

Doosan MX Series Alarm List

Alarm No.	Message
2001	WHETHER EMERGENCY BUTTON IS PRESSED OR OVERTRAVEL OF AXES IS DETECTED, RELEASE EMERGENCY BUTTON AND LIMIT SWITCH FOR OVERTRAVEL CHECK.
2002	THE ALARMS OF THE MAIN SPINDLE MOTOR AND SERVO UNIT DETECTED, CHECK ALARM DISPLAY ON THE SERVO UNIT THEN RETRY AFTER POWER OFF-ON.
2003	OVERCURRENT IN THE CONTROL POWER CIRCUIT, ABNORMALLY LARGE CURRENT FLOW IS DETECTED IN THE CONTROL POWER CIRCUIT, CHECK FOR CONTROL POWER SHORT CIRCUIT.
2004	HYD. PUMP MOTOR OVERLOAD IS DETECTED, CHECK OVERLOAD VALUE ON THE THERMAL RELAY AND MOTOR.
2005	HYD. PRESSURE IS DOWN, CHECK HYD. PRESSURE SWITCH, PRESSURE VALUE AND LEAKAGE OF HYDRAULIC.
2007	SPINDLE ROTATION IS ABNORMAL.
2009	REMOVING SPINDLE EMERGENCY STOP
2010	INVERTER FAULT ALARM
2011	KEEP RELAY SETTING ALARM. PLEASE CHECK THE KEEP RELAY(K5,K5)
2016	PSM POWER RUNNING ALARM. PLEASE CHECK AUXILLARY CONTACT ON THE MAGNETIC CONTACTOR (KM10 OR KM110).
2019	MILLING SPINDLE ORIENTATION OVERTIME
2020	COOLANT & LUB. PUMP MOTOR OVERLOAD OR Q11 FOR SERVO TURRET, CHIP CONVEYOR AND BAR FEEDER OVERLOAD IS DETECTED.
2021	TORQUE SKIP DATA ERROR
2022	SPINDLE ORIENTATION CONFIRM IS NOT DETECTED WITHIN 10SEC, CHECK ORIENTATION PARAMETER AND READJUST. ORIENTATION INDEX COMMAND ALARM.
2023	TOOL INDEX OVERTIME
2024	TOOL NUMBER COMMAND ALARM
2025	TOOL NUMBER SELECT KEEP RELAY SET ALARM
2027	SPINDLE SPEED ARRIVAL IS NOT DETECTED WITHIN 7SEC, CHECK SPINDLE SERVO UNIT.
2028	SPINDLE ROTATION CONDITION IS NOT READY, CHECK SPINDLE ROTATION CONDITION.
2029	SPLASH GUARD DOOR IS OPEN, CHECK SPLASH GUARD DOOR OPEN ANDLIMIT SWITCHES.
2030	M17 OR M18 IS COMMANDED IN ILLEGAL MODE, PLEASE CONFIRM MDI MODE.

