

Operation	Mode	Procedure [Text] = Hard Key, (Text) = Soft Key
Basic Operation		
Power Up	–	Press Power On in lower left corner, release E-stop buttons, [Reset] then [OPER ACK], [Reset] then [OPER ACK] again, [HYD ON], [Torch Inhibit] to turn off, [Ram Inhibit] to turn off, [Spindle Start] on, [Feed Start] on, consult messages
Power Down	–	(Menu Select), (→), (Exit) Wait until prompted to turn off power
Move Axis	Jog	[JOG], [DIRECTIONAL KEY] Example [X-], [Y+] Hold Rapid at same time for faster motion
Move Ram	Jog	[RAM UP] or [RAM DOWN]
Check and Clear Messages	–	(Menu Select), (Diagnosis), (Messages) for current status. Remedy problem displayed on screen, (Oper Ack)
Check and Clear Alarms	–	(Menu Select), (Diagnosis), (Alarms), Remedy problem displayed on screen, (Reset)
Program Functions		
Load Programs From Control	Auto	(Menu Select), (Program), (Part Programs), scroll to File Name, (Select)
Copy Programs From Floppy or Flash Drive	Auto	(Menu Select), (Services), (Manage Data), (Disk/Card), scroll to File Name, (Copy), (Programs\Data), Scroll to Part-Programs, (Insert), (OK), then use the Load Programs From Control step listed above
List Programs In Memory	Auto	(Menu Select), (Program), (Part Programs)
Send Programs to Floppy/ Flash	Auto	(Menu Select), (Services), (Manage Data), scroll to Part-Programs, Enter, scroll to highlight file, (Copy), (Disk/Card), (Insert), (OK)
Delete Program From Memory	Auto	(Menu Select), (Program), (Part Programs), scroll to file, (Manage Data), (Delete), (Yes)
Create New Program	Auto	(Menu Select), (Program), (Part Programs), (New ...), Type in Name, Enter, (OK), Type in data thru Editor, (Close Editor), (Yes)
Editing Functions		
Keys to Use While Editing Programs	–	Use normal word processing keys on keyboard. Delete to delete highlighted character, Backspace to delete character to the left of the cursor. All characters are added to the right hand side of the cursor. To make a new line, press Enter at the front or end of line.
Edit or View Active Program	Auto	(Machine), (Correct Program), make changes, press (Close Editor) when done
Edit or View Any Program	Auto	(Menu Select), (Program), (Part-Programs), scroll to highlight file, press Enter
Using Find/Goto Function	Auto	In Editor, press (Find/Goto), (Search), type in data, press Enter, repeat as needed You can also Goto Start of Program, End of Program and Goto specific block numbers
Making Multiple Changes	Auto	In Editor, press (Find\Goto), (Search), type in old data, press Enter, press (Replace), type in new data, press Enter. To replace all instances in the program, press Replace all texts
Diameter (Kerf) Offset	Auto	(Menu Select), (Parameter). Use + and – keys to select different offset values. Adjust radius value by 1/2" the amount you need. Adding makes OD's larger and ID's smaller.
Torch (Fixture) Offset	Auto	Pre 2009 models: (Menu Select), (Parameter),(Work Offset). Edit G55 value as needed. 2009 & Up: (Machine), (3400 Status), (Edit G55 Offsets), use screen to calculate values

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Maintenance Functions		
Message & Alarm History	–	(Menu Select), (Diagnosis), (Alarm Log)
Setting Access Levels	–	(Menu Select), (Services), (Password), (Delete Password), (Set Password), type in password, press Enter. User: CUSTOMER. Service: EVENING. Safest operation at User
Search & Set Parameters	–	(Menu Select), (Parameters), (Search), input address _ _ _ _ , press Enter. Always use the first [0] value when multiple choices are available
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PLC Signal Status	–	(Menu Select), (Diagnosis), (PLC Status), input signal value on left, watch status on right I=External Input, Q=Ext. Output, DB10.DBX??=High Speed Digital Signals Each byte is made of 8 bits numbered 0-7 from RIGHT to LEFT on Screen <div style="text-align: center;"> Bit 7 6 5 4 3 2 1 0 </div> You can read the entire byte (Example IB33 = 00111010) or individual bit's (I33.1 = 0) Type in the address to read. Add "B" to look at the entire byte (example above) A 1 indicates an active output or input. A 0 indicates no signal. Note: This is reversed on normally closed inputs (refer to electrical prints for which inputs are NO or NC)
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Create Start-Up (NC, PLC) Archives	Auto	(Menu Select), (Services), (>), (Series Start-up), use the arrow keys to move and the space bar to check/uncheck your selection, input file name in Archive Name box (normally NC### or PLC### with the current date), (Archive)
Create User Cycle or Part Program Archive	Auto	(Menu Select), (Services), (Data Out), use arrow keys to highlight User Cycle or Part Programs directory, (Archive), input file name (normally USERCY### or PARTPRO### with the current date), press Enter, (Start)
Backup Files or Archives to Floppy or Flash	Auto	(Menu Select), (Services), (Manage Data), use arrow keys to highlight directory containing files and press Enter, use arrow keys to highlight file, (Copy), (Disk/Card), (Insert), (OK)
Copy Files From Floppy or Flash to Control	Auto	(Menu Select), (Services), (Manage Data), (Disk/Card), use arrow keys to highlight file, (Copy),(Programs/Data)use arrow keys to highlight directory you want to copy to and press Enter, (Insert), (OK)