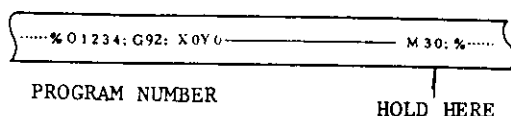


4.5 LOADING PART PROGRAMS INTO MEMORY

4.5.1 LOADING PART PROGRAM TAPE INTO MEMORY

- (1) Loading a part program which has a program number.
 - a. Select EDIT mode.
 - b. Depress the PROG key.
 - c. Load the NC tape to the tape reader or an equivalent external device.



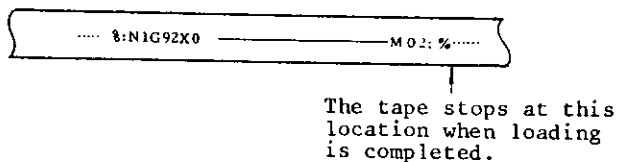
- d. Depress the RESET key.

- 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 duplicator of program number as in 1. Operation ends with error if the designated program number is not found on the tape.

When the tape reader has read "M02 ;," "M03 ;," or "M99 ;," it stops and "IN" disappears from the CRT. Now the part program has been stored in memory.

- (2) Loading a part program which has no program number.
 - a. Select EDIT mode.
 - b. Depress the PROG keys.
 - c. Load the NC tape to the tape reader or an equivalent external device.



- d. Depress the RESET key.
 - e. Depress the address O key then enter the program number.
 - f. Depress the IN key.

The system starts to read the tape. If the keyed-in program number coincides with the registered program number, "ALREADY IN" blinks on the CRT screen. If this happens, delete the program number, then repeat steps a. through f. while the tape is being read, "IN" blinks on the CRT.

- g. When the tape reader has read "M02 ;," "M03 ;," or "M99 ;," it stops and "IN" disappears from the CRT. Now the part program has been stored in memory.

NOTES:

1. Program number "00000" is always in the registered state, so it cannot be erased. This program number should not be used in general.
2. The tape which has no program number may be stored as described before. However, write a program number to the head of the tape, in principle. The operation of "Oxxxx IN" described before causes only program number registration. It does not cause the storing of information of "00000" into the part program memory. Only the program number on tape is stored into the memory. Assume that a tape having no program number is stored and then all part programs are punched out by depressing "0," "-", "9," "9," "9," "9," and "OUT" keys. Since this tape contains programs with no program number, the correct restoring of all part programs may not be performed by depressing "0," "-", "9," "9," "9," "9," and "IN" keys.
3. Consequently, when a tape having no program number has been stored, write the program number to the head of part program by the EDIT operation.

EXAMPLE:

N1 G92 X0 Z0 ;

When this is in the first block, position the cursor to N and key in as follows (in EDIT and PROG modes):

Oxxxx ; N1 ALTER

- (3) Storing a program with program numbers changed I

To register a program with a program number different from the one punched on tape, perform the following operations:

- a. Select the EDIT mode.
- b. Depress the PROG key.
- c. Set the NC tape to the tape reader or the external equivalent equipment.