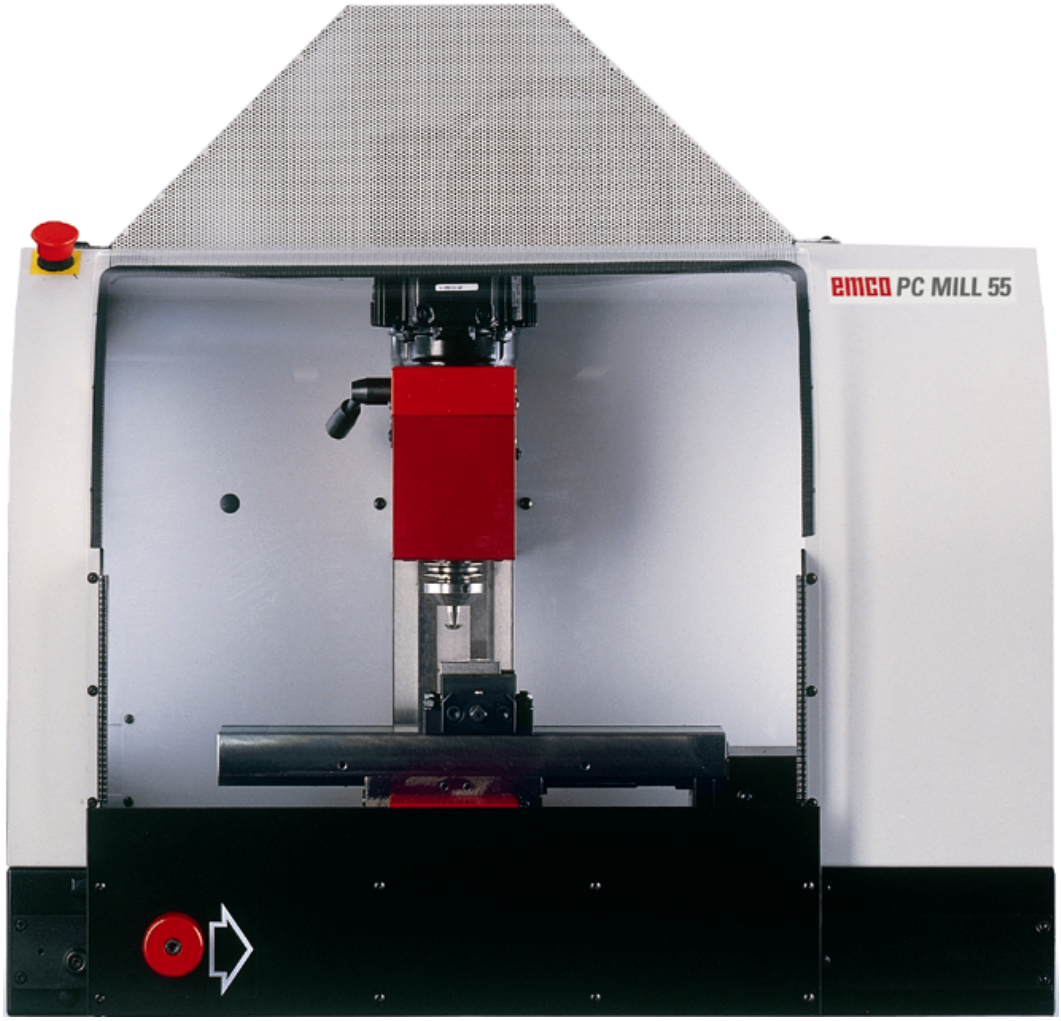
innovative machine tools

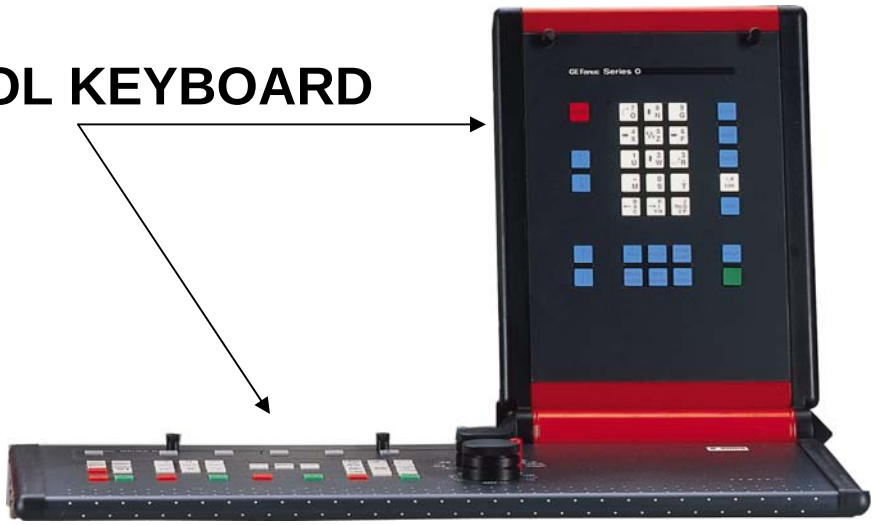


GE FANUC O
50/55 MILL
TRAINING GUIDE

7/11/08 Version 7
Made by EMCO
Authored by Chad Hawk

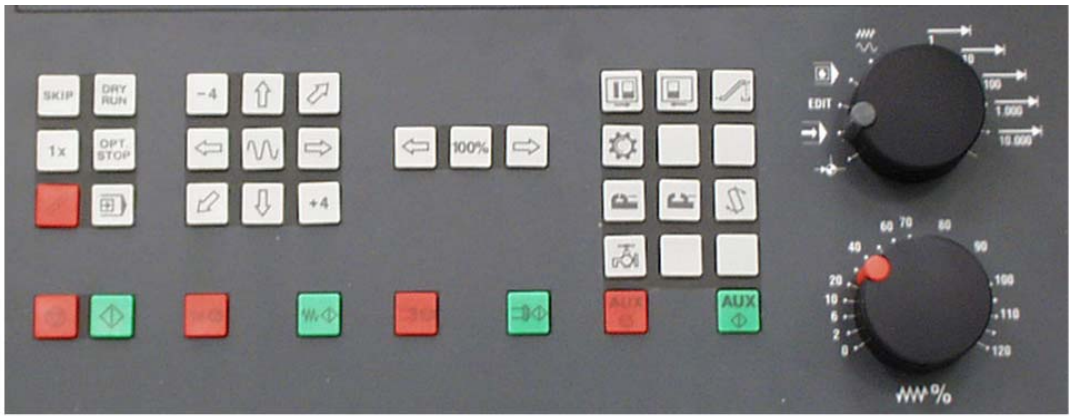
Training Index

CONTROL KEYBOARD

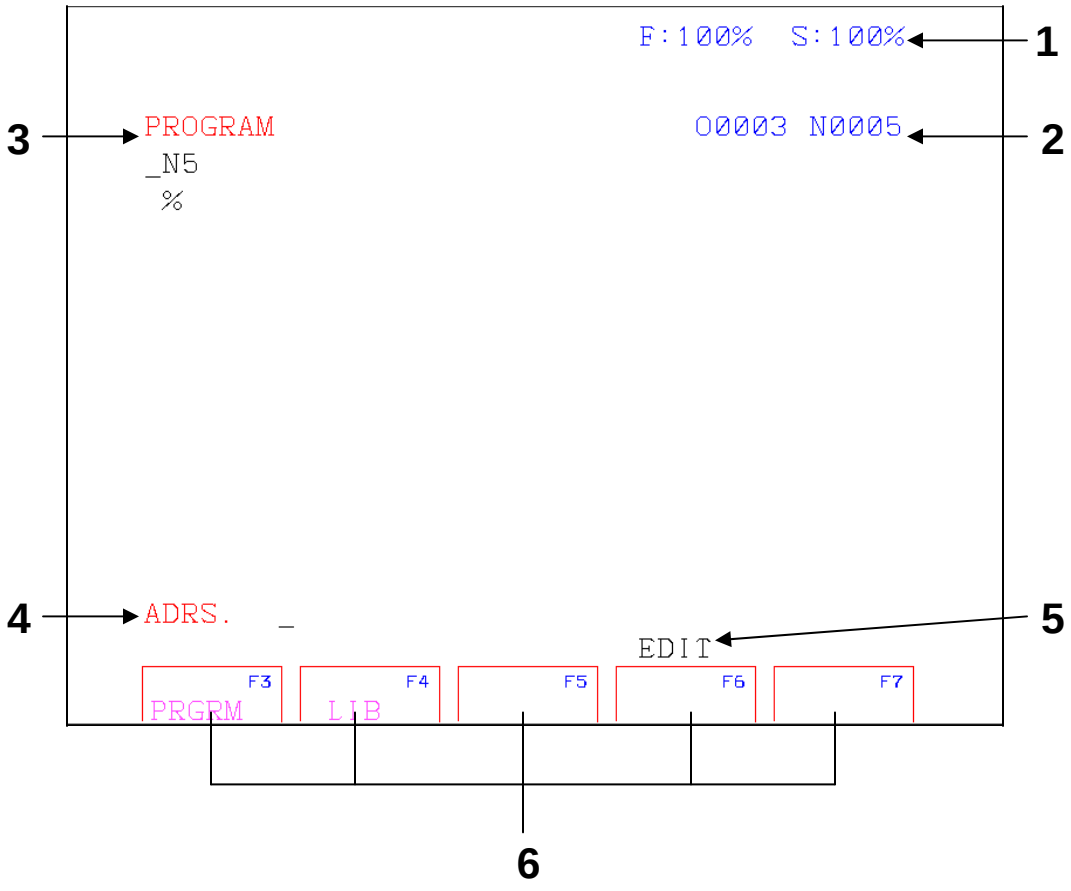


FANUC O CONTROL

MACHINE CONTROL



The Fanuc O Screen



1. **Displays of Feed and Spindle Speed override**
2. **Display of Program and Number block**
3. **Display of active Screen**
4. **Entry line**
5. **Display of active Mode**
6. **Display of Soft key Functions**

FANUC O KEYS

RESET = cancels most alarms, resets program, interrupts programs

CURSOR MOVEMENT KEYS

CURSOR UP = moves cursor up

CURSOR DOWN = moves cursor down, search function, program call up

PAGE UP = moves one page up

PAGE DOWN = moves one page down

CHANGE KEYS

ALTER = alter word (replace word)

INSRT = insert word, create new program

DELET = deletes word / block or a program

EOB = end of block, skip block

CAN = deletes entries in the address

STORE KEYS

INPUT = inputs program / offsets / word / numbers

OUTPT / START = sends program / offsets out

DATA INPUT KEYS

Continually press keys to see all possibilities of that Key.

