



MIYANO CONVERSATION
CNC SYSTEM FOR LATHE

INSTRUCTION MANUAL



CONTENTS

1.	SPECIFICATION OF CONVERSATIONAL FUNCTION	1
2.	OPERATOR'S CONTROL PANEL	3
3.	DEVICES ARE USED FOR INTERACTIVE INPUT TO THE GRAPHIC SYSTEM	4
4.	OPERATION PROCEDURE CONVERSATION FLOW CHART	7
5.	START OF CONVERSATIONAL PROGRAMMING	8
6.	INPUT OF BLANK	14
7.	INPUT OF WORK PROFILE	23
7-1	Input of the Work Profile	23
7-2	Input of Start Point	24
7-3	Input of Profile Element	26
7-4	Each Profile Element Data	29
7-5	End of Profile Element Input	45
8.	TURRET INDEX POSITION AND TAILSTOCK SHAPE	46
9.	CUTTING DEFINITION	48
9-1	Setting of Machining Process	48
9-2	Common Items to Each Process	53
9-3	Input of Cutting Direction and Cutting Area	55
9-4	Input of Tool	55
9-4-1	Input of tool control number	56
9-4-2	Input of tool shape	58
9-4-3	Input of tool data	60
9-4-4	Input of tool (tip) material	61
9-5	Setting of Each Condition on the Cutting Method to Each Process and Working Explanation Notes	62
9-5-1	Common input items	62
9-5-2	Drilling and reaming	63
9-5-3	Roughing of OD and ID	69
9-5-4	Finishing of OD & ID	72
9-5-5	Roughing & Finishing of OD & ID	73
9-5-6	Grooving	74
9-5-7	Necking	78
9-5-8	Threading	80
9-5-9	Tapping	85
9-5-10	Bar feeding	88
9-5-11	Cutting-off	93
10.	PROGRAM PREPARATION	99
11.	SIMULATION & DATA DISPLAY	104
11-1	Flow Chart	104
11-2	While [6. Simulation Data Display] is Selected Through [MENU SCREEN], the Screen Will Be As follows;	105
11-3	Operation Mode	105
11-4	Prescribed Modes	105
11-5	Program Display	106

11-6 Tool Path	107
11-7 Animated Graphics Drawing	109
11-8 Process Chart	115
12. PROGRAM TRANSFER	116
13. SYSTEM PARAMETER	124
14. MATERIAL FILE	125
15. TOOL FILE	130
16. CUTTING FILE	135
17. [AVX REGISTER],[AVX INPUT]	136
18. INPUT OF CUTTING DIRECTION AND CUTTING AREA	140
19. MACHINING PROCESS AND ITS OPERATION	159
19-1 General Term on Each Process	159
19-2 Machining of OD & ID	159
19-3 Grooving	172
20. CUTTING PROCESS CYCLE (EXAMPLE)	178
21. FORMAT	179
22. CHANGE OF DATE AND TIME	180
23. STANDARD SETTING	182
24. SYSTEM PARAMETER LIST	184
25. PROFILE INPUT ALARM LIST	199