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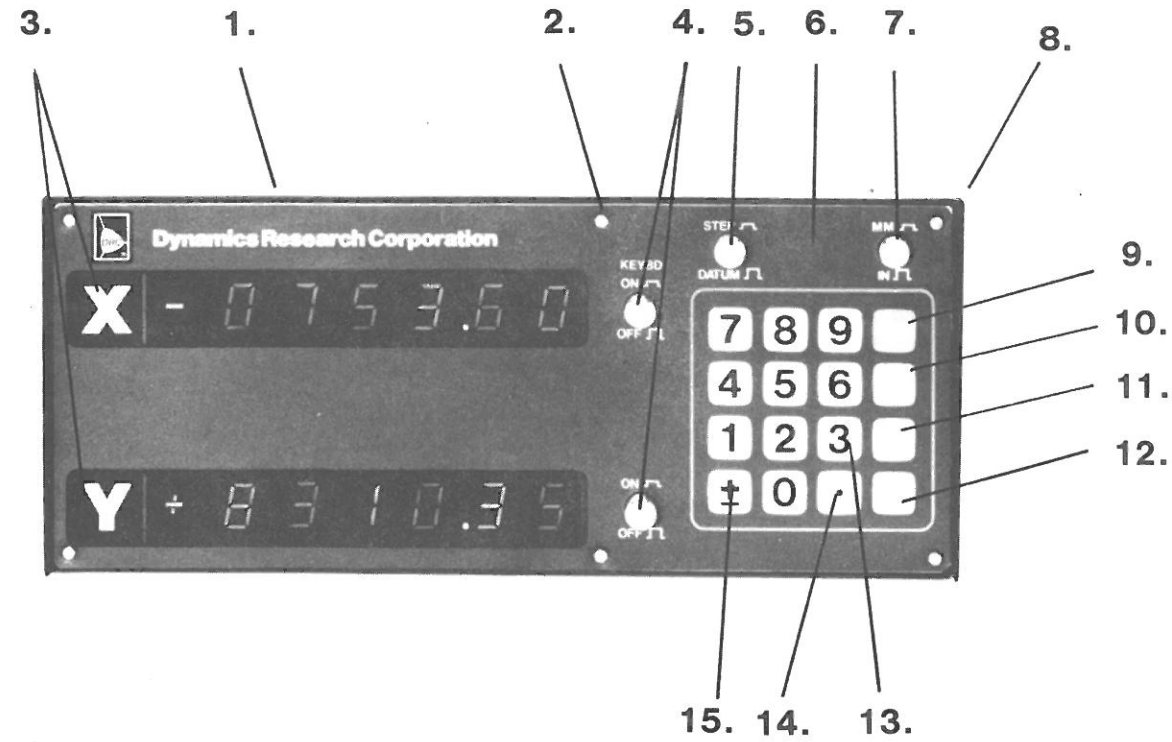
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1. ONE PIECE DISPLAY AND TOUCH SENSITIVE KEYBOARD OVERLAY
2. SCREWS FOR QUICK REMOVAL OF FRONT PANEL AND KEYBOARD (ALSO PERMITS EASY ACCESS TO REPLACE INDIVIDUAL LED's)
3. DIGITAL LED DISPLAYS
4. AXIS SELECTION BUTTONS
5. STEP/DATUM BUTTON
6. RADIUS/DIAMETER BUTTON (OPTIONAL; NOT SHOWN)
7. INCH/METRIC SELECTION BUTTON
8. CALCULATOR KEYBOARD
9. EXM-PRESET MEMORY EXAMINATION KEY
10. STO-STORAGE ENTRY KEY
11. PRE-PRESETS KEY
12. CLR-CLEAR KEY
13. NUMERIC KEYS
14. DECIMAL KEY
15. SIGN KEY

Figure 1-1. DRC 700 Display Front View

2. OPERATING INSTRUCTIONS For The DRC 700/1400 COUNTER

2.1 GENERAL INSTRUCTIONS

TO ACTIVATE UNIT-Turn on Power Switch on back of unit. Only minus sign will light. Depress the keyboard ON/OFF button for each display axis, then depress the "CLR" key and the entire display will light. This procedure must be followed each time power interruption has occurred in order to light the display. This operational characteristic is also a signal to the operator that a momentary power interruption has occurred so as to remind him of the need to recalibrate the table position under this circumstance.

TO ENTER PRESETS-Activate the axis which you want to preset and enter the desired dimension which will instantly appear in the display. Depress the "STO" key to store that dimension in the preset memory. That dimension will remain in the preset memory until either some other dimension is entered or until a power interruption occurs. A momentary depression of the "EXM" key enables one to examine the contents of the preset memory without affecting counting or the contents of either step or datum memories. To permanently recall a stored dimension depress the "PRE" key.

2.2 FEATURES

OVER-TRAVEL-The 6½ digit display of the DRC 700/1400 exceeds the measurement requirements of most machine tool applications. It is possible, however, for an operator to enter a large dimension and then move in a direction which would exceed a number which could be displayed. The DRC 700/1400 system will indicate such an error by displaying all "E's", and will continue to count internally until the machine axis travel limits have been reached. When travel is reversed and the original position is reached or beyond, the display picks up the count and continues to show the correct measurement. In other words, exceeding the capability of the display either by overtravel or an inch/millimeter conversion of very large dimensions will never cause the system to lose count.

KEYBOARD ROUNDING-The DRC 700/1400 system will automatically round all keyboard entries to the nearest number of the system's resolution in both inches and millimeters. If, for example, an operator using a 0.0005" resolution system enters 0.0006", the display will read 0.0005". If the operator enters 0.0008", the display will read 0.0010". The operator need never concern himself with the rounding of dimensions. The DRC 700/1400 system does it automatically.

EXAMINE KEY-The EXM key on the DRC 700/1400 keyboard allows the user to examine the contents of the PRESET STORAGE without altering the contents of either the STEP or DATUM memories. This key is a momentary contact type and when released, the display returns to the previous dimension. Counting continues if travel occurs.

CALCULATOR KEYBOARD-The DRC 700/1400 keyboard entry allows numbers to be entered as they are normally stated. It uses a floating decimal and corresponds to calculator-type operation.

INSTANT INCH-MILLIMETER CONVERSION-The english-metric conversion feature of the DRC 700/1400 system is an **exact** conversion. All calculations are two digits more accurate than what is displayed. The results are then rounded to the resolution of the system and displayed error free.

KEYBOARD SOFTWARE-The DRC 700/1400 system software will not allow any "illegal" entries. If, for example, more digit keys are depressed than the counter can display (if the user pressed his palm against the keyboard), the software will ignore those additional entries that cannot be displayed. If, for another example, a number is entered in millimeters that is too large to be displayed in inches, the display will show the error code all "E's". In other words, any numeric value which is displayed must be a valid one by design.

PLUS-MINUS-If the plus-minus key of the DRC 700/1400 keyboard is pressed, the sign of the value being displayed will change without affecting the magnitude of that value.

AXIS SELECTION-The DRC 700/1400 has an enable-disable switch on the front panel which allows the user to disable the keyboard. This protects the position integrity from accidental keyboard contact.

KEYBOARD ROLLOVER-The DRC 700/1400 keyboard software is structured such that once a key has been pressed no others will be acknowledged until it is released. This protects against "double-hits" of the keyboard.

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