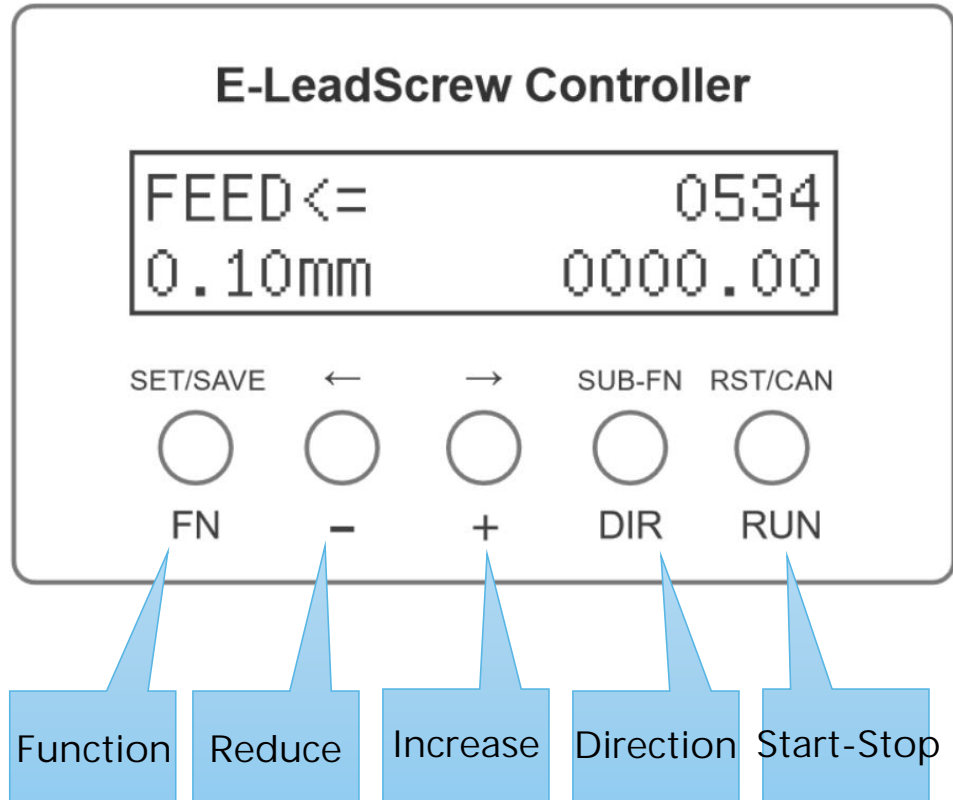


Button



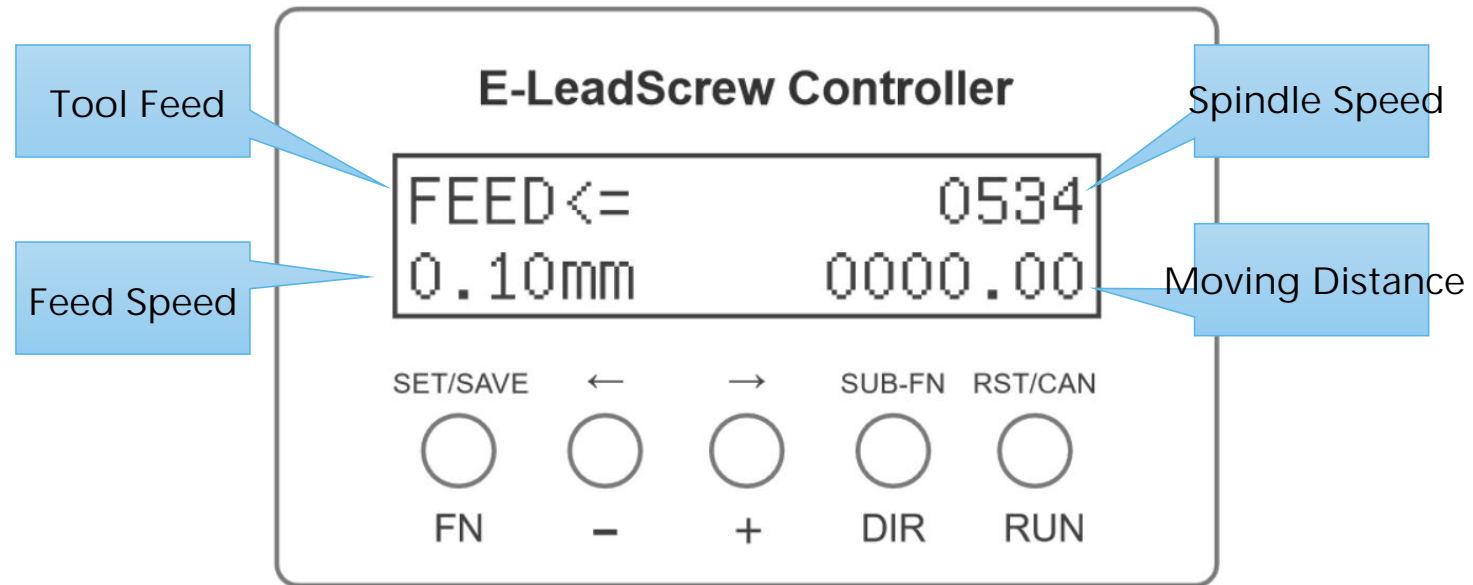
Explanation of name below button:

