

PARAMETER NUMBERS AND THEIR CONTENTS (CONT'D)

#6019			D5	D4		D2	D1	D0
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- D5 1: Enables dry run at thread-cutting (G33).
0: Disables dry run at thread-cutting (G33).

- D4 1: Employs the feedrate set in parameter #6232 for the skip function command (G31).
0: Employs the F code command as the feedrate for the skip function command (G31).

D2, D1

Specify the tool shift direction in the canned cycles of G76 and G77 (effective when #6019 = 0).

D2	D1	Shift direction
1	1	-Y
1	0	+Y
0	1	-X
0	0	+X

- D0 1: Allows the tool shift direction in the canned cycles of G76 and G77 to be specified in setting #6506 (specifiable in the +X direction in increments of 0.001; the shift being cutting feed).

- 0: Allows the tool shift direction in the canned cycles of G76 and G77 to be specified in D2 and D1 of parameter #6019 (specifiable only axially).

#6020					D3	D2	D1	D0
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- D3 1: Sets F14 (in/rev.) for the feed per revolution in the inch system.
0: Sets F13 (in/rev.) for the feed per revolution in the inch system.

- D2 1: Sets F23 (mm/rev.) for the feed per revolution in the metric system.
0: Sets F22 (mm/rev.) for the feed per revolution in the metric system.

- D1 1: Sets F32 (mm/min.) for the feed per minute in the metric system.
0: Sets F31 (mm/min.) for the feed per minute in the inch system.

- D0 1: Sets F51 (mm/min.) for the feed per minute in the metric system.
0: Sets F50 (mm/min.) for the feed per minute in the metric system.

#6021							D1	D0
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- D1 1: Employs the value following address O or N as the program number (specifiable in one block).
0: Employs the value following address O as the program number.

- D0 1: Considers M02, M30 and M99 as the program end when machining data is stored into memory.
0: Does not consider M02, M30 and M99 as the program end when machining data is stored into memory.

#6023		D6		D4	D3	D2	D1	D0
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- D6 1: Enables the additional axis to ignore signal 4NG.
0: Disables the additional axis to ignore signal 4NG.

D4-D0

Set the address for pan-out and CRT display on the additional axis.

Address	D4	D3	D2	D1	D0
A	0	0	0	0	1
B	0	0	0	1	0
C	0	0	0	1	1
U	1	0	1	0	1
V	1	0	1	1	0
W	1	0	1	1	1