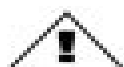

Slide Hold

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

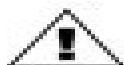
X 0.2854      S5000      T1  40  617  670  691  80  =D
Y      0        F3      /M49  58  640  680  698  80  =D
Z      0 C      D      M9      80      80.00-07
                        05998 SPINDLE BREAK IN

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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Athlete Transitions into Retirement Deborah Agnew, 2021-08-12 Transitions in sport can be either normative relatively predictable or non normative less predictable and are critical times in the development of athlete s careers Whilst retirement from sport is inevitable the timing of retirement can be less predictable If an athlete copes well with the transition they may be better able to adjust to life after sport However not coping with the transition can lead to a crisis and negative consequences for the athlete Transition periods from sport and in particular retirement from sport have been identified as high risk periods for athletes in terms of psychological distress However circumstances surrounding the athlete s retirement are a critical factor in the transition into life after sport Voluntarily retiring from sport for example leads to a smoother transition than being forced into retirement through injury or deselection Research indicates that retirement from sport should be seen as a process rather than a single moment with many athletes taking up to 2 years to successfully transition out of sport Currently there are few bodies of work that are solely devoted to retirement transition *Athlete Transitions into Retirement Experiences in Elite Sport* and *Options for Effective Support* provides contemporary viewpoints on athlete transitions from elite sport in a global context This volume is a collaboration of research from leading authors around the world offering global perspectives to athlete transitions into retirement and is key reading for both researchers and practitioners in the fields of Sport Psychology and Coaching as well as the Athletes themselves

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