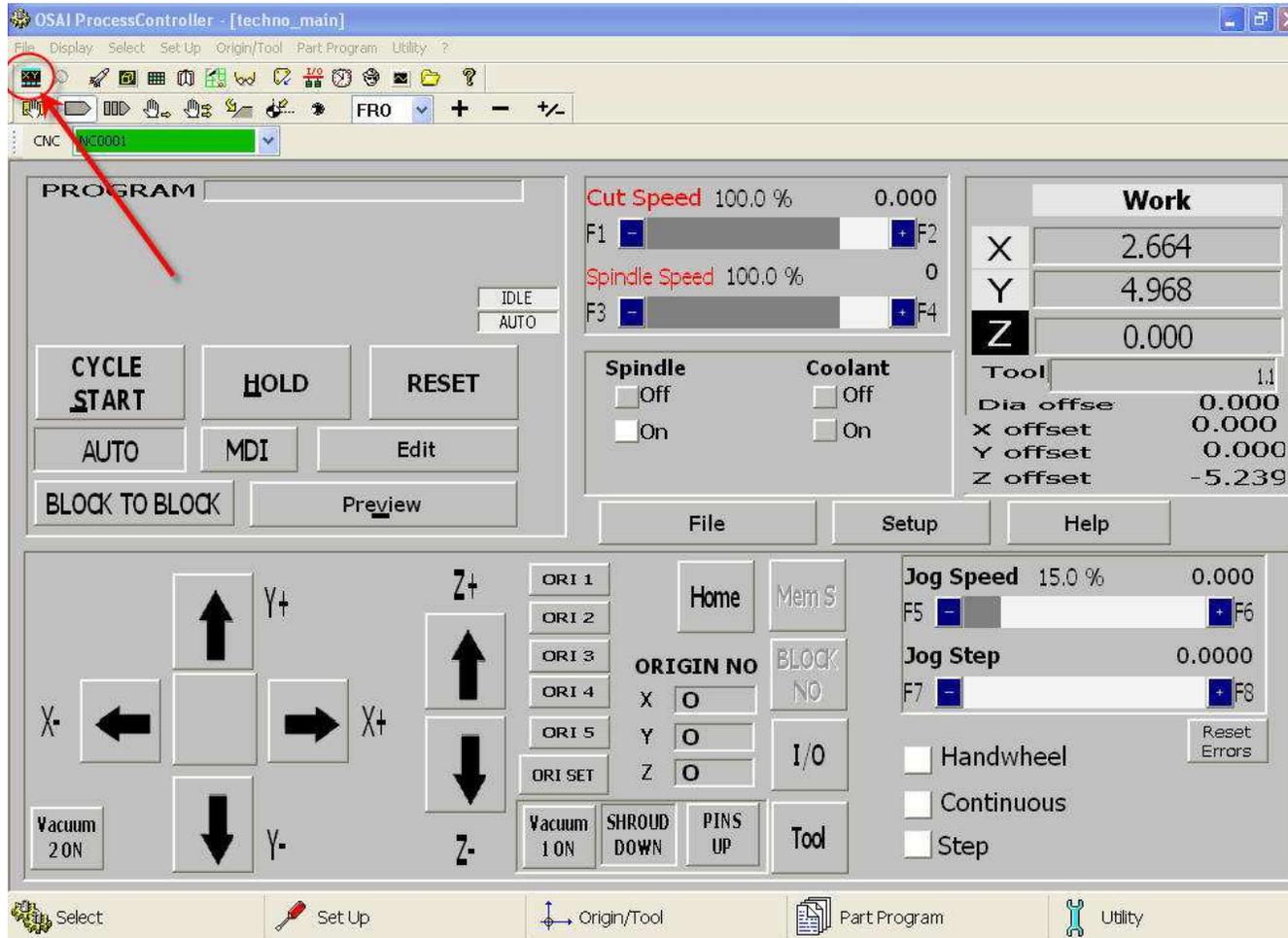


## How To Learn the Probe Location on HDS Machines

*Note: To navigate through the menus in the controller screens: use F10 to scroll the highlight bar and then the corresponding function key to select what's highlighted.*



