

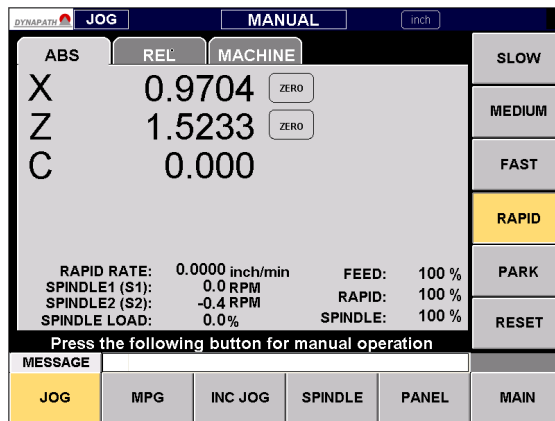
Manual Moves, Spindle, MDI and Semi-Auto

DynaPath WinDelta CNC Lathe Control · Operator Quick Guide

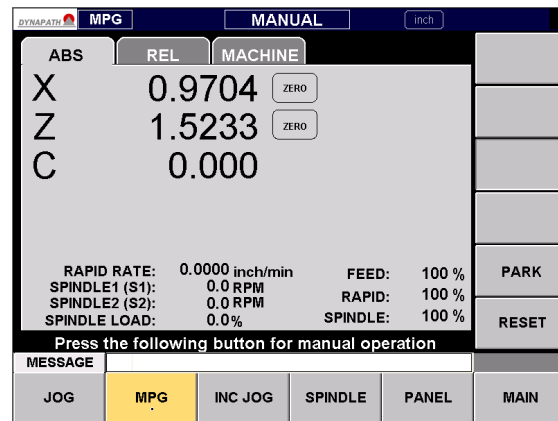
All manual moves start from the JOG screen (**MODE → 0**). Spindle, coolant and panel keys are live in every manual mode. [6]

Three ways to move an axis Manual 6.1–6.3

Mode	How to enter	How it moves
JOG	JOG screen opens in this mode	Hold an axis jog key; pick speed with the buttons on the right. RAPID OVERRIDE dial also applies.
MPG	MPG button along the bottom	Turn the X or Z handwheel. The RAPID OVERRIDE dial sets x1, x10 or x100 per click.
INC JOG	INC JOG button along the bottom	Each jog key press moves the distance selected on the right.



JOG screen: speed buttons on the right [Fig. 6.1-1]



MPG screen [Fig. 6.2-1]

Spindle and C-axis Manual 6.4

- 1 JOG screen → **SPINDLE** (bottom of screen).
 - 2 Tap the RPM field and enter the speed.
 - 3 Press **CW** or **CCW** on screen, or **SP CW** / **SP CCW** on the panel.
 - 4 Stop with **STOP** on screen or **SP STOP** on the panel.
- **C-axis** (if fitted): press **C/S** (LED lights) or run M45 in MDI. Then C+/C- jog the spindle, or e.g. C90.0 moves it to 90°. M46 turns C-axis mode off. [6.4.1]
 - **PANEL** (on screen or hard key) toggles coolant, chuck, tailstock and other functions fitted to your machine. [6.5]

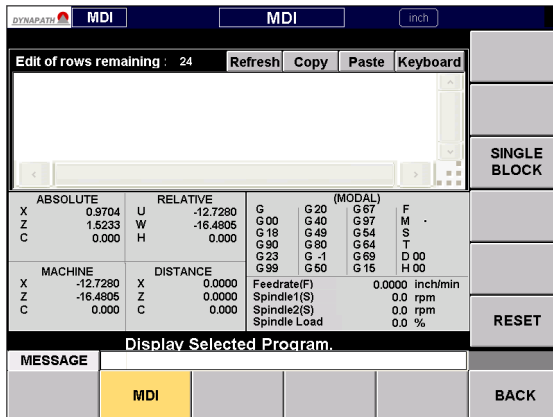
CAUTION Never start the spindle with the tool touching the part. The SPINDLE OVERRIDE dial scales the final RPM.

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MDI: run a few lines of code Manual 11

- 1 **MODE** → 9 (MDI).
- 2 Type one or more lines of G-code, e.g. G00 X50 . Z5 .
- 3 Press **CYCLE START**.

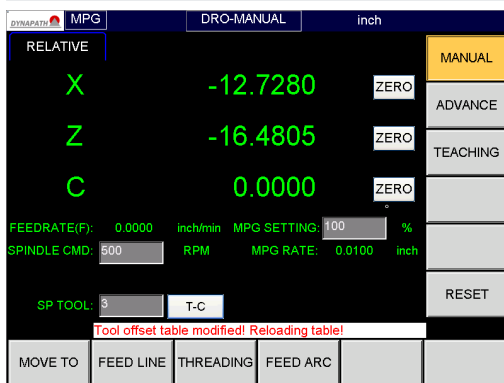


MDI screen [Fig. 11.1-1]

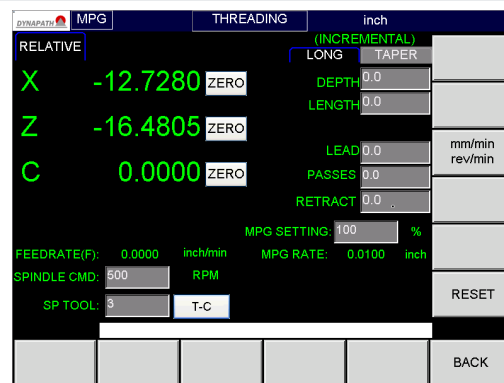
DRO / Semi-auto — **MODE** → R Manual 10

Opens in MANUAL (MPG) mode. Enter a feed rate and spindle RPM, run the spindle from the panel, and change tools by entering **SP TOOL** and pressing **T-C**. Then pick a function and press **CYCLE START**:

Function	What it does	Inputs
MOVE TO	Moves straight to an X/Z position	Target X and Z (ABS)
FEED LINE	Feeds a straight line in X, Z and/or C	Incremental distances; optional POS2 return
THREADING	Cuts a thread from the current position	DEPTH, LENGTH, LEAD (pitch), PASSES, RETRACT
FEED ARC	Feeds an arc from the current position	R, end point EX / EZ, CW or CCW



DRO manual screen [Fig. 10.2-1]



Semi-auto threading [Fig. 10.5-1]

NOTE To pick up an existing thread, home the C-axis first (HOME mode → C/S → C+ or C-), then zero X and Z at the thread start and back off in Z by a whole number of pitches. [10.5]