

Using Recovery Restart

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Recovery Restart is a way to restart a program – either conversational or NC – in the middle, without the need to enter extra code or start on any particular line in the program.

Simply cursor to the line you wish to start on, manually set or auto set the restart marker, and press START CYCLE to begin machining.

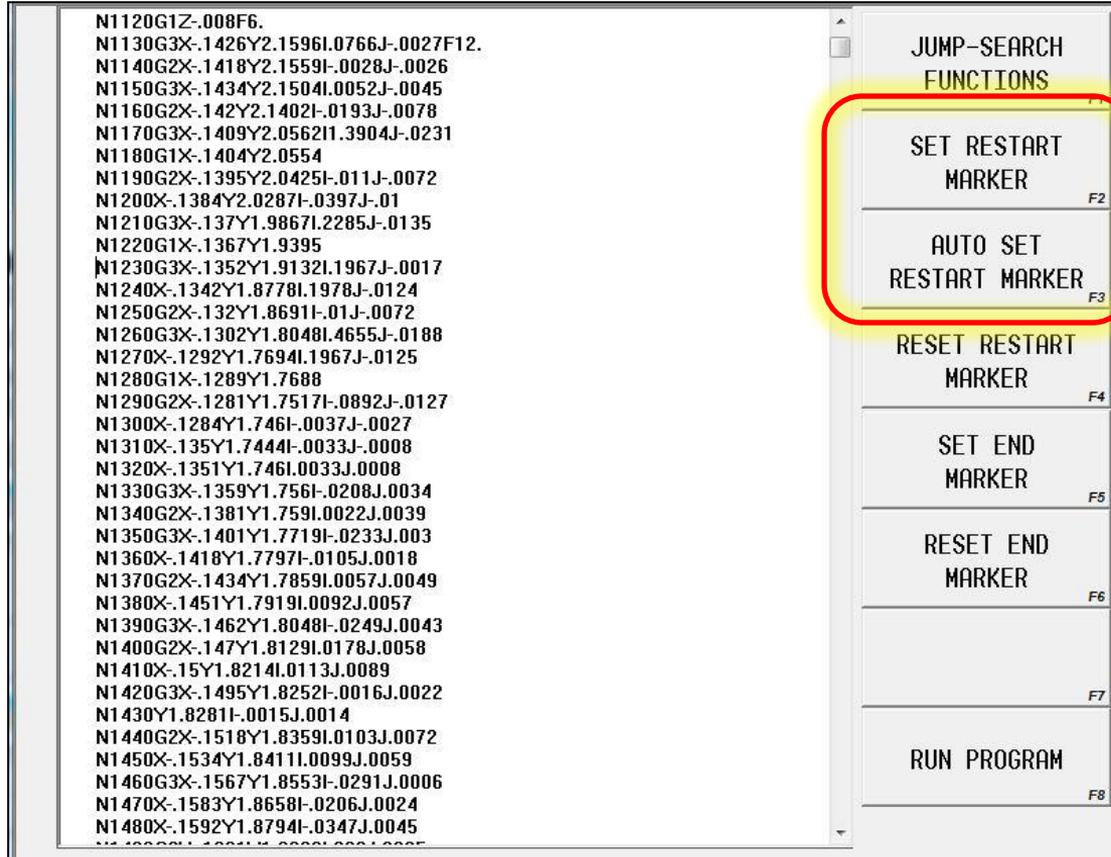
The control will buffer any necessary modal codes from the program, above the location where the restart marker was placed, and begin movement from the desired location.

A Recover Restart is a single-shot execution, and will disappear once the program has been completed – meaning that the program will begin from the beginning of the file the next time it is started.

Restarting an NC Program

AUTO (NC)		NO <small>F1</small>
PART PROGRAM PATH	C:\Users\copem\Desktop\JH WES TATTOO\	YES <small>F2</small>
PART PROGRAM NAME	JH WES TATTOO.FNC	LINEAR THERMAL COMPENSATION <small>F3</small>
		CHECK FOR ERRORS <small>F4</small>
ENABLE LINEAR THERMAL COMPENSATION	NO	COMPUTE ESTIMATED RUN TIME <small>F5</small>
		RECOVERY RESTART <small>F6</small>
		DRY RUN <small>F7</small>
		RUN PROGRAM <small>F8</small>

- Once the AUTO menu has been selected, press the RECOVERY RESTART softkey – instead of RUN PROGRAM – to enter the recovery restart menu



- There are two ways to use recover restart:

1. Selecting the AUTO SET RESTART MARKER softkey will place the restart marker on the last line of the program that was completed before it was stopped
2. Using the arrow keys, place the cursor on the line of the program where you want to begin, and select the SET RESTART MARKER softkey



- Select the RUN PROGRAM softkey to begin buffering the program into memory
- Depending on how large the program is, and how far down the program the restart marker has been placed, this could take several minutes
- Once the buffering has been completed, press the flashing START CYCLE button to begin machining

Restarting a Conversational Program

AUTO
(CONVERSATIONAL)

PART PROGRAM PATH

PART PROGRAM NAME

START BLOCK HOLES

END BLOCK MILL CIRCLE

ENABLE LINEAR THERMAL COMPENSATION

USE EDITING FILE F1

FEED & SPEED OPTIMIZATION F2

LINEAR THERMAL COMPENSATION F3

CHECK FOR ERRORS F4

COMPUTE ESTIMATED RUN TIME F5

RECOVERY RESTART F6

DRY RUN F7

RUN PROGRAM F8

- Once you are in the AUTO screen, enter the START and END range of blocks that you wish to run in the recovery sequence
- Select the RECOVERY RESTART softkey – instead of RUN PROGRAM – to enter the recovery restart menu

AUTO
(CONVERSATIONAL)

PART PROGRAM PATH

PART PROGRAM NAME

START BLOCK

 HOLES

END BLOCK

 MILL CIRCLE

USE EDITING
FILE

F1

FEED & SPEED
OPTIMIZATION

F2

LINEAR THERMAL
COMPENSATION

F3

CHECK FOR ERRORS

F4

COMPUTE ESTIMATED
RUN TIME

F5

RECOVERY
RESTART

F6

F7

F8

WinMax [NTID 201, WINMAX.WRC]



Starting hole sub-operation (max = 2)

WinMax [NTID 200, WINMAX.WRC]



Starting location (max = 6)

OK

WinMax [NTID 196, WINMAX.WRC]



Starting peck level (max = 4)

OK

Cancel

- The program may begin immediately after the RECOVERY RESTART softkey has been selected
- Or, depending on the operations in the program, you may be prompted to answer one or more of the pop-up questions displayed in the image