Press one time a letter appears
Press again a number appears

FUNCTION KEYS (DISPLAY KEYS)

POS

POS = displays actual, relative, machine positions

PRGRM

PRGRM = displays program, library page

MENU OFSET

MENU / OFSET = displays Offsets, Work shifts

DGNOS PARAM

DGNOS / PARAM = displays parameters, diagnostic pages

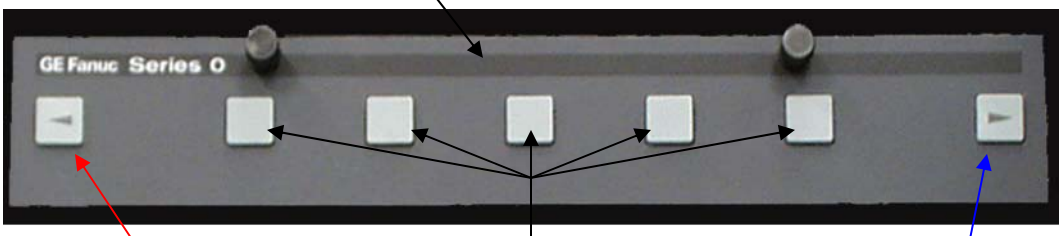
OPR ALARM

OPR / ALARM = displays operator & alarm messages

AUX GRAPH

AUX / GRAPH = displays 2–D graph

SOFT KEY MODULE



SCROLL BACK **SOFT KEYS** **PAGES OVER**

MACHINE KEYS

MACHINE FUNCTION KEYS

= Press skip for any block lines with (/) (Slash) before block number will be skipped

= Press for test run without spindle on (remove raw material from vise)

= (Single piece) for continuous mode active only on automatic material loading

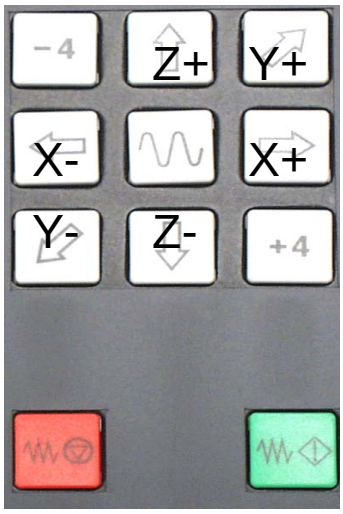
= (Optional stop) for programs with (m1)

= (Reset) cancels most alarms, resets program, interrupts programs

= (Single block) reads one block line at a time

= (Cycle stop) program hold, feed hold

= (Cycle start) program start

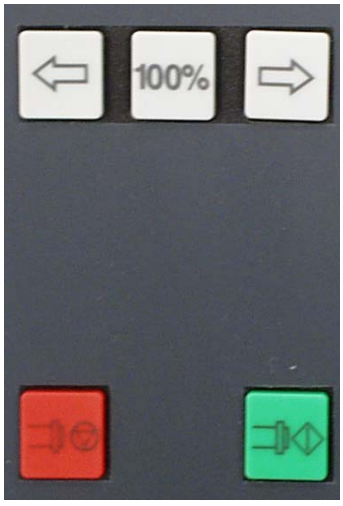


DIRECTION KEYS

These keys control axis directional movements

+4 & -4 = Additional axis

Feed stop (Red) / Feed start (Green)
Works all modes but EDIT & ZRN



SPINDLE OVERRIDE KEYS

Arrow key pointing right increase the Spindle speed (120% high)

Arrow key pointing left decrease the Spindle speed (50% low)

100% key jumps speed to 100%

Spindle stop (Red) / Spindle start (Green)
Works all modes except EDIT & ZRN

ACCESSORY FUNCTIONS

Arrow right door open
Arrow left door closed

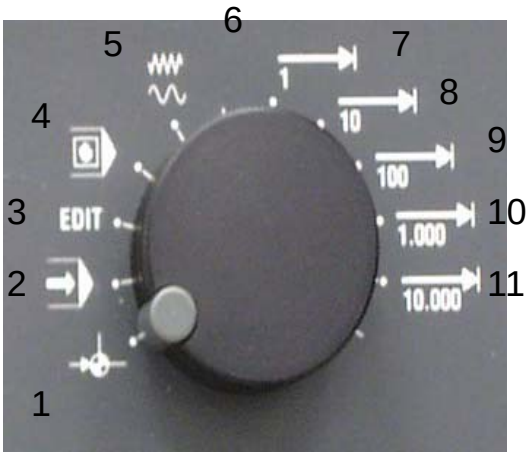
Press for Rotary axis Indexing

Press once vise closed
Press once vise open

Press once coolant on
Press again coolant off

Press auxiliary drives on (Green)
Press auxiliary drives off (Red)

MODE DIAL



(1) ZRN = Zero / Reference or Home mode

(2) AUTO = Automatic mode for running a program

(3) EDIT = Edit mode for program changes or entering a new program

(4) MDI = Manual Data Input mode for manually running the machine

(5) JOG = Manual moving the axis in X, Y, Z

(6) STEPS = Incremental feed movements

(7) STEPS = .0001 or tenths

(8) STEPS = .001 or thousands

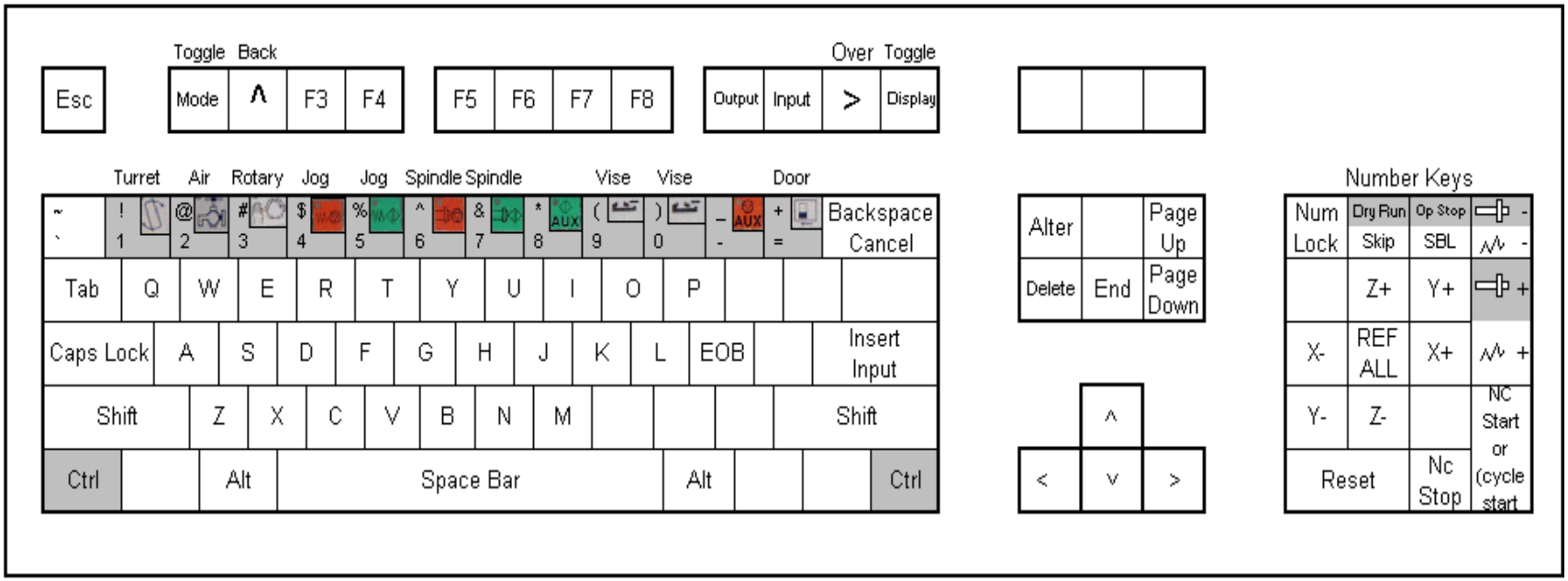
(9) STEPS = .010 or ten thousands

(10) STEPS = .100 or hundred thousands

(11) STEPS = .100 or hundred thousands

FEED OVERRIDE DIAL

Controls feed for jogging in the X, Y, Z Axis. Overrides from 0% to 120% of the programmed feed rate or the rapid rate



1. Any key with Gray highlight Press Ctrl + the key for that function
2. Some keys have two functions to them for 1st function just press the key
3. 2nd function will be Grey press Ctrl + the key for the function
4. Some automative keys when you press them 1 time this will close/turn off press them again will open/turn on
5. F1 is a toggle key for the modes: Zero, Auto, Edit, MDI, Jog and F1 then F11 give Increment Step
6. F12 is a toggle key for the Display screens: Position, Program, Offsets, Parameter, Alarm and F12 then F11 then F3 gives Graph
7. F12 then F11 then F3 then F11 then F3 gives you 3D view
8. Press enter 2 times this is the same as pressing EOB insert
9. Alt + F4 will exit the software back to the desktop
10. The Top right corner will allow the screen to be minimized, restored and close just like a standard windows screen

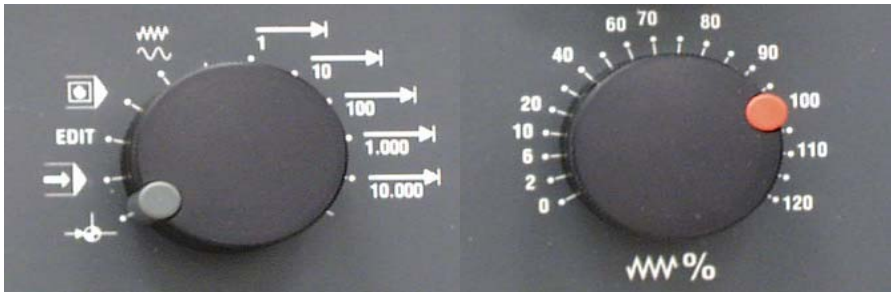
The machine functions are active only with NUM LOCK on

Keys are active they will move the axes if used as numbers. Use numbers on the keyboard.

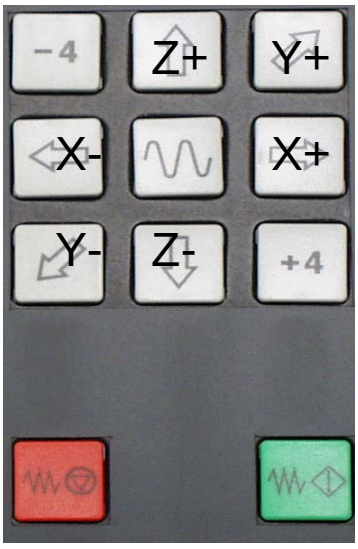
Turning the Machine On/Entering Fanuc Software

Referencing the Machine

1. Move the MODE dial to ZRN position also know as Reference make sure your feed rate is not on "**0**"



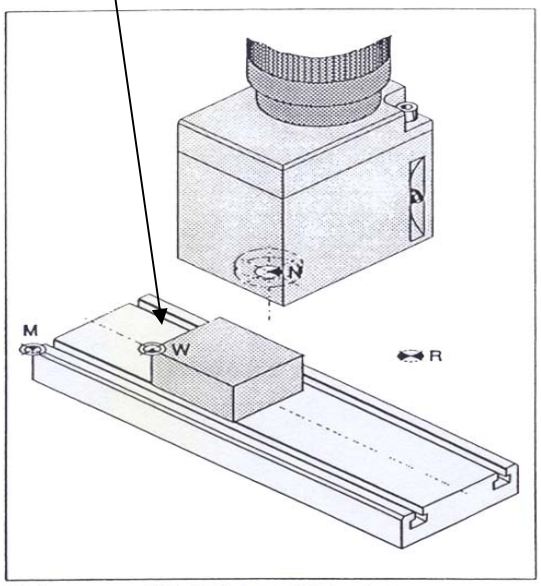
2. Make sure the Door is closed
3. Press the Z+ (arrow pointing up) this references the Z axis. (Wait until Z is fully reference)
4. Press the X- (arrow pointing left) this references the X axis
5. Press the Y- (arrow pointing left) this references the Y axis



Note: Every time you enter Fanuc O Software or Turn the Machine On you must reference the axis

WORK SHIFT

Pages 10 – 18 is setting the Work shift & offsets to the lower left corner & the top of the part with the Spindle nose



