OmniTurn - Trouble shooting guide, G4 CNC

Input Monitor Function (Alt-I Diagnostic)

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1.Slow                                                      Position
2.Medium                                                    X: +0.00000
3.Fast                       X+ Jog:          1             Z: +0.00000
4. 0.00005"/.01°             X- Jog:          1
5. 0.00100"/.1°              Z+ Jog:          1
6. 0.01000"/1°               Z- Jog:          1
7. 0.10000"/10°              C+ Jog:          1             Feed
8. 1.00000"/90°              C- Jog:          1               0.0000 IPM
9.Establish Home             Left CS:         1               100 %
H.Go Home                    Right CS:        1
T.Set Tool                   Motion Stop:     1
M.Manual Data Input          Collet Open:     1             Speed
A.Automatic                  Collet Close:    1               0   RPM
                             Spin. Off/Auto:  0             100 %
                             Guards:          0             Tool  0
                             Inhibit:         1
                             M91 input:       1
                             M93 input:       1
                             M95 input:       1
                             X Ref LS :       1
                             Z Ref LS :       1
                             0 indicates active input
```

Input Monitor Function (Alt-I Diagnostic)

Pressing Alt-I in Jog Mode displays status of inputs.
Active inputs (on) are displayed as 0, inactive inputs (off) are shown as 1.

This diagnostic is helpful for quickly determining if the states of the various switches and M-functions are being communicated to the motion control card.

For example: if the machine won't jog, you can quickly verify that the motion control card is reading the state of the Jog Stick by moving the Jog Stick and watching the 1's change to 0's.

Also, when door interlock switch (Guards, above) is open (1), the Spindle Off/Auto switch is shown as off (1) regardless of its actual condition, and Motion Stop is shown as on (0) regardless of its actual condition.

To cancel Alt-I press Alt-I again.

Temporarily Bypass Guards (Alt-G Diagnostic)

If the slide won't jog, and "Guards" stays at 1 and Motion Stop stays at 0 regardless of whether the door is open or closed, press and hold the Alt key, then press G key (Alt-G), then press Esc. Note that Motion Stop will change to 1, but Guards will remain at 1. Select a jog speed and attempt to jog: if the slide jogs with Alt-G active, the problem is a bad door switch or open connection in the door interlock string.

Alt-G is cancelled if Auto mode is selected.