04 - Run a Part Program

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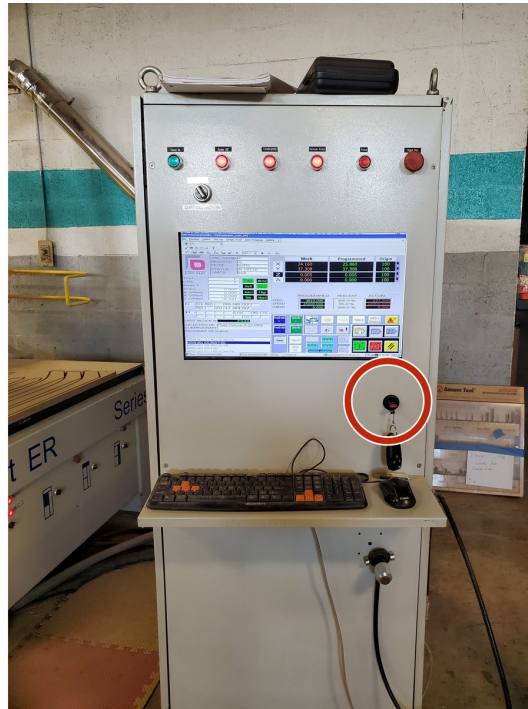## INTRODUCTION

Once you have your G Code program from VCarve, it is ready to run on the machine. This guide explains how.

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## Step 1 — Move the Part Program to The Controller

- ● Export your program from the CAM software to a USB drive.

- ● Plug your USB into the port on the lower right of the control panel.

Step 2 — Activate the Part Program
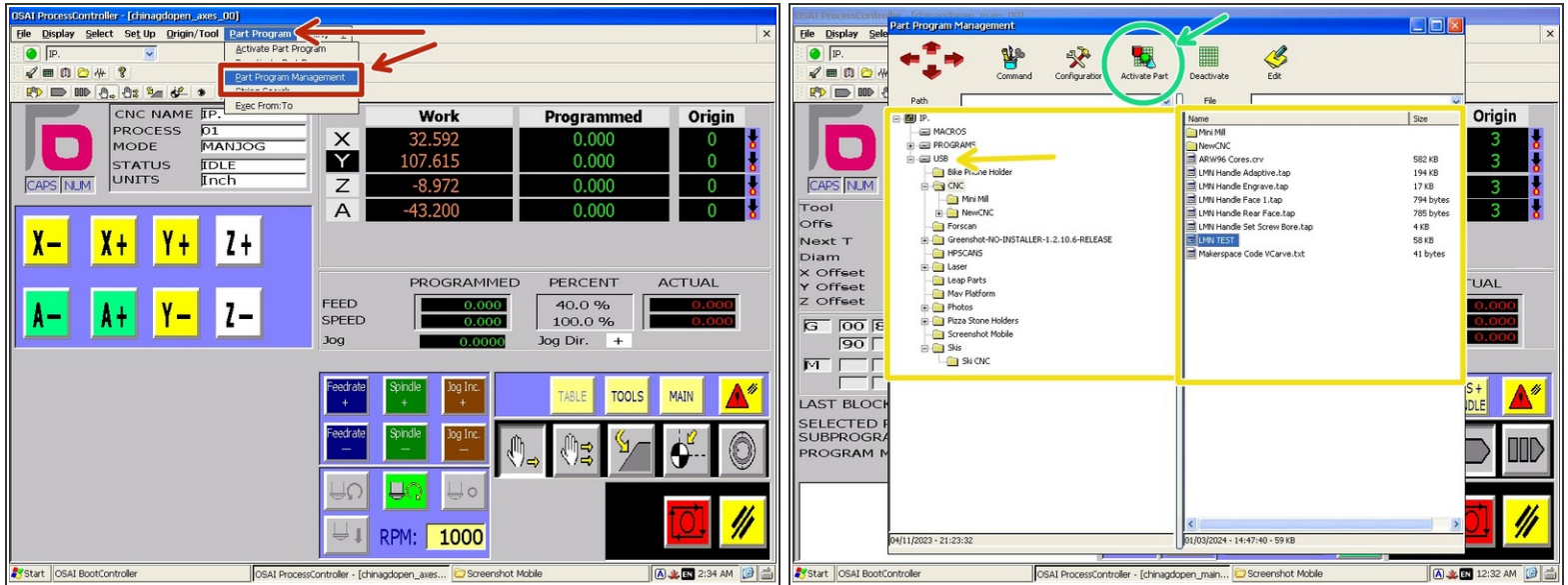
- ● Click "Part Program" in the top tool bar and select "Part Program Management."

- ● Navigate to and select the part program. It will be in the "USB" directory.

- ● Click "Activate Part" to load the program in the controller.

- ⓘ Alternately, click "Edit" to open the file in the text editor and manually modify or view the G code.

- ● Close the Part Program Management Window. Your program name should now appear in the "Selected Part Program" field.