Reference points in the working area

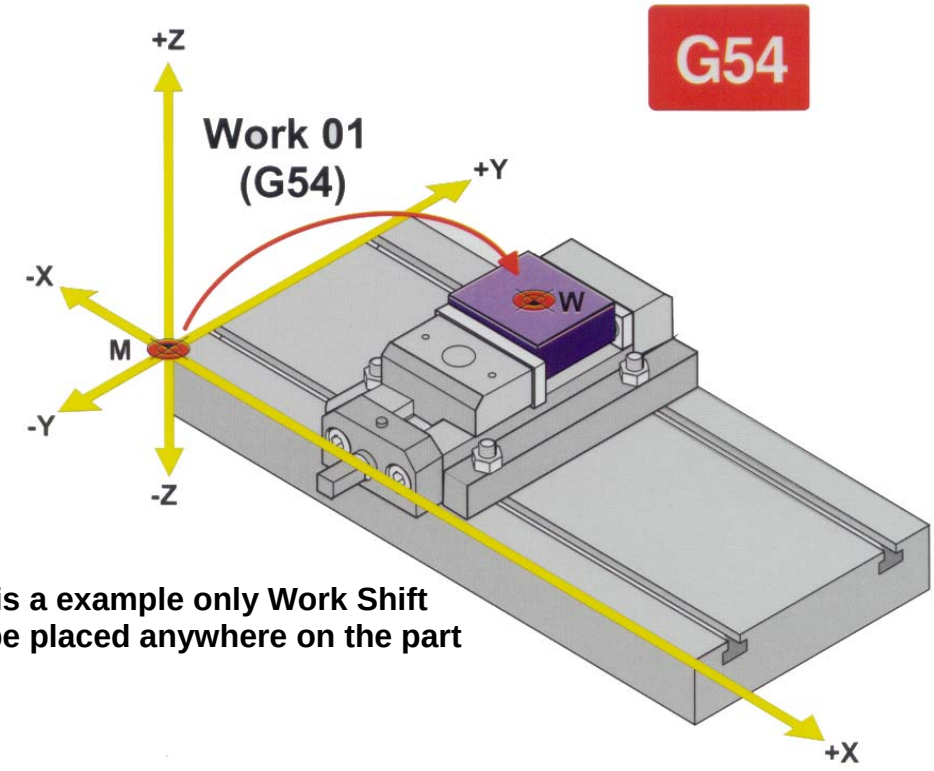
Reference Points of the EMCO Milling Machines

M = Machine zero point
An unchangeable reference point established by the machine manufacturer.
Proceeding from this point the entire machine is measured.
At the same time "M" is the origin of the coordinate system.

R = Reference point
A position in the machine working area which is determined exactly by limit switches. The slide positions are reported to the control by the slides approaching the "R".
Required after every power failure.

N = Tool mount reference point
Starting point for the measurement of the tools. "N" lies at a suitable point on the tool holder system and is established by the machine manufacturer.

W = Workpiece zero point
Starting point for the dimensions in the part program. Can be freely established by the programmer and moved as desired within the part program.



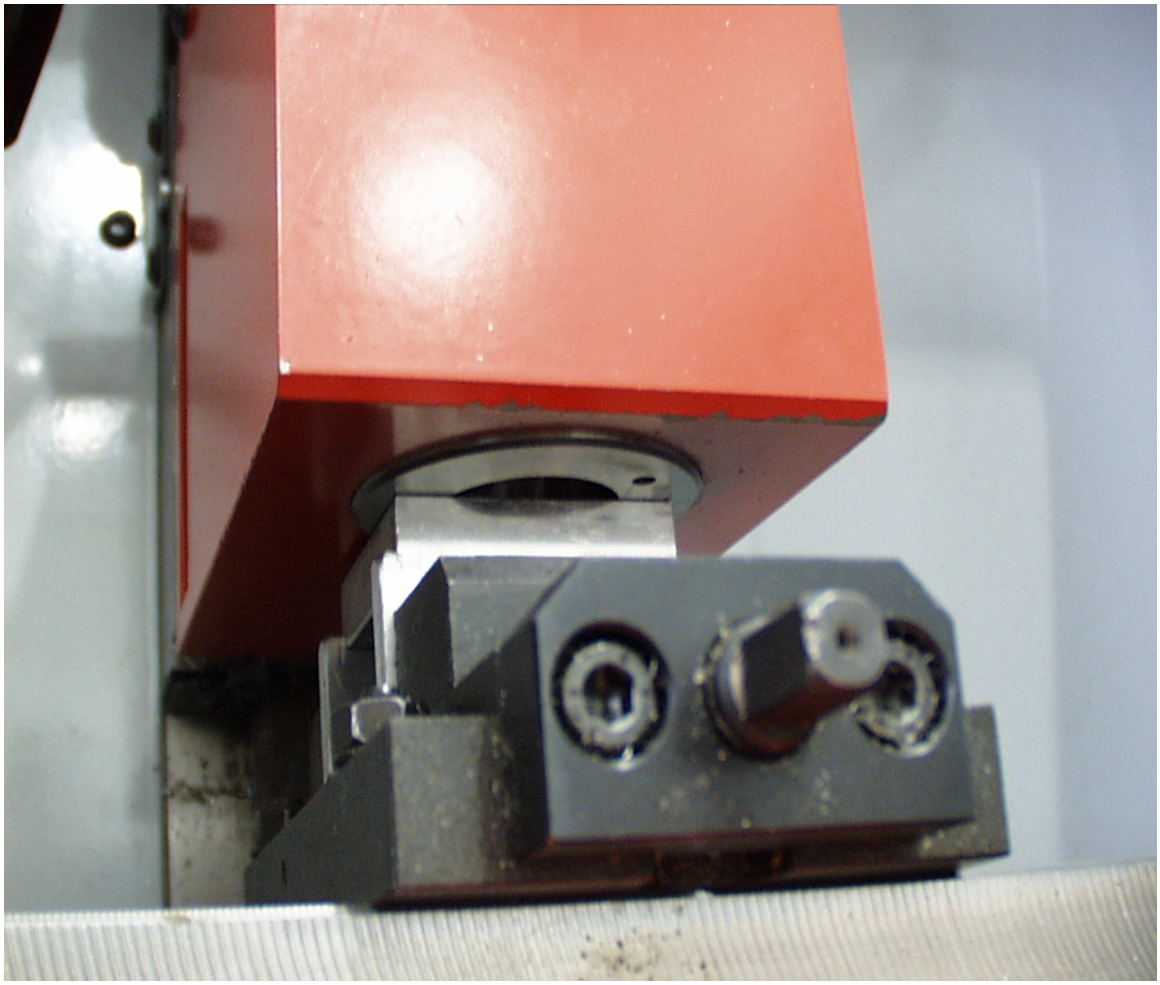
This is a example only Work Shift can be placed anywhere on the part

Work Shift:

1. Move the MODE dial to JOG position
2. Jog the Spindle nose to the top of the Work Piece & touch using the Direction keys.

Note: Use Feed Dial or Steps to approach at a slower feed rate.

Use piece of paper between nose and Work Piece



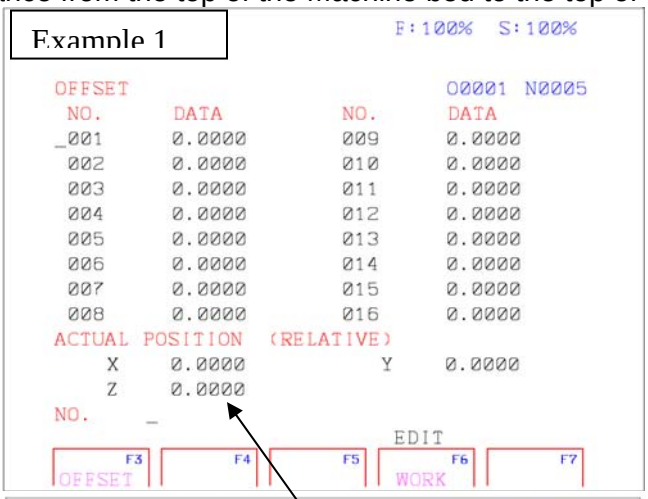
3. Press the MENU/OFSET button 

4. Press the WORK Soft key (Gray Button) Example 2
5. Make sure that X, Y, Z are all 0 if they have values then the Work Shift will be taken from those values not from the machine 0
6. Press the OFFSET Soft key (Gray Button)
    - Example 1 in the picture below
    - Record the value in the Actual Position Relative Z
7. Press the WORK Soft key (Gray Button) Example 2
8. Move Cursor to 01 location
9. Recorded value type in Work Coordinates 01(Z) which is G54

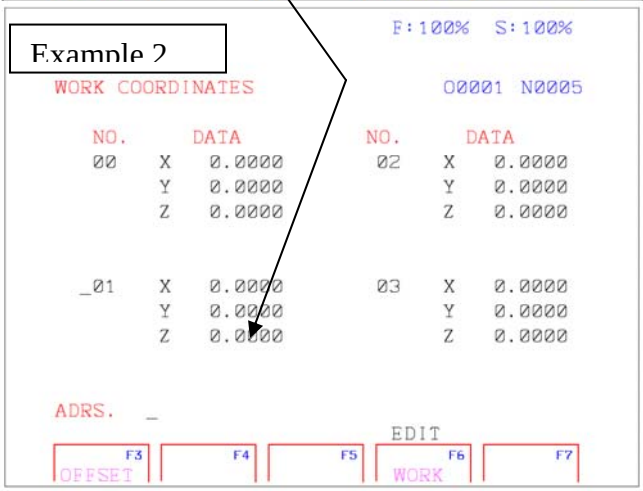
    Example: Type Z 2.463 press Input button 

This value is the distance from the top of the Machine bed to the top of the Work Piece.

Example 1



Example 2

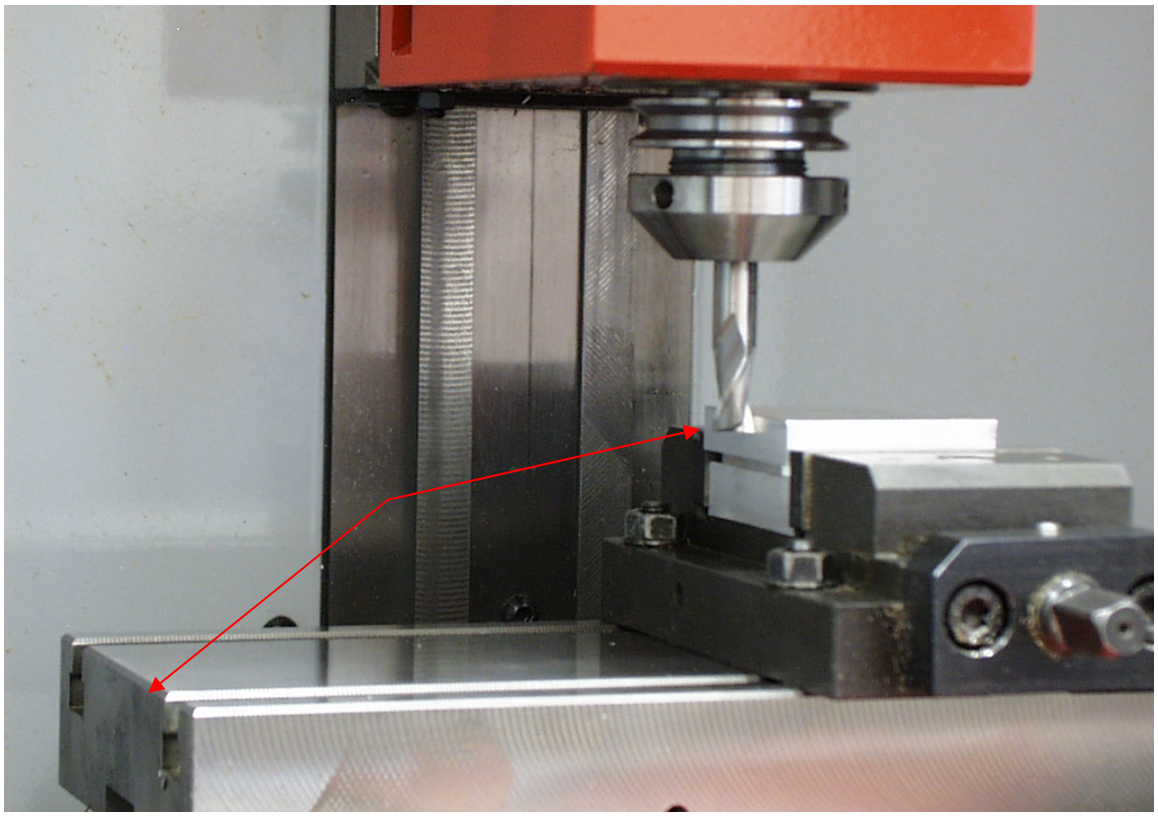


Note: Machine 0 is the spindle nose touching the top of the Machine bed.

