

TI

LK

How to Clear memory area by manual

~~Q~~ - does it work on YL1 ~~*(sundries)~~ (YL2)
YL3

COPY TO DATE

NJ	7/6/93
ATL	"
LAX	"
CANADA	"
SALES	_____
MFG	_____

- Save programs first
if not corrupted.

REVISION

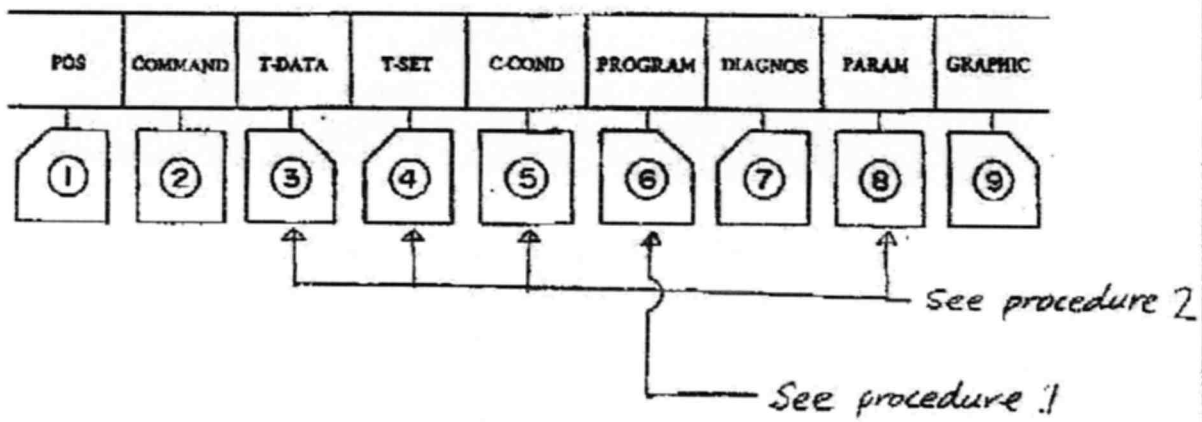
* 7/6/93

- This procedure clears "Tool set"
ie. you lose - Chuck Barrier
- Tail Barrier
- Stroke limit
- Hours.

- make sure you save these values
before clearing control.

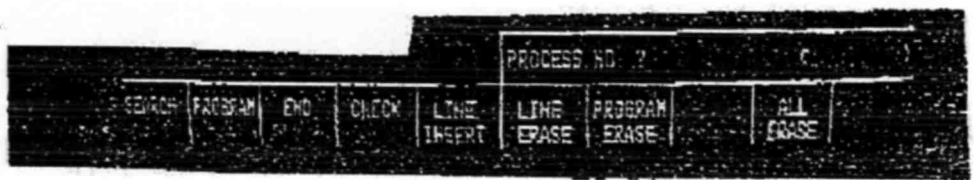
DWG NO.	REV.
MESA- A016	*
-009	

Memory area to be cleared



Procedure 1 (To clear program area)

- ① Select "PROGRAM" screen



- ② Press "ALL ERASE" then Input key

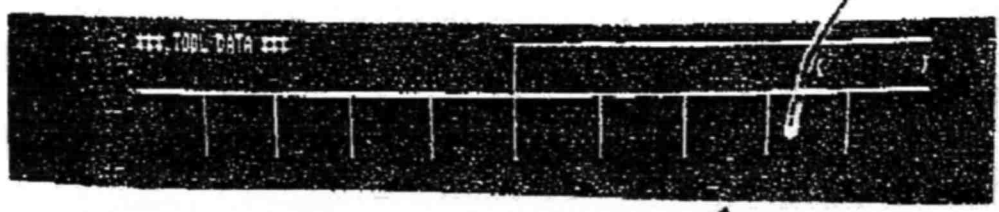
Procedure 2 (To clear other areas)

- ① Select "PARAM" screen
- ② Press key to appear cursor.
- ③ Move cursor to "OP12"
- ④ Enter 11111118 then Input
- ⑤ Power Off and On quickly

