

START UP

HYUNDAI-KIA VX MILLING

Application Notes

This is the recommended startup procedure for the Hyundai-Kia VX style milling machines. This addresses a height error that is possible to introduce to the tool height setup (H Values) when using INP.C Softkey. Please read the Notes section for details about spindle stop behavior by pressing the [RESET] button.

Machine Startup Procedure

1. Turn cabinet power switch to ON
2. Press the [ON] button on the machine control panel, wait until CNC system starts
3. Release the [EMERGENCY STOP], then press the [STANDBY] key to fully start the machine
4. Press the [ZERO RETURN] key, then the [CYCLE START] key, machine will reference and park at machine zero positions
 - ✓ Please read the Notes section for the manual [ZERO RETURN] procedure

Set Machine Relative Position to Zero

5. Press the [POS] Hardkey on the FANUC panel, press the relative position [REL] Softkey, press the [OPRT] Softkey, then [ORGIN] then [ALLAXE], this will set all relative position to zero
6. Machine is ready for operation

Notes:

1. During machine shut down, operator can park the X, Y, Z axis anywhere.
2. When using the softkey INP.C to set tool height, it reads the value from Relative Position. Typically Relative Position is left alone, therefore it remains the same as machine position, but if the operator uses an alternative value in the relative position fields, be sure to reset it to match the machine position when setting tool height using INP.C. **Otherwise the tool height will be WRONG.**
3. The default machine parameter setting leaves the spindle running when an operator presses the [RESET] button
 - a) To alter this setting, change parameter D109 bit 6 from 0 to 1, (same as add 64 to D109), this only needs to be done once
 - ✓ Please have certified service personnel modify parameters
4. For Machines without the automatic [ZERO RETURN] function, the zero return must be handled manually.
 - In JOG mode, move the XYZ axis' away from the travel limits
 - Press the [ZERO RETURN] button, press and hold the axis button with the Datum picture until axis home light is on, do this for each axis.