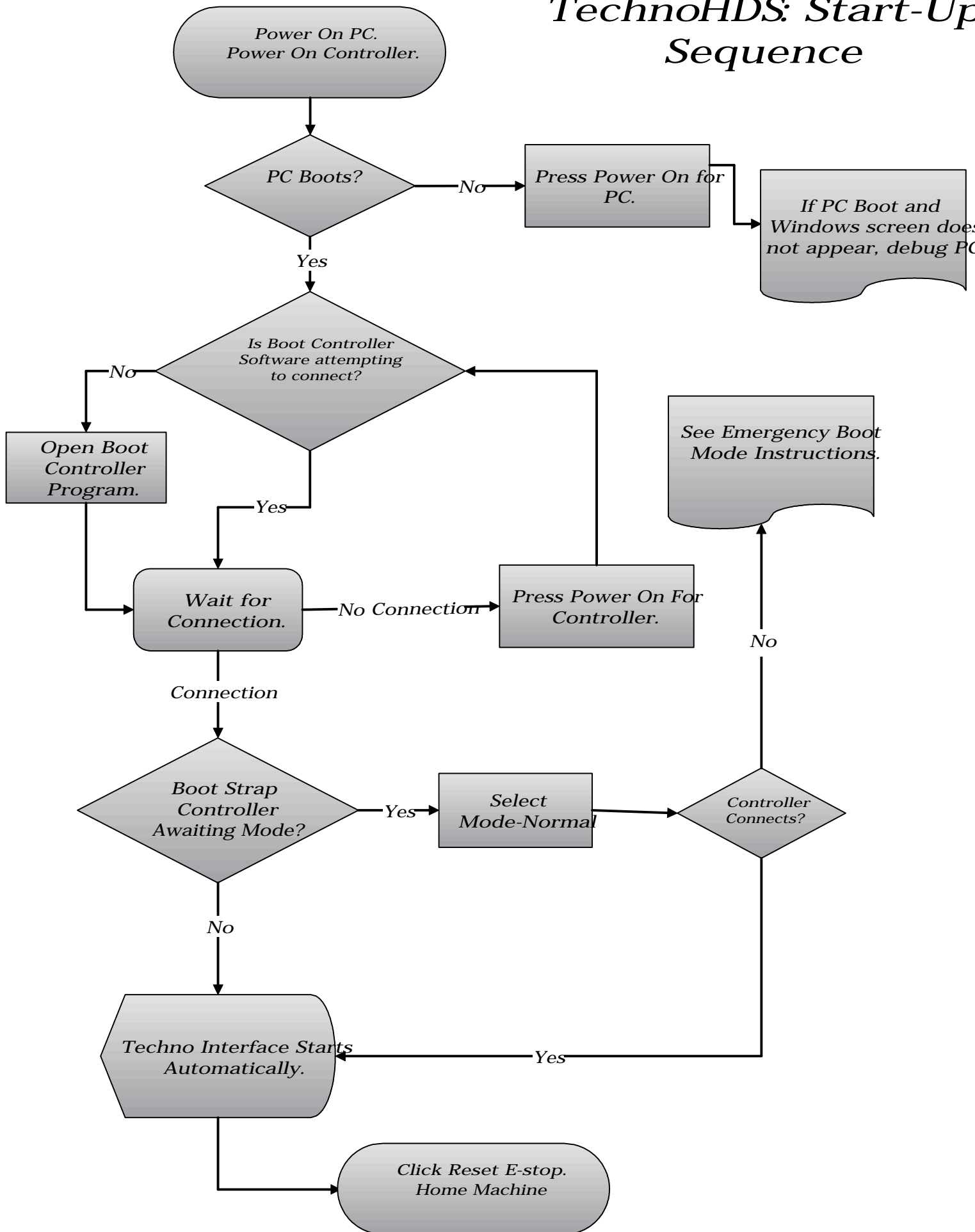
