

HOW TO USE PROGRAM RESTART FUNCTION

HYUNDAI-KIA VX400/500

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Application Notes

Operator can start a program from any tool change without using this function, just move the cursor (in EDIT mode) to the tool change block and run from there, but it is up to operator to make sure all the fixture and tool offset are properly called before motions.

Program Restart function however allows operator to start in the middle of a motion. A typical scenario would be change a worn tool in the middle of a long cutting, after replace and set the new tool, operator can restart right at or around the spot where was interrupted earlier. Program Restart will ensure all the proper offsets are called and retrace back to the starting point.

1. To use this function, NC code must have block number.
2. Operator must know which block number to restart at, so record it before you interrupted a running program.
3. When ready to restart, go to MDI mode, and command the RPM.
4. Go to MEMORY mode.
5. Push [PROGRAM RESTART] key to light on.
6. Type in the block number you want to restart from.
7. On soft key, page over by [+] and find and push soft key [Q TYPE].
8. Push [PROGRAM RESTART] key to light off.
9. Push cycle [START], and spindle will travel back to that starting point one axis at a time, the approaching federate is controlled by JOG FEEDRATE override (the lower one).
10. Operator can use SINGLE BLOCK function to monitor the approaches and first few moves.
11. Once everything looks OK, 100% everything and let it run.