10. Jog Spindle up away from WORK PIECE using Z+
11. Place a edge finder or tool in the Spindle (Example uses 3/8 end mill)
12. Either follow step 13 or follow step 14 when finished go on to step 15
13. Jog the Tool to the left side of the Work Piece & touch using the Direction keys. (Use Feed Dial or Steps to approach at a slower feed)
14. For Scratching move MODE Dial to MDI

- Press the PROGRAM display button PRGRM until top of the screen shows MDI (Program)
- Type S1000 INPUT M03 INPUT

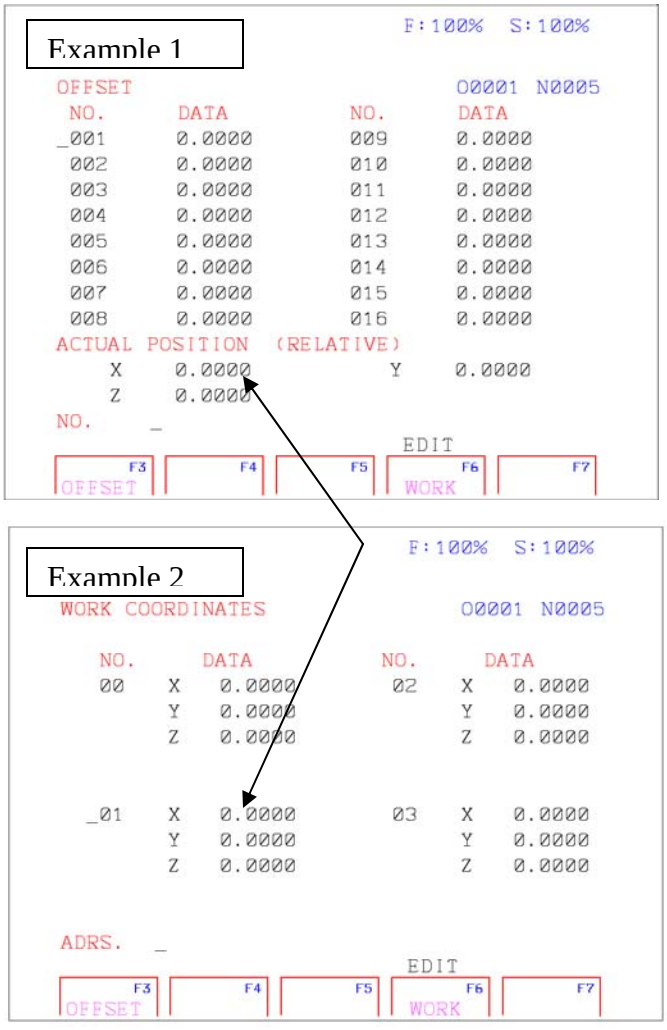
  S = RPM M03 = Spindle on Clockwise
- Then press CYCLE START **(Door must be closed)**
- Move MODE Dial to Jog then Jog the Tool to the left side of the Work Piece & touch using the Direction keys.



Note: Machine 0 in X is the center of the spindle to the left side of the Machine bed.

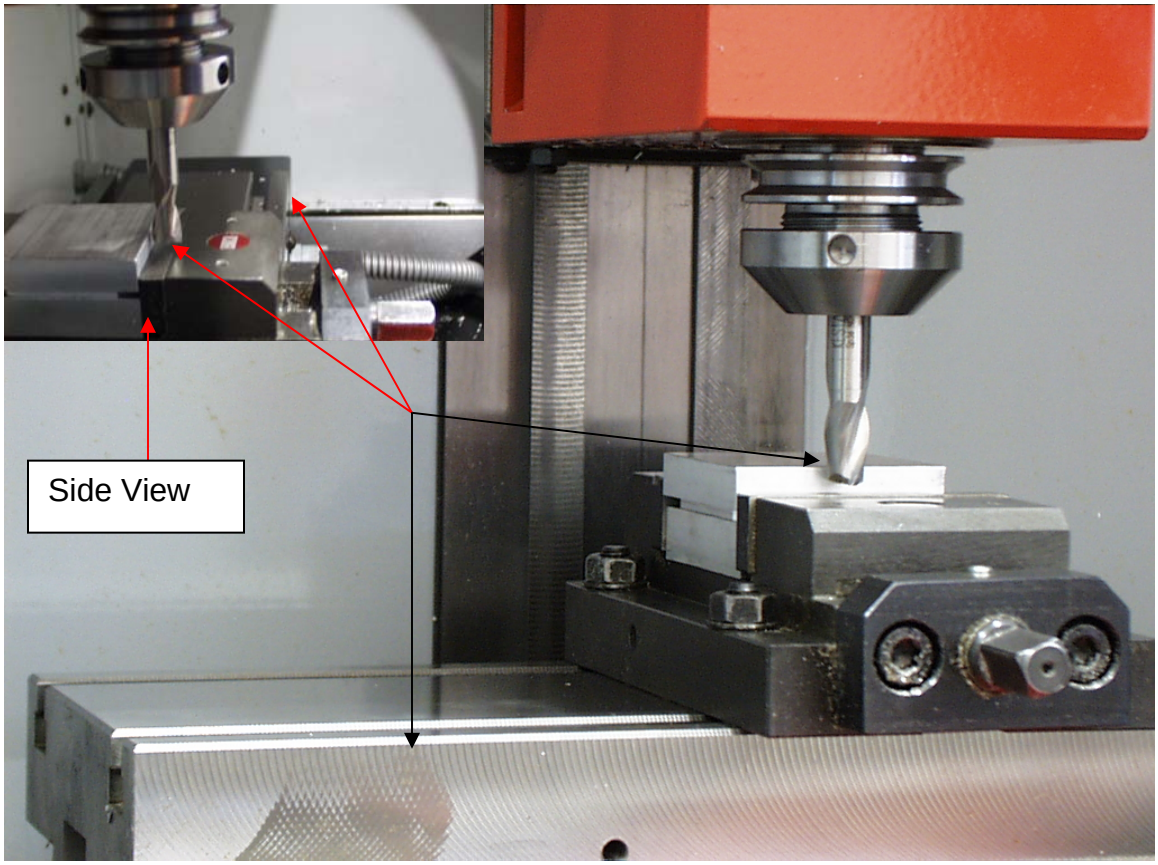
15. Press the MENU/OFSET button 

    - Example 1 in the picture below
    - Record the value in the Actual Position Relative X
16. Press the WORK Soft key (Gray Button) Example 2
17. Move Cursor to 01 location
18. The Recorded value PLUS the radius of the tool being used to scratch (3/8 Tool) type in Work Coordinates 01 (X)



19. Jog Spindle up away from WORK PIECE using Z+
20. Jog the Tool to the Front of the Work Piece & touch using the Direction keys.

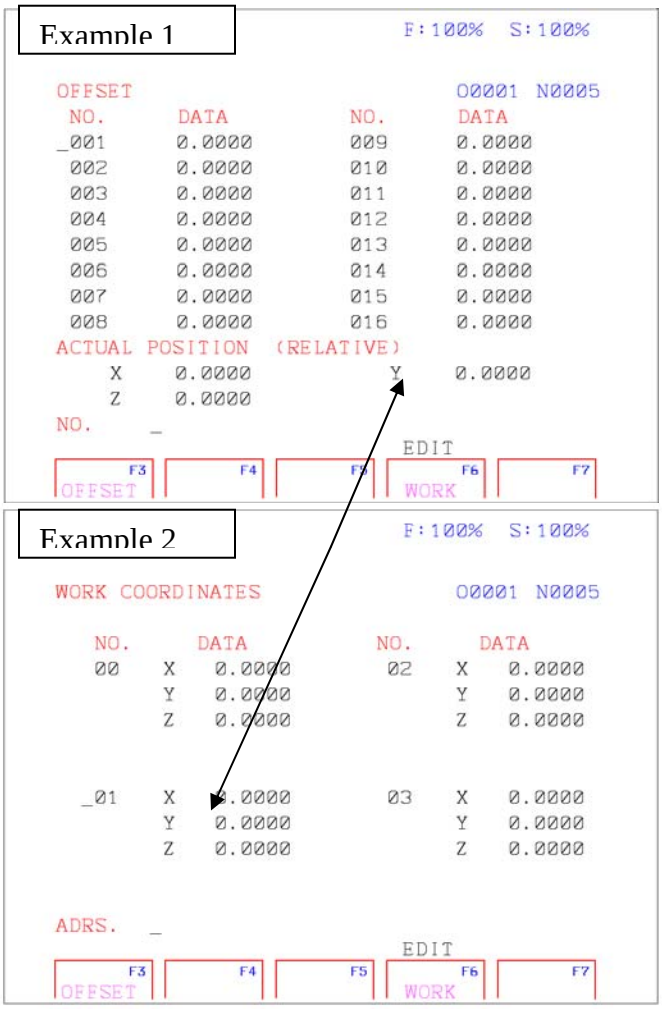
(Use Feed Dial or Steps to approach at a slower feed)



Note: Machine 0 in Y is the center of the spindle to the Front of the Machine bed.

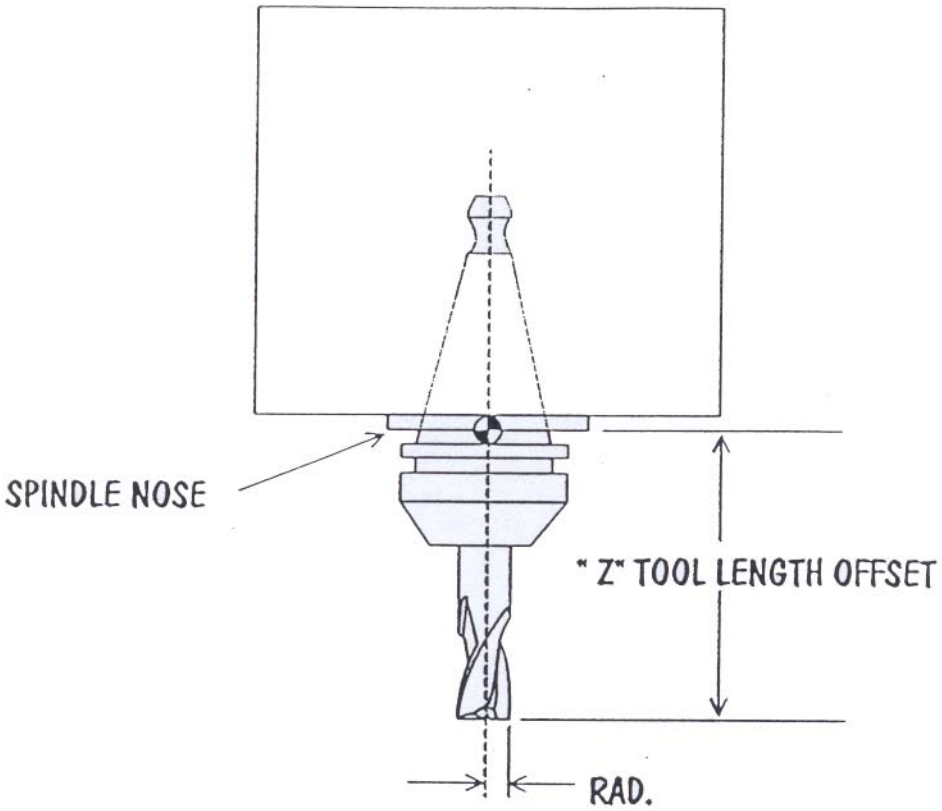
21. Press the MENU/OFSET button 

    - Example 1 in the picture below
    - Record the value in the Actual Position Relative Y
22. Press the WORK Soft key (Gray Button) Example 2
23. Move Cursor to 01 location
24. The Recorded value plus the radius of the tool being used to scratch (3/8) type in Work Coordinates 01 (Y)