- 2031 PLEASE MANUAL REF.POINT RETURN, OTHERWISE AUTO.OPERATION IS IMPOSSIBLE.
- 2032 FEEDHOLD PUSH BUTTON IS PRESSED.
- 2033 AIR OR COOLANT PRESSURE SWITCH IS DOWN.
- 2034 PROXIMITY SWITCH FOR CHUCK CLAMP CONFIRM POSITION ERROR, RESET SWITCH POSITION (PX1.M) (PX2.M)
- 2035 AXIS CHANGE OVERTIME.
M68 OR M69, M168 OR M169 IS NOT FINISHED WITHIN 15SEC AFTER
2036 COMMAND, CHECK SOLENOID VALVE, POSITION SWITCH AND OPERATION CONDITION.
- 2037 M78 OR M79 IS NOT FINISHED, WITHIN 15SEC AFTER COMMAND, CHECK SOLENOID VALVE, POSITION SWITCH AND OPERATION CONDITION.
- 2038 M45,M46,M47 IS NOT FINISHED WITHIN 15SEC AFTER COMMAND, CHECK SOLENOID VALVE, POSITION SWITCH AND OPERATION CONDITION.
- 2039 M10 OR M11 COMMAND ALARM, CHECK SOLENOID VALVE, POSITION SWITCH AND OPERATION CONDITION.
- 2040 M50 OR M51 IS NOT FINISHED, WITHIN 15SEC AFTER COMMAND, CHECK SOLENOID VALVE, POSITION SWITCH AND OPERATION CONDITION.
- 2041 THE ALARMS OF THE BARFEEDER IS DETECTED, CHECK BAR-FEEDER.
- 2042 M52, M53, M152 OR M153 IS NOT FINISHED, WITHIN 15SEC AFTER COMMAND, CHECK SOLENOID VALVE, POSITION SWITCH AND OPERATION CONDITION.
- 2043 M58 OR M59 IS NOT FINISHED, WITHIN 15SEC AFTER COMMAND, CHECK SOLENOID VALVE, POSITION SWITCH, AND OPERATION CONDITION.
- 2045 Q-SETTER OPERATION ALARM. CHECK SENSOR AND SOLENOID. TO MEASURE X1-AXIS THAT Y-AXIS SHOULD BE LOCATED AT 0. (1ST.REF) POSITION
- 2046 CHUCK IS OPENED DURING THE SPINDLE ROTATION, CHECK HYD.PRESSURE.
- 2047 TURRET CLAMP SWITCH ERROR
- 2048 THE RESET COMMAND IS USED WHILE PROGRAM IS RUNNING.
- 2049 M88,M89,M90,M188,M189,M190 COMMAND ALARM. CHECK SOLENOID VALVE, POSITION SWITCH AND OPERATION CONDITION.
- 2050 LUB.PRESSURE IS DOWN OR LUBRICATION OIL LEVEL IS LOW,CHECK LUB.UNIT AND REPLENISH THE OIL.
- 2051 OIL COOLER ALARM
- 2052 M61 OR M62, M161 OR M162 IS NOT FINISHED WITHIN 15SEC AFTER COMMAND. PLEASE CHECK INITIAL CONDITION.
- 2053 WORK EJECTOR & DETECTOR ALARM
- 2054 MILLING SPINDLE IS UNCLAMPED.MILLING SPINDLE SHOULD BE CLMAPED IN TURNING MODE.

- 2055 ILLEGAL SYNCHRO INITIAL STATE IS DETECTING . PLEASE CHECK CHUCK STATE.
- 2056 THIS COMMAND CANNOT BE PERFORMED. PLEASE PERFORM THE REF. POSITION RETURN OF X & Y-AXIS BEFORE THIS COMMAND.
- 2057 TOOL LIFE COUNT END ALARM.
- 2058 PARTS COUNT END ALARM.
- 2059 M,T-CODE COMMAND ALARM WITH A-AXIS.
- 2060 CHUCK UNCLAMP STATUS.
- 2061 SAFETY LOCKING SWITCH ALARM. PLEASE CHECK CONDITION OF THE LOCKING KEY SWITCH OR WIRE CONDITION THAT IS CONNECTING BETWEEN NO.11 AND NO.12 IN SAFETY LOCKING SWITCH.
- 2062 LIMIT SWITCH FOR PROGRAMABLE TAILSTOCK IS NOT OPERATED WITHIN 5SEC AFTER COMMAND, CHECK SOLENOID VALVES AND LIMIT SWITCHES.
- 2063 PROXIMITY SWITCH FOR Q-SETTER IS NOT OPERATED WITHIN 5SEC AFTER COMMAND, CHECK SOLENOID VALVES AND PROXIMITY SWITCHES.
- 2064 M66 OR M67 COMMAND ON THE M/C, THE NEXT M03 OR M04 COMMAND.
- 2065 Y-AXIS IS NOT IN A REFERENCE POSITION. PLEASE RETURN THE Y-AXIS TO REFERENCE POSITION FOR BT-AXIS MOVING.
- 2066 CHECK POSITION DETECTING SWITCHES ARE OPERATED SIMULTANEOUSLY, CHECK SWITCH.
- 2067 TOOL SWITCH ALARM
- 2068 DRY RUN STATUS. IF YOU PRESS CYCLE START BUTTON, THIS ALARM WILL RESET.
- 2069 COOLANT FILTER CHANGE ALARM
- 2070 SPINDLE COMMAND IS ABNORMAL. CHANGE SPINDLE COMMAND AFTER SPINDLE STOP(M05/M35/M65/M105/M165).
- 2071 CHIP CONVEYOR ALARM
- 2072 TORQUE ALARM
- 2073 ILLEGAL COMMAND ALARM
- 2074 COOLJET LOW PRESSURE OR FILTER BLOCK ALARM
- 2075 TOTAL CYCLE START ALARM
- 2076 HIGH PRESSURE FILTER OR COOLJET FILTER BLOCK
- 2077 MILLING SPINDLE CLAMP, UNCLAMP COMMAND ALARM. MILLING SPINDLE IS ROTATING OR SENSOR IS ABNORMAL.
- 2078 B-AXIS DISC CLAMP COMMAND IS NOT AVAILABLE WHEN NEW TYPE B-AXIS IS USED.
- 2079 B-AXIS SENSOR ALARM. PLEASE CHECK THE B-AXIS DISC CLAMP CHECK SENSOR AND CURVIC CLAMP CHECK SENSOR.
- 2080 B-AXIS ANGLE IS NOT A MULTIPLE OF 15 DEGREE

