

Alarm 417, 427, 1007, 1003 Over Travel

Alarm 417 Servo Alarm: Axis DGTL Parameter

Alarm 427 Servo Alarm: Axis DGTL Parameter

The Action Done by our staff was:

1. Manually input the machine parameter coming from the machine manual, the parameter placed was for machine LTC10P
2. After the technician placed the parameters the alarm disappeared.

The problem that arose after the action:

1. If you perform Zero Return to X and Z Axis then move X and Z axis it will alarm over travel X and over travel Z.

Please modify the parameter 700 from 5000 to 99999999 and parameter 701 from 5000 to 99999999

Then perform Zero returned with slow speed and at last modify the value of parameter 700/701 back to 5000.

2. If you rotate the spindle it will alarm 1007 CHK END Stroke

This alarm means the spindle chuck clamp/unclamp function did not sense (check whether the sensor was installed); you can set diagnosis D486#4 = 1 to bypass the function.

3. If you index the turret manually it will alarm 1003.

This alarm means the Diagnosis parameter was not correctly set.

Please set D440=13 when 12 tools or D440=9 when 8 tools according to the exact tool numbers.

Other Diagnosis parameters must be set as per the parameter list.

Please set PW=1 / Protection KEY=1 and then the diagnosis parameters and program can be allowed to be modified.