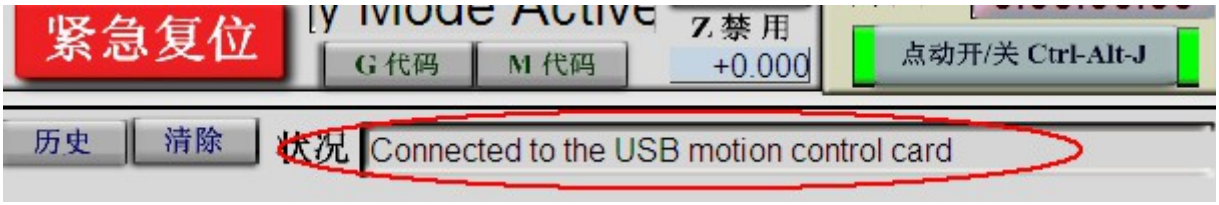
First step:

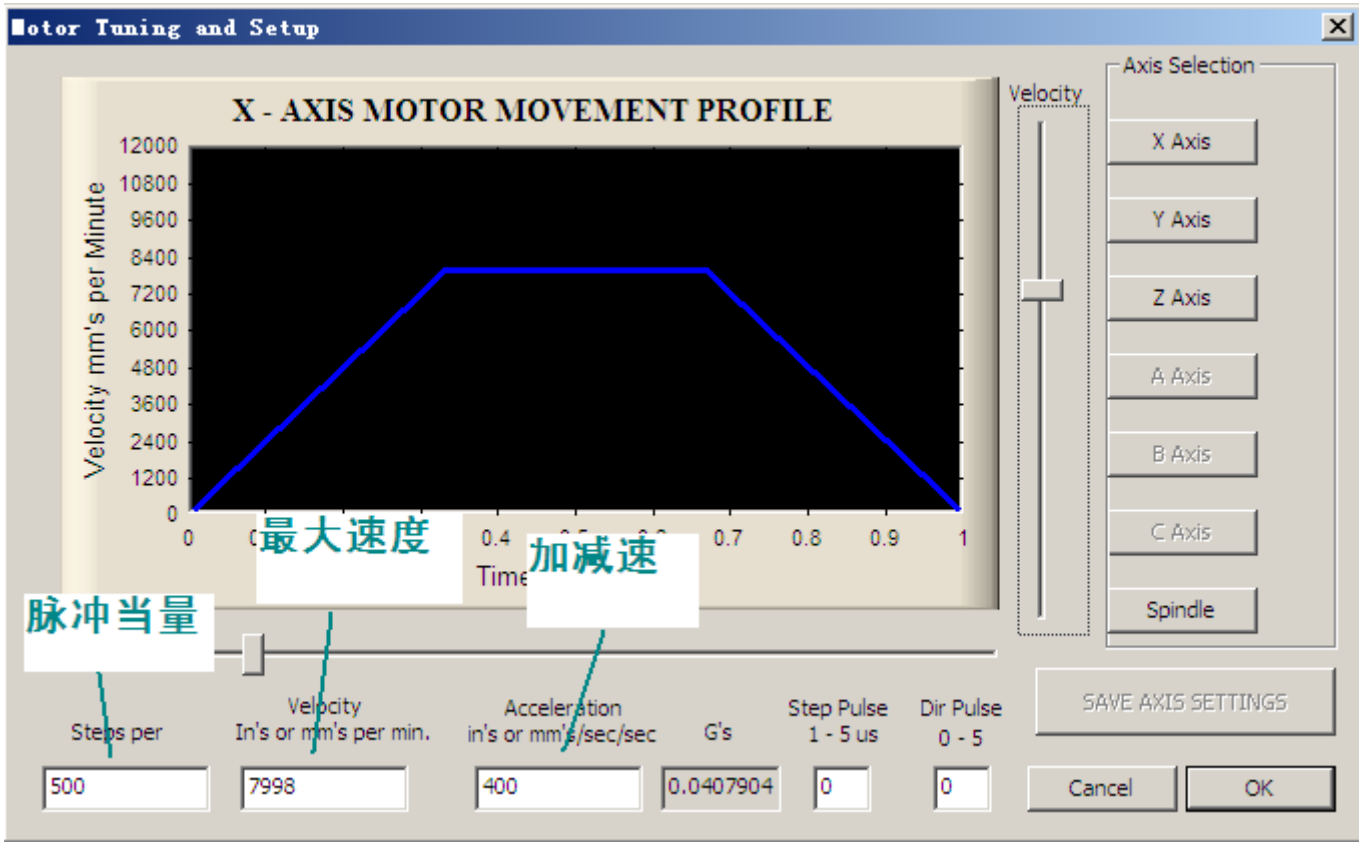
Software and driver installation is completed, running Mach3 software should be in the software status bar has the following tips:



If there is no description of the software and the software driver is not properly installed.