25. Jog the Tool up above the Work Piece using Z+

TOOL OFFSET



F:100% S:100%

OFFSET O0001 N0005

NO.	DATA	NO.	DATA
_001	0.0000	009	0.0000
002	0.0000	010	0.0000
003	0.0000	011	0.0000
004	0.0000	012	0.0000
005	0.0000	013	0.0000
006	0.0000	014	0.0000
007	0.0000	015	0.0000
008	0.0000	016	0.0000

ACTUAL POSITION (RELATIVE)

X 0.0000 Y 0.0000

Z 0.0000

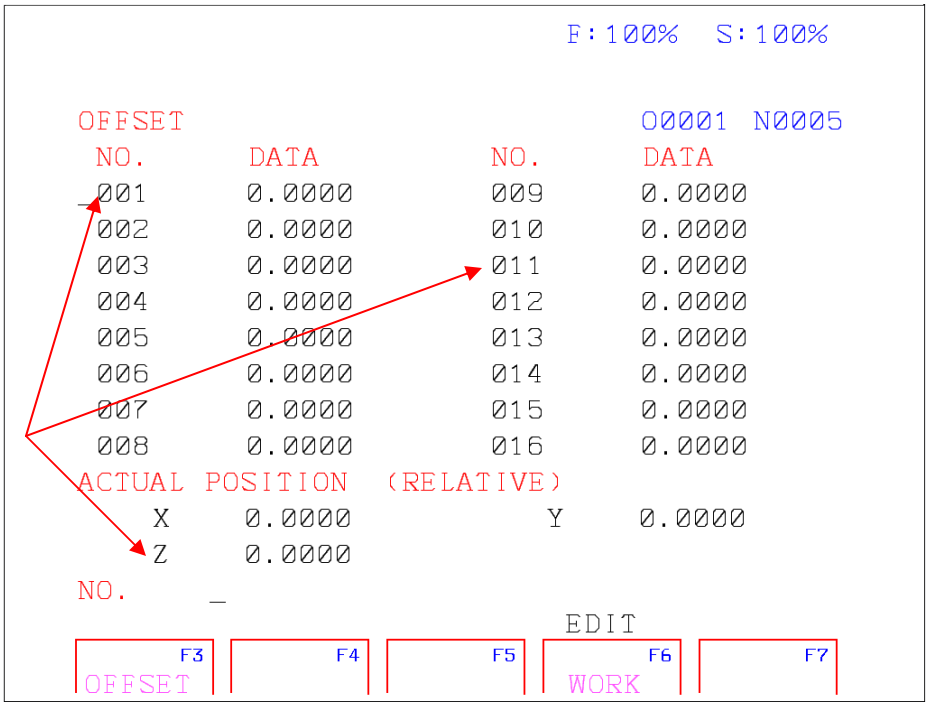
NO. _

EDIT

F3 OFFSET | F4 | F5 | F6 WORK | F7

1. Jog Tool tip down & touch the Top of the Work Piece
   (Use Feed Dial or Steps to approach at a slower feed)
2. Press the MENU/OFSET button 

3. The value in Actual Position (Relative) Z type this value in Offset NO. 001(H1) If tool is going to be T1
4. Place the Radius in the corresponding Offset 011 (H11)
   - This is for the cutter compensation when using G41 or G42
5. To set more Tools Repeat Steps 1 thru 4
   - Drills & Taps need no Radius set for them

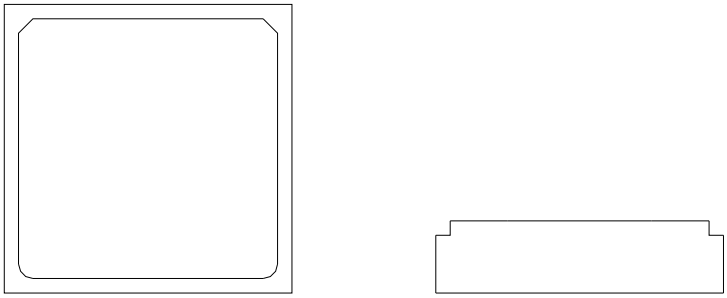


NOTE: When you use a T the H = Height

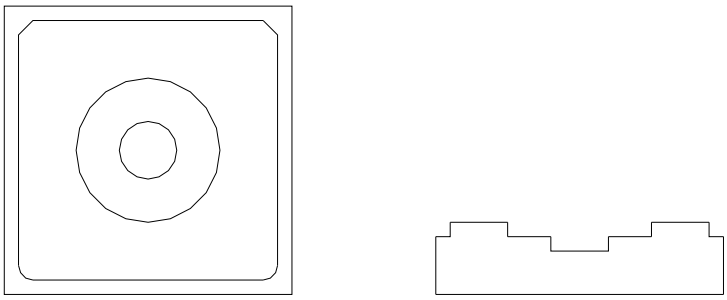
When you use a G41 or G42 the H = Radius

Program Training

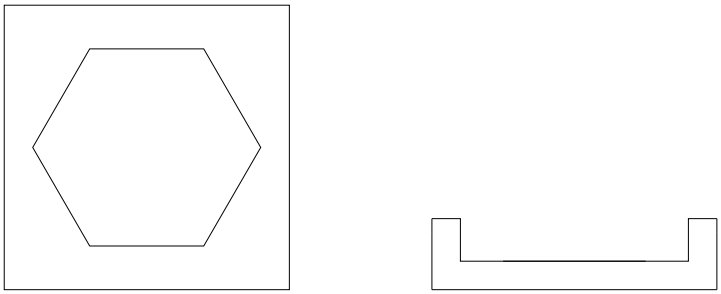
Program O0001



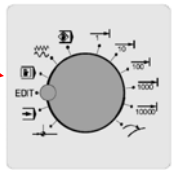
Program O0006



Program O0007



Change the Mode Dial to Edit
Press the Program Button
To do functions on this page



- ## INSERT A NEW PROGRAM

  1. Press letter o then program number
  2. Press insert button INSRT

  Example: O0001 OR O1

- ## CALL A EXISTING PROGRAM UP

  1. Press letter o then program number
  2. Press cursor down button ↓

- ## INSERT A WORD

  1. Press letter then number
  2. Press insert button INSRT

  Example: press once letter O appears press again number 7 appears

  HINT: When inserting a word place the cursor one word on the left before the place being inserted

  Example: _**N5 G01 X 0.25; G01** is the word being inserted

- ## INSERT END OF BLOCK

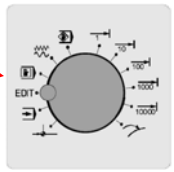
  1. Press the (EOB) button / , # EOB
  2. Press insert button INSRT

  HINT: at the end of each number line needs an End Of Block looks like a Semicolon (;)

  Example: N5 G01 X1.00 F.003;

NOTE: IN EDIT & IN PROGRAM USE INSERT ONLY.
USE INPUT ALL OTHER APPLICATIONS.

Change the Mode Dial to Edit
Press the Program Button
To do functions on this page



- ## DELETE A PROGRAM

1. Press letter o then program number
2. Press delete button DELET

Example: **<u>O</u>0001 OR <u>O</u>1**

- ## DELETE ALL PROGRAMS

1. Press letter o plus the – & 9999

2. Press delete button DELET

Example: **<u>O – 9999</u>**

- ## DELETE A CODE

1. Press letter then number
2. Press delete button DELET

Example: press once <u>S</u> appears press again 0 appears

HINT: Deleting a word; place the cursor on the left side before the word being deleted

Example: BEFORE N5_S1000; AFTER N5;

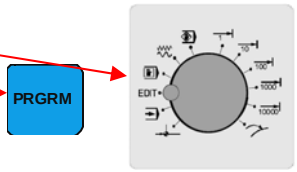
<u>(S1000)</u> is the word being deleted?

- ## DELETE A BLOCK OR LINE NUMBER

1. Type the number line
2. Press delete button DELET

Example: _N10 G0 X1.0 F.003; make sure cursor is on the line being deleted (_N10)

Change the Mode Dial to Edit
Press the Program Button
To do functions on this page



- **CANCEL MISTYPED CODE**

  1. Press cancel button CAN

  HINT: In the ADRS. (Address) at the lower left of the screen is the code and numbers that you typed in. Before pressing insert check if what was typed in is correct. If not press cancel and retype code and numbers.

- **ALTER A CODE**

  1. Type the code needed altered
  2. Press alter button ALTER

  Example: Make sure the cursor is to the left of the words being altered (_N5 CHANGE TO _N10)

- **SEARCH FOR NUMBER BLOCK**

  1. Press letter n and the number of the block
  2. Press cursor down button

  Example:(N50)

  HINT: The arrow button pointing down

- **SEARCH FOR CODE**

  1. Type in code & number **Example: (M30)**
  2. Press cursor down button

- **SEARCH FOR LETTER**

  1. Press letter
  2. Press cursor down button

  HINT: This goes to the first (G). Follow steps 1 & 2 cursor goes to the next (G)

Survey commands G CODES: Mostly used only

G00	**Rapid motion**
G01	Linear interpolation in working feed
G02	Circular interpolation, clockwise
G03	Circular interpolation, counter-clockwise
G04	Dwell time, active block by block
G09	Exact hold
G17	**Selection of plane X-Y**
G18	Selection of plane Z-X
G19	Selection of plane Y-Z
G20	Dimension in inch
G21	Dimension in millimeter
G28	Approach reference point
G40	**Deselect miller radius compensation**
G41	Miller radius compensation left
G42	Miller radius compensation right
G43	Tool length compensation positive
G44	Tool length compensation negative
G49	**Deselect tool length compensation**
G53	Machine coordinate system
G54	**Zero point shift 1**
G55	Zero point shift 2
G56	Zero point shift 3
G57	Zero point shift 4
G58	Zero point shift 5
G59	Zero point shift 6
G73	Chip break cycle
G80	**Delete drilling cycle (G83 to G85)**
G81	Drilling cycle
G83	Excavation drilling cycle
G90	**Absolute value programming**
G91	Incremental value programming
G94	**Feed in inch/min**
G95	Speed with feed in inch/revolution
G97	**Spindle speed per minute**
G98	**Retract to plane of start (drilling cycles)**

Survey commands M-CODES: Mostly used

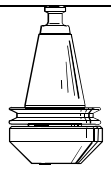
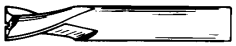
M00 Programmed stop, unconditional
M01 Programmed stop, conditional
M03 Spindle ON clockwise
M04 Spindle ON counter clockwise
M05 Spindle OFF
M25 Open clamping vice
M26 Close clamping vice
M30 Main program end with new start of program
M71 Blow-off ON
M72 Blow-off OFF
M98 Subroutine call-up
M99 Subroutine end

A maximum of three M commands allowed for each program block!

