 QUILL PRESSURE WORK.POS.	Quill not in working position; quill pressure drop; no clamping	Move quill into working position; advance quill or move it into basic position.
A028 M29 QUILL NOT BACK	Quill advanced in setting mode must not be returned to basic position by M29	Retract quill in setting mode.
A029 TAILSTOCK LIMIT POSITION	Operation with quill and tailstock at the rear	Only indication - tailstock still in end position.
A032 FAULT WORKPIECE SORTER	Workpiece sorter not in basic position; time for traverse direction exceeded	Move workpiece sorter in setting mode into basic position.
A033 TAILSTOCK/ STEADY COLLISION	Prot. zone X/Z of tailstock reached	Move tailstock into working position.
A034 B1 CONFIRMATION MISSING	Aux.function not executed or confirmed	Check PC equipment, operation in MDI or setting mode. Press RESET key.
A035 S1 CONFIRMATION MISSING	Main drive / main spindle does not reach desired speed.	Check desired value and actual value. Press RESET key.
A036 T1 CONFIRMATION MISSING	Turret has not reached desired position or is not locked	Move turret in setting mode into locked position. Press RESET key.



Alarms	Cause	Rectification
A037 M1 CONFIRMATION MISSING	Aux.function not executed or confirmed	In case of supplementary equipment, check PC facilities, operation in MDI or setting mode. Press RESET key.
A038 BAR FEED NOT READY	Starting conditions for bar feed not satisfied.	Establish starting conditions for bar feed as per description.
A039 SWITCHES PARTING-OFF SLIDE	Limit switches parting-off slide rear/front have been actuated simultaneously.	Check setting or operation. Press RESET key.
A040 IDENTIFICATION PARTING-OFF SLIDE?	Input of wrong identification number when programming B10xxxx	Correct programming (B10xxxx, B1020xx, B103xxx or B104xxx). Press RESET key.
A041 PARTING-OFF SLIDE NOT REAR	Parting-off slide is not in rear end position	Move parting-off slide in setting mode into its rear end position.
A042 MEASURING TOLERANCE \$1	Maximum tolerance exceeded	Press RESET key.
A045 FAULT SPINDLE POSITIONING	Monitoring time for spindle positioning exceeded	Check signal POSITION REACHED.
A046 MEASURING IN GO-RANGE \$1	Measuring value within insensitivity range	Reset at end of sub-routine. Press RESET key.
A047 MEASURING CORRECTION \$1	Measuring value within tolerance band	Reset at end of sub-routine. Press RESET key.
A048 MEASURING IN-FEED TOTAL \$1	Maximum correction total exceeded	Press RESET key.
A064 MAG PROGRAMMING ERROR	see description of magazine	
A065 MAG INPUT ERROR	dto.	
A066 MAG WRONG OPERATION MODE	dto.	
A067 MAG PARAMETER ERROR	dto.	

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PC ALARMS: TX S D



Alarms	Cause	Rectification
A068 MAG COVER OPEN	see description of magazine	
A069 MAG SPINDLE IS ROTATING	dto.	
A070 MAG NO REFERENCE POINT	dto.	
A071 MAG FEEDER TIME OVER	dto.	
A072 MAG NO MOTION	dto.	
A073 MAG FAULT ENCODER/HARDWARE	dto.	
A074 MAG FAULT PIC SCREEN	dto.	
A075 MAG NO MATERIAL	dto.	
A076 MAG NO BAR OR BAR TOO SHORT	dto.	
A077 MAG PART LENGTH MISSING	dto.	
A078 MAG NO WORKPIECE PRESENT	dto.	
A079 CODE TOOL TABLE 1?	The identification END OF TOOL TABLE is missing.	Program END OF TOOL TABLE. Press RESET key.
A080 TOOL LIFE TIME OVER	Tool life time exceeded or tool wear feed-back.	Change tool, set actual time to zero. Press RESET key.
A081 PICK-UP SPINDLE NO PRESSURE		
A082 PICK-UP SPINDLE FILTER		
A083 ANUE WEAR 1	Tool wear	Press RESET key.
A084 ANUE TOOL BREAKAGE 1	Tool breakage	Press RESET key.
A085 TURRET 1 NO BASIC POS.	No precision stop signal angle encoder	Set turret again.
A090 END POSITION	Limit switch not correctly activated	Check limit switch. Gearbox position not defined.



Alarms	Cause	Rectification
A091 FAULT GEAR LUBRICATION	Gear lubrication does not work correctly.	Oil filter contaminated; pressure switch defective.
A092 FILTER MONITORING X AXIS 1	Filter contaminated.	Clean filter
A102 CONTROL CAB. TEMP.TOO HIGH	Temperature control system does not work correctly; automatic breaker tripped or off.	Check temperature control system or switch on automatic breaker.
A105 OVERLOAD X AXIS 2	dto. A005	dto. A005
A106 OVERLOAD Z AXIS 2	dto. A006	dto. A006
A107 OVERLOAD R AXIS	Overload clutch R axis tripped - collision.	Clear axis; engage clutch; press key DRIVES OFF. Position to R axis reference point.
A108 DRIVES OFF AUTOM.MODE	Trouble with machine or preset number of work-pieces has been reached.	Eliminate trouble as per fault display or set work-piece counter to "0". Press key DRIVES OFF.
A110 MAIN DRIVE BRAKE NOT RELEASED	Brake not released after switching on main drive	Check limit switch or limit switch setting.
A113 PICK-UP SPINDLE CLAMPED	Switching on drive for rotating tools with pick-up spindle clamped.	Release clamping of pick-up spindle.
A114 CLUTCH SYNCHR./ SERVO SELECTED	Pick-up spindle clamped with drive for rotating tools on.	Switch drive for rotating tools off.
A116 CLUTCH SERVO ROT.TOOL ON	Engagement of synchronous operation with asynchronous operation on.	Switch asynchronous operation off.
A117 CLUTCH SPINDLE ROT.TOOL SELECTED	Engagement of asynchronous operation with synchronous operation on.	Switch synchronous operation off.



