

7.9 MDI OPERATION INTERRUPTING AUTOMATIC OPERATION

To modify the block data after interrupting operation in TAPE or MEM mode, the following operation should be done after interrupting the operation.

1. Turn on SINGLE BLOCK switch, and the operation is interrupted after the completion of the block being executed. At the same time, the next blocks of data may be read in advance.
2. Display the data on CRT DISPLAY according to 4.3.2 DISPLAY OF COMMAND DATA, and check it.
3. Set MODE SELECT switch to MDI operation.
4. Write the data referring to 4.3.3 Writing in Blocks and Displaying Contents by MDI. Execute the data by depressing the CYCLE START button.
5. Set back MODE SELECT switch to the interrupted automatic mode (TAPE or MEM).
6. Return SINGLE BLOCK switch to OFF position.
7. Depress CYCLE START button, and TAPE or MEM operation can be continued.

NOTES:

- Writing data by MDI cannot be executed in tool radius compensation modes (G41, G42) because two - four blocks are read ahead.
- In manual operation mode, when the CYCLE START button is depressed after writing 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 a new data to an active buffer. However, M00, M01, M02, M30 and M90 to M99 cannot be written.

- Writing data by MDI should not be performed in canned cycle modes (G73, G74, G76, G77, G81 to G89). The machine may not operate properly.
- Excepting in tool radius compensation and canned cycle modes, MDI operation is possible.

7.10 PREPARATION FOR TURNING OFF POWER

1. Make sure that the machine is at standby and CYCLE START lamp is extinguished.
2. Check to see that NC ALARM is not indicated on CRT. If alarm is displayed, detect the causes of displayed alarm code and eliminate them. Refer to 4.3.12 DISPLAYING ALARM CODE.
3. Inspect the machine referring to the machine tool builder's manual.

7.11 TURNING OFF POWER

1. Depress EMERGENCY STOP pushbutton to turn off the servo power supply.
2. Depress POWER OFF pushbutton on the operator's panel to turn off the control power supply.
3. Cut off the main power supply from the control.