Used Addresses

C Chamfer
F Feed rate, thread pitch
G Path function
H Tool height, tool radius
I, J, K Circle parameter, scale factor, K number of repetition
M Miscellaneous function
N Block number 1 to 9999
O Program number 1 to 9499
P Dwell, subroutine
Q Cutting depth or shift value
R Radius, retraction height
S Spindle speed
T Tool called out
X, Y, Z Position data
; Block end

Tools needed for Programs 1, 2, 3, 4, 5, 6

F1Z 010	**Collet holder**	For ESX-25 collets	
225 100	**(9.0-10.0mm)∅ 3/8”**	**ESX 25 COLLETS**	
764 308	Acc. to DIN 327, shape B cutting-ø10 mm / shank-ø10mm	**Slot end mill, HSS**	

Program screen & Edit mode

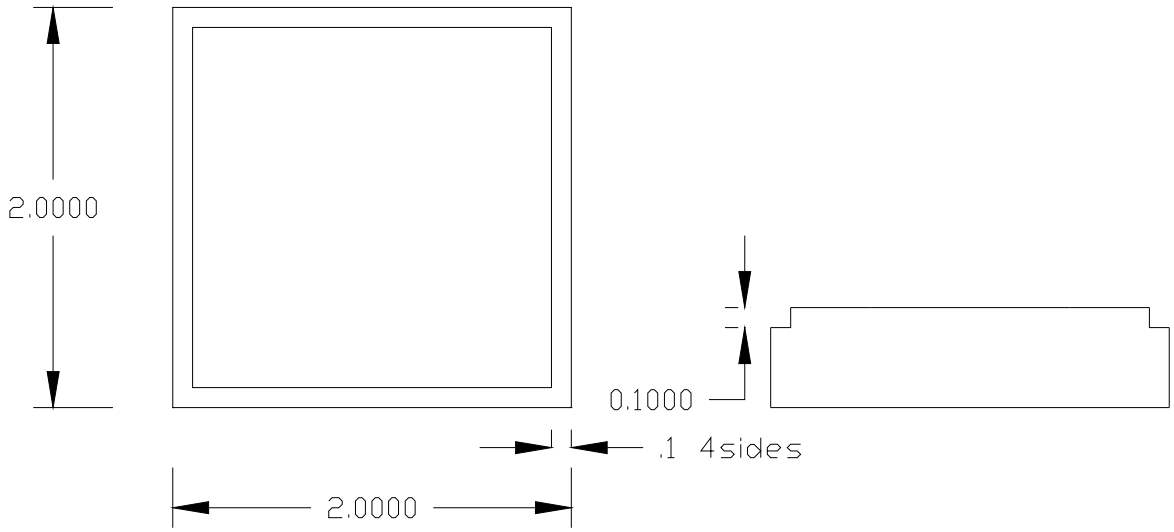
- **To edit / change a program / insert new programs & input or output excising programs & offsets**

Program screen & MDI mode

- **To manually program the spindle speed / move the axis (X,Y,Z) to a specified location and or Index to a certain tool**

Note: Material is 2024-T4 Alum, All feeds & speeds are programmed for this type of Aluminum

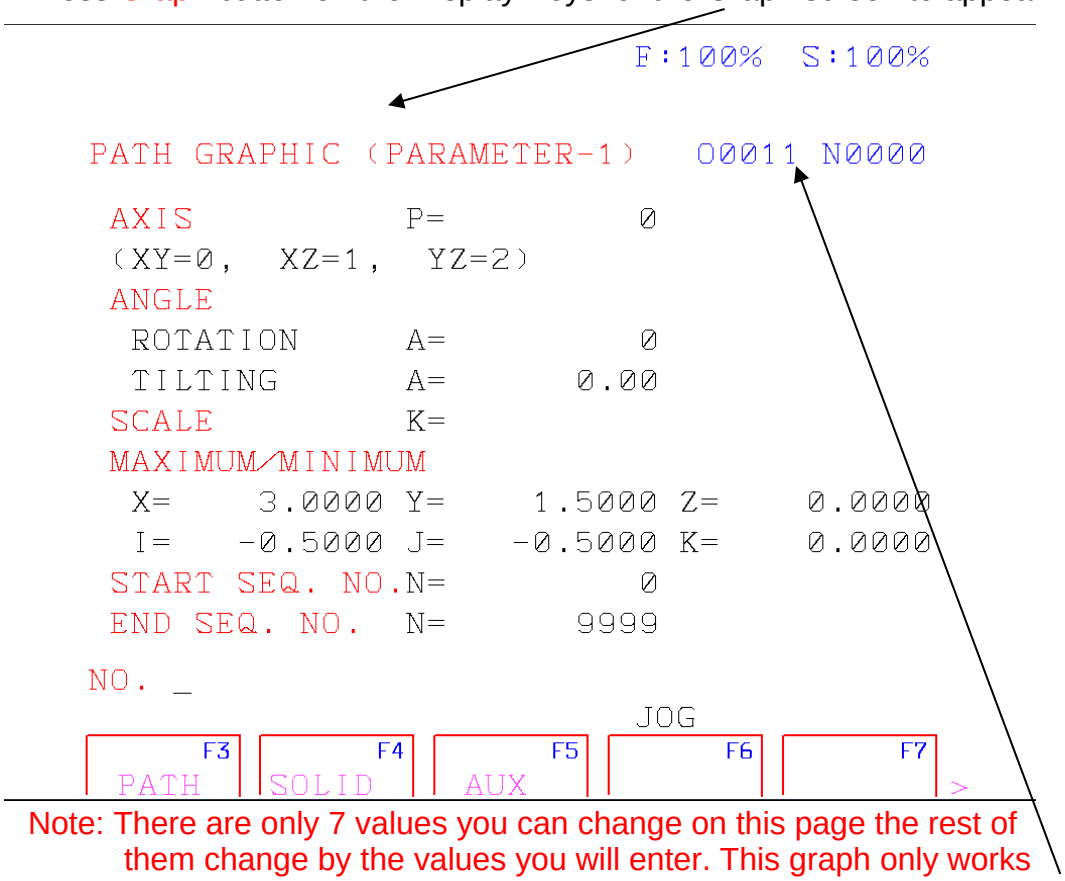
Program O0001



N5 G00 G17 G40 G80 (Demo 1) (2 X 2 X .5 Alum.)
N10 G90 G94 G98
N15 **G54**
N20 G43 T1 H1 M0 (3/8 or 10mm Endmill)
N25 S1800 M3
N30 G0 Z1
N35 X-1 Y1
N40 Z-.1
N45 G1 G41 H11 X.1 F7
N50 Y1.9
N55 X1.9
N60 Y.1
N65 X.1
N70 Y1
N75 G0 G40 X-1
N80 G28 Z3
N85 G28 X2.5 Y2.5
N90 M30

2D Simulation

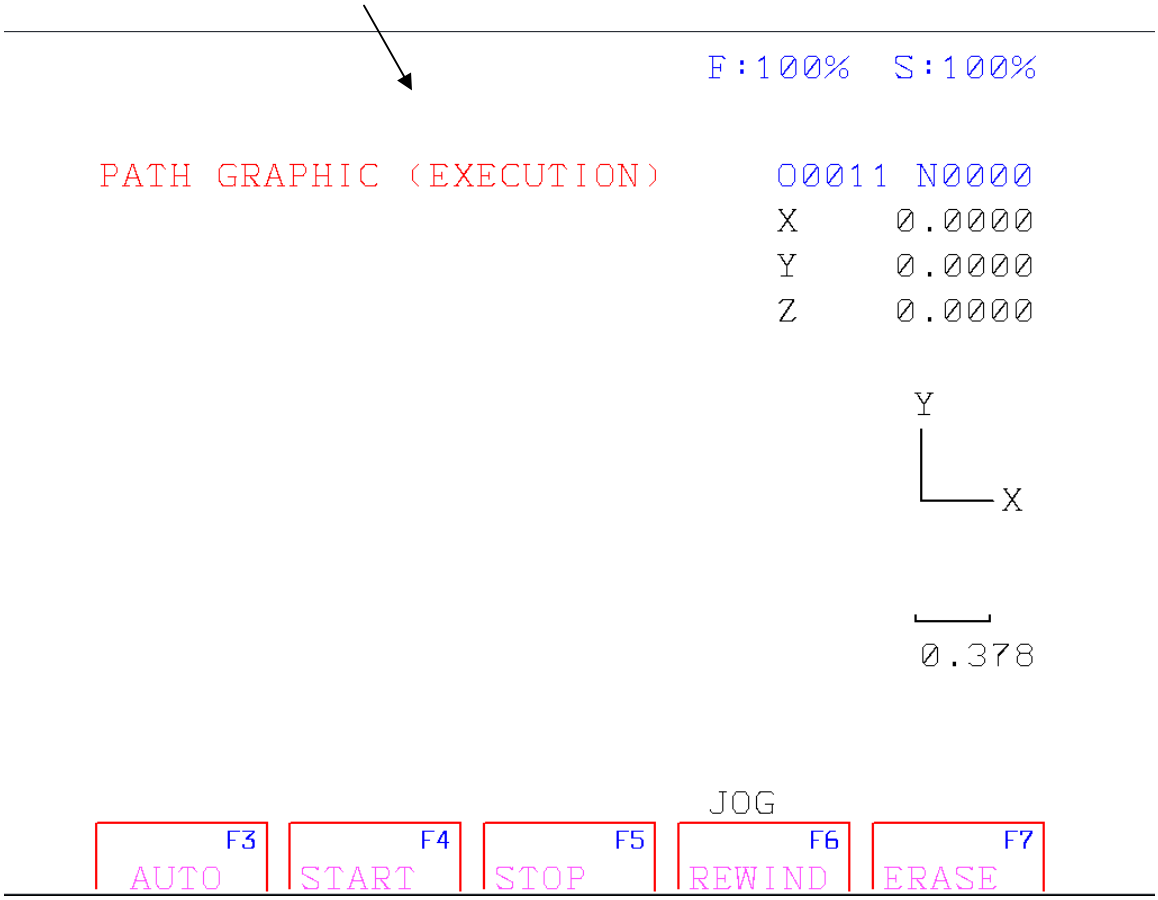
1. Press Graph button on the Display Keys for the Graph screen to appear



Note: There are only 7 values you can change on this page the rest of them change by the values you will enter. This graph only works with an active program and runs only the current program selected

2. Axis P = 0 means G17 1 means G18 2 means G19
3. Maximum/Minimum X = Overall Length of the stock in X direction this is a positive value
4. Maximum/Minimum Y = Overall Width of the stock in Y direction this is a positive value
5. Maximum/Minimum Z = Overall Height of the stock in Z direction this is a positive value
6. Maximum/Minimum I = This value is normally a negative number and this is the viewable area passed X0 going negative
7. Maximum/Minimum J = This value is normally a negative number and this is the viewable area passed Y0 going negative
8. Maximum/Minimum K = This value is normally a negative number and this is the viewable area passed Z0 going negative

9. Press the Soft key PATH
10. Press the Soft key EXEC for Execution screen



Note: If you press the AUTO on this screen this will auto scale for you. You will need to press the arrow left on the soft keys to go back and enter your values that you originally had.

