3.2.4 TV CHECK (TAPE VERTICAL RARITY CHECK)

When the tapes are to be checked for vertical parity, programs must be so made that each block (including EOB) contains even number of characters. Normally, SP codes are used to make the number of characters even.

The TV check function is turned on and off by the setting function. While the TV check function is on, all blocks containing odd number of characters are regarded as errors.

Setting No.: $\#6000_{D}6 = 0$ ··· TV check off

$\#6000_{D}6 = 1$ ··· TV check on

3.3 PART PROGRAM TAPE PUNCHING

3.3.1 PAPER TAPE SELECT

For part program tapes, eight-channel paper tapes for computers conforming to JIS C6243 (width: 25.4 ±0.08 mm, thickness: 0.108 mm) are used.

The color should be black or gray.
Tapes with high transparency tend to cause reading errors, and should not be used.

3.3.2 NC TAPE PUNCH

Part programs written on process sheets are punched in EIA or ISO codes in paper tape with a tape puncher.

A part program tape should be provided with a proper length of feed hole part at the leading and the trailing ends. For a tape reader using 6" reels, the feed hole length should be at least 70 cm, and for a tape reader using 8" reels, it should be at least 1 m.

3.3.3 NC TAPE CHECK

Punched part program tapes can be checked by an NC with the following functions.

· Machine lock
· M function lock
· Dry run
· Single block operation

3.4 PART PROGRAM TAPE HANDLING

3.4.1 SPLICNG NC TAPE

To join part program tapes, the two ends should be placed end to end without overlapping and without a space, and a proper length of splice tape should be pasted on one side. (approx. 0.08 mm in thickness) Splice tapes are available in the fully perforated type and in the type with which only the feed holes are punched, but the former is more convenient. After splicing, the tape should be checked for correct alignment of the feed holes before use. Do not use rigid industrial adhesive, and do not make the joint too thick, as these conditions are conductive to jamming troubles.
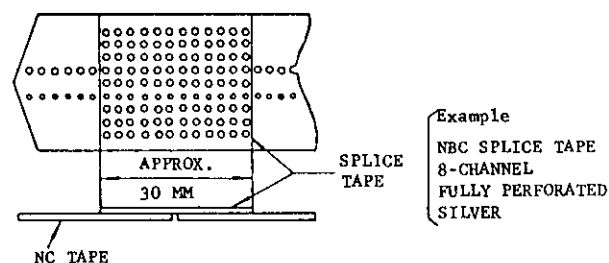

Fig. 3.4 Splicing Part Program Tape

3.4.2 KEEPING NC TAPE

Part program tapes should be stored in a clean area, free of contaminants and humidity. Do not handle part program tapes wearing gloves contaminated with oil or cutting fluid.
Generally, properly maintained part program tapes can last at least 300 cycles, with one cycle consisting of one reading and one rewinding pass.