*AXYZ*

# MOVE
# Customer operating manual

*Prepare • Position • Run • Monitor • Repeat*

A2MC router operation
Illustrated Word edition • 9 October 2026

## ILLUSTRATED REVIEW EDITION

Illustrated with real MOVE screens from live A2MC bench testing. Short operating steps cover program preparation, tools, references, movement and job control. Fitted hardware procedures still require the machine review recorded in the companion validation notes.

**For trained customers using an installed and commissioned machine. Features vary with the fitted equipment.**

# Contents

**Use the chapter links below or Word’s Navigation Pane. Subheadings provide quick reference during operation.**

1 Using MOVE

2 Know the screen

3 Readiness and recovery

4 Load a program

5 Position and repeat parts

6 Run, pause and finish

7 Feed rate and movement

8 References and saved positions

9 Heads and tools

10 Material and height references

11 Outputs and vacuum

12 Camera and AVS alignment

13 Plates and cutoff

14 Optional production equipment

15 Preferences, maintenance and support

16 Quick troubleshooting

**This document covers operation. Installation, account administration, firmware deployment and service calibration are outside its scope.**

# 1 Using MOVE

MOVE loads CNC programs, places parts on the table and controls the job queue. Use this guide with the operating instructions for your installed machine. Only use features fitted and commissioned on that machine.

## Before you start

Know the machine’s emergency-stop and safe-access procedures. Keep the operating area clear and secure the material. PAUSE/STOP, Sleep and output switches do not isolate the machine for tool handling or maintenance.

Check the program revision, active head, tool, work reference and material values before motion. A preview does not prove that the tool will clear the stock, clamps or other heads.

## A normal job

| Step | What to check |
|---|---|
| 1. Prepare | Machine ready; correct material, tools and workholding. |
| 2. Set references | Work offset, wasteboard, cutting mat and material offset match the job. |
| 3. Load | Correct program, units, tool numbers and dimensions. |
| 4. Arrange | Position, orientation, quantity and queue order. |
| 5. Run | Area clear; outputs, feed override and continuation setting correct. |
| 6. Finish | Confirm completion and a safe machine state before unloading. |

## About the pictures

These are real screens from MOVE running against an A2MC test bench. Tool names, values and available equipment are examples, not recommended cutting settings. Enlarged panel views use the same unaltered screenshots.

This is an illustrated review edition. The bench confirms the software workflows described in the accompanying validation record; it cannot qualify physical cutting, tool contact, vacuum holding or optional equipment.

# 2 Know the screen

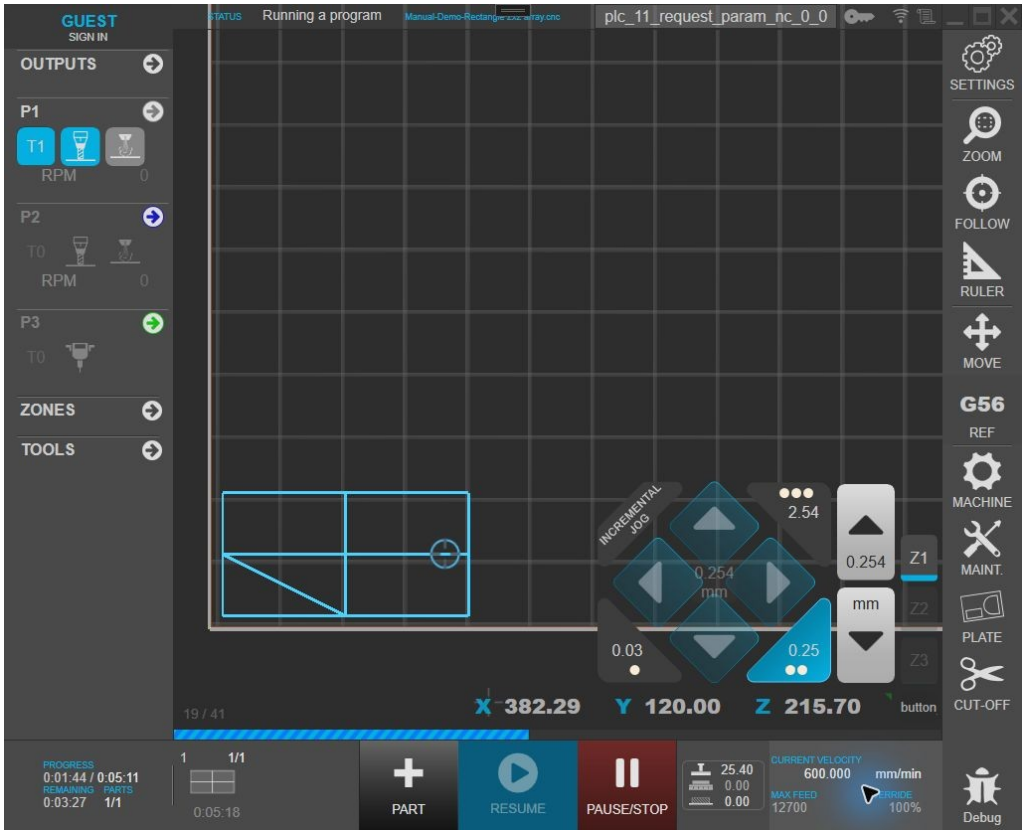



**Figure 1. The operating screen during a program. LOOK FOR: status at the top; equipment at the left; task buttons at the right; queue, RUN/RESUME, PAUSE/STOP and feed along the bottom.**

## Main controls

| Control | Use |
|---|---|
| PART | Open the parts and programs library. |
| Progress / queue area | Open QUEUE and FINISHED. |
| Part thumbnail | Open that part’s action menu. |
| RUN / RESUME | Start the action currently named on the button. |
| PAUSE/STOP | Request a controlled pause during a program. |
| MOVE / REF | Prepare a direct move or select a saved reference/position. |
| MACHINE | Material, wasteboard, mat and fitted equipment controls. |
| Feed display | Open FEEDRATE / UNITS and JOGGING SPEEDS. |

## Enter a value

Select the value, read the limits and units, enter the number, then select enter on the keypad. Use cancel to leave it unchanged. Check the displayed value before selecting a separate Set, Save or motion button.




**Figure 2. Numeric entry. LOOK FOR: the permitted range above the entry and the separate enter and cancel buttons.**

## View and measure

Use the mouse wheel to zoom. ZOOM fits the table view. FOLLOW tracks the head; turn it off before panning freely. These controls change the view, not the job coordinates.

Select RULER and two points to measure a distance. Measure Mode Snap in SETTINGS → CNC affects point selection. Leave RULER when finished. Check which object is selected before dragging: a selected part can move instead of the view.

## Units and position

Select the feed display, then FEEDRATE, to switch mm/in. Check units at the value you are editing; a display-unit change does not rewrite the CNC program’s units.

Build note: in the tested development build, the position ribbon remained in millimetres while other controls displayed inches. Use metric display for this review walkthrough and confirm coordinates before movement. Report a mismatch rather than interpreting the ribbon as inches.

# 3 Readiness and recovery

## Ready state and homing

Complete the machine’s pre-operation checks. Wait for MOVE to connect and synchronize. Read the status and resolve active faults. Confirm the required heads and tools are ready.

When HOME is offered, clear the travel area and follow the machine’s homing procedure. Wait for completion before running work. Recheck references after interrupted homing or a loss of machine position.

## Alarms and messages

Read the complete message. Correct its cause before acknowledging or retrying. For an emergency, use the machine’s emergency-stop procedure.

The history icon at the upper right opens History and Information. Use Open or Download when a log is available. If no log is available, capture the displayed message and record the program and action that caused it.

## Lost connection or interrupted work

After reconnection, check the machine, controller reference, tool and job state. Do not assume the job resumed. Use only the recovery or restart procedure allowed for that job and machine.

