


VR CNC Milling - Quick Reference



①  Click on this ICON to start the software

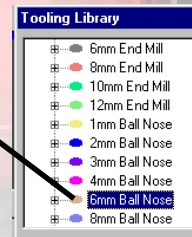
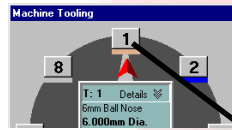
②  **Load your CNC program**
You need to locate your CNC file and load it into the software. From the file menu select Open. (look for a file with a '.FNC' extension)

③ Set-up the tooling



Click on these two ICONS to check your tooling setup. To make sure your simulation works with the correct tool, you must select it first using this option.

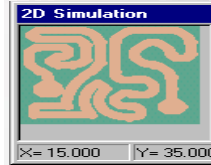


Using the left mouse button, drag-and-drop the required tool from the library window over to the tool number in the tooling window.



(click the ICONS again to close the windows)

④  **Simulation**
Click on either the 2D or 3D ICONS to open the simulation window. To run the program simply press play 



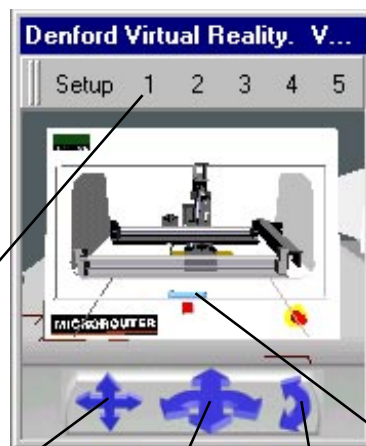
(click the ICONS again to close the windows)

⑤ Virtual Reality machine

Press this button to launch the VR machine window. You can control the VR machine in the same way as the 'real' machine. You need to HOME the machine and set the tool offsets before you run a program.

Moving around:

Click and hold down the left mouse button over one of the three movement buttons. The further you drag the mouse away from the button the further you will move.



Preset viewpoints

Move up toward the ceiling and down to the floor. You can also step left and right.

Allows you to walk forward, backwards and turn around.

Tilts the viewpoint only (you stand still but nod your head up and down)

Note: You can execute the program, but the VR block of material will always stay solid even though the cutter appears to cut through it.

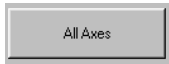
Note
If you have the 'real' machine running, you must close it down first before you can open the 'VR' window.

Click on the handle to open the guard.

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Datum the machine (click on the **Home** tab)



Click 'All Axes' to send to home position

Note

Close the guard... the machine will start moving!

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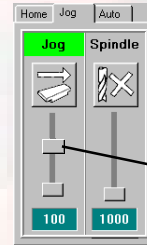
Jog Mode (click on the **Jog** tab)

In this mode use the cursor keys on the keyboard / keypad to move each axis of the machine.

Note: The jog mode is only active if the display is GREEN. If the green highlight 'goes out', click on the JOG tab again re-activate the jog mode.

Note

Page Up = Z+ UP
Page Down = Z- DOWN




Push the slider here to increase the jog speed.

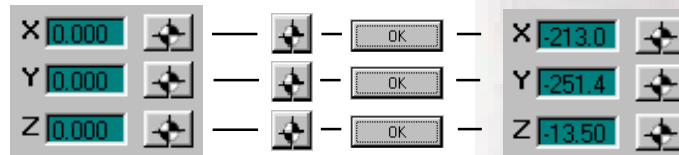
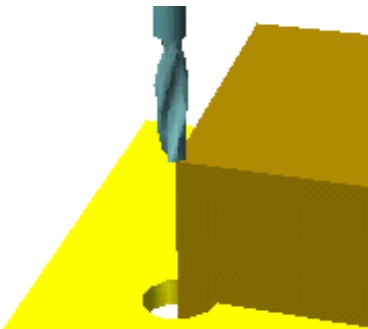
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Setting the offsets

Jog the cutter to the near, left top corner of the workpiece as shown.



Click on  to register the offsets for X Y and Z.



Executing the program (click on the **Auto** tab)

To start the program running on the machine you must be in Auto mode.

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Press  to make sure the program is stopped. Press  to make sure the program is at the beginning. For complex 3D programs it is usual to

use 'turbo' mode, press  now. Finally press play. 

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Link to the machine

At this point the computer will try to 'find' the machine via the serial port.

Before clicking here, check the machine is switched on and the VR machine window is closed. The method for 'homing', setting the tool offsets and executing the program is the same as the VR machine.

