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# operation manual

**ANOTRONIC LTD.™**

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## A. Control Panel

- (1) Clear Key: Set the counter at "0"
- (2) MM/Inch Key: Unit changeover key. Without machining. Press on the key to act. You can alternate mm with inch.
- (3) MM/Inch LED: When it lights, the unit is "mm".  
When it is dark, the unit is "inch".
- (4) DSP/EDM Key: It displays mode changeover. There are four modes.
  1. DSP MODE
  2. TOTAL DEPTH
  3. DEPTH MODE
  4. WEAR MODE

The sequence is (1) → (2) → (3) → (4).
- (5) 2 LED of DSP: They show which mode is acting on the monitor.

※ Dark      Light  
 ●            ○

DSP (UP)	DSP (DOWN)	DISPLAY MODE
○	○	DSP MODE
●	○	TOTAL DEPTH MODE
○	●	DEPTH MODE
●	●	WEAR MODE

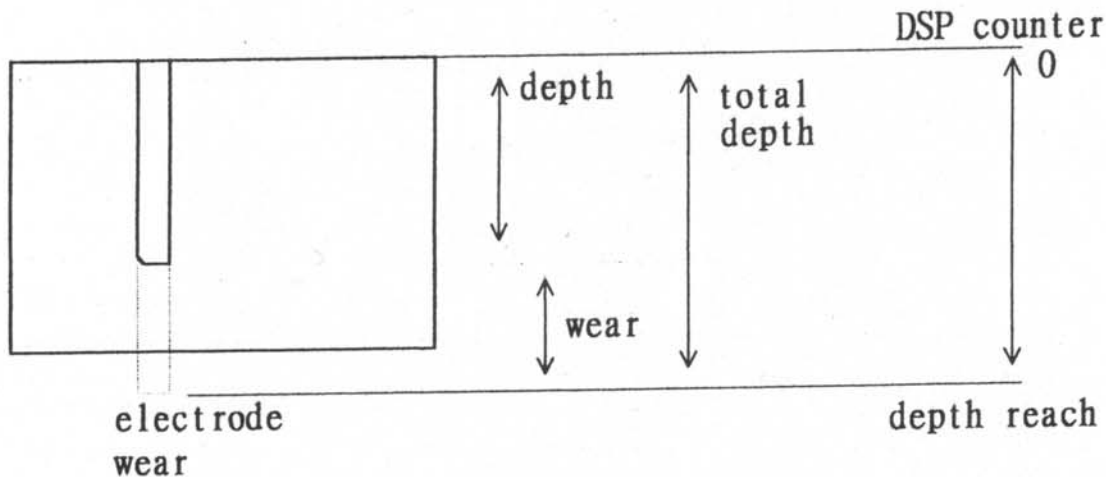
DSP: Shows the parameters of counter at present.

TOTAL DEPTH: It displays the end amounts to process. It means when DSP counts as equal as or smaller than TOTAL DEPTH, the end position to reach the depth will present. It is "DEPTH + WEAR = TOTAL DEPTH"

DEPTH: The setting depth to process. It means user sets actual machining depth on 50 mm. The amount is 50 mm.

WEAR: The setting of wear.

Example: We try to drill actual depth for 50 mm. After calculation, its wear is 80%.  $50 \times 80\% = 40$  mm (its wear). At this moment. The total travel is 50 mm + 40 mm. It finished when counters count to be equal as or less than the total travel.



(6) AUTO/MANUAL KEY: Alternate Auto Mode with Manual Mode.

(7) AUTO LED: "Light" means machining is at Auto Mode.

"Dark" means machining is at Manual Mode.

※ Auto Mode: Electrode rises automatically when work is finished.

