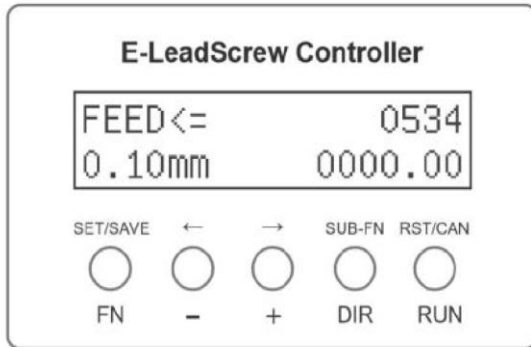


## Button Function Description



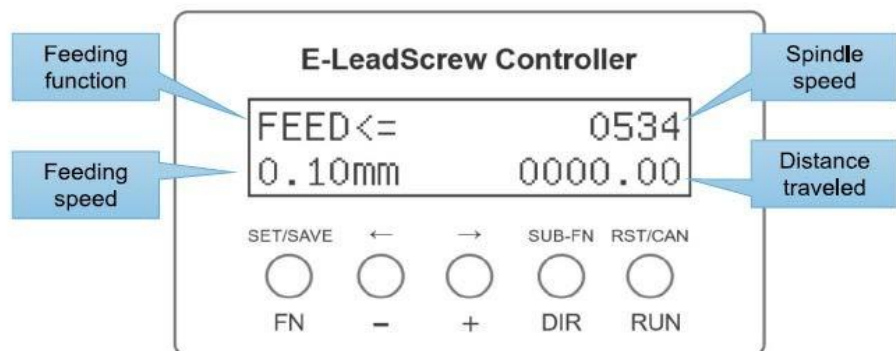
### Main function (button subscript) :

- ◆ **【FN】** : Short press to switch function ;
- ◆ **【-】** :Reduce
- ◆ **【+】** :Increase
- ◆ **【DIR】** :Direction key
- ◆ **【RUN】** :Rev. Stop button

### Sub-function (button superscript):

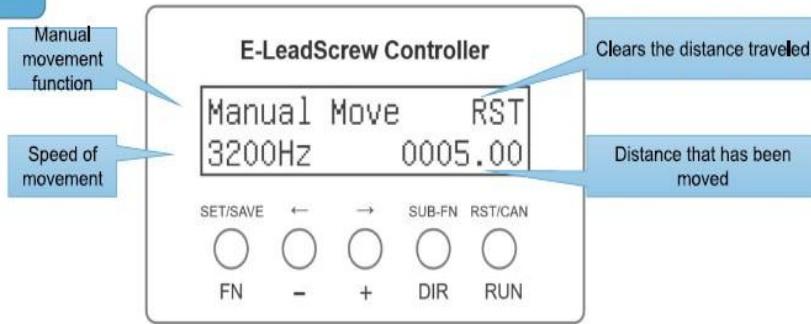
- ◆ **【SET/SAVE】** :Hold down to set or save
- ◆ **【←】** : In the manual move function, move the turning tool to the left
- ◆ **【→】** : In the manual move function, move the turning tool to the right
- ◆ **【SUB-FN】** :In some functions, used to enter a sub-function
- ◆ **【RST/CAN】** :In some situations, used to reset or cancel
- ◆ **【<=】** : Arrow indicating the feed direction
  - 【<=】** : The feed direction of the tool is close to the chuck
  - 【>=】** :The feed direction of the tool is far away from the chuck