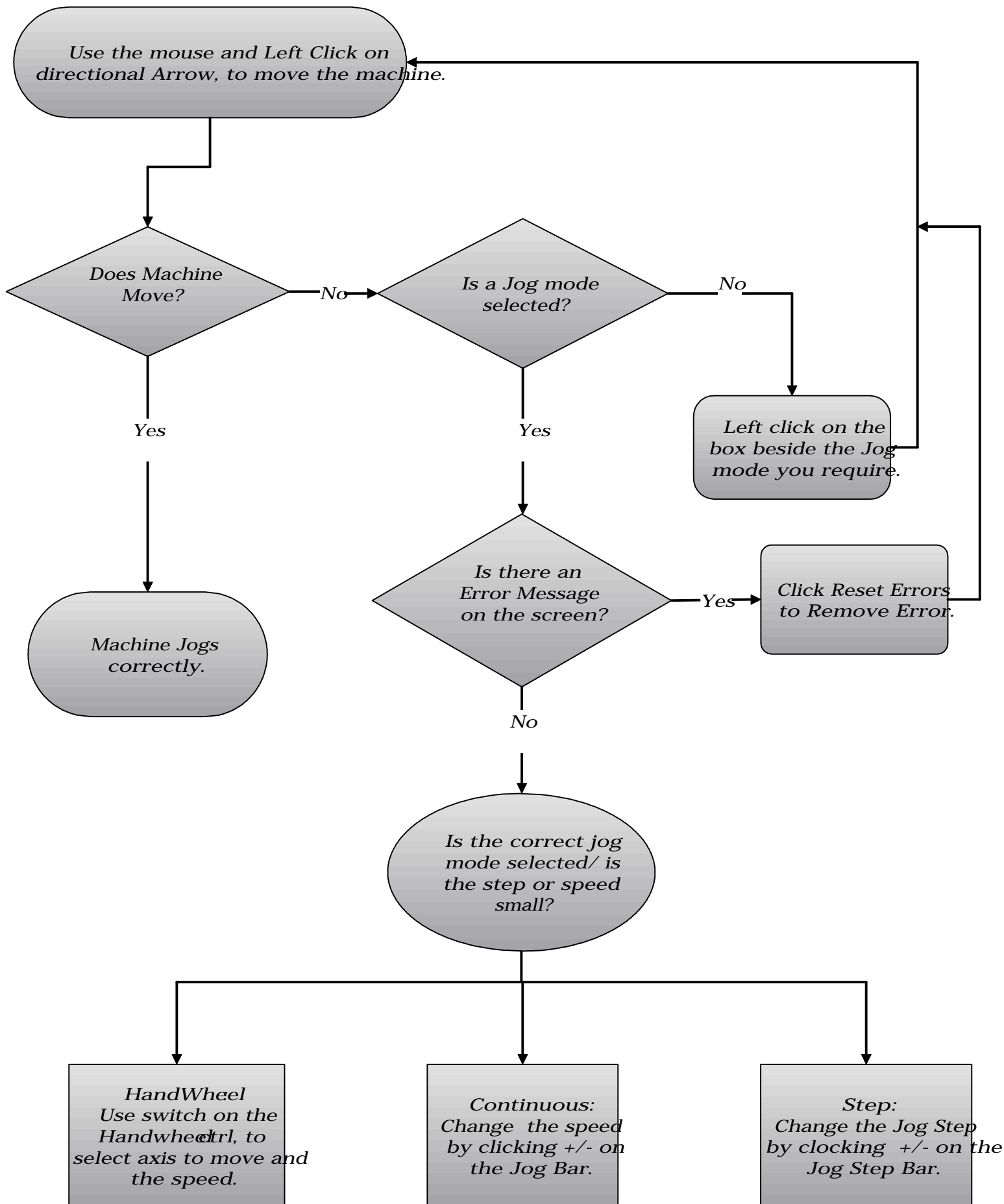


