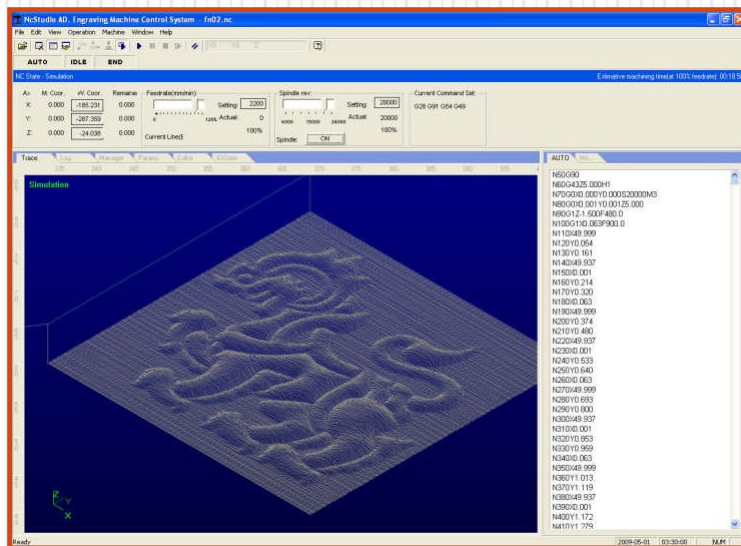


QUICK START-UP CNC ROUTER WITH NC STUDIO V. 4.44-B

By:
AUTOMATION MAKER LTD.



QUICK START- CONTENTS

1. INSTALL &
INSERT CARD

2. SET IO

3. SET
PARAMETERS

4. TEST
RUN



Each machine is different. Therefore we are not responsible for any inaccurate data that maybe occur in this manual.

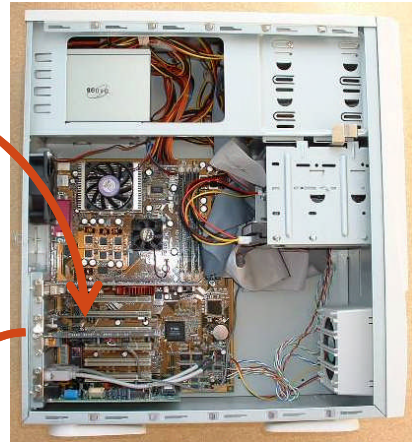
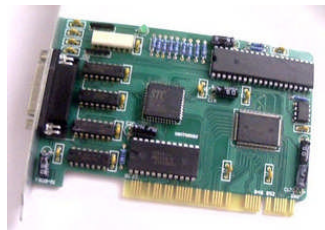
WWW.SALECNC.COM

