Slow Jog

Home Jog Buttons
Press until Button is lighted to place machine at Machine Home. X0 Y0 Z0 etc.

Single Block
Steps through a program one line at a time.

Machine Lock
All move commands are suppressed

Rapid Jog
Jog Machine at High Speed

Lock out all M & T codes

Z Lock
Locks out all Z movement
Machine runs only in X and Y

Spindles On
Spindles on when Lighted

Spindle Up/Down
Lifts Spindle. Must be in Jog Mode

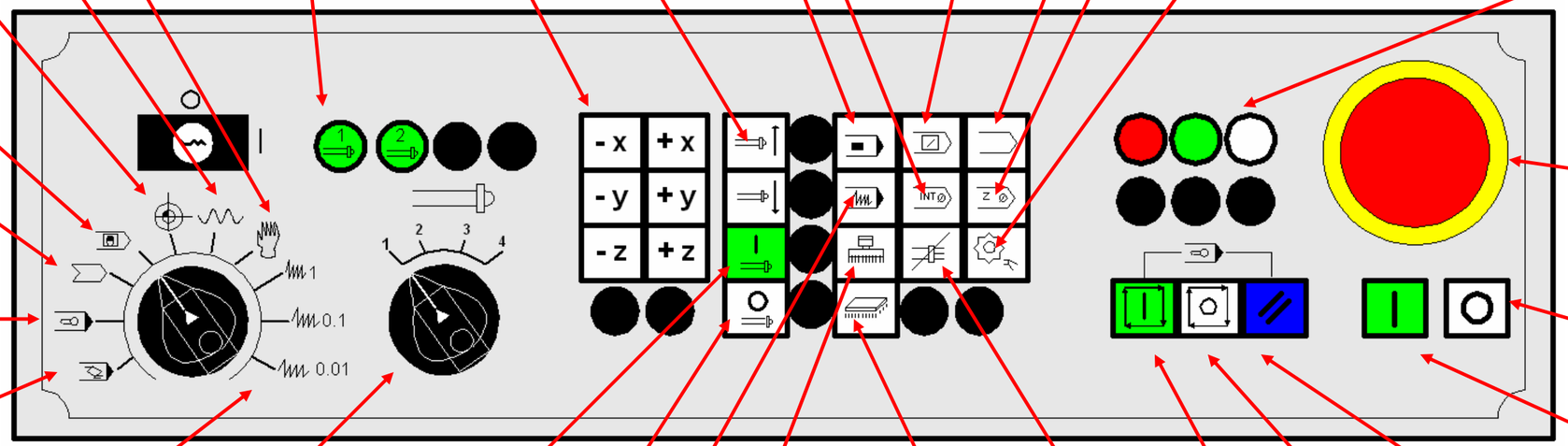
Block Skip Enable
Skips line of code

Tool Rotation Button
Rotates Tool Changer

Reference Return
Homing the machine manually

Red – Alarm
Green – Machine On
White – Power On

MDI
Manual Data Input



Emergency Stop

Tape Reader
Used for DNC Mode(Drip feeding)

Memory Mode
Where you run the programs from

Turn Off Control

Edit

Start CNC Control

Incremental Jog
X1 = .100”
X10 = .010”
X100 = .001”

Select Spindle
Router might be 1
Drill Block 2 etc.

Lift Dust Brush

Vacuum Override

Reset Button

Spindle On

DRN
Controller skips all F codes

Reverse Air Blower

Feed Hold

Spindle off

Cycle Start