Before contacting support, record the machine identity from SETTINGS → ABOUT, the MOVE version/build, program revision, tool, reference, units and exact message. Include a screenshot.

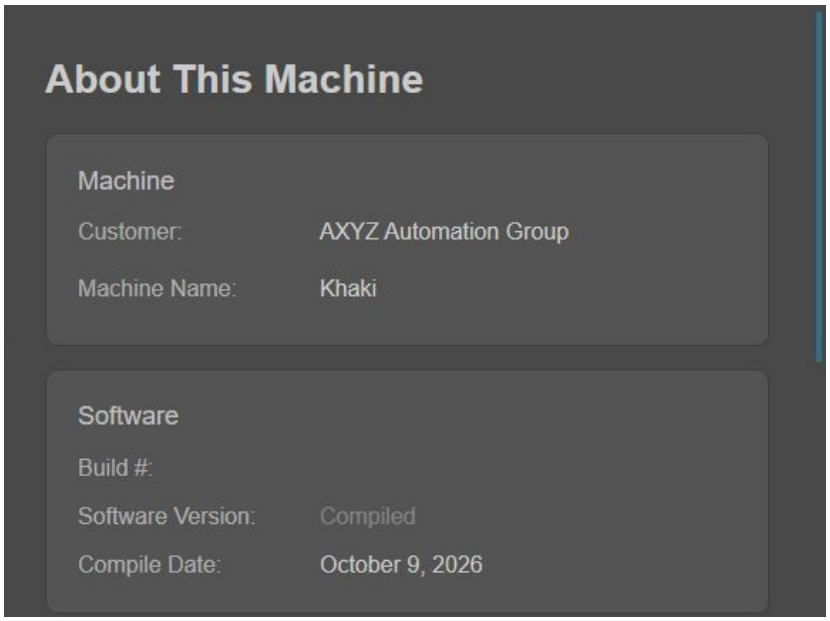



**Figure 3. SETTINGS → ABOUT identifies the machine and software. Record this information with a support request.**

# 4 Load a program

## Find a file

Select PART. Choose PARTS for the configured library, RECENT for recently used programs, or DEMO for examples. Search for the required name and check the revision before loading it. Demonstration files must match the machine and tooling.

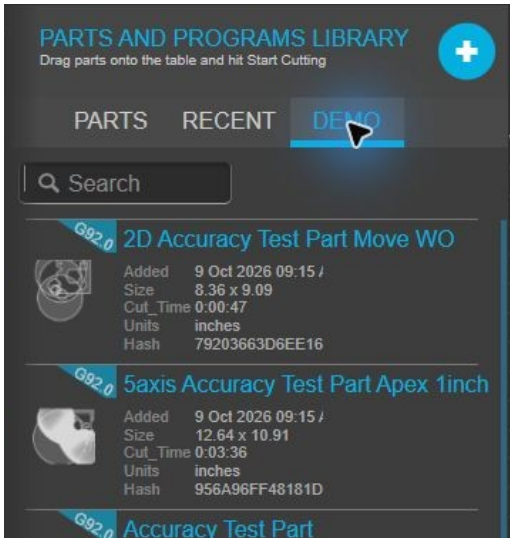



**Figure 4. The library tabs and blue + button. LOOK FOR: the selected tab, program name and units. This pictured DEMO list contains waterjet examples; use programs suitable for your machine.**

## Import a CNC program

1. Select PART, then the blue + button.
2. In Add Program, browse to the CNC file and select Open.
3. Read any warnings. Confirm the name, shape, dimensions and tools.
4. Check that the program appears in the queue. Loading does not start cutting.

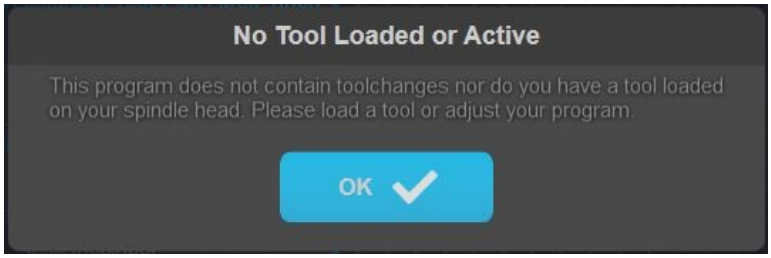



**Figure 5. “No Tool Loaded or Active” means the program has no tool change and no tool is loaded on the spindle head. Load the correct tool or correct the program before running.**

Supported file drag-and-drop and library add actions provide other loading routes. Always inspect the loaded result, including translated programs.

## Change the library folder

With the machine idle, open SETTINGS → SOFTWARE. Use the folder control beside “Change where to search for cnc files,” choose the intended folder and restart when requested. Reopen PARTS and check the files.

For a fitted barcode workflow, use its assigned barcode folder. After scanning, verify the resolved program and preview before running.

# 5 Position and repeat parts

## Open the part actions

Select the part thumbnail along the bottom. You can also open the queue and select the program name. The thumbnail route leaves the whole action menu visible.

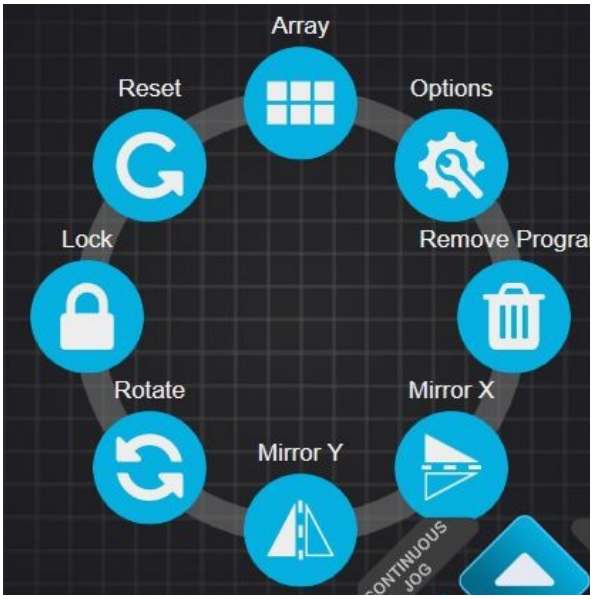



**Figure 6. Part actions. LOOK FOR: Rotate and Mirror for orientation; Lock for editing protection; Array for repeated placement; Options for cycle and continuation settings.**

Drag an unlocked part to position it. Check its full bounds, toolpath and travel clearance against the material before running.

## Rotate, mirror, lock and remove

Choose Rotate and enter the required angle, or select Mirror X / Mirror Y. Check the resulting orientation and bounds. Lock protects the part from the editing actions disabled in that state; unlock before editing.

Reset restores supported part transforms. Remove Program removes the selected queued item. These are preparation controls, not stopping controls.

## Jump and reuse

Jump to Start, Jump Any Point, Jump Pierce Point and Jump to shape number are available only in the relevant job state. Check the selected restart point and required tool/output state before executing the offered jump. Cancel Jump discards the proposed jump.

A finished part can be reloaded at its old location or placed again through its available actions. Recheck stock restraint, tool, reference and quantity before a recut. Remove Ghost removes the selected finished display/history item. CLEAR ALL clears the Finished list; neither starts a cut.

## Create an array

1. Open the part actions and select Array.
2. Set Rows, Columns and Max #. Enter Row Spacing and Column Spacing.
3. Select Array Direction. Check count, spacing and material fit.
4. Select Accept Array, or Cancel to abandon it.