2081 B-AXIS POSITION S/W ALARM
2082 MILLING SPINDLE IS CLAMPED YET
2083 MILLING SPINDLE IS UNCLAMPED YET
2084 IN HANDLE MODE, CAN'T CHANGE TOOL OFFSET WITH Q-SETTER.
PLEASE, CHANGE MODE TO JOG MODE AND TRY AGAIN.
2085 RETURN THE REFERENCE POINT OF X1 AND X2-AXIS FOR MOVING A-AXIS.
2086 TOOL MONITOR ALARM.DETECT ABNORMAL LOAD AND TOOL WARN
ALARM
2087 TOOL MONITOR ALARM.DETECT ABNORMAL LOAD AND TOOL BROKEN
ALARM
2088 THE SPINDLE SWITCHING IS INVALID IN RIGID TAPPING MODE. CANCEL
RIGID TAPPING MODE TO SWITCH OTHER SPINDLE.
2089 B-AXIS IS NOT CLAMPED YET. PLEASE MAKE SURE THAT THE B-AXIS IS
CLAMPED BY M106,M110 OR M112.
2090 PROGRAM RESTART TOGGLE SWITCH ON STATE.
2091 SERVO TURRET BATTERY LOW ALARM, PLEASE CHANGE BATTERY IN
AMP. MODULE WITHIN 2 WEEKS.
2092 SPINDLE COMMAND ALARM. WHEN COMPOSITION CONTROL MODE, REV-
SPINDLE RECOMMAND IS IMPOSSIBLE AFTER REV-SPINDLE STOP.
2093 REFERENCE COMMAND FROM REFERENCE POSITION KEEP STATE.
2094 HIGH LOW CHUCK SWITCHING STATE. OPERATE CHUCK AS UNCLAMPING
AND CLAMPING BY FOOT SWITCH.
2095 RIGID TAPPING OR ORIENTATION COMMAND ALARM. M19 OR M119, M29
IS INVALID ON G96 MODE. PLEASE MODIFY PROGRAM.
2096 SPINDLE OVERRIDE OR FEEDRATE 0%.
2097 MACHINE LOCK ON STATUS.
2098 M00 OR M01 COMMAND.
2099 M02 OR M30 COMMAND.
2100 MACHINE IS IN SERVICE MODE. 1)MACHINE WILL OPERATE WITH DOOR
OPEN. 2)SPINDLE WILL NOT START UNLESS THE DOOR IS
CLOSED.3)TAPPING OR THREADING MAY NOT WORK UNLESS THE DOOR
IS
2101 SPINDLE TOOL UNCLAMP ALARM
2102 MAIN POWER PHASE ALARM
2103 M06 OVERTIME ALARM
2104 T-CODE COMMAND ERROR
2105 ATC OPERATION COMMAND ERROR
2106 TOOL POST SEARCH OVERTIME ALARM
2107 ATC MAGAZINE ROTATION OVERTIME ALARM
2108 ATC DOOR SWITCH ERROR

