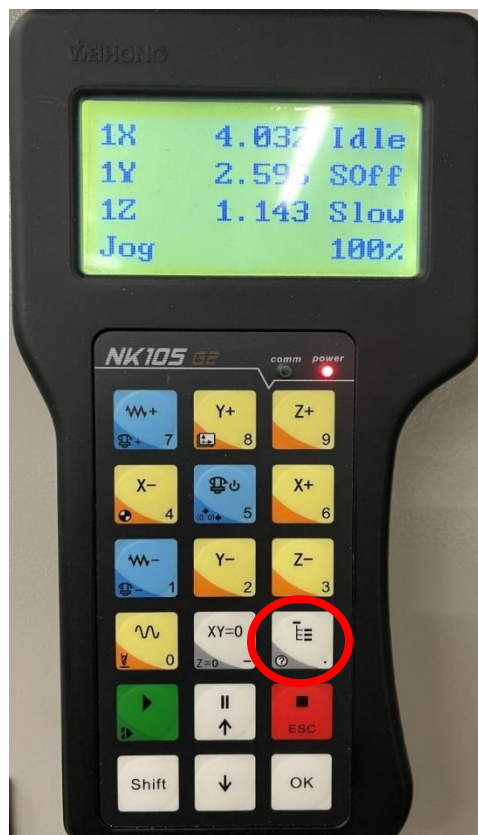


Techno **CNC** Systems

Skipping Ahead: Atlas Series, HDII Tabletop

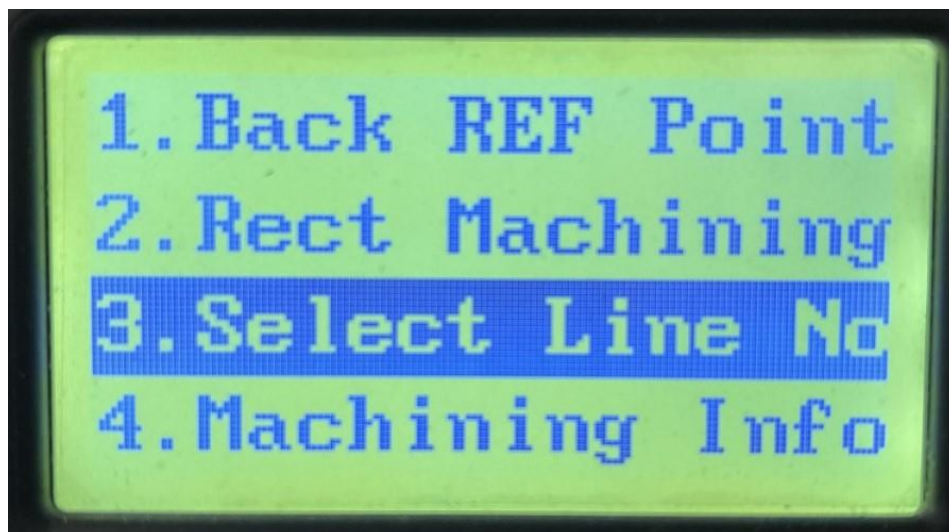
NOTE: Before completing the procedure depicted below it is important to understand that the skipping function of the controller will also skip past the spindle on command. In order to have the spindle turn on in order to execute the file the operator wishes to skip ahead on, the spindle must be powered on at the correct spindle speed prior to completing the below procedure. Failure to do so may result in damaged cutting tools or machine components.



