

HD Settings

High/Low Speeds and Step distances (From main screen, hit 'Stop/Cancel')

High: 1000
Low: 100
XY Step: 0.005
Z Step: 0.002

Note: These numbers can vary.

*All following settings will be under 'MENU' and worded/abbreviated as you would see on screen.

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

MACHINE PARAM

→ Pulse Equivalent (password required: 123456)
* Pul Eq (mm/p)
X Axis 0.007855 0.005000 (HD Mini)
Y Axis 0.007855 0.005000
Z Axis 0.002500 0.002500

→ Machine Stroke
*Stroke (inch)
X+: 51.00
Y+: 97.00
Z+: 0.00
X-: 0.00
Y-: 0.00
Z-: -9.00

→ Axis Output Dir
*Axis output dir
X Axis: NegDir
Y Axis: NegDir
Z Axis: NegDir

→ Back to ref pt
→ Bk to ref pt sp
X Axis: 70.000
Y Axis: 70.000
Z Axis: 55.000
→ Bk to ref pt dir
X Axis: NegDir
Y Axis: NegDir
Z Axis: NegDir
→ Retract Distance

X Axis: 0.079
Y Axis: 0.079
Z Axis: -0.079

→ Spindle setting

→ Spindle gear set

*Spin status no.

7

→ Spin on/off delay

Spindle delay time (ms)

5000.000

→ Spin initial gear

*Spindle initial gear

6

→ Max spin speed

*Max spindle speed (r/min)

18000

→ Stop spindle

→ Stop when pause

*WT to stop spindle while pause

YES

→ Stop when stop

*WT to stop spin while stop mac

YES

→ Port polarity st

→ Input polarity (password required)

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| 0 | 1 | 2 | 3 | 4 | 5 | 6 | 7 |
| + | + | + | + | + | + | + | + |
| 8 | 9 | A | B | C | D | E | F |
| + | + | + | + | + | + | + | + |

→ Output polarity

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| 0 | 1 | 2 | 3 | 4 | 5 | 6 | 7 |
| + | + | + | + | + | + | + | + |

→ Block thickness

Block thickness (inch)

1.578 (will vary – must measure each!!)

→ Backlash comp

→ Compensation EN

Backlash compensation EN

NO

→ Backlash set

*Backlash (inch)

X: 0.000

Y: 0.000
Z: 0.000

→ Offset setting

→ Public offset

Public offset

X: 0.000
Y: 0.000
Z: 0.000

→ Workpiece offset

G54 > G59 will correspond to offsets 1 – 6 on main screen.

Coords will be distance from home position.

→ Tool change param (N/A)

→ Tool maga capa

*Tool magazine capacity

10

→ Current tool no.

Current tool no

1

→ Tool offset

Tool 1 – 10 (all zero)

→ Op tool cha cue

Whether to open tool change cue

YES

→ Safe height

Safe height (inch)

0.250

→ Select tool

*Pause Z offset (inch)

0.250

PROCESS PARAM

→ Speed Config

→ G00 speed

G00 speed (inch/min)

1000.000

→ Processing speed

(what override speed will run at)

Processing speed (inch/min)

100.00

→ Approaching speed

Approaching speed (inch/min)

75.000

→ Z max speed
Z max speed (inch/min)
225.000
→ Z dir speed
→ Speed enable
Whether to use Z direction speed
NO
→ Z direction speed
Z direction speed (inch/min)
50.000

→ Lubrication set
→ Start Auto Lubri
Whether to open auto lubrication
NO
→ Time interval
Tm interval for auto lubri (s)
18000
→ Duration
Duration for each lubri (s)
5

→ Acceleration set
→ Jerk
Jerk (inch/sec³)
300.000
→ Single axis ac
Single axis acceleration
25.000
→ Max cyc acc
Max cyc acc (inch/sec²)
100.000

→ Revolve axis set (N/A)