## Feeding function



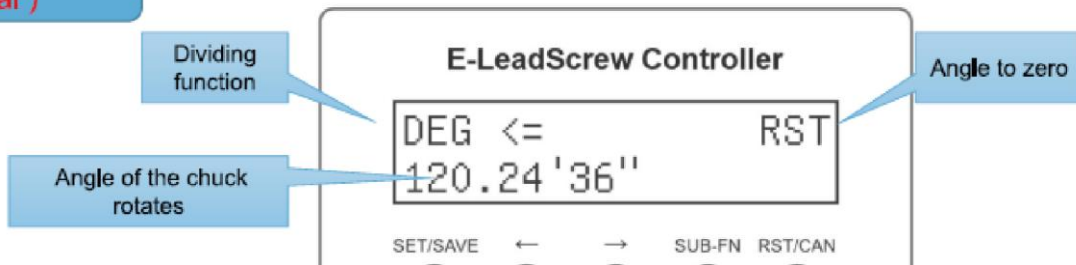
- ◆ **【-】 【+】** : Adjust the cutting speed ;
- ◆ **【DIR】** : Click to switch the direction of turning tool ;
- ◆ **【RUN】** : Short press to start and stop moving knife
- ◆ Long press the [SUB-FN] key to switch the function to the cutter mode or the winding mode
- ◆ Long press the key [RST/CAN] to clear the moving distance

## Manual movement function



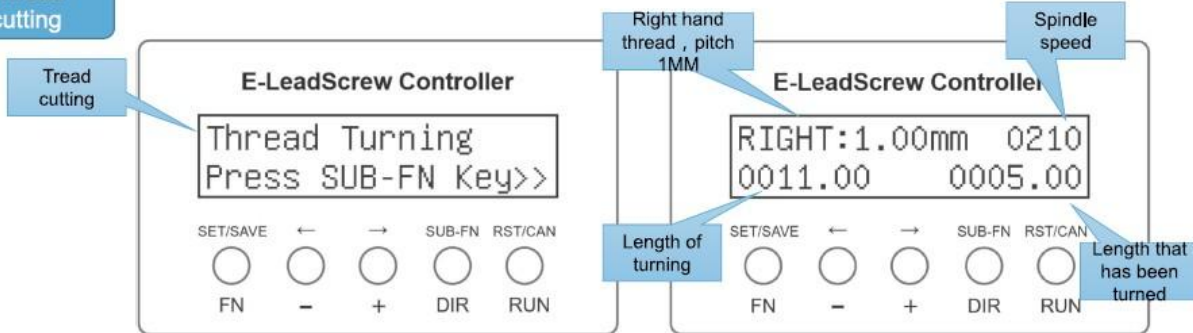
- ◆ 【←】 【→】 Move the turning tool to the left and right ;
- ◆ Short Press the [SUB-FN] key to switch the moving speed, 400-9600Hz/SEC ; The speed is set in cycles The higher the frequency, the faster the feed speed.
- ◆ Short Press the key [RST/CAN] to clear the moving distance

## Dividing function ( optional )

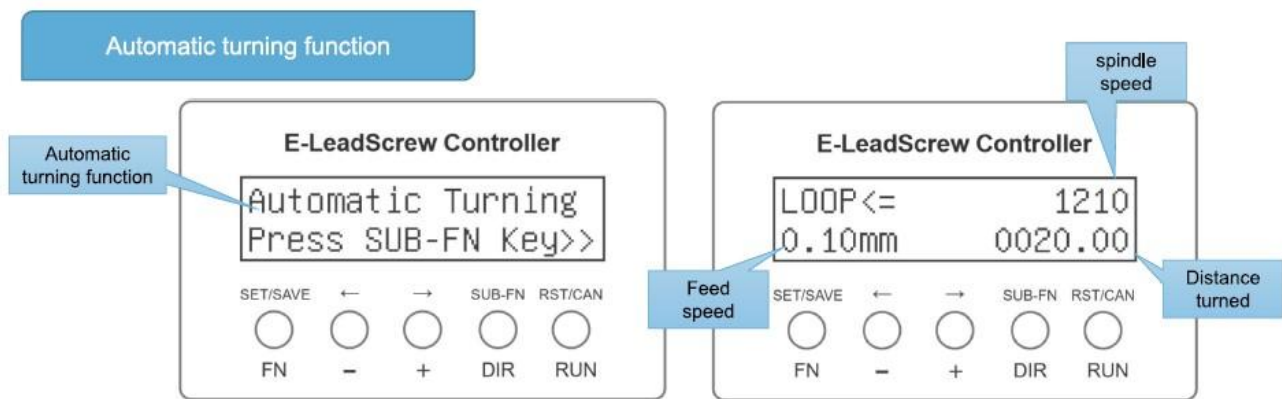


- ◆ Short Press the [DIR] key to switch the Angle direction
- ◆ Short Press the key [RST/CAN] to clear the Angle to zero

