

## 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.

The screenshot shows the VINSTON MACHINERY control interface. At the top, there are menu items: FILE, SYSTEM, and HELP. Below these are function buttons: CUT [F4], RUN TO [F5], STOP [F6], RUN TOP [F7], and RUN LINE [F8]. A status bar shows RUNNING SPEED [PAD-/+ ] OR [O/P]: 6%. Below this, it displays BLADE: WIRE FEED, P-INDE: 4, and FILE: VINSTON\JOHN. The main area is a table with columns: [F2]->, BLADE, DEFAULT, SET [+/-], and SPEED\_CHANGE. The table has 9 rows, numbered 0 to 8. Row 0 shows AC11 =0.00. Row 1 shows BC23. Row 2 shows AC11. Row 3 shows FEED. Row 4 is highlighted in red. A modal dialog box is open over the table, titled 'WIRE FEED VALUE SYSTEM<0.00>'. It contains the following fields: FDC9: 0.00mm (range <0.00> to <+/-200000>), PIN: 0 (range <0> to <0=NO, 1-3>), SLOW DOWN: 0 (range <0> to <0-50>), and FAULT STOP: 0 (range <0> to <0=NO, 1-CHECK>). At the bottom, there is a status bar with [FILE]: CHANGED, [POWER]: SERVO ON, [MODE]: EDITING, [TIME]: 03/16 14:46:00, and [PIN]: T1=1 2=1 3=1.

[F2]->	BLADE	DEFAULT	SET [+/-]	SPEED_CHANGE
0			AC11 =0.00	
1			BC23	
2			AC11	
3			FEED	
4				
5				
6				
7				
8				

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.

FILE			SYSTEM			HELP			VINSTON MACHINERY					
CUT [F4]			RUN TO [F5]			STOP [F6]			RUN TOP [F7]			RUN LINE [F8]		
						RUNNING SPEED			[PAD-/+ ] OR [O/P]:			6%		
BLADE: WIRE FEED			P-INDE: 4			FILE: VINSTON\JOHN								
[F2]->			BLADE			DEFAULT			SET [+/- ]			SPEED_CHANGE		
0														
1														
2														
3														
4														
5														
6														
7														
8														
[FILE]: CHANGED			[POWER]: SERVO ON			[MODE]: EDITING								
[TIME]: 03/16 14:50:48			[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.