

Special PLC functions for the parameter menu

PLC program: t400bm21v3p.src, t400bmae.src.

Parameter 170

Bit #	Value	Function
Bit 0	1	6 position Electrical turret
Bit 1	2	4 position Electrical turret
Bit 2	4	8 position Electrical turret
Bit 3	8	Gear Selection. Selection between 21xx (3 sensors) and 16xx (2sensors). Default: 21xx series lathe.

Parameter 178

Bit #	Value	Function
Bit 11	2048	Door Switch NC / NO. Default – NC

Add 2048 into the existing value in parameter 178 to change door switch state.

How to add tool turret function

Examples,

1. KL 2140 lathe with 6 position turret

Parameter 6 set 1

Parameter 170 set 1

"cnc10.tch.bak" should be renamed to "cnc10.tch" you can rename a file name by going to F7 <utility> -> F5 <file OP.> -> highlight the file you wish you change its name. -> F7 <Rename>

2. KL 1640 lathe with 4 position turret

Parameter 6 set 1

Parameter 170 set 10 (2+8)

"cnc10.tch.bak" should be renamed to "cnc10.tch" you can rename a file name by going to F7 <utility> -> F5 <file OP.> -> highlight the file you wish you change its name. -> F7 <Rename>