

This document will explain how to switch operating units on the Techno HDS system. The HDS-Osai Techno system will operate in inches or millimeters. The following files and folders are involved in changing units. In the upp on "nc001" (Z) : Macros\ folder -P01M006 -P01M006.mm or -P01M006.inc -P01M401 -P01M401.mm or -P01M401.mm And in the folder location C:\Program Files\osai\WinNBI\Q Video\Techno QV\ The folder MMpp or inchPP These files are contained with in the TechnoHDsInch2mm.zip file



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Techno lr	IC. <i>Since 1986</i>	Changing L Techno HD	Jnits in S System
1. Go to My computer and l	ocate the Network o	lrive llpp op "pc0001"	
My Computer			
File Edit View Favorites Tools Help			
🌀 Back 🔹 🕥 🕤 🏂 🔎 Search	Folders 🚯 🏂 🗙	(19	
Address 😼 My Computer			💌 🄁 Go
Name Type	Total Size	Free Space Comments	
Files Stored on This Computer			
🚞 Shared Documents 🛛 File Folder			
🚞 Techno's Docume 🛛 File Folder			
Hard Disk Drives			
☞Local Disk (C:) Local Disk	55.5 GB	51.1 GB	
☞Local Disk (D:) Local Disk	117 GB	117 GB	
☞Local Disk (E:) Local Disk	146 GB	146 GB	
🍛 Local Disk (G:) 🔋 Local Disk	146 GB	145 GB	
Devices with Removable Storage			
DVD Drive (F:) CD Drive			
Network Drives			
🕿 usr on 'nc0001' (Y:) 🛛 Network Drive	62.8 MB	53.9 MB	
🕿 upp on 'nc0001' (Z:) Network Drive	1.79 GB	1.72 GB	

2. On this drive locate the folder MACROS

🗁 MACROS			
File Edit View Favorites 1	Fools Help		4
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Address 🛅 Z:\MACROS			💌 🄁 G
Name 🔺	Size Type	Date Modified	
🖬 DAHX	1 KB File	12/13/2011 8:35 AM	
DAHXY	1 KB File	12/13/2011 8:35 AM	
DAHY	1 KB File	12/13/2011 8:35 AM	
01M1	4 KB File	12/13/2011 8:35 AM	
01M006	7 KB File	12/14/2011 5:05 AM	
01M006.MM	7 KB MM File	12/13/2011 8:35 AM	
E P01M029	1 KB File	12/13/2011 8:35 AM	
P01M030	1 KB File	12/13/2011 8:35 AM	
E P01M401	4 KB File	4/9/2012 9:39 PM	
D1M401.MM	4 KB MM File	12/13/2011 8:35 AM	
JT00013 Tel: 516/328	3-3970 · Web: http://www.t	echnocnc.com · E-mail support	@technocnc.com 2





5. Click on the CncVision highlighted in the red square below to access the CNC Vision screen.



6. When the CNCVision screen opens press the F4 key to navigate to the main screen. Note: The mouse will not select any options in cnc vision. The F10 key will move the selection bar, and the corresponding F function key below the option will select.

OSAI ProcessC	Controller - [CncVision]					_ 6
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100013	Tal: 516/228 2		www.tochpocpc.	com . E mail su	nort@tachnocnc.c	om





9. Use the arrow keys to move the Dark Blue bar to highlight option 2 in the Amp directory list. Press F5 to Activate.



10. Press F6 to SELECT. When the parameter screen opens, press F10 to move the highlight bar, and F9 to Select EXIT.

Adjust Machine Status :	Parameters	amp2 011 AX	date:23/04/2012 ES NOT REFERENCED	time:14:47:17
AMP Ready: use	Softkey			
HARDWARE SELECT PROCESS	GENERAL INFO PROCESS CONFIG	LOGIC CONF AXIS CONFIG	OPTIONS HUMAN INTERF	HELP
(F5)	(F6)	(F7)	(F8)	(F9)



11. When you exit press y and then hit the Enter key. Note, use the enter key on the Number pad on the far right of the keyboard. The retrun carriage/enter key will not be accepted.

