

Table 6.4 FEEDRATE OVERRIDE

| STEP | % | STEP | % |
|------|-----|------|-----|
| 0 | 0 | 11 | 110 |
| 1 | 10 | 12 | 120 |
| 2 | 20 | 13 | 130 |
| 3 | 30 | 14 | 140 |
| 4 | 40 | 15 | 150 |
| 5 | 50 | 16 | 160 |
| 6 | 60 | 17 | 170 |
| 7 | 70 | 18 | 180 |
| 8 | 80 | 19 | 190 |
| 9 | 90 | 21 | 200 |
| 10 | 100 | | |

OVERRIDE
CANCEL

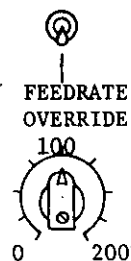


Fig. 6.8

6.1.13 FEEDRATE OVERRIDE CANCEL SWITCH

Turning on the OVERRIDE CANCEL switch prevents the function of FEEDRATE OVERRIDE switch.

6.1.14 SPINDLE SPEED OVERRIDE SWITCH†

1. With this switch, the current spindle speed can be changed to an override speed which is set at 10% intervals between 50 and 120% of the current spindle speed.
2. During the tapping cycle by G74 and G33 under the command of G84, the spindle speed may selectively be made independent of this switch, remaining at the speed set by an S code. This selection is made with the parameter #6007D2.

SPINDLE-SPEED
OVERRIDE†

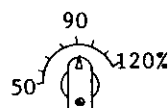


Fig. 6.9

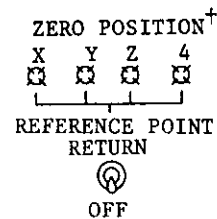
6.1.15 MANUAL REFERENCE POINT RETURN SWITCH†

This switch is for bringing the tool back to the reference point manually.

For its operation method, refer to 6.2.1 MANUAL RETURN TO REFERENCE POINT.

6.1.16 REFERENCE POINT LAMPS†

These lamps indicate that the tool is positioned on the reference point. They light when the tool is brought to the reference point through the manual or automatic return to reference point (G28), or by the reference point return check (G27), and goes out as the tool moves away from the reference point by a subsequent operation.



SINGLE
BLOCK
OFF

Fig. 6.10

6.1.17 SINGLE BLOCK SWITCH

Turning on this switch permits individual block-by-block operation. Turning on this switch after finishing the current block in the automatic operation mode, the machine stops. A block of data is executed each time the CYCLE START push-button is activated.

6.1.18 OPTIONAL STOP SWITCH

This switch is to execute M01 command in automatic operation mode (TAPE, MEM or MDI).

When the switch is on, the program stops on completion of the block including M01 command, while CYCLE START pushbutton remains illuminated. When the control catches FIN signal, the light is extinguished. To restart the program, depress the CYCLE START button. When the switch is off, M01 command is ignored.

Operation of the switch is not effective for the block being executed. During the automatic operation, the switch acts for the next block.

6.1.19 OPTIONAL BLOCK SKIP SWITCH

This switch selects whether the data in blocks including a "/" is disregarded or not.

1. While the switch is on, all the commands in a block programmed after a "/" are neglected. However, block data appearing before the "/" remains effective.