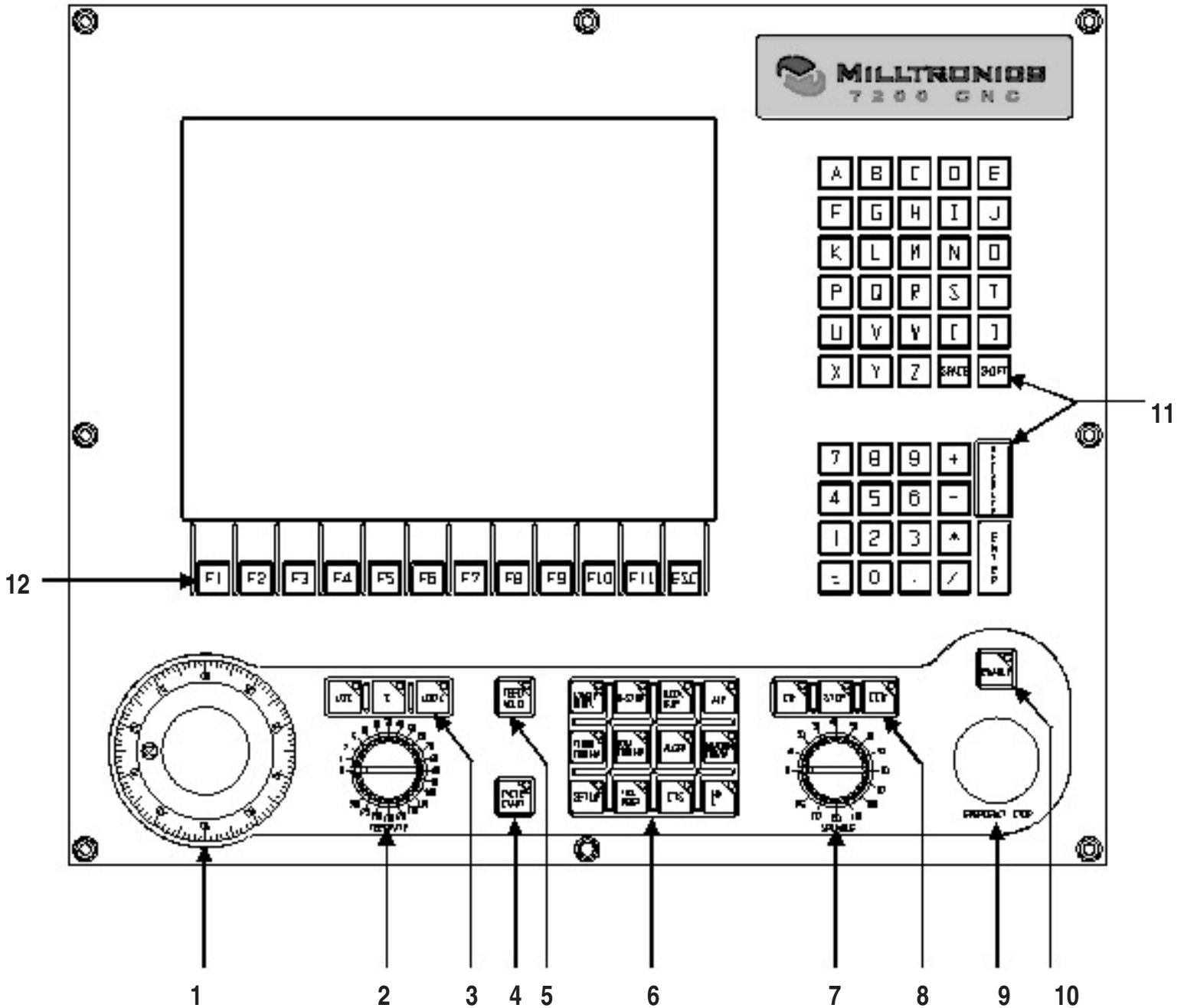




Milltronics 7200 Control Panel

7200 Series CNC TIPS are applicable to the Milltronics 7200 Series controls.



- **Power ON:** The main power switch is located on the electrical cabinet at the back of the machine. When main power is switched on, the power to the CNC is also applied.
- **Power OFF:** Before switching off the main power, press the E-Stop button to ensure the machine is in emergency stop mode.

(over)



Milltronics 7200 Control Panel Page 2 Continued

1. Manual Pulse Generator (Handwheel): Rotate this wheel to control axis feed while in HDW mode.
2. Feedrate Override Switch: Labeled in percentages. Controls the feedrate and rapid traverse (exception - see #3) of the machine axes. Also affects handwheel rate.
3. Rapid Override Buttons: By selecting 10% or 100%, rapid will run at the selected rate regardless of feedrate override control. By selecting “%”, the feedrate override setting controls the rapid speeds.
4. Cycle Start Button: Starts automatic operation. In most cases the control will prompt the operator when this button needs to be pressed.
5. Feedhold Button: Illuminated when active. Pauses axis movement. When feedhold is active and HDW mode is selected, the axes can be positioned with the handwheel. Opening the chip pan enclosure doors may cause a feedhold condition.
6. Machine Function Buttons: Illuminated when active. These control dedicated machine functions. Configuration varies by machine type and options.
 - Single Block: Single block program execution on/off.
 - Optional Stop: Optional stop (M01) on/off.
 - Block Skip: Block skip function (/) on/off.
 - Air: Air blast function on/off
 - Flood Coolant: Flood coolant function on/off.
 - Mist Coolant: Mist coolant function on/off.
 - Auger: Auger or Conveyor chip removal function on/off.
 - Washdown Coolant: Washdown function on/off.
 - Setup: Releases the enclosure door safety interlock. Holding the switch in with the enclosure door open will allow axis jog.
 - Tool Reset: This button is a safety interlock. It prevents the spindle from starting during a manual tool change. It will flash during a tool change and needs to be pressed after the tool change is completed before program operation can be resumed. The control will display a prompt as to when this button needs to be pressed.
 - CTS: Coolant through spindle function (if equipped) on/off.
 - Spindle Jog: Used to rotate (lathe) spindles at slow speed for setup use. Especially useful for turning large chucks.
7. Spindle Override Rotary Switch: Labeled in percentage of programmed spindle rpm. Controls the actual spindle rpm.
8. Spindle Function Buttons: CW button starts spindle in clockwise direction provided there is a programmed spindle rpm. CCW button starts spindle in counter-clockwise direction provided there is a programmed spindle rpm. Spindle Stop button stops spindle rotation.
9. Emergency Stop Button: Disables machine motion, control enable, and axis waylube oiler. Emergency stop buttons lock down when pressed and must be rotated to release.
10. Enable Button: When pressed and released it enables axis and spindle drives. All Emergency stop and limit switches must be released for drives to enable.
11. Alphanumeric Keypads: Used to enter characters in MDI mode or program mode.
12. Function Keypad: Used to select machine functions that are shown along the bottom of the operator’s panel display.