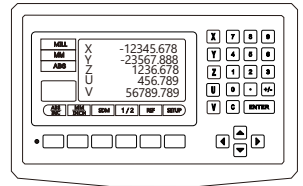
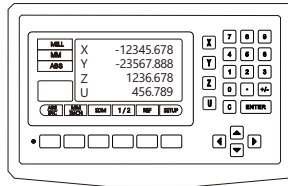
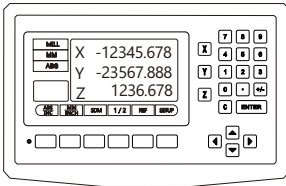
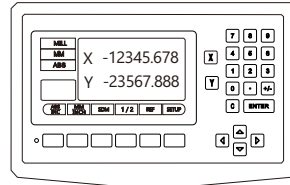
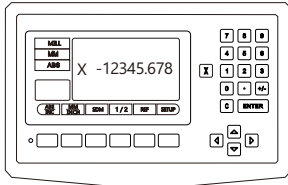


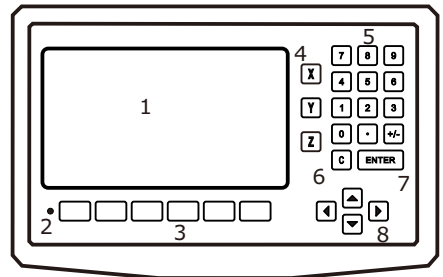
DS50 Digital Readout Operation Manual

Version: 1.0



Key Layout

1. LCD Display
2. Power LED
3. Function Keys
4. Axis Key
5. Numeric Keys
6. Cancel Key
7. Enter Key
8. Arrow Key



Safety

Dear Users:

Thank you for purchasing our Digital Readouts. The digital readout is Applicable for the machines such as millers, lathes, boring machines, grinding machines and EDM ,etc.. Read all the instructions in the manual carefully before used and strictly follow them. keep the manual for future references.

Safety attention:

To prevent electric shock or fire, moisture or directly sprayed cooling liquid must be avoid. In case of any smoke or peculiar smell from the digital readout, please unplug the power plug immediately, otherwise, fire or electric shock may be caused. In such a case, do not try to repair it , please contact distributors

Digital readout is precise measuring device used with an optical Linear scale. When it is in use, if the connection between the Linear Scale and the digital readout is broken or damaged externally, incorrect measuring values may be resulted. Therefore, the user should be careful.

Do not try to repair or modify the digital readout, otherwise, failure fault or injury may occur. In case of any abnormal condition, Please contact distributors.

If the optical Linear Scale used with the digital readout is damaged, do not use a Linear Scale of other brand. Because the performance, specification and connection of the products of different and can not be connected without the instruction of specialized technical personnel, otherwise, trouble will be used to the digital readout.

SYSTEM SET	LOGO:	<input type="text" value="ON"/>
AXIS SET	LANGUAGE:	<input type="text" value="ENGLISH"/>
SERIAL PORT	MACHINE TYPE:	<input type="text" value="MILL"/>
KeyPad TEST	No. AXIS :	<input type="text" value="3"/>
FACTORY RESET	No. DECIMALS:	<input type="text" value="5"/>
	BRIGHTNESS:	<input type="text" value="200"/>
	SAVE TIME:	<input type="text" value="30min"/>
	ABS SET:	<input type="text" value="ON"/>
	BUTTON SOUND	<input type="text" value="ON"/>

MENU
↑

MENU
↓

+

-

OK

- Note:** (1) use to select menu between
- (2) use Arrow keys to select items
- (3) use to change the value of the selected item.

