### 6.1.26 TOOL LENGTH MEASUREMENT PUSH-BUTTON AND LAMP†

Use the WRITE button to automatically store the amount of Z-axis move manually made between "home-position" and "base-position" directly in the tool offset memory. For operating procedure, refer to 6.2.3 Automatic Tool Length Measurement†.

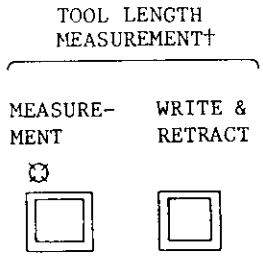


Fig. 6.17

### 6.1.27 START LOCK INPUT (OR SWITCH)†

When the START LOCK is on, CYCLE START pushbutton does not function. Use the START LOCK input to prevent operating the machine in abnormal condition during automatic operation. The input may be used as on/off switch on control station for machine.

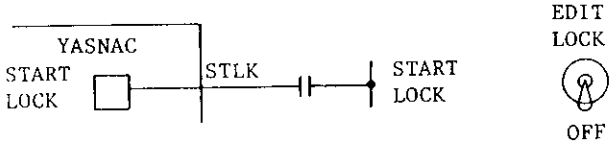


Fig. 6.18

### 6.1.28 EDIT LOCK SWITCH†

Turning on the EDIT LOCK switch prevents the function of ERS, INS, ALT, and EOB keys, and storing from NC tape. When editing is made with EDIT LOCK switch turned on, "EDIT LOCK" flickers on the CRT display.

### 6.1.29 AXIS INTERLOCK INPUT

The control is provided with AXIS INTERLOCK input for each axis to prevent axis motion.

Interlocking an axis in feed motion causes the axis to slow down to a stop. When the interlock is released, the axis motion finishes the interrupted block and proceeds to the next.

Interlocking one of the two or three axes being simultaneously interpolated disables the interpolation.

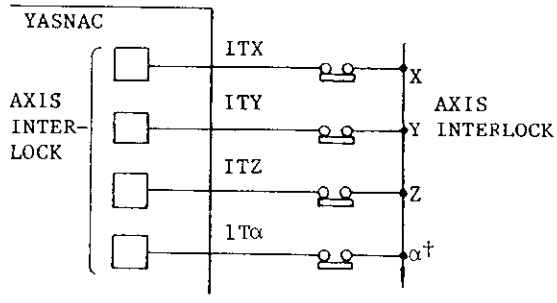


Fig. 6.19

### 6.1.30 EXTERNAL DECELERATION INPUT SIGNALS

In order to eliminate the danger of high speed contact at speed end caused by erroneous motion commands, limit switches for originating external deceleration input signals may be installed at selected points.

1. During rapid traverse (G00) and manual operation

   When the limit switch is tripped by the tool movement, the traverse speed is decelerated in the tripping direction to a level set by the parameter #6340. In the direction opposite to the tripping direction, the original speed remains unchanged.

2. During motion at feedrate (G94)

   While the limit switch is being tripped, the tool moves at a speed set by the parameter #6341. If the feedrate set by the F command is lower than the rate set by the parameter, the original feedrate remains unchanged.