

4.4.2 INPUTTING SETTING DATA AND PARAMETER DATA

Though setting data and parameter data are inputted by MDI operation normally, they may also be entered by means of paper tape. Setting data and parameter data may be inputted from a single tape.

1. The tape format is as follows.

Label	%	:
#6000	X128	;
#6001	X 5	;
#6002	X 0	;
.	.	.
.	.	.
.	.	.
.	.	.
.	%	.

Notes:

1. "%" is used in the ISO code and "ER" in the EIA code.
2. "N" is used in the EIA code instead of "#."

2. The input operation is as follows.

- A. Select EDIT mode.
- B. Depress the RESET key.
- C. Depress the PRM key.
- D. Set the setting/parameter data tape onto the tape reader.
- E. Depress IN key.

The tape reader starts to read the tape. "IN" blinks on the CRT while the data are read.

- F. The tape reader stops when it has read "%" (or "ER"). "IN" disappears from the CRT. Now the setting/parameter data have been read into memory.

Turn on power again because the control is in the HOLT state (key inoperative) at completion of input.

4.4.3 OUTPUTTING TOOL OFFSETS TO PAPER TAPE

The tool offset data set in the system may be outputted to paper tape.

1. The output operation is as follows.

- A. Select EDIT mode.
- B. Depress the RESET key.
- C. Depress the OFS key.
- D. Check that the punch is ready for operation.

- E. Depress the OUT key.

The paper tape punch punches the tool offset data onto paper tape and stops automatically when all contents of the tool offset memory have been outputted.

- F. To suspend the operation, depress the RESET key.

At this time, the output operation cannot be resumed. Restart from the beginning.

2. The tape format is the same as that described in 4.4.1 INPUTTING TOOL OFFSETS FROM TAPE.

4.4.4 OUTPUTTING SETTING DATA AND PARAMETER DATA TO PAPER TAPE

1. The output operation is as follows.

- A. Select EDIT mode.
- B. Depress the RESET key.
- C. Depress the PRM key.
- D. Check that the punch is ready for operation.
- E. Depress the OUT key.

The paper tape punch punches the setting/parameter data onto paper tape continuously.

- F. To suspend the operation, depress the RESET key.

At this time, the output operation cannot be resumed. Restart from the beginning.

2. The tape format is the same as that described in 4.4.2 INPUTTING SETTING DATA AND PARAMETER DATA.

4.4.5 OUTPUTTING PART PROGRAM TO PAPER TAPE

- (1) The part program of the designated program number is punched out by the following operations:
 - a. Connect the external equipment such as the tape puncher to the NC via the data input/output interface.
 - b. Make the external equipment relay for operation.
 - c. Power on the NC.