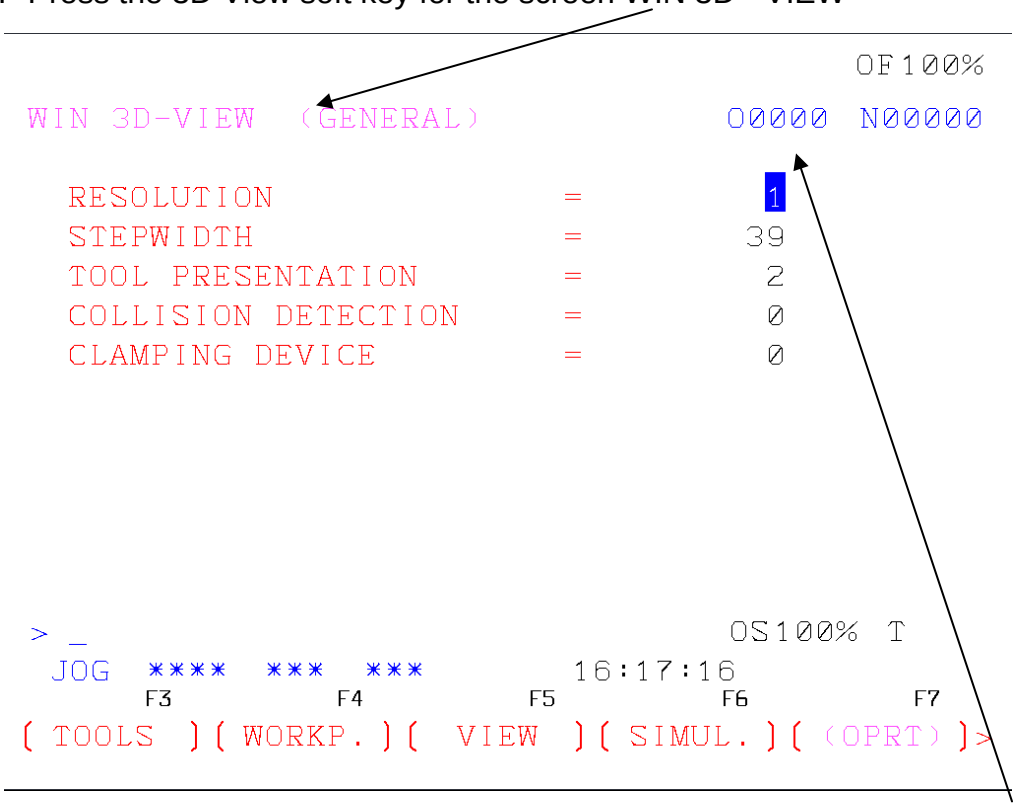
3D Simulation

1. Change the Mode Dial to MEM
2. Press Graph button on the Display Keys for the Graph screen to appear
3. Press the arrow right on the soft keys
4. Press the 3D View soft key for the screen WIN 3D - VIEW

