Using Recovery Restart



Hurco Applications applications@hurco.com 317-614-1549 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	
PART PROGRAM PATH	C:\Users\copem\Desktop\JH WES TATTOO\		YES
PART PROGRAM NAME	JH WES TATTOO.FNC	•	F2
			LINEAR THERMAL COMPENSATION
ENABLE LINEAR THERMAL COMPENSATION NO -			CHECK FOR ERRORS
			COMPUTE ESTIMATED RUN TIME
			RECOVERY RESTART
			DRY RUN
			RUN PROGRAM

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



mind over metal[®]

N1120G1Z008F6. N1130G3X1426Y2.1596I.0766J0027F12. N1140G2X1418Y2.1559I0028J0026 N1150G3X1434Y2.1504I.0052J0045	JUMP-SEARCH FUNCTIONS
N1160G2X142Y2.1402I0193J0078 N1170G3X1409Y2.0562I1.3904J0231 N1180G1X1404Y2.0554 N1190G2X1395Y2.0425I011J0072 N1290X1394Y2.0935Y_0.02071_01	SET RESTART MARKER
N1210G3X136412.0207F.02057J01 N1210G3X1367Y1.9867I.2285J0135 N1220G1X1367Y1.9395 N1230G3X1352Y1.9132I.1967J0017 N1240X1342Y1.8778I.1978J0124	AUTO SET RESTART MARKER
N1250G2X132Y1.8691I01.J0072 N1260G3X1302Y1.8048I.4655.J0188 N1270X1292Y1.7694I.1967J0125 N1280G1X1289Y1.7688 N1290G2X1281Y1.7517I0892J0127	RESET RESTART MARKER
N1300X1284Y1.746H0037J0027 N1310X135Y1.744H0033J0008 N1320X1351Y1.746H.0033J.0008 N1330G3X1359Y1.756H0208J.0034	SET END Marker
N134062X-1381Y1.7591.00223.0039 N1350G3X-1401Y1.7719I-0233J.003 N1360X-1418Y1.7797I-0105J.0018 N1370G2X-1434Y1.78591.0057J.0049 N1380X-1451Y1.7919I.0092J.0057	RESET END MARKER
N1390G3X1462Y1.8048I0249J.0043 N1400G2X147Y1.8129I.0178J.0058 N1410X15Y1.8214I.0113J.0089 N1420G3X1495Y1.8252I0016J.0022	F7
N1430T1.0201100153.0014 N1440G2X1518Y1.8359I.0103J.0072 N1450X1534Y1.84111.0099J.0059 N1460G3X1567Y1.8553I0291J.0006 N1470X1583Y1.8658I0206J.0024	RUN PROGRAM
N1480X1592Y1.8794I0347J.0045	-

mind over metal

- 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

HURCO

	N1120G1Z008F6. N1130G3X1426Y2.1596I.0766J0027F12. N1140G2X1418Y2.1559I0028J0026 N1150G3X1434Y2.1504I.0052J0045 N1150G3X1434Y2.1504I.0052J0045	^ 	JUMP-SEARCH FUNCTIONS
	N1160G2X-142Y2.1402F.0193J0078 N1170G3X1409Y2.0562l1.3904J0231 N1180G1X1404Y2.0554 N1190G2X1395Y2.0425I011J0072 N1200X1384Y2.0287I0397J01		SET RESTART MARKER
R	N1210G3X-137Y1.98671.2285J0135 N1220G1X1367Y1.9395 N1230G3X1352Y1.91321.1967J0017 N1240X1342Y1.87781.1978J0124		auto set Restart Marker _F
	N1250G2X132Y1.8691101J0072 N1260G3X1302Y1.80481.4655J0188 N1270X1292Y1.7694I.1967J0125 N1280G1X1289Y1.7688 N1290G2X1281Y1.7517I0892J0127		RESET RESTART MARKER
	N1300X1284Y1.746I0037J0027 N1310X135Y1.7444I0033J0008 N1320X1351Y1.746I.0033J.0008 N1330G3X1359Y1.756I0208J.0034		set end Marker
	N1 340G2X1 381 Y1.7591.0022J.0039 N1 350G3X1401 Y1.7719I0233J.003 N1 360X1418 Y1.7797I0105J.0018 N1 370G2X1434 Y1.7859I.0057J.0049 N1 380X1451 Y1.7919I.0092.L0057		reset end Marker
	N1390G3X-1462Y1.8048E-0249J.0043 N1400G2X-147Y1.8129I.0178J.0058 N1410X-15Y1.8214I.0113J.0089 N1420G3X-1495Y1.8252E-0016J.0022		
	N1430Y1.8281F.0015J.0014 N1440G2X-1518Y1.8359I.0103J.0072 N1450X-1534Y1.8411I.0099J.0059 N1460G3X-1567Y1.8553I-0291J.0006 N1470X-1583Y1.8658I-0206J.0024		RUN PROGRAM
	N1480X-1595Y1.8794I-0347J.0045	-	

mind over metal

- 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





mind over metal

- 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

HURCO



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



mind over metal