Step 3 — Double Check Tools and Origin
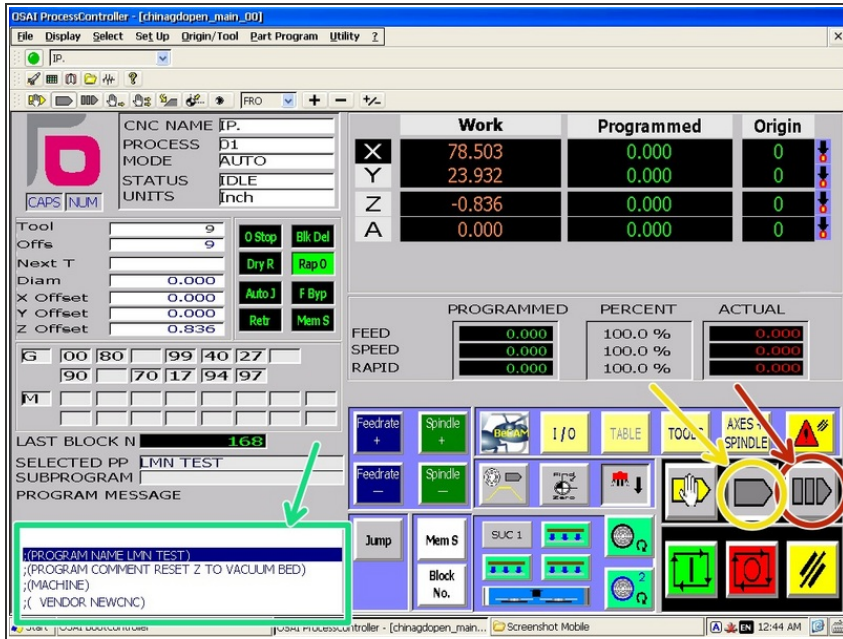
● Click the "Block-by-block Mode" button.

● Use the keyboard up and down keys to navigate between blocks (lines) of code.

● Check that the notes at the top of the program match what you anticipate based on the setup:

  ● Tools and their numbers match what is actually loaded.

  ● The origin you set matches the program origin.

● Use the up arrow key to scroll back to the top of the program. Click the "Auto Mode" button.

Step 4 — Turn On Dust Collector
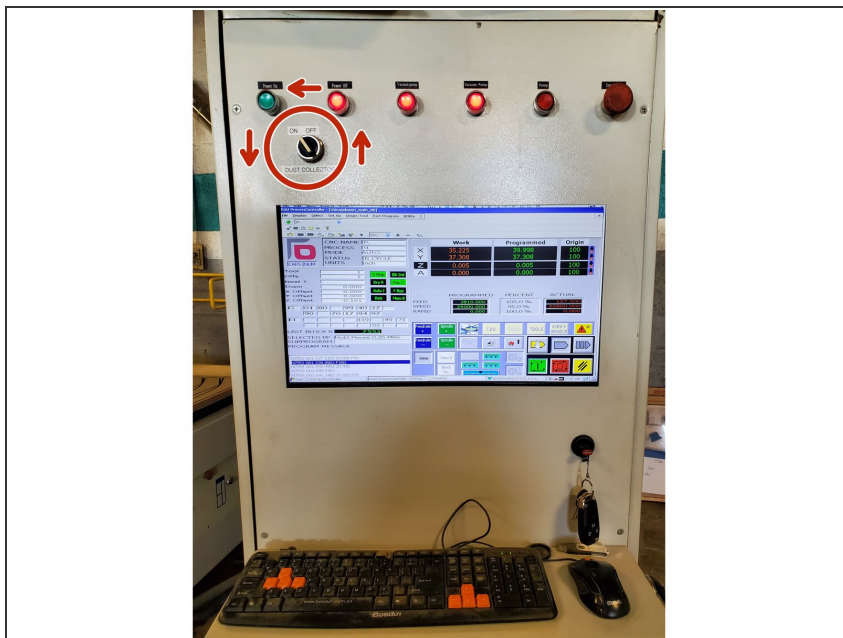
● Use the switch on the control panel to turn on the dust collector.

● Also make sure the vacuum pumps are on and valves open if using vacuum work holding.

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Step 5 — Start the Progam in Hand Wheel Prove Out Mode
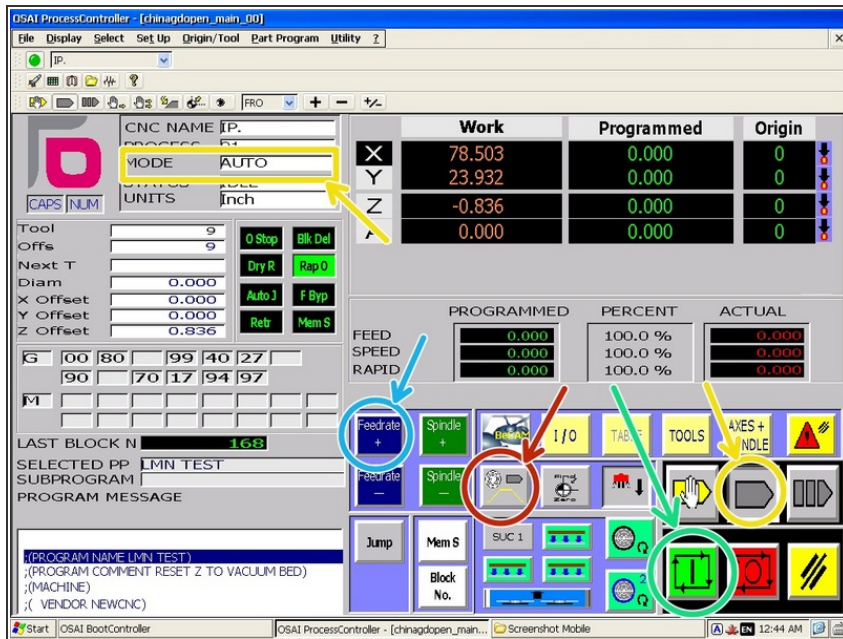
- ● Click the "Hand Wheel Prove Out Mode" Button.

- ● Ensure the controller is in "Auto" mode. Click the "Auto Mode" button if not.

- ● Click "Cycle Start."

- ● Rotate the hand wheel to slowly proceed through the initial moves of the program.

- ● If everything looks good, disable hand wheel prove out mode and click "Feedrate +" until the feedrate reaches 100% to continue cutting the part automatically.