Hand Wheel Run Mode

Tips are applicable to the Milltronics 8200 & 9000 Series controls.

This function allows the hand wheel to function as a 'dead man' switch. The feedrate override knob controls the step size and/or increment. Access the RUN menu and press [F10] Hand-whl. It will turn green to indicate it is active, a blue status indiation will appear in the status/settings bar. Start the program as normal and expect that the axes will not move unless the hand wheel is cranked.

The feedrate is controlled by the rate the hand wheel is cranked. If the hand wheel is cranked slowly, the axes will move slowly. If the hand wheel is cranked fast, the axes will move fast. The control will move forward through the program regardless of which direction the hand wheel is turned. DO NOT attempt to back the program up if an obstacle is encountered. If the tool needs to be backed away from an obstacle, the program must be halted by pressing the [F9] HALT key. The operator must then access JOG mode to move the tool away from an obstacle.

The hand wheel run mode may be activated any time during a program. To do this, press [F10] Hand-whl.
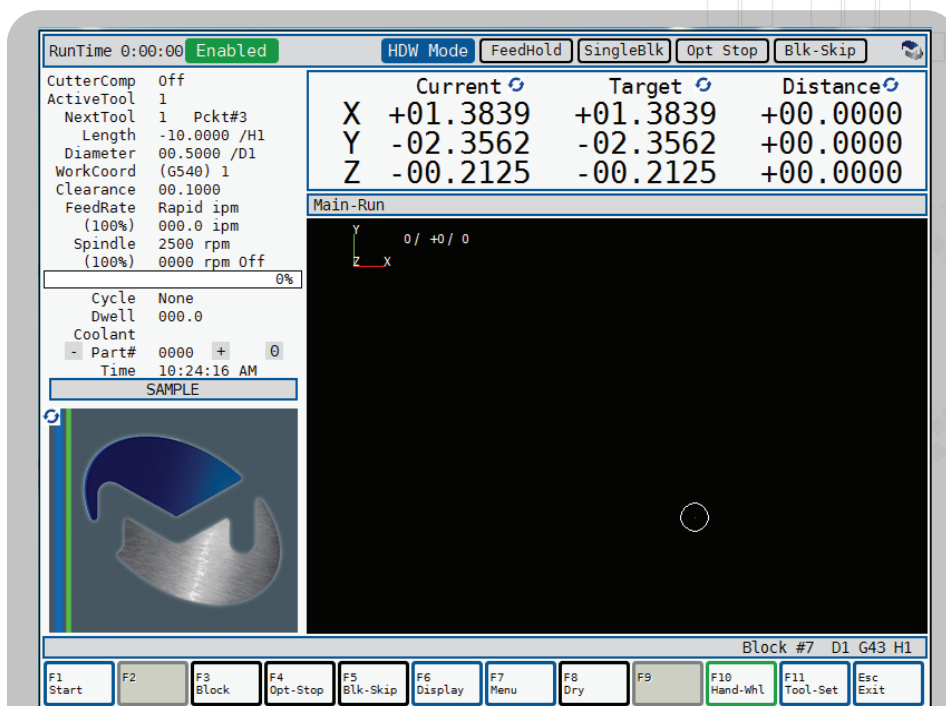

Figure 1: Example of .DXF Program in Parts Diretory

NOTE Tap cycles cannot be controlled with the hand wheel run mode. When the control encounters a tap cycle, a red message will prompt the operator to press the cycle start button to start the cycle. When the tap cycle is complete, the user will be prompted to press the cycle start button to continue with the hand wheel run mode.