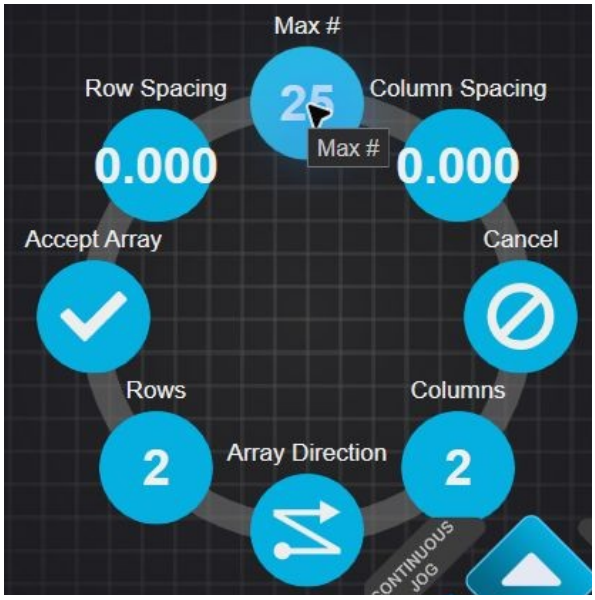



**Figure 7. Array controls. LOOK FOR: row/column counts, spacing and the Accept Array check mark. Use spacing appropriate for your tool and material.**

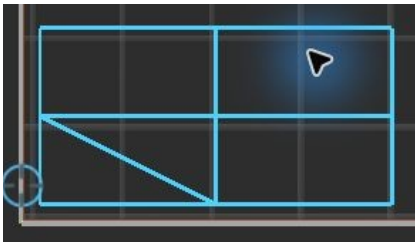


**Figure 8. The accepted 2 × 2 test array. Check the generated layout before running; zero spacing in this bench example is not a recommended cutting clearance.**

An accepted array becomes a generated program. In testing, Reset did not turn it back into one original part. To return to the original, remove the array and reload the source program.

## Cycle and continuation options

In Options, Cycle sets repeated runs at the same placement; it is different from an array. Check the cycle count and whether the next part starts automatically. Review “Apply Header/Footer When Arraying/Cycling” in SETTINGS → CNC before repeating a program with output or tool commands.

# 6 Run, pause and finish

## Check the queue

Select the progress area to open PARTS QUEUE. Check program names and order. Use an item’s drag handle to reorder movable queued work. Active or locked items may not be movable.

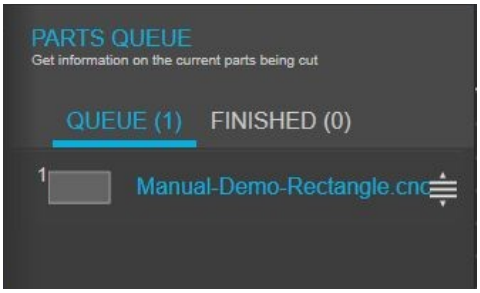



**Figure 9. QUEUE shows upcoming work; FINISHED shows completed work. LOOK FOR: the program name, count and drag handle at the right of the row.**

## Start

1. Check the program, placement, tools, references and workholding.
2. Check feed override, automatic outputs and whether the queue pauses or continues.
3. Clear the operating area. Read the main action label.
4. Select RUN and monitor the first operation.

The main action changes with context. MOVE TO and SAVED POS command movement; HOME starts homing; RESUME continues paused work; RECUT relates to finished work. Close an unwanted movement panel before starting a job.

## Pause and resume

Select PAUSE/STOP. Wait for “Paused in program” and stopped motion. Before RESUME, resolve the reason for pausing and recheck the tool, stock and return path. Resume can include return or repeated-path motion.

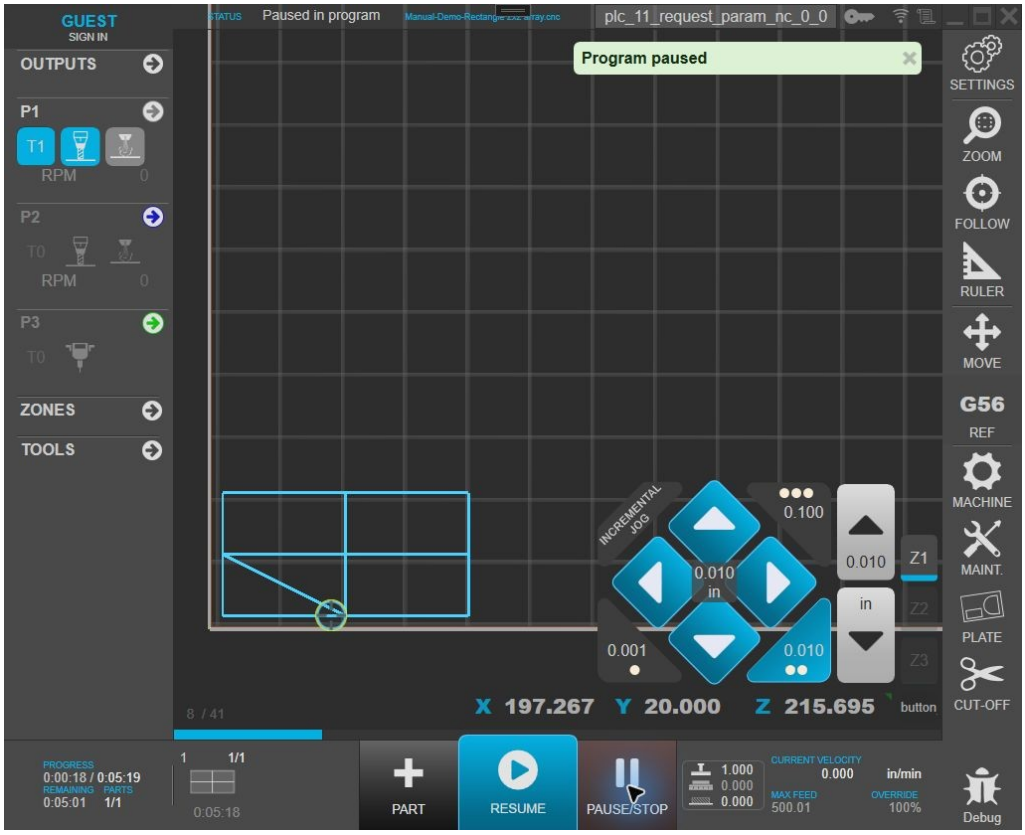



**Figure 10. A confirmed pause. LOOK FOR: “Paused in program,” zero current velocity and the RESUME button. PAUSE/STOP does not provide isolation for access.**

To abandon a job, use its offered Abort Program action and confirm the intended program. Wait for the controller to settle, then review the remaining queue before another run.

## Completion

Wait for the ready/completed state and check FINISHED. Estimated time and a progress bar are not proof of a good cut. Inspect the actual part and put the machine in its required safe state before unloading.

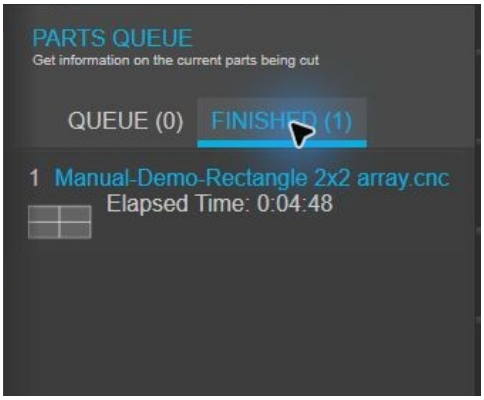



**Figure 11. Completed work appears in FINISHED. Verify the program identity before reloading or recutting it.**

# 7 Feed rate and movement

## Feed override and units

Select the feed display → FEEDRATE. The override slider scales programmed feed: 100% requests the programmed value; 80% requests 0.8 times that value, subject to controller limits. Stay within the approved cutting conditions.

