

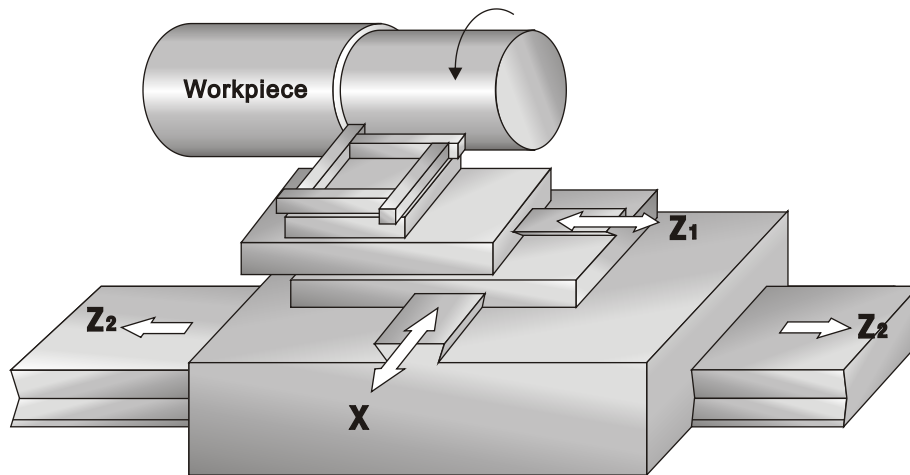
DC

LATHE FUNCTION

F

Set lathe function

- F — 1. LATHE : Summing function (38p)
- 2. DIA : Double counting function (39~40p)



1. Lathe Summing Function (1.LAtHE)

- This function is available in the model DSC-803, 804.
- X-axis can be adjustable.
- Result from summing Y & Z-axis appears in the Y-axis window.
- Inputting value and Zero setting don't work in the Z-axis
- If Y-axis is reset by , Z-axis is also reset automatically.
- Bolt hole circle doesn't work.

		X	1LAtHE		
		Y	0.000		
		Z	0.000		
		X	1LAtHE		
		Y	nor		
		Z	0.000		
} }		X	1LAtHE		NOR ↔ LATHE by
		Y	LAtHE		
		Z	0.000		
		X	0.000		
		Y	0.000		
		Z	LAtHE		

Ex. Summing present values

		X	-23600		
		Y	41260		
		Z	65085		
		X	1LAtHE		
		Y	nor		
		Z	65085		
		X	1LAtHE		
		Y	nor		
		Z	65085		
} }		X	1LAtHE		Result from summing Y, Z-axis shows in the Z-axis window
		Y	LAtHE		
		Z	65085		
		X	-23600		
		Y	106345		
		Z	LAtHE		

Ex. To set double counting function
(by diameter) for X-axis.

X	25.000
Y	-8.395
Z	40.620

F 
(5 times)

