Fadal

User Manual

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:



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.



WARWING: 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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Table of Contents Fadal User Manual Section 17

- 1. Understanding the eBook Fadal User Manual Section 17
 - The Rise of Digital Reading Fadal User Manual Section 17
 - Advantages of eBooks Over Traditional Books
- 2. Identifying Fadal User Manual Section 17
 - Exploring Different Genres
 - o Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
- 3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Fadal User Manual Section 17
 - User-Friendly Interface
- 4. Exploring eBook Recommendations from Fadal User Manual Section 17
 - Personalized Recommendations

- Fadal User Manual Section 17 User Reviews and Ratings
- Fadal User Manual Section 17 and Bestseller Lists
- 5. Accessing Fadal User Manual Section 17 Free and Paid eBooks
 - Fadal User Manual Section 17 Public Domain eBooks
 - Fadal User Manual Section 17 eBook Subscription Services
 - Fadal User Manual Section 17 Budget-Friendly Options
- 6. Navigating Fadal User Manual Section 17 eBook Formats
 - ∘ ePub, PDF, MOBI, and More
 - Fadal User Manual Section 17 Compatibility with Devices
 - Fadal User Manual Section 17 Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Fadal User Manual Section 17
 - o Highlighting and Note-Taking Fadal User Manual Section 17
 - Interactive Elements Fadal User Manual Section 17
- 8. Staying Engaged with Fadal User Manual Section 17
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - o Following Authors and Publishers Fadal User Manual Section 17
- 9. Balancing eBooks and Physical Books Fadal User Manual Section 17
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Fadal User Manual Section 17
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Fadal User Manual Section 17
 - Setting Reading Goals Fadal User Manual Section 17
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Fadal User Manual Section 17
 - Fact-Checking eBook Content of Fadal User Manual Section 17

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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