#6092

Specifies the exponential function acceleration/deceleration time constant for cutting feed (common to all axes).

The setting formula is: "n" = $\frac{t}{4}$ - 1

where, t: time constant(ms), specifiable in units of 4 ms

#6093

Specifies the exponential function acceleration/deceleration speed bias for cutting feed (common to all axes).

Setting: "1" = 2 kpps.

#6094 (X-axis)

#6095 (Y-axis)

#6096 (Z-axis)

#6097 (4th-axis)

#6094 to #6097:

Specify the reference point return method, respectively, for the X-, Y-, Z- and 4th-axes.

"0" of NZ signal enabled		○	
NZ signal employed		○	○
Reference point pulse used	○		
Parameter setting	64	48	32

Standard setting: 64

#6106

Specifies the "rapid traverse section" for a "returning semicircle" by the proportionate semicircle radius in circle cutting (G12, G13).

Setting range: 0 - 10 (x 10%)

Examples:

1. A setting of 0 creates a rapid traverse section automatically computed by the program command values.
2. A setting of 10 (= 100%) makes the entire "returning semicircle" into a "rapid traverse section."

#6107

Specifies the number of manual pulse generators.

Setting range: 1 - 3

#6120 G-1

#6121 G-2

#6122 G-3

#6123 G-4

#6124 G-5

#6125 G-6

#6126 G-7

#6127 G-8

#6128 G-9

#6129 G-10

#6120 to #6129:

Specify up to 10 G codes for calling user macros.