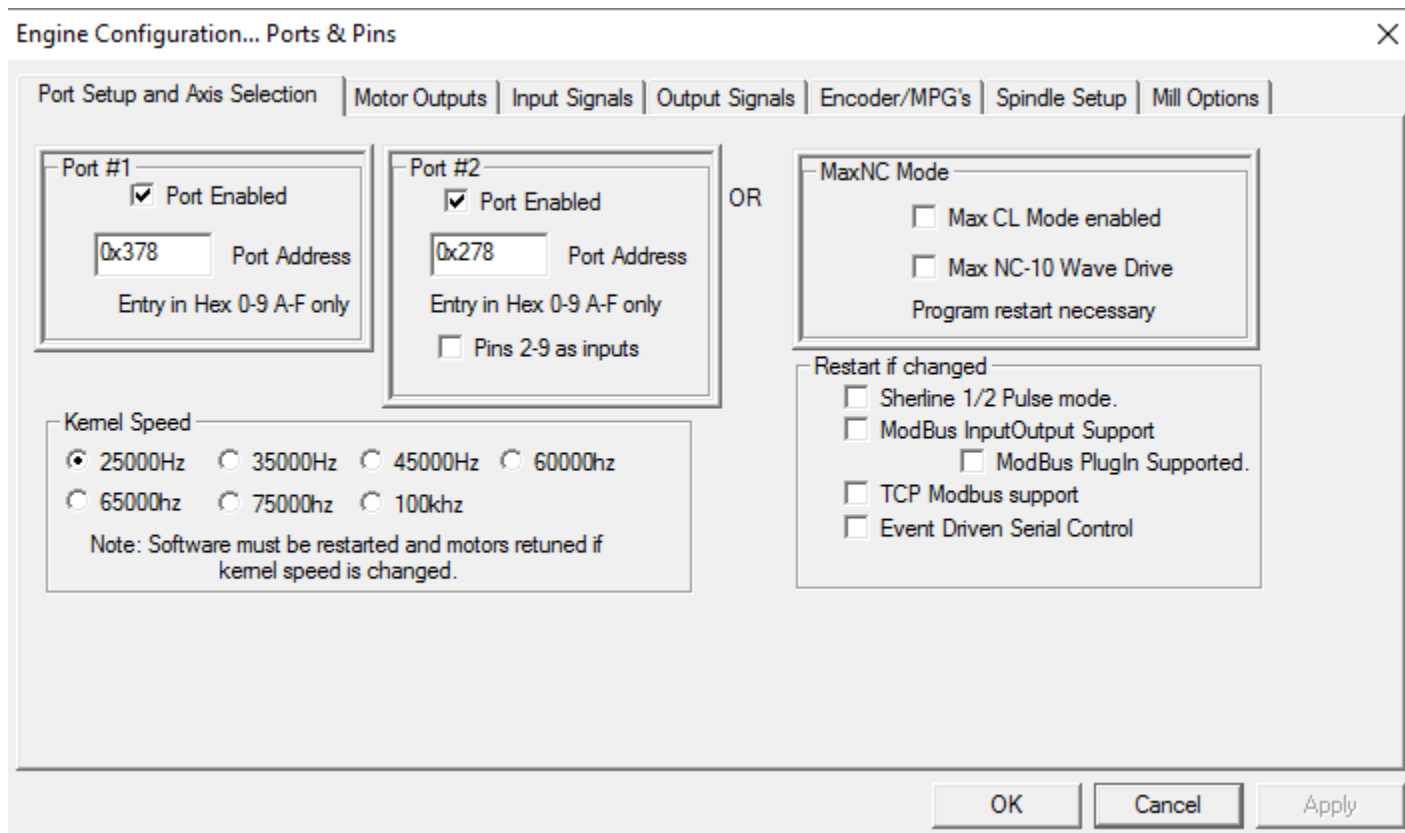


SCREEN SHOTS FOR MACH 3

Following are a series of screen shots for Mach 3 settings for the Shopmaster machines. Most of the settings are for the Mill Turn, but they will work for all Shopmasters. The only adjustments that will be necessary are the Motor tuning, backlash and spindle pulley settings for different machines with different stepper and spindle drive ratios. Most of the settings are identical for both lathe and mill modes, so at the end we have placed the screen shots which are unique to the lathe.

THE FOLLOWING SETTINGS ARE UNDER “CONFIG”



Port Setup and Axis Selection | Motor Outputs | Input Signals | Output Signals | Encoder/MPG's | Spindle Setup | Mill Options

Signal	Enabled	Step Pin#	Dir Pin#	Dir LowActi...	Step Low A...	Step Port	Dir Port
X Axis		2	3			1	1
Y Axis		4	5			1	1
Z Axis		6	7			1	1
A Axis		8	9			1	1
B Axis		2	3			2	2
C Axis		4	5			2	2
Spindle		14	14			1	1

OK Cancel Apply

NOTE: Changing the Dir Low Active from red to green or vice-versa will reverse the direction of your carriage.

NOTE: The Input Signals screen shots are in 6 parts due to the size of the screen shots

Engine Configuration... Ports & Pins



Port Setup and Axis Selection | Motor Outputs | **Input Signals** | Output Signals | Encoder/MPG's | Spindle Setup | Mill Options

Signal	Enabled	Port #	Pin Number	Active Low	Emulated	HotKey
X ++		1	10			0
X --		1	10			0
X Home		1	10			0
Y ++		1	11			0
Y --		1	11			0
Y Home		1	11			0
Z ++		1	12			0
Z --		1	12			0
Z Home		1	12			0

Pins 10-13 and 15 are inputs. Only these 5 pin numbers may be used on this screen

Automated Setup of Inputs

OK

Cancel

Apply

Port Setup and Axis Selection | Motor Outputs | Input Signals | Output Signals | Encoder/MPG's | Spindle Setup | Mill Options

Signal	Enabled	Port #	Pin Number	Active Low	Emulated	HotKey
A ++		1	0			0
A --		1	0			0
A Home		1	10			0
B ++		0	0			0
B --		0	0			0
B Home		0	0			0
C ++		0	0			0
C --		0	0			0
C Home		0	0			0

