EXAMPLE:

```
EOR ;

N1 G28 X··· Y··· Z···;

N2 G92 X··· Y··· Z···;
   .
   .
   .
```

Fig. 7.4

7.6 OPERATION IN TAPE AND MEMORY MODE

1. Make sure that NC ALARM lamp is not illuminated. If illuminated, detect and eliminate the cause by the indication of alarm code. Refer to 4.3.12 DISPLAYING ALARM CODE.

2. Check and correct the stored offset values, and then put the machine in the correct start point.

3. Set the switches on the control station of machine to the proper positions.

   · MODE SELECT switch

   · SINGLE BLOCK toggle switch

   · RAPID TRAVERSE RATE OVERRIDE switch

   · MANUAL ABSOLUTE toggle switch

   · OPTIONAL BLOCK SKIP toggle switch

   · OPTIONAL STOP (M01) toggle switch

   · DRY RUN toggle switch

   · FEEDRATE OVERRIDE & JOG FEEDRATE switch

4. Set the punched tape onto the tape reader. In MEM mode, this opration is not required.

5. Depress RESET key on the control station. Then LABEL SKIP lamp will be illuminated and the memory will be rewound.

6. Depress CYCLE START button to give a Cycle Start to the system.

7. When the Feed Hold is required for the machine during the system operation, depress FEED HOLD button.

8. If the unexpected event occurs in the system, immediately depress EMERGENCY STOP pushbutton.

7.7 MANUAL OPERATION INTERRUPTING AUTOMATIC OPERATION

1. Stop the automatic operation temporarily by depressing FEED HOLD pushbutton or by setting SINGLE BLOCK switch to ON position.

2. Record the current positions of each axis on a paper using the current position display operation.

3. Set MODE SELECT switch to manual operation mode (HANDLE, JOG or RAPID), and the machine can be manually operated.

4. Return the machine manually to the recorded positions.

5. Set MODE SELECT switch to the interrupted automatic-mode (TAPE, MDI or MEM).

6. Depress CYCLE START pushbutton, and the machine will resume the automatic operation.

NOTES:

· Where MODE SELECT switch is changed without depressing FEED HOLD pushbutton.

   a. When the automatic-mode (TAPE, MDI or MEM) is changed to the manual-mode (HANDLE, JOG or RAPID), the machine rapidly slows down and stops.

   b. When the automatic-modes are changed the machine is stopped at the block end.

· Where the machine is restarted by depressing CYCLE START button, the tool path shifted due to manual operation will be changed by ON-OFF operation of MANUAL ABSOLUTE switch. Refer to 6.1.24 MANUAL ABSOLUTE SWITCH.

In manual operation mode, when the CYCLE START button is depressed after wiring F, M, S, T or B† code by use of the same procedure as that of MDI operation, the command becomes effective and is executed as soon as written. This procedure is used to add new data to an active buffer. However, M00, M01, M02, M30 and M90 to M99 cannot be written.

7.8 AUTOMATIC OPERATION IN MDI MODE

1. Set MODE SELECT switch to MDI position.

2. Write up to 10 blocks of data by MDI operation, and execute by pressing CYCLE START. Refer to 4.3.3 Writing in Blocks and Displaying Contents by MDI.

3. Depress CYCLE START button, and automatic operation can be executed in MDI mode.