Max Feedrate % limits the slider. The current software caps this setting at 200%. Restore the intended override before another job. The mm/in switch changes display units.

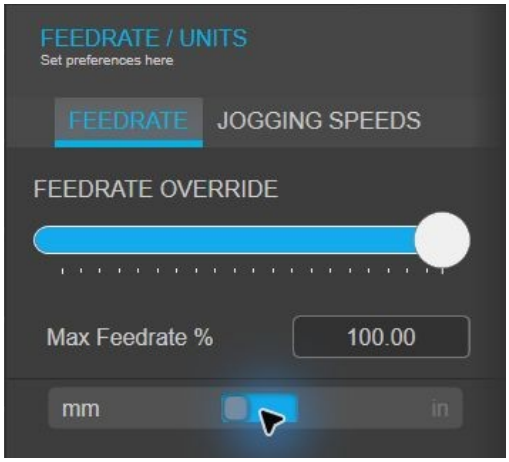



**Figure 12. FEEDRATE / UNITS. LOOK FOR: override slider, Max Feedrate % and mm/in selector. These are separate settings.**

## Jog mode and presets

Use the mode control beside the jog arrows to select Continuous or Incremental. Continuous jogging moves while the direction control is held. Incremental jogging requests one selected step.

Choose the intended axis/head and a suitable speed or small increment. Release a continuous control and verify stopping before changing direction or approaching a limit.

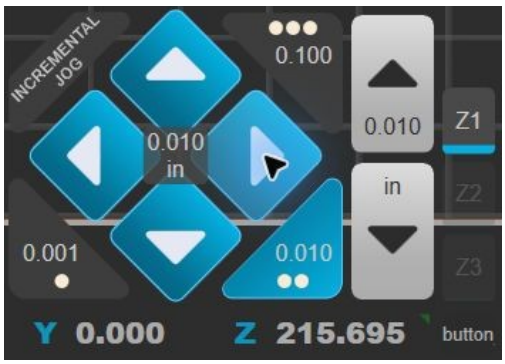



**Figure 13. Incremental jogging. LOOK FOR: INCREMENTAL JOG, the step size, XY arrows and selected Z axis. One 0.010-inch X step was verified on the bench.**

## Pendant, override source and profiles

If fitted, confirm pendant ownership and follow its operating instructions. Select the approved override source or motion profile; these settings do not remove machine limits.

## Jogging speeds

Open the feed display → JOGGING SPEEDS to inspect Slow, Medium and Fast XY/Z values and Increment Move. Do not copy the example values as production settings.

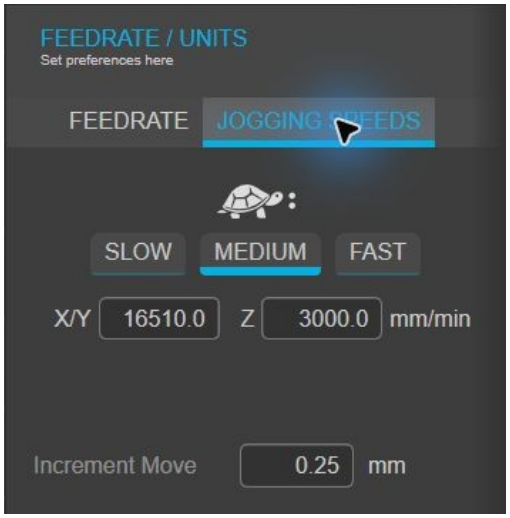



**Figure 14. Jog presets and increment distance. Set these before approaching stock or fixtures.**

## Move to a coordinate

1. Select MOVE. Choose Incremental for a displacement or Absolute for a destination.
2. Enable the required axis fields using their eye controls.
3. Enter the values and check the destination marker and units.
4. Clear the full travel area, then select MOVE TO.

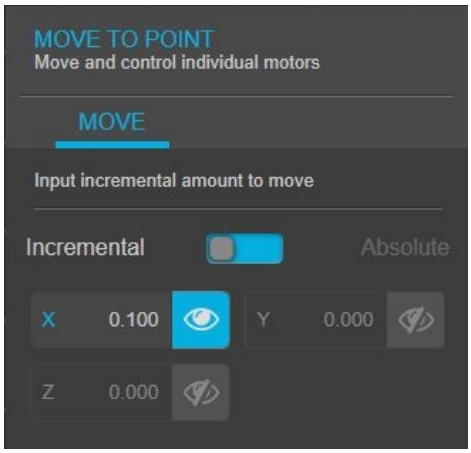



**Figure 15. A prepared incremental move. LOOK FOR: mode, enabled X field and entered value. Preparing a value does not execute the move.**

MOVE TO can include clearance motion, including raising Z. Do not assume unchecked axes remain physically stationary. Watch completion and confirm the resulting coordinates.

# 8 References and saved positions

## Find a reference

Select REF. OFFSETS lists work references such as G54–G59; POSITIONS lists saved destinations. Search for the intended entry and check its name and coordinates.

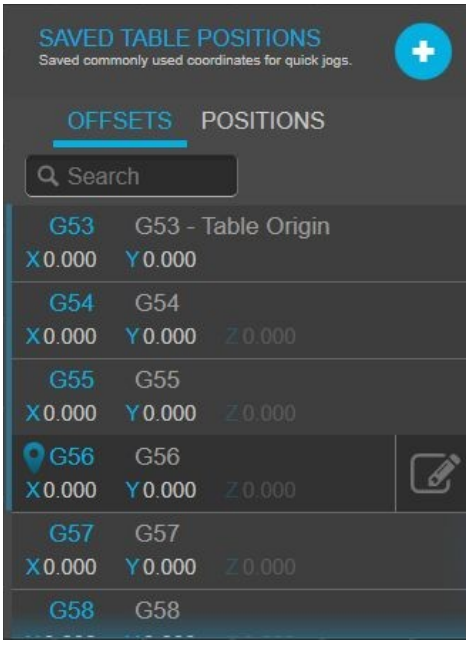



**Figure 16. Reference list. LOOK FOR: OFFSETS/POSITIONS, the selected reference and its edit icon. The main action changes to SAVED POS.**

## Edit or add

Select an entry’s edit control, or + to add an allowed entry. Enter a clear name and the required axis values. The capture controls copy current coordinates; use them only at the verified reference position. Enable only the intended axes and select SAVE. CANCEL leaves the entry unchanged.

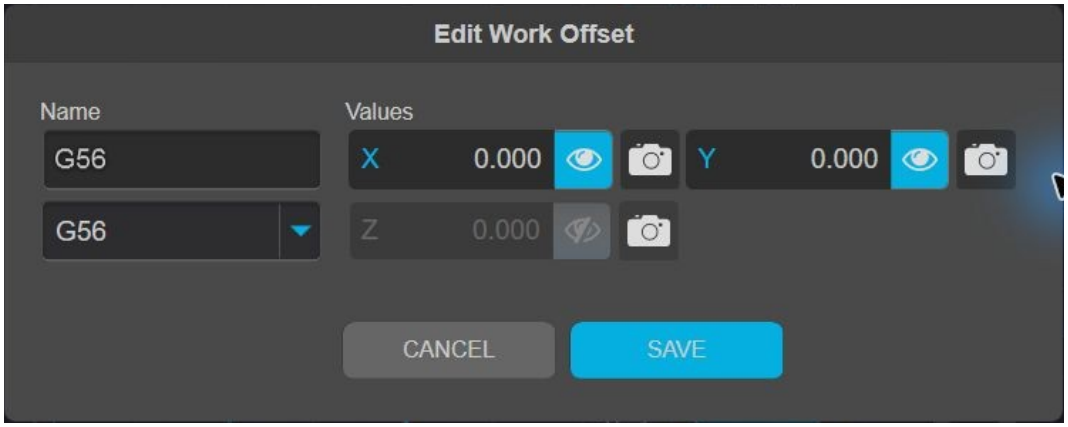



**Figure 17. Edit Work Offset. LOOK FOR: reference selection, axis values, eye/capture controls and SAVE. Check the physical reference before capturing a position.**

## Apply or travel

Selecting/applying a work offset changes how work is referenced. SAVED POS requests travel to the selected destination. Read the current action and allow for clearance motion before pressing it.