→ DXF parameter
→ Tool lift height
* Tool lifting height (inch)
0.039
→ Machining depth
* Machining depth (inch)
-0.039
→ Ft pt is zero pt
* Use first point as zero point
YES
→ Sp separate proc

* Shape separate processing_valid
NO
→ Bottom machining
* Bottom machining valid
NO
→ Metric size
* Use metric size
NO

→ Eng param
→ Tool lifting ht
* Tool lifting height (inch)
0.039
→ Tool change cue
* Tool change cue
YES
→ Cyc time
* Cyc time_of_eng processing
1
→ Home machining
* 0: Chip removal; 1: the high speed
0
→ Retract amount
* Retract amount (inch)
0.039
→ Select tool
* Select tool to do machining
YES

→ Back to ori bf pro
Whether to bk to mec ori bf proc
YES

→ Analytic param
→ Pre pgm seg num
Predicted program segments num
50
→ Ref circle radii
Reference circle radii (inch)
0.100
→ Ref circle speed
Reference circle speed (inch/min)
100.000
→ Limit max veloci
Limit max velocity for short line
YES

→ Ref length
Limit of short lines
0.100
→ Path smooth time
Path smoothing time (s)
0.000

→ Feedrate
Feedrate
1.0

→ G code Id config (override speed on/off)
G code Id attri
Scr F NO *NO for programmed speeds
Scr S NO *YES for override speeds

→ Proc time range
File select
U_disk file list
System File list

→ OR imp on man op
* OR imp on manual jg ad stp op
YES

→ Algorithm param
Wht to use S type alg for ac/dc
YES

→ G73_G83 retr amt
G73_G83 retract amount (inch)
0.000

→ G00 use 100% feed
* Whether to use 100% feedrate
YES

→ Bk to the ref pt
WH to cal rf pt ag af e-stop
YES

→ Decelerated dist
Decelerated distance (inch)
0.394

→ IJK increment md

Whether to use IJK inchement

YES

→ Recycle settings

→ Recycle mach on

Whether to use recycle machining

NO

→ Recycle times

Recycle times

2

→ Recycle interval (ms)

0

→ Stop spin

WT to stop spin when recycle

NO

→ Stop spin at end

WT to stop spin at end

YES

→ Eng unit

WT to change to Eng unit

YES

SYSTEM PARAM

→ File maintenance

→ View files

→ Copy to local

→ Delete local file

→ Backup param

(Will create backup file)

→ Export log

(Will create log.txt file. Need USB drive.)

→ Restore bakparam

(Will restore backed up settings.)

→ Restore facparam

(Will restore factory parameters.)

→ Language

Select language

Chinese

English

- Delete param bak
(Will delete backup.)

ADVANCED CONFIG

- Stalling set
 - Stalling way
After processing
 - Keep still
 - Stalling position
 - Workpiece origin
 - Stalling position
 - Enter position
Stalling position
 - X 0.000
 - Y 0.000
 - Z -0.039
 - Select position
Select position
Select after processing any key

- Rec mil pla proc
 - Processing param (vary)
Unit: Inch
 - Carvedpt 0.004
 - Cut depth 0.004
 - Tool diam 0.118
 - Nosepitc 0.079
 - Height 3.937
 - Width 3.937
 - X start 0.000
 - Y start 0.000
 - Manner crossmil
 - GenAFileAndLoad

- Sel region proc
 - Select file
 - Processing param (vary depending on loaded file)
 - Total:
 - Startline:
 - End line:
 - Start machining

SYSTEM DIAGNOSIS

→ Self check input
(No settings.)

→ Check output
(No settings.)

→ System info

→ Software version
NK105_04_37_102

→ Board card no
- #### - #### -

→ Remaining time
Perpetuity

→ Registered times
1

→ Keystroke diagn
(Will check if buttons work.)

→ System upgrade
Are you sure you want to upgrade the system?

→ Register (N/A)
Enter regcode