

Beginning of OP = ~~#500~~ #3012 #500 = #3012

End of OP = ~~#501~~ #3012 #501 = #3012

Cycle Time = #502 = [#501 - #500]

Tool changes = #503 = #3012 } for one tool

(new variable for #504 = #3012 } change

(every tool change) #505 = #3012 } one tool

#506 = #3012 } change

Σ Tool changes = #507 = [#506 - #505] + [#504 - #503]

Manual Time = #508 = #3012

#509 = #3012

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Same things  
as with tool changes

Σ Manual Time = #512 = [#511 - #510] + [#509 - #508]

1.48 → p. 457

4.51 → p. 472

- #3012 takes the stamp by operation
- actual time accumulated during operation is the sum of parameters No. 6751 and No. 6752. ~~operation time~~
- cutting time, performed by G01, G02, or G03. Sum of 6753 and 6754
- operation time = 6757 + 6758, ~~operation time~~ "one automatic operation time"

#100 #3012

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#101 = #3012 (end of life)

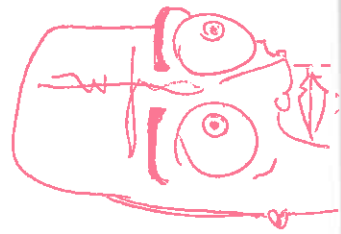
#103 = [#101 - #100] (total time)

POPEN

DPRINT [CYCLE \* TIME \* 15 \* #102 [50] \* 500000]

PCLOS

file store in c:\MC\_sdprint



do not  
make  
wipe out after power  
off  
- #500