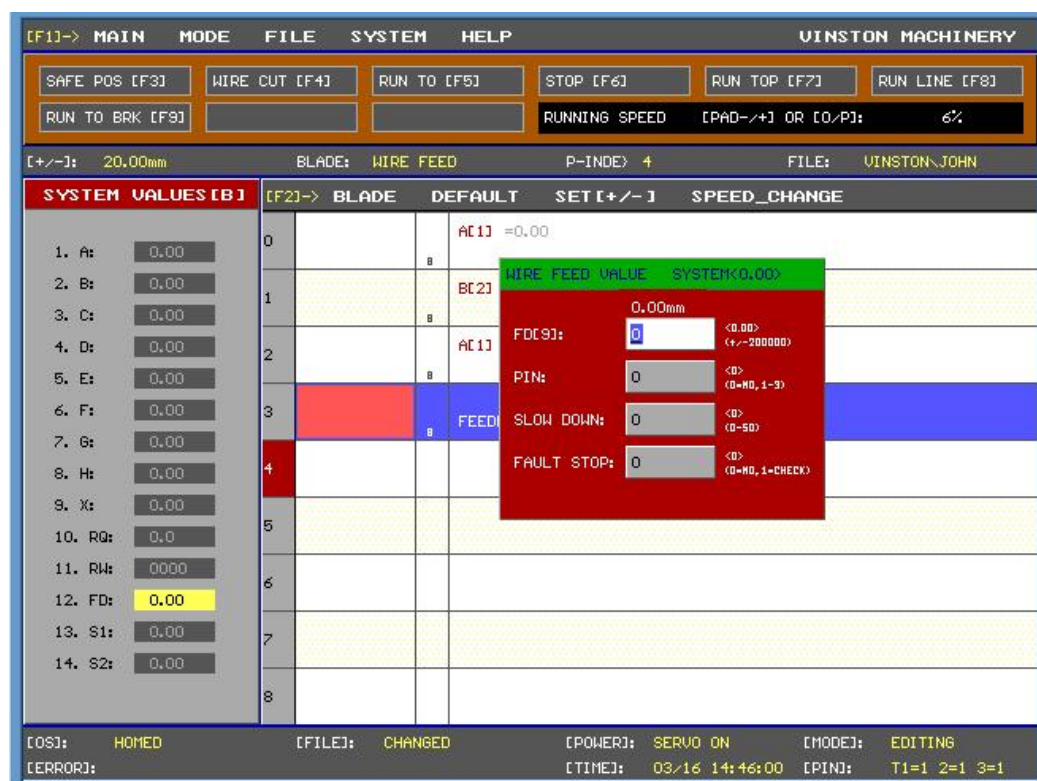# 11. PROGRAM MODIFICATIONS

11.1 DIRECT AXIS MODIFICATIONS

Select the program line to modify and the axis to be modified. Each axis has a shortcut key. For example, Axis A can be accessed with the number 1 (on the keyboard, not keypad) and so on. The numeric value in brackets next to the axis illustrates the shortcut key. The screenshot below illustrates accessing the servo feed axis with the "9" key.

```
[F1]-> MAIN    MODE    FILE    SYSTEM    HELP                    VINSTON MACHINERY

 SAFE POS [F3]      WIRE CUT [F4]     RUN TO [F5]      STOP [F6]      RUN TOP [F7]     RUN LINE [F8]

 RUN TO BRK [F9]                                      RUNNING SPEED   [PAD-/+] OR [O/P]:      6%

[+/-]:  20.00mm          BLADE:  WIRE FEED          P-INDE>  4              FILE:   VINSTON\JOHN

 SYSTEM VALUES[B]  [F2]-> BLADE    DEFAULT    SET[+/-]    SPEED_CHANGE

 1. A:    0.00    0                  A[1] =0.00
                                B
 2. B:    0.00                    WIRE FEED VALUE    SYSTEM<0.00>
 3. C:    0.00    1                         0.00mm
                                B
 4. D:    0.00    2              A[1]   FD[9]:   0      <0.00>
                                                       (+/-200000)
 5. E:    0.00                B
 6. F:    0.00    3                     PIN:     0      <0>
                                                       (0=NO,1-3)
 7. G:    0.00                B  FEED  SLOW DOWN: 0     <0>
 8. H:    0.00    4                                    (0-50)
 9. X:    0.00                          FAULT STOP: 0  <0>
 10. RQ:   0.0    5                                    (0=NO,1=CHECK)
 11. RW:  0000
 12. FD:   0.00   6
 13. S1:   0.00   7
 14. S2:   0.00
                  8

[OS]:    HOMED        [FILE]:   CHANGED        [POWER]:  SERVO ON     [MODE]:   EDITING
[ERROR]:                                       [TIME]:   03/16 14:46:00  [PIN]:   T1=1 2=1 3=1
```

Once the user has entered the new value for the axis, save it by pressing the ENTER key.

NOTE: This process does not change the current position of the axis. The axis will only change positions once the program runs that particular line of code.

11.2 SELECTIVE MODIFICATIONS

Run through the program step by step with the F8 key until the line that needs to be modified. Press the ESC key and use the arrow keys to navigate through the program line to individual axes. Press the ENTER key to modify the value of the axis. Press the ENTER key again to save changes. The user can also press the number or character (2 times) corresponding to the axis within the line of code. Press the ENTER key again to save the changes.

The user can also move the axis with the command RPG CONTROL. The sensitivity of the axis can be adjusted by using the "<" and ">" keys on the keyboard. The incremental movement of the axis can be adjusted to 0.01 mm, 0.50 mm, 1.00 mm, 2.00 mm and 4.00 mm. Use the INS (Insert) key to save the position of the axis. Repeat process for all axes that are listed in the current line of code.