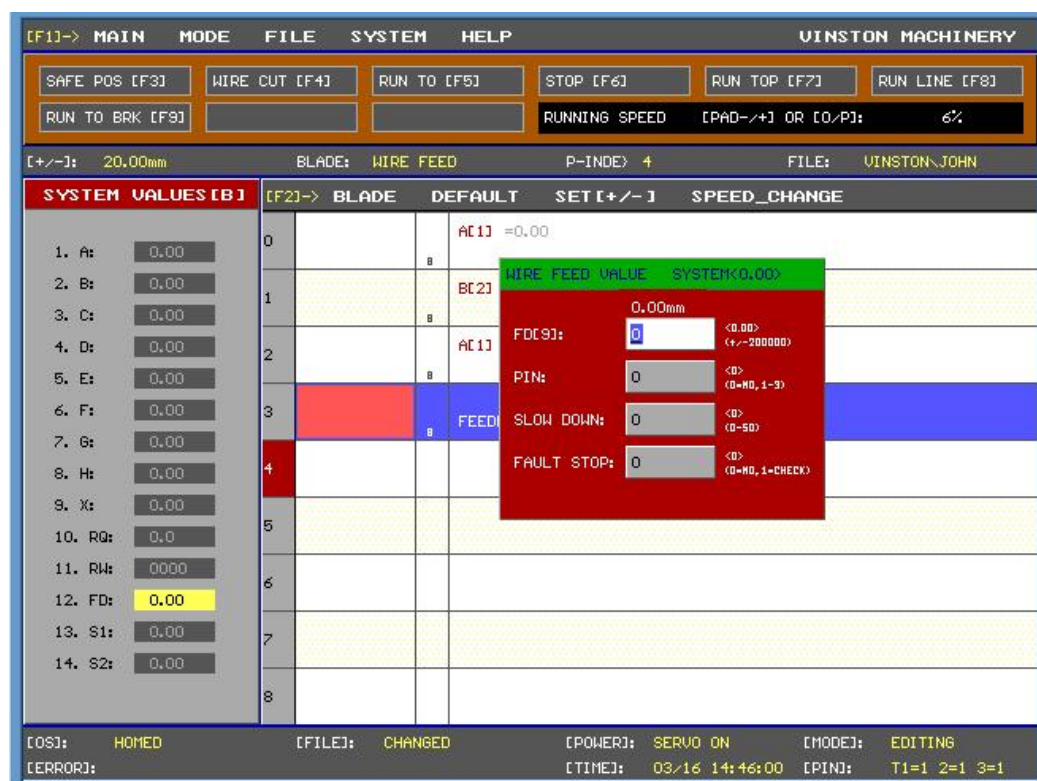


## 11. PROGRAM MODIFICATIONS

### 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.



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 screenshot displays the WINSTON MACHINERY CNC control interface. At the top, there is a menu bar with options: [F1]-> MAIN, MODE, FILE, SYSTEM, and HELP. Below this is a row of function keys: SAFE POS [F3], WIRE CUT [F4], RUN TO [F5], STOP [F6], RUN TOP [F7], and RUN LINE [F8]. A second row of function keys includes RUN TO BRK [F9], a blank space, another blank space, RUNNING SPEED [PAD-/+], and OR [O/P]: 6%. Below these is a status bar showing [+/ -]: 20.00mm, BLADE: WIRE FEED, P-INDE: 4, and FILE: WINSTON\JOHN.

The main display area is titled [F2]-> BLADE, DEFAULT, SET [+/ -], and SPEED\_CHANGE. It contains a table with 14 rows, each representing an axis (A through S2). The first column shows the axis number (1-14), the second column shows the axis letter (A, B, C, D, E, F, G, H, X, RQ, RH, FD, S1, S2), and the third column shows the current value. The values for axes A through S2 are all 0.00. The row for axis FD is highlighted in yellow. The row for axis S1 is highlighted in red. The row for axis S2 is highlighted in blue.

At the bottom of the screen, there is a status bar with the following information: [OS]: HOMED, [FILE]: CHANGED, [POWER]: SERVO ON, [MODE]: EDITING, [TIME]: 03/16 14:50:48, and [PIN]: T1=1 2=1 3=1.

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.