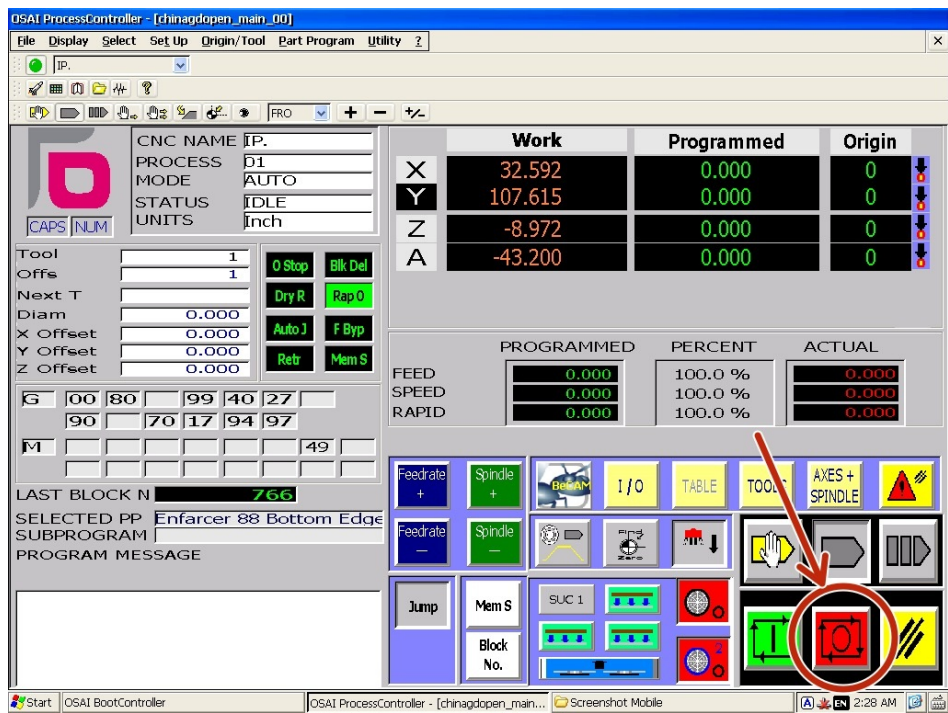


04a - Pause and Resume a Program

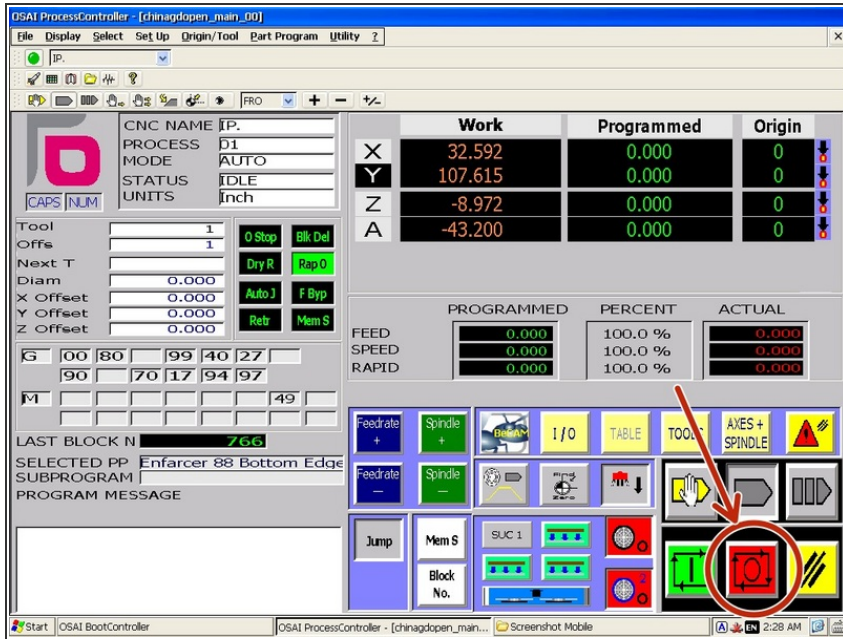


INTRODUCTION

Sometimes you may need to pause the machine during the execution of a cut. Here are some possible reasons:

- Too much dust and chip build up which needs to be cleared manually.
- A piece has come loose from the stock and you want to make sure it wont be in the way for the rest of the cut.
- You need to step away from the machine briefly for some reason.

