Section 5: Emergency Stop

Emergency Stop

The emergency stop mode will “cut” the computer control to all axis motors, the spindle drive, and the tool changer. When the control detects a crash or overload situation, it places itself into emergency stop. Also, the operator can press the EMERGENCY STOP button to place the control in the emergency stop mode.

**WARNING:** If the machine is in motion when the Emergency Stop is activated, the spindle will free wheel for 30 seconds and the axis will coast to a resting position.

1) Press the EMERGENCY STOP button to put the control in the emergency stop mode (See Figure 5-1).

The message “EMERGENCY STOP - TAKE APPROPRIATE ACTION:” will appear on the screen when the control is in the emergency stop mode.

The appropriate action to take is:

1) Release the EMERGENCY STOP button if it has been pressed.

2) Press the JOG button which enables the amplifiers to reset if the problem has been resolved.

**Note:** It is not necessary to move the axes to their Cold Start position or establish the part home again. Sending the machine to Part HOME is recommended.

If the message:

“JOG AXES TO HOME POSITIONS, THEN ENTER THE CS COMMAND” appears, continue with the following steps.
To move the axes back to their COLD START home positions:

1) Press the manual key until the ENTER NEXT COMMAND prompt is displayed.

2) Press the jog key and align each axis at the alignment marks within .05 of each other.

3) Press the manual key until the ENTER NEXT COMMAND prompt is displayed, type CS then press the enter key.

4) Wait, the machine will now find the axis origin.

5) This procedure is complete when the move to last home position screen is displayed.

6) Press the start button to begin motion to the last home position established by the set commands.