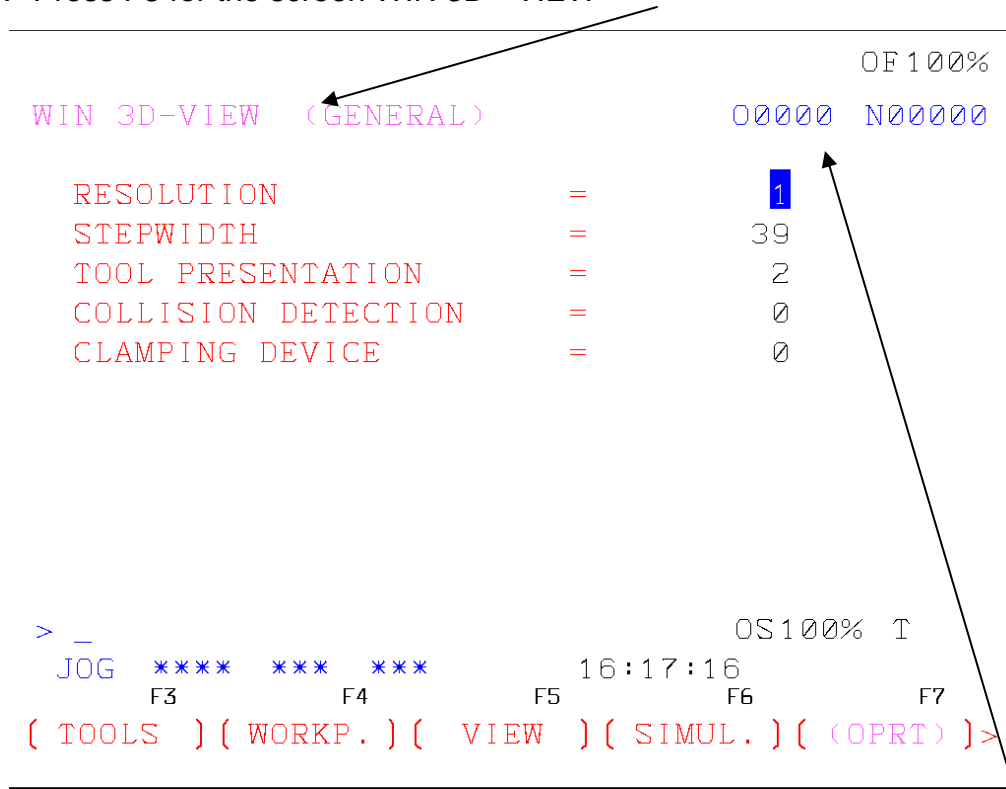


3D Simulation

1. Press F12 then F11 then F3 for the Graph screen to appear
2. Press F11
3. Press F3 for the screen WIN 3D - VIEW



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

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

9. Press F3 for TOOLS and this screen will appear

OF 100%

WIN 3D-VIEW (TOOL SELECTION) 00000 N00000

TOOL HOLDER	T 01 02	I 0
TOOL LIBRARY	TOOL NUMBER 1	
COMMENT	1/8" endmill	
TOOL ANGLE	0.000000	
EDGE ANGLE	0.000000	
CUTTER RADIUS	0.062500	
CUTTER LENGTH	0.393700	
CUTTER POSITION	0	
COMMENT		

OS100% T

> _ JOG **** ** F3 F4 F5 16:18:35 F6 F7

{ POS.- } { POS.+ } { TOOL- } { TOOL+ } { TAKE }

OF 100%

WIN 3D-VIEW (TOOL SELECTION) 00000 N00000

TOOL HOLDER	T 01 02	I 0
TOOL LIBRARY	TOOL NUMBER 1	
<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p>T = the tool position on the turret</p> <p>Use the (POS.-) and (POS.+) to change what tool that is being set</p> </div> <div style="width: 45%;"> <p>I = Type of tool that is in the position of the turret</p> <p>Use the (TOOL-) and (TOOL+) to select type of tool</p> </div> </div>		
CUTTER POSITION	0	
COMMENT		