Establish references before loading work. If MOVE rejects a reference change while jobs are queued, remove the affected work intentionally, set the reference, then reload and check it.

Remove an obsolete saved entry only after checking its identity and whether your workflow still uses it.

# 9 Heads and tools

## Select the correct head

The left side shows each configured head and its loaded tool. Open the arrow beside a head for HEADS MANAGEMENT. Check the head identity before operating an output or entering Manual RPM.




**Figure 18. Head controls. LOOK FOR: H1/H2/H3, the selected head, separate Auto/Manual output controls and Manual RPM.**

Use Wake/Sleep or Park only through the actions offered for your machine. A sleeping carriage affects attached heads. These are operating states, not isolation. Spacing, docking and head-level operations need the fitted machine's approved procedure and clear travel paths.

## Tool definitions and installed tools

TOOLS → Tool Library contains reusable product definitions. TOOLS → Tools contains the numbered tools assigned to the machine. A definition does not install, load or qualify a physical tool.

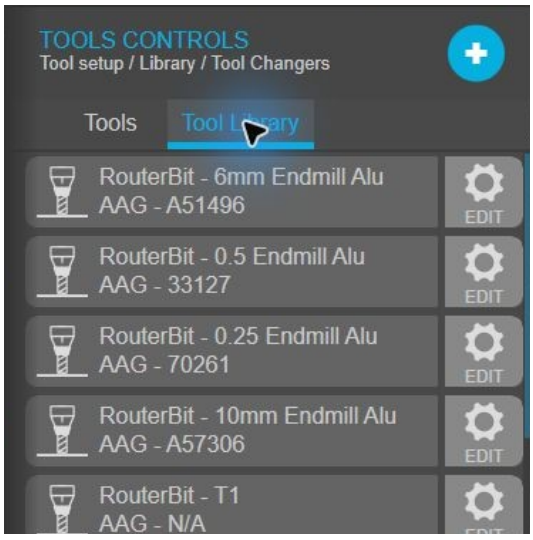



**Figure 19. Tool Library. Select EDIT for a product definition. The blue + adds an allowed new entry.**

To add or edit a definition, select its type and enter the actual product, diameter and approved speed/life values. Save and check the entry. Use the properties required for the fitted knife or other specialized tool; do not copy unrelated geometry.

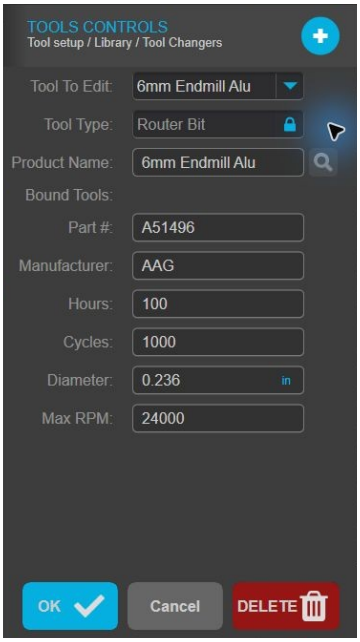



**Figure 20. Library definition. LOOK FOR: product identity, diameter and Max RPM. Example values belong to the pictured product only.**

To create an installed tool, use the definition’s instance/add action. Choose a compatible head, tool number and storage location/changer. Review the name and fitted options, save, then check the Tools list. Install the actual tool in the recorded location and qualify it.

## Load or change a tool

1. Make the required head and changer ready.
2. Open Tools and select the required tool.
3. Read Perform Tool Change and confirm only the intended change.
4. For a manual change, follow the physical tool-handling procedure and the displayed prompt. Confirm only after the tool is fitted and everyone is clear.
5. Wait for completion. Check the tool number on the head and the loaded indication.

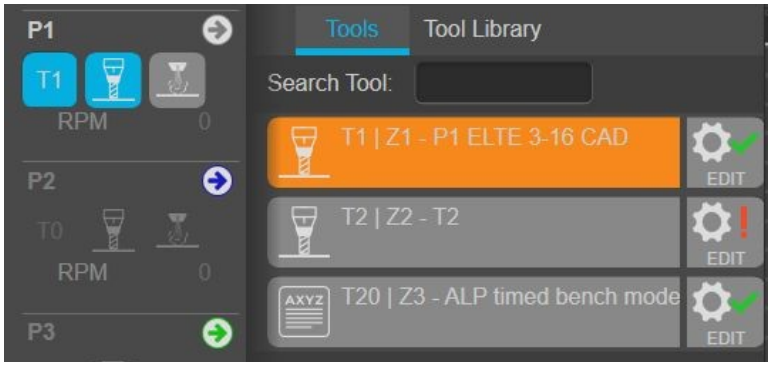



**Figure 21. T1 is loaded on P1 after the manual change. LOOK FOR: T1 on the head and the orange loaded-tool row.**

Selecting an already loaded tool may request unloading. Automatic changes require changer readiness and pressure; stay clear throughout. Cancel or abort if the requested change cannot be completed.

## Edit and qualify

Open EDIT beside the tool number. Check its head/location, options and qualification status. Changing an insert, holder or relevant geometry may require qualification again.

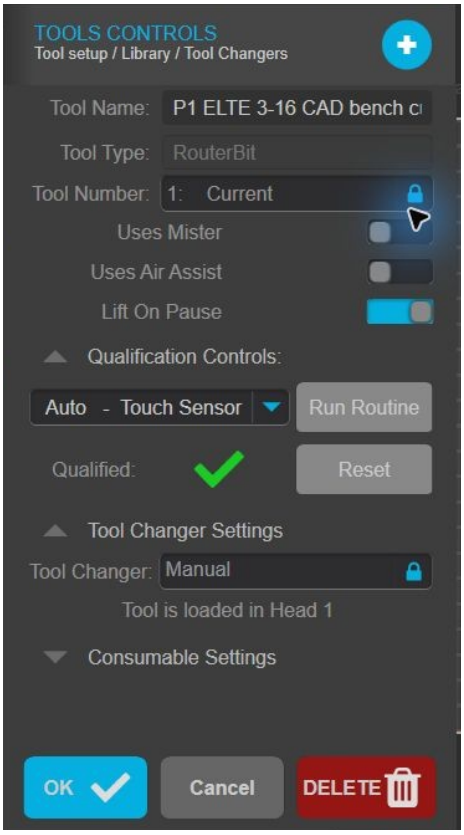



**Figure 22. Installed-tool settings. LOOK FOR: tool number, qualification method, Qualified indication and changer. The bench screen shows Touch Sensor; available methods vary.**

For automatic qualification, select the approved method and Run Routine with the sensor and approach area ready. F25 refers to the supported automatic qualification workflow; F26: Qualify All Tools is a separate group action where available. Verify completion before cutting.

For manual qualification/F24, use the machine’s approved reference surface and approach procedure. Confirm actual contact/reference before accepting the value. Reset invalidates qualification and requires remeasurement.

Do not enter guessed values to bypass a missing sensor or disabled routine. Tool Changers, when shown, reports pressure, ready and busy state; these do not establish safe access.

# 10 Material and height references

Set these values before loading production work. If MOVE blocks a change with queued jobs, remove the affected jobs intentionally, make the change, then reload and inspect them.