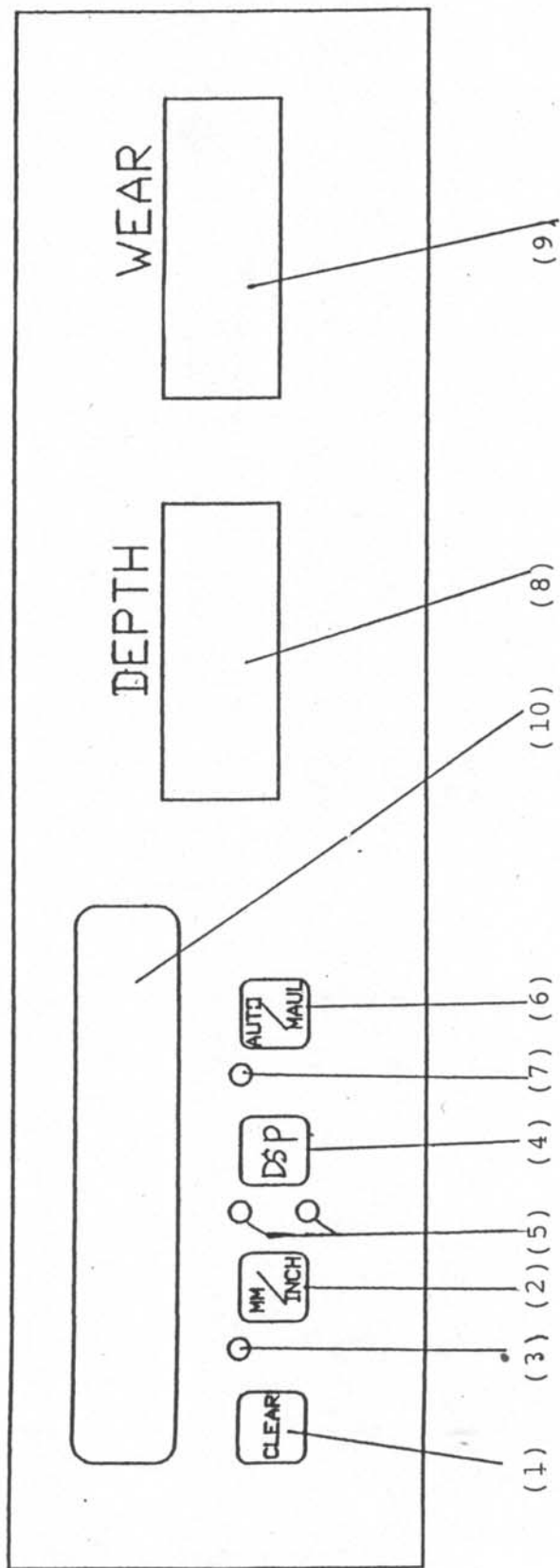
Manual Mode: Raise Electrode manually when work is finished.

Depth Switch: Setting of machining depth.

Wear Switch: Setting of electrode wear.

Display: 7 sections display counter. It shows depending on display mode.

