

Loading and Running a Program

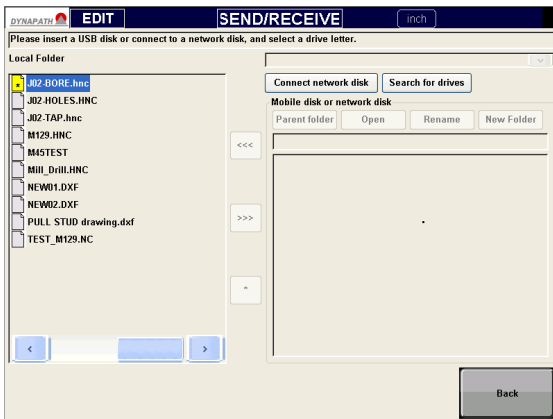
DynaPath WinDelta CNC Lathe Control · Operator Quick Guide

A program opened in FILE MANAGER becomes the active program, ready to run in AUTO. [12.1]

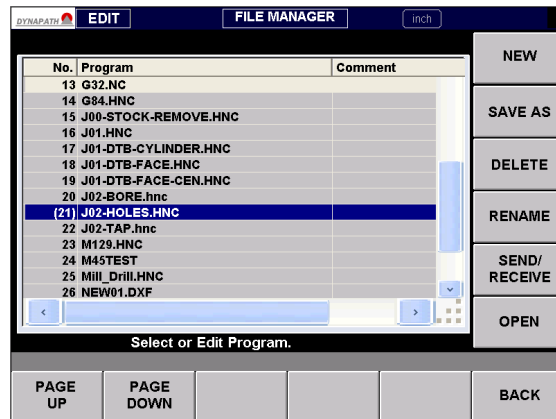
Get the program onto the control

Manual 12.2, 18.3

- **USB or network folder:** MODE → 8 SEND/RECEIVE. Control files are on the left, the external device on the right; select a file and press the arrow to copy.
- **From a PC on the same network:** use the control's FTP file access [18.3], then refresh FILE MANAGER.
- Don't delete files named **O9xxx**: they are system macros for tool change and setting.



SEND/RECEIVE: control left, USB/network right [Fig. 12.2-1]

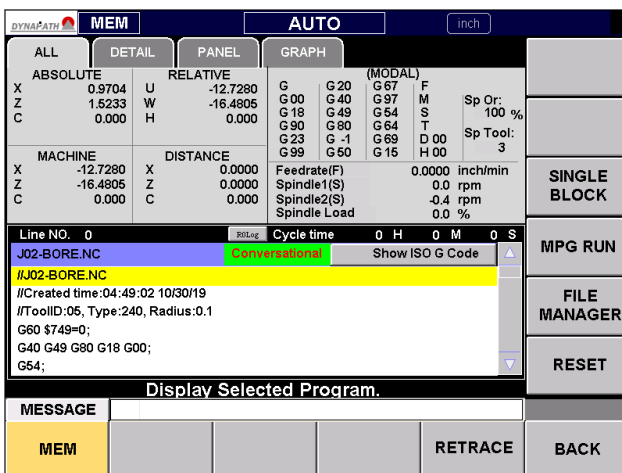


FILE MANAGER: select and OPEN [Fig. 12.1-1]

Run it

Manual 7

- 1 **MODE → F FILE MANAGER → select the program → OPEN.**
- 2 Optional: **MODE → G GRAPHICS** to simulate the toolpath.
- 3 Check the tool offsets (Guide 3) and work offset (Guide 4) the program uses are set, and the part is clamped in the chuck.
- 4 **MODE → 1 AUTO.** For a first run, turn on **SINGLE BLOCK** and turn RAPID and FEED overrides down.
- 5 Close the guards and press **CYCLE START**.



AUTO / MEM screen: positions, modal codes and the running program [Fig. 7.1-1]

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Controls while running Manual 7.1–7.6

Control	What it does
FEED HOLD	Pauses the program
SINGLE BLOCK	One line per CYCLE START press; toggle any time
MPG RUN	Feed follows clockwise turns of the MPG; toggle any time
SPINDLE / FEED / RAPID OVERRIDE	Scale RPM, feed rate and rapid speed
RETRACE	Restart from a chosen line; defaults to where the program last stopped
RESET	Stops the program, returns to line 1 and resets modal codes (work offset back to G54)

CAUTION A program won't start, and will stop, if a software over-travel limit is hit. Make sure the whole toolpath fits inside the travel envelope. [4.7.2]