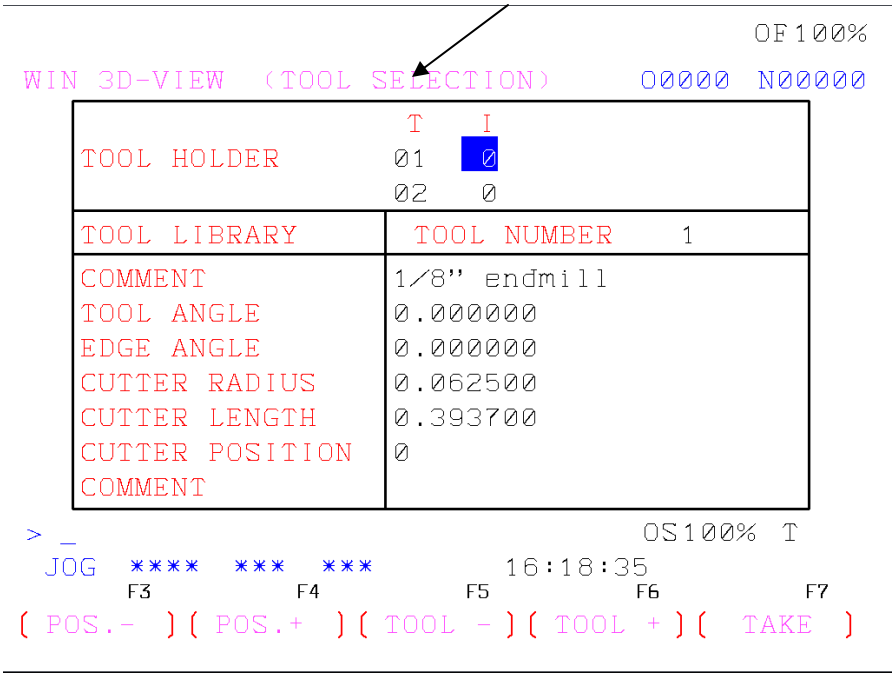


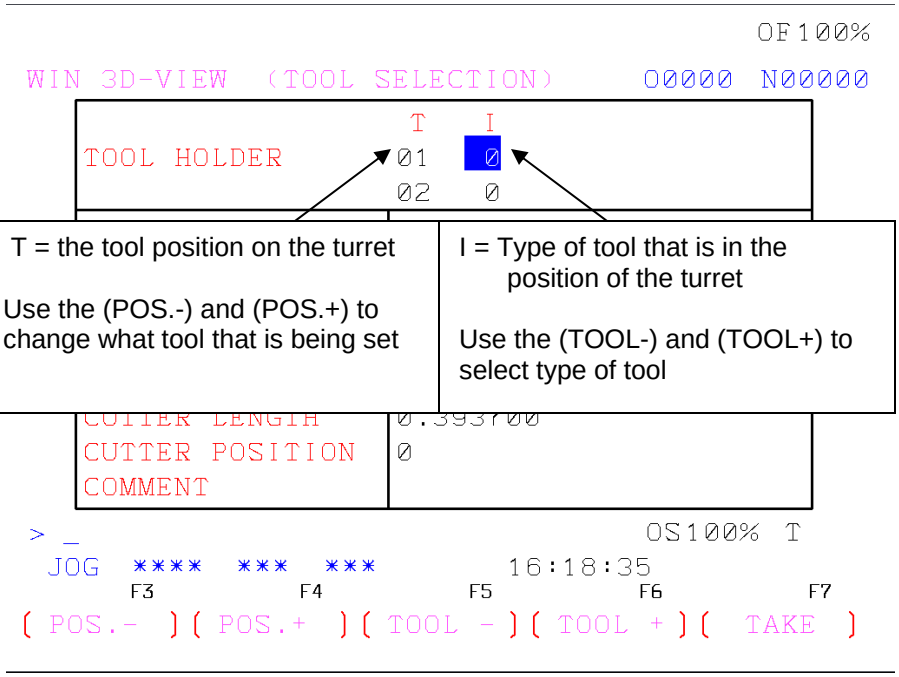
Note: This 3D graph only works with an active program and runs only the current program selected

5. Resolution = 0 means Low 1 means Medium 2 means High

   The higher the number the better appearance you will see the part
6. Step Width = The higher the number the faster the simulation will run
7. Tool Presentation = 0 means solid model 1 means transparent
   2 means wire frame 3 means no tool shown
8. Collision detection = 0 off 1 on
9. Clamping Device = 0 off 1 on

