

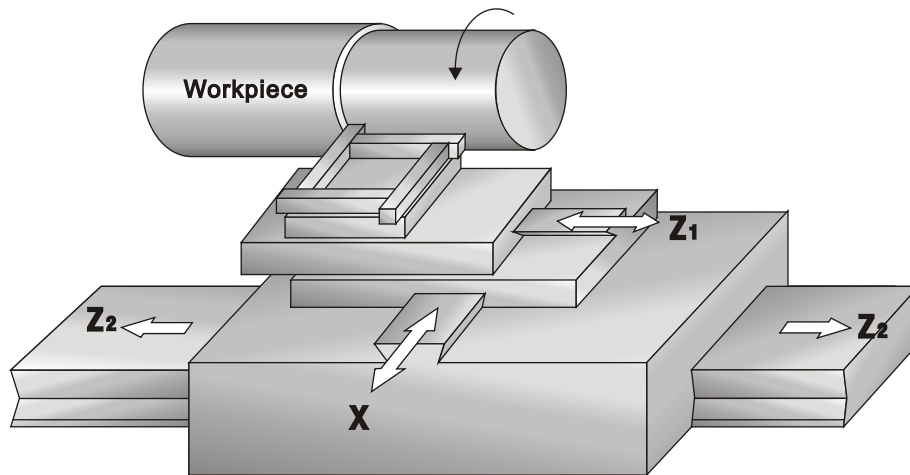
# DC

## LATHE FUNCTION

F

Set lathe function

- F — 1. LATHE : Summing function (38p)
- 2. DIA : Double counting function (39~40p)



# 1. Lathe Summing Function (1.LAtHE)

- This function is available in the model DSC-803, 804.
- X-axis can be adjustable.
- Result from summing Y & Z-axis appears in the Y-axis window.
- Inputting value and Zero setting don't work in the Z-axis
- If Y-axis is reset by , Z-axis is also reset automatically.
- Bolt hole circle doesn't work.

<p></p>	<p>X <span style="border: 1px solid black; padding: 2px;">LAtHE</span></p> <p>Y <span style="border: 1px solid black; padding: 2px;">0.000</span></p> <p>Z <span style="border: 1px solid black; padding: 2px;">0.000</span></p>			
<p></p>	<p></p> <p>X <span style="border: 1px solid black; padding: 2px;">LAtHE</span></p> <p>Y <span style="border: 1px solid black; padding: 2px;">nor</span></p> <p>Z <span style="border: 1px solid black; padding: 2px;">0.000</span></p>			
<p> } </p>	<p></p> <p>X <span style="border: 1px solid black; padding: 2px;">LAtHE</span></p> <p>Y <span style="border: 1px solid black; padding: 2px;">LAtHE</span></p> <p>Z <span style="border: 1px solid black; padding: 2px;">0.000</span></p>			<p>NOR ↔ LATHE by  </p>
<p></p>	<p></p> <p>X <span style="border: 1px solid black; padding: 2px;">0.000</span></p> <p>Y <span style="border: 1px solid black; padding: 2px;">0.000</span></p> <p>Z <span style="border: 1px solid black; padding: 2px;">LAtHE</span></p>			

Summing present values

	<p>X <span style="border: 1px solid black; padding: 2px;">-23600</span></p> <p>Y <span style="border: 1px solid black; padding: 2px;">41260</span></p> <p>Z <span style="border: 1px solid black; padding: 2px;">65085</span></p>		
<p></p>	<p>X <span style="border: 1px solid black; padding: 2px;">LAtHE</span></p> <p>Y <span style="border: 1px solid black; padding: 2px;">nor</span></p> <p>Z <span style="border: 1px solid black; padding: 2px;">65085</span></p>		
<p></p>	<p></p> <p>X <span style="border: 1px solid black; padding: 2px;">LAtHE</span></p> <p>Y <span style="border: 1px solid black; padding: 2px;">nor</span></p> <p>Z <span style="border: 1px solid black; padding: 2px;">65085</span></p>		
<p> } </p>	<p></p> <p>X <span style="border: 1px solid black; padding: 2px;">LAtHE</span></p> <p>Y <span style="border: 1px solid black; padding: 2px;">LAtHE</span></p> <p>Z <span style="border: 1px solid black; padding: 2px;">65085</span></p>		
<p></p>	<p></p> <p>X <span style="border: 1px solid black; padding: 2px;">-23600</span></p> <p>Y <span style="border: 1px solid black; padding: 2px;">106345</span></p> <p>Z <span style="border: 1px solid black; padding: 2px;">LAtHE</span></p>		