Pins 10-13 and 15 are inputs. Only these 5 pin numbers may be used on this screen

Automated Setup of Inputs

OK

Cancel

Apply

Port Setup and Axis Selection | Motor Outputs | Input Signals | Output Signals | Encoder/MPG's | Spindle Setup | Turn Options

Signal	Enabled	Port #	Pin Number	Active Low	Emulated	HotKey
Input #1		0	0			0
Input #2		0	0			0
Input #3		0	0			0
Input #4		0	0			0
Probe		0	0			0
Index		1	10			0
Limit Ovrd		0	0			0
EStop		1	15			0
THC On		0	0			0

Pins 10-13 and 15 are inputs. Only these 5 pin numbers may be used on this screen

Automated Setup of Inputs

OK

Cancel

Apply

Port Setup and Axis Selection | Motor Outputs | **Input Signals** | Output Signals | Encoder/MPG's | Spindle Setup | Mill Options

Signal	Enabled	Port #	Pin Number	Active Low	Emulated	HotKey
THC Up		0	0			0
THC Down		0	0			0
OEM Trig #1		1	13			0
OEM Trig #2		0	0			0
OEM Trig #3		0	0			0
OEM Trig #4		0	0			0
OEM Trig #5		0	0			0
OEM Trig #6		0	0			0
OEM Trig #7		0	0			0

Pins 10-13 and 15 are inputs. Only these 5 pin numbers may be used on this screen

Automated Setup of Inputs

OK Cancel Apply

Port Setup and Axis Selection | Motor Outputs | **Input Signals** | Output Signals | Encoder/MPG's | Spindle Setup | Mill Options

Signal	Enabled	Port #	Pin Number	Active Low	Emulated	HotKey
OEM Trig #8		0	0			0
OEM Trig #9		0	0			0
OEM Trig #10		0	0			0
OEM Trig #11		0	0			0
OEM Trig #12		0	0			0
OEM Trig #13		0	0			0
OEM Trig #14		0	0			0
OEM Trig #15		0	0			0
Timing		0	0			0

Pins 10-13 and 15 are inputs. Only these 5 pin numbers may be used on this screen

Automated Setup of Inputs

OK Cancel Apply

Port Setup and Axis Selection | Motor Outputs | Input Signals | Output Signals | Encoder/MPG's | Spindle Setup | Mill Options

Signal	Enabled	Port #	Pin Number	Active Low	Emulated	HotKey
Jog X++		0	0			0
Jog X--		0	0			0
Jog Y++		0	0			0
Jog Y--		0	0			0
Jog Z++		0	0			0
Jog Z--		0	0			0
Jog A++		0	0			0
Jog A--		0	0			0

Pins 10-13 and 15 are inputs. Only these 5 pin numbers may be used on this screen

Automated Setup of Inputs

OK Cancel Apply

NOTE: The Output Signals screen shots are in 4 parts due to screen shot size.

Port Setup and Axis Selection | Motor Outputs | Input Signals | Output Signals | Encoder/MPG's | Spindle Setup | Mill Options

Signal	Enabled	Port #	Pin Number	Active Low
Digit Trig		0	0	
Enable1		0	0	
Enable2		0	0	
Enable3		0	0	
Enable4		0	0	
Enable5		0	0	
Enable6		0	0	
Output #1		1	17	
Output #2		1	1	
Output #3		1	0	

Pins 2 - 9 , 1, 14, 16, and 17 are output pins. No other pin numbers should be used.

OK Cancel Apply

Port Setup and Axis Selection | Motor Outputs | Input Signals | Output Signals | Encoder/MPG's | Spindle Setup | Mill Options

Signal	Enabled	Port #	Pin Number	Active Low
Output #2		1	1	
Output #3		1	0	
Output #4		1	0	
Output #5		0	0	
Output #6		0	0	
Charge Pump		1	16	
Charge Pump2		2	16	
Current Hi/Low		0	0	
Output #7		0	0	
Output #8		0	0	

Pins 2 - 9 , 1, 14, 16, and 17 are output pins. No other pin numbers should be used.

Port Setup and Axis Selection | Motor Outputs | Input Signals | Output Signals | Encoder/MPG's | Spindle Setup | Mill Options

Signal	Enabled	Port #	Pin Number	Active Low
Output #8		0	0	
Output #9		0	0	
Output #10		0	0	
Output #11		0	0	
Output #12		0	0	
Output #13		0	0	
Output #14		0	0	
Output #15		0	0	
Output #16		0	0	
Output #17		0	0	

Pins 2 - 9 , 1, 14, 16, and 17 are output pins. No other pin numbers should be used.

OK

Cancel

Apply

Port Setup and Axis Selection | Motor Outputs | Input Signals | Output Signals | Encoder/MPG's | Spindle Setup | Mill Options

Signal	Enabled	Port #	Pin Number	Active Low
Output #12	<input checked="" type="checkbox"/>	0	0	<input checked="" type="checkbox"/>
Output #13	<input checked="" type="checkbox"/>	0	0	<input checked="" type="checkbox"/>
Output #14	<input checked="" type="checkbox"/>	0	0	<input checked="" type="checkbox"/>
Output #15	<input checked="" type="checkbox"/>	0	0	<input checked="" type="checkbox"/>
Output #16	<input checked="" type="checkbox"/>	0	0	<input checked="" type="checkbox"/>
Output #17	<input checked="" type="checkbox"/>	0	0	<input checked="" type="checkbox"/>
Output #18	<input checked="" type="checkbox"/>	0	0	<input checked="" type="checkbox"/>
Output #19	<input checked="" type="checkbox"/>	0	0	<input checked="" type="checkbox"/>
Output #20	<input checked="" type="checkbox"/>	0	0	<input checked="" type="checkbox"/>

Pins 2 - 9 , 1, 14, 16, and 17 are output pins. No other pin numbers should be used.

