4.3.3 WRITING IN BLOCKS AND DISPLAYING CONTENTS BY MDI (CONT'D)

C. Operation in MDI mode

Depress the Cycle Start button to let the program of blocks displayed on the CRT to run automatically.

At the end of operation, the multi-block program displayed is cleared from the CRT.

2. In EDIT mode

See 4.6 EDITING OPERATION OF PART PROGRAMS.
Programs written by MDI can be executed repeatedly by M99.

3. In MEM mode

This mode permits to display the program which is running by memory operation. The cursor points to the top of the block which is currently being executed, and it moves to the next block as execution proceeds.

Up to 10 lines may be displayed at a time. When execution of the ninth has been completed, the next page appears with the tenth line of the last screen appearing at the top.

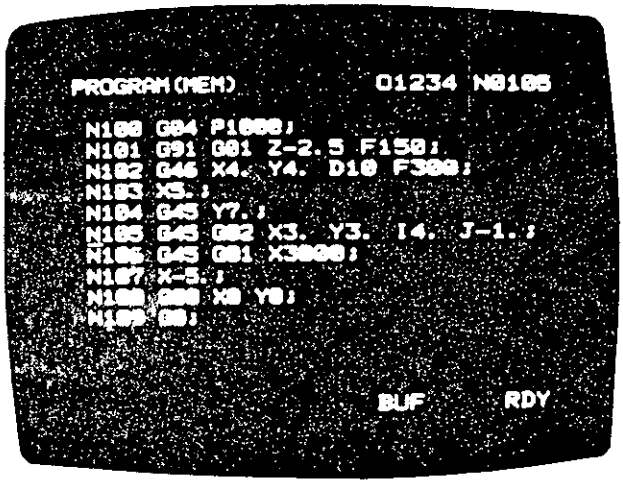

Fig. 4.19

4.3.4 DISPLAYING AND RESETTING CURRENT POSITION

It is possible to observe the current position in any mode. Operate as follows.

1. Depress the POS key. Any of the following screens will appear.

   A. Current position display-universal (POSITION [UNIVERSAL])

   B. Current position display-external (POSITION [EXTERNAL])

   C. Current position display-increment (POSITION [INCREMENT])

   D. Current position display-all (POSITION)

   E. Servo positioning error display (POSITION [ERROR])

2. Depress the [PAGE ↓] or [↑ PAGE] key, and one screen will change to the next.

NOTE: Mode E is possible only when the system No. switch is set at "4."

4.3.4.1 CURRENT POSITION DISPLAY (UNIVERSAL):

POSITION (UNIVERSAL)

The current tool position which is the sum of the parameters of move commands will be displayed. Depending on the value of parameter $\#6005_{D5}$ (G92 display preset), either of the following will appear.

· When parameter $\#6005_{D5} = 1$ (Position in the reference coordinate system)

1. The tool position displayed is based on the coordinate system set up with G92.

2. To reset this screen, depress the ORG key after designating an axis with the ADDRESS key. The current position will be reset to "0." This is possible only during a manual operation mode (RAPID, JOG, STEP, or HANDLE). The depression of the ORC key is ineffective during normal operation and in the "buffer full" state.

3. The coordinate system which is employed for this screen is called the "reference coordinate system." A work coordinate system (option) will be set up in reference to the reference coordinate system.