

AUTO: AU, START FROM, TO, DRY RUN, DIRECT BLOCK START

START FROM: LINE NUMBER TO BEGIN EXECUTION FROM

TO: LINE NUMBER TO END EXECUTION AT

DRY RUN OPT: 1=(G0)150ipm (G1)AS PROG, 2=(G0)150ipm, 3=(G0)300ipm (G1)75ipm

DIR.BLK.START OPT:0=PROCESS PROGRAM FROM BEGINNING & EXECUTE AT START FROM

1=BEGIN EXECUTION AT START FROM, WITH NO PROCESSING BEFORE

LINE NUMBER = PROCESS FROM LINE NUMBER & BEGIN EXECUTION AT START FROM

BACKLASH: BL, AXIS #, AMOUNT AT CENTER, AT NEGATIVE END, AT POSITIVE END

AXIS #: X=1 Y=2 Z=3 A=4 B=5 / AMOUNT IS IN TENTHS: i.e. 10=.0010

CHANGE DEVICE: CD, BAUD RATE, LINE FEED OPTION, ECHO OPTION, DEVICE OPTION

BAUD RATE: 1=110 2=150 3=300 4=6-- 5=1200 6=2400 7=4800 8=9600 9=19200

10=38400 11=57600 12=115200

LINE FEED OPT: 0=LINE FEEDS, 1=NO LINE FEEDS

ECHO OPT: 0=ECHO, 1=NO ECHO

DEVICE OPT: 0=EXTERNAL, 1=INTERNAL

CHANGE PROGRAM LINE: CH, FROM, THROUGH

COLD START: CS

COPY PROGRAM LINES: CO, FROM, THROUGH, TO JUST AFTER

DELETE PROGRAM LINE: DE, FROM, THROUGH

DIAGNOSTIC MODE: DI (TRAINED MAINTENANCE PERSONNEL ONLY)

DNC (DNCX): DNC (DNCX), VIDEO OPTION, ERROR OPTION, DRY RUN, START LINE NUMBER

VIDEO OPT: 1=SCREEN

ERROR OPT: 1=DISABLES ERROR CHECKING

DRY RUN OPT: 1=(G0)150ipm (G1)AS PROG, 2=(G0)150ipm, 3=(G0)300ipm (G1)75ipm

START LINE NUMBER: SPECIFIES WHICH LINE TO BEGIN EXECUTION

DISPLAY FIXTURE OFFSETS: DF

DISPLAY TOOL TABLE: DT

DISPLAY TIME TABLE: DTT

DRAW: DR (DRAWS THE CURRENTLY ACTIVE PROGRAM) (-4 and -5 ONLY)

FIXTURE OFFSET: FO, NUMBER, (X AMOUNT), (Y AMOUNT), (Z AMOUNT)

HOME ALL AXES: HO

INSERT PROGRAM LINES: IN, FROM, SEQUENCE INCREMENT

LEARN MODE: LE, FIRST BLOCK NUMBER, INCREMENT, TOOL NUMBER

LIST PROGRAM LINES: LI, FROM, THROUGH

[DISPLAY SCROLL, SPEED CONTROL: 1(SLOWEST) - 9(FATEST), 0(PAUSE SCROLL)]

MACRO: MA

MANUAL DATA INPUT: MD

MEMORY FREE: ME

MENU: MU

NEW PROGRAM: NE (THIS DELETES THE CURRENTLY ACTIVE PROGRAM)

NUMBER PROGRAM LINES: NU, INCREMENT FOR LINE NUMBERS

PAGE EDITOR: PA, OPTIONAL FROM

PROGRAM MAINTENANCE: PR, OPTIONAL PROGRAM NUMBER

PUNCH PROGRAM: PU, DATA OPTION, CODE OPTION, TTY OPTION

DATA OPT: 0=CURRENTLY ACTIVE PROGRAM & OFFSETS, 1=OFFSETS ONLY

DATA OPT: 2=CURRENTLY ACTIVE PROGRAM, 3=ALL PROGRAMS IN MEMORY
4=PUNCH OUT PARAMETERS

CODE OPT: 0=ASCII, 1=EIA

TTY OPT: 0=COMPUTERS, 3=LEADER, PROGRAM, TRAILER

REINITIALIZE: RI

1) DELETE THE TOOL TABLE & RESET THE TURRET

2) DELETE THE FIXTURE OFFSET TABLE

3) DELETE THE ENTIRE PROGRAM LIBRARY, CURRENT PROGRAM & RESET TURRET

RESET HOME TO COLD START POSITION: SETCS

RESET TOOL CHANGER: SETTO (SETS CURRENT TURRET POSITION TO ONE)

RESET SYSTEM PARAMETERS: SETP (AXES MUST BE AT CS POSITION)

SET (AXIS): SETX or SETY or SETZ or SETA or SETB or SETH

SET LENGTH OFFSET: SL, TOOL NUMBER, OPTIONAL CHANGE VALUE

SUM PROGRAM: SU, DISPLAY FROM, THROUGH, CRC OPTION, DISPLAY OPTION

DISPLAY FROM: DISPLAY DATA STARTING AT DISPLAY FROM NUMBER

THROUGH: STOP DISPLAYING DATA AT THROUGH NUMBER

CRC OPT: 1=IGNORE G41 & G42

DISPLAY OPT: 0=ERROR MESSAGES ONLY

OPT: 1=INCREMENTAL MOVES & ERROR MESSAGES

OPT: 2=INCREMENTAL MOVES, ERROR MESSAGES & ABSOLUTE POSITIONS

OPT: 3=CURRENT G CODE STATUS AND ALL OTHER OPTIONAL INFORMATION

[DISPLAY SCROLL, SPEED CONTROL: 1(SLOWEST) – 9(FATEST), 0(PAUSE SCROLL)]

SURVEY: SV (TRAINED MAINTENANCE PERSONNEL ONLY)

TAPE (PROGRAM) INPUT: TA, DEVICE OPTION, ERROR OPTION, ADD AT END

DEVICE OPT: 0=INTERNAL TAPE READER

OPT: 1=INPUT THROUGH RS-232 PORT

ERROR OPT: 1=IF DATA HAS PARITY ERRORS

OPT: 2=TO IGNORE ERRORS AND GIVE ERROR COUNT

OPT: 3=TO ACCEPT DATA FROM OTHER CNC CONTROLS

ADD AT END: 1=ALLOWS DATA TO BE ADDED TO THE END OF CURRENTLY ACTIVE PROGRAM

TOOL CHANGER OPEN: TC, 1 (OPENS TOOL CHANGER AT CURRENT POSITION)

TOOL DATA INPUT: TO, TOOL NUMBER, DIAMETER, LENGTH OFFSET

UTILITIES: UT (FOR SETTING TOOL & FIXTURE OFFSETS, or FOR TESTING PROBES & PALLET UTILITIES)

*ALTERNATE USE: UT, # (# SPECIFIES A TOOL NUMBER TO PICK UP FROM THE TURRET)

VERIFICATION OF PUNCHED TAPE: VT, 1