

## 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.



**Figure 5-1** Emergency stop button.

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ENTER NEXT COMMAND
EMERGENCY STOP - TAKE APPROPRIATE ACTION
CHECK EMERGENCY STOP SWITCH AND MOTOR OVERLOAD RELAYS

PRESS THE JOG KEY TO RESET THE EMERGENCY STOP

ENTER NEXT COMMAND
  
```

**Figure 5-2** Screen display in emergency stop mode.

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.