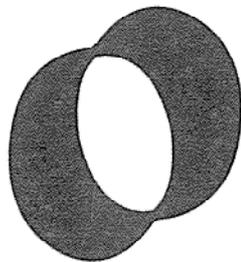
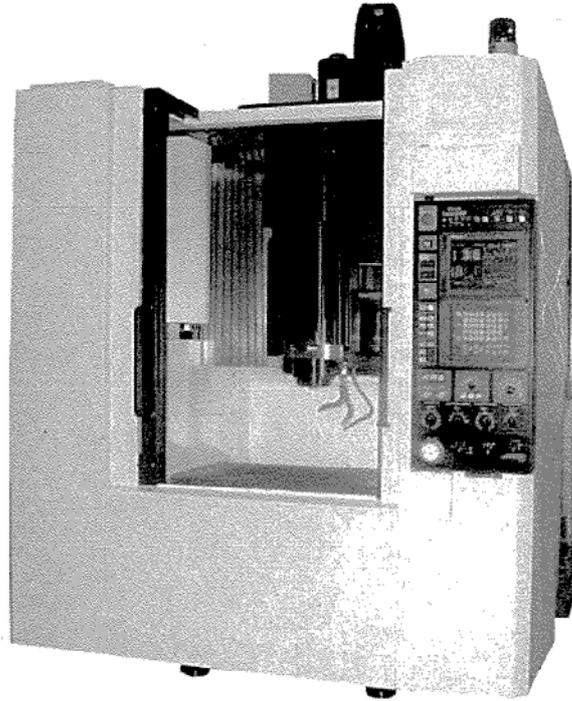


S33/S56 MACHINE

AWM/ATLM

OPERATION MANUAL

(MFX650E001-01)



MAKINO

**AUTOMATIC TOOL LENGTH MEASUREMENT SYSTEM
(ATLM)**

OPERATION MANUAL

CONTENTS

SECTION 1 ABSTRACT

SECTION 2 CONSTRUCTION

SECTION 3 ARRANGEMENT

- 3.1 LOADING OF SYSTEM TAPE
- 3.2 CALIBRATION
- 3.3 PROGRAM SPECIFICATION

**SECTION 4 AUTOMATIC TOOL LENGTH MEASUREMENT
SYSTEM**

- 4.1 AUTOMATIC MEASUREMENT
- 4.2 MANUAL MEASUREMENT
- 4.3 AUTOMATIC COMPENSATION

SECTION 5 ALARM CODES AND PARAMETERS

- 5.1 ALARM CODES TABLE
- 5.2 PARAMETERS

**AUTOMATIC WORK MEASUREMENT SYSTEM
(AWM)**

OPERATION MANUAL

CONTENTS

- SECTION 1 LIST OF COMMON VARIABLES USED BY RENISHAW MACRO PROGRAMS**
- 1.1 BASIC MOVE FACTOR
 - 1.2 THE BASIC GAUGING MOVE
- SECTION 2 INPUT/ OUTPUT FORMAT**
- 2.1 INPUT FORMAT FOR MACRO PROGRAMS
 - 2.2 OUTPUT FORMAT FROM MACRO PROGRAMS
 - 2.3 SPINDLE ORIENTATION
- SECTION 3 STYLUS PROTECTION**
- 3.1 PROTECTED POSITIONING
- SECTION 4 PROBE STYLUS CALIBRATION**
- 4.1 CALIBRATE IN A BORE HOLE
 - 4.2 CALIBRATE IN A RING GAUGE
 - 4.3 CALIBRATE IN THE Z-AXIS
- SECTION 5 MEASUREMENT AND SETTING PROGRAMS**
- 5.1 BORE/ BOSS MEASURE OR SET
 - 5.2 WEB/ POCKET MEASURE OR SET
 - 5.3 SINGLE SURFACE MEASURE OR SET
 - 5.4 Z MEASURE OR SET
 - 5.5 INTERNAL CORNER (SETTING ONLY)
 - 5.6 EXTERNAL CORNER (SETTING ONLY)
 - 5.7 PRINT MACRO OPTION (WHEN FITTED)
- SECTION 6 SOFTWARE ALARMS**
- SECTION 7 GENERAL SOFTWARE APPLICATIONS**
- 7.1 GENERAL SOFTWARE APPLICATIONS
 - 7.2 TO CHECK NTH COMPONENT