

EMCO MAIER PC MILL-30
QUICK START

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At C:\ Prompt Type CD\EMCO
Press Enter
Type M
At Logo Screen PC-Mill 30 Choose Programming
Press Enter
At Main Menu Press F1
Input Length, Width of Workpiece Type 2", 2"
Press Enter
Input thickness of workpiece Type 1.5"
Move Cursor to Workpiece Zero Front Left of Part
Enter
Press Hot Key Z Zoom
Press F2 Draw
Page Down to .025 Increments
Move Cursor to Y.350 X.625
Press Hot Key S For Start of Line Point
Move Cursor to Y.350 X 1.375
Press the Plus Key to draw line
Move Cursor to X 1.750 Y 1.000
Press Plus Key to Draw Line
Move Cursor to X 1.375 Y 1.650
Press Plus Key
Move Cursor to X.625 Y 1.650
Press Plus Key
Move Cursor to X.250 Y 1.000
Press Plus Key
Move Cursor to X.625 Y.350
Press Plus Key
Move Cursor to X.625 Y 1.000
Press the F4 Arc
Press F5 Circle
Press Enter to define Center Point
Type .062 Half the Diameter of the .125 Drill
Enter Draws the Circle
Move the Cursor to X 1.375 Y 1.000
Press F5
Press Enter
Press Enter No Change Draws the Circle
Press ESC
Press ESC to Main Menu
Press F3 Program
Press F7 Tool Change
Type 2 .125 End Mill
Press Enter
Press F3 Z-ABS
Type .100
Press Enter
Press F9 Parameters
Press F1 Feed Rate
Type 15.

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Press Enter
Press F2 Spindle Speed
Type 20000
Press Enter
Press ESC
Press F5 Cycles
Press F8 Drilling
Press F2 Deep Hole
Press F10 To End
Move Cursor to Center of First Hole
X.625 Y 1.000
Press Enter
Move Cursor to Center of Second Hole X 1.375 Y 1.000
Press Enter
Press the Number Key 1 To End
Press F1
Press F1
Type 0.
Press F2
Type .100
Press F3
Type .400
Enter
Press F4
Type - .400
Enter
Press F5
Type .100
Enter
Press F6
Type 0
Enter
Press F7 Feed Rate
Type 15
Press Enter
Press F8 Spindle Speed
Type 20000
Press Enter
Press F9
Type 0
Press Enter
Press F10 To End
Press Enter
First Hole is Drilled
Press F2 Automatic
Drill Cycle is complete
Press F6 Free Pocket
Press F1 Contour
Type Number of Subroutine
Press Enter
Move Cursor to Start Point
Lower Left Front of Part

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Press Enter
Press Enter until Cursor moves back to Start Point
Press Enter
Move Cursor to Part Center X 1.", Y 1."
Press Enter
Press N for NO!
Press
F2 Machining
Press F1 Left Side of Line Inside Part
Press F3 Offset
Type 0
Press F4 Depth of Single Cut
Type .200
Press Enter
Press F5 Depth of Cut
Type -.100
Press Enter
Press F6 Angle of Cut
Type 30 Degrees
Press Enter
Press F7 Cutter Stepover Use Default or type in .106
Computer calculates this
Press F8 Retract Height
Type .100
Press Enter
Press F9 Cutter Approach
Press F1
Press F10 To Execute
Part is Complete
Press ESC to Main Menu
Press F7 Archive
Press F1 Store Program
Type a Program Name or Number Exp. (Hex)
Press Enter
Press ESC
Press F4 Display
Press F5 Change Simulation
Press Enter Wait
Press F4
Press Number 1
Press S = Cut
Use Cursor Key Up or Down to Move Knife
Press Enter to Cut
Continue
Press ESC
Press F5
Press Enter
Press ESC to Main Menu
Press F6 Machining
Press F1 to Reference Machine "Wait"
Press F9 Manual
Follow Direction at Bottom of Screen

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Remember Number 1 and 9 on the Key Pad is used for the Y Movement

Move the Cutter to the Front Left Side of Blank

Use the + and - keys to change the step size as you get closer to touch off!

Press Enter

Press F2 Position

Press F1 Zero's X Axis

Type 0

Enter

Press F2 Zero's Y Axis

Type 0

Enter

Press F3 Zero's Z Axis

Type 0

Enter

Press F10 End

Ready to Machine Part

"Use Pause Key to Feed Hold Enter to Continue"

Press F3 Automatic

Press ESC

Press F3 Program

Press F6 Edit Shows Program

Press ESC To End