LANGUAGE: ENGLISH / TURKCE / DEUTSCH / PORTUGUES

MACHINE TYPE: MILL / LATHE / GRIND / EDM

No. AXIS: 1/2/3/4/5

No. DECIMALS: 4/5 (only useful @ INCH unit)

BRIGHTNESS: (Dark) 1 – 255(Bright)

SAVE TIME:

ABS SET: OFF (don't Clear Zero and Enter Dimension)

BUTTON SOUND: ON / OFF Button Buzzer

MACHINE TYPE:

MILL FUNCTIONS

ABS INC	MM INCH	SDM	1 / 2	REF	SETUP
			ERR COMP		
D/R	Y + Z				

LATHE FUNCTIONS

ABS INC	MM INCH	SDM	1 / 2	REF	SETUP
	Y + Z	D / R	ERR COMP	TOOLS	

EDM FUNCTIONS

ABS INC	MM INCH	SDM	1 / 2	REF	SETUP
		EDM	ERR COMP		

GRIND FUNCTIONS

ABS INC	MM INCH	SDM	1 / 2	REF	SETUP
			ERR COMP		

No.Axis: 1 / 2 / 3 / 4 / 5

MM	X	-12345.678
ABS		
MM		
ABS		
MM		
ABS		
MM		
ABS		
MM		
ABS		

1 Axis

MM	X	-12345.678
ABS		
MM	Y	-23567.888
ABS		
MM		
ABS		
MM		
ABS		
MM		
ABS		

2 Axes

MM	X	-12345.678
ABS		
MM	Y	-23567.888
ABS		
MM	Z	1236.678
ABS		
MM		
ABS		
MM		
ABS		

3 Axes

MM	X	-12345.678
ABS		
MM	Y	-23567.888
ABS		
MM	Z	1236.678
ABS		
MM	U	456.789
ABS		
MM		
ABS		

4 Axes

MM	X	-12345.678
ABS		
MM	Y	-23567.888
ABS		
MM	Z	1236.678
ABS		
MM	U	456.789
ABS		
MM	V	56789.789
ABS		
MM		
ABS		

5 Axes

Parameters Setup – AXIS SET

SYSTEM SET	TYPE	RES	DIR	ERR COMP	
AXIS SET	X	L	5um	L	LINE
SERIAL PORT	Y	L	5um	L	UN-LINE
KeyPad TEST	Z	L	5um	L	LINE
FACTORY RESET					
MENU ↑	MENU ↓	+	-		OK

Note: (1) use to select menu between

(2) use Arrow keys to select items

(3) use to change the value of the selected item.

Type: the Type of the Scale, L (linear Scale) and R (Rotary Scale)
RES: Resolution of the scale . you can press to change the value.
DIR: Direction , L for Left direction and R for Right direction.
ERR COMP: Error compensation, Linear for linear compensation and UN-Linear for un-linear compensation.

Parameters Setup – Serial Port

SYSTEM SET	BAUD RATE: <input type="text" value="115200"/> DATA: <input type="text" value="8"/> STOP: <input type="text" value="1"/> PARITY: <input type="text" value="No Parity"/>				
AXIS SET					
SERIAL PORT					
KeyPad TEST					
FACTORY RESET					
MENU ▲	MENU ▼	+	-		OK

Setup the RS-232 Serial Port

Parameters Setup – KeyPad Test

SYSTEM SET	<table border="0"><tr><td>(X)</td><td>(7)</td><td>(8)</td><td>(9)</td></tr><tr><td>(Y)</td><td>(4)</td><td>(5)</td><td>(6)</td></tr><tr><td>(Z)</td><td>(1)</td><td>(2)</td><td>(3)</td></tr><tr><td>(U)</td><td>(0)</td><td>(.)</td><td>(+/-)</td></tr><tr><td>(V)</td><td>(C)</td><td>(ENTER)</td><td></td></tr><tr><td></td><td>(←)</td><td>(↑)</td><td>(→)</td></tr><tr><td></td><td></td><td>(↓)</td><td></td></tr></table>	(X)	(7)	(8)	(9)	(Y)	(4)	(5)	(6)	(Z)	(1)	(2)	(3)	(U)	(0)	(.)	(+/-)	(V)	(C)	(ENTER)			(←)	(↑)	(→)			(↓)	
(X)		(7)	(8)	(9)																									
(Y)		(4)	(5)	(6)																									
(Z)		(1)	(2)	(3)																									
(U)		(0)	(.)	(+/-)																									
(V)	(C)	(ENTER)																											
	(←)	(↑)	(→)																										
		(↓)																											
AXIS SET																													
SERIAL PORT																													
KeyPad TEST																													
FACTORY RESET																													
MENU ▲	MENU ▼	+	-		OK																								