10. Press the soft key labeled TOOLS this screen will appear



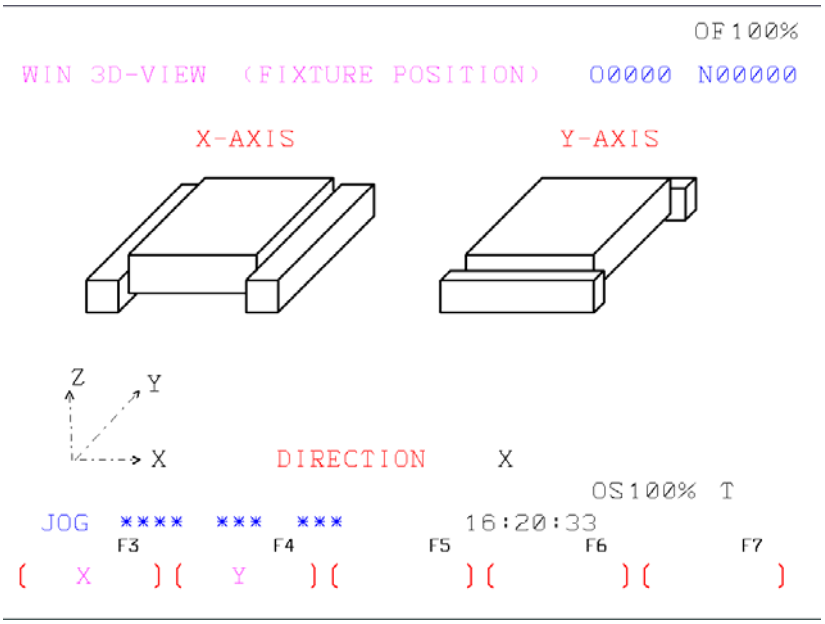


11. Press the Take soft key to place type of tool in the I place for that position

12. Press the Left arrow key on the soft keys to go back to the main page

13. Press the right arrow key on the soft keys to page over for more options

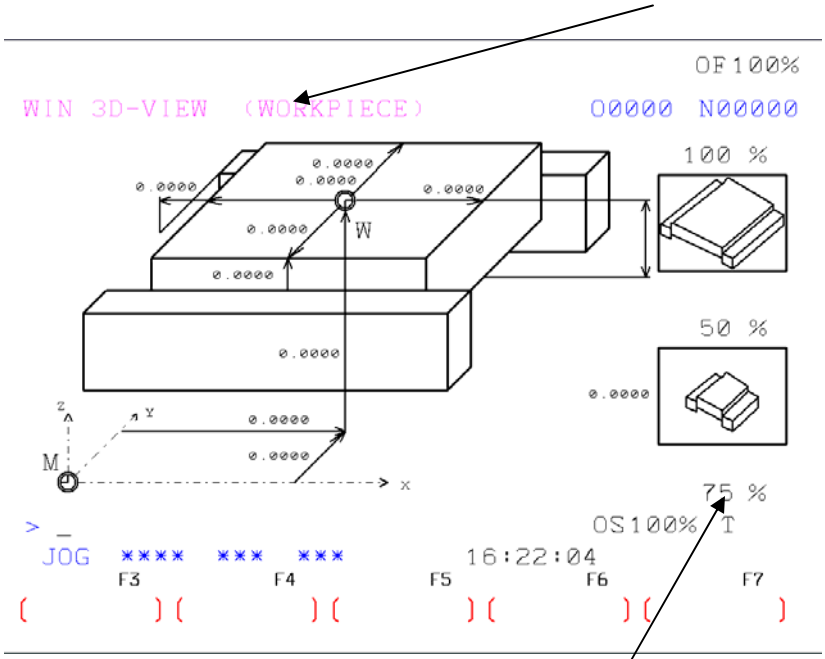
14. Press the FIXT. soft key for this screen



15. Select the way the vice has been placed on the machine. The Y direction is common for the 55 Mill

16. Press the Left arrow soft key to go back to the main page

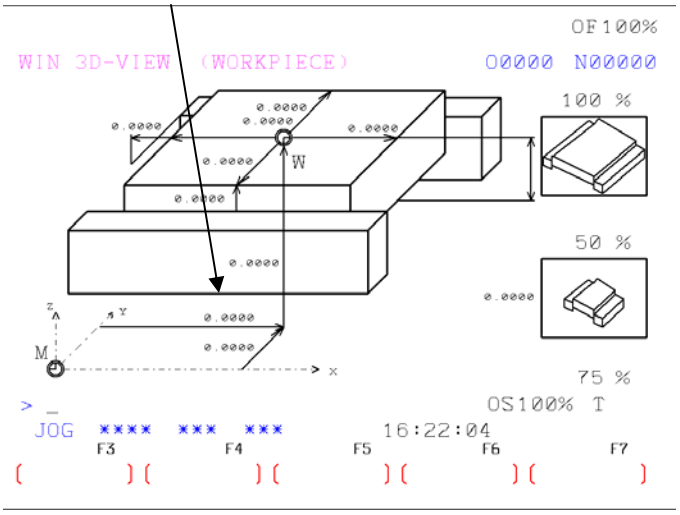
17. Press soft key for WORKP. to setup the work piece



