

PROGRAM RESTART FUNCTION

HYUNDAI-KIA VX MILLING

Application Notes

The Program Restart function allows an operator to start in the middle of a motion. A typical scenario would be to change a worn tool in the middle of a long cutting period, after replacing and setting the new tool, the operator can restart at or around the line of code at which the machine was interrupted.

Program Restart will ensure all the proper offsets are called and retrace to the desired starting point.

To use this function:

1. NC code must have block numbers
2. Record block number before interrupting a running program
3. Go to MDI mode and command the spindle RPM
4. Go to MEMORY mode
5. Push [PROGRAM RESTART] key and notice the light on
6. Type in the block number to restart from
7. On the screen, page over with [+] to find and push the [Q TYPE] softkey
8. Push [PROGRAM RESTART] key and notice the light off
9. Push cycle [START], the spindle will travel to the cutting point one axis at a time, the approach feed rate is controlled by the JOG FEEDRATE override nob (the lower one)
10. Use the SINGLE BLOCK function to monitor the approach and first few moves
11. Once everything looks okay, return the machine to standard running conditions

***NOTE:** *An operator can start a program from any tool change without using this function, move the cursor (in EDIT mode) to the tool change block and run from there, it is up to operator to make sure all the fixture and tool offsets are properly called before motion is allowed.*