- ◆ **【FN】** : Function, Switching function by short press.
- ◆ **【-】** : Reduce
- ◆ **【+】** : Increase
- ◆ **【DIR】** : Direction
- ◆ **【RUN】** : Start-Stop

Explanation of name above button:

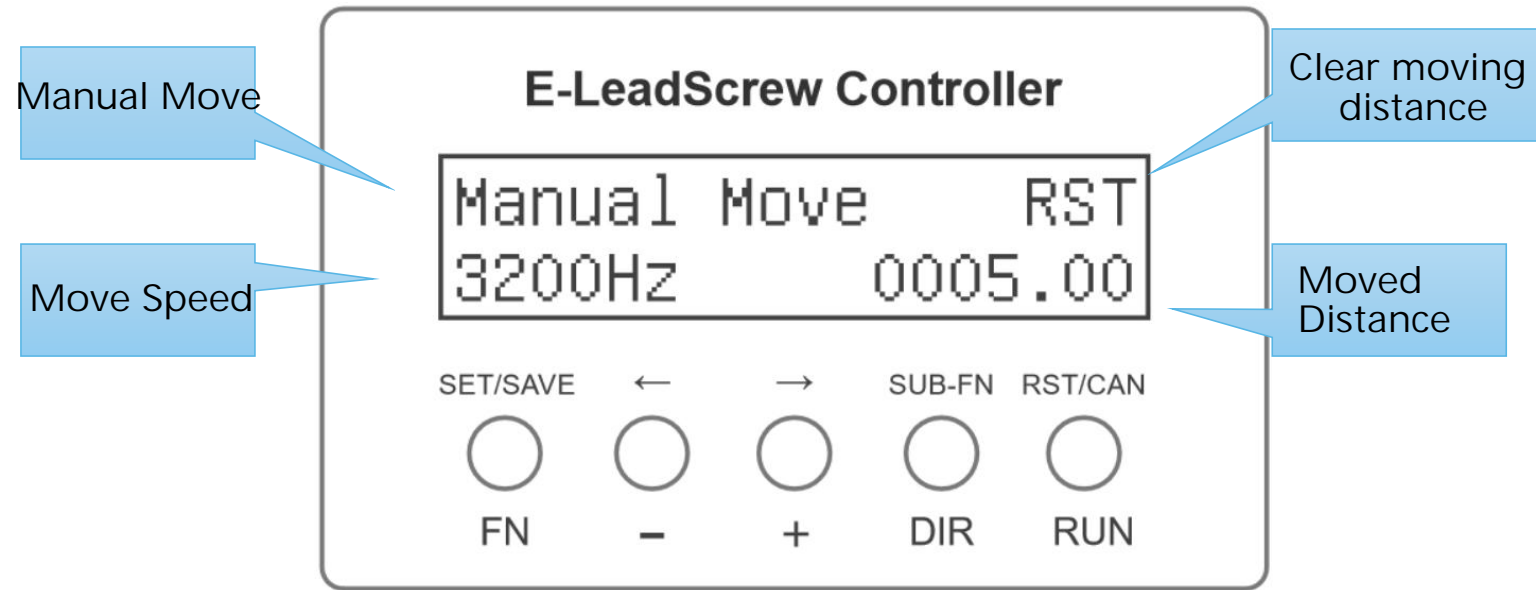
- ◆ **【SET/SAVE】** : Long Press to (set) or (save) system
- ◆ **【←】** : In the manual movement function, move the turning tool to the left
- ◆ **【→】** : In the manual movement function, move the turning tool to the right
- ◆ **【SUB-FN】** : Enter sub functions in some functions
- ◆ **【RST/CAN】** : (reset) or (cancel) in some scene