START UP- INSTALL NCSTUDIO & INSERT CARD

1

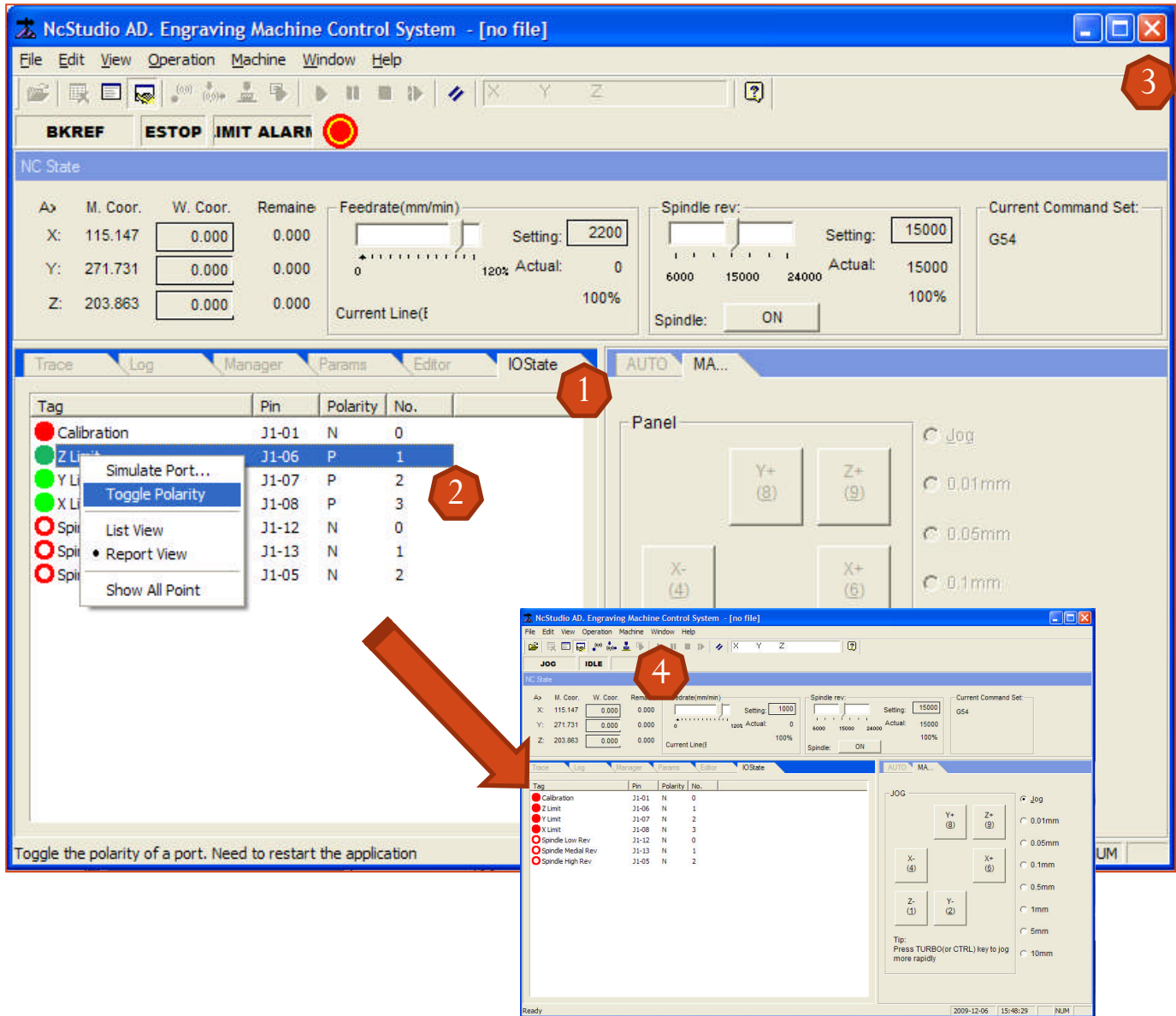


2



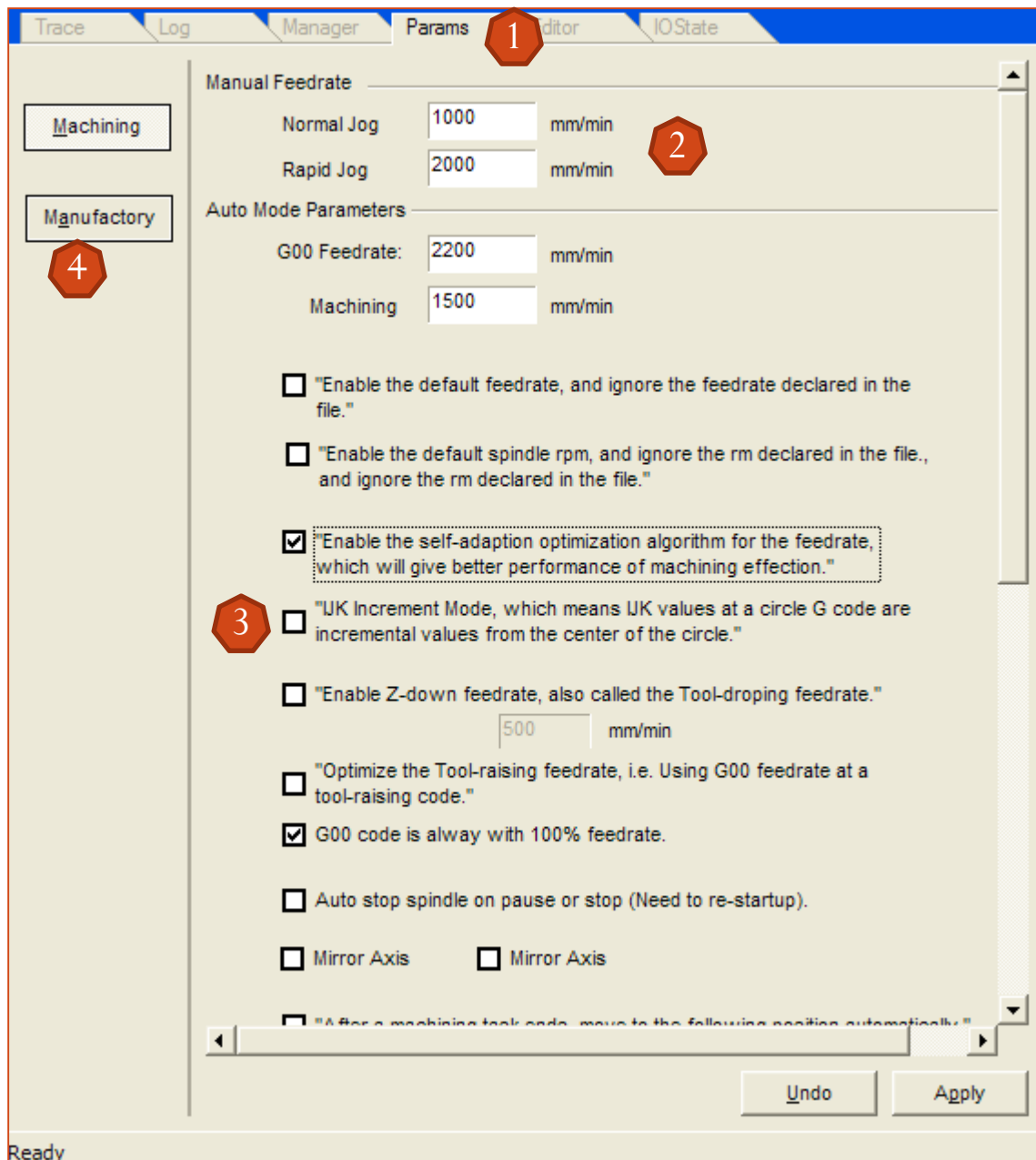
1. First install the program **NcStudio**.
2. Insert the card and find its driver in the NcStudio folder.

