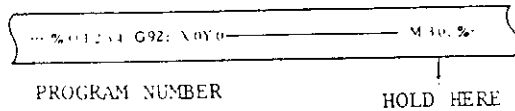


#### 4.5.1 LOADING PART PROGRAM TAPE INTO MEMORY (CONT'D)



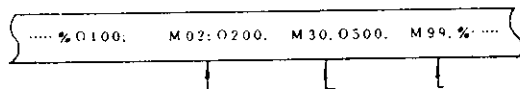
- d. Depress the RESET key.
- e. Key in "O" and PROGRAM NUMBER.
- f. Depress the IN key.

The program number entered from the key is registered in preference to the program number punched on the tape. At this time, the program number on the tape is written to the part program memory simply as a label.  
M02 ;, M30 ; or M99 ; is read and the storing operation is completed.

#### NOTE:

1. If a program is stored with a changed program number as described above, the program number punched on the tape is stored in the part program memory without change. Consequently, to avoid the confusion in the later handling, replace the program number in the part program memory with changed program number by the EDIT operation.

- (4) Loading part programs from a tape
  - a. Select EDIT mode.
  - b. Depress the PROG key.
  - c. Load the NC tape to the tape reader or an equivalent external device.



- d. Depress the RESET key.
  - e. Depress the IN key.
- Then the system starts to read the tape and enlists the program number punched on the tape as the first record. The system checks for duplication of program number as described in (2).

The tape reader stops each time it has read "M02 ;," "M30 ;," or "M99 ;."

- f. Depress the IN key again.

The tape reader resumes to read the tape. Repeat this operation until all programs are loaded.

- (5) Storing a program with program numbers changed II

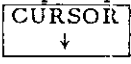
When "O" key is depressed and program number is keyed in before depressing IN key as described in (4) above, the keyed in program number is registered in preference to the program number punched on the NC tape.

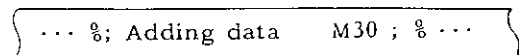
- (6) Loading programs continuously

Programs existing on a tape as shown in (4) may be loaded continuously without interruption. For this purpose, depress "O," "-", "9," "9," "9," and "9" before the first depression of the IN key. The tape reader stops at the position of "%."

#### 4.5.2 MAKING ADDITION TO A PART PROGRAM

Perform the following operation to add data to a part program which is already loaded.

- a. Select EDIT mode.
- b. Depress the PROG key
- c. Depress the O key then enter the part program number and depress the  key. The system searches the designated program.
- d. Load the tape of adding data to the tape reader.



- e. Depress the RESET key.
  - f. Depress the NEXT and IN keys in this order.
- The data will be read from the tape into the memory.

NOTE: You cannot add data to a program from the middle of it. If necessary, delete the last part of the program by editing operation and perform this adding.