

Saw File Specification - Messages

Specification of the Messages.saw file

Contents

Specification

Sample

Comments

Specification

The Messages file contains details of the screen messages used

No	Name	Format	Example	Notes
1			Press start to continue	

Sample

Press start to continue
Emergency Stop circuit broken
Press ES Reset to reset
Guard door open
Air pressure low
Timeout on Eject Cylinder Out
Timeout on Eject Cylinder Home
Timeout on Saw Cut Cylinder Up
Timeout on Saw Cut Cylinder Home
Centralise not retracted
Guard door ready to open
Please close guard door to continue
Laser cannot see laser hole
Laser measuring system is blocked or bar is longer than expected
Returning pusher to home position
Timeout on Saw At 45
Timeout on Saw At 90
Timeout on Saw At 135
Check the bar is upright and loaded correctly
Press Start to retry. (Auto load off allows return to main menu)
Loading Error - Laser hole to big
Loading Error - Laser hole to small
Loading Error - Laser Offset outside tolerance
Large Piece now ejecting - Please ensure Outfeed Area is Clear
Motion Error: Motion aborted
Pusher Axis Stalled (Following Error)
Pusher Axis Drive Error
Press Start to Reinitialise
Machine Pause: Stop Button Pressed
Machine Pause: Guard Door Open
Machine Pause: Air Pressure Low
Press Start to resume cycle, Stop to abort the bar
Machine is not able to start - check Machine Status indicators
Press Start to initialise machine
Motion Controller Shutting Down.....
Press Start to begin cutting

Press Start to begin cutting
If there is an offcut trapped, try using the service screen
Please wait for saw blade to stop rotation
Auto Load off to stop blade
Auto Load On to Begin
Waiting for bar to load
Profile type has changed
Machine Cycle Stopped
Load bar manually to backfence
Timeout on Midclamp Switch
Timeout on Gripper Switch
Measuring Error
Measuring Offcut.....
Offcut Sensor appears to be blocked
Replace Bar and try again
Incorrect bar length loaded
Longlength sensor is blocked or loaded bar is too long
Clear blockage and press start to retry
Alarm has caused machine to stop
Safety Circuit Open
Press ES Reset to open Guard door
Crossfeed sensor not activated
V Notch blade retract
Loading Error: Bar exists in loading position
Press and hold Start to reverse infeed table
Machine is initialising. Please Wait.....
Manual Mode Active
Setup Mode Active
Gripper has not located properly -
Press start to attempt to load again
Check loaded bar is not bent
Shutdown: Moving X to safe position.....
Waiting for bar data transfer
Moving to measuring position....
Gripper Docking.....
Sent Measured Length
Downloading recipe....
Outfeed table is full. Please remove cut pieces to continue
Printing Label

Failsafe: Gripper cut aborted. Press Start to cut safely..
Shutdown: Reset Estop to continue or press Stop to park in current state
Controller Error
Outfeed Beam sensor is blocked
Outfeed Clear sensor is blocked
Infeed Load Cycle Failed. Please try again
Waiting for transfer table to clear
Please reset Emergency Stop
Please press 'F10 Reset Machine'
Eject Table is jammed. Please remove the offcut.
Gripper switch illegally activated. Blockage must be cleared.
Material At Fence Sensor Blocked. Please clear to continue
Saw Tilt Not Home
Saw Tilt not at pos 1
Saw Tilt not at pos 2
Machining Centre Infeed Top Clamp not home
Machining Centre Infeed Side Clamp not home
Machining Centre Outfeed Top Clamp not home
Machining Centre Outfeed Side Clamp not home
Saw Infeed Side Clamp not home
Saw Infeed Top Roller not home
Machining Centre Infeed Side Wide Position not home
Machining Centre Outfeed Top Tall Position not home
Machining Centre Outfeed Side Wide Position not home
Saw Infeed Top Tall Position not home
Saw Outfeed Top Tall Position not home
Check that profile is not wedged on the gripper
If the gripper is clear, press start to attempt reload
If gripper is not clear, it could be damaged
On Drive X
On Drive Y
On Drive Z
On Drive G
On Drive V
On Drive W
On Drive B

On Drive R

Recipe Download Mismatch
Offcut Sensor Calibration Measuring.....
Bar Too Short for Offcut Calibration
Offcut Sensor Calibration Finished
Remove bar from gripper infeed area
Saw Cut Axis (SZ) is blocked from moving fully down. Check for Swarf.
Recipe Dowload Error. Machine cannot continue
Gripper has not released profile. Attempting to release.....
Waiting for spindle start (other spindles need to stop)....
Waiting for drives to settle.....
Debug mode, press start to activate next command
Safety device Outfeed Clear sensor is not working and needs to be repaired
Cannot Return X: Under Roller #1 Not Retracted
Cannot Return X: Under Roller #2 Not Retracted
Cannot Return X: Under Roller #3 Not Retracted
Cannot Return X: Under Roller #4 Not Retracted
Cannot Return X: Eject Push to Transfer Table Not Home
Datuming Axis group 1 of 3
Datuming Axis group 2 of 3
Datuming Axis group 3 of 3
Profile Base Plates Need to be removed
Profile Base Plates Need to be changed to RED
Profile Base Plates Need to be changed to GREEN
Profile Base Plates Need to be changed to BLUE
Pusher EndPiece Needs to be removed
Pusher EndPiece Need to be changed to RED
Pusher EndPiece Need to be changed to GREEN
Pusher EndPiece Need to be changed to BLUE
Infeed Light Guard Has Been Interrupted
Next Piece must be manually removed.
Press Start when the part is clear.
Cannot Initialise Axis until light beam clear