OS100% T

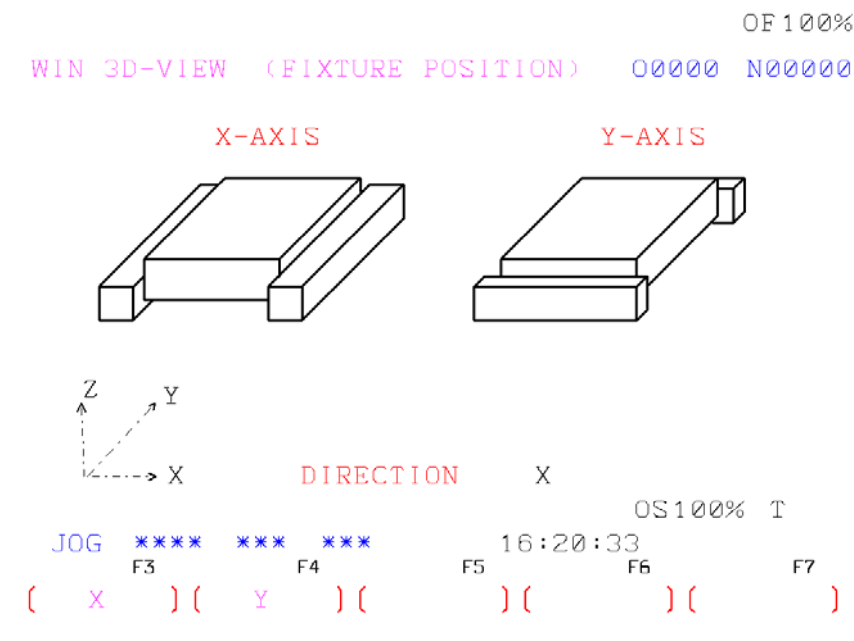
> _ JOG **** ** F3 F4 F5 16:18:35 F6 F7

{ POS.- } { POS.+ } { TOOL- } { TOOL+ } { TAKE }

10. Press F7 for Take to place type of tool in the I place for that position

11. Press F2 to go back to the main page

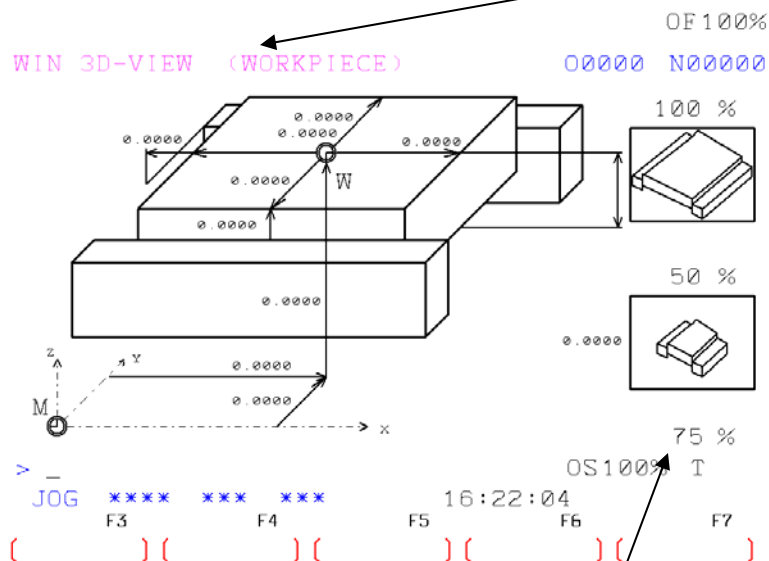
12. Press F11 then F3 for FIXT. and this screen displays



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

14. Press F2 to go back to the main page

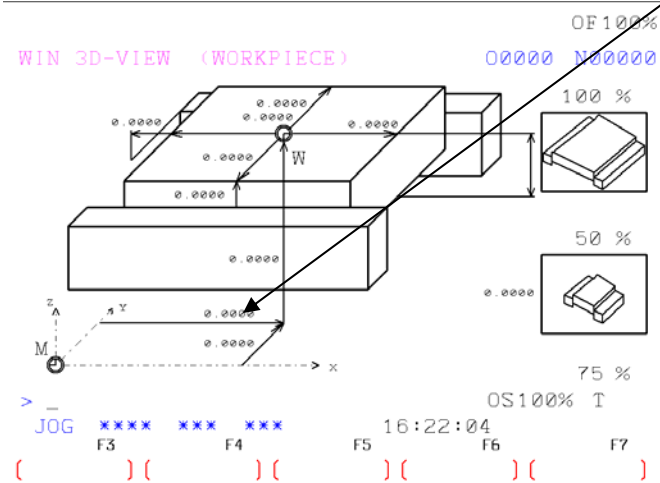
15. Press F4 for WORKP. to setup the work piece



