

0671	TPLGH
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TPLGH Loop gain for position control of the spindle and Z- axis of each gear in the rigid tapping mode. Set the position control loop gain of the 3rd stage gear.

Data type: Word

Set value: **1** -9999

Unit: 0.01 msec-1

0700	LT1X1
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0701	LT1Y1
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0702	LT1Z1
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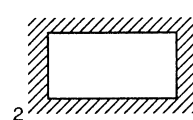
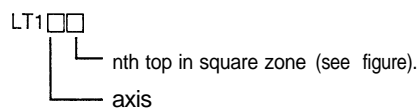
0703	LT141
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0704	LT1X2
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0705	LT1Y2
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0706	LT1Z2
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0707	LT142
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Set stroke limit mentioned above.

Setting range : 0 to 199999999 (unit: 0.001 mm in mm output or **0.0001** inch in inch output)

Set with the distance from the reference point.

In the case of diameter designation, set with the diameter designation value.

The outside of the boundary set with the parameter is set as the inhibited region.

Normally, set at the max. stroke of the machine.

When the axis enters the inhibited region, over-travel alarm is indicated. A margin should be provided with respect to the stroke to cope with the fluctuation in the detecting operation. As a rule, in the case of metric designation, multiply the rapid traverse by a factor of 1/5 and set it as the margin.

Example) Rapid traverse **10** m/min.

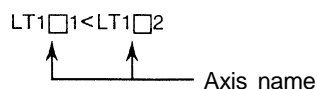
$$10 \times 1/5 = 2 \text{ mm}$$

The actual position of the machine slightly differs from the position stored in the CNC unit after the power is turned on, emergency stop is reset, or servo alarm is reset.

Therefore, before starting operation, be sure to return the axes to reference point.

Otherwise, over-travel detecting position deviates by the value corresponding to the above-described deviation in the position.

When the parameters are set as follows, the stroke limit becomes infinite.



Example) LT1ZI = -1 and LTIZ2 = 1

the Z axis stroke becomes infinite.

(Note 1) For the axis whose stroke is infinite, the incremental command can be specified. If the absolute command is specified, the absolute register may overflow and it is not operated normally.

(Note 2) These parameters cannot be set for the rotary axis.

(Note 3) Unit becomes 1/10 in increment system 1 /10.

0708

PRSX

0709

PRSY

0710

PRSZ

0711

PRS4

PRSX, PRSY, PRSZ, PRS4

These set the coordinate values of the reference point of the X, Y, Z and 4th axes when automatic coordinate system setting is conducted, respectively.

Setting range:
0 to ±99999999
unit: 0.001 mm (mm input)
unit: 0.0001 inch (inch input)

(Note) Unit becomes 1/10 in increment system 1 /10.

0712

PECINTX

0713

PECINTY

0714

PECINTZ

0715

PECINT4

PECINTX, PECINTY, PECINTZ, PECINT4

Pitch error compensation interval for each axis

Setting range :
8000 to 99999999 unit: 0.001 mm (mm input)
4000 to 99999999 unit: 0.0001 inch (inch input)

(Note 1) If zero is set, no compensation is done.
(Note 2) Unit becomes 1/10 in increment system 1 /10.

0730

PROTAG

PROTAG Parameter of angle value used when no angle command is present at coordinate rotation.
Setting value:
-360000 to 360000
unit: 0.001 deg.

0731

PSCRT

PSCRT Parameter of magnification value used when the magnity command is not specified in scalling.
Setting value : 1 to 9999999
Unit: 0.001 magnification
 0.00001 magnification

0732

PSCRT2