## Wasteboard

Select MACHINE → Waste Board. Enter the measured Wasteboard Thickness in the displayed units and select Set Waste Board. Re-read the value. Use “Machine at Waste Board Height” only as part of the approved touch/reference procedure.

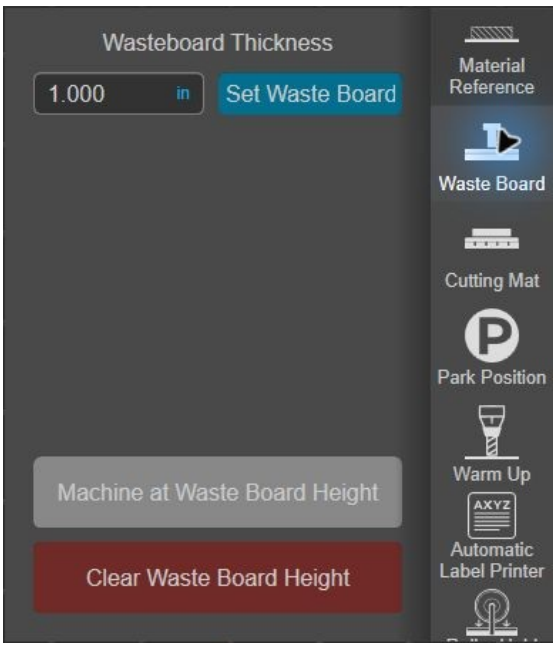



**Figure 23. Wasteboard controls. LOOK FOR: thickness, units and Set Waste Board. Clear Waste Board Height removes the reference; do not use it as routine acknowledgement.**

## Material offset

Select MACHINE → Material Reference. Enter the intended Material Offset and select Set Offset. This adjusts program Z0 and applies to programs added to the queue after setting it. Match it to the way the job was programmed.




**Figure 24. Material Offset. LOOK FOR: Set Offset and the diagram relating material to the wasteboard.**

“Machine at Material Surface” uses a verified physical reference position. Clear Material Offset removes the offset. Do not use either to hide an unexplained depth error.

## Cutting mat

Select MACHINE → Cutting Mat. Enter the actual mat thickness, use Set Cutting Mat and set Apply Cutting Mat as required. Verify the resulting state before loading work. The machine-at-mat method requires the correct loaded, qualified tool and an approved physical reference procedure.

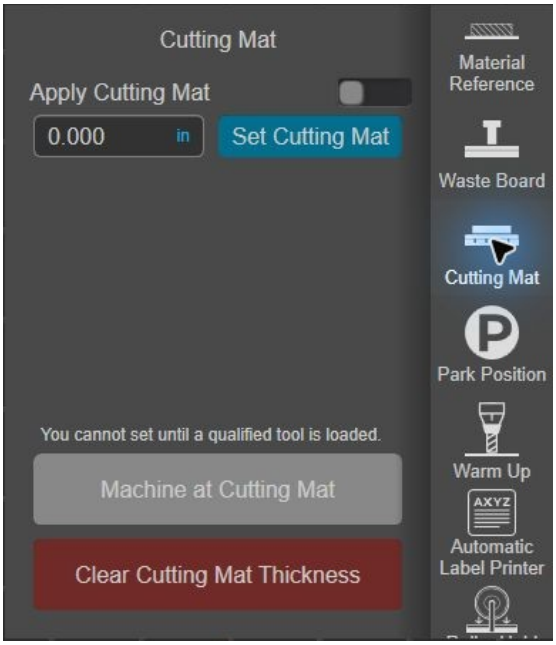



**Figure 25. Cutting Mat. LOOK FOR: Apply Cutting Mat, thickness and Set Cutting Mat. A disabled action may require a qualified loaded tool.**

## Compensation

Check the program's compensation method and tool diameter together. Where the main cutter-compensation trim is shown, its current limit is ±0.127 mm (±0.005 in). It is a temporary trim, not a permanent tool-diameter edit. Recheck the path after changing it.

## Spindle warm-up

Select MACHINE → Warm Up, select the available spindles and choose Launch Warmup. Follow the progress prompts and keep clear until completion. Use the spindle's approved warm-up requirement. An empty list or disabled action needs readiness/configuration checks, not guessed settings.

# 11 Outputs and vacuum

## Automatic and manual outputs

OUTPUTS lists configured general outputs; the head arrow opens head-specific controls. Auto enables the programmed behavior. Manual requests the displayed output state. Check which mode you are changing and restore the intended state before running.

For dust extraction, pins, mister, air assist or named auxiliary outputs, follow the fitted equipment’s operating sequence. A displayed output state does not prove airflow, pressure, spindle speed or physical actuation.

## Vacuum zones

Select ZONES. Set each zone to the offered Off, On or Auto state. To set all zones, choose the state beside All Zones and select Apply. Inspect the result and actual material restraint.




**Figure 26. Zone Controls. LOOK FOR: the mode tabs, individual zone selectors, All Zones / Apply and Show overlay.**

## Vacuum modes

| Mode | Operator use |
|---|---|
| SIMPLE | Basic automatic-zone behavior. Check the required zones and turn unused ones off. |
| LIVE DECK | Automatic zones follow the configured cutting-head region. Check the overlay and holding area; radius adjustment is machine-dependent. |
| PENDULUM | Set the Pendulum Line and confirm both operating areas and their zones. |

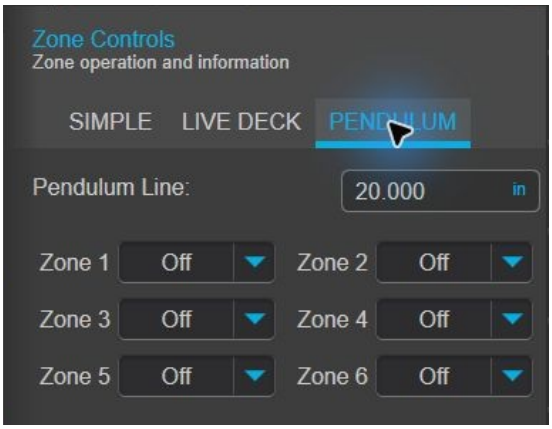



**Figure 27. PENDULUM adds the dividing-line value. This controls vacuum behavior; it does not make the other side safe to enter.**

Mode changes affect automatic zones. Forced On/Off selections still need checking. Vacuum pendulum and roller pendulum are separate settings.

# 12 Camera and AVS alignment

Use this chapter only with a commissioned alignment camera and a suitable registration program. Camera calibration and camera-to-tool offsets are service settings.

## Align a job

1. Load the registration program and confirm stock, tool and work reference.
2. Open the available camera/alignment control. Confirm a live, usable image.
3. Start the offered alignment sequence. Inspect the current mark and requested point.
4. Use Next to record the correct point and advance.
5. Complete the required marks and use Apply Offsets when offered.
6. Check the transformed path and next action before cutting.

The basic calculation needs at least two usable points; the selected method or job can require more. A failed or partial sequence is not completed alignment.

## Skip, retry and automatic progression

Skip excludes the current point. Use it only when the remaining marks are sufficient for the approved method. Retry or reposition when a mark is wrong; do not accept an unrelated feature.

Auto Proceed can advance and apply alignment automatically, and the workflow may continue into execution. Do not assume Test Mode prevents motion. Keep the machine ready for the next commanded action.

If alignment is wrong, stop the workflow and check program revision, mark order, stock, tool, reference and image. Re-establish alignment rather than adding guessed offsets.

# 13 Plates and cutoff

## Define and locate a plate

Select PLATE, then +. Enter Plate Title, Plate Material, Width and Height, and SAVE. Check the dimensions and units. Select the plate and Load Plate To Grid.