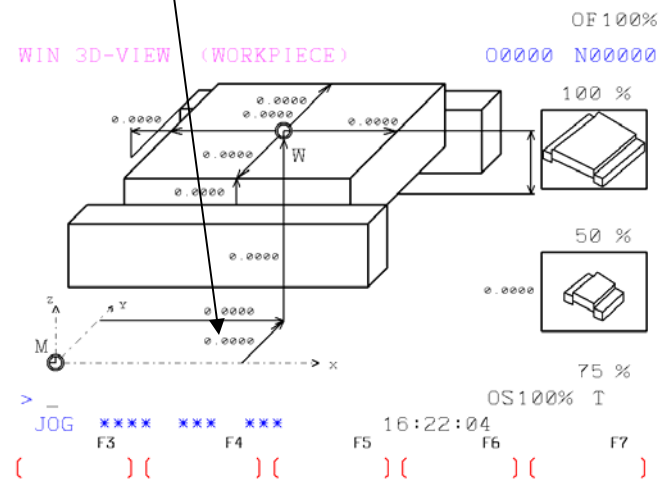
16. The cursor automatically starts at view size. This can be set to 100% down to 50%

17. Type in the viewable size then Press Enter

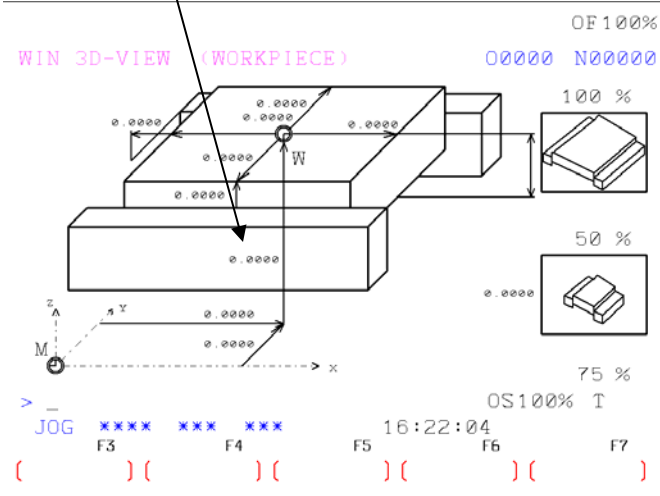
18. Type in the Work Shift for X if this is on the Machine. If not leave 0
 19. Press Enter



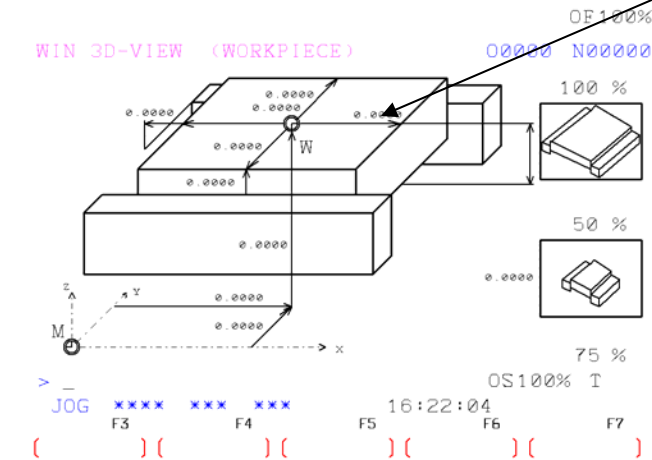
20. Type in the Work Shift for Y if this is on the Machine. If not leave 0
 21. Press Enter