- 2109 TOOL MAGAZINE SYNCHRO MAL-FUNCTION
- 2110 ATC INTERLOCK ALARM
- 2111 ATC MAGAZINE GUARD DOOR OPEN
- 2112 MAINTENANCE MODE ON STATE
- 2113 M149 COMMAND ERROR
- 2114 SPINDLE TOOL INTERFERENCE ALARM
- 2115 SPINDLE TOOL NO.IS MISMATCHED
- 2116 MINI-TURRET 180 COMMAND ALARM. MILLING SPINDLE SHOULD BE ORIENTATED BEFORE COMMAND G400 J12.
- 2117 MUST BE ATC 1CYCLE
- 2118 ATC OP MANUAL MODE
- 2119 SPINDLE AND WAITING TOOL NUMBER IS ZERO.
- 2120 SPLASH GUARD DOOR MUST BE OPENED WHEN THE TOOL UNCLAMP OPERATION IS DOING IN MANUAL MODE
- 2121 TOOL NUMBER SELECT KEEP RELAY IS NOT SET PROPERLY.
- 2122 TOOL CHANGER MOTOR BRAKE RELEASE
- 2123 TOOL SEARCH ILLEGAL ALARM
- 2124 M06 COMMAND ILLEGAL POSITION
- 2125 SPINDLE TOOL CLAMP/UNCLAMP ALARM
- 2126 WAITING POT SWITCH ERROR
- 2127 CHANGER ARM POSITION CHECK ALARM
- 2128 MUST BE COMMAND NEXT TOOL NO.
- 2129 ATC OPERATION COMMAND ERROR
- 2130 CONSTANT SURFACE COMMAND ALARM.IN COMPOSITION CONTROL MODE, THE CONSTANT SURFACE CONTROL COMMAND FROM LOWER(UPPER) MUST BE COMMANDED AFTER MILLING ROTATING COMMAND
- 2131 SPINDLE COMMAND ALARM. AFTER SPINDLE SELECTION, SPINDLE ROTATION COMMAND IS VALID(M05/M35/M105/M135). IF SPINDLE TO SELECT IS ROTATING, MUST BE STOP SPINDLE TO SELECT
- 2132 ATFER MAIN POWER OFF/ON, C1 AND C2 AXES MUST BE RETURN REF.POINT BY MANUAL, OTHERWISE AUTO.OPERATION IS IMPOSSIBLE.
- 2133 COMPOSITION CONTROL COMMAND ALARM. AFTER SELECT C2-AXIS(M135)FROM UPPER OR C1-AXIS(M35) FROM LOWER, M211 COMMAND IS POSSIBLE.
- 2134 TURRET CONTROL UNIT ALARM. CHECK SERVO CONTORL UNIT IN CONTROL CABINET.
- 2135 LEFT SPINDLE RIGID TAP IS VALID ONLY FOR THE UPPER PATH AND RIGHT SPINDLE RIGID TAP IS VALID ONLY FOR LOWER PATH
- 2150 A-AXIS MOVEMONT IS PROHIBITED IN CHUCKING CLOSED CONDITION

2161 SPINDLE WARM UP IS REQUESTED. PLEASE RUNNING ALL SPINDLES
MORE THAN 15 MINUTES UNDER 1,000RPM

2162 SPINDLE WARM UP IS COMPLETED

2165 CHECK HOME POSITION OF EACH UNIT FOR PARTS CATCHER(STOPPER
ADV:X64.5, BODY RET:X64.6, BUCKET RET:X65.2, ARM RET:X65.4)

2166 A-AXIS IS REF.POINT AND Z1,Z2-AXIS IS IN RIGHT POSITION REGION FROM
REF.POINT, M310/M311/M256 COMMAND CONDITION :A-AXIS IS REF. POINT
AND Z1 AND Z2 AXIS IS IN LEFT POSITION REGION FROM REF.

