

High/Low Speeds and Step Distances (from main screen, press 'OK')

MSpd: 800 / 100

Step XY: 0.005

Step Z: 0.005

File: (active file name)

Note: These numbers can vary.

All following settings can be found by pressing the 'Menu' key and are worded/abbreviated as you would see them on screen.

Note: All settings with '' on screen requires reboot to take effect.*

1. LOCAL FILES
2. USB FILES
3. OPERATIONS
 1. Back to REF Point
 1. All Home
 2. Z Home
 3. X Home
 4. Y Home
 2. Rect Machining
 1. Params Setting
Engr Depth = 0.004
Each Depth = 0.004
Tool Dia = 0.118
Nose Gap = 0.079
Height3 = 3.937
Width = 3.937
X Init = 0.000
Y Init = 0.000
Mode Horiz Mill
EXECUTE
 2. Load the Last
 3. Select Line No
Total: ____
StartLine: ____
EndLine: ____
EXECUTE NOW
 4. Machining Info
Time
X: ____
Y: ____
Z: ____
 5. Park MCS Site

1. Park Mode
 - Not Move
 - To Park Site
 - To WCS Origin
2. Park Site
 1. Input Site
 - Input Park Site
 - X: _____
 - Y: _____
 - Z: _____
 2. Select Site
 - Select Current Position As
 - Park Pos by [OK] Key
 - Return ny [ESC] Key
6. Select WCS
 - G54 WCS
 - G55 WCS
 - G56 WCS
 - Select by [OK]
4. Oper Param
 1. G00 Speed
 - 400.000 in/min
 2. GXX Speed
 - 250.000 in/min
 3. Back REF First
 - YES
 4. Lifts on Pause*
 - 0.25 inch
 5. Offset →
 1. Public Offest
 1. X
 2. Y
 3. Z
 2. Work Offset
 1. G54 Offset →
 1. X = 0.000
 2. Y = 0.000
 3. Z = 0.000
 2. G55 — G59 →
 1. X = 0.000
 2. Y = 0.000
 3. Z = -7.126
 6. Cycle Process →
 1. Cycle Process

- NO
- 2. Cycle Times
2
- 3. Cycle Interval
0 ms
- 4. S-Off in Intev
NO
- 7. G73-G83 Retract
0.0 inch
- 8. Ignore F Code
NO
- 9. Ignore S Code
NO
- 10. Spindle Stop →
 - 1. S off at Pause*
YES
 - 2. S off at Stop*
YES
 - 3. S off at End
Yes
- 11. Ratio on Manu*
NO
- 12. DXF Params →
 - 1. Lifting Height* = 0.039
 - 2. Process Depth* = - 0.039
 - 3. 1st Point as 0*
YES
 - 4. Shape Process*
NO
 - 5. Bottom Process*
NO
 - 6. Metric Size*
NO
- 13. ENG Params →
 - 1. Lifting Height*
0.039
 - 2. Tool Change Tip*
YES
 - 3. Cycle Times*
1
 - 4. Deep Hole Mode*
0
 - 5. Retract Amount*
0.25

6. Select Tool No*

YES

14. Tool Change →

1. ATC Capacity*

10

2. Current Tool No

1

3. Tool Offset

1. Tool 1

X: _____

Y: _____

Z: _____

(settings repeat through tool 10)

4. Tool Change Tip

NO

15. ENG Unit

YES

5. MFR Param

PASSWORD: 33587550

1. Velocity →

1. Decel Dist

0.394 inch

2. Approach Speed

25.00 in/min

3. Single Axis Acc

25.00 in/sec²

4. Max Turn Acc

100.00 in/sec²

5. Jerk

300.00 in/sec³

6. Max Speed of Z

125.00 in/min

7. Short Seg Spd Lmt

YES

8. SPDLMT Length

0.1 inch

9. Enbl Plunge Rate

NO

10. Z Plunge Cut Spd

11.811 in/min

11. REF Circle Radius

0.1 inch

12. REF Circle Speed

100.00 in/min

2. Axis Output Dir →*

X: Negative

Y: Negative

Z: Negative

3. Pulse Equiv →*

X: 0.005000 (Mini)

Y: 0.005000 (Mini)

Z: 0.002500 (Mini)

4. Machine Stroke →

1. Strk Upper Lmt →

X: 23.622

Y: 35.433

Z: 0.000

2. Strk Lower Lmt →

X: 0.000

Y: 0.000

Z: -5.900

5. Ref Point Set →

1. RefP Speed →

X: 70.866 in/min

Y: 70.866 in/min

Z: 59.055 in/min

2. RefPDir

X: Negative

Y: Negative

Z: Positive

3. Retract Dist

1. X Retract Dist

0.079 in

2. Y Retract Dist

0.079 in

3. Z Retract Dist

0.079 in

6. Spindle Set →

1. Spindle Gears*

7

2. On/Off Delay

5000 ms

3. Initial Gear*

6

4. Max Spdl Speed*

24000 in/min

7. Y Rotary Axis →

1. Y as Rotary Axis*

NO

2. Rotary Y Pulse

- 0.006 deg/pulse
- 3. MM as Unit
NO
- 4. Rev Work Radius
0.394
- 5. Rotary Takeoff
0.291 rad/s
- 6. Rotary Y Acc
6.98 rad/s²
- 7. Max Rotary Vel
30 r/min
- 8. Backlash Set
 - 1. Compensation on
NO
 - 2. Axis Backlash →*
X: 0.0
Y: 0.0
Z: 0.0
- 9. Calib Thickness
1.587 inch *(will vary slightly)*
- 10. Enable S Algo
YES
- 11. Arc Increment
YES
- 12. Forward Look Seg
50
- 13. Sign of BK REF
YES
- 14. Safety Height*
0.25 inch
- 15. Lube →
 - 1. Enable Auto Lube
NO
 - 2. Time Interval
5000s
 - 3. Duration
5s
- 16. G00 Feed 100%*
YES
- 17. Smoothing Time
0.0s
- 6. Param Upkeep
 - 1. Backup Params
 - 2. Restore Params

3. Factory Params
4. Export Params
5. Import Params
7. System Upkeep
 1. Language
 1. Chinese
 2. English
 2. Export Log
 3. System Update
 4. Register
 5. Help

Spec: Help Message Show Delay
Value: 60
Unit: S
6. Reboot
7. Exit
8. Diagnosis
 1. System Info
 1. Software Version
 2. Card No
 3. Remaining Time
 4. Register Tmes
 2. Port List
 3. Keypress Diag
 4. Import Diag
 5. Outport Diag