

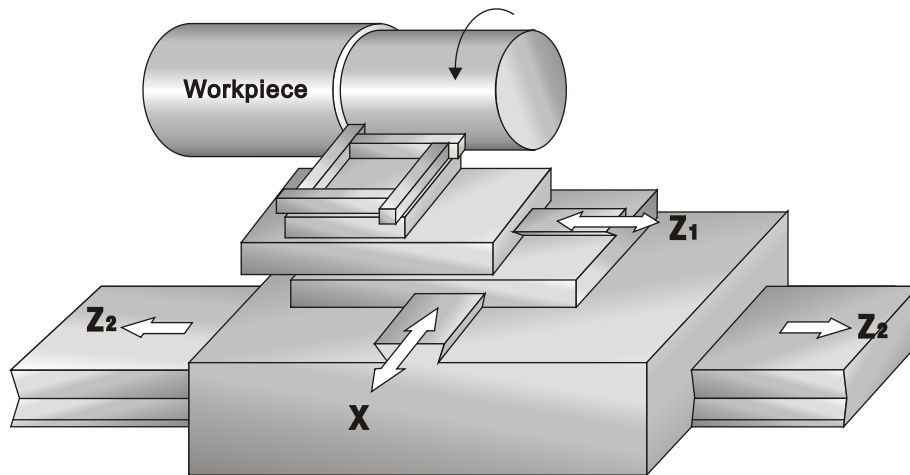
DC

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 [Y], Z-axis is also reset automatically.
- Bolt hole circle doesn't work.

F

ENT

▶
◀

ENT

X	1.1 A t h E
Y	0.0000
Z	0.0000
INCH/FUN	

X	1.1 A t h E
Y	n o r
Z	0.0000
INCH/FUN	

X	1.1 A t h E
Y	L A t h E
Z	0.0000
INCH/FUN	

X	0.0000
Y	0.0000
Z	L A t h E
INCH	

NOR ↔ LATHE by **▶** **◀**

Ex. Summing present values

F

ENT

▶
◀

ENT

X	-2.3600
Y	4.1260
Z	6.5084
INCH	

X	1.1 A t h E
Y	n o r
Z	6.5084
INCH/FUN	

X	1.1 A t h E
Y	n o r
Z	6.5084
INCH/FUN	

X	1.1 A t h E
Y	L A t h E
Z	6.5084
INCH/FUN	

X	-2.3600
Y	10.6344
Z	L A t h E
INCH	

Result from summing Y, Z-axis shows in the Z-axis window

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

X	2.2000
Y	-0.8394
Z	4.0620

INCH

F
(5 times)