2167 CUTTING FEED COMMAND IS COMMANDED WHEN THE B-AXIS IS NOT
CLAMPED YET.

2168 RETURN A-AXIS TO THE REFERENCE POINT FOR MOVING Z2-AXIS OR
COMMAND M217 TO RELEASE Z2 AXIS INTERLOCK.

2169 EXIN DATA READ ALARM.

2170 IT IS NOT ABLE TO MOVE Z-AXIS WHEN WAITING POT IS NOT IN THEIR
HOME POSITION(WAITING POT UP AND HOME POSITION)

2173 LUBRICATION OIL LEVEL IS LOW.

2174 TOUCH PROBE UNIT ALARM. BATTERY IS LOW OR SIGNAL LEVEL IS LOW.

2175 TRANSFERRING WITH FEED FROM THE TURRET UNCLAMP CONDITION
WHICH IS IMPOSSIBLE.

2176 THIS COMMAND CANNOT BE PERFORMED. PLEASE PERFORM THE REF.
POSITION RETURN OF C1 & C2-AXIS BEFORE THIS COMMAND.

2177 TOOL SPINDLE OVERLOAD ALARM, PLEASE CHECK CUTTING CONDITION
IN PROGRAM.

2178 C-AXIS HIGH/LOW CLAMP OR UNCLAMP M-COMMAND CONDITION
ALARM. THE M88 OR M89,M90(M188 OR M189,M190) COMMAND OF THE
OTHER PATH IS VALID IN COMPOSITION CONTROL STATE.

2179 LOWER TURRET CAN NOT INDEX OR MOVE TO -Z2 DIRECTION IN
INTERFERENCE AREA WITH LEFT SPINDLE. PLEASE MOVE THE Z2-AXIS TO
THE RIGHT WHERE THE INTERFERENCE WITH LEFT SPINDLE IS NOT

2180 X2-AXIS CAN NOT MOVE IN INTERFERENCE AREA WITH LEFT SPINDLE.
PLEASE MOVE THE Z2-AXIS TO THE RIGHT WHERE THE INTERFERENCE
WITH LEFT SPINDLE IS NOT EXIST.

2181 KNOLL COOLANT SYSTEM ALARM@0A@

2182 Y-AXIS & A-AXIS ARE IN INTERFERENCE AREA. PLEASE CHECK THE
INTERFERENCE AREA

2185 CHECK HOME POSITION OF EACH UNIT FOR PARTS CATCHER(STOPPER
ADV:X64.5, BODY RET:XX64.6, BUCKET RET:X65.2, ARM RET:X65.4@0A@)

2186 WHEN PARTS UNLOADER IS OPERATING BY M256 COMMAND,THE Z1,Z2-
AXIS CAN MOVE ONLY IN THE LEFT POSITION REGION FROM REF.POINT.

2187 RIGHT SPINDLE ROTATION STATE. PLEASE SPINDLE STOP.

2188 PROGRAM START M FUNCTION ALARM. PLEASE CHECK M-CODE (M23)

- 2189 C-AXIS BRAKE NOT RELEASED, PLEASE CHECK C-AXIS UNCLAMP
SOLENOID VALVE AND PRESSURE SWITCH.
- 2190 PROGRAM RESTART ERROR BY OPTIONAL STOP. MUST BE IN STATE OF
UPPER/LOWER UNIT AND MEM MODE TO RESTART PROGRAM STOPPED BY
OPTIONAL STOP ON MEM MODE.
- 2192 TAIL STOCK INTERLOCK ALARM, PLEASE CHECK THE POSITION OF Z-AXIS
AND TAIL STOCK.
- 2193 THE PROGRAM NUMBER OF UPPER UNIT AND ONE OF LOWER UNIT ARE
NOT SAME. PLEASE CHECK PROGRAM NUMBER OR SET K60.1(CHECK
PROGRAM NUMBER) TO 0