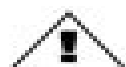

Slide Hold

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

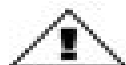
X 0.2854      S5000      T1  40  617  670  691  80  =D
Y      0        F3      /M49  58  640  680  698  80  =D
Z      0  C  0      M9      80      80.00-07
                        05998 SPINDLE BREAK IN

M15 X1.
M16 S7000 M3
M17 X-0.5
M18 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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