

2 LK1 ~ LK6: Unassigned

3 P1 ~ P16: 1 Byte data

P1 Decelerated speed in rapid traverse (%)

P2 Max. approach length in thread cutting
(thread lead x N)

l = 0.1 times

P3 Error rate in thread cutting (%)

P8 Turret index position selection

0: X = max. OD + Parameter data (X)

Z = Z end face + Parameter data (Z)

1: X = zero point

Z = Z end face + Parameter data (X)

2: X = max. OD + Parameter data (Z)

Z = zero point

3: X = zero point

Z = zero point

P9 Simple automatic tool compensation

0: Disable

1: Count up of number of machined works

2: Tool service hours

P10 Spear tool index

0: Disable

1: Count up of number of machined works

2: Tool service hours

3: Wear of tool, exceeding max. limit

~~P11~~ Automatic "handle" interrupt magnification

X 0 ~ X 100 *Need Switch*

P16 Inch system

Others Unassigned

4 P17 ~ P32: 2 Byte data

P17 Undercut height for grinding (1 μ unit, in radius)

P18 Undercut width for grinding (1 μ unit, in radius)

P19 Reduction rate of depth of cut in bar turning
(rough cut) (%)

P23 Finishing allowance in thread cutting
(1 μ unit, in diameter)

P24 Clearance in thread cutting (1 μ unit, in diameter)

P25 Step amount in grooving (1 μ unit, in radius)

P26 Tolerance of infeed amount in drilling
(1 μ unit, in radius)

P27 Step amount in drilling (1 μ unit, in radius)

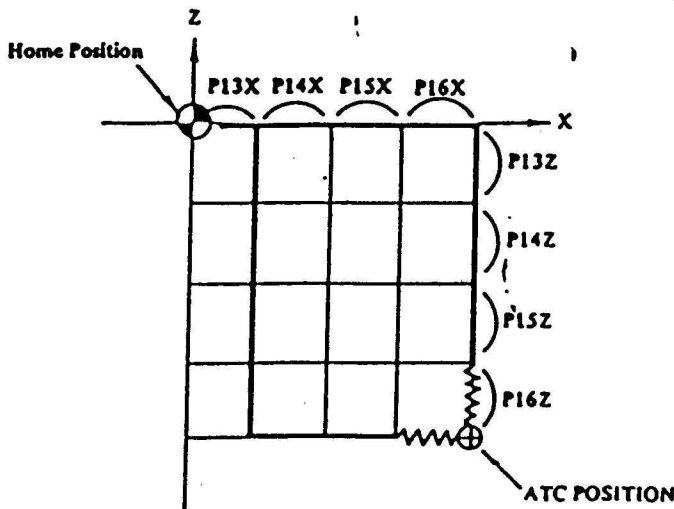
- P28** Slotting overlap
- ~~P29~~ Measured stroke
- ~~P30~~ Tool nose measuring sensor diameter
- ~~P31~~ Speed at measurement
- ~~P32~~ Speed at measurement approach
- Others Unassigned

5 P33 ~ P48: 4 Byte data

- ~~P33~~ Tool nose measuring sensor position (X)
- ~~P34~~ Tool nose measuring sensor position (Z)
- P35** Tool change position (index) clear (X)
- P36** Tool change position (index) clear (Z)
- P40 Dwell when thread cutting starts
- P41 Dwell time for grooving
- P42 Infeed clamp amount in drilling
(1 μ unit, in radius)
- ~~P47~~ Automatic "handle" interrupt clamp value (X)
- ~~P48~~ Automatic "handle" interrupt clamp value (Z)
- Others Unassigned

6 PX1 ~ PX16: 4 Byte data (X/Z)

- PX1 Air cut clearance X/Z (1 unit, in diameter)
 - PX3 Air cut clearance in grooving X/Z
(1 unit, in diameter)
 - ~~PX13~~ (X/Z) ATC position (index) setting 1
 - ~~PX14~~ (X/Z) ATC position (index) setting 2
 - ~~PX15~~ (X/Z) ATC position (index) setting 3
 - ~~PX16~~ (X/Z) ATC position (index) setting 4
- (Others are not in use.)