11. Now press Cycle start or Soft Key Start and you will see the tool movements of the program

- **Changing I/O to floppy drive** (Only need to do this once stays default)
    1. Move the Mode Dial to **EDIT**
    2. Press **Parameter** on the display keys
    3. Page down until you see Parameter (Setting 1)
    4. Cursor down to I/O
    5. Type A (for the Floppy Drive) press Input key

  Other Drives useable: B (Drive), C (Drive), P (Printer), 1, 2 (Com Ports)

  Note: If you want to use USB use C and then follow the appendix

- **Output Program from Fanuc software to Drive unit**
    1. Press the **Program** on the display key
    2. Type program number to be send out

       Example: letter O and program number (O0002) or (O2)

    3. Press (**Output Start)** key

- **Output Offsets from Fanuc software to Drive unit**
    1. Press the **Menu Offset** display key
    2. Press (**Output Start)** key

- **Input Program into Fanuc Software from Drive unit**
    1. Press the **Program** display key
    2. Type program number to be read

       Example: letter O and program number (O0002) or (O2)

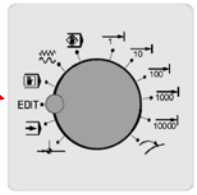
    3. Press (**Input)** key

- **Input Offsets into Fanuc Software from Drive unit**
    1. Press the **Menu Offset** display key
    2. Press **(Input)** key

Running a Program

Note: If the correct program # is at the top right corner of the screen then skip step 3 only and press reset for step 3 

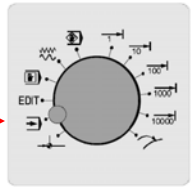
1. Rotate the Mode dial to Edit



2. Press the Program button 

3. Call up Program to be run / cut (Example O1 for program 1)

4. Rotate the Mode dial to Auto

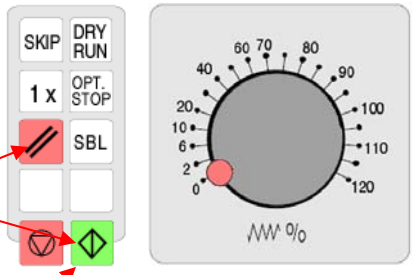


5. If screen is not in 

then press the check soft key

6. Press the Single Block button for the program to run one line at a time. 

Note: Use one hand on the feed override dial slowly increasing it and the other pressing cycle start and close to the reset button



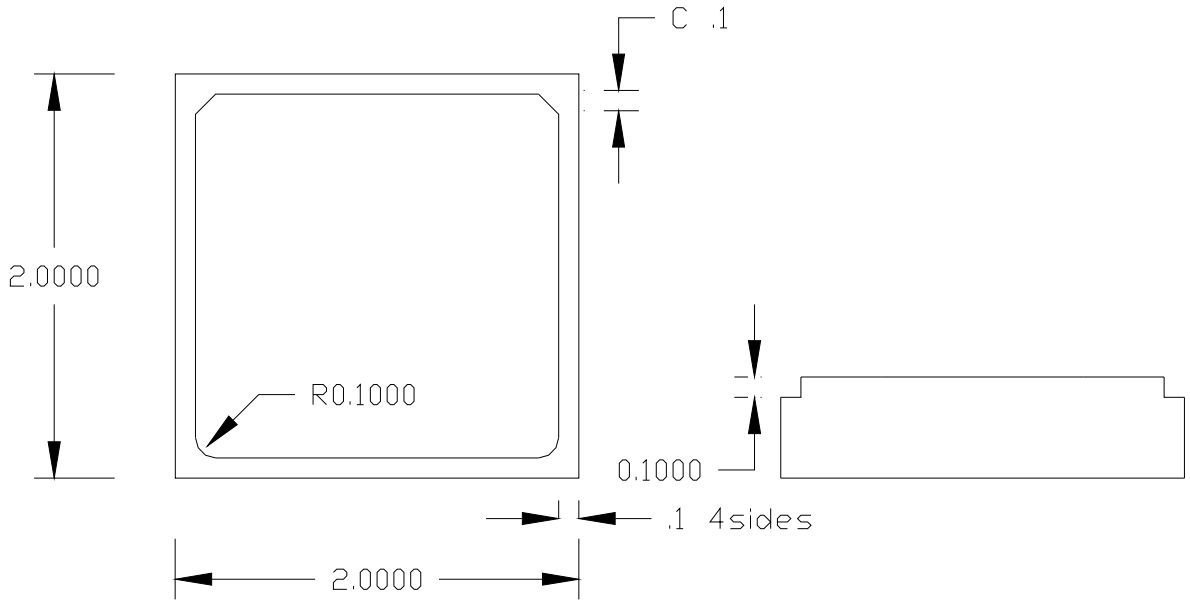
7. Press Cycle Start and continue

(Once the program have moved in the safe called out locations for X, Z and looks right; you can take single block off and run the program)

8. Press Cycle Start one more time

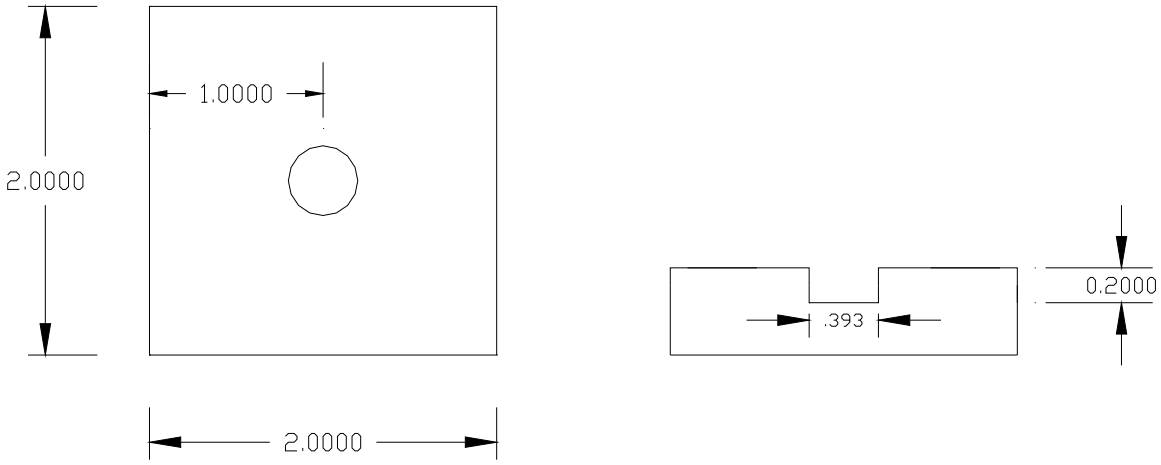
(If there is more than one tool; before the next tool use single block to check the offsets locations for X, Z then continue at step 8 again)

Program O0002 (C & R)



N5 G00 G17 G40 G80 (Demo 2) (2 X 2 X .5 Alum.)
N10 G90 G94 G98
N15 **G54**
N20 G43 T1 H1 M0 (3/8 or 10 mm end mill)
N25 S1800 M3
N30 G0 Z1
N35 X-1 Y1
N40 Z-.1
N45 G1 G41 H11 X.1 F7
N50 Y1.9 **C.1**
N55 X1.9 **C.1**
N60 Y.1 **R.1**
N65 X.1 **R.1**
N70 Y1
N75 G0 G40 X-1
N80 G28 Z3
N85 G28 X2.5 Y2.5
N90 M30

Program O0003 (Deep Hole Drilling)



G83 X = Location of hole Y = location of hole
Z = Overall Depth of hole P = Dwell at bottom of hole
R = Retract after Cycle Q = incremental peck depth per pass
K = Incremental repeats only used with G91 **F = Feed rate**

N5 G54 (Demo 3) (2 X 2 X .5 Alum.)

N10 G43 T1 H1 M0 (3/8 or 10 mm end mill)

N15 S1500 M3

N20 G0 Z1

N25 X1 Y1

N30 Z.05

N35 G83 Z-.2 R.1 Q.05 F3

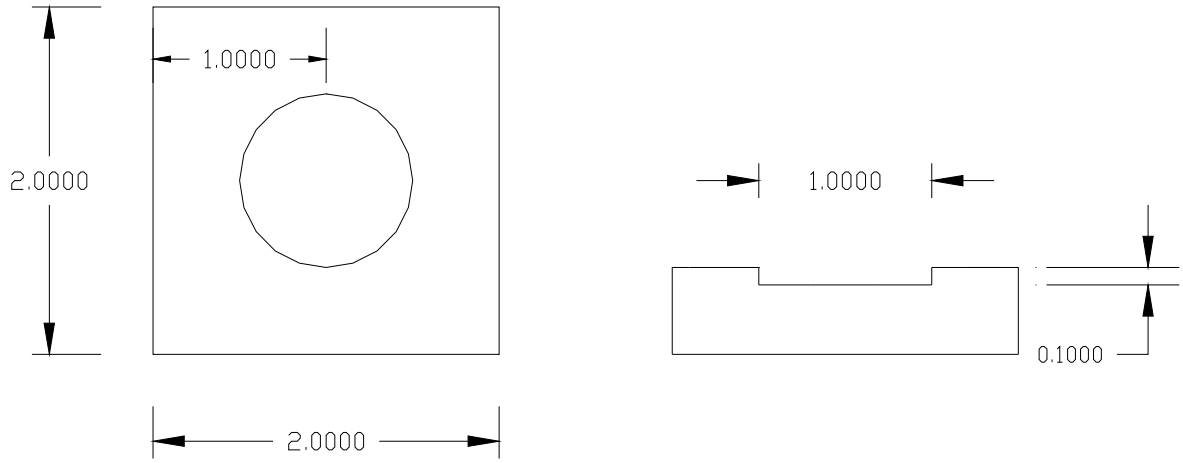
N40 G80

N45 G28 Z3

N50 G28 X2.5 Y2.5

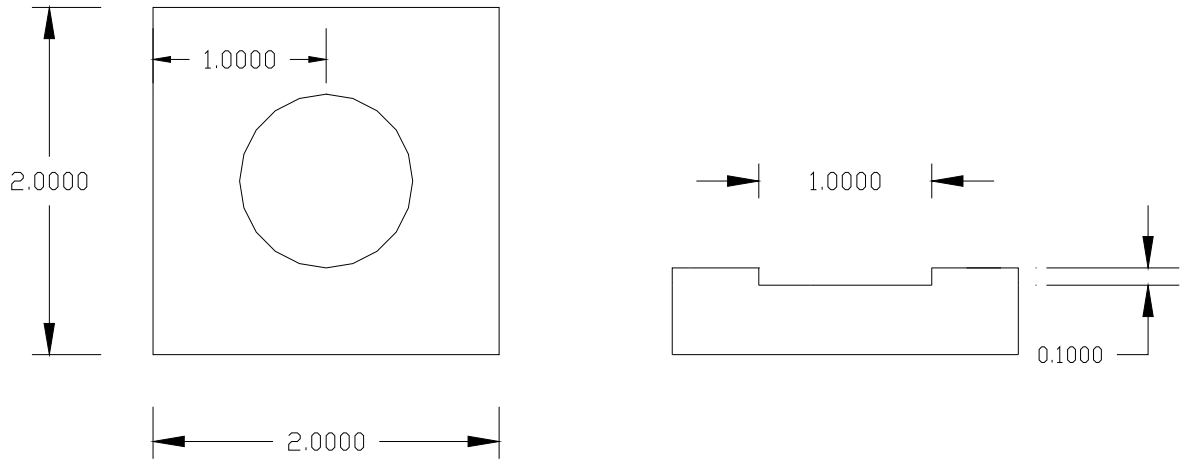
N55 M30

Program O0004 (I & J)



N5 G54 (Demo 4) (2 X 2 X .5 Alum.)
N10 G43 T1 H1 M0 (3/8 or 10 mm end mill)
N15 S1500 M3
N20 G0 Z1
N25 X1 Y1
N30 Z.1
N35 G1 Z-.1 F3
N40 S1800
N45 G1 G42 H11 X.5 F5
N50 G2 X.5 Y1 I.5 J0 (360 degrees)
N55 G0 G40 X1
N60 G28 Z3
N65 G28 X2.5 Y2.5
N70 M30

Program O0005 (R)



N5 G54 (Demo 5) (2 X 2 X .5 Alum.)

