Copying a Program From Disk or Memory Stick

1. Press **Menu Select** hardkey

2. Press **Services** horizontal softkey

3. Press **Manage Data** horizontal softkey

4. Press **Disk/Card** horizontal softkey

5. Using the arrow keys, highlight the file you wish to copy

6. Press **Copy** vertical softkey

7. Press **Programs\Data** horizontal softkey

8. Highlight Part-Programs directory

9. Press **Insert** vertical softkey

10. Press **OK** vertical softkey

Loading a Program to Execute

1. Press **Menu Select** hardkey

2. Press **Program** horizontal softkey

3. Press **Part Programs** horizontal softkey

4. Using the arrow keys, highlight the file you wish to run

5. Press **Select** vertical softkey

Continuing a Program

1. Press **Machine** hardkey

2. Ensure you are in Auto mode

3. Write down your current block number

4. Press **Reset** hardkey

5. Press **Block Search** horizontal softkey

6. As needed, scroll up or down through the program to your recovery point.
   Note: Remember to always start your cuts at the G55 at the beginning of the sequence.

7. Press **Calculate Block End Point** vertical softkey

8. Press **Cycle Start** hardkey 2 times

Restarting a Program After E-stop or Loss of Power

1. Clear e-stop and/or follow Power Up Procedure

2. Press **Machine** hardkey

3. Ensure you are in Auto mode

4. Press **Correct Program** horizontal softkey

5. Scroll down through the program until you find your stopping point or use the search function to find this point. Example: If you are restarting a cut, you can count the number of cuts executed so far and use this to find your location in the program. Press **Search** vertical softkey then type in Cut and the cut number (ex. Cut 43) then press OK.
   Note: Remember to always start your cuts on a G55 command.

6. Write down the block number you wish to start at

7. Press **Close Editor** vertical softkey

8. Press **Block Search** horizontal softkey

9. If searching by block number, set P to 1

10. Type in N and the block number for Target (ex. **N1435**)

11. Press **Calculate Block End Point** vertical softkey

12. Press **Cycle Start** hardkey 2 times

End of Procedure