

Standard Procedure of VC 630 5AX

Machine Parameter Programming

VC 630 5AX ATC



MOD

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ENT

END



Manual operation	Machine parameter programming
Error	
File: 340494.MP Line: 1544 Column: 14 OVERWR	
MP 960.0 : 032.35000	MP config
MP 960.1 : -35.00000	Total
MP 960.2 : +15.85000	
MP 960.3 : +0.00000	MP data
MP 960.4 : +0.00000	Total
MP 960.5 : +0.00000	
MP 960.6 : +0.00000	MP data
MP 960.7 : +0.00000	spindle
MP 960.8 : +0.00000	
MP 960.9 : +0.00000	MP data
MP 960.10 : +0.00000	PLC
MP 960.11 : +0.00000	Feed
MP 960.12 : +0.00000	
MP 960.13 : +0.00000	MP data
=====	
;MP 1000 .. 1399	
;Positioning / Controlling	
=====	
;MP1010 Axis-specific rapid traverse. At program-end and	
; program-choice is always MP1010 active.	
;Input: 10 to 300 000 (mm/min) or (degrees/min)	
MP 1010.0 : 10000	TC
MP 1010.1 : 10000	
MP 1010.2 : 10000	
MP 1010.3 : 10000	
MP 1010.4 : 2000	
MP 1010.5 : 2000	
MP 1010.6 : 2000	
MP 1010.7 : 10000	
MP 1010.8 : 10000	
MP 1010.9 : 10000	

ATC

MP data TC

MP data TC

MP data Position After Ref

INSERT OVERWRITE MOVE WORD MOVE WORD PAGE PAGE BEGIN END FIND



Doosan Infracore

Machine Parameter Programming

098 TNC programming station
Parameter value ?

Machine par. programming

File: PLCTABED.TAB

Nr	Comment	Value
55	---Tool change position---	+0
56		+0
57	Position TC axis X	-930.1234
58	Position TC axis X prepositin	-650
59	Position TC axis Y	-650.1234
60	Position TC axis Y preposition	-650.1234
61	Position TC axis Z put out	+0
62	Position TC axis Z	+0
63	Position TC axis X manual	-325
64	Position TC axis Y manual	-315
65	Position TC axis Z manual	-0.1234
66	Position TC axis Z safety	-0.1234
67	Position TC axis spindle	+0
68	TC magazine offset load position	+0
69		+0
70		+0
71	---position window TC PLC posit	+0

0% -[Nm]
100% S-OVR TABLE 1 14:22

X	+0.000	Y	+0.000	Z	+500.000
*B	+0.000	*C	+0.000		

S1 0.000

ACTL. 0 T Z/S 10000 F 0 M 5 / 9

BEGIN END PAGE PAGE BEGIN LINE END LINE NEXT LIST
↑ ↓ ↑ ↓ ← → LINE FORM

55	---Tool change position---	+0
56		+0
57	Position TC axis X	-930.1234
58	Position TC axis X prepositin	-650
59	Position TC axis Y	-650.1234
60	Position TC axis Y preposition	-650.1234
61	Position TC axis Z put out	+0
62	Position TC axis Z	+0
63	Position TC axis X manual	-325
64	Position TC axis Y manual	-315
65	Position TC axis Z manual	-0.1234
66	Position TC axis Z safety	-0.1234
67	Position TC axis spindle	+0
68	TC magazine offset load position	+0

MP data TC Change