*Click on the 'CNC Vision' icon to bring up the controller screen.*

```

PROCESS CONTROLLED:1  CAPS ON  SCREEN 1 OF 2  TIME: 16:36:30
PROC:1 IDLE  AUTO  OPT-STOP BLK-DELETE  FEED-BYPASS  RETRACE
  AXIS  WORK  [inch]  PROGRAMMED  ORIGIN
  X  2 . 6 6 4  0 . 0 0 0  0
  Y  4 . 9 6 8  0 . 0 0 0  0
  Z  0 . 0 0 0  0 . 0 0 0  0

S:  0.000  F:  0.00000  RAP:  0.00000  ACT: T1.1
100.0% 0.000  100.0% 0.00000  100.0% 0.00000  NXT:
G: 00 80 99 40 29 90 70 17 94 97  d: 0.000000
M: 48  Z: -5.238721
JOG: 0.00000  Y: 0.000000

PROGRAMS:

POS DISPLAY  NEXT DISPLAY  SELECT PROCESS  ENLARGE  HELP
  AUTO  MANUAL  PART PROGRAM  VARIABLES  GEN SOFTWARES
MACHINE SET-UP  TABLES  DIAGNOSTICS  UTILITY
(F5) (F6) (F7) (F8) (F9)

```

*Hit F4 to go to the top menu. Use F10 to move the highlight bar until it is on the bottom line, and then hit F9 to go to the 'Utility' menu.*

```
PROCESS CONTROLLED:1  CAPS ON  SCREEN 1 OF 2  TIME: 16:37:09
PROC:1 IDLE  AUTO  OPT-STOP BLK-DELETE  FEED-BYPASS  RETRACE
  AXIS  WORK  [inch]  PROGRAMMED  ORIGIN
  X  2 . 6 6 4  0 . 0 0 0  0
  Y  4 . 9 6 8  0 . 0 0 0  0
  Z  0 . 0 0 0  0 . 0 0 0  0

S:  0.000  F:  0.00000  RAP:  0.00000  ACT: T1.1
100.0% 0.000  100.0% 0.00000  100.0% 0.00000  NXT:
G: 00 80 99 40 29 90 70 17 94 97  d: 0.000000
M: 48  Z: -5.238721
JOG: 0.00000  Y: 0.000000

PROGRAMS:

AMP  PLUS  DOS SHELL  PERTIPHERALS  HELP
(F5) (F6) (F7) (F8) (F9)
```

*Go to the 'AMP' menu.*

Adjust Machine Parameters      date:29/03/2012      time:16:37:25

SELECTED AMP 3	ACTIVATED AMP 3	RUNNING AMP 3
-------------------	--------------------	------------------

```
-- AMP DIRECTORY LIST --                               COMPILED
0 - DEFAULT                                             N
1 -
2 - EXITECH - 3 ANALOGUE AXES + SPINDLE  25-4-2011     Y
3 - TECHNO - 3 ANALOGUE AXES + SPINDLE  11-OCT-2011- INCHES  Y
```

ACTIVATE (F5)	SELECT BACKUP (F6)	EDIT COMMENT DELETE (F7)	PRINT (F8)	HELP EXIT (F9)
------------------	--------------------------	--------------------------------	---------------	----------------------

