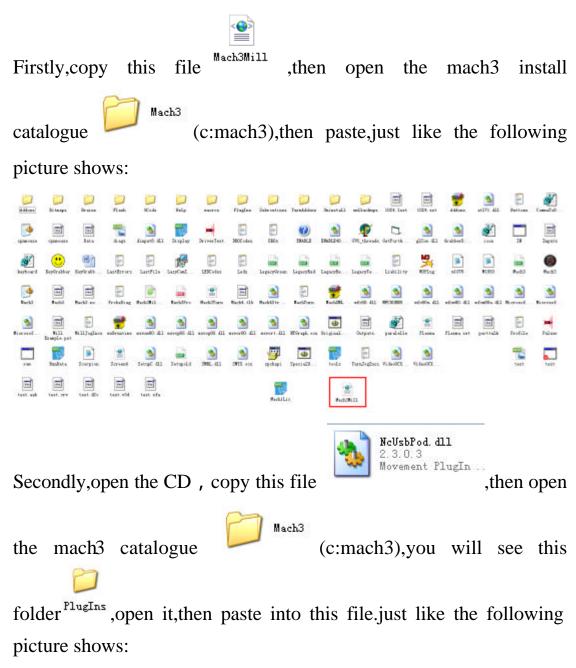
Mach3 Manual

When you install the mach3 software, don't open it immediately.





Thirdly, connecting the data wire, open the power, double click this



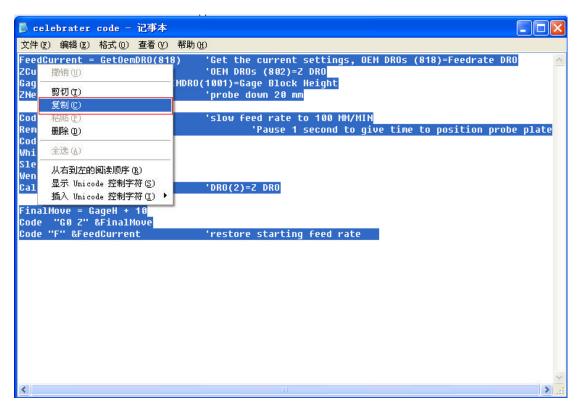
Then next step is set the calibrater

Firstly, open	the CD,check this file	celebrater code MIS 文件 1 KB ,then open it by
	 推荐的程序: 记事本 其它程序: ACDSee Adobe Reader AutoCAD Application Autodesk DWF Application CAXA DRAFT 2013 File Foxmail 7.2 Internet Explorer 	
the notepad	JDPaint	then you will

	🖹 celebrater cede - 2004	
	文件(2) 編構(2) 接式(2) 遊客(2) 稀助	8 (Q)
	FeedCurrent - GetOemDRO(818) 2Current - GetOemOro(802) GageH - GetOEMDRO(1001) *OEMBR 2New - 2Current - 100	'Get the current settings, OEH BR0s (010)-Feedrate 000 'OEH DROS (002)-2 DRO DG(1001)-Gage Black Weight 'probe down 20 mm
	Code "6905200" Hem Sode "54 P1" Code "621 2" 62New White 15Newing() Slump(10) Wend	'slow feed rate to 100 MM/HIH 'Pause 1 second to give time to position probe plate
	Gall SetBro (2,GageH) FinalNove - GageH + 10	*DA0(2)=2 DAD
	Code "60 2" SFinalHove Code "F" AFeedCurrent	'restore starting feed rate
coc		

copy this code, like the following picture shows

see



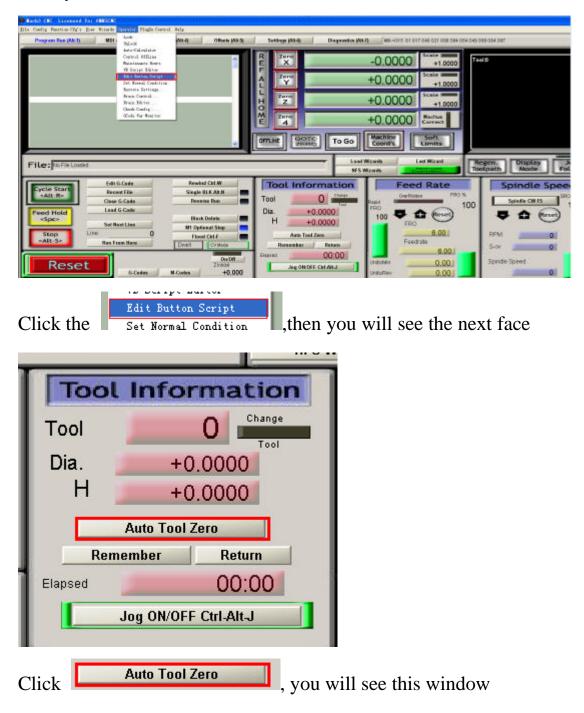
Secondly ,open mach3 software

1	
	+0.0000
let let berg code Rester Conw	III'S Wrisels TERRINA TOOLDSCH. Model Fr
Second Hould S	
Down Colora	Analytic Alexandre Contraction (Contraction

Chik the operater in the top of the mach3

		C Licensed				p.	
<u>F</u> ile	Config	Function Cfg's	<u>V</u> iew	Wizards	Operator	PlugIn Control	Help

