

7. The chuck to workpiece contact position cannot be judged if the feedrate override setting is raised after executing the G38 block with 0% set for feedrate override. It is necessary to set a value other than 0% for feedrate override when executing the G38 block. It must also be remembered it is not allowed to change the feedrate override setting during the execution of the G38 block.
8. In a G38 block, all numeric values must be specified with a decimal point.

### 2.3.1 Operation (Workpiece Pushing Check)

- 1) The B-axis starts positioning at the feedrate of 2000 mm/min under torque limited conditions to the target position obtained by deducting " $K + Q + 0.002 \text{ mm}$ " from the position specified by B (J, V).  
\* If the target position is set as "B (J, V)" - " $K + Q$ ", the B-axis position reached by returning by "K" from the target position without detecting pushing (the position finally reached) is always within the tolerance range and it is therefore impossible to detect an alarm status. For this reason, the target position is set  $-0.002 \text{ mm}$  further from the "B (J, V)" - " $K + Q$ " position. The system judges that pushing has not been detected if the B-axis stops at this position.
- 2) When chuck 2 comes into contact with the workpiece, the B-axis servomotor fails to rotate due to torque limit and only servo error increases. When the error reaches the value set for the parameter, the servomotor stops.
- 3) If the stop position is within 0.1 mm from the B-axis movement start point or at the B-axis movement end point, a pushing detection alarm is triggered.
- 4) B-axis returns the distance specified by K.  
This return travel usually eliminates mechanical workpiece deflection that might be generated by pushing operation.  
If no K command is specified, the B-axis returns by "present servo error + 0.1 mm" and then moves back 0.1 mm in the pushing direction.
- 5) The torque limited state is cleared.
- 6) If the returned position is within the allowable tolerance, chuck 2 is clamped and the program advances to the next block.
- 7) If the returned position is outside the allowable tolerance, steps 1) to 6) are repeated once. If the returned position is still outside the allowable tolerance, an alarm is triggered.

### 2.3.2 Alarm Table (Workpiece Pushing Check)

No.	Alarm	Function
3001	'B POSITION ERROR'	The position obtained in the pushing detection process is outside the tolerance range.
3003	'B, J AND V SPECIFIED'	Two or more coordinate values are specified.
3005	'B POSITION NOT SPECIFIED'	No target position is specified.
3007	'SKIP NOT DETECTED'	No B-axis current is detected during axis feed up to the end position.
3008	'SKIP ALREADY DETECTED'	The specified level current is detected at the start or just after the start of Z-axis feed.
3009	'RETURN AMOUNT IS NEGATIVE'	The specified K value is not positive.

#### NOTE

The pushing detection program is called by G38.  
Since this program is written to ROM as a macro executor and not stored in the NC memory, it is not possible to display or edit it.  
It is not possible to change the G code.

### 2.4 Workpiece Cut-Off Detection (M80)

The M80 command is used to check if the cut-off cycle, executed after the transfer of the workpiece clamped in the chuck of spindle 1 to the chuck of spindle 2, has been completed.  
Completion of cutting off is confirmed by detecting the spindle speeds of spindles 1 and 2. If spindle 2 does not follow spindle 1 when the spindle speed of spindle 1 is changed, cutting off is judged to have been completed.

#### CAUTION

When cutting off a solid workpiece, the tool reaches the center of rotation of the workpiece. For this reason, tools or holders adjacent to the tool in use may interfere with the chuck. When mounting tools or holders on turrets, confirm that there will be no interference caused between the chuck and the adjacent tools or holders.  
[interference of chuck and adjacent tools/holders, machine damage]

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**AW Rasmussen**



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