

## Rapid Broken Tool Cycle for NC2 — Okuma OSP/U100M.

**Call line:** CALL O700 (P1=0.2) (P2=10.) (P3=1.) ( ) denotes optional inputs

### Inputs used

P1 = h	h =	Broken Tool tolerance, measured from the bottom of the tool. Default value 0.5mm
P2 = z	z =	Clearance Plane. This defines the first move in the Z-axis, relative to the <b>ACTIVE WORK OFFSET</b> , before moving to the laser beam measuring position. The tool also returns to this position after the cycle has finished. If the laser beam is positioned higher than the defined clearance position then the Clearance Plane value is modified to position the end of the tool above the NC2 prior to moving to the laser beam measuring position. The tool also returns to this position after the cycle has finished. The tool offset should still be <b>ACTIVE</b> . If the P2=z input is not used then the first and last moves will be to the Z-axis reference position.
P3 = m	m =	Alarm Flag. No input then machine stops with alarm. P3=1 then no alarm is generated and parameter #C000 is set to 1.

### Edits required before cycle O700 is used.

The Machine Co-Ordinates of the measuring position of the NC2 laser needs to be found and then edited into the header of macro program O700 **BEFORE** the cycle is run. Relevant M-codes and Probe Input (1 or 6) also need to be entered.

```
O700
M100
(HS BROKEN TOOL NC2)
(459)100.00
VNC00(1) = 0 (EDIT TO 6 IF INSPECTION PROBE INPUT IS USED)
PV14 = 100 (EDIT X AXIS BEAM POSITION)
PV15 = 200 (EDIT Y AXIS BEAM POSITION)
PV16 = -200 (EDIT Z AXIS BEAM POSITION)
PJ = 61 (EDIT M-CODE BROKEN TOOL)
PK = 62 (EDIT M-CODE CANCEL BROKEN TOOL)
```

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**Michal Rosen-Zvi**



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