





Begin Operation

	Procedure	Display
1	Press  key.	5079.5 → 50 → 507 → 5079
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 (Exmpl-1)

Preset 1	100mm
Preset 2	200mm
Preset 1	Change from "100mm" to "300mm"

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: 0100.000
4	Press  key, and then Press  key.	X: -----
5	Enter the preset value, and then press  key.	X: 0200.000
6	Press  key, and then press  key select to the "Value of Preset 1".	X: 0100.000
7	Enter the new preset value, and then press  key.	X: 0300.000

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.	x0200.000 (↑) x0300.000 (↑) x: ----- (↑)
4	Press  key and then set the selected preset value	X: 0300.000

Multiple Datum Point











The ABS coordinate value is registered by the datum point setting operation, and 10 datum point offset values can be set based on this coordinate value.

(LH71: up to 150 datum points)




Setting parameters (Example-2)

No. 0	0mm
No. 1	100mm
No. 2	200mm

1. Parameter input (Case of X-axis)

	Procedure	Display
1	Press  key.	X: No. * → No. *'s value
2	Enter the datum No. "0" and then press  key.	X: No. 0 → 0.000
3	Press  key.	X: 0000.000
4	Enter the datum No.0's value and then press  key.	X: 0.000
5	Press  key.	X: No. 1 → 0.000
6	Press  key.	X: -----
7	Enter the datum No.1's value and then press  key.	X: 0100.000
8	Press  key.	X: No. 2 → 0.000
9	Press  key.	X: -----
10	Enter the datum No.2's value and then press  key.	X: 0200.000

2. Execution (Case of X-axis)

	Procedure	Display
1	Press  key.	X: No. * → No. *'s value
2	Enter the datum No.	X: No. 1 --
3	Press  key. (Case of No.2)	X: No. 1 → 100.000
4	Enter the datum No.	X: No. 2 --
5	Press  key. (Case of No.2)	X: No. 2 → 200.000

Bolt Hole Circle

Setting parameters (Example-3)

Diameter	100mm
Number of holes	4
Starting Angle	0°
Ending Angle	0°

Same result

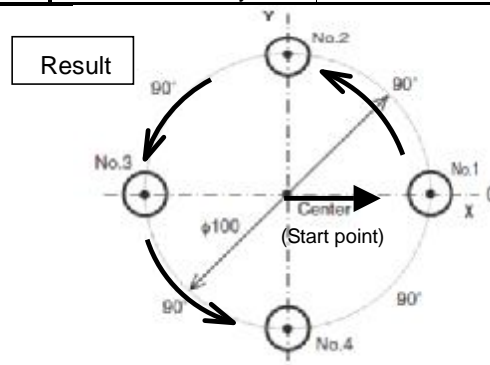
100mm
4
0°
270°

1. Parameter input

Procedure	Display
1 Press key so that BOLT flashes.	
2 Press key, and then enter the diameter.	X: <i>d IR</i> Y: 0100.000
3 Press key, and then enter the number of holes.	X: <i>NO. HOLE</i> Y: 004
4 Press key, and then enter the starting angle.	X: <i>ST. ANG</i> Y: 000.000
5 Press key, and then enter the ending angle.	X: <i>End. ANG</i> Y: 000.000
6 Press key. (Saved parameters)	Current position

2. Execution (After setting parameters)

Procedure	Display
1 Move the machine to start point(center of the circle).	
2 Press key.	No. 1 → X: -50.000 Y: 0.000
3 Move the machine to display "(0,0)".	
4 Press key.	No. 2 → X: 50.000 Y: -50.000
5 Move the machine to display "(0,0)".	
6 Press key.	No. 3 → X: 50.000 Y: 50.000
7 Move the machine to display "(0,0)".	
8 Press key.	No. 4 → X: -50.000 Y: 50.000
9 Move the machine to display "(0,0)".	
10 Press key.	End → Current position



Simple R Cutting (Outer diameter)

Setting parameters (Example-4)

Radius	20mm	Tool diameter	φ6
Starting Angle	0°	Ending Angle	90°
Pitch Angle	30°		

1. Parameter input

Procedure	Display
1 Press key to ARC flashes	
2 Press key. (Only 3-axis model)	X: <i>PLANE</i> Y: 1-2
3 Press key, and then enter the radius	X: <i>rAd IUS</i> Y: 0020.000
4 Press key, and then enter "+" the tool diameter. (enter "-" : inner diameter)	X: <i>7-d IR</i> Y: 0006.000
5 Press key, and then enter the starting angle.	X: <i>ST. ANG</i> Y: 000.000
6 Press key, and then enter the ending angle.	X: <i>End. ANG</i> Y: 090.000
7 Press key, and then enter the pitch angle.	X: <i>PCH ANG</i> Y: 030.000
8 Press key. (Saved parameters)	Current position

2. Execution (After setting parameters)

Procedure	Display
1 Move the machine to start point(center of the circle).	
2 Press key.	No. 1 → X: -23.000 Y: 0.000
3 Move the machine to display "(0,0)".	
4 Press key.	No. 2 → X: 3.081 Y: -11.500
5 Move the machine to display "(0,0)".	
6 Press key.	No. 3 → X: 8.419 Y: -8.419
7 Move the machine to display "(0,0)".	
8 Press key.	No. 4 → X: 11.500 Y: -3.081
9 Move the machine to display "(0,0)".	
10 Press key.	End → Current position

