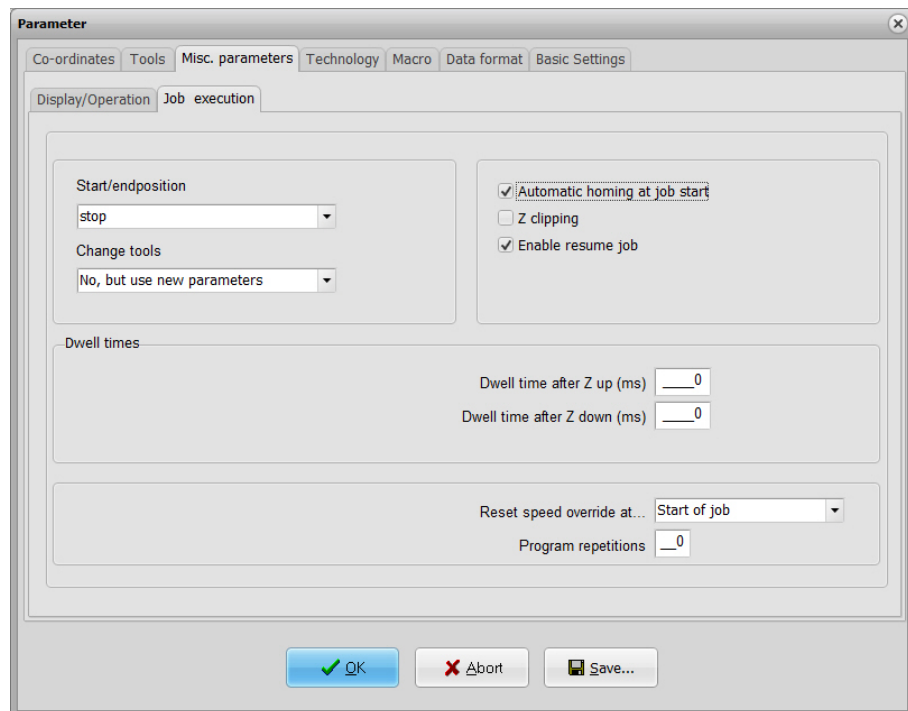


Miscellaneous-Job process



Parameter-Miscellaneous parameters-Job process

Start/End position

This switch specifies where the start and end point of each working process should be located. The machine also moves to the position after reference movement.

There are 4 possible start and end positions :

Stop

WinPC-NC stops at the reference position after reference movement, and at the last coordinate after each job process

Zero point

The machine moves to the defined zero point after reference movement and after each job process.

Park Position

WinPC-NC moves to the defined parked position after reference movement and after each job process.

Zero point and clearance distance

The machine moves to the defined zero point and lifts up the Z-axis to the defined clearance distance.

Tool change

The parameter defines how **WinPC-NC** handles the tool change commands during a working process.

There are 5 possibilities for the tool change :

<i>No</i>	No tool change is performed, the entire working process takes place with the current tool
<i>Yes</i>	Performs the tool change and remains stopped in the current position for every tool change
<i>Yes, at the park position</i>	Performs the tool change and moves to the defined park position for every tool change
<i>No, but use new values</i>	No tool change is performed, although the values for plunge depth, plunge speed and feed speed of the new tool are adopted.
<i>YES by ATC</i>	Performs automatically a tool change by existing tool changer

Homing at a job

On request a homing sequence can automatically be performed by **WinPC-NC** prior to each job. This switch is recommended in case of an exact movement to the positions or if you presume that there are stepping errors.

Z-axis clipping

When the Z-axis clipping function is activated, **WinPC-NC** monitors the maximum Z-axis depth and cuts off all deeper movements at the working area limit.

Enable resume job



Interrogation at a restart or continuation of an interrupted job

WinPC-NC can continue operation of an interrupted job exactly at the interruption point. However, this function has to be enabled by a parameter.

Dwell time after Z up and Z down

In many applications, it is a good idea or indeed a requirement to wait a moment after the tool has been lowered or raised, before starting X and Y-axis movements. This may be the case when working with flexible materials or if you want the tool to freewheel.

The waiting time is defined in milliseconds.

Reset override speed

The feed and spindle rate are permanently changeable while **WinPCNC** is processing a job. This parameter stipulates how long this alteration is activated.

Following settings are possible :

<i>Machinen reset or programm reset</i>	Only with restarting WinPC-NC it is possible to place back the override values to 100%
<i>New file</i>	Values are placed back by loading a new NC file
<i>Job start</i>	Reset of the values is made by the following start of a job process

Program repetitions

The program repetitions parameter enables you to repeat a working process up to 999 times. This enables series production to be achieved in conjunction with a start signal.