X	6.d 1A
Y	-0.8394
Z	4.0620

INCHFUN

Move to No.6

ENT

X	6.d 1A
Y	SEL RH 15
Z	4.0620

INCHFUN

X

X	rAd
Y	SEL RH 15
Z	4.0620

INCHFUN

}
 }

X	d 1A
Y	SEL RH 15
Z	4.0620

INCHFUN

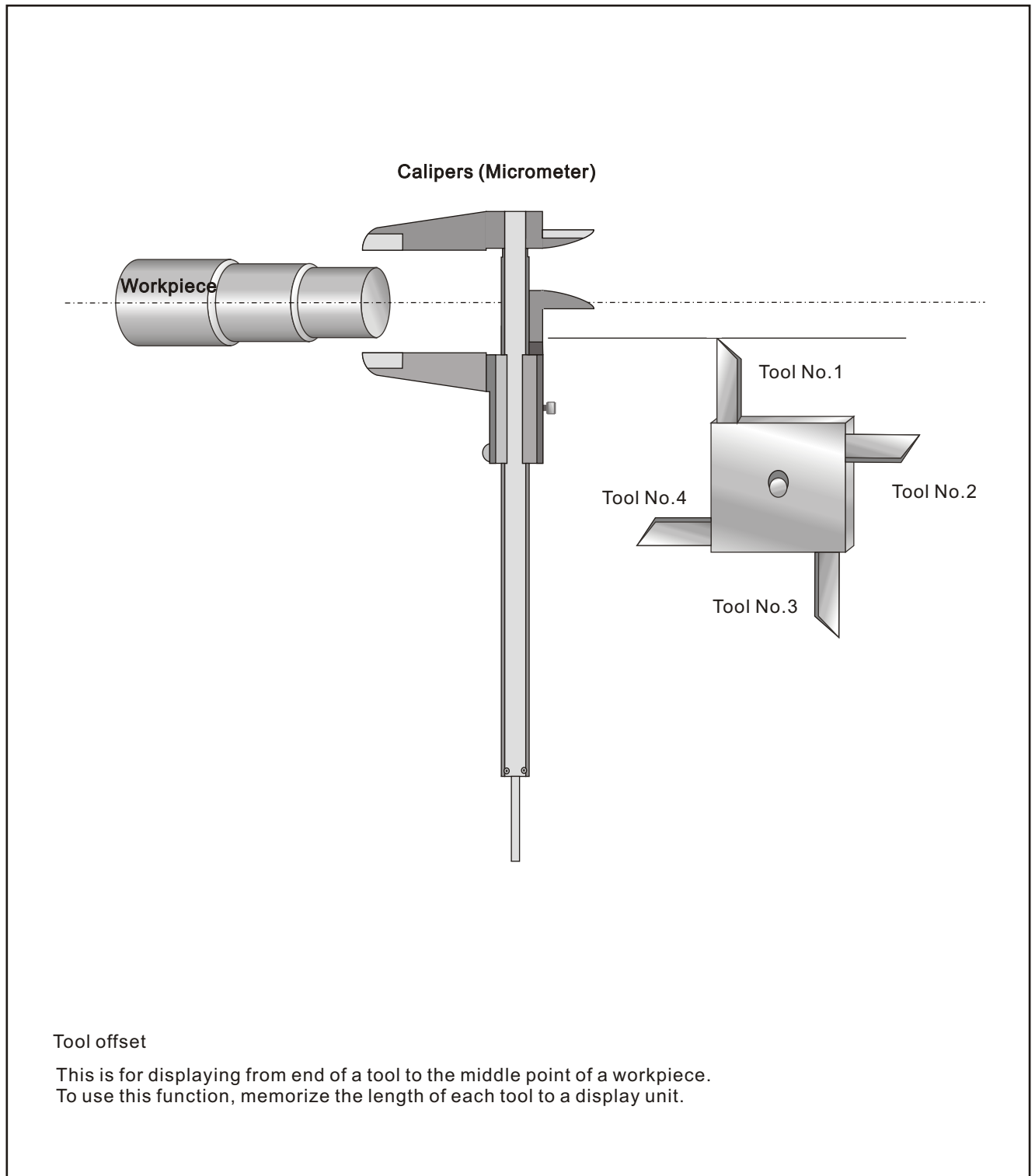
ENT

X	2.2000
Y	-0.8394
Z	4.0620

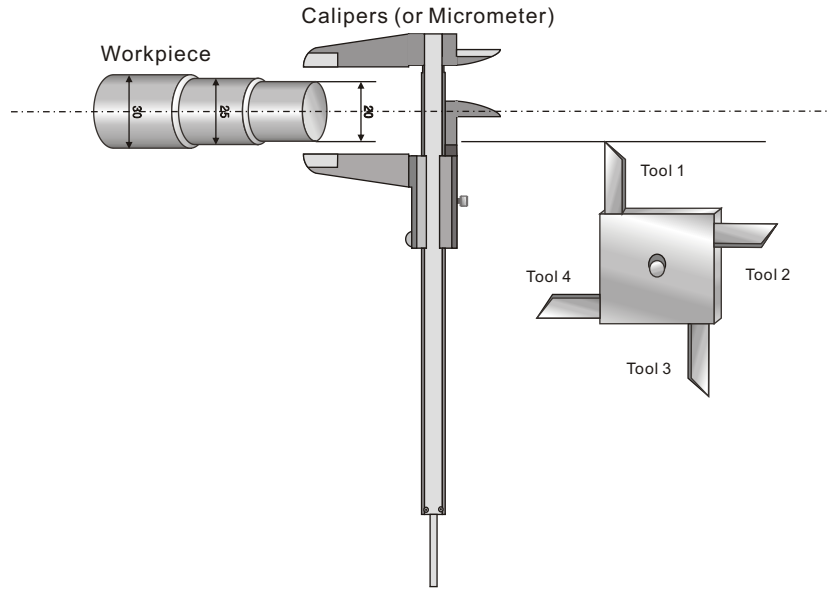
DIA/INCH

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 6.8530
 Y -0.5404
 Z 1.8700
 INCH ABS 0

Select ABS function

1 ENT

X 6.8530
 Y -0.5404
 Z 1.8700
 INCH ABS 1

Assign tool#1 to ABS No.1

X 20 ENT

Measured diameter value, 20, of the workpiece.

X 20.0000
 Y -0.5404
 Z 1.8700
 INCH 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 3.0080
 Y 1.0860
 Z 2.2350
 INCH ABS 2

Assign tool#2 to ABS No.2

X 25 ENT

X 25.0000
 Y 1.0860
 Z 2.2350
 INCH 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	5.7800
	INCH ABS 3

X 3 0 ENT

X	30.0000
Y	18860
Z	5.7800
	INCH 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".