

USING THE SKEW PROBING CYCLE ON YOUR HURCO MILL

Instructions:

1. INPUT Key
2. PART SETUP Softkey
3. PART PROBING Softkey
4. You will need to find your part zero first, so you will want to select PART ZERO PROBE CYCLES Softkey
5. You can use any of these cycles listed on the screen, but for demonstration purposes we are going to select the PLANE INTERSECTION softkey
6. Once you are at this screen you will need to tell the control which direction in X and Y you want to move, as well as the distance between probe touches.
7. You will then select START PROBING CYCLE and press the CYCLE START button
8. Once you have your part zero set you will want to move onto your skew cycles. So you will need to EXIT the probing screen and select PROBE SKEW CYCLES Softkey

9. On this screen you will see that we have quite a few options for skew cycles. For demonstration purposes we are going to select TWO POINT EDGE

10. For this particular cycle you will have to move your probe into the starting position using the handwheel.

11. You will then tell the control which direction you would like the probe to move [+ or -] for the second touch to contact the part, then input the offset between the two probe touches.

12. Press the START PROBING CYCLE softkey and CYCLE START

13. In this example you can see that the probe will make its first bump, then it will move 8" which is the offset we set for our probe for its second touch.

14. Your skew angle results will appear in the results screen, press YES to accept them.

15. For future reference, you can also find view your current skew angle in the PART SETUP screen.