

ABSTRACT

The present invention relates to a method of
controlling a numerically controlled machine tool having
5 a plurality of feed shafts. Also, the present invention
relates to a numerically controlled machine tool.
According to the present invention, it is possible to
solve conventional problems so as to realize highly
accurate machining even when a moving body of the machine
10 is moved at high speed. As the means for solving the
problems, an appropriate command corresponding to a
frictional force of the feed mechanism of the numerically
controlled machine tool and also corresponding to a
change in the weight of a workpiece is estimated by
15 calculation, and the thus estimated command is outputted
into the drive unit of the feed shaft motor so as to
drive the feed shaft motor.



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