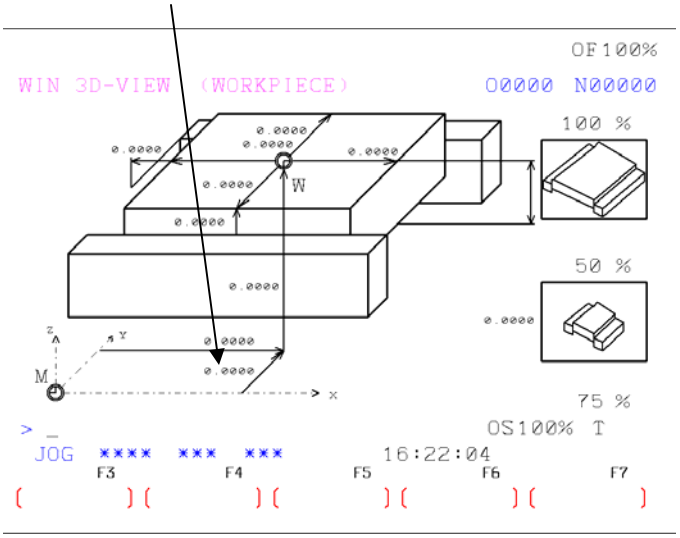
18. The cursor automatically starts at view size. This can be set to 100% down to 50%

19. Type in the viewable size then Press INPUT

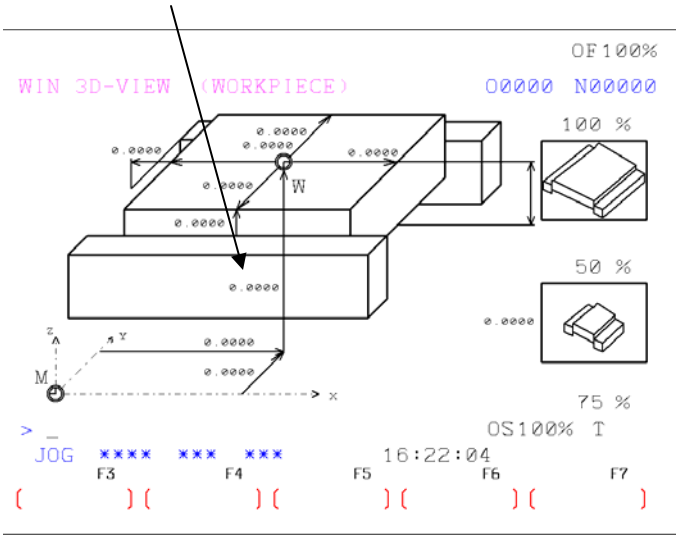
20. Type in the Work Shift for X if this is on the Machine. If not leave 0
21. Press INPUT



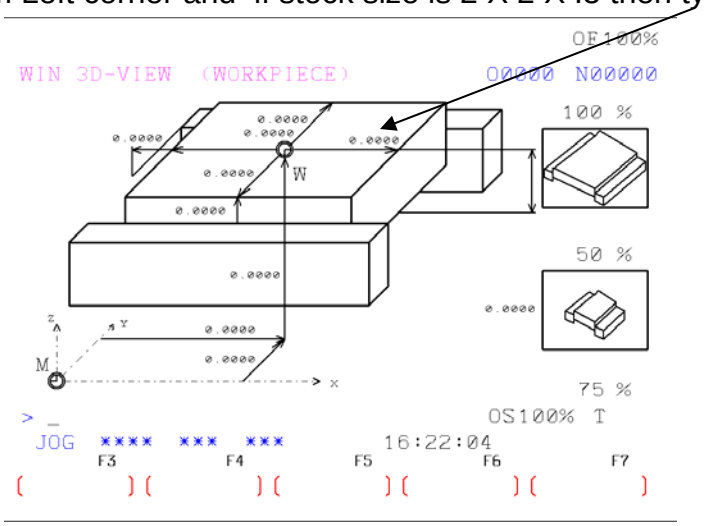
22. Type in the Work Shift for Y if this is on the Machine. If not leave 0
23. Press INPUT



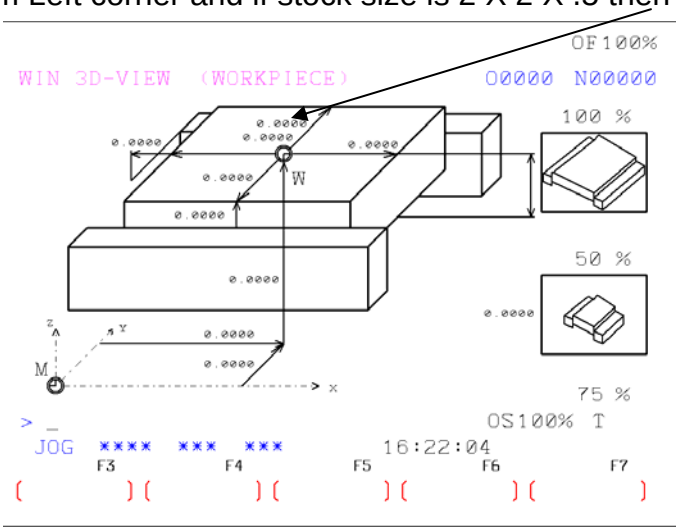
24. Type in the Work Shift for Z if this is on the Machine. If not leave 0
25. Press INPUT



