16 - NUMERICAL CONTROL CUSTOMIZATION

The numerical control customization operation configures the numerical control in relation to the number of axes used.

In case of the ERROR 00 or ERROR 80 message, it is advisable to check that this configuration is correct.

16 - 1 METHOD OF ACCESS

- Press the [⟳] (28) and [✊] (30) keys, and hold them down while you turn on the numerical control.

- Do not release the keys before hearing two successive sound signals.

- No display is visible on the screen.

16 - 2 KEY VALUES

- Along X axis: number of axes installed:

  > 1 = X
  > 2 = X + Y
  > 3 = X + Y + R or Z
  > 4 = X + R or Z

- Along Y axis: 1   the Y count decreases when the press is closed
  > 2   reverse counting (not used).

- Along AUX axis: 1   adjustment on FC- (R axis)
  > 2   adjustment on FC+(Z axis)

- Along--> t: Multiplication factor   1 on R axis
  > 2 on Z axis

- Along M: End-of-travel value =   200 on R axis
  > 60 on Z axis

  Along : Number of parts between two position resets of AUX axis. It is recommended that this value be set to zero.

16 - 3 METHOD OF CHECKING

- After carrying out procedure 16.1, press [X] (1), then [Y] (2), then [AUX] (3) then [→t] (4), then [M] (5), then [/\/\ ] (6). The respective values can be read on the alpha-numeric display (24).

- Watch out for the squared zeros, which are a sign that the memory is polluted.

16 - 4 METHOD OF WRITING

- If a checked value is not in compliance with your machine, as shown in table 16.2:

  Enter the correct value on the numeric key-pad, then press the [X] (1) or [Y] (2) or [AUX] (3), etc. key.