You can check the DRO keyPad

Parameters Setup – Factory Reset

SYSTEM SET	SoftWare Ver: V1.12 SYSTEM ID: 35383537 34365117 0056003C FACTORY RESET: Press 'C' + '0000'+ 'ENTER'				
AXIS SET					
SERIAL PORT					
KeyPad TEST					
FACTORY RESET					
MENU ▲	MENU ▼	+	-		OK

Press 'C' + '0000' + 'ENTER' for Default

Clear Zero, Enter Dimension, ABS, MM

ABS
INC

MM
INCH

1. Clear Zero: Set the current position to Zero
For example: press **X** **C** set the X coordinate to Zero

MILL	X	888.000
MM	Y	0.000
ABS	Z	0.000
ABS INC	MM INCH	SDM 1/2 REF SETUP

X **C**

MILL	X	0.000
MM	Y	0.000
ABS	Z	0.000
ABS INC	MM INCH	SDM 1/2 REF SETUP

2. Enter Dimensions:
For example: Press **X** **+/-** **7** **8** **9** **.** **5** **ENTER** to enter the X Dimension.

MILL	X	0.000
MM	Y	0.000
ABS	Z	0.000
ABS INC	MM INCH	SDM 1/2 REF SETUP

X **+/-** **7** **8** **9** **.** **5** **ENTER**

MILL	X	-789.500
MM	Y	0.000
ABS	Z	0.000
ABS INC	MM INCH	SDM 1/2 REF SETUP

3. Inch / MM Display conversion:

MILL	X	25.400
MM	Y	0.000
ABS	Z	-25.400
ABS INC	MM INCH	SDM 1/2 REF SETUP

MM INCH
MM INCH

MILL	X	1.0000
INCH	Y	0.0000
ABS	Z	-1.0000
ABS INC	MM INCH	SDM 1/2 REF SETUP

4. ABS / INC (Absolute / Incremental) Display conversion:
Description: There are two sets of basic coordinates display mode , ABS and INC. the operator can store the workpiece datum (zero position) in ABS coordinate, the switch to INC coordinate for continue machining operations. ABS and INC can be simply toggle by pressing the Function key **ABS INC**

MILL	X	25.400
MM	Y	0.000
ABS	Z	-25.400
ABS INC	MM INCH	SDM 1/2 REF SETUP

ABS INC
ABS INC

MILL	X	111.000
MM	Y	222.000
INC	Z	333.000
ABS INC	MM INCH	SDM 1/2 REF SETUP

5. 1/2 Function:

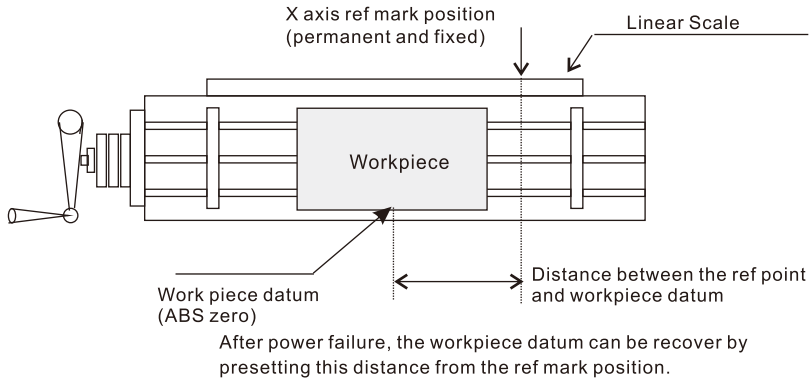
For example: press **X** **1/2** set the X coordinate to Half.