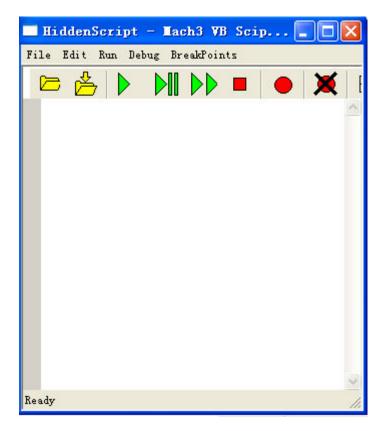
Then you will see this face



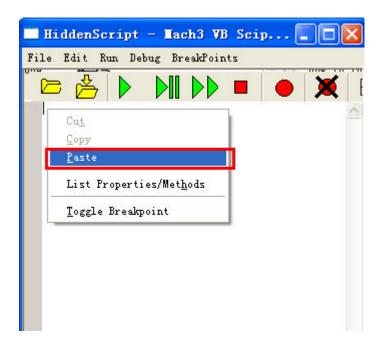
HiddenScript - Mach3 V	78 Scip	×
File Edit Run Debug BreakPoi	ints	
Message("Not Yet Impl		1
nessage(Not fet impi	.emented)	_
		2
Ready		11.

Just delete the word Message("Not Yet Implemented") ,when you

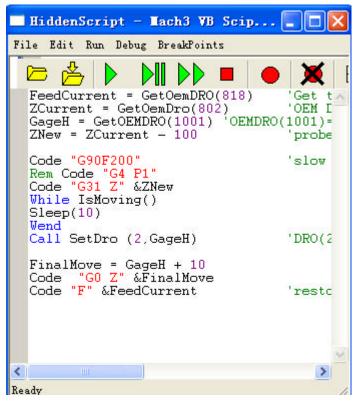
delete them you will see the following part



Then paste the word we copied before



The following picture is the copied file



When you copied this just save it, like the following picture shows.

HiddenScri	pt - Mach3 VB Scip		
File Edit Run	Debug BreakPoints		
Open File		N	
Save	= GetOemDRO(818)	'Get to	
Save As	GetOemDro(802)	'OEM I	
Close File Options	OEMDRO(1001) 'OEMDR rent - 100	0(1001)= 'probe	
Code "G90F Rem Code " Code "G31 While IsMo Sleep(10) Wend Call SetDr	G4 P1" Z" &ZNew	'slow 'DRO(2	
Code "GO	= GageH + 10 Z" &FinalMove FeedCurrent	'restc	
<		>	
Save Sript File		,wher	n you save this

close this window.



,just

Click the Reset button once

Or, you can restart the mach3.

The next step is we use the calibrater to setting the tool.

Let the Z axis down some distance ,put the calibrater under the tool .then click this button Auto Tool Zero then the Z axis will go down automatically.when the tool just touch the calibrater like the following picture shows



,it will go up 10mm automatically.

Then go to this face

Die Coulis Pasitire Lig's five Rivershi Sperator	Digits formed this				
Program Raw (MILT) MDI (MILZ)	Tool Peth (Mi-0	Offices (MI-B) Settings (MI-B)	Disgnowikes (AA -7) 1411	-015 D1 017 048 001 080 084 084 04	3 059 054 057
Gage Block Height	Current	Work Offset	Active Work Offset	R 20m	-0.0000
+12.0000 Set Z		+11,9796	054		+0.0000
- V	ŤY	+61.8460	Fixture 1 (556) Fixture 2 (555)		+0.0000
¥	Z	-76.4100	Fixture 3 (656) Frature 8 (657)	H Zero A	+0.0000
	4	+0.0000	Fixture 5 (559) Fixture 8 (559)	E E	chine Coord's
	Select Edge F	inder Location	G	age Block Height	Tool Information
(Select)	Center It Indicating	(Select HELP - War	Offsets	+12.0000 Set Tool	HELP - Tool Offsets
	A CISM	Edge Find		-	Tool Offset On/Off
	10 B	Provide State Stat	0000	a	Tool 0
	~ ~			-	Z Offset 0.000
Select	x	Select			Diameter 0.000
			Save	Offset Tables Here	to Make Them Permanent
Reset	oden M Ceden	ang ON OFF	siasu 👔 🧾	ave Work Offsets	Save Tool Offsets
Heav Our Status:			Profi	le:Mach3MM	
					0

Set Gage Block Height 12,then clik



,back to this face

	R Zero	-0.0000	Tast0
· · · · · · · · · · · · · · · · · · ·	F X	-0.0000 +1.000	
		+0.0000 +1.0000	
	L Zara	+12.0000 +1.0000	
	M Zaro	+0.0000 Contest	
		(Wathke)	
	OFTLHE GENTE TO GO	Coord's Unnits	
le: Ja Fielzadet		Winanda Lest Winest	Resen. Display Jos Toolpath Mode Police
Lefe Start Revise Call	Tool Information	Feed Rate	Spindle Speed
Alt-R- Close G-Cole Revenue Ran	Tool O	Tapo FRO %	O Splaste CW 75 10
eed Hold Losd G Cade #Spc.# Block Dates	Dia. +0.0000	100 🗣 🏠 (Renarc)	₽ ☆ "
Stop Life 0 Paul Cals	H +0.0000	FR0 6.00	RFM 0
+Alt-S> Run Franc Here Dwell CV Mice	Fananber Return	Pestrals	S-0Y 0
Reset	Exerce 00:00	0.00 0.00	Spindle Speed
Reset	Joy ON OFF CNIAR J	Unitatives 0.00	
Glades Blades +0,000			

The Z axis 's coordinate becomes 12.0000,the autotool setting is finished.