OK

Cancel

Apply

Port Setup and Axis Selection | Motor Outputs | Input Signals | Output Signals | Encoder/MPG's | Spindle Setup | Mill Options

Signal	Enabled	A -Port #	A -Pin #	B -Port #	B -Pin #	Counts/U...	Velocity
Encoder1	<input checked="" type="checkbox"/>	0	0	0	0	1.000000	100.000000
Encoder2	<input checked="" type="checkbox"/>	0	0	0	0	1.000000	100.000000
Encoder3	<input checked="" type="checkbox"/>	0	0	0	0	1.000000	100.000000
Encoder4	<input checked="" type="checkbox"/>	0	0	0	0	1.000000	100.000000
MPG #1	<input checked="" type="checkbox"/>	0	0	0	0	1.000000	100.000000
MPG #2	<input checked="" type="checkbox"/>	0	0	0	0	1.000000	100.000000
MPG #3	<input checked="" type="checkbox"/>	0	0	0	0	1.000000	100.000000

OK

Cancel

Apply

Port Setup and Axis Selection | Motor Outputs | Input Signals | Output Signals | Encoder/MPG's | Spindle Setup | Mill Options

Relay Control

Disable Spindle Relays

Clockwise (M3) Output #

CCW (M4) Output #

Output Signal #'s 1-6

Motor Control

Use Spindle Motor Output

PWM Control

Step/Dir Motor

PWMBase Freq.

Minimum PWM %

Special Functions

Use Spindle Feedback in Sync Modes

Closed Loop Spindle Control

P I D

Spindle Speed Averaging

Flood Mist Control

Disable Flood/Mist relays

Mist M7 Output # Delay

Flood M8 Output # Delay

Output Signal #'s 1-6

General Parameters

CW Delay Spin UP Seconds

CCW Delay Spin UP Seconds

CW Delay Spind DOWN Seconds

CCW Delay Spin DOWN Seconds

Immediate Relay off before delay

Special Options, Usually Off

HotWire Heat for Jog

Laser Mode. freq I

Torch Volts Control

Torch Auto Off

ModBus Spindle - Use Step/Dir as well

Enabled Reg 64 - 127

Max ADC Count

OK Cancel Apply

Port Setup and Axis Selection | Motor Outputs | Input Signals | Output Signals | Encoder/MPG's | Spindle Setup | Mill Options

Z - Inhibit

Z - Inhibit On

Max Depth Units

Persistent

Compensation G41,G42

Advanced Compensation Analysis

Digitizing

4 Axis Point Clouds

Add Axis Letters to Coordinates

Loop Control

Allow Servo Hold on Input#1

Max CL Closed Loop Emulation

THC Options

Allow THC UP/DOWN Control even if not in THC Mode.

G28.1 No Initial Move.

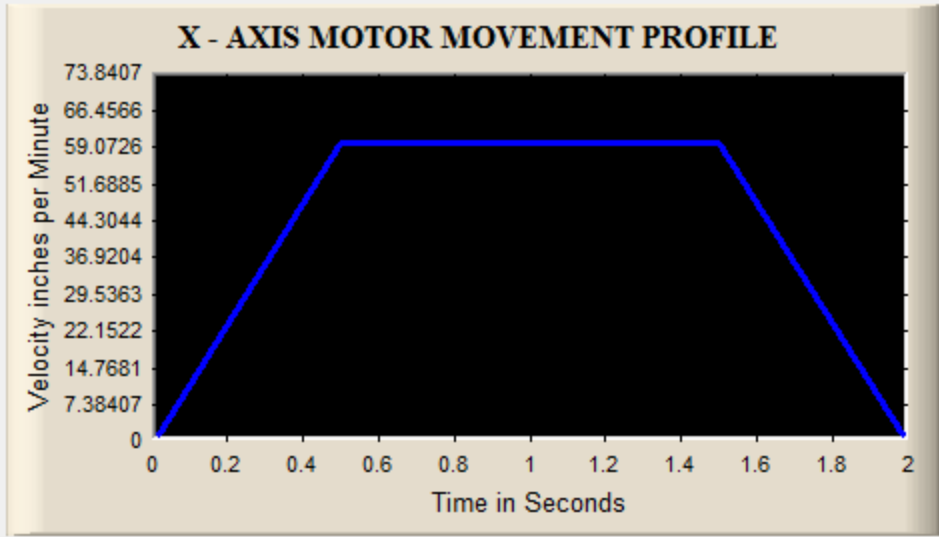
Set OUTPUT5 when in THC

General Options

Homed true when no home swithes

G73 Pullback

OK Cancel Apply



Velocity

Axis Selection

X Axis

Y Axis

Z Axis

A Axis

B Axis

C Axis

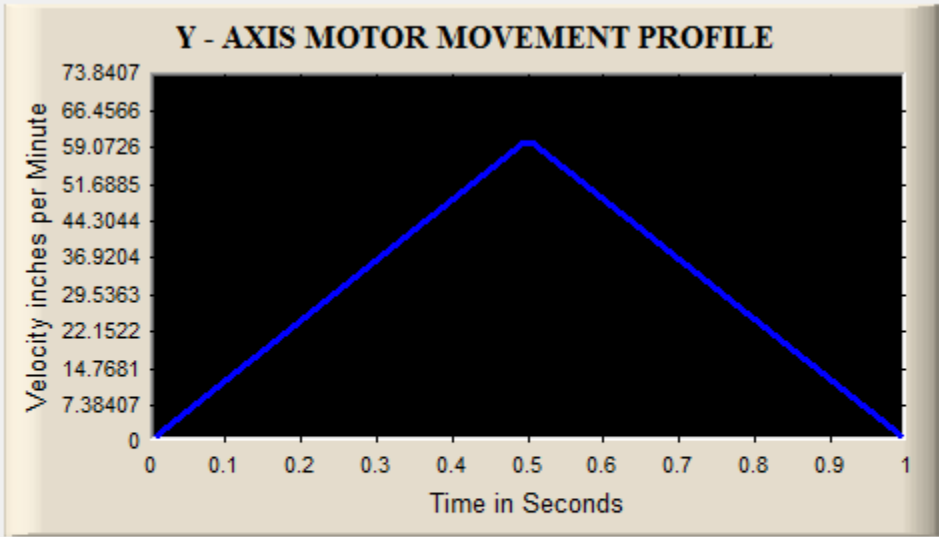
Spindle

Accel

Steps per	Velocity In's or mm's per min.	Acceleration in's or mm's/sec/sec	G's	Step Pulse 1 - 5 us	Dir Pulse 0 - 5
10157	60	2	0.0025901	5	5

