

6.1.19 OPTIONAL BLOCK SKIP SWITCH (CONT'D)

2. While this switch is off, blocks including a "/" are executed along with other blocks. This switch is ineffective on the block under execution and blocks stored in the advance-reading buffer. When this switch is turned on during an automatic operation cycle, it works on the block read after the switching on has occurred.

NOTES:

- a. The two commands "/" and "/1" are equivalent.
- b. With the control provided with the optional block skip B function⁺, 8 independent blocks can be skipped with the switching of the switches corresponding to "/2" through "/9."

6.1.20 DRY RUN SWITCH

Turning on the DRY RUN switch in the TAPE, MDI or MEM mode causes the tool to move at the speed selected by the JOG FEEDRATE switch, ignoring all programmed F-functions. F commands can be displayed as they are programmed. This switch may be used to check the program.

Rapid traverse (G00) rate for dry run operation can be set by setting parameter # "6006D2."

Parameter # "6006D2"	Rapid Traverse at Dry Run Operation
"0"	Rapid traverse rate*
"1"	Jog feedrate

* The tool moves at the traverse rate set by RAPID TRAVERSE RATE OVERRIDE switch if provided.

NOTES:

- Switching the DRY RUN switch during automatic operation becomes effective on the current block. Switching it in mm/rev mode[†] or during tapping becomes effective on the next block.
- Rapid traverse rate override is kept effective during dry run operation.
- During tapping, the set speed when tapping starts will be kept. It cannot be changed by JOG operation during dry run operation.



Fig. 6.11

6.1.21 DISPLAY LOCK/MACHINE LOCK SWITCH

This switch functions to stop updating the position display, or to stop move command pulses to the servos. This switch cannot be set unless the machine is stopped at block end or temporarily stopped by FEEDHOLD pushbutton.

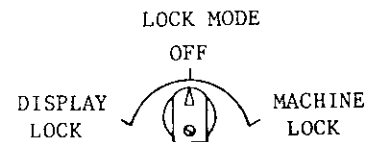


Fig. 6.12

"OFF"

Usual operation is made at "OFF" position in both manual and automatic operation. The machine and the position display operate according to the command by automatic operation or manual operation.

"DISPLAY LOCK"

This position is used to exclude the axis movement value from the position display. Current position display is not updated, though the machine moves.

"MACHINE LOCK"

Setting the switch at MACHINE LOCK inhibits axis movement including Zero Return. The position display is updated. M-, S-, and T-functions are executed. This position is selected to preset the display or to check the tape data.

6.1.22 Z-AXIS FEED NEGLECT SWITCH

The switch is used for dry run operation or drawing-check operation on the X-Y plane. Turning on the switch causes the Z-axis in MACHINE LOCK condition. The Z-axis movement is inhibited, though the position display is updated.

Operate the switch when the machine is stopped. That is, the switch does not function except when the machine is stopped at the block end by SINGLE BLOCK switch or temporarily stopped by FEED HOLD pushbutton.