X	6.d 1R
Y	-8.395
Z	40.620

FUN

Move to No.6

ENT

X	6.d 1R
Y	SEL RH 15
Z	40.620

FUN

X

X	rAd
Y	SEL RH 15
Z	40.620

FUN

 }
 }

X	d 1R
Y	SEL RH 15
Z	40.620

FUN

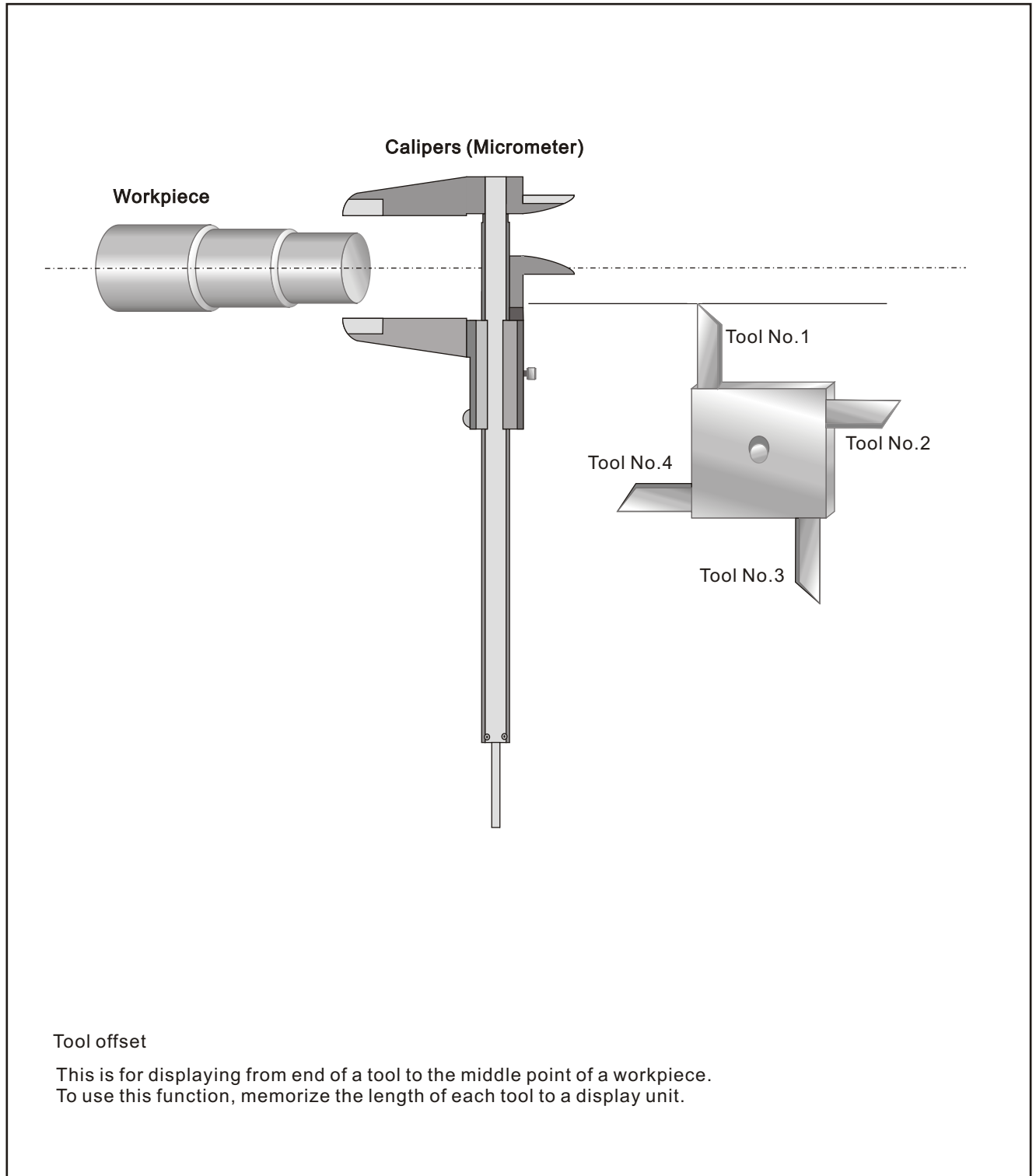
ENT

X	25.000
Y	-8.395
Z	40.620

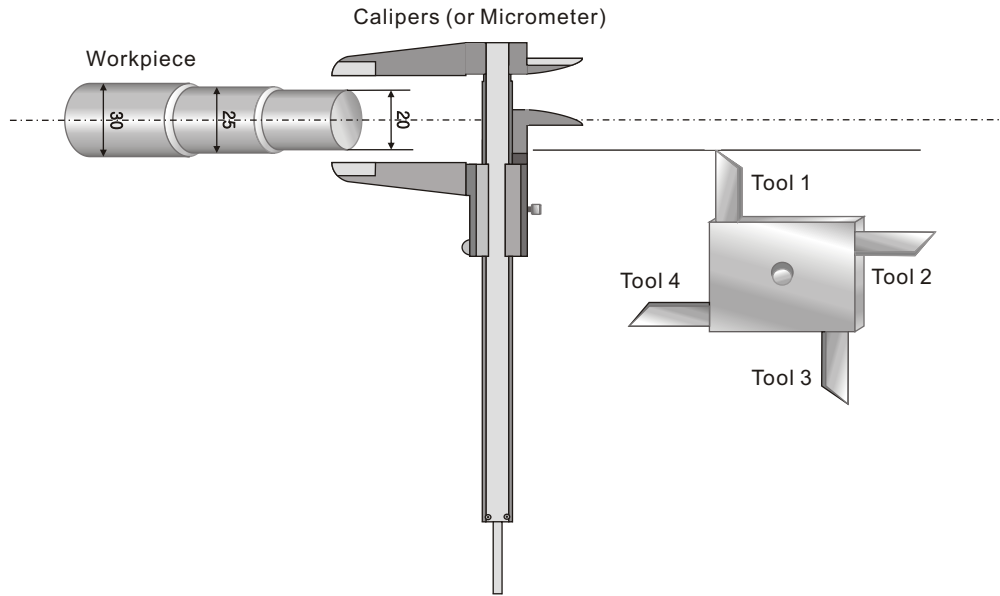
DIA

X-axis will be double counted.

3. Tool Offset



Ex. Tool#1 → Imitation processing → measuring diameter → input the value
 Tool#2
 Tool#3
 Tool#4



ABS

X 68.530
 Y -5.405
 Z 18.700
 ABS 0

Select ABS function

1 ENT

X 68.530
 Y -5.405
 Z 18.700
 ABS 1

Assign tool#1 to ABS No.1

X 2 0 ENT

Measured diameter value, 20, of the workpiece.

X 20.000
 Y -5.405
 Z 18.700
 ABS 1

Offset of Tool#1

Do imitation processing with Tool#1. Then, take off the tool and measure diameter of the workpiece with a calipers or micrometer. Input the measured value to a display unit.

Tool#1 will be set by inputting measured value, "20".

▶

X 30.080
 Y 10.860
 Z 22.350
 ABS 2

Assign tool#2 to ABS No.2

X 2 5 ENT

X 25.000
 Y 10.860
 Z 22.350
 ABS 2

Offset of Tool#2

Do imitation processing with Tool#2. Then, take off the tool and measure diameter of the workpiece with a calipers or micrometer. Input the measured value to a display unit.

Tool#2 will be set by inputting measured value, "25".



X	43060
Y	18860
Z	57200

ABS 3

X 3 0 ENT

X	30000
Y	18860
Z	57800

ABS 3

Assign tool#3 to ABS No.3

Offset of Tool#3

Do imitation processing with Tool#3. Then, take off the tool and measure diameter of the workpiece with a calipers or micrometer. Input the measured value to a display unit.

Tool#3 will be set by inputting measured value, "30".