MILL	X	888.000			
MM	Y	0.000			
ABS	Z	0.000			
ABS INC	MM INCH	SDM	1/2	REF	SETUP

X **1/2**

MILL	X	444.000			
MM	Y	0.000			
ABS	Z	0.000			
ABS INC	MM INCH	SDM	1/2	REF	SETUP

6. Ref Datum Memory function: This function allows the operator to store the workpiece zero position in memory. If the machine is turned off or there is a power failure, the zero reference point can be recovered.



6.1 Store the workpiece zero position in memory(FIND REF function)

MILL	X	12.550			
MM	Y	-123.560			
FIND REF	Z	34.785			
Move Scale Black Color means Find REF					
FIND REF	RECALL REF				EXIT

Note: Green display Color indicate not Find the Ref.

Move the workpiece, Black display color indicate Find the Ref.

6.2 Recover the workpiece zero position (RECALL REF Mark function)

MILL	X	10.500			
MM	Y	-222.560			
RECALL REF	Z	333.785			
Move Scale Black Color means Recall REF					
FIND REF	RECALL REF				EXIT

Note: Green Color means not Recall Ref.

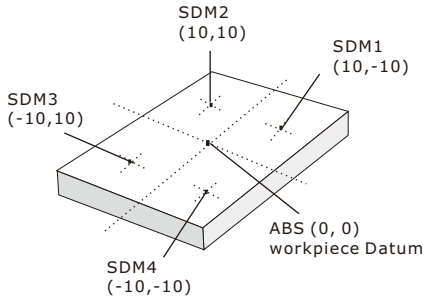
Move the workpiece, Black display color indicate find REF.

After REF, operator can continue their work as before

7. 200sets SDM (Sub Datum Function)

There are three kinds of coordinate systems. ABS(1set), INC(1set) and SDM Mode(200sets). It is a good way to store the datum of workpiece in ABS Mode and to machine in INC or SdM Mode. INC Mode is independent of ABS, it is not relative to ABS datum. However, all Sdm coordinate are relative to ABS coordinate, the SDM position will shift together with the ABS zero position change.

Application to workpiece that have more than one datums



MILL	X	12.550
MM	Y	-123.560
SDM 1	Z	34.785
ABS INC	MM INCH	SDM
	1 / 2	REF
		SETUP

There are two methods to setup the all Datums.

Mode1(Zeroing when reaching position):

1. Set the origin of ABS
2. In ABS mode, move the machine worktable to coordinate(10,-10) then press $\uparrow\downarrow$ arrow key to enter SDM 1 Mode, clear X, Y zero,SDM1 OK.
3. Press $\left[\begin{array}{c} \text{ABS} \\ \text{INC} \end{array} \right]$ key to ABS Mode. move the machine worktable to coordinate (10,10), press $\uparrow\downarrow$ arrow key to enter SDM2, clear X,Y zero. SDM2 OK.
4. Press $\left[\begin{array}{c} \text{ABS} \\ \text{INC} \end{array} \right]$ key to ABS Mode. move the machine worktable to coordinate (-10,10), press $\uparrow\downarrow$ arrow key to enter SDM2, clear X,Y zero. SDM3 OK.
5. Press $\left[\begin{array}{c} \text{ABS} \\ \text{INC} \end{array} \right]$ key to ABS Mode. move the machine worktable to coordinate (-10,-10), press $\uparrow\downarrow$ arrow key to enter SDM2, clear X,Y zero. SDM4 OK

Mode2: (Directly input SDM zero)

Note: the input value and the coordinate value is contrary.

Reason: the TOOL is at the origin of ABS Mode. As the input value is contrary to the coordinate.

Retract the axes until the displays read 0. the TOOL can be placed exactly at the origin of SDM.