SAVE AXIS SETTINGS

Cancel OK



Velocity

Axis Selection

X Axis

Y Axis

Z Axis

A Axis

B Axis

C Axis

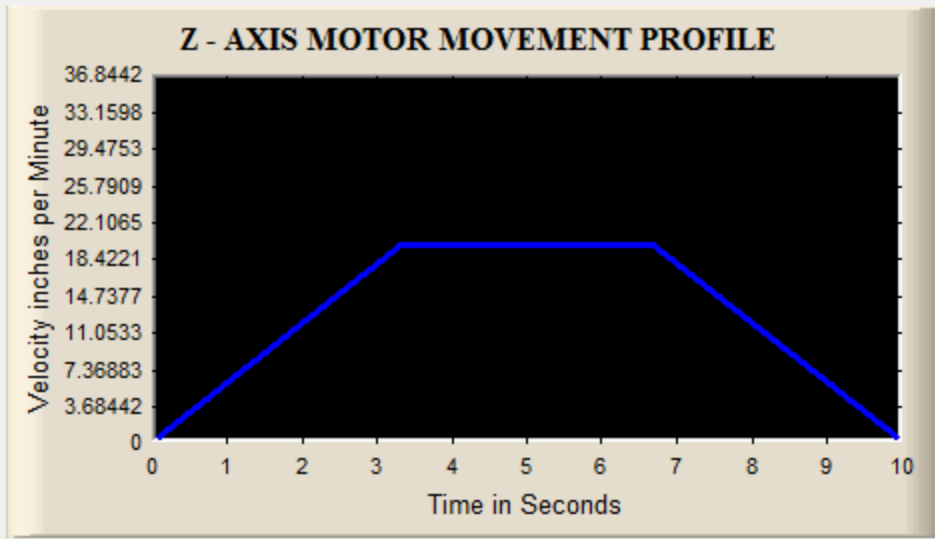
Spindle

Accel

Steps per	Velocity In's or mm's per min.	Acceleration in's or mm's/sec/sec	G's	Step Pulse 1 - 5 us	Dir Pulse 0 - 5
10157	60	2.0306193	0.0052596	5	5

SAVE AXIS SETTINGS

Cancel OK



Velocity

Axis Selection

X Axis

Y Axis

Z Axis

A Axis

B Axis

C Axis

Spindle

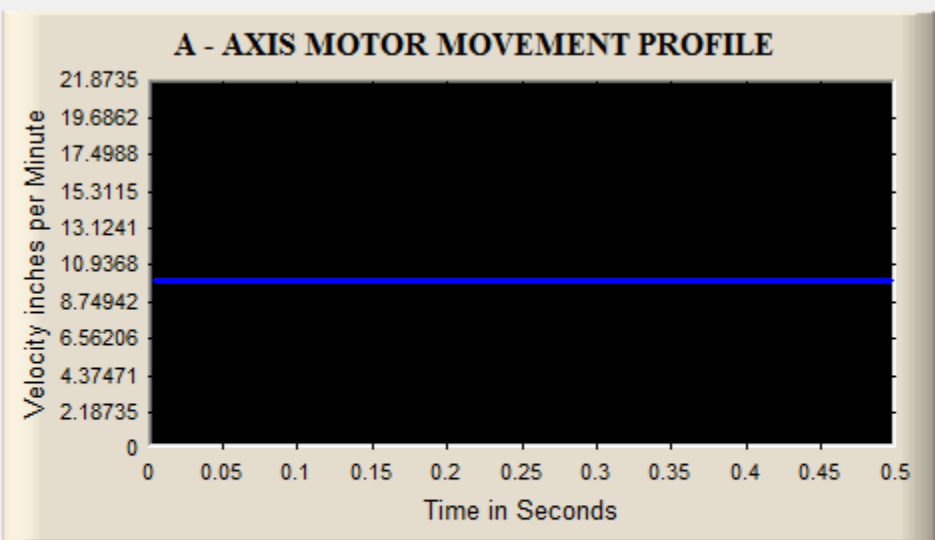


Accel

SAVE AXIS SETTINGS

Steps per	Velocity In's or mm's per min.	Acceleration in's or mm's/sec/sec	G's	Step Pulse 1 - 5 us	Dir Pulse 0 - 5
20356	20	0.1	0.0002590	5	5

Cancel OK



Velocity

Axis Selection

X Axis

Y Axis

Z Axis

A Axis

B Axis

C Axis

Spindle



Accel

SAVE AXIS SETTINGS

Steps per	Velocity In's or mm's per min.	Acceleration in's or mm's/sec/sec	G's	Step Pulse 1 - 5 us	Dir Pulse 0 - 5
2143	10	120	0.4532530	5	5

Cancel OK

General Logic Configuration

G20,G21 Control

 Lock DRD's to setup units

Editor

GCode Editor

\\WinNT\Notepad.exe

Shuttle Wheel Setting

Shuttle Accel. Seconds

Inputs Signal Debouncing/Noise rejection

Debounce Interval: x 40us

Index Debounce

Tool Change

 Ignore Tool Change
 Stop Spindle. Wait for Cycle Start.
 AutoTool Changer

Startup Modals

 Use Init String on ALL "Resets"

Initialization String

General Configuration

 Z is 2.5D on Output #6
 Home Sw. Safety
 LookAhead Lines
 Ignore M calls while loading
 M9- Execute after Block
 UDP Pendent Control
 Run Macro Pump
 ChargePump On in EStop
 Persistent Jog Mode.
 FeedOverride Persist
 No System Menu in Mach3
 Use Key Clicks
 Home Slave with Master Axis
 Include TLO in Z from G31
 Lock Rapid FRD to Feed FRD

Disable Gouge/Concavity Checks

 G04 Dwell in ms
 Use WatchDogs
 Debug This Run
 Enhanced Pulsing
 Allow Wave Files
 Allow Speech
 Set Charge Pump to 5Khz - Laser Stndby
 Use OUTPUT20 as Dwell Trigger
 No FRD on Queue
 Turn Manual Spindle Incr.
 Spindle OV increment

