

Logs in NCT 104/101/102/115 controls

One log includes the following data:

1. Date: year, month, day, hour, minute, second.
2. Mode: EDIT, AUT, MDI, DNC, JOG, INCR JOG, MANUAL, REF.
3. MACHINE ON/OFF
4. Turning the control panel off: POD
5. Spindle status: M3/M4/M5/M19
6. START/STOP
7. Number of assigned program for automatic running.
8. Number of finished workpieces.
9. Error code.

If even one of the 2-9 points given above change, a new log is made. The user can only obtain the logs from control panels equiped with FEW. By using an additional software the log entries appear in an evaluatable form. The maximal number of evaluation: 4194304 (more than 4 millions). Which means that depending on the use of the machine, it can mean years of logs.