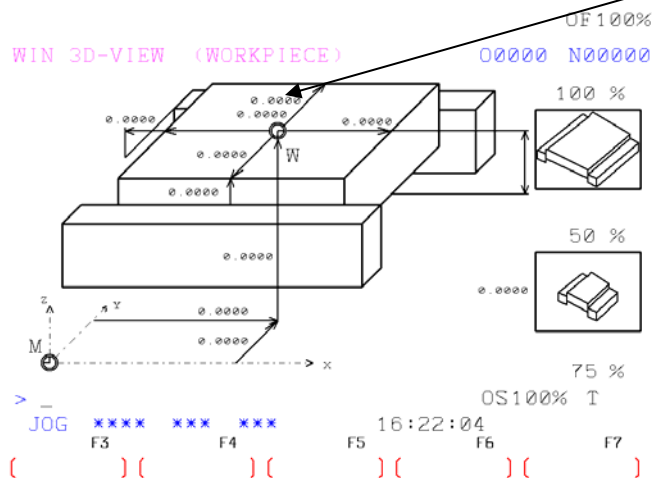
22. Type in the Work Shift for Z if this is on the Machine. If not leave 0
 23. Press Enter



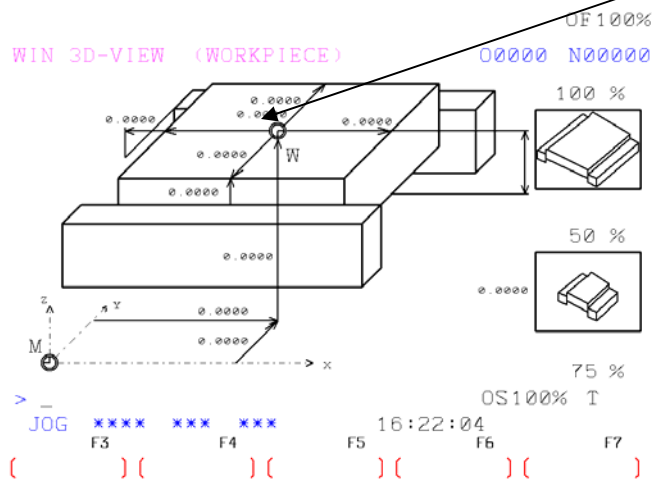
24. Type in amount of stock in the X+ direction of the Work Shift. If the Work Shift is the bottom Left corner and if stock size is 2 X 2 X .5 then type in 2.
25. Press Enter



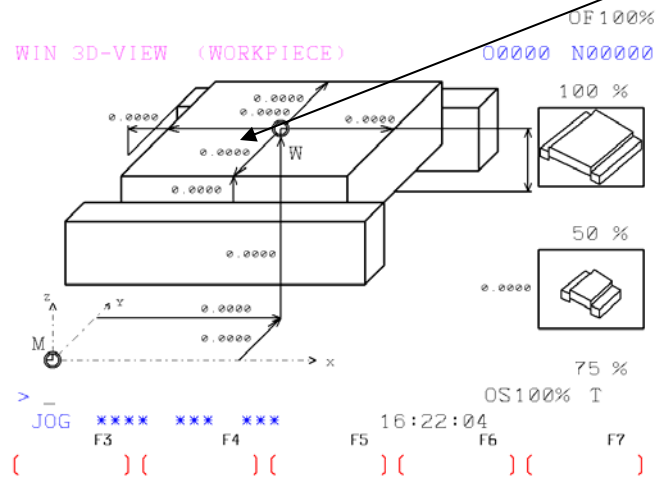
26. Type in amount of stock in the Y+ direction of the Work Shift. If the Work Shift is the bottom Left corner and if stock size is 2 X 2 X .5 then type in 2.
27. Press Enter



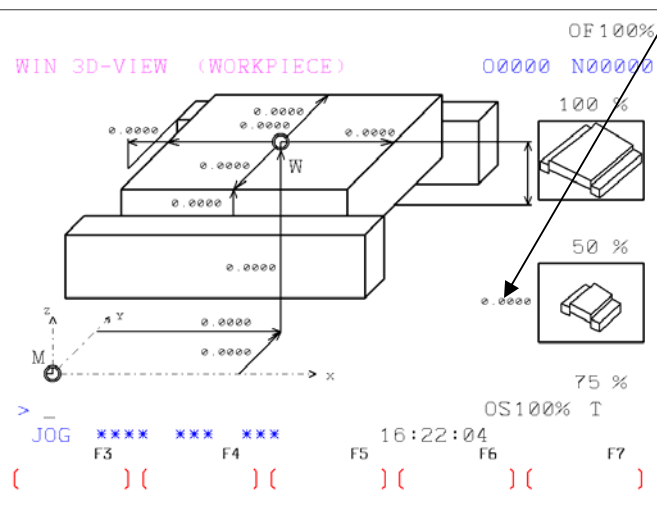
28. Type in amount of stock in the X- direction of the Work Shift. If the Work Shift is the bottom Left corner and if stock size is 2 X 2 X .5 then leave 0
29. Press Enter