*Hit 'Select' to activate the current configuration.*

```
Adjust Machine Parameters      amp3      date:29/03/2012      time:16:38:13
Status :

AMP Ready: use Softkey

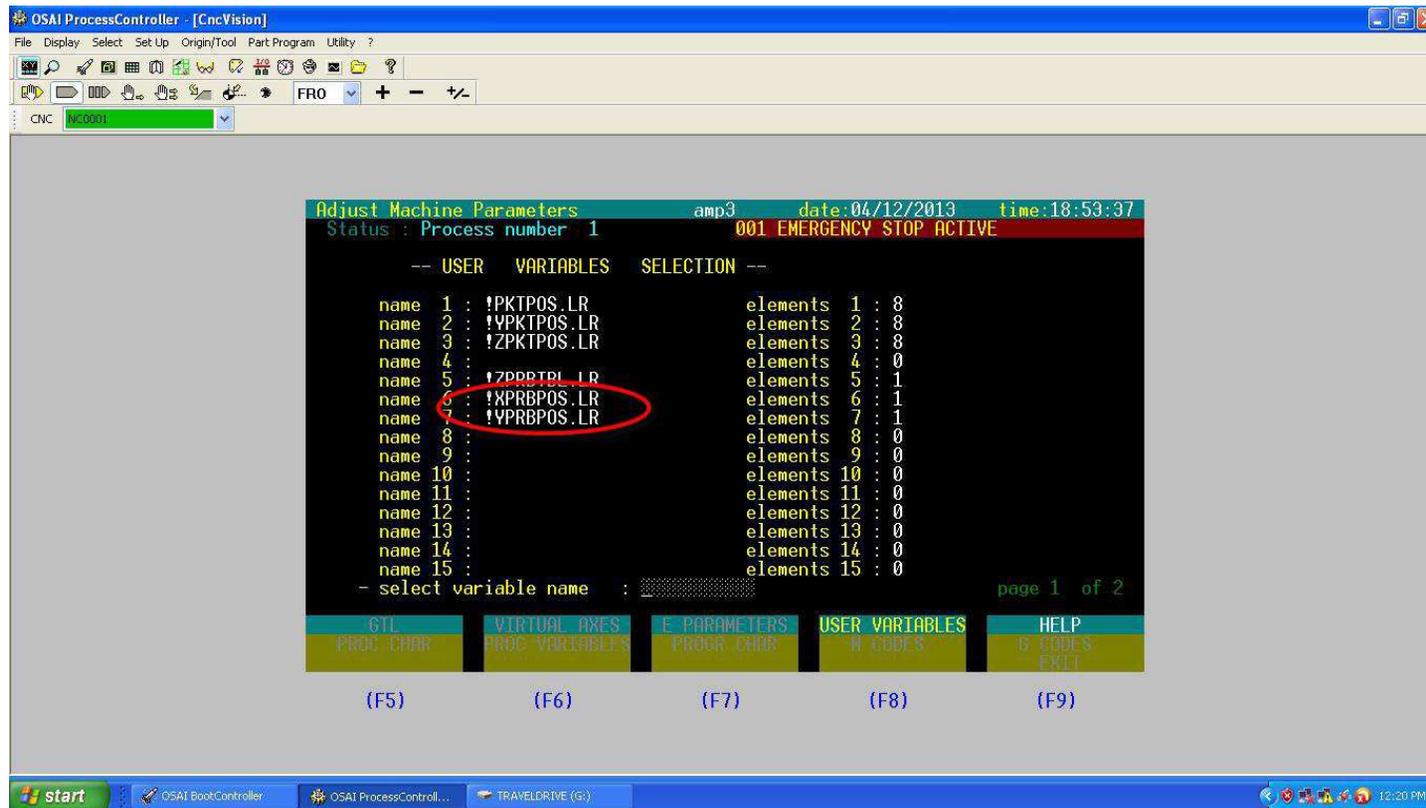
HARDWARE      GENERAL INFO      LOGIC CONF      OPTIONS      HELP
SELECT PROCESS PROCESS CONFIG  AXIS CONFIG      HUMAN INTERF
(F5)          (F6)          (F7)          (F8)          (F9)
EXIT
```

*Go to 'Process Config'*

```
Adjust Machine Parameters      amp3      date:29/03/2012      time:16:38:31
Status : Process number 1

GTL      VIRTUAL AXES      E PARAMETERS      USER VARIABLES      HELP
PROC CHAR  PROC VARIABLES  PROGR CHAR      H CODES      G CODES
(F5)      (F6)      (F7)      (F8)      EXIT
(F5)      (F6)      (F7)      (F8)      (F9)
```