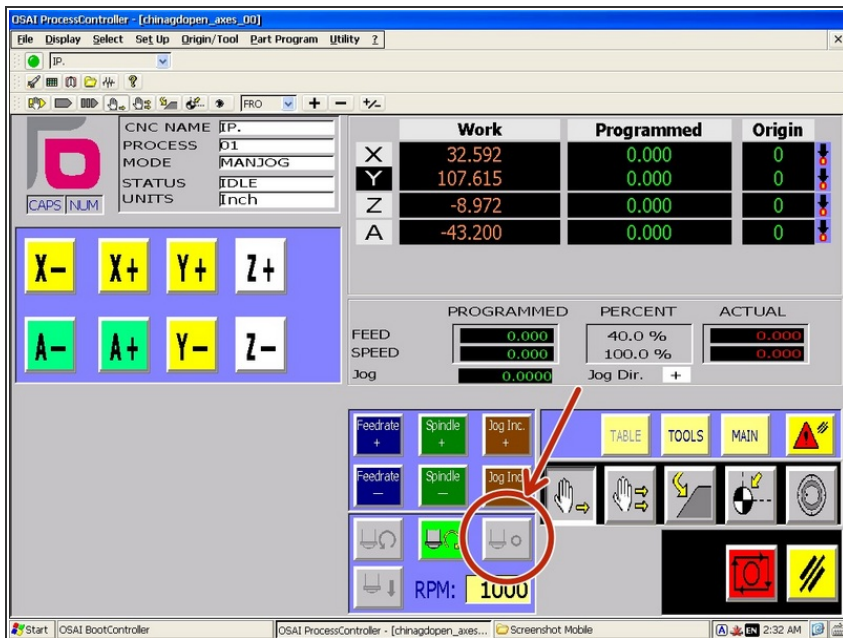
Step 1 — Enable Feed Hold Mode



- Click the "Hold" button.

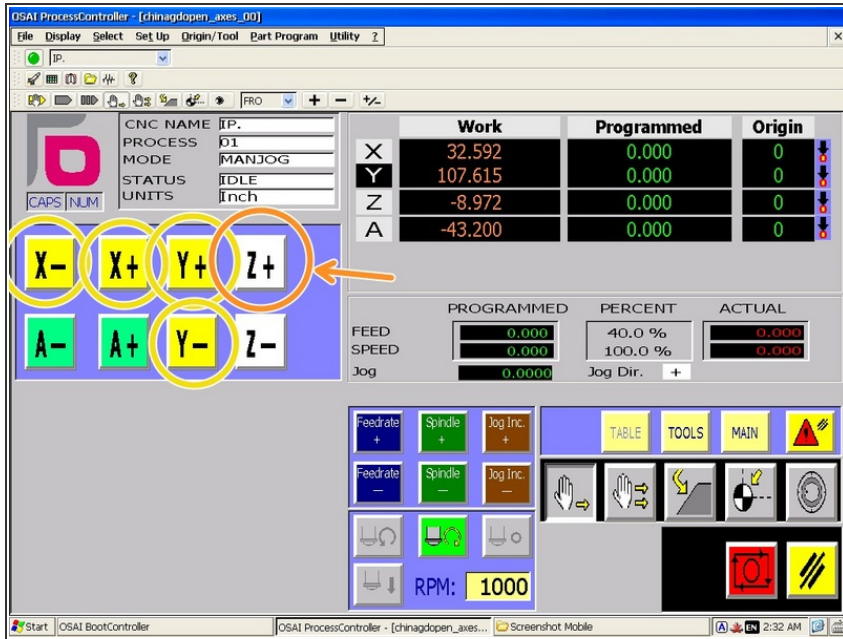
ⓘ The cutting movement will stop, but the spindle will keep rotating. The controller will change automatically to the "Axes+Spindle Screen."

Step 2 — Stop The Spindle



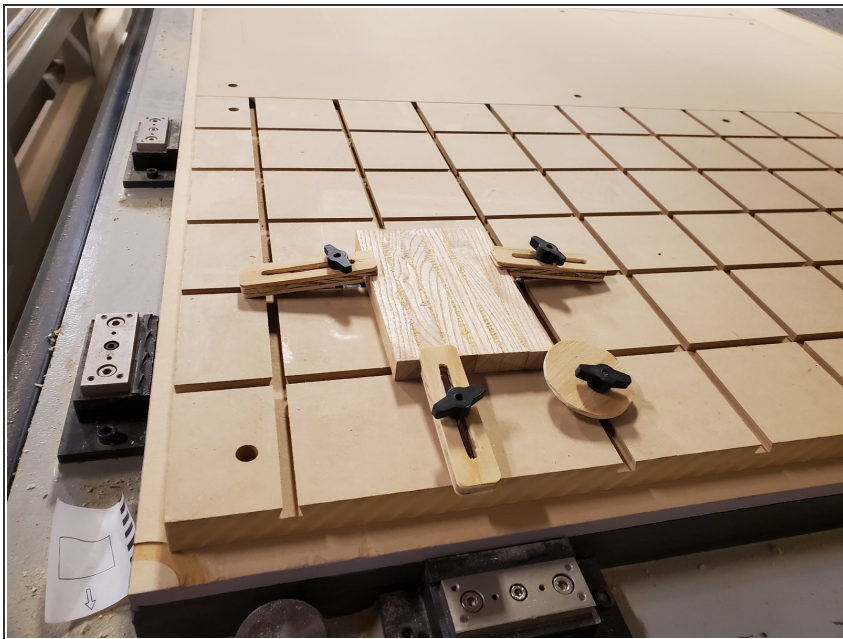
- On the "Axes+Spindle Screen," click the "spindle stop" button.