START UP- SET IO State



1. When start up, if the polarity of X,Y, Z limit are P, we must change to N by click **Ctrl + Shift + Alt +Right Mouse button**.
2. Change the all the Toggle Polarity for X,Y, Z limit
3. Close the program and Restart the program again. The warning sign should be off
4. Once it restarted the program, it should not be any Alarm.

START UP- SET PARAMETERS



1. Now click on the Params
2. Normal Jog and Rapid Jog can be adjust with this number.
3. If IJK are needed, this button should be unclick
4. Now click on Manufactory. The password is “**ncstudio**”.

START UP- SET PARAMETERS

Password

Please input the password to open the Manufactory Parameter Window:

Please enter a: *****

OK Cancel

Manufactory

Workbench

"Set the workbench dimensions, wh raises an out-of-limit alarm after the become effective."

Start (Mechanical) Coord.

X: 0 mm

Y: 0 mm

Z: -80 mm

Note: Please restart after changing above

Mobile Calibrator:

Thickness of the 10 mm

Motor Parameter rate of z axis:

X: 0.00625 mm/pulse

Y: 0.00625 mm/pulse

Z: 0.00625 mm/pulse

Start-up Feedrate:

300 mm/min

the maxium feedrate of z axis:

1500 mm/min

Acceleration

Set the angle-per-pulse while Y axis is a revolving axis:

Linear Acceleration: 400 mm/sec²

Connection Acceleration: 1000 mm/sec²

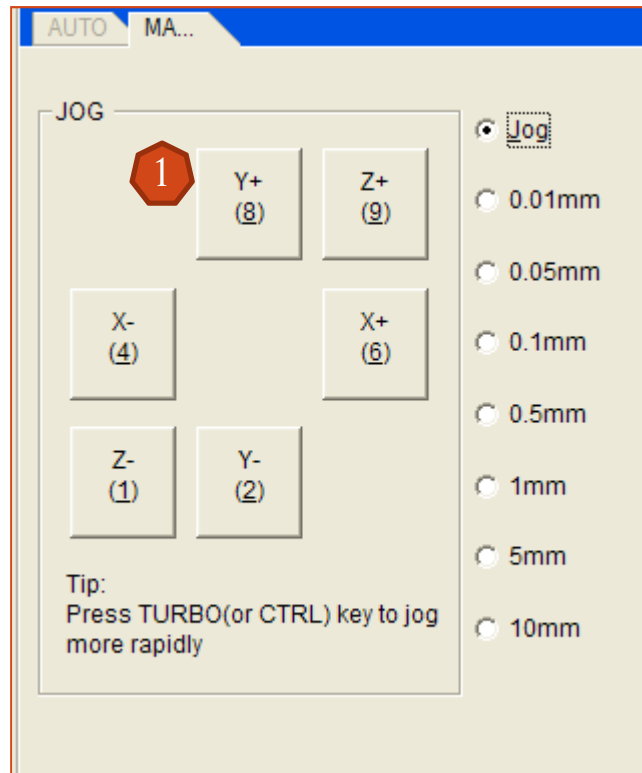
Spindle

Undo Apply

Normally, motor parameter is either **0.003125 or 0.00625** depending on machine models.

