

Instructions for engraving machine handle setting

1. Handle instruction

Stop/cancel: stop the current carving progress and cancel the current setting.

Run/pause/delete: run the engraving file, pause the carving progress, delete the input value;

Manual mode: the available mode can be selected for continuous, step and step distance, which can be used to adjust the operation mode of each axis.

Zero/determination: operation machine to set the origin, determine the current setting item;

Menu: set the parameters of the machine;

Shaft stop: start/stop spindle motor running;

High speed/low speed / 0: adjust spindle motor speed, input value 0;

Return zero / 9: return machine zero, input value 9;

X + / 1: adjust the X axis to the left, enter a value of 1, and move the cursor upward;

X - / 5: adjust the X axis to the left, input the value 5, and move the cursor downward;

Y + / 2: adjust the Y axis to move backward, input the value 2, increase the speed of engraving;

Y - / 6: adjust the Y axis to move forward, enter the number 6, slow down the engraving speed;

Z + / 3: adjust the z-axis upward movement, input the value 3, adjust the main axis operation mode;

Z - / 7: adjust the Z axis to move down, input the value 7, adjust the main axis operation mode;

X/Y - 0/4: reset the X/Y axis, input number 4;

Z - 0/8: will the Z axis, input numerical 8;

Ii. Menu Settings and usage

1. Machine parameter setting:

The configuration of machine tool parameters is the consistency between control card and mechanical characteristic of machine tool. Including: pulse equivalent, machine tool size setting, back to zero setting, main shaft setting, level definition, pulse definition, thickness of knife instrument, screw clearance, etc. It is recommended that this parameter be set by the manufacturer. Once the setting is completed, no customer changes are required. Change the parameters, press the corresponding numeric key, press the "ok" button to save when the input is finished, press the "delete" key to change the input, and press the "cancel" key to move the cursor. Change the properties and press "Y +" and "y-" key changes. "Cancel" button to return to the parent menu until exit.

Connect the handle to the machine tool through 50 needles.

"Does the liquid crystal display" return to the origin?" Click "ok" to return to the machine's origin, press "delete" key not to return to the machine tool origin, press "cancel" key to only the z-axis to return to the origin;

Return to origin operation: the origin refers to the machine tool zero, so the return to the origin is also called the zero operation. The origin location is mainly determined by the loading location of various zeros detection switches. The point of the origin is to determine the corresponding relation between the working coordinate system and the mechanical coordinate system. Many functions of the control system depend on the operation of the back origin, such as breakpoint processing, power recovery, etc. Without the return to the origin operation, none of the above functions can work.

The setting of the origin: the back origin parameters include zero movement speed and zero movement direction, and the modification parameters must be carried out in the menu.



Press the "mode" button on the operating interface to step in mode and set the low speed grid to 0.05 according to the "stop" key. To ensure the accuracy of machining and debugging, the system introduces the concept of grid. Some systems are also called minimum supply. Its scope is: 0.05mm- 1.0mm. When the user switches the manual motion mode to the step, press the three-axis direction key and the machine tool will be set in the grid

Distance motion.



Enter machine setting, select "machine tool parameter configuration"; The machine parameter configuration is mainly set up the supporting parameters of the drive part, transmission part, mechanical part and I/O interface part of the machine tool. These parameters, if incorrect, will

result in improper operation of the file and may cause mechanical failure and operator damage. Users are advised not to change this parameter at will. If you need to change it, please do it under the guidance of the technical engineer.



. Select "pulse equivalent"; Pulse equivalent refers to the number of impulses required by mechanical movement of 1 mm, so its unit is: pulse/mm.

If the number of pulse equivalent values is different from the actual machine tool, the size of the processed documents will be inconsistent with the requirements when the document is executed.



Select "machine tool size setting"; The X and Y axes are set to 300, and the Z axis is set to 50. Machine tool size refers to the effective movement stroke of machine tool. The maximum machining dimension of the three-axis can be set in this item.

If the range of file processing is beyond the size of the machine tool, in the process of checking the code, the system will automatically prompt the processing to exceed the scope, such as the processing beyond the X axis positive limit; If you are moving the tri-axis in the manual state, the upper left hand corner and the "stop" are quickly changed when the position reaches the limit, and the screen is prompted to exceed the limit. Because this system USES the machine tool size as the limit position of the soft limit, the size of the machine must be the same, otherwise the phenomenon of overlimit or collision can occur.



Select "reset reset"

Set "zero speed" to select X axis, Y axis 3000mm/min, and Z axis is 1800mm/min. Set the X-axis and Y-axis of the "back zero movement direction" in negative direction, and the Z axis is set in the positive direction;

The change of velocity parameters of zero movement must be based on the overall structure of the machine tool. If the speed is too high, it can lead to the failure of the machine tool or the origin detection switch.

The direction of the zero movement direction is determined by the motor direction and the return zero switch installation position, and it is also associated with the definition property of the input level definition and the return zero detection switch attribute

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