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Code @ Code Group
Function G00 G00) A
Positioning Ot G01 A
Linear Interpolation
G02 coz A Circular
Interpolation CW GOs
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Interpolation CCW Or
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Metric Data Input G27
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(G29 G29) Return from

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A command for the manual/automatic simultaneous valid axis was issued from the automatic mode. The manual speed command was issued while the "tool length measurement 1" signal is ON. A travel

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command has been issued to an inclined axis whose base axis is in control axis synchronization across part systems. Remedy

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System W/ 8" x *" x 6"
Work envelope 1)
Mitutoyo Model ATK-
F1000 Hardness Tester

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Anyway if this is a
Fanuc, #8409 is the
current tool H
compensation number
selected by tool life, at
which point you can
use that to read the
length in the table by
using #2200 or
#11000 variables
(compensation
memory C parameter
6000 bit 3 = 0) So your
H code in the macro

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call to measure the
length would read
H#[2200+#8409].

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I am having an issue
with the turret. It is not
clamping at 2 tool
stations. The turret was
taken off as the
machine crashed. The
turret was taken off

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and replaced and the tool stations that did not clamp changed (it started with problems at 9 and 10 then moved to 3 and 4). I read one post that the O-ring on the mounting place caused this problem but the surface has been cleaned thoroughly.

Mori Seiki lathes > SL25-MC5 Turret problem

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Gen3; Vertical

Machining Centers.

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5100 with Lyndex

Nikken 4 th /5 th Axis
Rotary Table; Mori

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with Troyke 4 th /5 th
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