

Altering an Existing Numerical Value

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Altering an existing numerical value in the Hurco control is easy. Simply follow these steps:

1. Highlight the value field that you want to alter
2. Type in the amount that you want to alter the current value by
3. Select the direction you would like to alter the number in (+/-)
4. Then press the ENTER key

Note: if you hit the + or – key first, you will CHANGE the current number to whatever you are about to enter. You MUST enter the amount or distance first, then the sign, then enter.

This procedure can be performed for ANY numerical value in the control.

PART SETUP																					
	MACHINE	PART																			
X	12.5449	0.0000	A	0.000	-0.000																
Y	7.1554	0.0000	C	0.000	-0.000																
Z	0.0000	16.4357	TOOL IN SPINDLE		0																
PART ZERO		SHIFT	SAFETY WORK REGION																		
X	12.5449		(-)	(+)																	
Y	7.1554		Z	-399.0000	399.0000																
Z	-16.4357	0.0000	X	-399.0000	399.0000																
IV	0.000		Y	-399.0000	399.0000																
V	0.000																				
				X/Y SKEW (DEG)	0.0000																
<table border="1"> <tr> <td>WORK OFFSETS</td> <td>F1</td> </tr> <tr> <td>TOOL SETUP</td> <td>F2</td> </tr> <tr> <td>PART PROGRAMMING</td> <td>F3</td> </tr> <tr> <td>PROGRAM PARAMETERS</td> <td>F4</td> </tr> <tr> <td>PART PROBING</td> <td>F5</td> </tr> <tr> <td>STORE MACHINE POSITION</td> <td>F6</td> </tr> <tr> <td>MORE →</td> <td>F7</td> </tr> <tr> <td>EXIT</td> <td>F8</td> </tr> </table>						WORK OFFSETS	F1	TOOL SETUP	F2	PART PROGRAMMING	F3	PROGRAM PARAMETERS	F4	PART PROBING	F5	STORE MACHINE POSITION	F6	MORE →	F7	EXIT	F8
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- In this example, let's say we are using an edgefinder to locate our part setup in the X-axis, and have stored the current position of the left edge of the part in the PART ZERO X field.
- Now we would like to alter the number by the radius of the edgefinder (.100")
- Notice the Part display reads 0.0000" for the X-axis

PART SETUP					
	MACHINE	PART			
X	12.5449	-0.1000	A	0.000	-0.000
Y	7.1554	0.0000	C	0.000	-0.000
Z	0.0000	16.4357	TOOL IN SPINDLE		0
PART ZERO		SHIFT	SAFETY WORK REGION		
X	12.6449		(-)	(+)	
Y	7.1554		Z	-399.0000	399.0000
Z	-16.4357	0.0000	X	-399.0000	399.0000
IV	0.000		Y	-399.0000	399.0000
V	0.000				
			X/Y SKEW (DEG)	0.0000	
<div style="display: flex; justify-content: space-between;"> <div> <p>WORK OFFSETS <small>F1</small></p> <p>TOOL SETUP <small>F2</small></p> <p>PART PROGRAMMING <small>F3</small></p> <p>PROGRAM PARAMETERS <small>F4</small></p> <p>PART PROBING <small>F5</small></p> <p>STORE MACHINE POSITION <small>F6</small></p> <p>MORE → <small>F7</small></p> <p>EXIT <small>F8</small></p> </div> </div>					

- Highlight the PART ZERO X field
- Type in .100, then +, then ENTER
- Notice the value changed by .100" (see previous screen for reference), and also notice that the current part position for the X-axis is now -.1000".