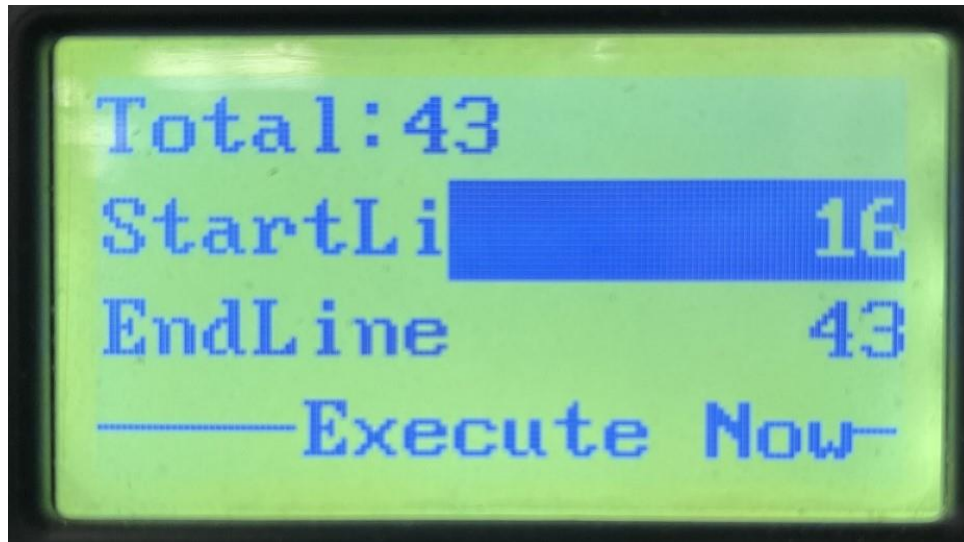
Step 1: On the handheld pendant, press the “Menu” button located above the red Esc button.



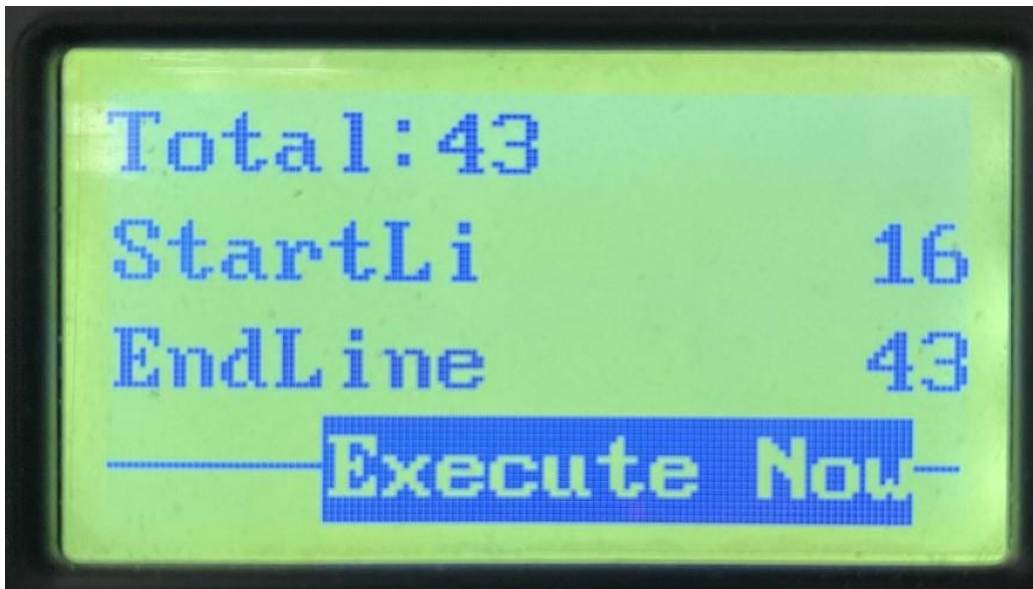
Step 2: Using the up and down arrow buttons, scroll down to “Operations”. Press the OK button to select Operations.



Step 3: Using the up and down arrow buttons, scroll down to option #3 – “Select Line No.”



Step 4: If you have stopped a file using the red Esc button and the file remains loaded onto the controller, the line # the file was stopped at will appear next to “StartLi”. If you want to skip ahead to a different line number, simply enter the number in the window and press the OK button.



Step 5: Once the correct line number had been input into the StartLi option, use the down arrow button to highlight “Execute Now”. Press the OK button to select. The operator will be sent back

to the main screen of the handheld controller, and the machine will begin to execute the gcode file from its commanded location.