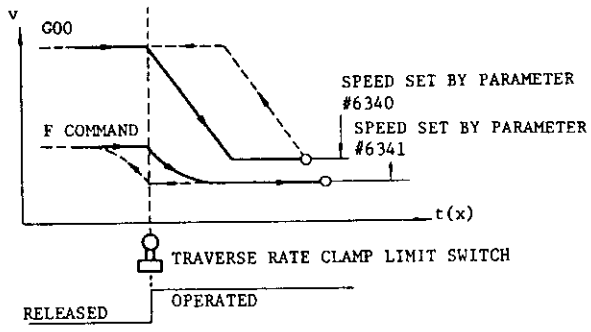

Fig. 6.20

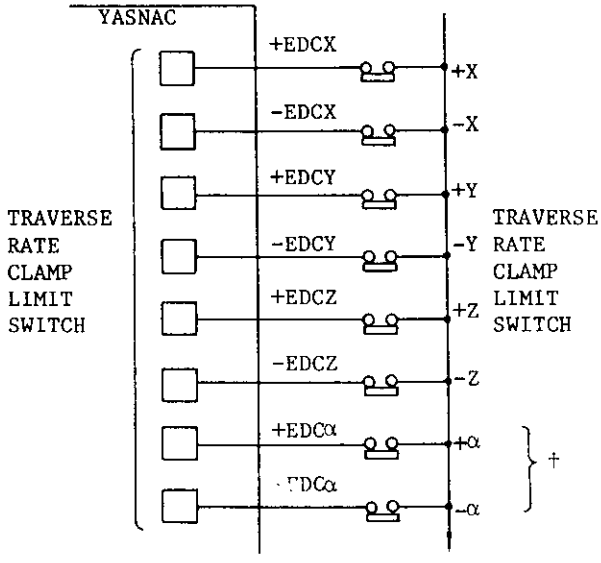

Fig. 6.21

Notes:

i. The external deceleration function is ineffective on feedrate specified in mm per revolution of the spindle (mm/rev).

ii. It is also ineffective on the HANDLE feed.

6.2 OPERATION PROCEDURE

6.2.1 MANUAL RETURN TO REFERENCE POINT

With this function, the tool is returned to the reference point manually. The procedure is as follows.

1. Set the mode select switch to RAPID or JOG.

2. Manually move the tool to a position some distance away from the reference point. When the tool is within the range A shown below, it can be brought back to the reference point in the normal way, as described below.

3. Turn on the REFERENCE POINT RETURN switch.

4. Keep the JOG button for the return direction depressed. The tool starts to move as in the normal manual control, but the speed is decelerated at the deceleration point, and the motion stops automatically at the reference point.

5. Then, the REFERENCE POINT lamp for the relevant axis lights.

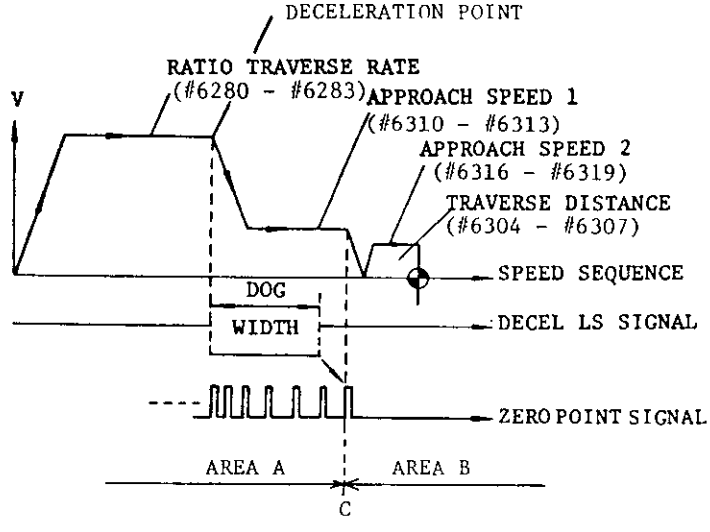

Fig. 6.22

NOTES:

a. As long as the power supply is turned on, either the manual or the automatic return to reference point can be initiated, regardless of the tool position, but the tool will not return to the reference point accurately if the tool is started from a point in the area B. Be sure to bring the tool into the area A before initiating a manual or automatic return motion.

b. Once the tool is returned to the reference point, the point C is stored, and if the reference return motion is initiated from a point in the area B, this is regarded as an error. Start the reference return motion from a position in the area A.