

SUPERIOR ELECTRIC NEDERLAND B.V.

INFORMATION STORAGE OPTIONS

for

PNC, MNC, LNC

SLO-SYN[®] NUMERICAL CONTROLS



PROGRAM STORAGE OPTION

- MEMORY STORES COMPLETE TAPE PROGRAM
- OPERATES FROM TAPE OR FROM STORED PROGRAM
- STORED PROGRAM OPERATION REDUCES CYCLE TIME BY ELIMINATING NEED FOR READING AND REWINDING TAPE
- 4K MEMORY STANDARD, TO 20K AVAILABLE
- AVAILABLE ON PNC, MNC AND LNC CONTROLS

PROGRAM MEMORY FILE OPTION

- MEMORY STORES UP TO 9 SUBROUTINES
- TAPE PROGRAM CAN CALL SUBROUTINES ANY NUMBER OF TIMES, IN ANY ORDER
- REDUCES PROGRAMMING TIME AND TAPE LENGTH
- 1K TO 4K MEMORY STANDARD, TO 20K AVAILABLE
- AVAILABLE ON PNC, MNC, LNC CONTROLS

INFORMATION STORAGE OPTIONS for PNC, MNC, LNC SLO-SYN[®] NUMERICAL CONTROLS

PROGRAM STORAGE OPTION

The Program Storage option provides the numerical control with a self-contained memory which can store an entire tape program. Once the program has been entered in the memory, it is not necessary to use the tape reader again until a new program is to be entered or the control power has been interrupted. The memory can store any program which can be programmed on tape.

When the control is operating from a stored program, tape reading and rewind time are eliminated. Tape and tape reader wear are also eliminated since the reader is not being used. The control can also be operated from the tape reader, but cannot be switched from the reader to the stored program or vice versa in the middle of a program.

The Program Storage option provides a memory capacity of 4000 characters, equivalent to 33 feet (10 meters) of tape. On special order, memories to 20K can be provided.

The right to make engineering refinements on all products is reserved. Dimensions and other details are subject to change.

ALL PRODUCTS ARE MANUFACTURED IN THE U.S.A.
BY THE SUPERIOR ELECTRIC COMPANY,
BRISTOL, CONNECTICUT.

PROGRAM MEMORY FILE OPTION

The Program Memory File option allows storage of up to 9 subroutines, canned cycles or part programs which are addressed by commands G61 through G69. During operation, the control is directed by a tape program which can call the stored subroutines as often as needed and in any order. Use of the memory file simplifies and shortens the actual job tape.

In practice, a tape containing the subroutines would be loaded into memory, using a G60 command to open the file and another G60 to close the file after loading. The job program itself could be a continuation of the same tape. When a subroutine is required, the job program would call out the correct G function command (G61-G69) and the control would act on this subroutine. The subroutines can be called any number of times and in any order. If more than 9 subroutines are required, the subroutines can be rewritten during the part program.

The length of the subroutines is not limited. Assuming typical x and y axis moves requiring an average of 12 characters per block, a 1000 character storage would accommodate more than 83 blocks of information. The Program Memory File has a basic storage capacity of 1000 characters, expandable in steps of 1000 characters up to a maximum of 4000 characters. Capacities to 20,000 characters can be supplied on special order.



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