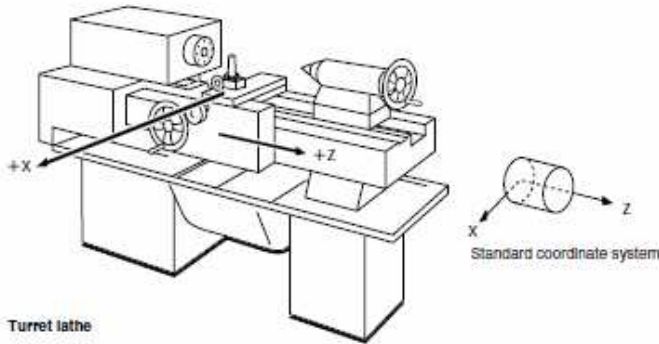


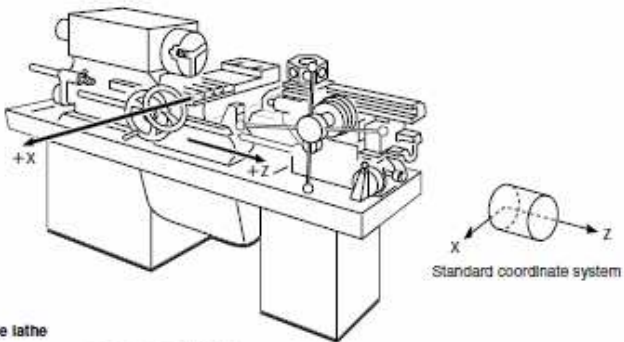
LATHE FUNCTIONS (LH70/LH71)

Display resolution: 0.001mm Unit: mm

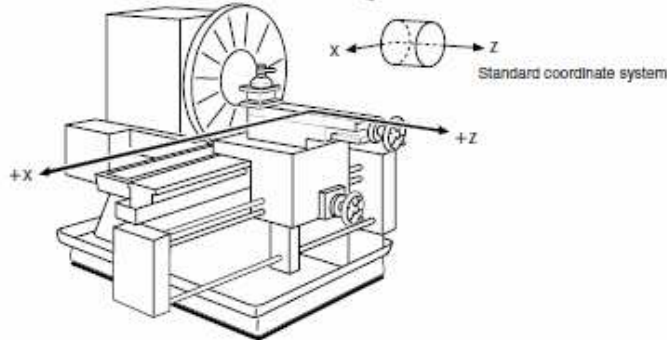
Center lathe



Turret lathe



Face lathe



Begin Operation

Procedure	Display
1 Press key.	5004 → 5 → 0 → A → 4 → 5004
2 Press key.	The previously displayed value (incremental mode when the power is turned on) is displayed.

Finish Operation

Procedure	Display
1 Press key.	

Zero Reset

Procedure	Display
1 Press key.	0.000 (Zero is displayed only for the reset axis)

Preset / Recall

Up to three values can be preset for each axis.

Setting parameters (Example)

Preset 1	10mm
Preset 2	20mm
Preset 3	Change from "15mm" to "30mm"

1. Parameter input (Case of X-axis)

	Procedure (Preset)	Display
1	Press key	
2	Press key.	X: ----- (Only first setting)
3	Enter the preset value, and then press key.	X: 00 10.000
4	Press key, and then Press key.	X: -----
5	Enter the preset value, and then press key.	X: 00 20.000
6	Press key, and then Press key.	X: 00 15.000
7	Enter the new preset value, and then press key.	X: 00 30.000

2. Execution (Case of X-axis)

	Procedure (Recall)	Display
1	Press key	
2	Press key.	Preset value
3	Select the preset value by press key.	x: 00 10.000 (O ↑) x: 00 20.000 (O ↑) x: 00 30.000 (O ↑)
4	Press key and then set the selected preset value	X: 00 30.000

Addition Display

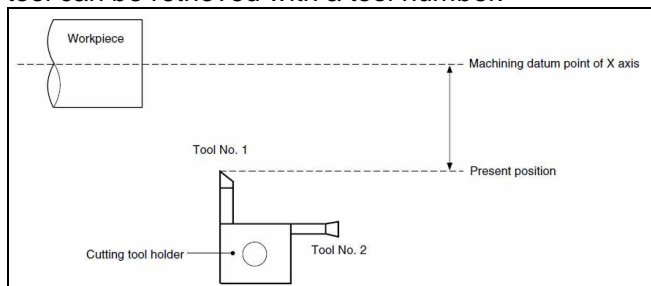
Select count display of measuring unit connected to second and third axes.

(Only for selected **Add** mode on basic setting)

	Procedure	Display
1	Press second-axis key	Z: Z flashes
2	Select the display mode by press key	Z: 2 → 3 → Add
3	Press key	Z: Current position (by selected mode)

Tool coordinatng

The provided number of coordinates can be set as tool coordinates, and the coordinate of any cutting tool can be retrieved with a tool number.



First, X-axis set the diameter display (to light up when the display resolution is selected)

Setting parameters (Example)

Tool No.1	Tool offset value: 20mm
Tool No.2	Tool offset value: 10mm

1. Parameter input

1-1 Setting the tool coordinate for tool No.1

	Procedure	Display
1	Press key	Current position (ABS)
2	Using tool No.1, machine the outside of work piece in the direction of the X-axis. 	
3	Press X-axis key, and then press key.	X: The display is held. Z: Current position
4	Move the cutting tool and measure the diameter of the machined workpiece with a micrometer. 	
5	Press X-axis key, and then enter the diameter of the workpiece into the X-axis.	X: 0020.000 (Hold value) Z: Current position
6	Press key	X: Current + hold value Z: Current position
7	To make a datum point for the Z-axis direction, briefly machine the end surface of the workpiece. 	
8	Press Z-axis key, and then enter the "0".	Z: 0000.000
9	Press key	X: Current + hold value Z: 0.000

1-2 Setting the tool coordinate for tool No.2

	Procedure	Display
1	Press key	Current position (ABS)
	Press third-axis key	700L --
	Enter the tool number and then press key	X: Current position Z: Current position : 700L 2
2	Using tool No.2, machine the outside of work piece in the direction of the X-axis. 	
3	Press X-axis key, and then press key.	X: The display is held. Z: Current position
4	Move the cutting tool and measure the diameter of the machined workpiece with a micrometer. 	
5	Press X-axis key, and then enter the diameter of the workpiece into the X-axis.	X: 0010.000 (Hold value) Z: Current position
6	Press key	X: Current + hold value Z: Current position
7	To make a datum point for the Z-axis direction, briefly machine the end surface of the workpiece. 	
8	Press Z-axis key, and then enter the "0".	Z: 0000.000
9	Press key	X: Current + hold value Z: 0.000

2. Calling tool coordinate

	Procedure	Display
1	Press key	Current position (ABS)
2	Press third-axis key	X: Current position Z: Current position : 700L --
3	Enter the tool number and then press key	X: Current position Z: Current position : 700L 2