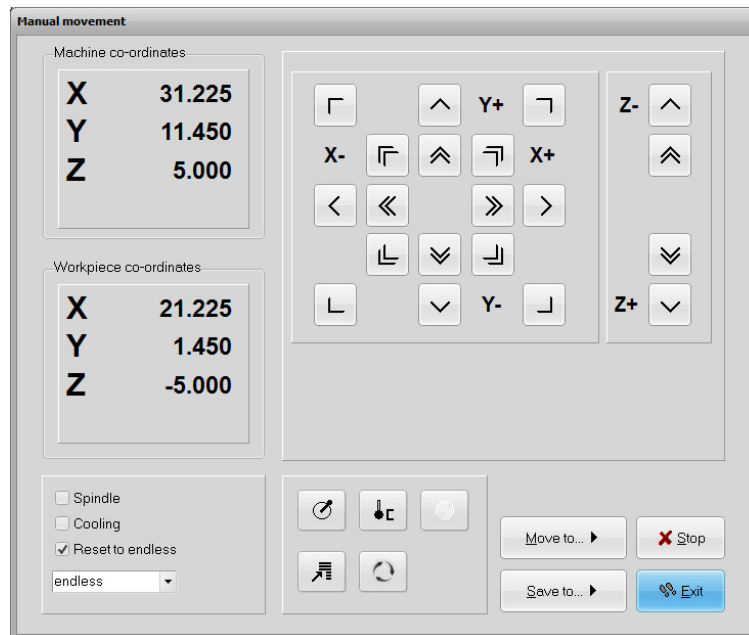


MOVE-JOG



The JOG menu item calls up the manual setup function for the machine. This function can also be accessed by pressing the **F5** function key or with the jog button.



JOG function

Exact movement with the keyboard or mouse

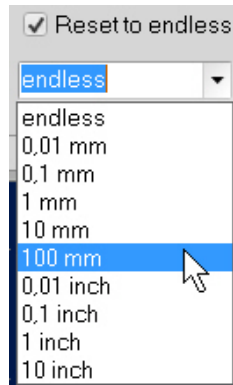
In JOG mode, it is possible to move all motors step-by-step or continuously with the cursor arrow keys in the numeric block or with the mouse. Pressing a key briefly or clicking the corresponding direction button causes only one motor step to be performed. Pressing the key for longer or keeping the mouse button pressed causes the motor to move continuously. The changeover time can be defined as a parameter.

Via PC keyboard you can execute slow or fast moves. Where the latter is the case, please keep pressed the button **STRG**. The righthand arrow keys **1** to **9** are responsible for individual or diagonal move of the axis X and Y, the keys **+** and **-** move the Z axes. The speeds are defined in the parameters.

Display of step counters

The absolute step counters for each axis are displayed in the top part of the window. Their values relate to the reference point on the reference switches. Below them are located the relative step counters which relate to the zero point of the working piece.

WinPC-NC distinguishes between two systems of coordinates. Firstly the machine coordinates with their origin on the reference switches and which are referred to as the reference point. Then there are the workpiece coordinates with the workpiece zero point, which is usually located in the bottom left-hand corner of the data area.



WinPC-NC can move the axes endlessly, i.e. movement continues

for as long as a key remains pressed. The axis brakes when the key is released and comes to a stop without any step losses.

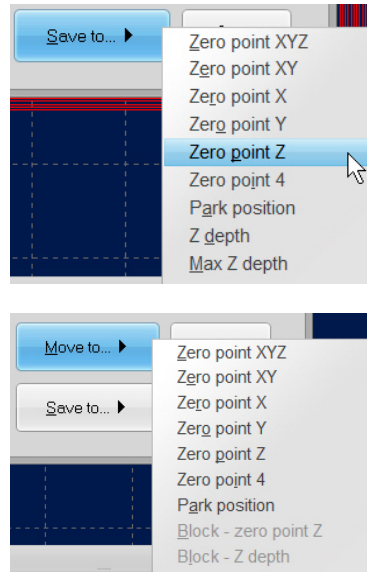
The second possibility involves moving discrete distances between 0.01mm to 100 mm and inches. The current set distance is displayed in the window. **WinPC-NC** moves this distance in any required direction and with both possible speeds, depending -on which button or key is pressed- In addition to the predefined distances, it is possible to enter any distance in the menu line.

Besides the pre-defined distances it is possible to enter any kind of distance in the entry field.

With enabled checkbox **Reset to endless** the individual selected distances are reset immediately in order to avoid new accidental travelling of remote distances.

Switching additional signals

Clicking the check boxes with the mouse all that is required is to switch the additional signals drilling spindle and coolant pump. This switches the signals on or off. Both signals are switched off when you exit the JOG function.



During manual movement, it is possible to move and store certain help points. After a position has been reached, it is easy to click the Save button to select the required point and save it permanently as a parameter.

Moving to saved help points is just as straightforward. All that is required is to click the *Move to* button and select the required help point. Then the machine moves to it.

Movement in progress can be interrupted at any time by clicking the Stop button. The JOG function can be exited by clicking the Exit button.

Automatic measurements of Z-heights

WinPC-NC can automatically determine the various Z-axis heights using a probe or surface block sensor. The sensor should be connected to an input on the LPT port using a cable to allow the block sensor to move freely. Depending on which Z-axis height you are measuring, place the probe against the clamped workpiece or the table surface to measure the maximum Z-axis depth.

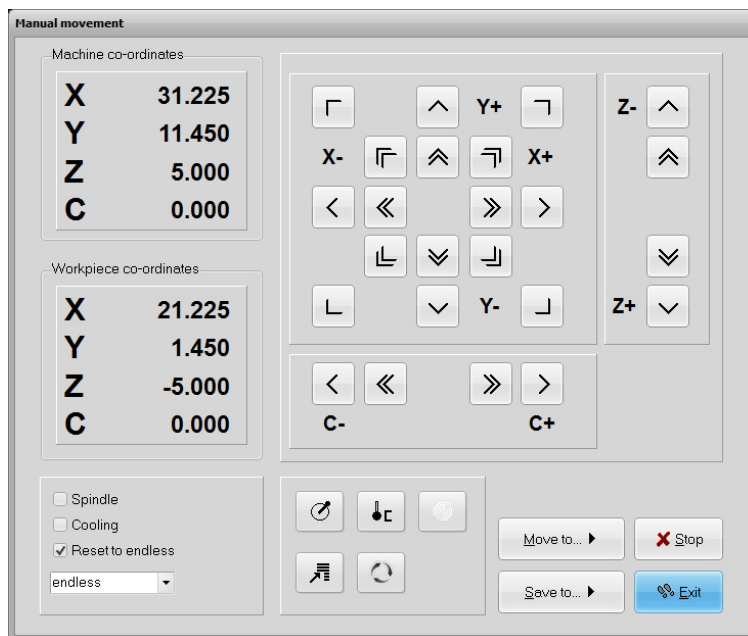
The measuring sequence involves several steps:

- Move the machine over the point to be measured
 - Place the probe or surface block
 - Start measuring process. **WinPC-NC** moves the z-axis down with slow speed until the probe contacts trips. Then the axis stops and **WinPC-NC** transfers the measured value together and probe width as parameter. The probe width can be defined as parameter.
-

Setting up the 4th axis

If a 4th axis is available, the appearance of the jog dialog box the 4th axis is some what different. In this case, it also includes buttons, for moving this axis slowly and quickly, as well as boxes for displaying the axis positions.

The used axis letter can be defined by parameter.



Jogging with the 4th axis