UNWIND YOUR ROTARY QUICKLY ON YOUR HURCO MILL

Instructions:

Method #1 Quickest

1. If you have a conversational program already made in your control go to the REVIEW SCREEN by pressing the REVIEW key on your control panel.

2. Highlight the location of the program where you want the block inserted

3. Then select INSERT BLOCK BEFORE softkey

4. And click on the ROTARY AND TRANSFORM PLANES softkey

5. Select ROTARY POSITION

6. You will see at the top of the screen a field called RESET ROTARY ENCODERS, select YES.

Method #2 Conversational

1. Press the REVIEW key

2. Place the cursor in the location where you want the M31 inserted

3. Then select the INSERT BLOCK BEFORE softkey

4. Press the MISCELLANEOUS softkey

5. Press the MACHINE FUNCTION softkey

6. From there you will type "31" into your M-Code field and hit ENTER

7. Or scroll down and select M31 from the provided list and then press the select M-code softkey.

8. We now need to tell the control our rotary position, so you will need to go to the REVIEW SCREEN, highlight the location where you want to insert the rotary command, and select INSERT BLOCK BEFORE softkey

9. Press the ROTARY AND TRANSFORM PLANES softkey

10. Selection ROTARY POSITION BLOCK and make sure your 4th axis is turned on.

Method #3 NC

1. Press the INPUT key

2. Press the PART PROGRAMMING softkey

3. Type in "M31" wherever you need to reset the rotary

4. If you don't have "G0, A0" already in your program, go ahead and type that in now.