*Go to 'User Variables'*



*This is where the coordinates will be stored.*

```

Adjust Machine Parameters      amp3      date:29/03/2012      time:16:39:20
Status : Process number 1

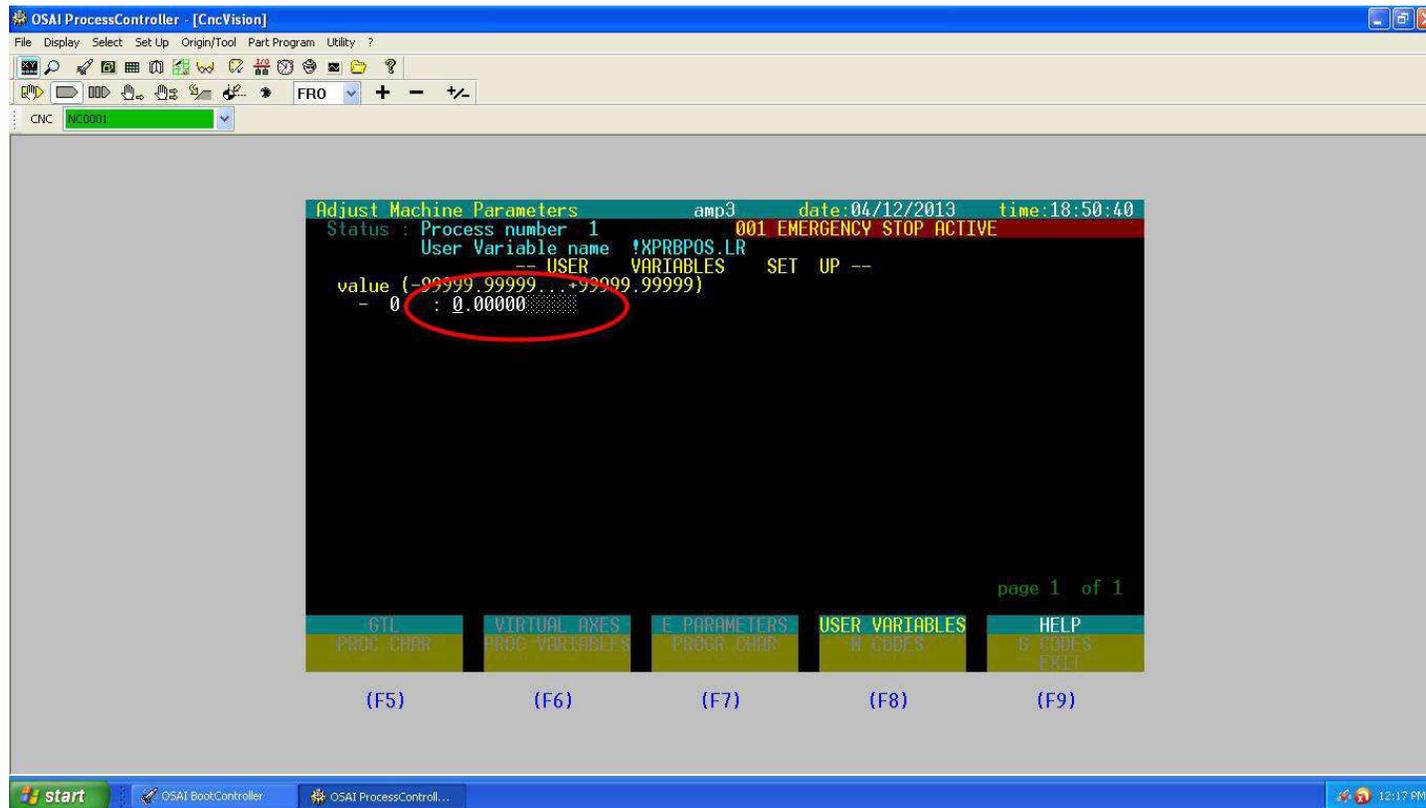
-- USER  VARIABLES  SELECTION --

name 1 : !PKTPOS.LR      elements 1 : 8
name 2 : !YPKTPOS.LR    elements 2 : 8
name 3 : !ZPKTPOS.LR    elements 3 : 8
name 4 :                 elements 4 : 0
name 5 : !ZPRBTBL.LR    elements 5 : 1
name 6 : !XPRBPOS.LR    elements 6 : 1
name 7 : !YPRBPOS.LR    elements 7 : 1
name 8 :                 elements 8 : 0
name 9 :                 elements 9 : 0
name 10 :                elements 10 : 0
name 11 :                elements 11 : 0
name 12 :                elements 12 : 0
name 13 :                elements 13 : 0
name 14 :                elements 14 : 0
name 15 :                elements 15 : 0
- select variable name : !PKTPOS.LR
page 1 of 2

GTL          VIRTUAL AXES  E PARAMETERS  USER VARIABLES  HELP
PROC CHAR   PROC VARIABLES  PROC CHAR    M CODES         G CODES
(F5)        (F6)          (F7)         (F8)            (F9)

```

*‘!XPRBPOS.LR’ is the X position of the probe. ‘!YPRBPOS.LR’ is the Y position. Type the directory you would like to edit and hit ‘Enter’ on the number pad.*



*There should already be numbers in here. Adjust accordingly. Hit 'Enter' on the number pad.*

```
Adjust Machine Parameters      amp3      date:29/03/2012      time:16:40:42
Status :
      -- Exit --

Translate new parameters ? (Y/N) Y

HARDWARE      GENERAL INFO      LOGIC CONF      OPTIONS      HELP
SELECT PROCESS  PROCESS CONFIG  OWS CONFIG     HUMAN INTERF

(F5)          (F6)          (F7)          (F8)          (F9)
EXIT
```

*Navigate back through the menus by hitting 'Exit'. When prompted to 'Translate New Parameters', type 'Y' and hit 'Enter'.*

**Reminder: You will have to re-start the controller for these changes to take effect.**

**IMPORTANT!! DO NOT exit out of the AMP settings without determining if you want to 'Translate New Parameters'. This could result in the controller settings not being compiled – which would mean that the machine WILL NOT run. Even if you say 'N', that's fine. However, the changes you made will not be saved.**