

## Writing Operation

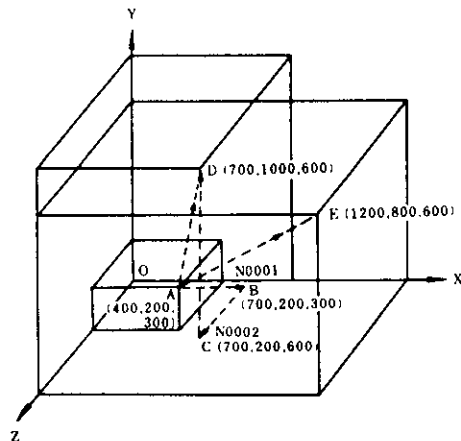


Fig. 6.31

Data of positioning at point A is stored in the part program. The block after point A is stored in the PLAYBACK mode.

A. Procedure of changing current position data using G00 when machine was moved from point A to point B. Sequence No. for this data block is N0001.

(1) Key-in N, 0, 0, 0, 1.  
Do not depress the WR key. If depressed, "INPUT ERROR" will appear on the screen.

(2) Key-in G, 0, 0.

(3) Depress WR key after X.

(4) Depress the EOB key.

(5) Depress the INSRT key.

Then, block of N0001 G00 X0.700; will be stored in the part program.

B. Procedure for storing current position data using G01, F02 when machine was moved from point B to point C. Sequence No. for this data block is N0002.

(1) Key-in N, 0, 0, 0, 2.

(2) Key-in G, 0, 1.

(3) Depress the WR key after Z.

(4) Key-in F, 2, 0.

(5) Depress the EOB key.

(6) Depress the INSRT key.

Then block of N0002 G01Z 0.600F20; will be stored in the part program.

C. Procedure for storing current position data using G00 when machine was moved from point C to point D. Sequence No. for this data block is N0003.

(1) Key-in N, 0, 0, 0, 3.

(2) Key-in G, 0, 0.

(3) Depress the WR key after Y.

(4) Depress the EOB key.

(5) Depress the INSRT key.

Then, block of N0003 G00 Y1.000; will be stored in the part program.

D. Procedure of storing current position data for three axes simultaneously when machine was moved from point A to point D with linear interpolation Sequence No. for the data block is N0004.

(1) Key-in N, 0, 0, 0, 4.

(2) Key-in G, 0, 1.

(3) Depress the WR key after X.

(4) Depress the WR key after Y.

(5) Depress the WR key after Z.

(6) Key-in F, 1, 0, 0.

(7) Depress the EOB key.

(8) Depress the INSRT key.

Then block of N0004 G01 X0.700 Y1.000 Z0.600 F100; will be stored in the part program.

E. When the machine current position is at point D (700, 1000, 600) with start at A, follow the procedure to store the current position data using the position data of point D when the machine is moved from point A to point E (1200, 800, 600).

Key-in the incremental value for each axis when machine moves from point D to point E. Sequence No. for this data block is N0005.