After the completion of the first step below is to set the 3 axis or 4 axis of the feed motor parameters such as the following figure:

The following figure is a description of the motor commissioning (X axis, other axis similar):

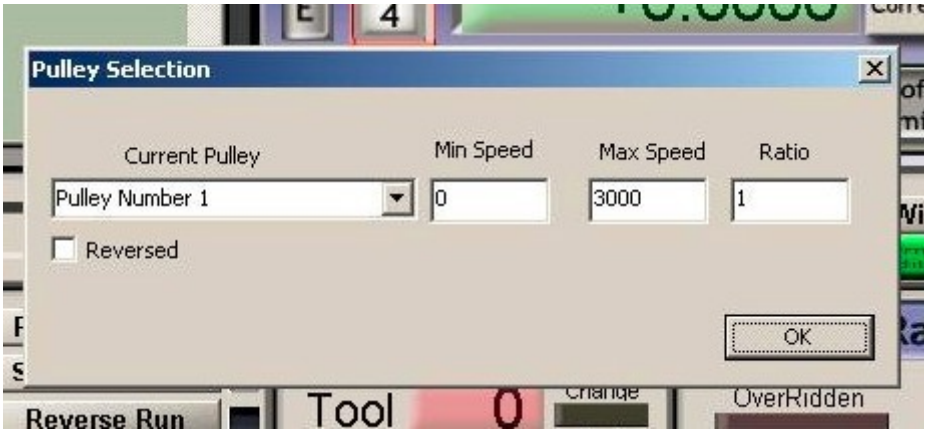


Pulse equivalent =200* fine fraction / pitch, if it is the first four weeks of the rotary table =200* small fraction * table deceleration ratio /360

Maximum speed: the maximum feed rate of the point move and machining. Recommended in 800-2000 (Z axis appropriate reduction).

Acceleration and deceleration: the motor start and stop time, the greater the set up, plus the slowdown, the slower the more slow.

Set the spindle speed as shown below



H gear is set to 0-3200, Ratio is 1.5

L gear is set to 0-980, Ratio is 5

The above parameters for reference, the specific customers can be set according to their own needs.

Set of handles: (if you do not use the handle does not need these settings)

Before the electronic handle is connected, it is required to put the disc on the

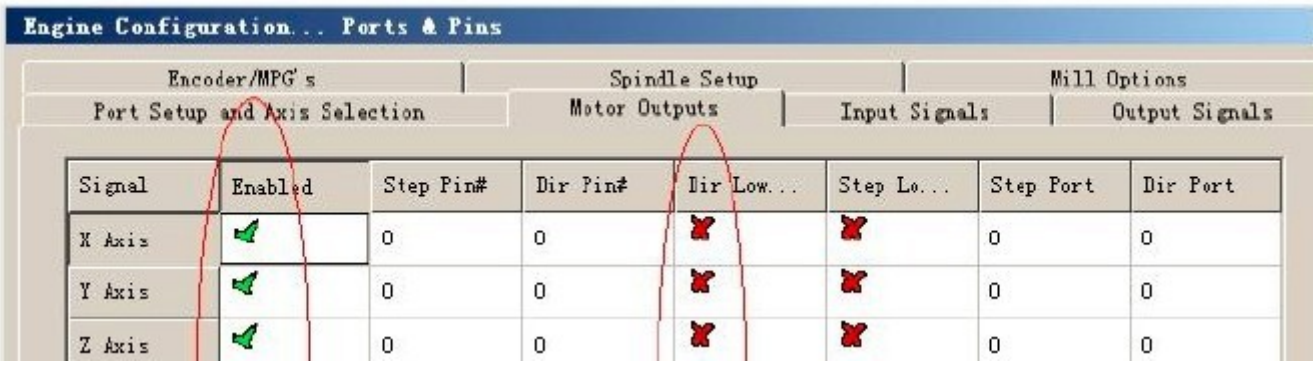
Ver1.62.dll JNC-40M file to put copy into the Mach3 path under the PlugIns folder,

Mach3Mill.xml file copy to Mach3 path,

2014-JNC-40M.brn file copy to the Mach3 path Brains folder,

In addition to the brain menu needs to be selected as the following figure, set to be able to run.

Also need to note is that if the X/Y/Z axis in the program inside the positive and negative direction is anti, only need to change the level of the motor output set the option to restart the computer can be. The following graph (low dir).



Other parameters of the software, in the installation of the driver has been automatically set, the general situation does not need to change