3. PART PROGRAM TAPE CODING

3.1 TAPE CODE

3.1.1 TAPE CODE

With this control, both the EIA and the ISO codes can be used.

EIA code: EIA RS-244-A

ISO code: ISO 84

Table 3.1.1 shows the EIA and ISO punched tape formats.

Before starting programming any machining operations, decision must be made as to the code to be used.

3.1.2 EIA/ISO AUTO-SELECT

Before starting to use part program tapes, the control must be switched to the same code as the tapes, inaccordance with the procedure for writing-setting under 4.3.6 DISPLAY AND WRITING OF SETTING DATA.

When "1" is set with setting $\#6001_{D6}$, the control is automatically adapted to the code used for the part program tape. The control recognizes the code used when it reads the first EOB code in the label skip mode, and all the subsequent data will be read automatically in that code.

When "0" is set with $\#6001_{D6}$, the control will not discriminate the code used automatically, and will read all tapes in the code specified by the setting with $\#6000_{D7}$. That is:

When "0" is set with $\#6000_{D7}$ $\cdots$ EIA code

When "1" is set with $\#6000_{D7}$ $\cdots$ ISO code

If the code setting of the control and the code of the tape are different, alarm code 015 will be displayed.

NOTE: For punching tapes, the code must be selected by the setting of $\#6000_{D7}$.

3.2 PROGRAMMING

3.2.1 PROCESS SHEET

Programs are first drafted on process sheets.

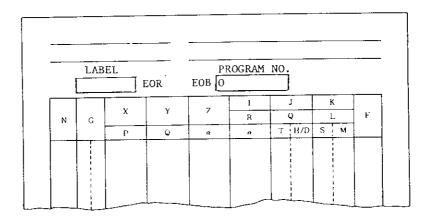Process sheets should be easy to read and to make corrections, and should preferably be designed and prepared by the user in conformity with the specifications of the NC.

Fig. 3.1 Example of Process Sheet