1. Set the origin of ABS
2. Press $\uparrow\downarrow$ arrow key to enter SDM 1 Mode, Press $\left[\text{SDM} \right] \left[X \right] \left[1 \right] \left[0 \right] \left[\text{SDM} \right]$ to enter X (10)coordinate ,press $\left[\text{SDM} \right] \left[Y \right] \left[+ \right] \left[1 \right] \left[0 \right] \left[\text{SDM} \right]$ to enter Y(-10)coordinate. SDM1 OK.
3. Press $\uparrow\downarrow$ arrow key to enter SDM 2 Mode, Press $\left[\text{SDM} \right] \left[X \right] \left[1 \right] \left[0 \right] \left[\text{SDM} \right]$ to enter X (10)coordinate ,press $\left[\text{SDM} \right] \left[Y \right] \left[1 \right] \left[0 \right] \left[\text{SDM} \right]$ to enter Y(10)coordinate. SDM2 OK.
4. Press $\uparrow\downarrow$ arrow key to enter SDM 3Mode, Press $\left[\text{SDM} \right] \left[X \right] \left[+ \right] \left[1 \right] \left[0 \right] \left[\text{SDM} \right]$ to enter X (-10)coordinate ,press $\left[\text{SDM} \right] \left[Y \right] \left[1 \right] \left[0 \right] \left[\text{SDM} \right]$ to enter Y(10)coordinate. SDM3 OK.
5. Press $\uparrow\downarrow$ arrow key to enter SDM 4 Mode, Press $\left[\text{SDM} \right] \left[X \right] \left[+ \right] \left[1 \right] \left[0 \right] \left[\text{SDM} \right]$ to enter X (-10)coordinate ,press $\left[\text{SDM} \right] \left[Y \right] \left[+ \right] \left[1 \right] \left[0 \right] \left[\text{SDM} \right]$ to enter Y(-10)coordinate. SDM4 OK.

8. Error compensation: Press ERR
COMP function key.

8.1 Linear compensation: Press Linear function key

MILL		StandLen	MeaLen	S
MM	X	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>
Linear	Y	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>
	Z	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>

Linear
UNLinear

CANCEL
OK

Press Linear Key ,The display is shown as Left.

Press ◀ ▲ ▶ to focus on different item.

**Note: StandLen: means Stand Length
MeaLen: Means Measure Length**

UNLinear Goto Un-linear Parameters Setup
CANCEL
OK

8.2 UnLinear Compensation: Press UNLinear function key

MILL		No.	StandLen	MeaLen
MM	001	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>
UnLinear	002	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>
	003	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>
	004	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>
	005	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>
	006	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>
	007	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>
	008	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>	<input style="width: 80px;" type="text"/>

LAST
PAGE
NEXT
PAGE

CANCEL
OK

Press UNLinear Key ,The display is shown as Left.

Press ◀ ▲ ▶ to focus on different item.

**Note: StandLen: means Stand Length
MeaLen: Means Measure Length**

LAST
PAGE NEXT
PAGE Goto Un-linear Parameters Setup
CANCEL
OK

9. Calculator

MILL		X	10.000
MM	12	Y	0.000
(CALC)	+ 12 = 24	Z	0.000

+
-
X
÷
π
EXIT

Press (CALC) Key to enter Calculator

Press ◀ ▶ can see all operators as follow

+
-
X
÷
π
EXIT

2nd
Sin
Cos
Tan
√
EXIT

C cancel key

ENTER equal sign key

EXIT Exit the calculator

For Example:

(1) 12 + 12 = 24: 1 2 + 1 2 ENTER

(2) SIN 45 = 0.707107: 4 5 Sin ENTER

(3) ArcSin0.707 = 44.9999: : 4 5 Sin ENTER Sin 2nd ENTER

The value computed from the calculator can be transfer to the axis, Operator can only press the X or Y or Z key.

