4. The preceding or following page may be displayed by depressing the [↑ PAGE] or [PAGE ↓] key. The cursor will be positioned at the first tool offset number displayed at this time.

5. Tool offset will be displayed in units of 0.001 mm (or (0.0001") and up to 999.999 mm (or 99.9999").

· Writing tool offset data

To rewrite a tool offset data, specify an increment which is to add arithmetically to a tool offset held in memory.

1. Position the cursor at the tool offset number whose offset data is to be changed.

2. Enter the increment which is to be added to the tool offset.

3. Depress the WR key. Then the specified increment will be added to the old tool offset.

NOTES:

· A new tool offset itself may be input instead of an increment. For this purpose, depress the ORG key first. The tool offset number pointed by the cursor will be reset to "0." Then enter a new tool offset.

· Tool offset data held in the memory of the control are preserved even after power is turned off.

· It is possible to rewrite tool offset data in any modes, even during automatic operation.

· Tool offsets modified during automatic operation become effective when the system starts to read commands for a new block. The old tool offsets remain effective for the current block and the blocks whose data are already read in the buffer for advance reading.

4.3.6 DISPLAYING AND WRITING SETTING DATA

In this system, varying setting data are held in the internal memory and permit to specify mirror image axes, TV check on/off, etc. For details, see Appendix 1, LIST OF SETTING NUMBERS.

It is possible to display and write setting data at any time even during automatic operation.

1, Types of setting

Setting is made in binary mode or decimal mode.

A. Binary mode

Setting numbers #6000-#6004 are associated with setting data of binary mode, that is, 8-bit information (D7-D0). Each bit indicates the on/off state of the associated function. The decimal value of each line is given at the rightmost column.

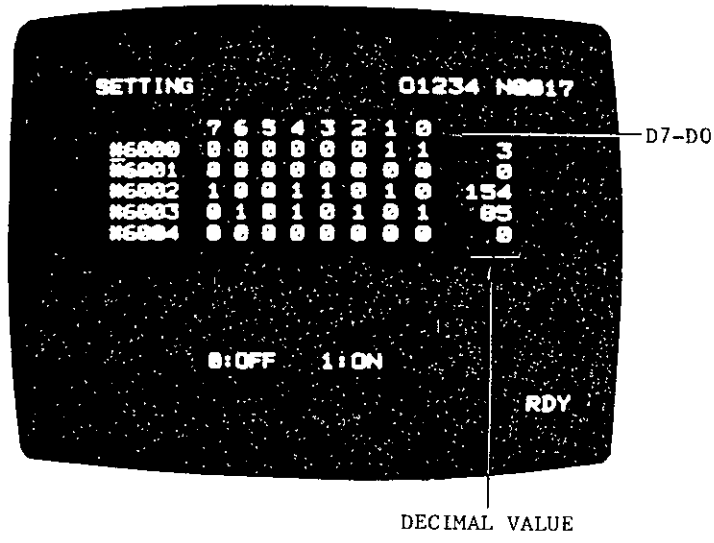

Fig. 4.25 Setting (Deciaml model)-Example

B. Decimal mode

Setting numbers of #6200-#6219 and #6500-#6599 are associated with setting data of decimal mode.

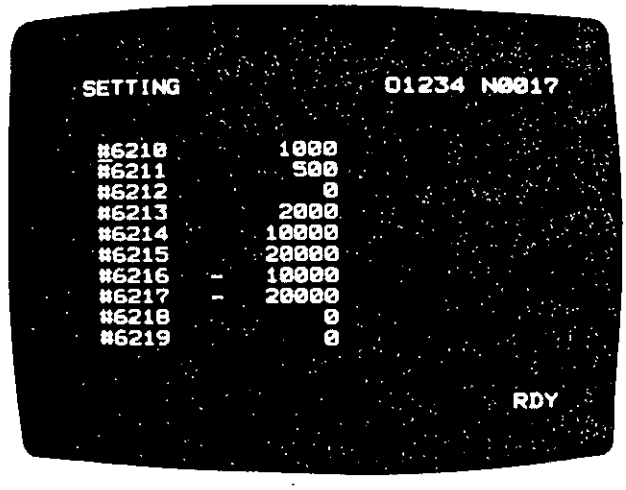

Fig. 4.26 Setting (Decimal mode)-Example