Tool Feeding



- ◆ **[-] [+]** : Modify tool feed speed, ranges from 0.01 mm~0.40mm;
- ◆ **[DIR]** : Change tool feed direction by short press;
- ◆ **[RUN]** : Start/Stop tool feed by short press
- ◆ **[RST/CAN]** :Clear the moving distance by long press

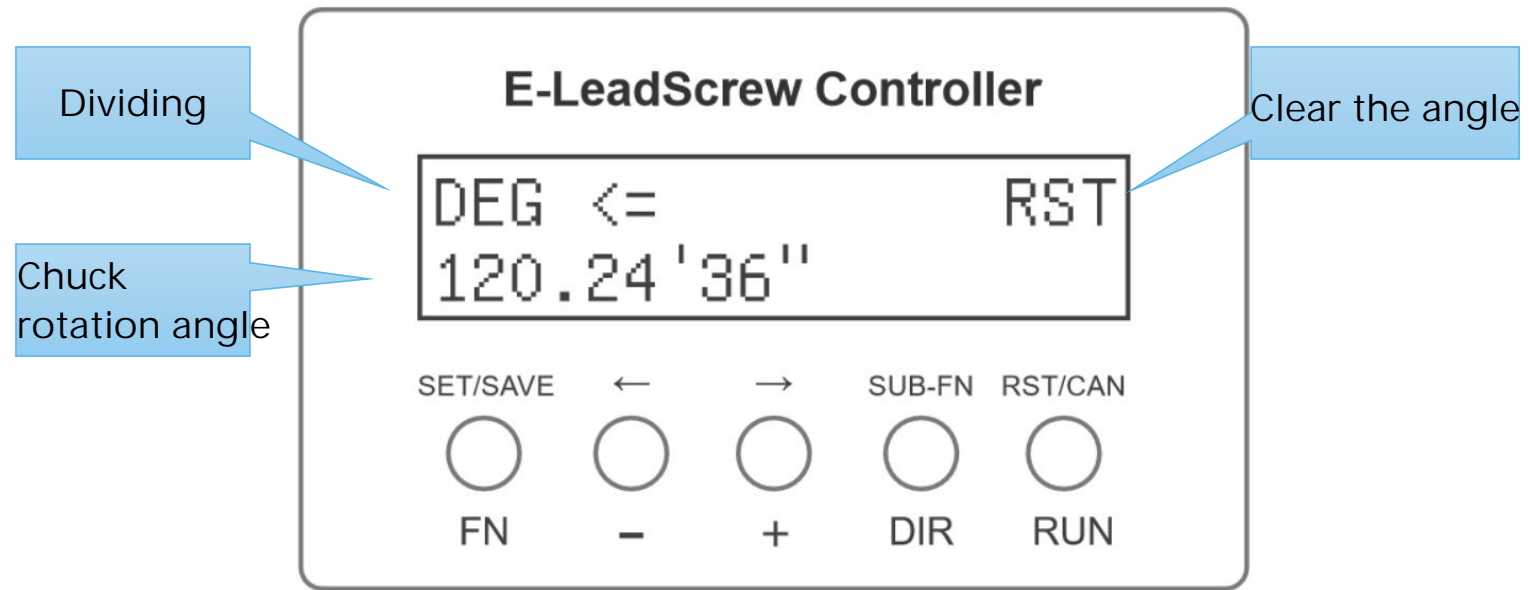
Manual Moving



- ◆ 【←】 【→】 : Move tool holder to left/right;
- ◆ Short press 【SUB-FN】 to modify move speed (ranges from 400~9600Hz/s);
- ◆ Short press 【RST/CAN】 to clear moving distance

Dividing Function

(Dividing function only suit for manual control lathe scene)