LINEAR HOLE, PCD



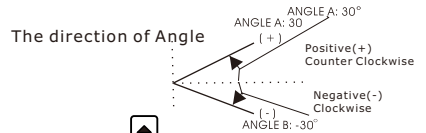
10. LINEAR HOLE: Press function key.

LINEAR HOLE		View
PLANE:	XY	
FIRST HOLE: X	0.000	
Y	0.000	
MODE:	TOTAL	
LENGTH/STEP:	100	
ANGLE:	30.0000	
HOLE:	10	
+ -		CANCEL OK

LHOLE Parameters Setup Panel

There are two modes to carry out the Linear Drilling

- TOTAL Mode:** Total Length of oblique line. the distance of the centers of the starting hole to the ending hole.
- STEP Mode:** STEP Length of two adjacent holes



press the keys and Numeric Keys to input the value of the item

MILL	X 0.000				
MM					
No. 1					
	Y 0.000				
	Z 0.000				
FIRST HOLE	END HOLE	←	→	PARAM SETUP	EXIT

- + - change the value of the item
- CANCEL Exit the Linear Hole
- OK Goto Linear Holes Machine

LHOLE Working Panel

- FIRST HOLE END HOLE ← → Select No. Hole
- PARAM SETUP Goto Parameters setup
- EXIT Exit Linear Hole Function

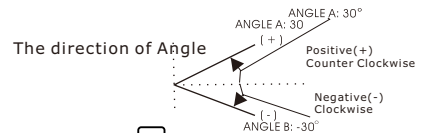
11. PCD: Press function key

TYPE:		SEGMENT	View
PLANE:	XY		
CENTER:	X	0.000	
	Y	0.000	
DIAMETER:	100.000		
HOLES:	7		
START ANGLE:	0.000		
END ANGLE:	270.000		
+ -		CANCEL OK	

PCD Parameters Setup Panel

There are two modes to carry out the PCD Drilling

- FULL Mode:** all circle
- SEGMENT Mode:** segment of a circle.



press the keys and Numeric Keys to input the value of the item

MILL	X 0.000				
MM					
No. 1					
	Y 0.000				
	Z 0.000				
FIRST HOLE	END HOLE	←	→	PARAM SETUP	EXIT

- + - change the value of the item
- CANCEL Exit the PCD function
- OK Goto PCD Machine

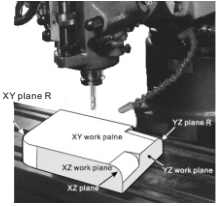
PCD Working Panel

- FIRST HOLE END HOLE ← → Select No. Hole
- PARAM SETUP Goto Parameters setup
- EXIT Exit PCD Function

ARC



12. R function:



Coordinate system of machine

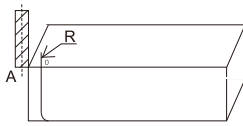


Figure A

Planar milling TOOL

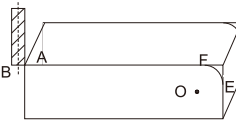


Figure B

Arc milling TOOL

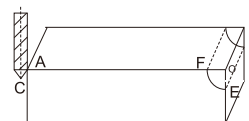
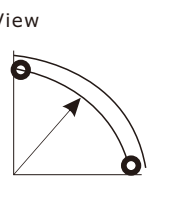


Figure C

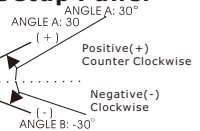
Install and fix the workpiece in accordance with Figure(A,B,C) and set the parameters.




