

Using Cycle Interrupt

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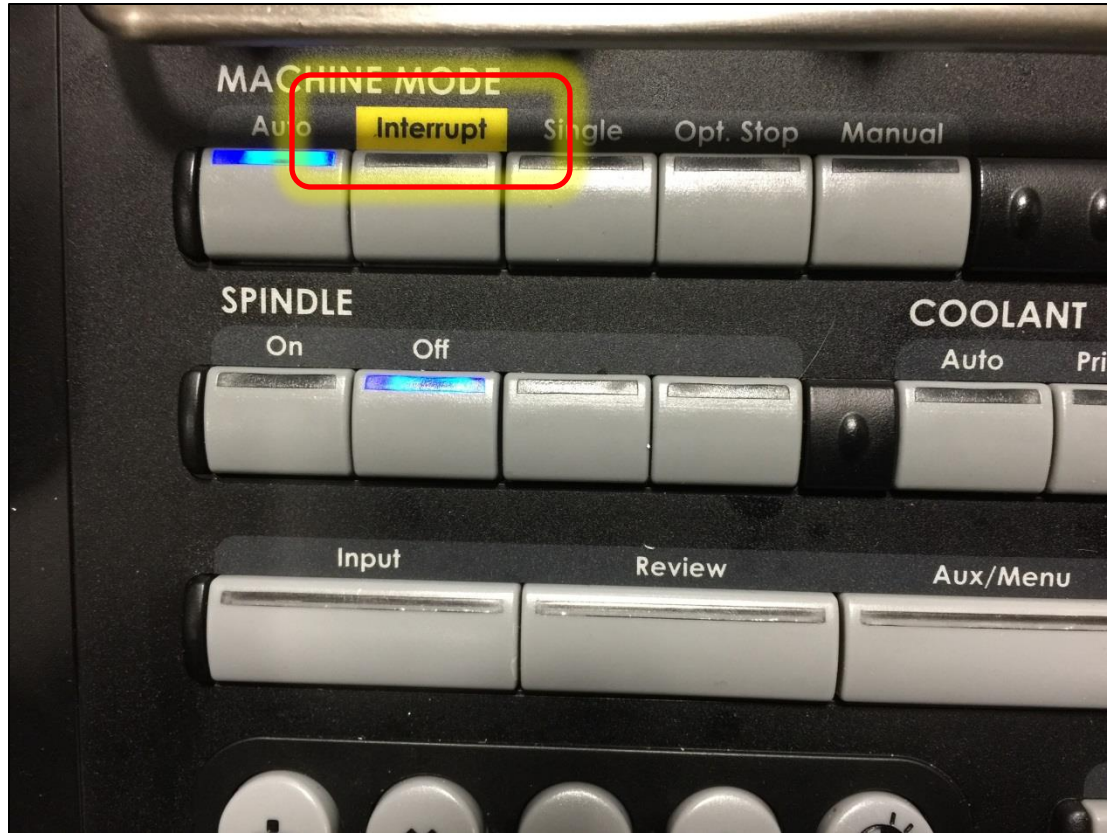
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Cycle Interrupt can be used anytime the operator wants to suspend the automatic operation of the machine – in either conversational or NC programs – and place the machine into a semi-manual mode.

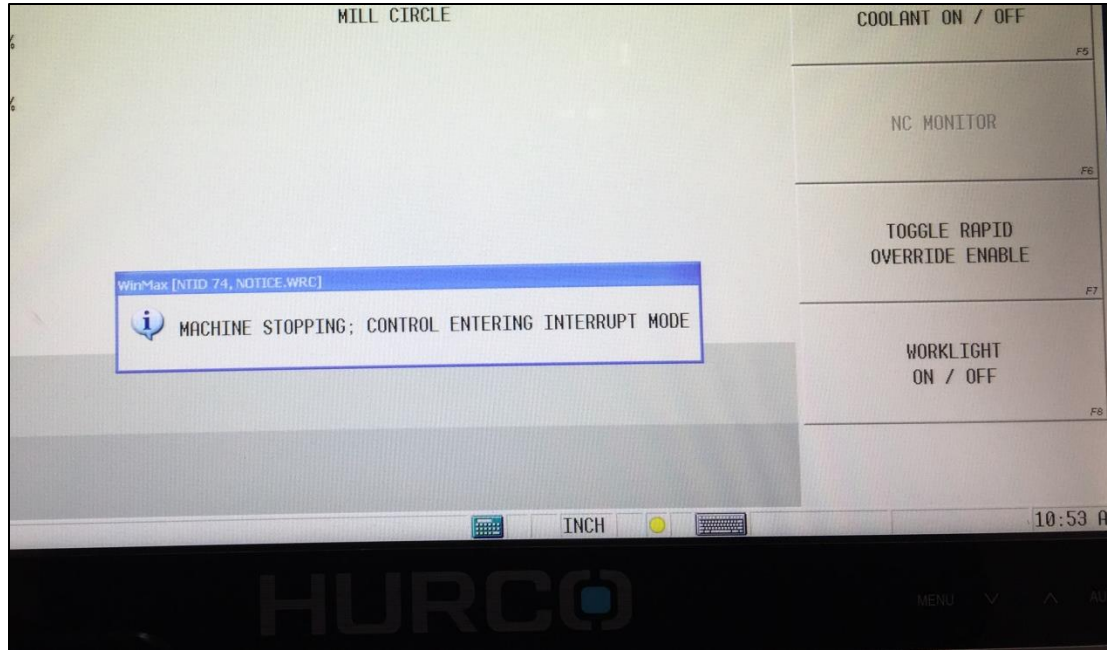
During a Cycle Interrupt the machine can be manually jogged – in any axis – to any desired location, for any reason.

