4.8 TAPE VERIFYING

The punched tape of the data shown below may be compared to the contents of the NC internal memory to check if they match.

· Part program

· Tool offset data

· Setting data and parameter

The punched tape is entered through the NC tape reader or the data input/output interface (option). For the methods of setting the input/output equipment (setting #6003) and the baud rate (parameters #6026 through #6029), refer to 4.9 DATA INPUT/OUTPUT INTERFACE. The following description is made assuming that this option is installed.

4.8.1 SETTING AND PARAMETER TAPE VERIFYING

1. Select "1" of system No. switch.

2. Set the MODE SELECT switch to the EDIT.

3. Depress PRM function key.

4. Depress RESET key.

5. Load the NC tape via tape reader.

6. Depress VER key.

   Tape starts, and the contents of tape and the contentns of setting/parameter are verified. "VER" is flickerlingly displayed. If disagreement with the tape data is detected, "INPUT ERROR" is flickeringly displayed.

7. After completion of verifying without disagreement, tape reader stops and "VER" disappears.

4.8.2 TOOL OFFSET VALUE TAPE VERIFYING

1. Set the MODE SELECT switch to the EDIT.

2. Depress OFS function key.

3. Depress RESET key.

4. Load the source tape via tape reader.

5. Depress VER key

   Tape starts, and the contents of tape and the contents of tool offset values are verified. If disagreement with the tape data is detected, "INPUT ERROR" is flickeringly displayed.

6. After completion of verifying without disagreement, tape reader stops and "VER" disappears.

4.8.3 VERIFYING PART PROGRAM TAPE

(1) Verifying a part program tape having program number

   a. Select the EDIT mode.

   b. Depress the PROG function key.

   c. Set the part program tape to the tape reader.

   d. Depress the RESET key.

   e. Depress the VER key.

      The tape is started to compare the contents of the part program memory to the contents of the part program tape. During this operation, "VER" keeps flashing. If a mismatch is found, "INPUT ERROR" is displayed flashing.
      When a match is found and this operation is completed, the tape reader stops, upon which "VER" display is erased.

      Note: By the operation of "RESET, VER," the verifying feature verifies the data from the tape head to % code.

(2) Verifying a part program tape having no program number

   a. Select the EDIT mode.

   b. Depress the PROG function key.

   c. Set the part program to the tape reader.

   d. Depress the RESET key.

   e. Depress the "O" key and key in program number.

   f. Depress VER key.

      The tape starts to compare the contents of the part program memory to the contents of the part program tape. During this operation, "VER" keeps flashing. If a mismatch is found, "INPUT ERROR" is displayed flashing. When a match is found and this operation is completed, the tape reader stops, upon which "VER" display is erased. If the keyed in program number is not found in the memory, "NOT FOUND!" is displayed flashing. In this case, depress the CAN key and start with the operation of d.