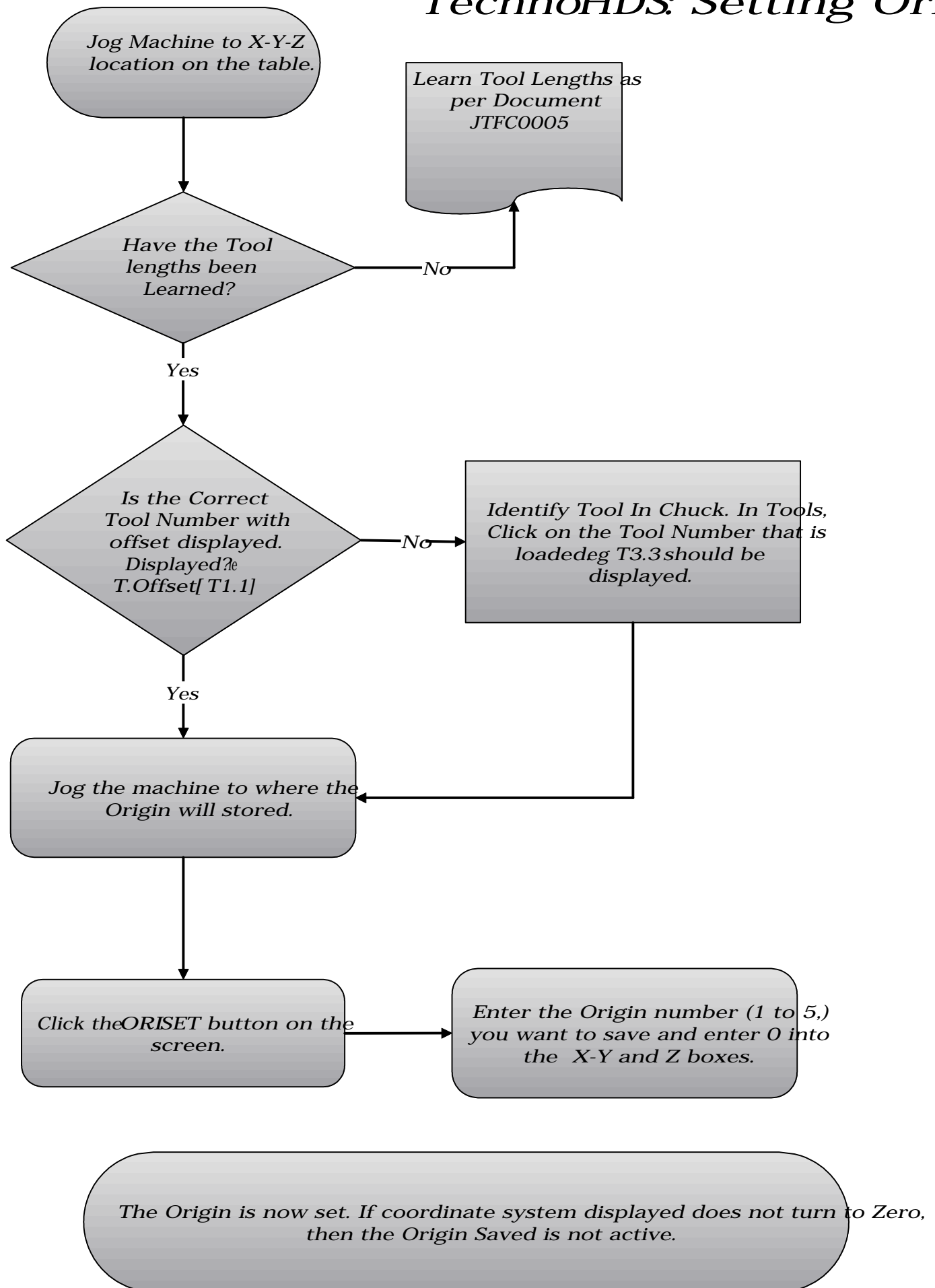
TechnoHDS: Start-Up Sequence



TechnoHDS: Jogging Machine



TechnoHDS: Setting Origin



TechnoHDS: Recalling/Activating Origin

This will activate an Origin/Working Coordinate.

Was an Origin Saved previously?

Save an Origin as per JTFC0002

*Is there a Tool Number with offset displayed?
T.Offset[T1.1]*

Identify Tool In Chuck. In Tools, Click on the Tool Number that is loaded eg T3.3 should be displayed.

Click on ORI(1-5) to select the origin number to be recalled. The Coordinate system will now change to that Origin.

To move the machine to the Origin. Click on MDI Enter the code G0X0Y0Z0 click OK. Click on Cycle Start. The machine will now move to the Origin.

TechnoHDS: Learning Tool Length

Learning Tool Lengths will record the different Tools Z offset so multiple tools can be used in a G-code file.

Are Tool Locations Learned?

Learn tool Locations as per JTFC0007

Is the Tool to be learned identified?

Go into the Tool Menu:
If the tool is in the chuck, Identify the Tool in Chuck by clicking on the Number.
If there is no Tool in the Chuck, Click on the number under Manual Tool Change to pick up the chuck.

Clear the Z-Offset by clicking the Reset button. The Machine Coordinate system will now be active.

Place the Touchpad under the Tool.

Under the Offset Update click on the corresponding OFST number for the Tool Length to be learned. (i.e. T4 will use OFST4) The Tool will move to Home, then slowly move down and touch the Touch pad.

Tool Offsets are now learned.
NOTE: If reset is pressed and the Offset reads just T# and not T#.# then the offset needs to be reloaded by identifying the Tool in the Chuck.

Learn more Tool lengths?

Yes

No

TechnoHDS: Loading a File

HDS controller will accept files with any extension, but the files name length cannot exceed 8 characters for clarity. `.cd` is the preferred file extension. The files must be copied **first** to the PLC. There is a folder called G-code Files or Programs on the desktop that the files must be dragged into. Sub-folders may be used to organize files in this folder.