Once automatic operation of the machine is required again, the operator can simply press the AUTO mode key, followed by the flashing START CYCLE button.

The machine will safely resume the previous operation from wherever it was interrupted.



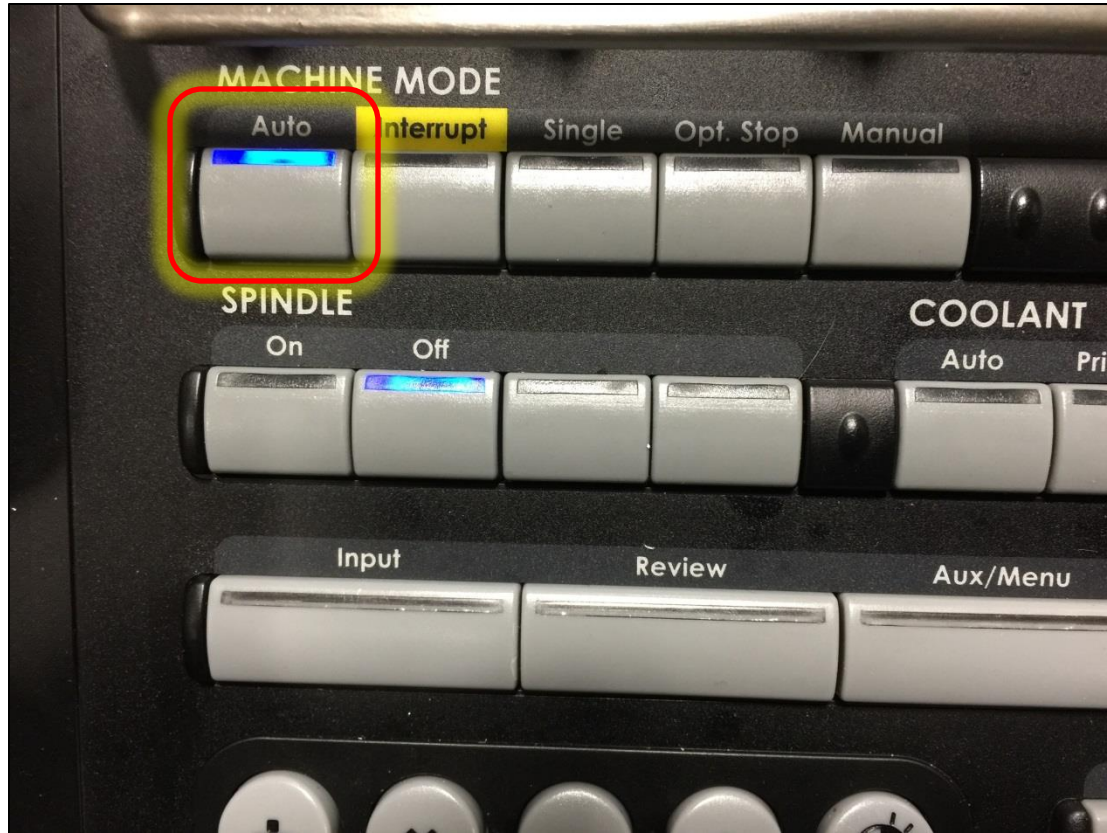
- During AUTO operation, press the INTERRUPT key to cause the machine to enter the cycle interrupt mode



- “CONTROL ENTERING INTERRUPT MODE” message should appear on the control screen while the Z-axis begins to retract to the full Z home position



- The control is now in a semi-manual mode, and any of the machine's axes can be jogged
- Simply select the axis that you wish to move with the axis jog selector switch, and move the axis to the desired location
- **NOTE:** do not press any other keys on the control panel, or you will force the control to exit the interrupt mode - note that the MANUAL key is automatically highlighted



- To resume automatic operation, simply press the AUTO mode key, followed by the flashing START CYCLE button
- The machine will safely reposition to the necessary location and resume the program from where it was interrupted