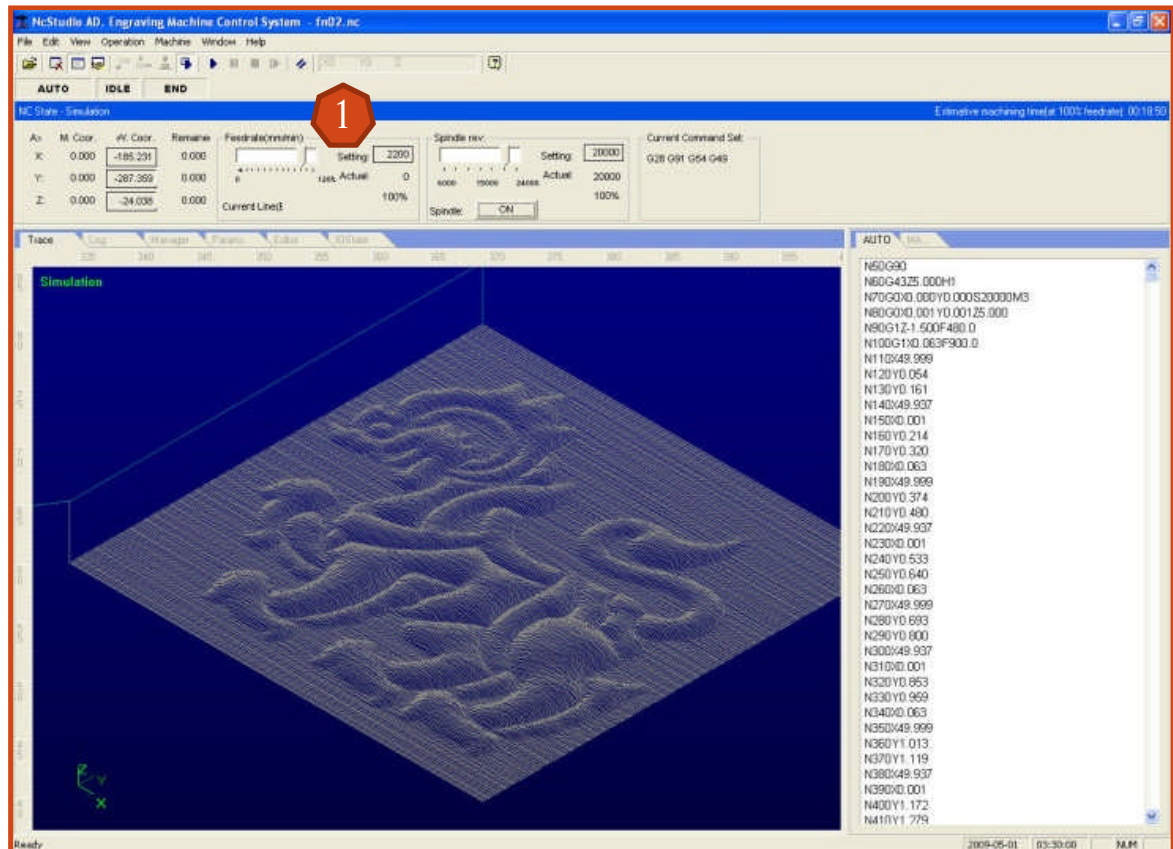
1. Once again, password is **"ncstudio"**
2. Normally, motor parameter for X,Y, Z is either 0.003125 or 0.00625 depending on machine models. We recommend you to start with 0.00625. Then test the axis for example try to move Y 100mm, if it's not right then change to .003125

START UP- TEST RUN



1. Test X,Y, Z to see if they work property or not.You can use ruler or vernier caliper to test if the machine run according to the control. If not, then readjust Manufactory Parameter.
2. Ctrl + Enter for Full Screen. Repeat will return back to the normal screen

START UP- ADVICE!



1. Always **reduce speed** to a very low before start the Auto Play. Then when everything is okay increase the speed to be normal.
2. **Simulation= F8, Start= F9, Pause=F10, Stop = F11**

For more detail please see
CNC Router Manual V4.4