

## **15 SPECIAL FUNCTIONS AND COMMANDS**

**15.1 SAFE POSITION:** The F3 key moves the slides back into their corresponding zero (safe) positions. Prior to pressing the F3 key, make certain that the slides will not collide with other slides or samples on the machine. The user can use manual movements (RPG CONTROL) to navigate the slides around until all obstructions are cleared. Once the path for each slide is cleared, press the F3 key to move them into their safe positions.

**15.3 AUTOMATIC CUTTER:** Press the F4 key in EDIT mode to cut the wire only when there is no risk of collisions. The machine will confirm with the user that no collisions will occur prior to slide movements. The system will run the F3 routine to open up the slides, feed 20 mm of wire (or whatever is set as the default when configured using the F2 menu), rotate the quill into the automatic cutter position and move in the blade slide for the cut. NOTE: The cutter parameters are set by the user using F2 menu options.

**15.4 WIRE FEED:** Press the "+" key will feed wire from the quill and press the "-" key to retract the wire into the quill. Make certain there are no angles on the wire when retracting or it could damage the tip of the quill.

**15.5 WIRE ROTATION SPECIAL POSITIONS:** Selecting the wire rotation function using the ~ key on the keyboard. Pressing the S key moves the rotary wire into the safe position. This position places all weight and counterweights in a vertical position so a loss of power will not result in injuries. Pressing the D key moves the rotary wire into the optimal position to calibrate the wire straighteners and various wire settings.

**15.6 FEED ON / OFF:** Enable / Disable the wire feed in the program. This feature is typically used during testing or demonstrations.

**IMPORTANT:** IF THE PROGRAM EXTENDS AN AIR PROBE OUT FOR A CONTACT TEST, ANOTHER SEPARATE LINE OF CODE MUST BE ADDED TO RETRACT THE AIR PROBE. THE PROGRAM WILL NOT RETRACT THE AIR PROBE AUTOMATICALLY.