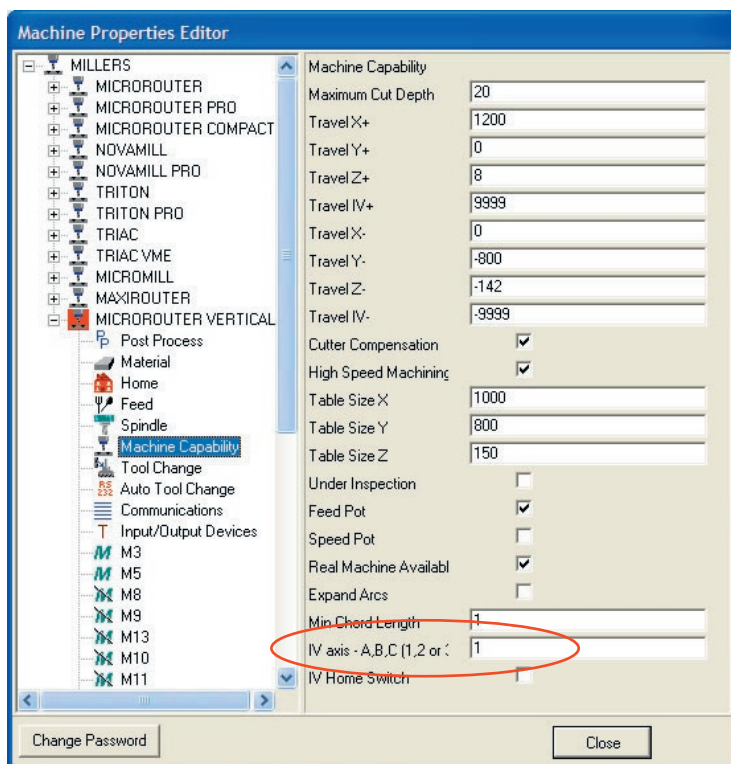


Step 3 - Enable the 4th axis.

Note: This step can only be performed if the software is **not** connected to the CNC machine
To reconfigure VR Milling V5 to enable the 4th axis you need to change the following options:

1. From the pulldown menu select "Setup" then "Setup Machine Parameters"
2. Enter the password. The default password is "denny".
3. The 'Machine Properties Editor' window will open. The current machine your software is configured for is highlighted red in the list.
Click on 'Machine Capability' in the list
4. Type a 1 in the box next to 'IV axis - A,B,C(1,2 or 3)' to activate the 4th axis option as circled red below.
5. Click the [Close] button to exit.



Step 3 - Enable the 4th axis.

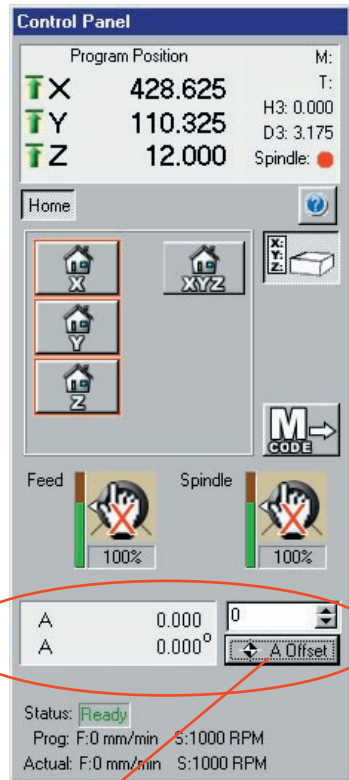
Once VR Milling V5 has been reconfigured to enable the 4th axis, the 'Control Panel' will now show the 4th axis display.

It is possible to control the 4th axis from within the software.

Once the machine is homed the 4th axis can be rotated by using the [.] and [/] keys on the QWERTY keyboard when in jog mode.



The angle the 4th axis has rotated to is displayed in the 4th axis display at the bottom of the control panel.



A Offset button

It is possible to set the work offset for the A axis (Rotary axis). This is not normally necessary because the billet will be rotated through 360 degrees during the program so the angle from which it starts is irrelevant.

There may be times where you want to start from a specific angle for example when using a rectangular billet. In cases like that jog the 4th axis fixture to the required angle and click the **[A Offset]** button to set the angle you would like to start from.

Note: When the machine is powered off the angle the 4th Axis is currently in becomes zero the next time the machine is powered on. This can be used to set the A offset. By jogging the 4th axis to the desired angle and then turning the machine off and back on the 4th axis position becomes zero meaning the A offset does not need to be set.