1. Move the TOOL to the start point and Clear zero every axis.
2. Press the  key to enter ARC function Parameters Setup Panel

ARC FUNCTION		View 
PLANE:	<input type="text" value="XY"/>	
CENTER:	X <input type="text" value="0.000"/>	
	Y <input type="text" value="0.000"/>	
RADIUS:	<input type="text" value="100.000"/>	
TOOL DIA:	<input type="text" value="10"/>	
MAX CUT:	<input type="text" value="30.000"/>	
START ANGLE:	<input type="text" value="0.000"/>	
END ANGLE:	<input type="text" value="90.000"/>	
R + TOOL:	<input type="text" value="R + TOOL"/>	
<input type="button" value="+"/> <input type="button" value="-"/> <input style="width: 20px; height: 20px;" type="button" value=" "/> <input style="width: 20px; height: 20px;" type="button" value=" "/> <input type="button" value="CANCEL"/> <input type="button" value="OK"/>		

ARC Parameters Setup Panel

The direction of Angle



press the    keys and Numeric Keys to input the value of the item

- change the value of the item
- EXIT the ARC function
- Goto ARC Machine

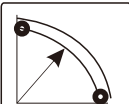
Note:

- * CENTER is refer to the position of the center of an arc relative to that of the TOOL at TOOL setting and clear.

When Plane XZ or YZ is machined

As shown in figure B. It refers to the position of Point O at the center of the Arc relative to Point B of the TOOL when a planar milling TOOL is used.

As shown in figure C. It refers to the position of point O at the center of the Arc relative to Point C of the TOOL when an Arc milling TOOL is used.

MILL	X <input type="text" value="0.000"/>
MM	
No. 1	
	Y <input type="text" value="0.000"/>
	Z <input type="text" value="0.000"/>
<input type="button" value="FIRST POINT"/> <input type="button" value="END POINT"/> <input type="button" value="←"/> <input type="button" value="→"/> <input type="button" value="PARAM SETUP"/> <input type="button" value="EXIT"/>	

ARC Function Working Panel

- Select No. POINT
- Goto Parameters setup
- Exit ARC Function



13. D/R Function

MILL	X	0.000
MM		
ABS		
	Y	0.000
	Z	0.000

D/R

Press **D/R** Key ,The display Mode of X axis is switched between Radius and Diameter. When in Diameter Mode , the color of display is Red. When in Radius Mode , the color of display is Black.

14. Y+Z Function

MILL	Enable/Disable		ITEM
MM	X	<input type="button" value="OFF"/>	<input type="button" value="X=Y"/>
Y+Z	Y	<input type="button" value="OFF"/>	<input type="button" value="Y=X"/>
	Z	<input type="button" value="OFF"/>	<input type="button" value="Z=Y"/>

Y+Z

Press **Y+Z** Key ,The display is shown as Left. Press to focus on different item.

change the value of item

OK, and exit Y+Z function.

Note:(1) when Enable/Disable is ON , the followed Item is enable.
(2)X= Y+Z indicate the Y value Plus Z value will display in X axis

15. TAPER Function

		POINT A	POINT B
		X <input type="text"/>	<input type="text"/>
		Y <input type="text"/>	<input type="text"/>

X	0.000	ANGLE <input type="text"/>
Y	0.000	TAPER <input type="text"/>



Press **D** Key ,The display is shown as Left.

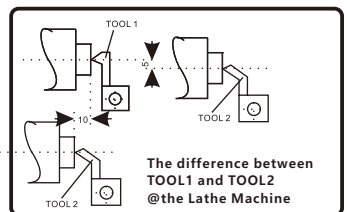
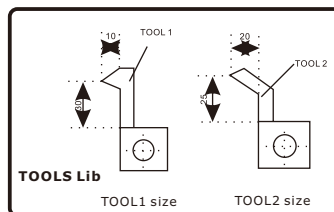
Move the Workpiece to POINT A , press the coordinate of POINT A display, Move the Workpiece to POINT B, press the coordinate of POINT B display, and Calculate the value ANGLE and TAPER will be displayed.

Exit the TAPER function

16. TOOLS Function

It always needs different TOOL when processing different parts. For convenient operation. the DRO has the function of 200 sets TOOL Libs.

Note: Only when the lathe is equipped with the tool setting block, the 200 sets TOOL Libs can be used.



