2.9.33.2 Restrictions on High-Speed Cutting Feature (Cont'd)

See NOTE.

```
┌─ ·─────────────┐
│ COMMAND (REG)      * O1234 N0018  │
│                                   │
│                                   │
│           PROGRAM                 │
│             REG                   │
│                                   │
│                                   │
│                                   │
│                   REG    RDY      │
└───────────────────────────────────┘
```
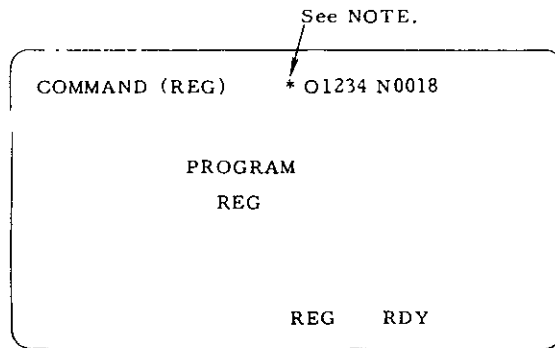
Note: During data processing and registration, * is displayed to the left of the program number. With G101 ; command, * is erased after the completion of registration, upon which the automatic operation mode is entered. With G102 P ; command, * remains displayed after the completion of registration until the registered program is erased.

When a reset operation is performed, the data being registered is erased and the reset state is provided. If FEED HOLD button is depressed or a mode switching operation is performed, the data being registered is erased and the label skip state is provided.

(7) The processed and registered program data is erased by any of the following operations:

a. NEXT key on NC operator's station was pressed.

b. Address search was performed in MEM or EDIT mode.

c. Some edit operation was performed either on the stored part program or on the high-speed cutting program.

Note: To change the tool offset amount after data processing and registration, depress NEXT key to erase the registered program data. In the case of the high-speed cutting (G101) in sequential processing mode, however, the data processing and registration are performed each time, eliminating the need for depressing NEXT key.

(8) The following parameter setting may invalidate the high-speed cutting feature temporarily. When this feature is invalidated, the part program memory may be used to its full capacity.

Parameter
Number

#6008

D7 = 1 ··· Disables high-speed cutting function

D7 = 0 ··· Enables high-speed cutting function

However, to change the part program memory capacity, key in 0 - 9 9 9 9 ERASE (by EDIT, PROG) for both changes of D7 from 0 to 1 and from 1 to 0. Hence, in either change, all the part programs are erased. If G101 or G102 is specified when #6008 D7 = "1," error "147" will be caused.

(9) The following setting may provide the mode in which only data registration is performed:

Setting
Number

#6004

D5 = 1 ··· The high-speed cutting is executed normally.

D5 = 0 ··· The high-speed cutting is not executed for G101 ; command but the usual automatic operation is performed. For G102 P··· ; command, only data registration is performed during the usual automatic operation.

This setting may be used for the checking of programs as follows:

a. Set #6004D5 to 0.

b. Select low-speed feed by FEEDRATE OVERRIDE or DRY RUN switch.

c. Cycle-start the program to be tested including G102 P ; through G100 ; commands. The usual automatic operation is performed, so that visually check the tool path. In some cases, the program may be single-block-stopped for checkups. Upon termination of the operation, the processed data up to G100 ; command have been registered in the machine.

d. Set #6004 D5 to 1.

e. Set the feedrate to the original value.

f. Cycle-start the same program. G102 P ; through G100 ; are immediately executed using the registered data.