30. 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
 31. Press Enter

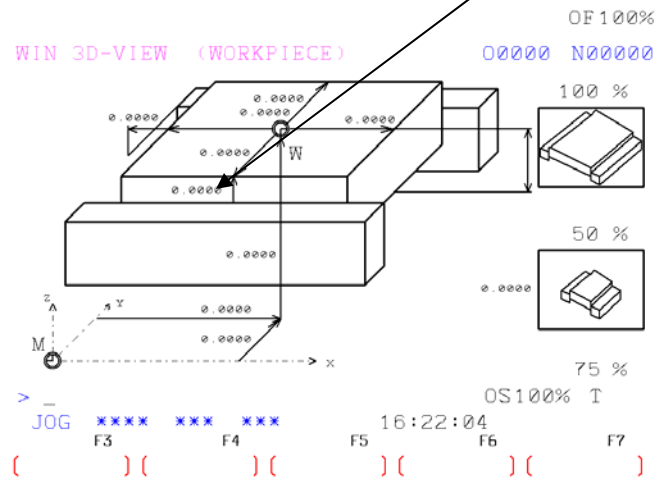


32. Height of Raw Stock if stock size is 2 X 2 X .5 then type in .5 Press Enter

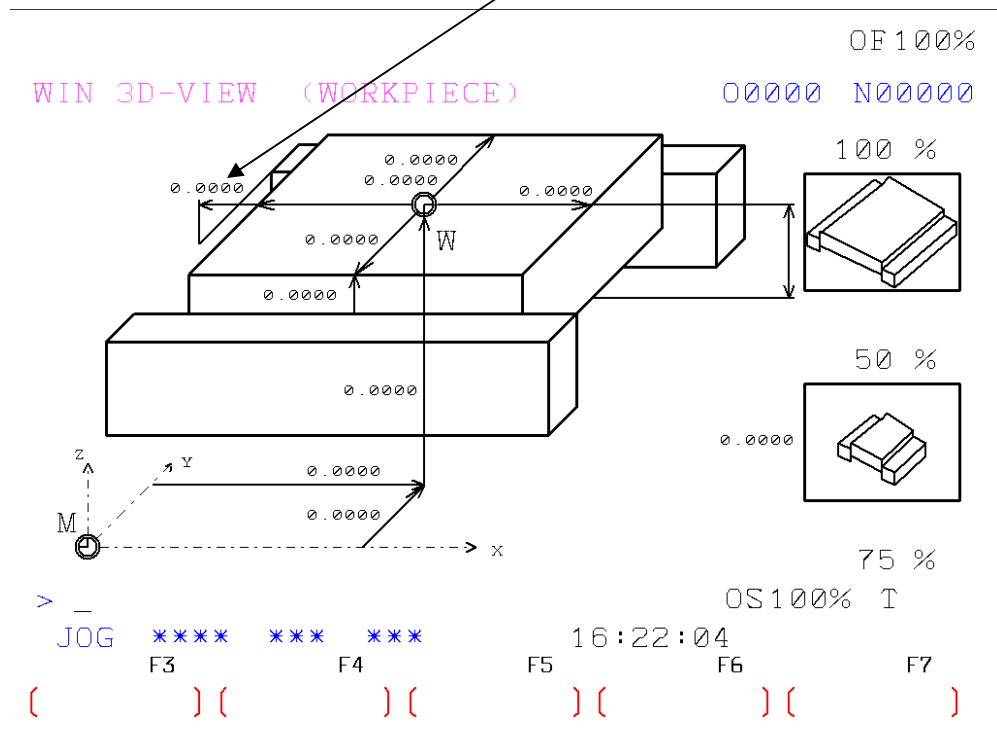


33. Type in amount of Stock from top of vise to the top of the Raw Stock

34. Press enter



35. Type in 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



36. Press Enter

37. Press F2 to go back to the main page

38. Now press F6 for SIMUL. then press F4 for start and 3D simulation will start