Angular Properties

Unchecked for Linear

 A-Axis is Angular
 B-Axis is Angular
 C-Axis is Angular

Motion Mode

 Constant Velocity Exact Stop

Distance Mode Absolute Inc

IJ Mode Absolute Inc

Active Plane of Movement

 X-Y Y-Z X-Z

CV Control

 Plasma Mode
 CV Dist Tolerance Units..
 G100 Adaptive NurbsCV
 Stop CV on angles > Degrees

Pgm End or M30 or Rewind

 Turn off all outputs
 E-Stop the system
 Perform G92.1
 Remove Tool Offset
 Radius Comp Off
 Turn Off Spindle

Jog Increments in Cycle Mode

Position 1	<input type="text" value="1"/>
	<input type="text" value="0.1"/>
	<input type="text" value="0.01"/>
	<input type="text" value="0.001"/>
	<input type="text" value="0.0001"/>
Use 999 to indicate a Continuous Jog selection.	<input type="text" value="1"/>
	<input type="text" value="0.1"/>
	<input type="text" value="0.01"/>
	<input type="text" value="0.001"/>
	<input type="text" value="0.0001"/>
Position 10	<input type="text" value="0.0001"/>

Rotational

 Rot 360 rollover
 Ang Short Rot on G0
 Rotational Soft Limits

Axis DRD Properties

 Tool Selections Persistent
 Optional Offset Save
 Persistent Offsets
 Persistent DRDs
 Copy G54 from G59.253 on startup

M01 Control

 Stop on M1 Command

Serial Output

ComPort # BaudRate

 8-Bit 1 Stop 7 Bit 2-Stop

Program Safety

 Program Safety Lockout
 This disables program translation while the External Activation #1 input is activated.

Screen Control

 Hi-Res Screens
 Boxed DRD's and Graphics
 Auto Screen Enlarge
 Flash Errors and comments.

System HotKeys Setup

Jog Hotkeys

	ScanCode		ScanCode
X++	<input type="text" value="39"/>	X--	<input type="text" value="37"/>
Y++	<input type="text" value="40"/>	Y--	<input type="text" value="38"/>
Z++	<input type="text" value="33"/>	Z--	<input type="text" value="34"/>
A / U ++	<input type="text" value="999"/>	A / U --	<input type="text" value="999"/>
B / V ++	<input type="text" value="999"/>	B / V --	<input type="text" value="999"/>
C / W ++	<input type="text" value="999"/>	C / W --	<input type="text" value="999"/>



















External Buttons - OEM Codes

Trigger #	OEM Code		OEM Code
1	<input type="text" value="1000"/>	8	<input type="text" value="-1"/>
2	<input type="text" value="-1"/>	9	<input type="text" value="-1"/>
3	<input type="text" value="-1"/>	10	<input type="text" value="-1"/>
4	<input type="text" value="-1"/>	11	<input type="text" value="-1"/>
5	<input type="text" value="-1"/>	12	<input type="text" value="-1"/>
6	<input type="text" value="-1"/>	13	<input type="text" value="-1"/>
7	<input type="text" value="-1"/>	14	<input type="text" value="-1"/>
		15	<input type="text" value="-1"/>

System Hotkeys

	ScanCode		ScanCode
DRD Select	<input type="text" value="999"/>	Code List	<input type="text" value="999"/>
MDI Select	<input type="text" value="999"/>	Reset On	<input type="text" value="999"/>
Load G-Code	<input type="text" value="999"/>		

Entries are in setup units.

Axis	Reversed	Soft Max	Soft Min	Slow Zone	Home Off.	Home N...	Auto Zero	Speed %
X		100.00	-100.00	1.00	0.0000			20
Y		100.00	-100.00	1.00	0.0000			20
Z		100.00	-100.00	1.00	0.0000			20
A		100.00	-100.00	1.00	0.0000			20
B		100.00	-100.00	1.00	0.0000			20
C		100.00	-100.00	1.00	0.0000			20

G28 home location coordinates

X A
 Y B
 Z C

OK

X Axis

Slaved Axis

- A Axis
 B Axis
 C Axis
 None

Y Axis

Slaved Axis

- A Axis
 B Axis
 C Axis
 None

Z Axis

Slaved Axis

- A Axis
 B Axis
 C Axis
 None

Restart Mach3 after resetting these selections

OK

NOTE: The backlash settings will be filled in after each machine is calibrated by the operator and then enabled.

Backlash Values

Backlash Distance in units

X Axis

Y Axis

Z Axis

A Axis

B Axis

C Axis

Backlash Speed % of Max

Backlash Enabled

Restart program to save these settings

NOTE: All the G code values from G54 to G59P253 are set to zero in the default mode. These values will be set by the operator preference.






Work Offsets

Work Offsets

G-Code Pos	X	Y	Z	A	B	C	Name
G54	0.000	0.000	0.0000	0.0000	0.0000	0.0000	G54
G55	0.0000	0.0000	0.0000	0.0000	0.0000	0.0000	
G56	0.0000	0.0000	0.0000	0.0000	0.0000	0.0000	
G57	0.0000	0.0000	0.0000	0.0000	0.0000	0.0000	
G58	0.0000	0.0000	0.0000	0.0000	0.0000	0.0000	
G59	0.0000	0.0000	0.0000	0.0000	0.0000	0.0000	
G59P7	0.0000	0.0000	0.0000	0.0000	0.0000	0.0000	

NOTE: The values for the tool table from 1-253 are set to zero in default mode. The tool table values will be filled in by the operator.

ToolTable

Tool	Description	Diameter(D)	Height (H)	Diam. Wear	HeightWear
0	Ref. Tool	0.000000	0.000000	0.000000	0.000000
 1	Empty	0.000000	0.000000	0.000000	0.000000
 2	Empty	0.000000	0.000000	0.000000	0.000000
 3	Empty	0.000000	0.000000	0.000000	0.000000
 4	Empty	0.000000	0.000000	0.000000	0.000000
 5	Empty	0.000000	0.000000	0.000000	0.000000

All Tool Entries are in your default setup measurement units irregardless of G20/G1 modes.

