

GEN. SETUP

AXES SETUP

SPINDLE

I/O SETUP

I/O TRIGGER

APPEARANCE

PROFILES

APPLY SETTINGS

SAVE SETTINGS

☒ PWM spindlePWM pin: 1 port: 1 ☐ Active lowDir pin: 0 port: 0 ☐ Active low

PWM frequency (Hz): 200

PWM min. duty (%): 0 max. (%): 100

☐ Step/direction spindleStep pin: 0 port: 0 ☐ Active lowDir pin: 0 port: 0 ☐ Active low

Steps per rotation: 500

☒ Enable spindle relay outputsM3 relay pin: 4 port: 1 ☐ Active lowM4 relay pin: 3 port: 1 ☐ Active low

M3 delay after on: 500

M3 delay after off: 500

M4 delay after on: 500

M4 delay after off: 500

Spindle PID control Set

Index pin: 0 port: 0

Index prescaler: 1

Encoder PPR: 2000 ☐ Reverse enc. dir.

Encoder A pin: 1 port: 2

Encoder B pin: 2 port: 2

☒ Enable flood/mist relay outputsM7 relay pin: 0 port: 0 ☐ Active lowM8 relay pin: 0 port: 0 ☐ Active low

M7 delay after on: 0

M8 delay after off: 0

M9 delay: 0

Spindle Velocity (1/min) min.: 100 max.: 3000 Acceleration (sec): 5

☒ Use pulleys

Pulley no.: 1

Spindle pulleys

☐ Wait for the spindle to spin up with \pm 90 % tolerance for 1 seconds

MAIN

OFFSETS

TOOLS

PROBE

SETTINGS

DIAG.

CAM

HELP

G0|G8|G18|G40|G49|G50|G54|G64|G69|G90|G94|G97|G98
Machine in reset.

CYCLE START

C. TIME: 00:00:00

ZO SCALE MACHINE CO. WORK CO. DTG REF

X 1.0000 0.0000 0.0000 0.0000

Z 1.0000 0.0000 0.0000 0.0000

ZERO ALL

GOTO PARK 1

PROBE

HOME ALL

CLEAR

LOAD FILE

EDIT FILE

REWIND FILE

CLOSE FILE

G54

G55

G56

G57

G58

G59

E-Stop

SoftIn.

Probing

Run

Homing

HardIn.

Idle

Jog

Sync.

MDI:

F OV: 6.0 + 100% R 6.0 ACT: 0.0

S OV: 1000.0 + 100% R 1000.0 ACT: 1291.1

DWELL TIME: 0 TOOL: 0 T 0 CHANGE TOOL

SPINDLE CW SPINDLE CCW MIST COOLANT

TOOL X OFFSET: 0.0000 TOOL Z OFFSET: 0.0000

SET X DIAMETER: 0.0000 SET Z POSITION: 0.0000

Profile: NEW_EMCO_TURN

File:

SINGLE LINE

FEED HOLD

LINE: 0

RUN FROM HERE

OFFLINE MODE BLOCK DELETE

OVERRIDE LIMITS

CYCLE STOP

RESET



Type here to search



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ENG

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03/12/2023