

HAAS C.N.C. LATHE SETTINGS

EXERCISE 1

The **SETNG** display lists some parameters that the user has easy access to. These parameters are called settings and you can change them during the operation of the machine.

1. **What is the serial number of your control, which is listed on Setting 26?**
2. **What is Setting 33? What's it set at?**
3. **What is the Setting number for Door Hold Override? Turn it on.**
4. **What is Setting 32? What does the selection of IGNORE do?**
5. **What is Setting 92?**
6. **What does Setting 98? Set it at 50.**
7. **What is the page title that is highlighted and listed on the top of the display page that has Setting 11, Baud Rate Select, listed on it?**
8. **On the Setting display page titled EDITING, what setting number is for the Parameter Lock?**
9. **On the Settings display page titled GRAPHICS, what setting number is for turning on and of the Rapid Path in Graphics?**

HAAS C.N.C. LATHE SETTINGS

EXERCISE 1 Answers

The **SETNG** display lists some parameters that the user has easy access to. These parameters are called “settings” and you can change them during the operation of the machine.

1. **What is the serial number of your control, which is listed on Setting 26?**

Each machine will have a different number.

2. **What is Setting 33? What’s it set at?**

Coordinate system, FANUC or YASNAC.

3. **What is the Setting number for Door Hold Override? Turn it on.**

51

4. **What is Setting 32? What does the selection of IGNORE do?**

Coolant override, M08 coolant commands will be ignored but you can still manually turn on with the coolant key.

5. **What is Setting 92?**

Chuck clamping O.D. or I.D.

6. **What is Setting 98? Set it at 50.**

This will set the RPM for the Spindle Jog key on the control.

7. **What is the page title that is highlighted and listed on the top of the display page that has Setting 11, Baud Rate Select, listed on it?**

RS-232 PORTS

8. **On the Setting display page titled EDITING, what setting number is for the Parameter Lock?**

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9. **On the Settings display page titled GRAPHICS, what setting number is for turning on and off the Rapid Path in Graphics?**

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HAAS C.N.C. LATHE DISPLAY MODES

EXERCISE 2

1. To power up a Haas machine and to start running a part that has been proven and is in production, which three buttons do you need to press to start the machine cycle for that part setup?
2. While running a program in MEM operating mode and on the PRGRM display, which key do you press to get a Program Review of the program that you're presently running?
 - 1) F1
 - 2) F2
 - 3) F3
 - 4) F4
3. You may edit a program in memory while another program is concurrently running. When you're running a program in the PRGRM Display mode and MEM operating mode, how do you get into Background Edit?
4. One of the four POSIT displays will "zero out" all axes when you select a different operation mode and then switch back by pressing HANDLE JOG. Which position display will be at zero to begin showing a distance moved?
5. How many tool geometry offsets are available in the OFFSET display?
6. How many different offset categories do you have in OFFSET display?
Which ones are they?
7. How many calculator pages do you have to choose from in the CALC display?
What are they?
8. The HELP display is a mini-manual that will list and briefly explain some of the functions of a Haas machine. How do you select one of the subject areas in the Help directory?
9. Which button do you press to "zero out" Tool Life, Tool Load, Timers and M30 Counters when you highlight these readouts in the CURNT COMDS display?
10. What function does Settings 105, 106 and 107 adjust for on a Haas Lathe.

HAAS C.N.C. LATHE DISPLAY MODES

EXERCISE 2 Answers

1. To power up a Haas machine and to start running a part that has been proven and is in production, which three buttons do you need to press to start the machine cycle for that part setup?

POWER ON, POWER/UP RESTART, and CYCLE START.

2. While running a program in PRGRM display, which key do you press to get PROGRAM REVIEW of the program your presently running.

- 1) F1
- 2) F2
- 3) F3
- 4) F4

3. You may edit a program in memory while another program is concurrently running by using BACKGROUND EDIT. How do you get into BACKGROUND EDIT?

Enter program number and press F4.

4. One of the four POSIT displays, will "zero out" on all axes when you select a different operation mode and then you switch back, by pressing HANDLE/JOG. Which position display will be at zero to begin showing a distance moved?

The DIST-TO-GO display

5. How many tool geometry offsets are available in the OFFSET display?

50

6. How many different offset categories do you have in OFFSET display? Which ones are they?

FANUC Tool Geometry / YASNAC tool shift offsets, Wear Offsets and Work Offsets.

7. How many calculator pages do you have to choose from in the CALC display? What are they?

Three calculators, Trigonometry, Circular, and Milling and Tapping.

8. The HELP display is a mini-manual that will list and briefly explain some of the functions of a Haas machine. How do you select one of the subject areas in the Help directory?

By pressing the letter next to the topic for information.

9. Which button do you press to "zero out" Tool Life, Tool Load, Timers and M30 Counters when you highlight these readouts in the CURNT COMDS display?

ORIGIN

10. What function does Settings 105, 106 and 107 adjust for on a Haas Lathe.

Positioning the tailstockRetract, Advance and Hold point,

HAAS C.N.C. LATHE PARAMETERS

EXERCISE 3

Parameters are rarely changed by the user and should be protected from being changed with SETTING 7 PARAMETER LOCK. But one parameter you may decide to change is in PARAMETER 57, which is a display page of parameter settings listed as COMMON SWITCH 1. This parameter page has a number of different selections to choose from. And one which you may decide to turn OFF with an "0" is listed as DOOR STOP SP. This parameter causes the machine control to slow the spindle down to 500 rpm and stop any motion, in a machine cycle, when the machine door is open when this parameter is ON with a "1". And turning ON Setting 51 DOOR HOLD OVERRIDE will not override this condition unless this parameter is OFF with an "0".

1. Press **SETNG DISPLAY**.
2. Cursor to SETTING 7 PARAMETER LOCK and press the left or right cursor arrow to select it **OFF** and then press **WRITE/ENTER** to select.
3. Press **PARAM DISPLAY**.
4. You also need to push in **EMERGENCY STOP** to change any parameters.
5. Cursor to PARAMETER 57.
6. To cursor thru all the different settings listed in this parameter, you need to use the left or right cursor arrow keys, "Not the up or down arrow cursor keys".
7. Cursor to **DOOR STOP SP**.
8. Enter in a "0" and press **WRITE** to turn this feature off.
9. Now "be sure," to go back to the **SETNG DISPLAY**, cursor to SETTING 7 PARAMETER LOCK, and turn it back ON to lock out any other changes being made, also release **EMERGENCY STOP** and press **RESET** to clear alarms.

NOTE: Parameters are seldom-modified values that change the operation of the machine. These include servo motor types, gear ratios, speeds, stored stroke limits, lead screw compensations, motor control delays and macro call selections. **Modifying some of these functions may void any warranty on machine.** If you need to change parameters, contact HAAS or your dealer. Parameters are protected from being changed by SETTING 7. Also be sure to download and save a copy of your machine parameters as a backup if needed.