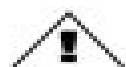

Slide Hold

The SLIDE HOLD button stops the movement of the X,Y, Z, A, & B. The Spindle and coolant are not affected by the SLIDE HOLD. The CNC will resume motion after the START or AUTO button is pressed.



WARNING: Before continuing AUTO, check to see if the Spindle or Coolant was shut off. If so, manually turn on the Spindle by depressing the SHIFT and SPINDLE ON button. To turn on the Coolant, press the COOLANT button.

Slide Hold, JOG AWAY

By pressing the **JOG button** while in SLIDE HOLD, any axis can be moved away from its current position. This Jog Away feature allows an optional automatic return of the jogged axes to that position to complete the machining cycle. The MANUAL key exits JOG and returns the CNC to SLIDE HOLD. After pressing the MANUAL key the CNC prompts the operator:

```

X      .7075    0
Y      0        0
Z      0        0 C

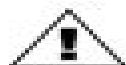
X 0.2854      S5000      T1 40 617 670 691 80 80
Y      0      F3  /M49  S8 640 680 698 80 80
Z      0 C  D  M9      80      60.00:07
          05998 SPINDLE BREAK IN

M55 X1.
M56 S7000 M3
M57 X-0.5
M58 M3
-----PRESS MANUAL TO ABORT--
JOG-----PRESS MANUAL TO ABORT--
1-RETURN AXES
2-REMAIN & SHIFT COORDINATES
3-REMAIN & NO SHIFT

```

Figure 7-1 Slide Hold, JOG AWAY

Pressing 1: The CNC will return the axes to the position before the JOG was initiated. This motion is accomplished at a rapid feedrate. Make sure the Z axis is in a position to clear work and fixturing.



WARNING: Slide Hold or Feedrate Override Pot will not function while the CNC is returning the axis to original location! The Rapid Travel selector will change the return speed.

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Sudan United States. Office of Geography,1962 **Official Gazette of the United States Patent Office** United States. Patent Office,1963 **Juba Arabic for Beginners** Richard L. Watson,2018-02-19 Juba Arabic is an Arabic creole closely related to Kinubi It began developing in the Equatoria Region of what is now South Sudan over 100 years ago and spread widely now being the spoken lingua franca of the region It has become so well established that expatriates working in Equatoria often find themselves in situations in which neither English nor Khartoum colloquial Arabic is adequate for communication Juba Arabic for Beginners was originally prepared by SIL as a language course for the communication needs of its own personnel but other people needing to communicate in Juba have found it invaluable The present course was adapted from the excellent Sudanese Colloquial Arabic for Beginners Andrew and Janet Persson with Ahmad Hussein in general format with its 30 dialogues However due to important linguistic and cultural differences five additional lessons relevant to southern culture are included This course is written in a Romanized orthography and represents a widespread dialect of Juba Arabic Over the past 30 years the course has served and continues to serve personnel of a number of expatriate organizations **In the Supreme Court of the State of Illinois , September 2023 - Surplus Record**

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