Parameter No. 2 Screen

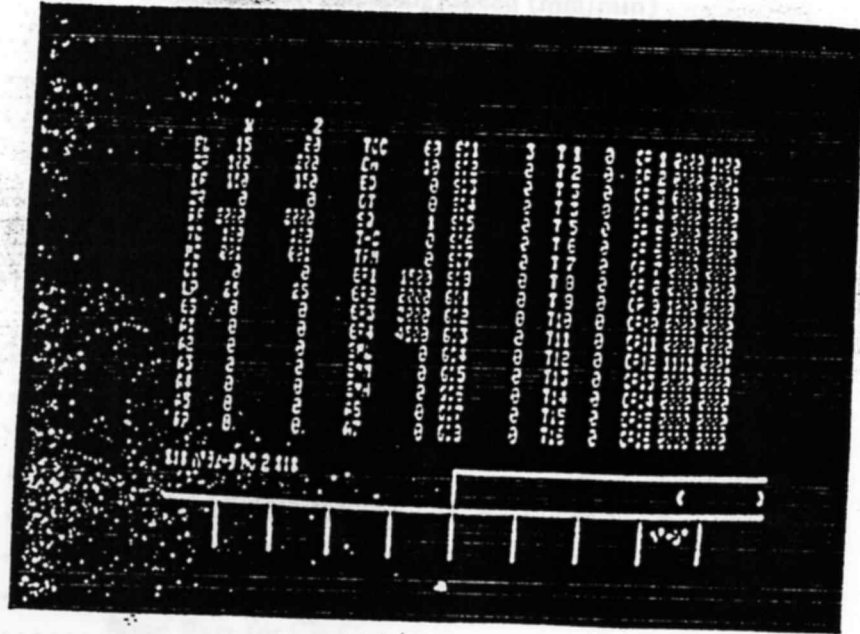
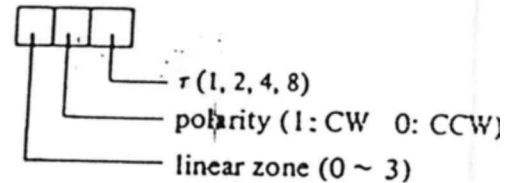


Fig. 9-3.

- BL X/Z Backlash amount (in diameter, 0 ~ 16383)
- ZP X/Z Zero point shift amount
(in diameter, 0 ~ 16383)
- DF X/Z Creep speed in zero return (0 ~ 500 mm/min.)
- ZR X/Z Direction of zero point
(0: positive, 1: negative)
- RF X/Z Rapid traverse speed (0 ~ 20,000 mm/min.)
- TC X/Z Time constant of rapid traverse
(0 ~ 500 msec.)
- MC X/Z Servo constant



- OD X/Z Time constant reduction rate in overtravelling (0 ~ 63%)
- LP X/Z Position loop gain
- AI ATC approach (creeping) speed (mm/min)
- RP X/Z Coordinates of reference point
- TCC Time constant of cutting feed (1 ~ 500 msec)
- CH Chamfering width (0 ~ 40)
 $l = 0.1 \times \text{thread lead}$
- ED Smoothing zero detection remaining distance
 (0 ~ 2000 μ)
- OT Axis stop method in case of overtravelling
 (1: servo off, 0: linear-deceleration)
- SQ Machine sequence constant (See YL Sequence Manual)
- TRM Switchover of chamfering constant
 Chamfering length
- GR1 Gear 1, spindle max. speed
- GR2 Gear 2, spindle max. speed
- GR3 Gear 3, spindle max. speed
- GR4 Gear 4, spindle max. speed
- A7 Baud Rate for CMT:
- SD1 System parameter
- SD2 Spindle gearing step setting
- SD3 Setting of number of tools on tool post (Lear Turnet)
- QD1 ~ QD8 Machine sequence data (See YL Sequence Manual)
- T1 ~ T8 Machine sequence timer (0 ~ 255 $l = 0.1 \text{ sec}$) (See YL Sequence Manual)
- T9 ~ T16 Machine sequence timer (0 ~ 255 $l = 1 \text{ sec.}$) (See YL Sequence Manual)
- OP1 ~ OP16 System parameter