N10 G43 T1 H1 M0 (3/8 or 10 mm end mill)

N15 S1500 M3

N20 G0 Z1

N25 X1 Y1

N30 Z.1

N35 G1 Z-.1 F3

N40 S1800

N45 G1 G42 H11 X.5 F5

N50 G2 X1.5 Y1 R.5 (180 Degrees)

N55 G2 X.5 Y1 R.5 (180 Degrees)

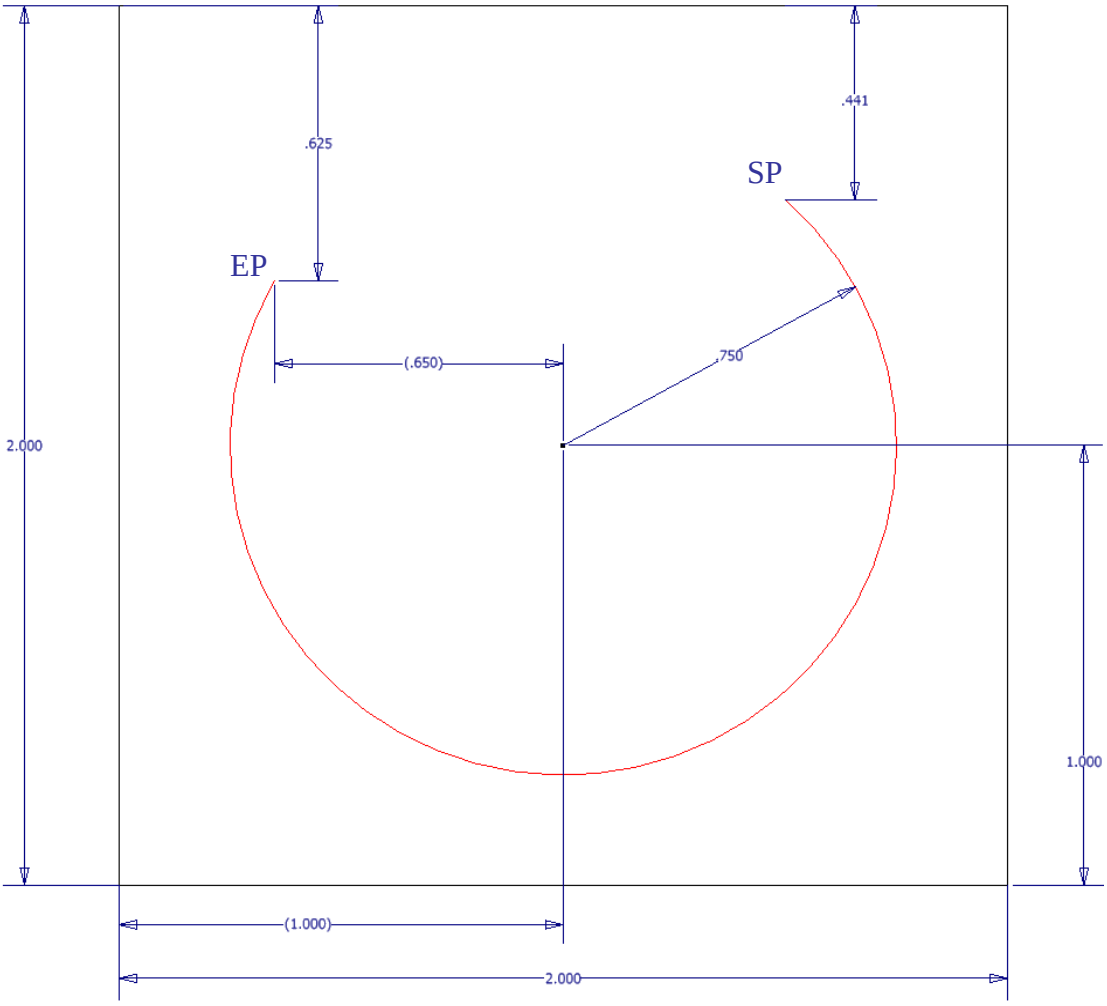
N60 G0 G40 X1

N65 G28 Z3

N65 G28 X2.5 Y2.5

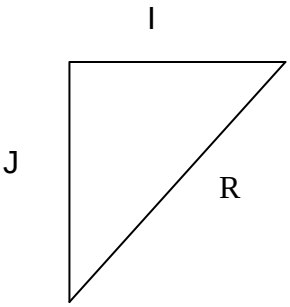
N70 M30

I and J Test



Using T1 (3/8 End Mill) and cutting on the inside of the red arc starting at the SP

N10 G1 Z.1
N15 G1 G H X Y (SP)
N20 G1 Z-.1
N25 G X Y I J (EP)
N30 G1 Z.1
N35 G0 G



A^2 (K leg) + B^2 (I leg) = C^2 (H radius)

$S \frac{O}{H}$

$C \frac{A}{H}$

$T \frac{O}{A}$

Degrees
Sally Can Tell Oscar Has A Hat On Always
SINE COSINE TANGENT

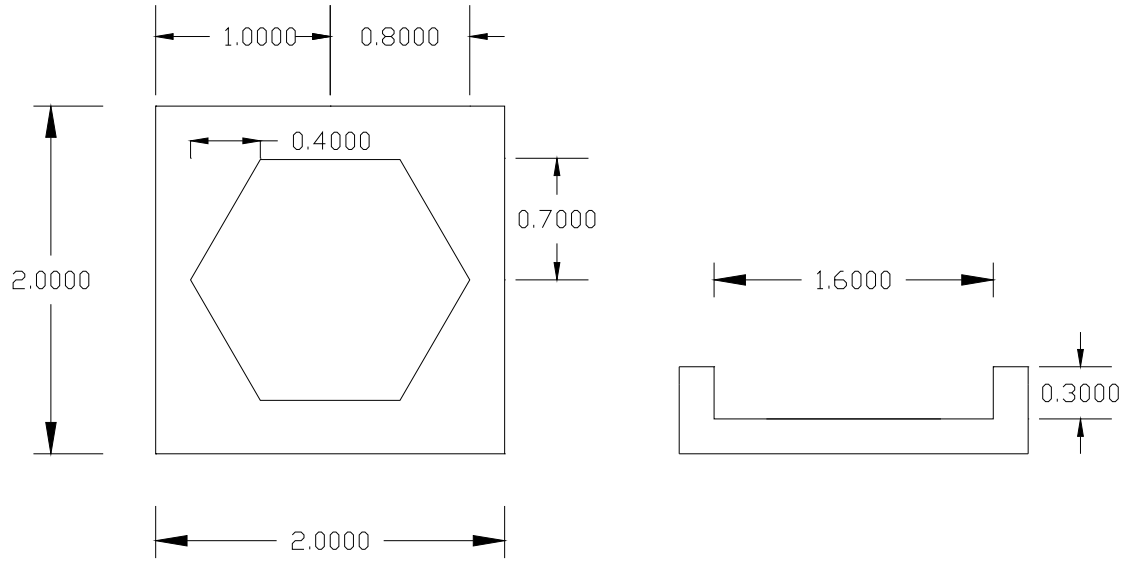
1. To make all programs tie together O0002, O0003, O0004 to run together. Use M98 this calls out Sub programs or Sub routines. Example: M98 P010001
2. After M98 P is identified with 6 digits.
   - The First 2 digits is the number of times program is to be repeated
   - The next 4 digits is the program number without the letter O
3. Programs that are being used as a Sub Programs must end with M99 instead of M30.
4. All programs can be used as Sub Programs or Main Programs M99 means program is Sub, M30 means program is a Main
5. A main Program can also use M99 at the end.
   - Program is being used to repeat without cutting multiple parts.
   - This is mainly used for Demo's for just seeing Tool movements.
6. To link all 3 programs together follow Program O0006
   - Program O0002(C/R), O0003, O0004(I,J) must all have M99 at the end to link together

TEST FOR SUB PROGRAMS

O0006 (Tie Programs)
N5
N10 (Demo 2 C/R)
N15 (Demo 3 Drilling)
N20 (Demo 5 I & J)
N25 M30
Changing Item
Note: Change the end of O0002, O0003, and O0005 to M99 for running them as SUB PROGRAMS

Program O0007 (Pocket Milling)

(Making a Cycle)



N5 G54 (Demo 7) (2 X 2 X .5 Alum.)

N10 G43 T1 H1 M0 (3/8 or 10 mm end mill)

N15 S1500 M3

N20 G0 Z1

N25 X1 Y1

N30 Z.1

N35 G1 Z0 F3

N40 M98 P030006

N45 G0 G28 Z3

N50 G28 X2.5 Y2.5

N55 M30

Program O0008 (Sub for program 7)

N5 G91 (Sub Prog. for Prog. 7)
N10 G1 Z-.1 F2
N15 G90
N20 S1800
N25 G41 H11 X.4 Y1.35 F7
N30 X.2 Y1
N35 X.6 Y.3
N40 X1.4
N45 X1.8 Y1
N50 X1.4 Y1.7
N55 X.6
N60 X.2 Y1
N65 X.4
N70 X.8 Y.5
N75 X1.2
N80 X1.6 Y1
N85 X1.2 Y1.5
N90 X.8
N95 X.4 Y1
N100 G0 G40 X1
N105 M99

Shorter Program Test:

Make program O0008 shorter by using the information given during the training!

N5 G91

N10 G1 Z-.1 F2

N15 G90

N20 S1800

N25 G41 H11 X.4 Y1.35 F7

N30 X.2 Y1

N35 X.6 Y.3

N40 X1.4

N45 X1.8 Y1

N50 X1.4 Y1.7

N55 X.6

N60
N65
N70
N75
N80

N60
N65
N70
N75
N80
N85

Appendix

Changing Drive to USB Port

1. **Close out the SW (software)**

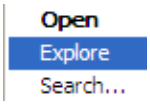
   - **Press** 

to allow you to exit
   - **Press** 

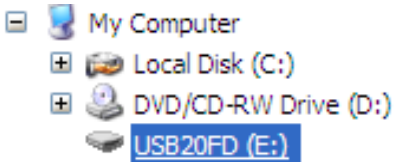
and  **together to exit the Software**

2. **Make sure USB is plug into port**

3. **Open Explorer**

   - **Right Click on Either My Computer, My Documents or any Folder on the Desktop**
   - **Move mouse to** 

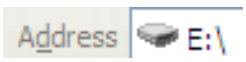
(Explorer)
   - **Left Click**
   - **If you right clicked on My computer skip to step 4 if not then Left Click on My Computer**



4. **Copy Drive directory**

   - **Click on you USB drive**

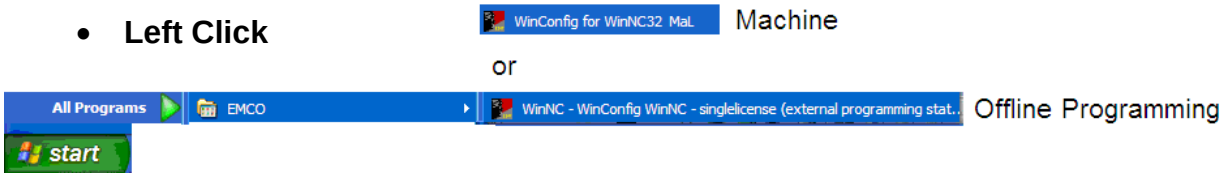
   - **At the top of the active screen or page in the Address copy or remember drive info**



   - **Close the active screen or page using either Alt and F4 or**  **at top of the active screen**

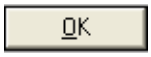
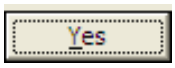
5. **Setting up WinConfig**

   - **Left Click on Green Start button on Desktop**
   - **Move mouse to All Program or Programs**
   - **Move mouse to EMCO**
   - **Move mouse to WinNC-WinConfig WinNC or WinNC32 – Singlelicense or MultipleLicense or Mal (Machine)**
   - **Left Click**



6. **In Winconfig**

   - **Left Click on**  **(INI) button**
   - **Double Left Click on**  **(Directories)**
   - **Left click on white box**

   - **Either Press Ctrl and V (this will paste in the info) or type in USB directory**
   - **Left Click on**  **(OK)**
   - **Left Click on**  **(Close)**
   - **Left Click on**  **(Yes) to save the changes**

7. **Restart SW (software)**

   - **Left Click on Green Start button on Desktop**
   - **Move mouse to All Program or Programs**
   - **Move mouse to EMCO**
   - **Move mouse to WinNC with this**  **icon on it**
   - **Left Click**