— cont'd —

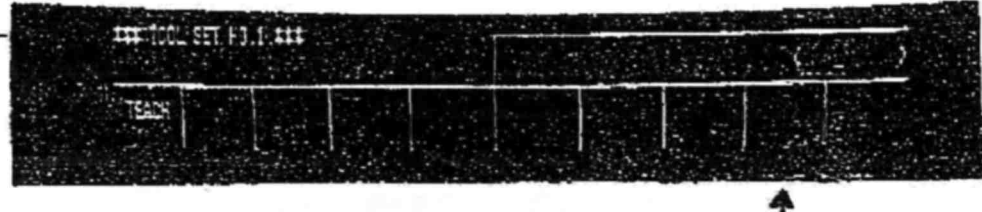
DWG. NO.	REV.
----------	------

⑥ Select "T-DATA" screen



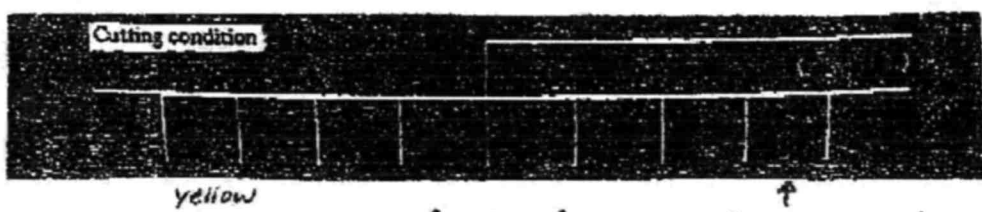
- (i) Press the yellow menu key of the second right hand, → menu key will be highlighted
- (ii) Press "CLEAR" key.
- (iii) All data will be zeroed out except "Life time count" & "Use time/count" data.

⑦ Select "T-SET" screen



- (i) Press the ^V menu key of the first right hand yellow
- (ii) Press "CLEAR" key
- (iii) All data will be zeroed out except "Total Hours"

⑧ Select "C-COND" screen

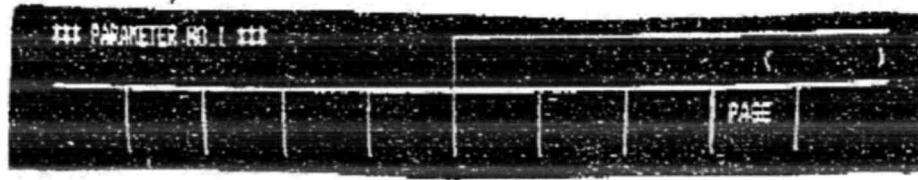


- (i) Press the ^{yellow} menu key of the first right hand.
- (ii) Press "CLEAR" key
- (iii) All data will be zeroed out.

DWG. NO.	REV.
----------	------

⑨ Select "PARAM" screen

(i) Press the ^v menu key next to "PAGE" (Left side).
_{yellow}



(ii) Press "CLEAR" Key

(iii) All data will be zeroed out.

(iv) Press "PAGE" menu key

(v) Do the same procedure done for PAGE 1.

Note: To clear PARAM Page 2 should be done last. because OP12 will be zeroed out if done first.

Note: This memory clear is not always necessary,

do use ~~the~~ CMT part. but. is recommended to be done.

Note: To load data by CMT after memory clear, you should type in "16" to "A7" parameter and "00000010(1)" to "OP 2" parameter.

DWG. NO.	REV.
----------	------

MAZAK T1 PARAMETERS

X Z

BL	SD1	T1	OP1	OP2	OP3	OP4	OP5	OP6	OP7	OP8	OP9	OP10	OP11	OP12	OP13	OP14	OP15	OP16
ZP	300	1160	160	50	300	1160	160	50	300	1160	160	50	300	1160	160	50	300	1160
DF	120	120	120	120	120	120	120	120	120	120	120	120	120	120	120	120	120	120
ZR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
RF	10000	10000	10000	10000	10000	10000	10000	10000	10000	10000	10000	10000	10000	10000	10000	10000	10000	10000
TC	120	120	120	120	120	120	120	120	120	120	120	120	120	120	120	120	120	120
MC	312	011	011	011	011	011	011	011	011	011	011	011	011	011	011	011	011	011
OD	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
LP	25	25	25	25	25	25	25	25	25	25	25	25	25	25	25	25	25	25
GS	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
A1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
A2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
A3	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
A4	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
A5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
RP	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0

B10	0	0	P1	12	P17	375	P33	0	PX1	250	78
B11	95	5	P2	60	P18	350	P34	0	PX2	0	0
B12	93	24	P3	20	P19	100	P35	3987	PX3	197	19
B13	93	32	P4	0	P20	0	P36	3987	PX4	0	0
B14	93	50	P5	0	P21	0	P37	0	PX5		
P15	105	15	P6	0	P22	0	P38	0	PX6		
P16	45	45	P7	0	P23	16	P39	0	PX7		
P17	60	60	P8	1	P24	487	P40	500	PX8		
P18	63	62	P9	0	P25	79	P41	18000	PX9		
P19	15	15	P10	0	P26	1969	P42	3937	PX10		
LK1	0		P11	0	P27	197	P43	0	PX11		
LK2	0		P12	0	P28	394	P44	0	PX12		
LK3	0		P13	0	P29	0	P45	0	PX13		
LK4	0		P14	0	P30	0	P46	0	PX14		
LK5	0		P15	0	P31	0	P47	0	PX15		
LK6	0		P16	1	P32	0	P48	0	PX16	6	0

CUTTING CONDITION

MODE	BARS	RV	FV	FEED	DEPTH	MATERIAL
BAR	OUT					
	IN					1 CBN-STL 100
CPY	FCE					2 ALY-STL 90
	OUT					3 CST-IRN 80
CNR	IN					4 ALUMINIUM 300
	FCE					5 STAINLESS 70
EDGE	OUT					
THR	IN					
GRN	FCE					
GRL						