

## Service Support Spirit

### How to breakpoint recovery function –SDF-CNC

→ Problem : When the machine is running, suddenly the power supply disappears, the machine is restart, and the breakpoint is restored.

Breakpoint restoration

1) In case of manual pause or power outage in machining operation, the system will automatically save the current position of cutting torch as a breakpoint, which will be kept permanently in the system, whether power the system off or not.

**Problem analysis:**

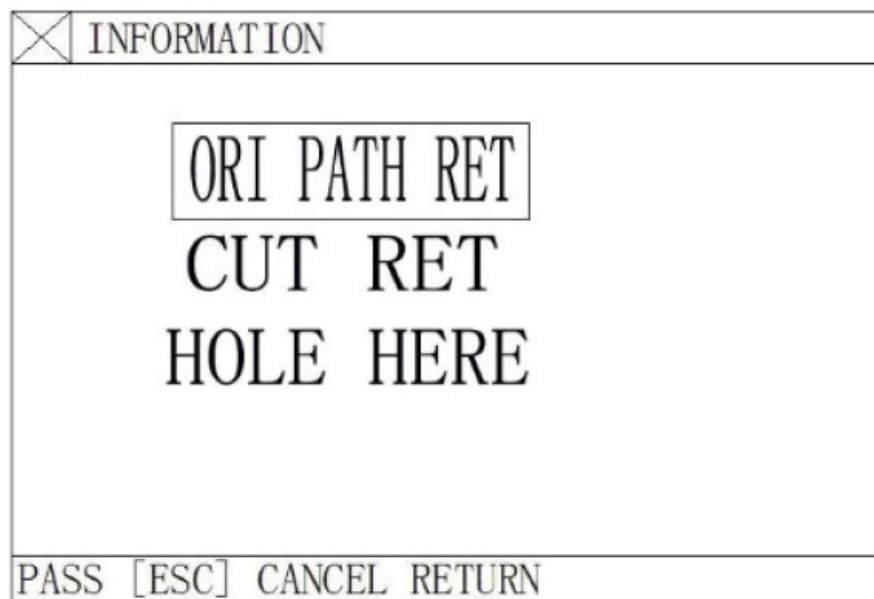
\* Solution: Step 1- Re-power the system. → The system enters the welcome interface and press any key to enter the cutting interface.



2) In automatic mode, press [F3] key to select RESBREK function and then [START] key to start breakpoint restoration as long as there is no change with the current program.

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- 3) If the position of cutting torch does not change, the system will prompt "Breakpoint" when a breakpoint is found and wait for subsequent command. User may select piercing directly or position adjustment of cutting torch. Refer to PIC for details.
- 4) If the position of cutting torch changed (not at the breakpoint any more), the system will provide three options when a program breakpoint is found, which is virtually position adjustment of cutting torch.



Pic2

ORI PATH RET: To return to the breakpoint at speed G00, which is often used for the breakpoint set for cutting torch replacement;

CUT RET: little bit off from the breakpoint after breakpoint restoration, which is somewhat like piercing along the exterior margin, making the breakpoint smoother;

HOLE HERE: the same operation as previous, which can also be used for transitional cutting.

Now, it is allowed to press a heavy-current function key such as IGN (ignition), PREHEA (piercing preheat), CUT (cutting oxygen), etc.

Tip: The system will continue to process from the breakpoint location if [PIERCE] key is pressed after preheating.

If press [ESC] key when a breakpoint is found, the system will exit machining mode.