17. TOOLS LIB (continue)

LATHE MM TOOLS LIB	Tool No.	X Value	Z Value	BaseTool	UseTool
	001	0.000	0.000	V	V
	002	0.000	0.000	X	X
	003	0.000	0.000	X	X
	004	0.000	0.000	X	X
	005	0.000	0.000	X	X
	006	0.000	0.000	X	X
	007	0.000	0.000	X	X
	008	0.000	0.000	X	X
	009	0.000	0.000	X	X
	010	0.000	0.000	X	X

TOOLS Lib Parameters Setup Panel

Press key, then press key to enter TOOLS Lib Parameters SETUP Panel.
 X Value and Y Value of TOOL are TOOL size.
 BaseTool is the Base TOOL, After Base TOOL setting, zero X axis and z axis, The set zero of absolute coordinate.(ABS)

Use key to focus on different TOOL and input Value.
 When in BaseTool and UseTool form, use key to change the state X or V.
 goto next Page or go back to last page
 OK and Exit the TOOL Lib parameter setup

LATHE MM BASE TOOL	X	0.000
	Y	0.000
	Z	0.000

USE TOOLS LIB Panel

18. EDM

EDM Parameters Setup Panel

EDM FUNCTION		
DEPTH:	<input type="text" value="10.000"/>	
ERRHIGH:	<input type="text" value="-120.000"/>	
DIRECTION:	<input type="text" value="POSITION"/>	
DELAY TIME:	<input type="text" value="3.0s"/>	
WORK MODE:	<input type="text" value="AUTO"/>	
RELAY OUTPUT:	<input type="text" value="R0"/>	
DISPLAY MODE:	<input type="text" value="M1"/>	

Press key to enter EDM function

Press keys and numeric keys to input the value

DEPTH -- Machining depth
 ERRHIGH -- Negative fireproof Height
 DIRECTION -- machining direction (POSITIVE / NEGATIVE)

DELAY TIME -- the time of relay ON when EDM work done. (unit: s)

WORK MODE -- AUTO / STOP Mode
 RELAY OUTPUT -- R0 / R1

DISPLAY MODE: there are two display mode,
 In DISPLAY MODE1 the X-axis will display machining depth target value, Y-axis will display value has been to be depth, and Z-axis will display self-position real time value.

In DISPLAY MODE2, all the X, Y, Z axis will display themself-position real time value.

EDM working Panel (Display Mode 1)

EDM MM DISPLAY M1	X	10.000
	Y	0.000
	Z	0.000

Select the Mode of display

Goto Parameters setup

Exit EDM Function



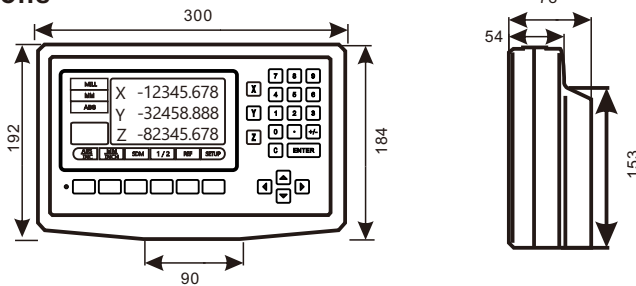
Pin	1	3	5
	NC	COM	NO

Specifications of Digital Readout

Features:

1. Supply Voltage range: AC80V --265V; 50--60Hz
2. Power consumption: 10VA
3. Operating temperature: -20° - 50°
4. Storage Temperature: -30° - 70°
5. Relative humidity: < 90% (@25)
6. Max coordinate number: 1,2,3,4,5
7. Readout allowable input signal: TTL square wave / EIA422
8. Allowable input signal frequency: < 5MHz
9. Max resolution of digital display length: 0.1um
10. Max resolution of digital display angle: 0.0001/PULSE
11. Weight: 2.5 kg
12. Dimensions: 300 x 192 x 78 mm³

Dimensions



InterFace Circuit and output signals:

