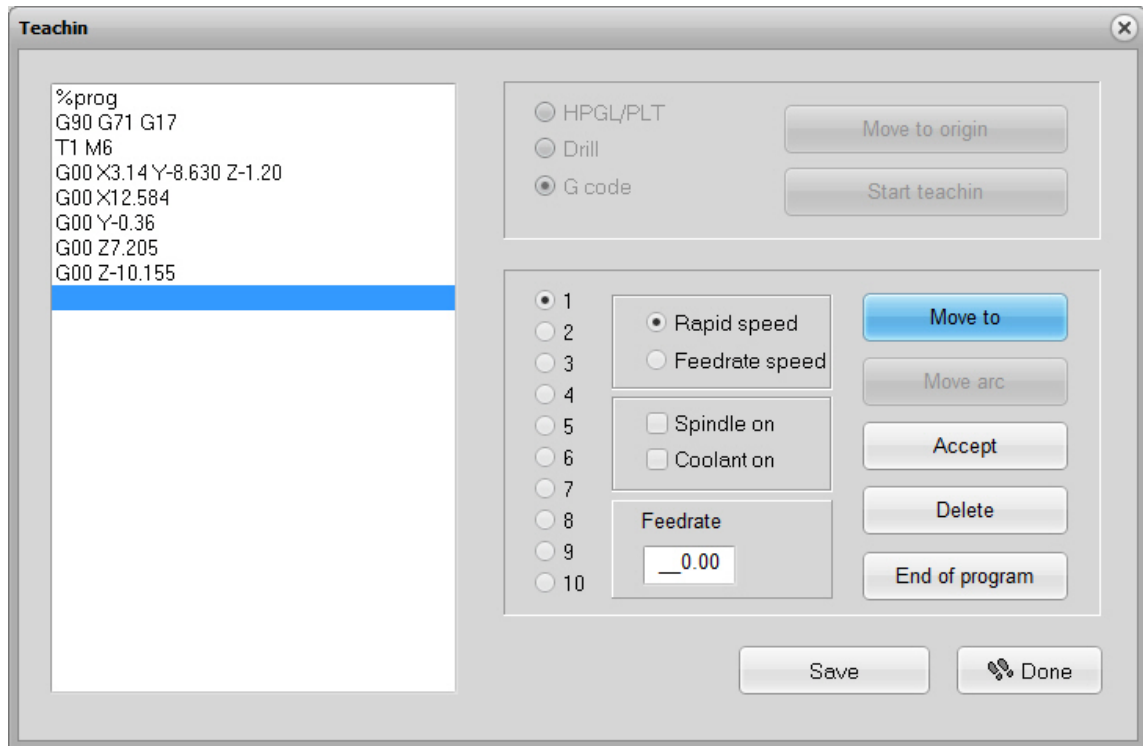


## SPECIAL FUNCTIONS TEACHIN

By means of the function TEACHIN simple programs in various formats can be created by moving and following the contours.



Special function Teachin

### *Creating programs interactive.*

The new program is displayed in the teachin window on the left side of the dialog. In the top part actions can be activated prior to the teachin process.

The large window on the right-hand displays all available actions, e.g. selecting the tool, speed settings, operating the spindle and cooling and provides the possibility to produce various contour shapes.

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**Executing commands depends on the selected data format. Commands as switching the spindle or cooling are useless with the HPGL format.**

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### *Teachin step by step*    **Gradual procedure with teachin:**

1. Execute reference move and call up teachin function
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2. Stipulate the desired data format and determine the zero point by moving
3. Start teachin process. Now the program head will be automatically set up and displayed in the program window
4. In the following steps you can create as many contour elements as necessary for the desired program either by moving the new line ends or by definition of circle points. Tool changes and unproductive movements to new start points and plunge positions are possible
5. Click on exit button and the program is automatically finished
6. The new created program should be stored before leaving the function.

**Possible actions during the teachin process are as follows :**

<i>Move line</i>	Moving to a new position. This moving step is either an operation in open curcuit with high speed or immersed with feed rate. Several lines can be taught successively and the function is left if no other movement has taken place.
<i>Circle arc</i>	Teachin of a circle or arc is taking place with always three points. The first point is also the current position. First any point on the circle arc is being moved to and finally to the final point. By these three points a circle or arc command can be clearly created.
<i>Accept</i>	This function inserts the actual position of the cursor bar into the program.
<i>Delete</i>	Deletes the line of the cursor bar. With this function it is also possible to delete and correct previous commands.
<i>Exit</i>	Inserts the necessary commands for exiting the program and finishes the new created NC program.

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**New commands are always inserted at the actual cursor position and enables the user to make up for overlooked actions.**

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