Apply OK

Enabled	PlugIn Name	Config
✘	ESS_v10r2d1d	CONFIG
✔	Flash-FlashScreen-SWF-PlugIn-A.Fenerty--B.-Barker-...	CONFIG
✘	JoyStick-JoyStick-PlugIn--Art-Fenerty-Ver-1.0a	CONFIG
✘	PrinterScope-Port-Scope-1.00.046	CONFIG
✔	ShuttlePro-XHC-FOR-MACH3-HB04L-V3.56	CONFIG
✘	TurnDiags-Turn-Diags-1.00.1	CONFIG
✔	Video---B.Barker-Ver-1.0	CONFIG

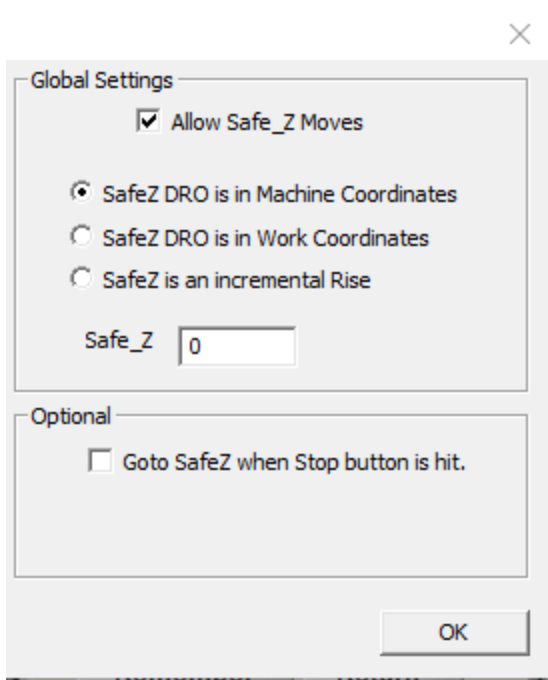
< >

OK

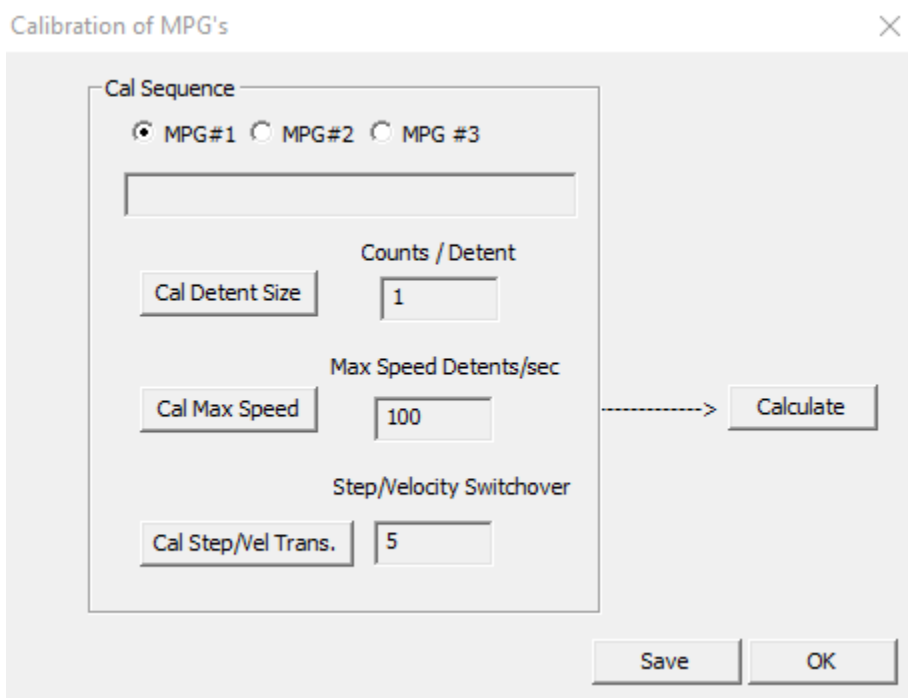
NOTE: The final Max Speed values will be filled in by the operator after doing his RPM setups as in another setup file. These values vary from machine models depending on the pulley ratios etc. The settings shown here are the defaults for the Mill Turn machine. Checking or un checking the “reversed” box will reverse the direction of your spindle. Because our spindle sensor is on the spindle, the ratio is always set to 1.

Current Pulley	Min Speed	Max Speed	Ratio
Pulley Number 1	0	5000	1
<input checked="" type="checkbox"/> Reversed			

OK



THE FOLLOWING 3 SETTINGS ARE UNDER “FUNCTION CON’FGS”



<input checked="" type="radio"/> X-Mapping	Clear Map	1300
<input type="radio"/> Y-Mapping	Clear Map	1300
<input type="radio"/> Z-Mapping	Clear Map	1300
<input type="radio"/> A-Mapping	Clear Map	50
<input type="radio"/> B-Mapping	Clear Map	50
<input type="radio"/> C-Mapping	Clear Map	50

Screw Lengths

ScrewMap Correction Enable

- X - Axis Correction
- Y - Axis Correction
- Z - Axis Correction
- A - Axis Correction
- B - Axis Correction
- C - Axis Correction

True Position

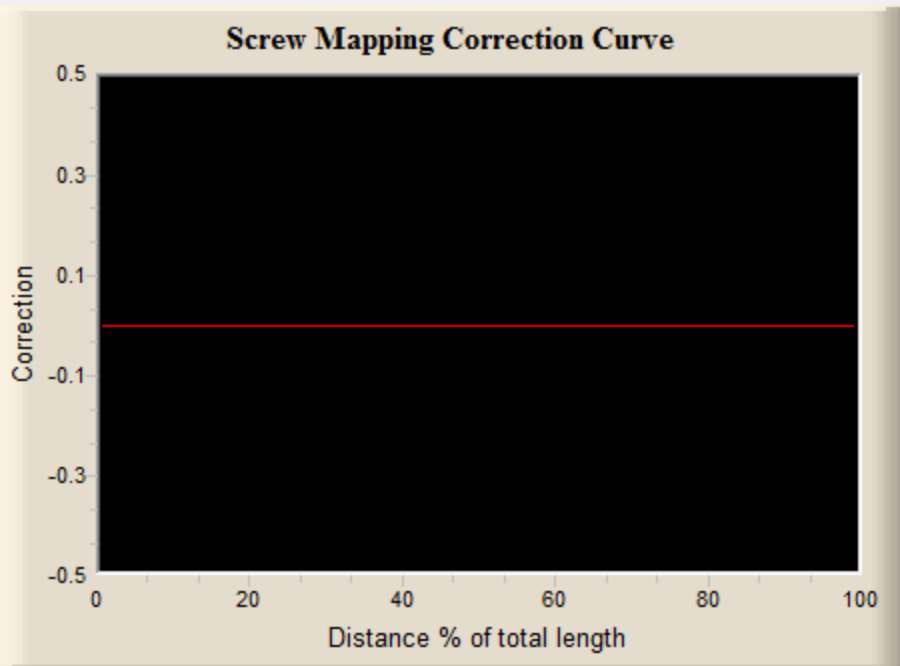
X - Coor	0
Y - Coor	0
Z - Coor	0
A - Coor	0
B - Coor	0
C - Coor	0