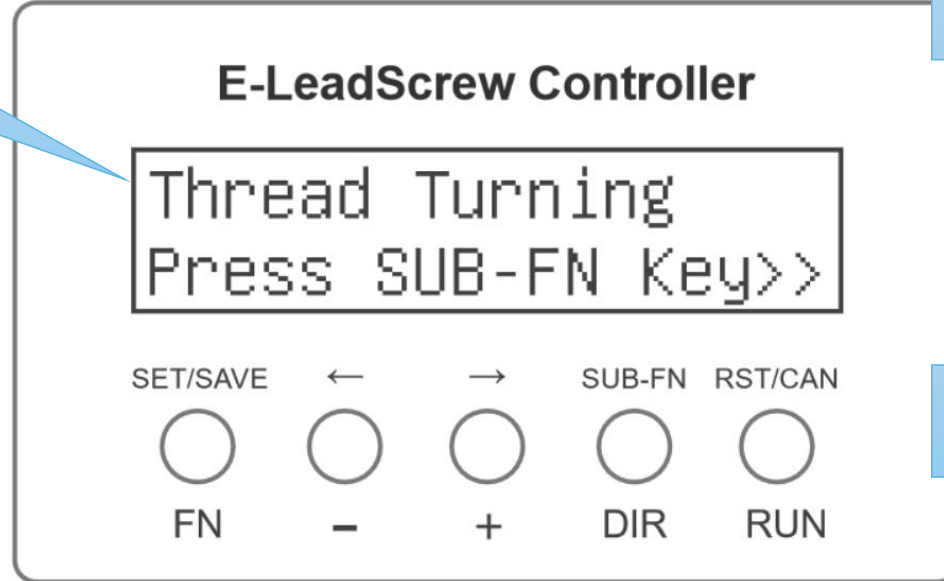


◆ Short press **【DIR】** to change angle calculate direction

◆ Short press **【RST/CAN】** to clear the angle

Make Thread

Thread Turning

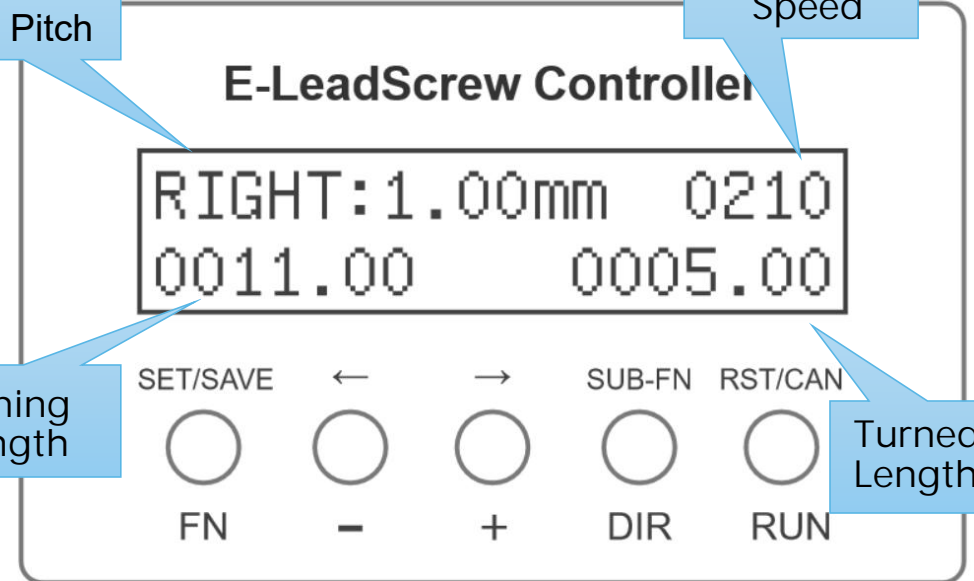


Right Thread
1MM Pitch

Spindle
Speed

Turning
Length

Turned
Length



◆ **Short press [SUB-FN]** to set the thread turning parameter:

- ◆ [Thread Standard]: metric/imperial
- ◆ [Thread Size]:
- ◆ [Thread Length]:
- ◆ [Thread Direction]: left thread/right thread
- ◆ [Start up Mode]: Manual Start,Auto Start,Delayed Auto Start
- ◆ [Backing Mode]: Turning tool returns to the starting point method: Manual Press Button,Auto Back,Delay Auto Back
- ◆ [Delay Times (Sec)]: Only valid on delay scene;

◆ **Long Press [FN]** to save all the setting parameter

◆ **Short Press [RUN]** to start working;

◆ **Machine will point out [Back Cutter]** when complete work, please turn back turning tool.

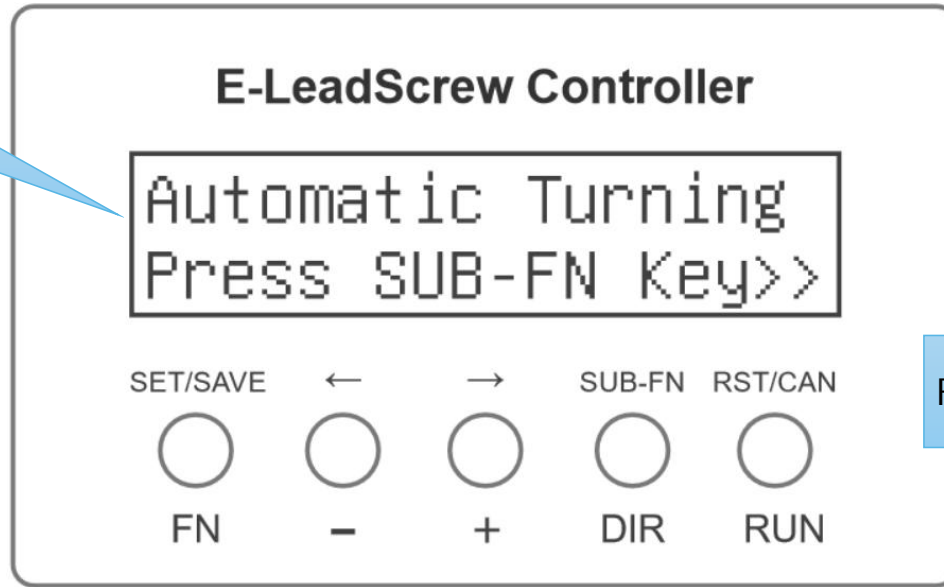
Then press **[RUN]**, tool holder will back to start point automatically;