## Thread cutting



- ◆ Short Press the [SUB-FN] key to enter the parameter setting of the screw thread function :
- ◆ [Thread Standard] : Thread system, metric system, British system, arbitrary [Thread Size]: Thread size
- ◆ [Thread Length]: Length of thread
- ◆ [Thread Direction]: Thread direction, left screw, right screw
- ◆ [Start up Mode] : Start turning mode: manual start, automatic start, delay automatic start
- ◆ [Backing Mode]: The way of turning tool back to the starting point: manual button back, automatic back, delay automatic back
- ◆ [Delay Times (Sec)] : Delay time. This parameter is valid only when you select the delay mode ;
- ◆ After setting, long press the [FN] key to save the setting and start turning threads ;
- ◆ Start spindle rotation, short press [RUN] key, start turning ;
- ◆ When turning is finished, prompt [Back Cutter], please exit the tool, and then press [RUN] key, the tool will automatically return to the starting point ;
- ◆ When the Cutter returns to the starting point, prompt [Feed Cutter], enter the cutter, then press [RUN] to start the second cutter, and so on.



- ◆ Short Press the [SUB-FN] key to enter the parameter setting of the round-trip turning function
- ◆ [When Finished] : When the turning tool reaches the end point, whether to stop or return
- ◆ [Thread Length]:Length of thread
- ◆ After setting, long press the [FN] key to save the setting and start round-trip turning ;
- ◆ Adjust the tool moving speed consistent with the tool moving function ◆ Short Press the [FN] key to exit the round-trip turning function and return to the automatic tool walking function

## System Setting

### Headstock and Driving Assembly

- ◆ Long press the [SET/SAVE] key to enter the system setting ;
- ◆ [Encoder Pulses]: The pulse number of the encoder for each turn of the spindle ;
- ◆ 【Step Motor Pulses】: The number of subdivision pulses of the step driver ;
- ◆ 【Lead Screw】 : Screw pitch, the distance that the turning tool moves in each turn of the stepper motor
- ◆ 【Limited Switch 01】 : Action after the trigger of limit switch 01: Turning tool stop or return
- ◆ 【Limited Switch 02】 : Action after the trigger of limit switch 02: turning tool stop or return
- ◆ 【Z-Moving Frequency】 : When moving function, how fast the tool moves;
- ◆ 【Key Sound】 : Key sound switch
- ◆ 【Feed ACCEL】 :Starting acceleration of turning tool with tool moving function ;
- ◆ 【Limit Feeding Speed】 : Safe range of tool going, after enabled, the tool going value will be limited between 0.01~0.4mm, to prevent users from setting the tool going speed too large by mistake;
- ◆ 【Start Motor by Def】 : After the controller is started, whether the stepper motor starts by default; ◆ 【FN:FEED】 : Enable/disable the automatic tool walking function;
- ◆ 【FN:MOVE】 :Enable/disable the mobile function.
- ◆ 【FN: Manual Moving】 : Enable/disable the manual movement function.
- ◆ 【FN: Index Plate】 :Enable/disable the indexing function;
- ◆ 【FN: Gear Shaping】 :Enable/disable the gear shaping function;
- ◆ 【FN: Thread Turning】 : Enable/disable the screw thread function;
- ◆ 【FN :Auto Turning】 :Enable/disable round trip turning function;
- ◆ SHORT Press the [RST/CAN] key to cancel the setting and exit the setting interface
- ◆ LONG Press the [SET/SAVE] key to save the setting and exit the setting interface