

Chapter 11

OBJECTIVE

Activate the desired program in the Auto mode of operation for machine operation.

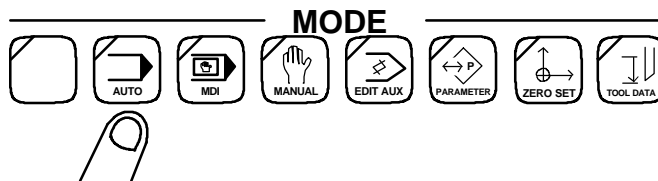
INTRODUCTION

This chapter covers how to take a program that has been entered into the bubble memory (either by IGF or manually) and make it the active program in the Auto RAM so that the machine can run this program. Commonly this is called *Program Select*.

PROGRAM SELECT

The following information will explain how to select a program to run.

1. On the Operation Panel, select the Auto mode of operation.



The AUTO OPERATION screen will be displayed.

AUTO OPERATION			N		0		
PROGRAM			UNIT 1in				
=PS							
PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA		TOOL LAYOUT	CHECK DATA	[EXTEND]
F1	F2	F3	F4	F5	F6	F7	F8

2. Select function key [F1] (PROGRAM SELECT).

In the lower left corner of the screen you will see the letters PS displayed. At this point you will need to enter the **name of the program**.

3. For this project call the program PROJECT3.MIN. Enter the characters at the keypad for this program.
4. After the program name has been entered select the WRITE key.

A modified AUTO OPERATION screen will be displayed.

AUTO OPERATION		PROJECT3.MIN		N		0	
PROGRAM				UNIT 1in			
N10 G50 S1500 N20 G0 X30 Z30 N30 G96 S800 T010101 M3 M8 M42 N40 X3.1 Z4.0 N50 G1 X-0.1 F.011 N60 Z4.1 N70 G0 X2.625 N80 G1 Z.75 F.011 N90 X3.1 N100 G0 X30 Z30 N110 G97 S1000 T020202 M3 M8 M42 N120 G0 X0 Z4.5 N130 G1 Z.75 F.011 N140 G0 Z4.5 N150 X30 Z30 M5 M9 N160 M2							
=							
PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA		TOOL LAYOUT	CHECK DATA	[EXTEND]
F1	F2	F3	F4	F5	F6	F7	F8

Notice that your program name, PROJECT3.MIN, is displayed in the upper center of the screen. If you press function key [F3] (PART PROGRAM) the actual program will be displayed.

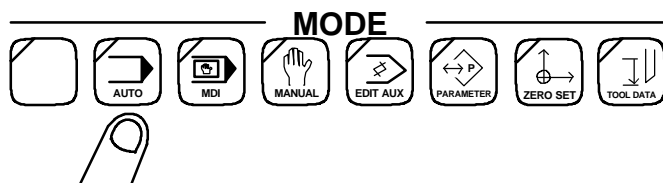
At this point you have selected a program to run in the Auto mode of operation.

PROGRAM SELECT USING MENU

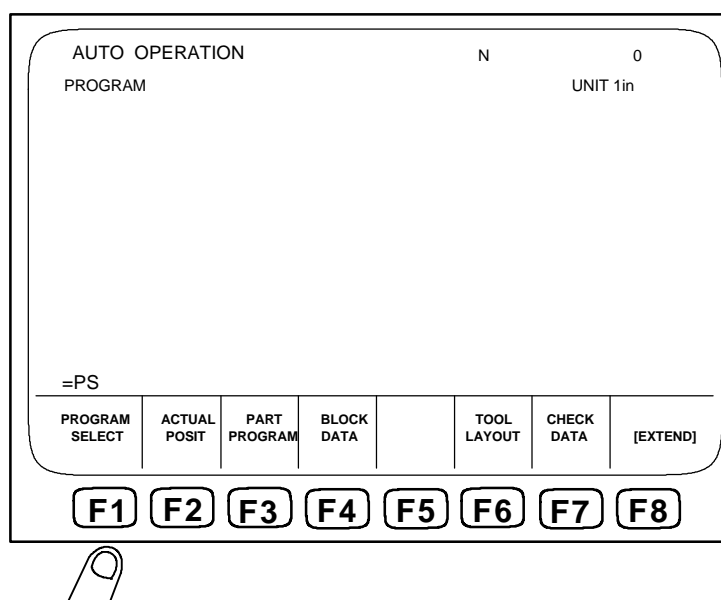
There is an alternate method for selecting a program to run for the Okuma 5000 series of control. Instead of entering a program name (such as PROJECT3) the * character can be used to represent program names.

The following information can be used to perform this procedure.

1. On the Operation Panel, select the Auto Mode of operation.



The AUTO OPERATION screen will be displayed.



2. Select the function key [F1] (PROGRAM SELECT).

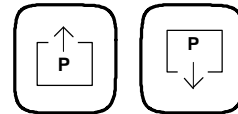
In the lower left corner of the screen you will see the letters PS displayed. This is the point where you normally entered the program name.

3. For this example enter a * at the Extended Keypad
4. Press the WRITE key.

The AUTO OPERATION (PROGRAM SELECT INDEX) will be displayed.

PROG OPERATION		EDIT	
PROGRAM SELECT INDEX		PAGE1	
MAIN PROGRAM FILE			
TEST.MIN			
A.MIN			
TEST2.MIN			
Z.MIN			
TEST3.MIN			
PROJECT3.MIN			
=PS PROJECT3.MIN			
>			
PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA
TOOL LAYOUT		CHECK DATA	
		[EXTEND]	
F1	F2	F3	F4
F5	F6	F7	F8

5. Use the cursor Arrow keys to position the cursor over the program name that you desire to select. If there are more programs stored in the bubble memory than can be displayed at one time, selecting one of the PAGE keys will show these additional listings.



6. When the cursor is properly positioned, select the WRITE key.

The AUTO OPERATION Edit Screen will be displayed.

AUTO OPERATION PROJECT3.MIN				N	0		
PROGRAM				UNIT 1in			
N10 G50 S1500 N20 G0 X30 Z30 N30 G96 S800 T010101 M3 M8 M42 N40 X3.1 Z4.0 N50 G1 X-0.1 F.011 N60 Z4.1 N70 G0 X2.625 N80 G1 Z.75 F.011 N90 X3.1 N100 G0 X30 Z30 N110 G97 S1000 T020202 M3 M8 M42 N120 G0 X0 Z4.5 N130 G1 Z.75 F.011 N140 G0 Z4.5 N150 X30 Z30 M5 M9 N160 M2							
=							
PROGRAM SELECT	ACTUAL POSIT	PART PROGRAM	BLOCK DATA		TOOL LAYOUT	CHECK DATA	[EXTEND]
F1	F2	F3	F4	F5	F6	F7	F8

Notice that your program name, PROJECT3.MIN, is displayed in the upper center of the screen. If you press function key [F3] (PART PROGRAM) the actual program will be displayed.

At this point you have selected a program to run in the Auto mode of operation.