Read from Encoders

Add Correction Point

Program Position

X - Coor	+0.000
Y - Coor	+0.000
Z - Coor	+0.000
A - Coor	+0.000
B - Coor	+0.000
C - Coor	+0.000



Save Curves

OK

Formulas Enabled

f(x) =

f(y) =

f(z) =

f(a) =

f(b) =

f(c) =

Available variables are axis letters X,Y,Z,A,B,C and the current tool diameter D and length T
You may also use math function such as Sin, Cos, Tan, PI, etc..
Sample Formula: $f(x) = \sin(y) * \cos(x) + \text{PI}^2 - (\cos(b) + \sin(a) - t * (\cos(d)))$

Test Variable settings

X	<input type="text" value="1"/>	Y	<input type="text" value="1"/>	Z	<input type="text" value="1"/>	D	<input type="text" value="1"/>
A	<input type="text" value="1"/>	B	<input type="text" value="1"/>	C	<input type="text" value="1"/>	T	<input type="text" value="1"/>

TestResult:

THE FOLLOWING ARE THE FEW SETTINGS THAT ARE DIFFERENT FOR THE LATHE MODE

NOTE: As you can see the Step and Dir pins are different for the axes in the Lathe mode, because in lathe the axes designations are different than in mill. This assures that when in lathe, the proper axis moves when given a G code command. As with the mill mode, changing the Dir Low Active from red to green or vice versa will reverse the direction of your carriage.

Port Setup and Axis Selection | Motor Outputs | Input Signals | Output Signals | Encoder/MPG's | Spindle Setup | Turn Options

Signal	Enabled	Step Pin#	Dir Pin#	Dir LowActi...	Step Low A...	Step Port	Dir Port
X Axis		4	5			1	1
Y Axis		6	7			1	1
Z Axis		2	3			1	1
A Axis		8	9			1	1
B Axis		0	0			0	0
C Axis		0	0			0	0
Spindle		14	14			1	1

OK

Cancel

Apply

Port Setup and Axis Selection | Motor Outputs | Input Signals | Output Signals | Encoder/MPG's | Spindle Setup | Turn Options

X Mode

 Radius Reversed Arc's in Front Post Diameter

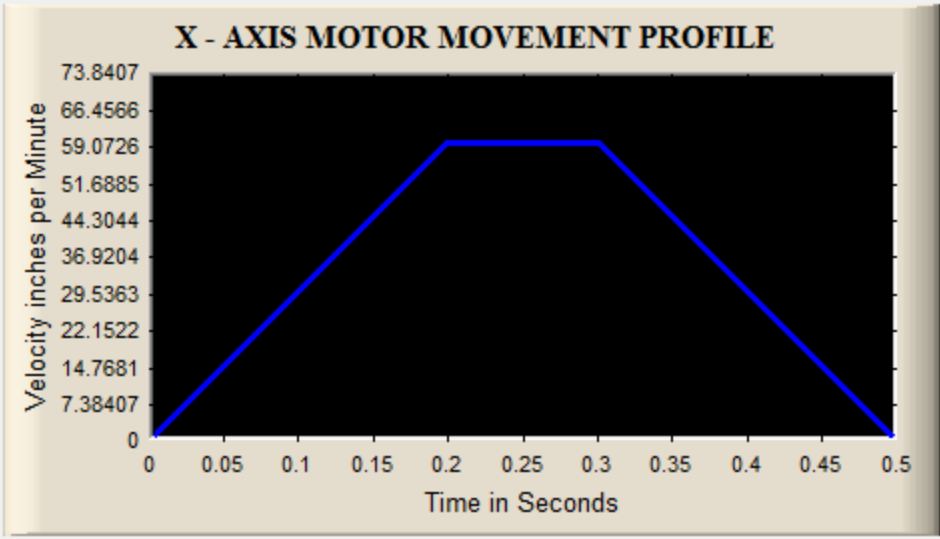
Turn cycle defaults

Depth Last Pass (B)	<input type="text" value="0"/>	Cut Type:	<input type="text" value="0"/>
InFeed Angle (I)	<input type="text" value="29.5"/>	InFeed Type:	<input type="text" value="0"/>
Spring Passes (Q)	<input type="text" value="1"/>	Z Clearance	<input type="text" value="0.1"/>
Min Depth per Pass	<input type="text" value="0.001"/>	Cut Depth	<input type="text" value="0.1"/>
X Clearance	<input type="text" value="0.1"/>		
Chamfer Angle (L)	<input type="text" value="0"/>		
Depth First Pass (H)	<input type="text" value="0.1"/>		

