

5.4 INDEX TABLE INDEXING FUNCTION

By specifying indexing positions (angles) for the indexing axis (rotary table, A, B, or C), the index table of the machining center can be indexed.

Before and after indexing, the index table is automatically unclamped or clamped.

NOTE

To enable the index table indexing function, reset bit 0 (IT) of parameter No. 5501 to "0" and set bit 3 (IXC) of parameter No. 6132 to "1".

Explanation

- Indexing position

Specify an indexing position with address A, B, or C (set to bit 0 of parameter BDT's No.1006).

The indexing position is specified by either of the following (depending on bit 4 of parameter G90 No.5000):

1. Absolute value only (Bit 4 (G90) of parameter No.5000 = 1)
2. Absolute or incremental value depending on the specified G code: G90 or G91 (Bit 4 (G90) of parameter No.5000 = 0)

A positive value indicates an indexing position in the counterclockwise direction. A negative value indicates an indexing position in the clockwise direction.

The minimum indexing angle of the index table is the value set to parameter 5512. Only multiples of the least input increment can be specified as the indexing angle. If any value that is not a multiple is specified, an alarm PS1543 occurs. Decimal fractions can also be entered. When a decimal fraction is entered, the 1st digit corresponds to degree units.



- Direction and value of rotation

The direction of rotation and angular displacement are determined by either of the following two methods. Refer to the manual written by the machine tool builder to find out which method is applied.

1. Using the auxiliary function specified in parameter No. 5511 (Address) (Indexing position) (Auxiliary function). Rotation in the negative direction (Address) (Indexing position). Rotation in the positive direction (No auxiliary functions are specified.)

An angular displacement greater than 360° is rounded down to the corresponding angular displacement within 360° when bit 2 of parameter ABS No. 5500 specifies this option.

For example, when G90 B=400.0 (auxiliary function) is specified at a position of 0°, the table is rotated by 40° in the negative direction.

2. Using no auxiliary functions

By setting to bits 2, 3, and 4 of parameter ABS, INC, G90 No.5000, operation can be selected from the following two options.

Select the operation by referring to the manual written by the machine tool builder.

- (1) Rotating in the direction in which an angular displacement becomes shortest

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web this interview was originally included as one of the chapters in pioneers of recovery published by parkinsons recovery lidia m epp is a molecular biologist who discovered that the symptoms of parkinson s disease she was experiencing were related to an overgrowth of candida in her body

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