

## Manual Axis Positioning

## Chapter 7

## OBJECTIVE

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Manually position the turret(s) using the SLIDE JOG and PULSE HANDLE controls.

## INTRODUCTION

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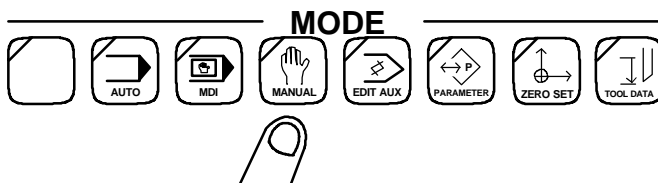
There are two different methods for positioning the Okuma X and Z-axes. The first method allows the operator to move the turret into a *general* position by using the Slide Jog Controls (see page 2-8).

**DO NOT USE THE SLIDE JOG CONTROLS FOR TOUCHING THE TOOL TO THE MATERIAL TO BE CUT!!!**

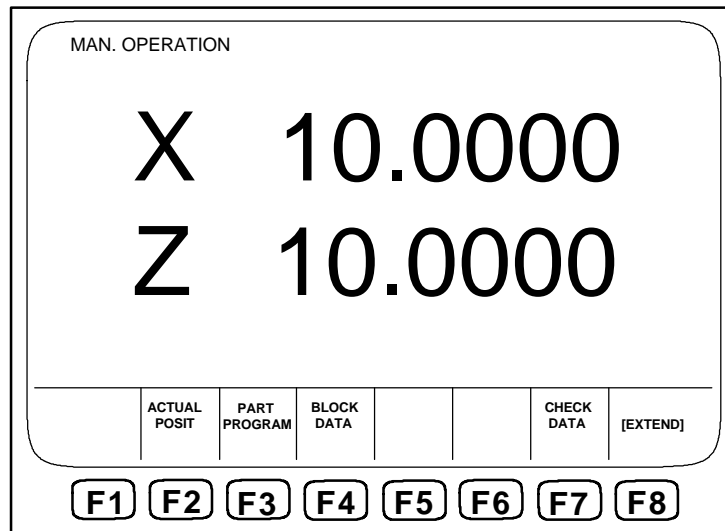
The second method **is** used to touch tools to the part. When touching off tools you will use the Pulse Handle Controls (see page 2-9)

## SLIDE JOG CONTROLS

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1. On the Operation Panel, select the Manual mode of operation.



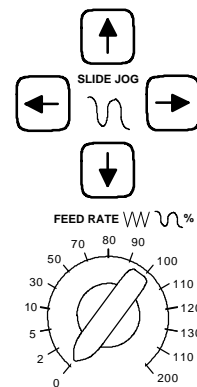
Note that the MANual OPERATION screen is displayed.



It is not particularly important if this is the page you see. Pressing the PAGE key will change the view and you should become familiar with all the choices.

At this point you will be able to use the Slide Jog Controls to position the axes. Use the following procedures to perform this task.

2. On the Operation Panel, rotate the Feed Rate Override dial **fully counter-clockwise!** This sets your turret movement at zero percent.
3. Select the Slide Jog Arrow key that matches the direction you want the turret to move (these arrow keys are only active when you are pressing them).

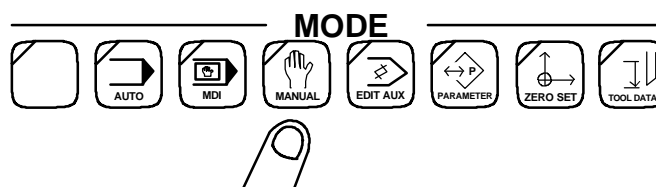


4. While holding the selected Slide Jog Arrow key, **slowly** rotate the Feed Rate Override in a clockwise direction. The turret speed will increase as you rotate the Feed Rate Override.
5. When the turret is in the desired position, release the Slide Jog Arrow key.

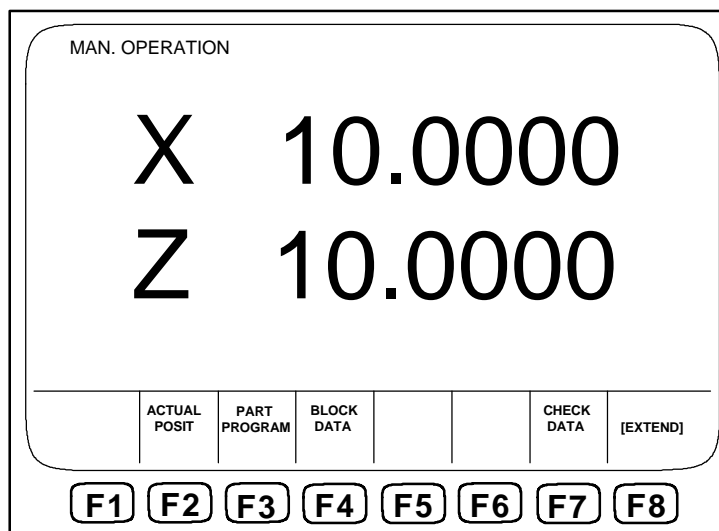
## PULSE HANDLE CONTROLS

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1. On the Operation Panel, select the Manual mode of operation.



Note that the MANual OPERATION screen has been activated.



It is not particularly important if this is the page you see.

At this point, you will be able to use the Pulse Handle Controls to position the axes. Use the following procedures to perform this task.

2. Select the desired X or Z Pulse Handle Control key that matches the axis you want to move (these keys will remain active after you have selected them).
3. Select the Control Switch for the axis feed amount you desire (see page 2-9 for detailed explanation of these Control Switches).
4. Now you can use the Pulse Handle to position the turret at the feed rate selected in step three. If you are going to touch off a part, turn the spindle ON using the instructions listed on pages 5-5 through 5-9.

