HAAS C.N.C. MILL SETTINGS
EXERCISE 1

The **SETNG** display lists some parameters that the user has easy access to. These parameters are called settings and you can change them during the operation of the machine.

1. **What is the serial number of your control, which is listed on Setting 26?**

2. **What is Setting 33? What setting choices do you have?**

3. **What is the Setting number for Door Hold Override? Turn it on.**

4. **What is Setting 32? What does the selection of IGNORE do?**

5. **What is Setting 30? Set it at HA5C.** (*To be able to change this, you need to have EMERGENCY STOP engaged. Be sure that your machine is POWERED OFF when you hook up a rotary unit.*)

6. **What does Setting 42 do when it's on?**

7. **What is the page title that is highlighted and listed on the top of the display page that has Setting 11, Baud Rate Select, listed on it?**

8. **On the Setting display page titled EDITING, what setting number is for the Parameter Lock?**

9. **On the Settings display page titled GRAPHICS, what setting number is for turning on and off the Rapid Path in Graphics?**

HAAS C.N.C. MILL SETTINGS
EXERCISE 1 Answers

The **SETNG** display lists some parameters that the user has easy access to. These parameters are called settings and you can change them during the operation of the machine.

1. **What is the serial number of your control, which is listed on Setting 26?**
   Each machine will have a different number.

2. **What is Setting 33? What setting choices do you have?**
   Coordinate System, choices are FANUC, HAAS, or YASNAC.

3. **What is the Setting number for Door Hold Override? Turn it on.**
   51

4. **What is Setting 32? What does the selection of IGNORE do?**
   Coolant override, M08 and M88 coolant commands will be ignored, but you can still manually turn on with the coolant key.

5. **What is Setting 30? Set it at HA5C.** (To be able to change this, you need to have EMERGENCY STOP engaged. Be sure that your machine is POWERED OFF when you hook up a rotary unit.)
   4th Axis Enable

6. **What does Setting 42 do when it's on?**
   The machine will program stop after a tool change.

7. **What is the page title that is highlighted and listed on the top of the display page that has Setting 11, Baud Rate Select, listed on it?**
   RS-232 PORTS

8. **On the Setting display page titled EDITING, what setting number is for the Parameter Lock?**
   7

9. **On the Settings display page titled GRAPHICS, what setting number is for turning on and off the Rapid Path in Graphics?**
   4

HAAS C.N.C. MILL DISPLAY MODES
EXERCISE 2

1. **To power up a Haas machine and to start running a part that has been proven and is in production, which three buttons do you need to press to start the machine cycle for that part setup?**

2. **While running a program in MEM operating mode and on the PRGRM display, which key do you press to get a Program Review of the program that you're pres ently running?**
   1) F1
   2) F2
   3) F3
   4) F4

3. **You may edit a program in memory while another program is running. When you're running a program in the PRGRM Display mode and MEM operating mode, how do you get into Background Edit?**

4. **One of the four POSIT displays will "zero out" all axes when you select a different operation mode and then switch back by pressing HANDLE JOG. Which position display will be at zero to begin showing a distance moved?**

5. **How many tool length offsets are available in the OFSET display?**

6. **How many work zero offsets are available in the OFSET display?**

7. **How many calculator pages do you have to choose from in the CALC display? What are they?**

8. **The HELP display is a mini-manual that will list and briefly explain some of the functions of a Haas machine. How do you select one of the subject areas in the Help directory?**

9. **Which button do you press to "zero out" Tool Life, Tool Load, Timers and M30 Counters when you highlight these readouts in the CURNT COMDS display?**

10. **Which Setting number selects how tool size is specified, Radius or Diameter for cutter compensation in the SETNG display?**

HAAS C.N.C. MILL DISPLAY MODES
EXERCISE 2 Answers

1. **To power up a Haas machine and to start running a part that has been proven and is in production, which three buttons do you need to press to start the machine cycle for that part setup?**
   POWER ON, POWER/UP RESTART, and CYCLE START.

2. **While running a program in MEM operating mode and on the PRGRM display, which key do you press to get Program Review of that program you're presently running?**
   1) F1
   2) F2
   3) F3
   4) F4

3. **You may edit a program in memory while another program is running. When you're running a program in the PRGRM Display mode and MEM operating mode, how do you get into Background Edit?**
   Enter the program number and press F4.

4. **One of the four POSIT displays will "zero out" all axes when you select a different operation mode and then switch back by pressing HANDLE JOG. Which position display will be at zero to begin showing a distance moved?**
   The DIST-TO-GO display

5. **How many tool length offsets are available in the OFSET display?**
   100 tool offsets. Software ver. 10.22 tool offsets increased to 200.

6. **How many work zero offsets are available in the OFSET display?**
   26

7. **How many calculator pages do you have to choose from in the CALC display? What are they?**
   Three, Trigonometery, Circular, and Milling and Tapping.

8. **The HELP display is a mini-manual that will list and briefly explain some of the functions of a Haas machine. How do you select one of the subject areas in the Help directory?**
   By pressing the letter next to the topic for information.

9. **Which button do you press to "zero out" Tool Life, Tool Load, Timers and M30 Counters when you highlight these readouts in the CURNT COMDS display?**
   ORIGIN

10. **Which Setting number selects how the tool size is specified, Radius or Diameter for cutter compensation in the SETNG display?**
    40

HAAS C.N.C. MILL PARAMETERS
EXERCISE 3

Parameters are rarely changed by the user and Setting 7 Parameter Lock should be on. But you may decide to turn on REPT RIG TAP, in Parameter 57. This is for the machines that have the Rigid Tap option. It will allow you the ability to follow into a hole that has allready been tapped, so as to go deeper. All you would need to do is progam a deeper Z depth, or offset down the distance of one pitch of the thread to follow into an existing tapped hole. Follow these steps to change this parameter.

1. Press the SETNG Display.

2. Cursor to Setting 7 Parameter Lock (*type 7 and cursor arrow down*) and press the left or right cursor arrow to select OFF press WRITE/ENTER.

3. Press PARAM Display.

4. Cursor to Parameter 57, which is a collection of general purpose single bit flags used to turn functions on (1) or off (0).

5. To cursor thru all the different bits in this parameter, use the left or right cursor keys, Not the up or down keys, or use the handle.

6. You need to push in EMERGENCY STOP to change any parameters.

7. Cursor to REPT RIG TAP enter a 1 and press WRITE to turn it on.

8. Now go back to the SETNG Display page. Cursor to Setting 7 Parameter Lock, turn it back on, to lock out any other changes being made. Release EMERGENCY STOP and press reset twice.

NOTE: Parameters are seldom-modified values that change the operation of the machine. These include servo motor types, gear ratios, speeds, stored stroke limits, lead screw compensations, motor control delays and macro call selections. Modifying some of these functions may void any warranty on machine. If you need to change parameters, contact Haas or your dealer. Parameters are protected from being changed by Setting 7. Also be sure to save a copy of your machine parameters as a backup if needed.