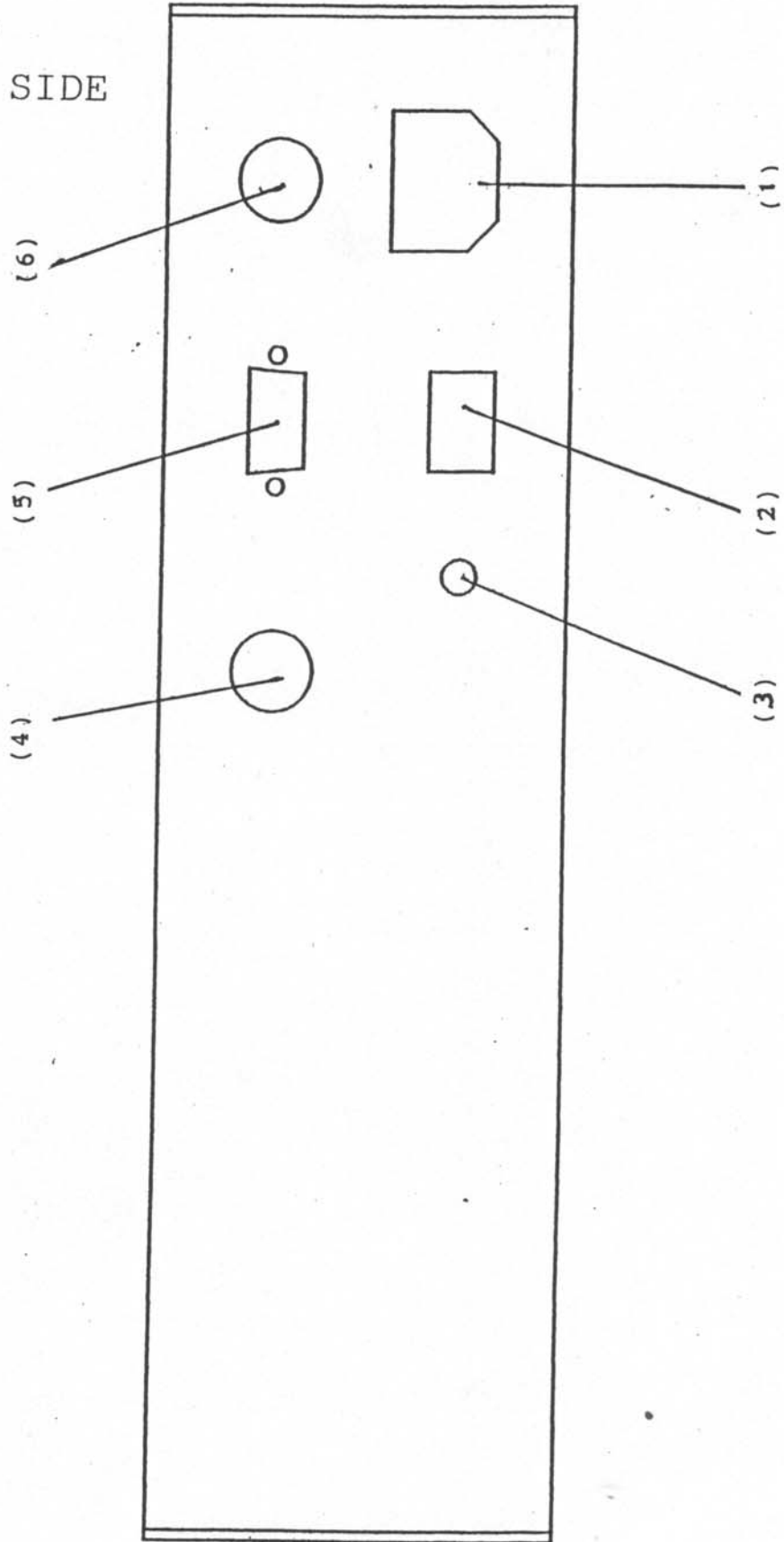
# PANEL



## B. Back Equipment

- (1) Power connection: AC 110V / 60HZ / 50HZ
- (2) Power Switch
- (3) Power LED
- (4) Input electrode connector (3 PIN):  
1 · 3: connect to E+ , E-  
2: empty
- (5) I/O connector (9 PIN): D type connector.  
It mostly connects JP5 of M-DEEP with DMACH terminal and UP terminal on control panel.
- (6) Encorder connector (5PIN): round type.  
PIN 1 = CHA  
PIN 2 = CHB  
PIN 3 = VCC  
PIN 4 = GND  
PIN 5 = FG

BACK SIDE



## C. How to operate and do trouble shooting?

### 1. Trouble Shooting

- (1) If there is nothing to show on Display, please check whether back power switch is turned on and wire is set ready. Besides, power is supplied.  
After set ready, try again.
- (2) After POWER ON, press each button to check whether each LED changes. If any one doesn't, please contact in technical afterservice department.
- (3) Check whether the setting of DEPTH SWITCH is the same as the amount of DEPTH MODE on Display, and confirm whether each byte is right. If it isn't, please contact in technical afterservice department.
- (4) Check whether the setting of WEAR SWITCH is the same as the amount of wear mode on Display. After confirmation, proceed it. If it isn't, please contact in technical afterservice department.

### 2. Operation

- (1) Power ON machine and confirm that controller is normal.
- (2) Depending on machining size, set unit and Depth amount.
- (3) Set Wear amount and which mode work is on.
- (4) Start machining. When electrode touch workpiece surface during sparking, Display becomes "0" and proceed depth count down.
- (5) Reaching the Specified depth on auto mode, electrode rises over workpiece automatically. If it is on manual mode, please raise the electrode by manual operation.
- (6) After item 5 is finished, drill next hole.

※ If any problem presents, please send your question to technical afterservice department.

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Anotronic-SKM EDMs  
Manual, ZNC, CNC



Anotronic-Ocean  
EDM Drilling Machines  
Manual, ZNC, CNC



CNC Wire EDM Sub-Contract  
On The Latest Technology  
Machines



Anotronic Electrochemical  
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Fully Automated 5axis cnc Milling

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CNC CMM inspection



5axis cnc Milling



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