◆ **When turning tool back to the start point, machine will point out [Feed Cutter]**, please feed turning tool then press **[RUN]** to start second time working.

◆ **After working complete, short press [FN] or long press [RST/CAN]** to quit thread making function, machine will back to feed function

Automatic Turning

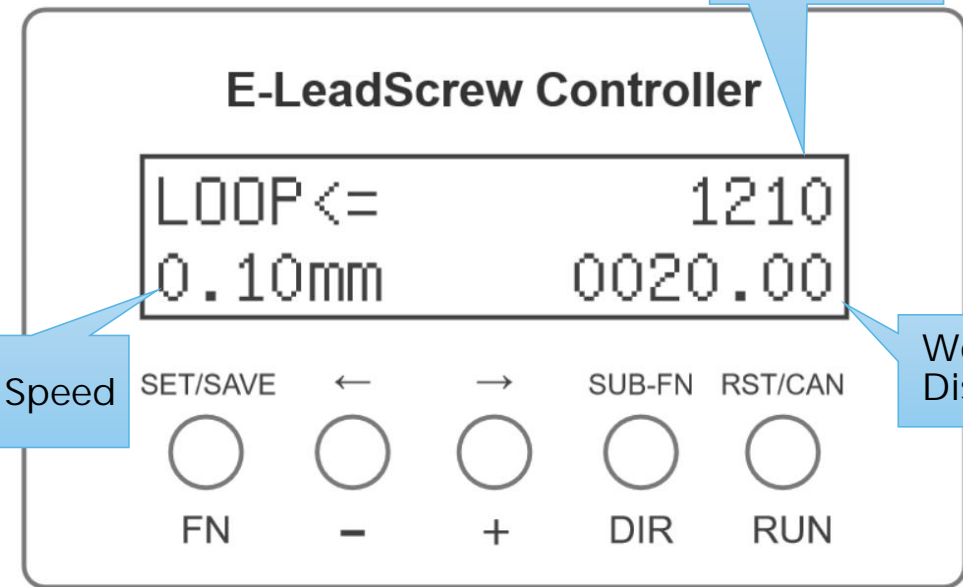
Round Trip Turning



Speed

Feed Speed

Worked Distance



- ◆ **Short Press [SUB-FN]** to select Automatic Turning
 - ◆ [Length Limited]: Round Trip Turning Length
 - ◆ [When Finished]: Stop/Back when finished
 - ◆ [Thread Length]: Thread length

- ◆ **Long Press [FN]** to save parameter;
- ◆ **Adjust the tool feeding speed to be consistent with the tool feeding function**
- ◆ **Short Press [FN]** to quit Automatic Turning function, machine will back to tool feed function.

- ◆ **Long Press 【SET/SAVE】** to enter into system setting;
- ◆ **【Encoder Pulses】** : Number of pulses of encoder per revolution of spindle;
- ◆ **【Step Motor Pulses】** : Number of subdivided pulses of stepping driver;
- ◆ **【Lead Screw】** : Screw pitch, the distance that the turning tool moves in each revolution of the stepping motor
- ◆ **【Key Sound】** : Press button sound on/off
- ◆ **【Feed ACCEL】** : Turning tool starting acceleration of tool feeding function;
- ◆ **【Limit FeedingSpeed】** : The safe range of tool feed. The tool travel value will be limited to 0.01 ~ 0.4mm when enabled to prevent the user from setting the tool speed too high by mistake.
 - ◆ **【Start Motor by Def】** : Whether the stepping motor starts by default after the controller is started
- ◆ **Short press 【RST/CAN】** to cancel settings and quit setting page
- ◆ **Long press 【SET/SAVE】** to save settings and quit setting page