

Knowledge Base: KB1024 – HP3 Controller Menu Functions

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APEX HP3 Menu

Batching	To aid the user running a set number of the same job.
Clear Home	To clear the currently active HOME position.
Configuration	Sub-Menu – allows for additional configuration. See the Configuration table.
Cut Speed	To set the speed during cutting.
Define Preset Home**	To set the “preset home” to the current position.
Display Job Time	To display the cycle time of the last complete job.
Ethernet Settings	Sub-Menu – allows configuration of Ethernet Settings. See the Ethernet Settings table.
Jog X Y Axis	To move the tool while displaying X/Y position.
Load Preset Home**	To load a previously defined preset home.
Move X Y Axis	To program a specific X/Y move /position.
Parking	To select the parking method (either NONE, PARK, or HOME).
Pocket Milling**	To allows the user to machine jobs within a deep pocket (up to the length of stroke on the spindle).
Pos After Datum**	To establish an origin after datuming the controller via the controller's front panel.
Purge Job	To abandon the current job in memory, and empty the job buffer.
Run Self-Test	To execute the built-in 10” square, self test program (HOME is lower-left).
Select Interface	To select the interface (either HPGL or G&M code).
Set Dwell Down	To set the delay, prior to starting motion with the tool DOWN.
Set Dwell Up	To set the delay, prior to starting motion with the tool UP.
Z Axis Speed*	To set the down travel rate for the controlled Z spindle.
Z Cut Depth*	To set the (total) depth of cut.
Z Delta*	To set the incremental depth of each engraving pass ('0' disables multi-pass).
Z Lift Height*	To set the distance that the tool will retract above the surface during engraving.

* Available only if Spindle Setup is “Controlled + Pneumatic”.

** Available only if datums are defined (Limit Mask is non-zero).

Configuration Sub-Menu

Display Units	To change between metric and imperial units.
DNC_Mode	To change the DNC mode from remote or local.
X Limit	To Enable / Disable the X datum.
Y Limit	To Enable / Disable the Y datum.
Z Limit	To Enable / Disable the Z datum.

Ethernet Sub-Menu

Specify IP	To manually set the IP address or use DHCP.
Display IP	To display the IP and subnet mask of the controller.
Display Host	To display the IP address of the host computer running Job Server.