

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 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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animal companion familiar character sheet r pathfinder2e reddit - Apr 14 2023

jan 18 2020 the animal companion familiar sheet is included in the pathfinder expanded character sheet which can be found here paizo com threads rzs42rfd printer friendly fillable expanded character the non fillable version can be found here if you just want to print it out drive google com file d 1tfschxujgoxfgzalraaiywj6wvlhxa8 view

animal character sheet pathfinder wrath of the righteous - Mar 01 2022

oct 15 2022 animal character sheet okay maybe i m blind but how do you access your animal companion s character sheet so far i only managed to do so when in base camp where you have access to all companions but not when i m elsewhere

5e final fillable companion sheet r dnd reddit - Sep 19 2023

apr 29 2016 fillable companion sheet hello again everyone i finally got around to making the companion character sheet fillable and have the link for you all here dropbox com s swl1t5dyszq7kqp final 20companion 20sheet pdf dl 0 i also tried this for those who don t like dropbox it should work

animal companion character sheet general discussion d d - Oct 08 2022

aug 4 2020 there s going to be a section of the revamped character sheet especially for this check out the preview of the character sheet that we saw here halfway through the latest developer update it s an overall look at the character sheet but we get a glimpse of where companions will be included