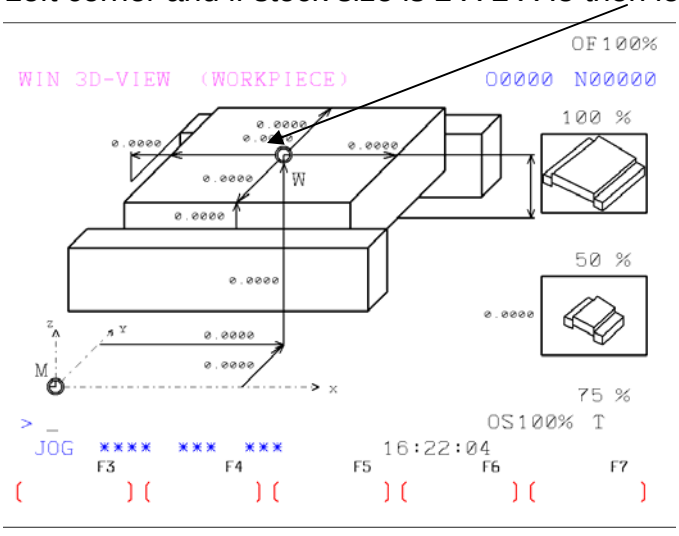
26. Type in amount of stock in the X+ direction of the Work Shift. If the Work Shift is the bottom Left corner and if stock size is 2 X 2 X .5 then type in 2.
27. Press INPUT



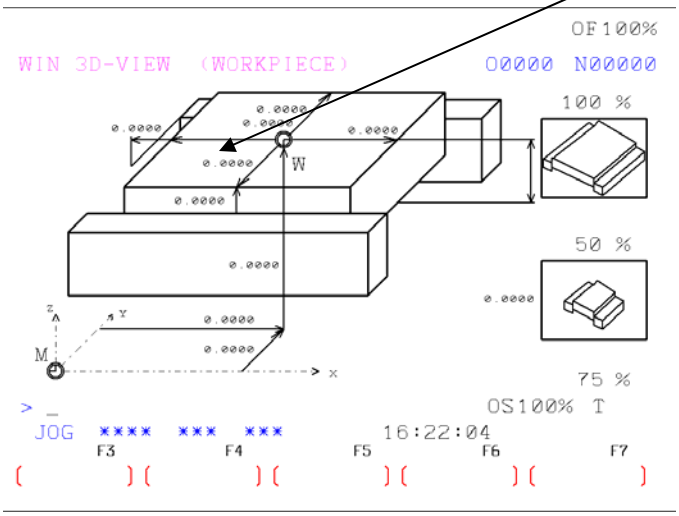
28. Type in amount of stock in the Y+ direction of the Work Shift. If the Work Shift is the bottom Left corner and if stock size is 2 X 2 X .5 then type in 2.
29. Press INPUT



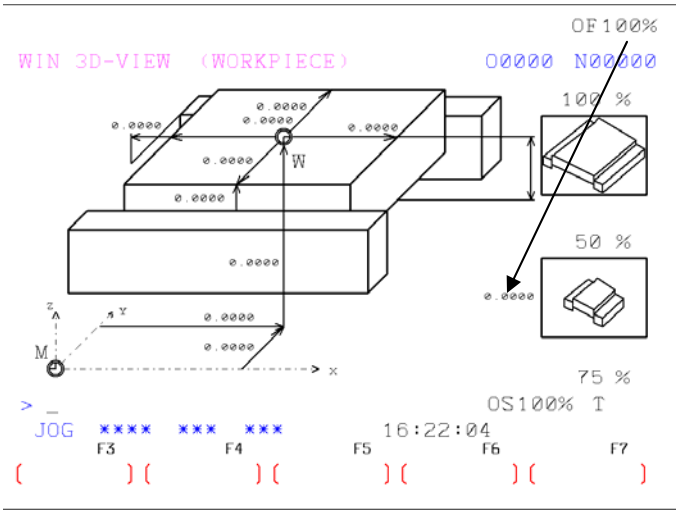
30. Type in amount of stock in the X- direction of the Work Shift. If the Work Shift is the bottom Left corner and if stock size is 2 X 2 X .5 then leave 0
31. Press INPUT