**Ex.** To set double counting function  
(by diameter) for X-axis.

X	25.000
Y	-8.395
Z	40.620

**F**   
(5 times)

X	6.d 1R
Y	-8.395
Z	40.620

**FUN**

Move to No.6

**ENT**

X	6.d 1R
Y	SEL RH 15
Z	40.620

**FUN**

**X**

X	rAd
Y	SEL RH 15
Z	40.620

**FUN**

 }  
 }

X	d 1R
Y	SEL RH 15
Z	40.620

**FUN**

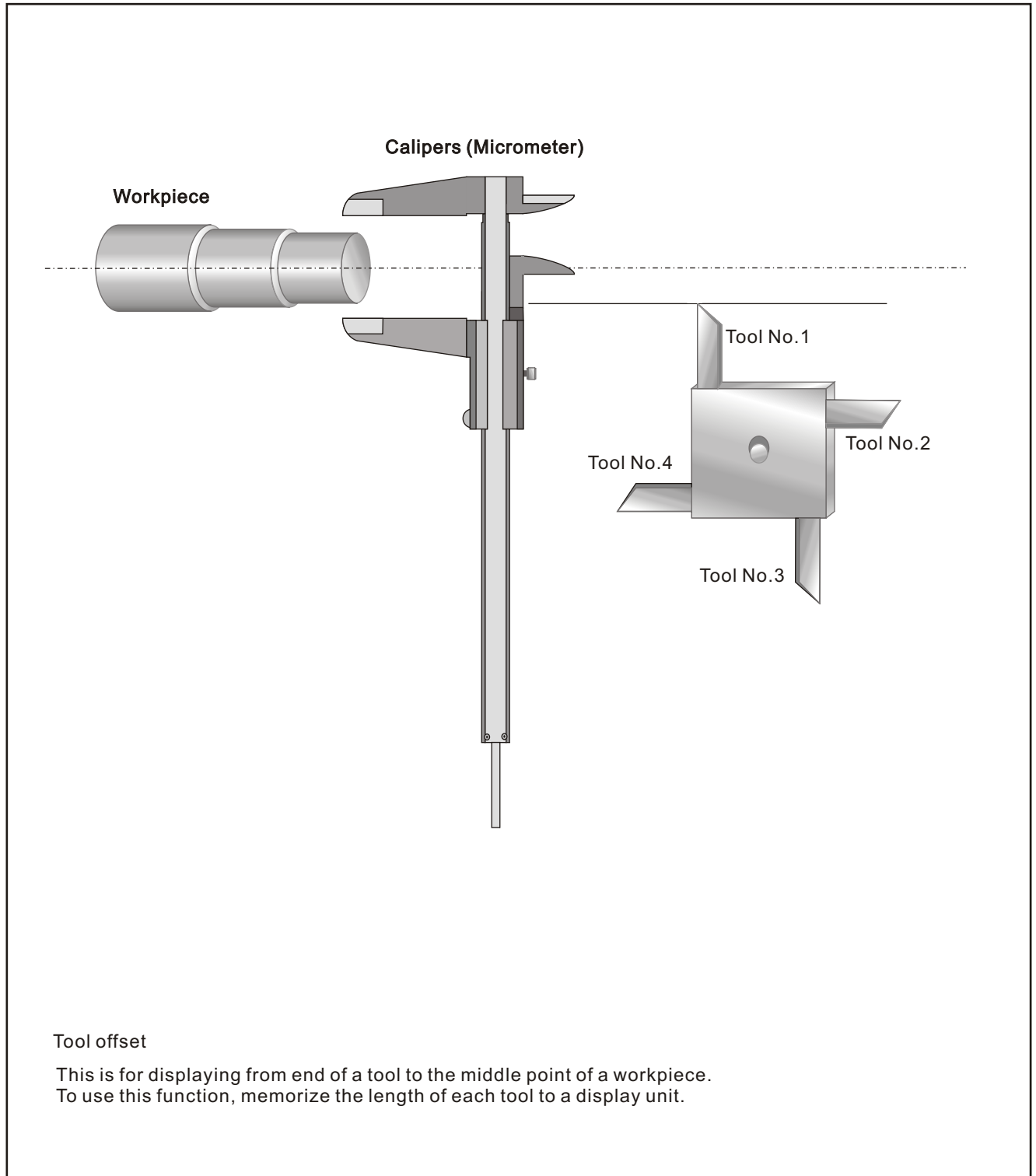
**ENT**

X	25.000
Y	-8.395
Z	40.620

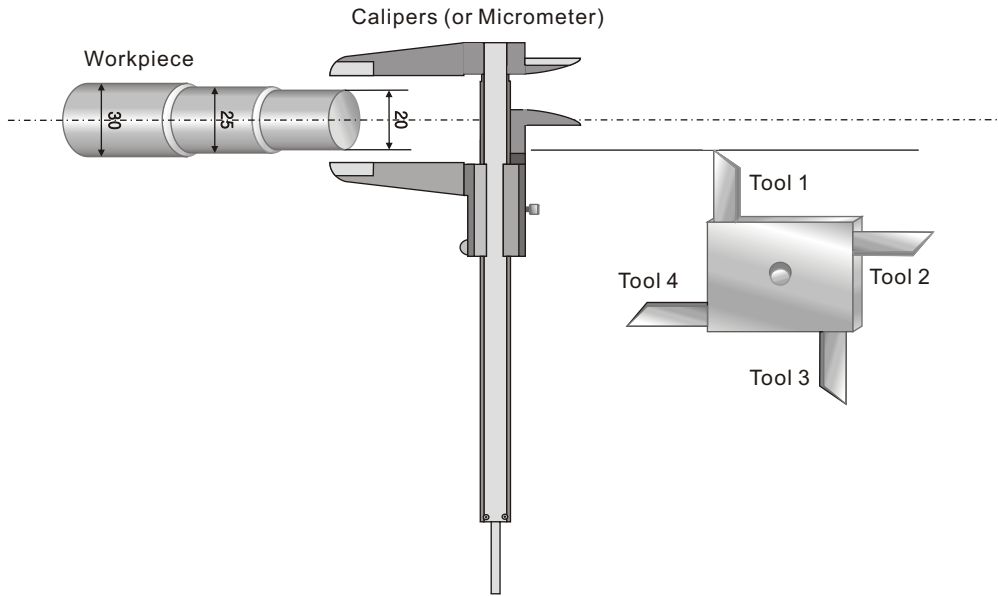
**DIA**

X-axis will be double counted.

### 3. Tool Offset



Ex. Tool#1 → Imitation processing → measuring diameter → input the value  
 Tool#2  
 Tool#3  
 Tool#4



ABS

X 68.530  
 Y -5.405  
 Z 18.700  
 ABS 0

Select ABS function

1 ENT

X 68.530  
 Y -5.405  
 Z 18.700  
 ABS 1

Assign tool#1 to ABS No.1

X 2 0 ENT

Measured diameter value, 20, of the workpiece.

X 20.000  
 Y -5.405  
 Z 18.700  
 ABS 1

**Offset of Tool#1**

Do imitation processing with Tool#1. Then, take off the tool and measure diameter of the workpiece with a calipers or micrometer. Input the measured value to a display unit.

Tool#1 will be set by inputting measured value, "20".

▶

X 30.080  
 Y 10.860  
 Z 22.350  
 ABS 2

Assign tool#2 to ABS No.2

X 2 5 ENT

X 25.000  
 Y 10.860  
 Z 22.350  
 ABS 2

**Offset of Tool#2**

Do imitation processing with Tool#2. Then, take off the tool and measure diameter of the workpiece with a calipers or micrometer. Input the measured value to a display unit.

Tool#2 will be set by inputting measured value, "25".



X	43060
Y	18860
Z	57200

ABS  3

X 3 0 ENT

X	30000
Y	18860
Z	57800

ABS  3

Assign tool#3 to ABS No.3

**Offset of Tool#3**

Do imitation processing with Tool#3. Then, take off the tool and measure diameter of the workpiece with a calipers or micrometer. Input the measured value to a display unit.

Tool#3 will be set by inputting measured value, "30".