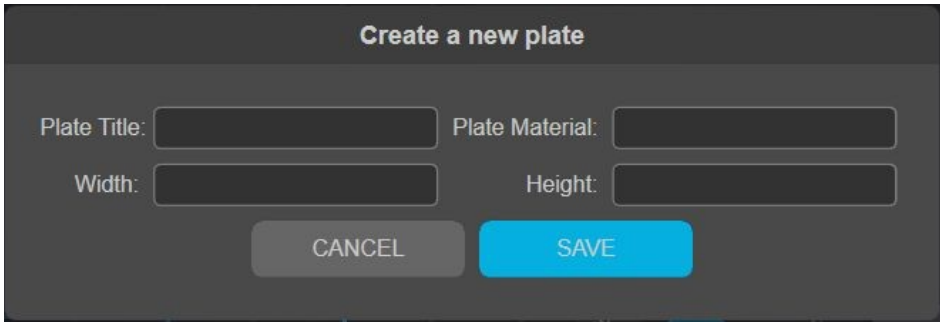



**Figure 28. Create a new plate. LOOK FOR: identification and both dimensions before SAVE.**

Follow the location prompts: select the intended corner, establish the marker position, select Next and the edge, then Save. Check the displayed plate against the actual stock. Cancel an incorrect location.

Set padding for the required margin. Auto Rotate and its related Lock option affect placement relative to the plate; inspect affected parts. Remove Plate removes its displayed placement, not the physical stock.

## Create a cutoff

1. Select CUT-OFF and the correct head/tool.
2. Check Feedrate, Edge Offset and any displayed depth, safe-height or pass settings.
3. Select Draw Cut-Off and mark the required path.
4. Correct it with Undo Last Line or Remove All Lines.
5. Check restraint and clearance, then select Create.
6. Inspect the resulting operation before running it.

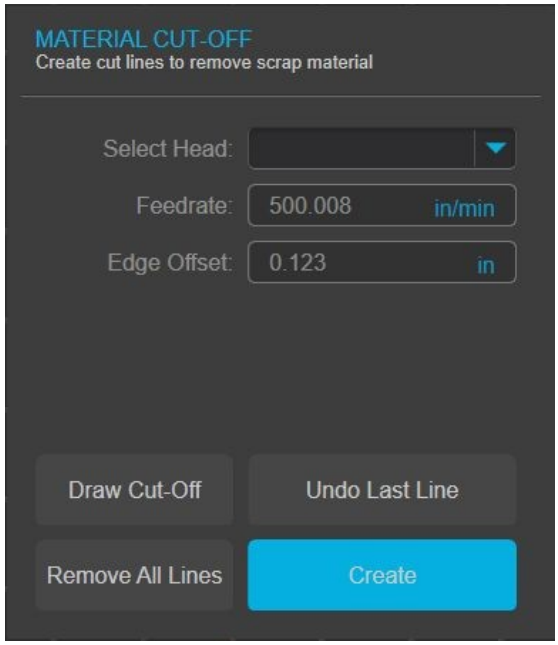



**Figure 29. MATERIAL CUT-OFF. LOOK FOR: head selection, feed/offset, drawing controls and Create. Creating the operation does not mean a cut has finished.**

A cutoff may free loose material. Plan how it remains supported. Use optional Cut B only for a machine and job that define that action.

# 14 Optional production equipment

Use only the section matching the equipment on your machine. The bench screens below illustrate the controls; they do not demonstrate a completed physical equipment cycle.

## Roller hold-down

Select MACHINE → Roller Hold Down. Enter Material Length, select Front Position and set Enable Rollers / Enable Pendulum Mode as required. Select Set Rollers and verify every setting.

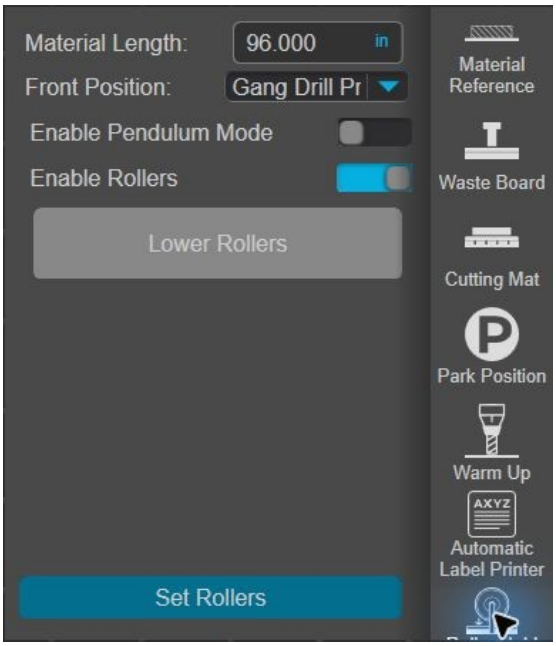



**Figure 30. Roller settings. LOOK FOR: length, front position, enable switches and Set Rollers. The Lower/Raise action operates the mechanism when available.**

Keep clear before Lower Rollers or Raise Rollers. If a setting fails, read back all values before retrying; the other settings may already have changed.

## Loading, unloading, conveyor and pinch

On fitted equipment, Load Material, Unload Material or Load and Unload starts the named routine. Check incoming stock, receiving area and guarding, then monitor through completion. A “Loading” message acknowledges the request, not a finished cycle.

Chain controls can offer In Feed, Out Feed, Neutral, manual +/− motion and Load. Pinch controls can offer a destination, Retract and +/− jogging. Check the direction, sensors and stock path before movement. Use the installation’s prescribed offsets and sequence; do not alternate commands to clear an unexplained obstruction.

## Rotary A axis

Use the matching fixture and rotary program. Check rotary enable, material reference and the axis convention. Home A Axis when required. Verify position and clearance before the job.

Operator-side/inversion choices affect motion interpretation. Keep commissioned centre/chuck/limit values unless the approved fixture-change procedure calls for an adjustment.

## Automatic labels

Select MACHINE → Automatic Label Printer. Choose the actual Label Size and compatible Label Applicator, then Set ALP Parameters. Verify the result and match the loaded label stock to the selection.

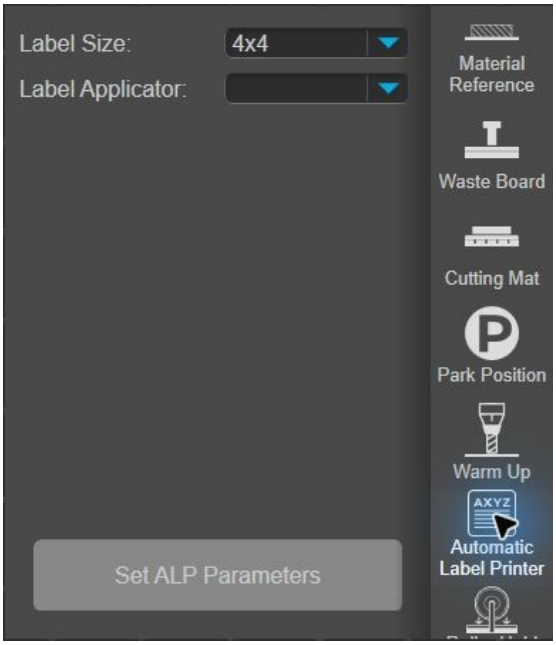



**Figure 31. Label settings. A missing Label Applicator selection prevents Set ALP Parameters. The button updates settings; it is not a completed label cycle.**

## Specialized heads and copy tools

Use the definition and qualification method for the fitted knife, oscillating, tangential, tapping or other tool. For copy tools, check the leading tool, following heads and spacing before running. Head calibration and gantry alignment are outside normal operation.

## Parking

Select MACHINE → Park Position where available. Check the stored destination and enabled state. Edit only to record an approved destination. Clear the travel area before Move To Parking Position. Parking does not isolate the machine.