Step 3 — Jog the Spindle Out of the Way



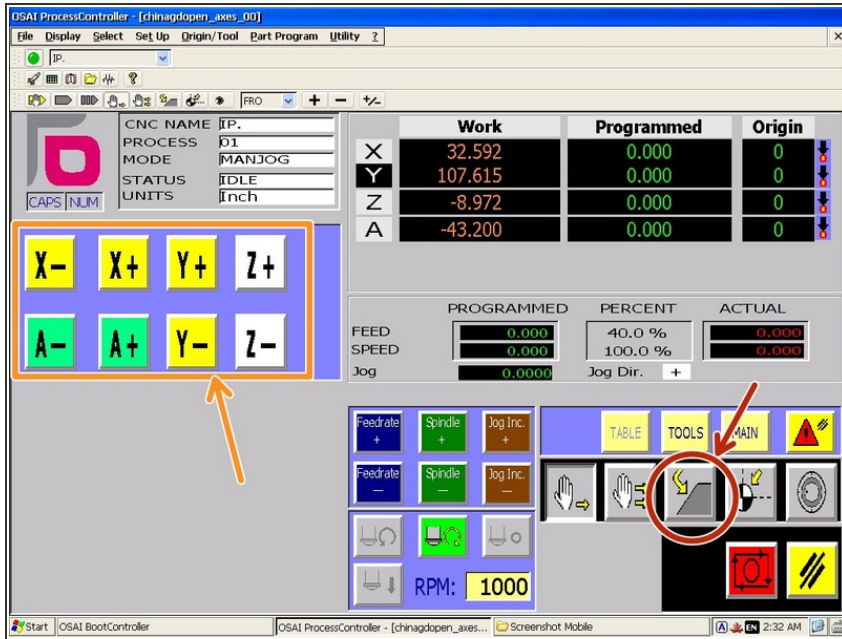
- Jog the spindle up and out of the work in the Z+ direction.
- Jog the spindle in X and Y to gain access to the material as needed.

Step 4 — Vacuum, Add Screws, etc...



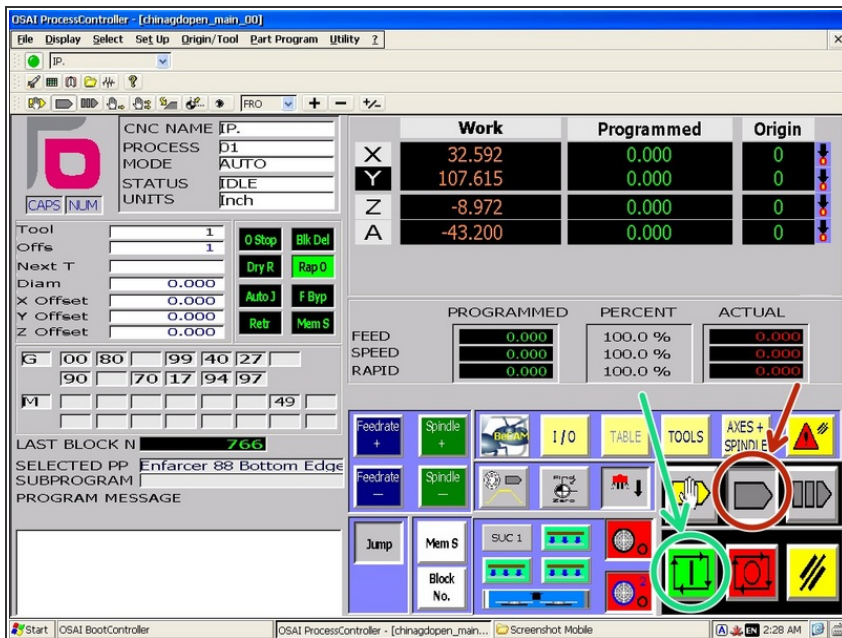
- Complete any tasks which prompted the pause. Clear loose parts, vacuum up dust, add screws or clamps.
- ⚠ If the work piece has shifted or is moved at all, the job can not be resumed as the origins will no longer match.

Step 5 — Return to Cutting Profile



- Click the "Return to Profile Mode" button.
- Hold the jog button for each axis you moved after pausing, making sure to do X and Y before Z.
- ① The jog movement should stop automatically when it reaches the position where the pause occurred.

Step 6 — Restart the Program



- Click the "Auto Mode" button.
- Click "Cycle Start/Run" button.
- ① The spindle will start and cutting will proceed once it reaches the programmed RPM.