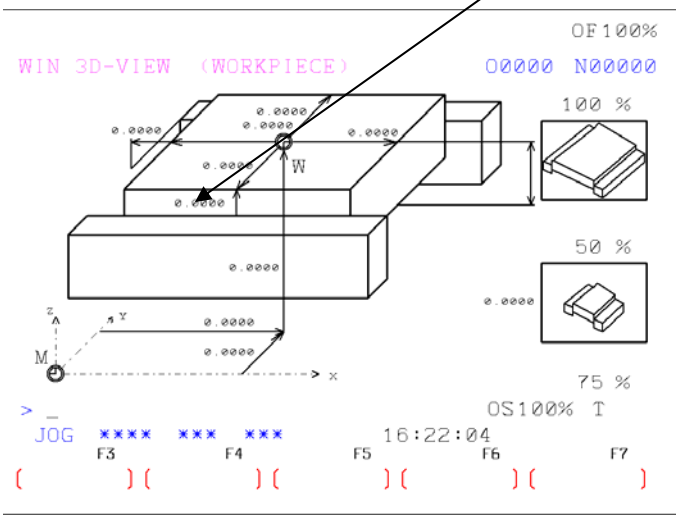
32. Type in amount of stock in the Y- direction of the Work Shift. If the Work Shift is the bottom Left corner and if stock size is 2 X 2 X .5 then leave 0
33. Press INPUT



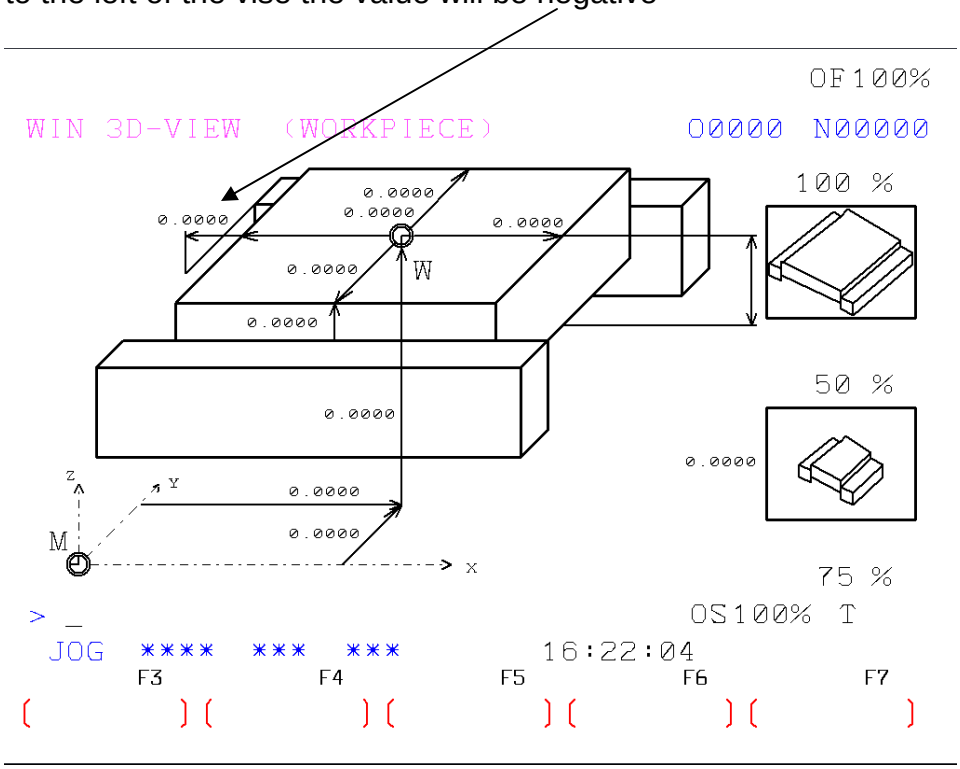
34. Type the height of Raw Stock if stock size is 2 X 2 X .5 then type in .5
35. Press INPUT



36. Type in amount of Stock from top of vise to the top of the Raw Stock
37. Press INPUT



38. Type in the amount of stock in or out of the vise. If the stock is sticking out to the left of the vise the value will be negative



39. Press INPUT

40. Press the Left arrow soft key to go back to the main page

41. Now press soft key for SIMUL. then press soft key for Start and 3D simulation will start