# 15 Preferences, maintenance and support

## Display and library preferences

SETTINGS → PROGRAM provides Toggle fullscreen (F11) and Close Program. Complete the machine operation and shutdown procedure before closing MOVE.

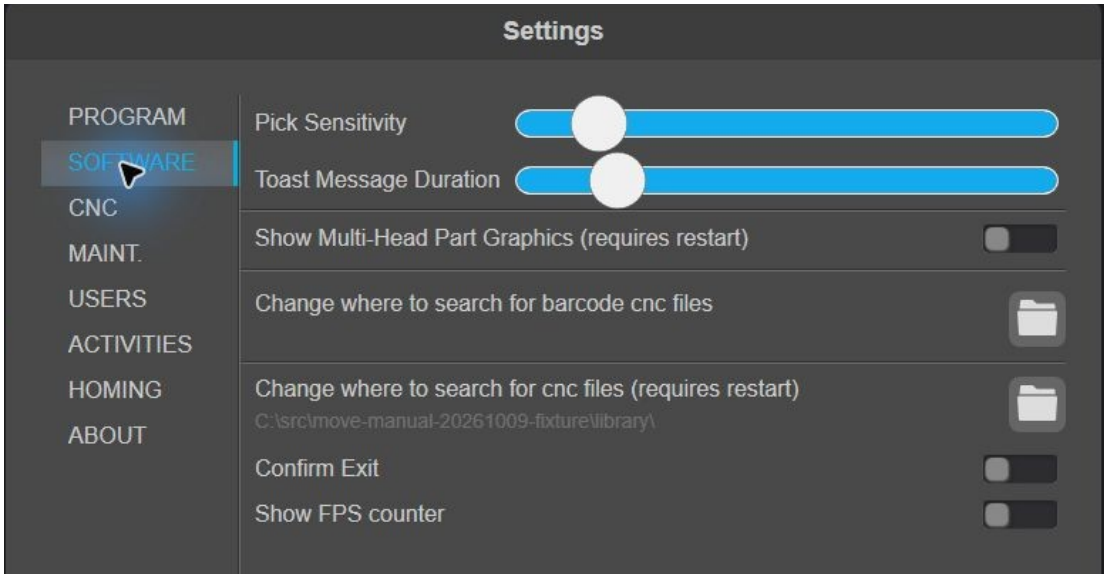



**Figure 32. SETTINGS → SOFTWARE. LOOK FOR: selection sensitivity, message duration, library folders and restart requirements.**

Pick Sensitivity affects selection. Toast Message Duration controls notification visibility. Show Multi-Head Part Graphics and the CNC folder change require the indicated restart. Confirm Exit adds a prompt; Show FPS counter is a display diagnostic.

## Language and identity

Where ABOUT offers Language, select the required display language and check the labels. Keep the machine name consistent with your records. A display-name change does not select a different controller.

## CNC preferences

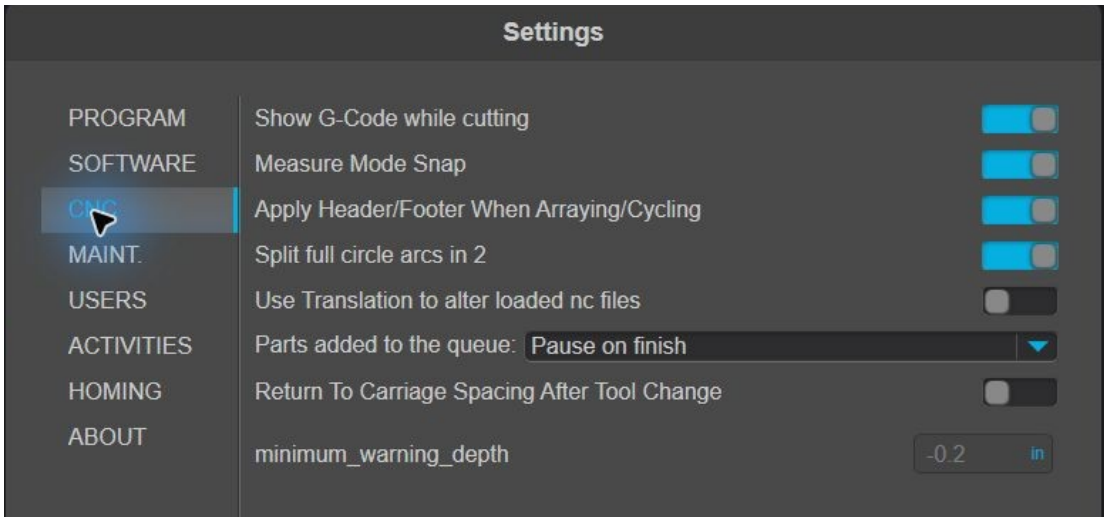



**Figure 33. SETTINGS → CNC. LOOK FOR: the queue continuation choice and options that alter program handling.**

| Preference | What to check |
|---|---|
| Show G-Code while cutting | Display preference; it does not validate code. |
| Measure Mode Snap | Point-selection behavior for the ruler. |
| Apply Header/Footer When Arraying/Cycling | Whether program start/end commands repeat. |
| Split full circle arcs in 2 | Program handling; recheck the loaded result after a change. |
| Use Translation to alter loaded nc files | Applies configured translation; inspect the resulting program. |
| Parts added to the queue | Choose Pause on finish or Auto-continue for the approved workflow. |
| Return To Carriage Spacing After Tool Change | Allow for the fitted machine’s spacing motion. |
| Minimum warning depth | A warning threshold, not a physical depth stop. |

Some configurations also offer M01 optional stops, Z/paused jogging, head lift, height-setting offset or Reverse Time. Use only the options shown for your machine. Check time/length units and the return or repeated cutting path before changing them.

## Consumables

Select MAINT. to review tracked usage/life. Hide Unloaded Consumables filters the list. Counters record time or cycles; inspect the actual tool/component as well.

After the physical replacement, choose Replace Same, Replace Different or Replace Existing as appropriate. Confirm the location and product, then check the resulting record. Remove applies when the item has left that location. Existing items retain their usage; they are not automatically new.

If the action is unavailable to your operator role, use the normal authorized maintenance process. Automatic consumable records do not install or qualify a tool.

# 16 Quick troubleshooting

| Symptom | What to do |
|---|---|
| RUN is unavailable or shows another action | Check status, active panel, queue, tool and qualification. Read the action label before pressing it. |
| No Tool Loaded or Active | Load the correct tool or correct the program’s tool selection. Verify the head’s tool number. |
| A part will not move/edit | Check selection, lock and whether it is already running. |
| Need one part instead of an accepted array | Remove the generated array and reload the original program. |
| Reference change rejected | Remove affected queued work intentionally, set the reference, then reload and inspect. |
| F25 or a tool change is unavailable | Check the fitted method, loaded/active tool, changer readiness and sensor. Do not bypass a missing condition with guessed values. |
| Unexpected depth | Stop. Reconcile qualification, program Z convention, wasteboard, mat and material offset. |
| Vacuum does not match the selected mode | Check each forced On/Off state, automatic zones and actual holding. |
| AVS result is wrong | Recheck marks, program, image, stock, tool and reference; repeat the approved alignment. |
| Connection restored but job stopped | Review the controller/job state and use the permitted recovery procedure. |
| Equipment command reports an error | Read back state; some settings may have changed. Follow the equipment recovery procedure. |
| Position units appear inconsistent | Stop and reconcile units. This development build’s ribbon remained in mm in the inch display setting. |

## Before each production run

Confirm the program revision and quantity; stock and restraint; heads, tools and qualification; units and work reference; wasteboard/mat/material values; placement and travel clearance; output/vacuum states; feed override; queue continuation; and the exact next action on screen.