OK

Cancel

Apply



Velocity

Axis Selection

X Axis

Y Axis

Z Axis

A Axis

B Axis

C Axis

Spindle

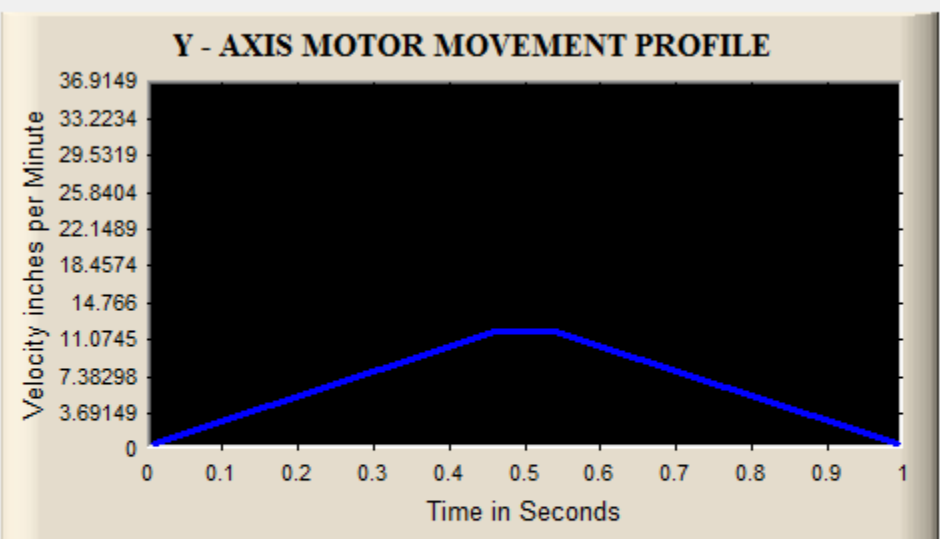


Accel

Steps per	Velocity In's or mm's per min.	Acceleration in's or mm's/sec/sec	G's	Step Pulse 1 - 5 us	Dir Pulse 0 - 5
10157	60	5	0.0478153	5	5

SAVE AXIS SETTINGS

Cancel OK



Velocity

Axis Selection

X Axis

Y Axis

Z Axis

A Axis

B Axis

C Axis

Spindle

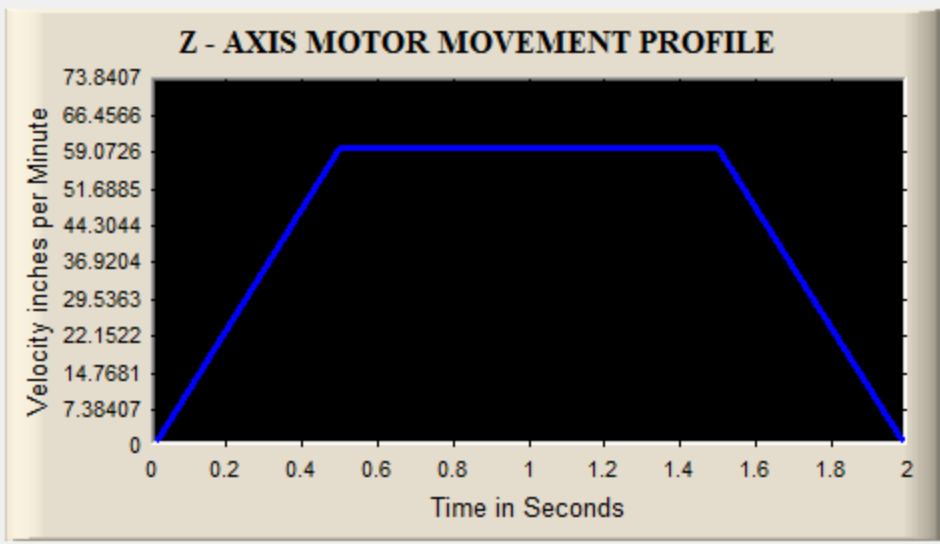


Accel

Steps per	Velocity In's or mm's per min.	Acceleration in's or mm's/sec/sec	G's	Step Pulse 1 - 5 us	Dir Pulse 0 - 5
20317	12	0.43351535	0.0011228	5	5

SAVE AXIS SETTINGS

Cancel OK



Velocity

Axis Selection

X Axis

Y Axis

Z Axis

A Axis

B Axis

C Axis

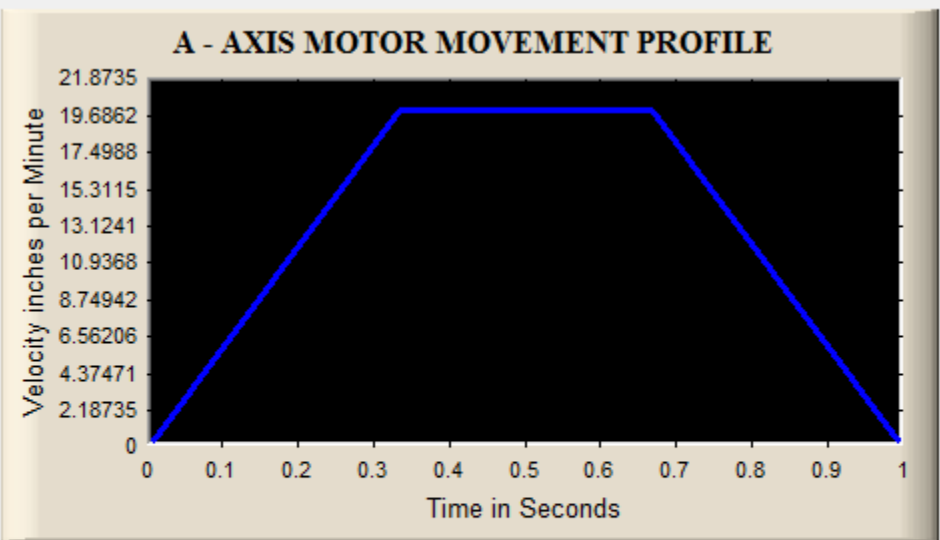
Spindle

Accel

Steps per	Velocity In's or mm's per min.	Acceleration in's or mm's/sec/sec	G's	Step Pulse 1 - 5 us	Dir Pulse 0 - 5
10157	60	2	0.0043038	5	5

SAVE AXIS SETTINGS

Cancel OK



Velocity

Axis Selection

X Axis

Y Axis

Z Axis

A Axis

B Axis

C Axis

Spindle

Accel

Steps per	Velocity In's or mm's per min.	Acceleration in's or mm's/sec/sec	G's	Step Pulse 1 - 5 us	Dir Pulse 0 - 5
2143	20	1	0.1160327	5	5

SAVE AXIS SETTINGS

Cancel OK

Current Pulley

Min Speed

Max Speed

Ratio

Pulley Number 1 ▾

0

1645

1

 Reversed

OK