Alarms	Cause	Rectification
A118 SERVO ALARM ROT.DRIVE 1	Fault in servo system of drive for rotating tools (asynchronous operation).	Check servo system. Press PC RESET or RESET key.
A119 WRONG SPEED ROT.DRIVE 1	Speed deviation exceeds acceptable tolerance (12,5 %) - e.g. overload- ing, belt breakage.	Reduce load, check system. Press PC RESET or RESET key.
A120 CLUTCH NOT ACTIVE	Switching on direction of drive for rot.tools with clutch disengaged.	Engage clutch for servo motor or clutch for rear-end work- ing station.
A121 TURRET 2 ERROR LIMIT SWITCHES	dto. A021	dt. A021
A122 TURRET 2 TOOL CHANGING TIME	dto. A022	dto. A022
A123 TURRET 2 NOT LOCKED	dto. A023	dto. A023
A124 TURRET 2 INCORRECT T NUMBER	dto. A024	dto. A024
A124 TURRET 2 PARITY ERROR	dto. A025	dto. A025
A126 TOOL CARRIER LIMIT SWITCH FAULT	Limit switch 'swung in/ swung out' incorrectly set or defective.	Check setting or operation.
A127 TOOL CARRIER NOT IN BASIC POSITION	On auto-start, tool carrier is not in starting position.	Swing tool carrier out in setting mode
A129 QUILL NOT SELECTED	Key OPERATION WITH QUILL not pressed.	Select operation with quill. Press RESET key.
A134 B2 CONFIRMATION MISSING	dto. A034	dto. A034
A135 S2 CONFIRMATION MISSING	dto. A035	dto. A035
A136 T2 CONFIRMATION MISSING	dto. A036	dto. A036
A137 M2 CONFIRMATION MISSING	dto. A037	dto. A037
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Alarms	Cause	Rectification
A138 TURRET 2 NO BASIC POS.	dto. A085	dto. A085
A142 MEASURING TOLERANCE \$2	dto. A042	dto. A042
A146 MEASURING IN GO-RANGE \$2	dto. A046	dto. A046
A147 MEASURING CORRECTION \$2	dto. A047	dto. A047
A148 MEASURING IN-FEED TOTAL \$2	dto. A048	dto. A048
A159 MACH.OFF AFTER MODIF.	Modification of PC CHECK DATA.	Switch NC off for data transmission.
A160 DATA INPUT LOCKED	Input or modification of PC parameter data without key word input.	Input key word. Press RESET key.
A161 2 SLIDES SELECTED	Two pairs of axes selected in setting mode.	Only information.
A162 SLIDE SELECTION LOCKED	In automatic mode, no additional axes can be activated.	Switch to setting mode.
A163 NEEDS SYNC.(!) BEFORE M30	In double-slide operation, synchronization symbol missing before M30.	Set synchronization (!) before M30 in both slide programs.
A164 SET UP MODE LOCKED	Mode selector switch on JOG or PULSE GENERATOR and KEY SWITCH not on SETTING MODE.	Turn key switch to SET UP.
A165 STOP FEED/ SPINDLE NC	Fault in NC or axis amplifier.	See corresponding NC faults.
A166 OPTION X2/Z2 NOT SET	PC parameter for second slide not set.	Set option.
A167 OPTION R/C NOT SET	PC parameter for R axis or C axis not set.	Set option(s).
A168 SET UP LOCKED WITH FHS SEL.		Inactivate FHS.
A179 CODE TOOL TABLE 2?	dto. A079	dto. A079



Alarms	Cause	Rectification
A180 WEAR MONIT. S1 + S2 SEL.		Select only one slide.
A183 AWUE WEAR 2	dto. A083	dto. A083
A184 AWUE TOOL BREAKAGE 2	dto. A084	dto. A084
A218 SERVO ALARM ROT.DRIVE 2	dto. A118	dto. A118
A219 WRONG SPEED ROT.DRIVE 2	dto. A119	dto. A119
A221 TURRET 3 ERROR LIMIT SWITCH	dto. A021	dto. A021
A222 TURRET 3 TOOL CHANGING TIME	dto. A022	dto. A022
A223 TURRET 3 NOT LOCKED	dto. A023	dto. A023
A224 TURRET 3 INCORRECT T NUMBER	dto. A024	dto. A024
A225 TURRET 3 PARITY ERROR	dto. A025	dto. A025
A227 TURRET 3 NO BASIC POS.	On auto-start, turret is not in basic position (station 17).	Move turret into its basic position (setting mode or MDI). Press RESET key.