Adjust Machine Status :	Parameters	amp2 d 011 AXE	ate:23/04/2012 S NOT REFERENCED	time:14:47:55
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SELECT PROCESS			TROUBLE STREET	
SELECT PROCESS	THURSDAY COMPTO			EXIT

12. The Amp selection screen will appear again. Press F10 to highlight and F9 to Exit.

A	M P D I R E C	TORY LIST		COMPILE
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U TEORINO	S HINLOOUL HAL	S + SPINULE II-UCI	-2011- INCHES	Ŷ
OCTIVOTE	CELECT	S + SPINULE II-UCI	-2011- INCHES	HELP
ACTIVATE	SELECT BACKUP	EDIT COMMENT DELETE	-2011- INCHES PRINT	HELP

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13. Press the CNCVision icon again to exit the Cnc Vision screen.



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EP MODE	BLOCK	Profile	Preview	G-CODE File			Setup		Help

Tec	hno Inc. Since 1986 Changing Units in Techno HDS System
15. Click on inches.	the Tool lengths, and select the Ruler Icon for mm, and the Thumbs up icon for
16. When the window.	<pre>che required unit is selected, exit out of the screen by closing (X-ing) the compare open com</pre>
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17. Select the Boot Icon (Rocket,) to open the Boot Controller screen.

PROGRAM	1	-	1 1	O11 AXES N	OT REFER	ENCED		5
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START	HOLD	CNC connected	(Serie 10) 61 Loaded bootstr	ap program		REPOR'	r :	4
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		HUMAN : SDO	00 Environment Ci	ceated		REPOR	Ť	- the set
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18. Click on Boot on the bottom of the window and select Shut Down...

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SERVO · SI	000 Environment Cr	eated		REPORT
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LUS:SI	000 Environment Cr	eated		REPORT
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File	Select	Boot	👸 Mode	🎤 Utility



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US: SD000	Enviror again.	ssion, shuts down CNC, ar	nd starts CNC	REPORT	
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Filo	State Select	Boot	Mode.		
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21. The controller will now boot in your selected units.

22. Go into the folder C:\Program Files\OSAI\WinNBI\QVideo\Techno QV\

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🛅 Bitmap		File Folder	4/12/2012 12:33 AM	
Dexx		File Folder	4/12/2012 9:37 PM	
MM PP		File Folder	4/23/2012 9:40 PM	
DPP		File Folder	4/23/2012 9:40 PM	
] messages_ENGLISH.txt	4 KB	Text Document	4/4/2011 6:54 PM	
anc0001.qvc	1 KB	QVC File	4/12/2012 9:38 PM	
OLDtechno_AUX.qv	41 KB	QV File	4/11/2012 3:36 AM	
RecentList.dat	1 KB	DAT File	4/13/2012 1:21 AM	
Techno_20.qv	24 KB	QV File	10/12/2011 12:22 AM	
Techno_20_Text.csv	2 KB	CSV File	10/17/2011 11:52 AM	
Techno_4I.qv	47 KB	QV File	10/12/2011 12:22 AM	
Techno_4I_Text.csv	4 KB	CSV File	9/26/2011 3:44 PM	
🗟 techno_AUX.qv	40 KB	QV File	4/12/2012 4:54 AM	
🖻 Techno_MAIN.qv	39 KB	QV File	4/12/2012 9:48 PM	
Techno_Offsets.qv	43 KB	QV File	4/13/2012 1:22 AM	
di Techno Origin.av	18 KB	QV File	4/12/2012 12:11 AM	

Rename the folder "PP" to "Inch PP" If the folder "MM PP" is not present copy it into this location and renam is "PP"

Everything is now set for metric units.

NOTE: Preform tool changes on all locations at a slow speed to see that they function correctly. Also preform the Z tool length/Tool Offset functions slowly at first. If they do not function correctly, copy the macros from the Zip folder into Upp\MACROS\ network drive.

P01M401 is for Tool Lengths.

P01M006 is for Tool locations.