

Mach3 Manual

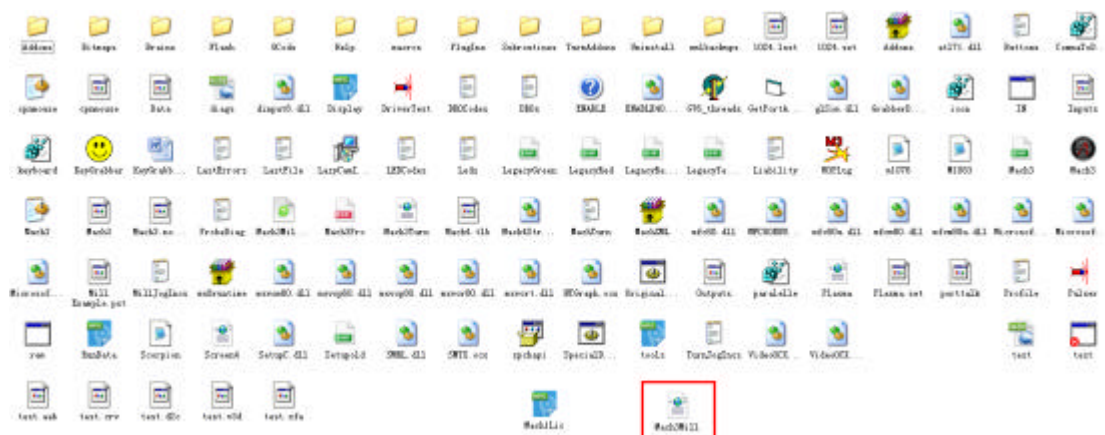
When you install the mach3 software,don't open it immediately.



Firstly,copy this file **Mach3Mill** ,then open the mach3 install



catalogue **Mach3** (c:mach3),then paste,just like the following picture shows:



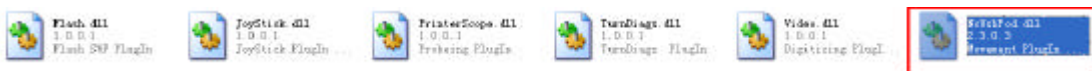
Secondly,open the CD , copy this file ,then open



the mach3 catalogue **Mach3** (c:mach3),you will see this



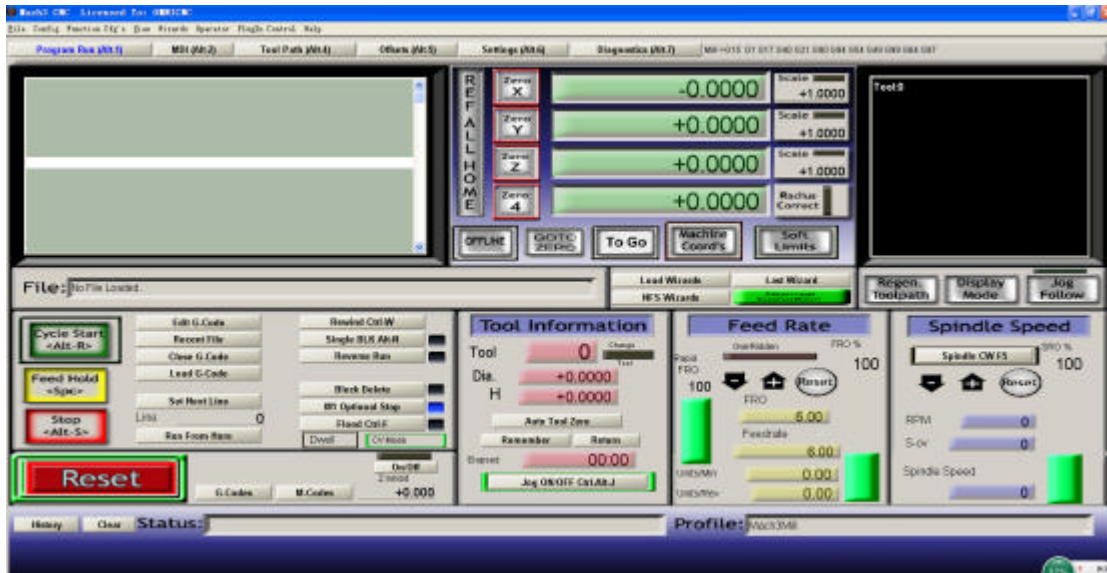
folder **PlugIns** ,open it,then paste into this file.just like the following picture shows:



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



icon then mach3 software will open



Then next step is set the calibrater



celebrater code
MIS 文件
1 KB

Firstly, open the CD,check this file ,then open it by



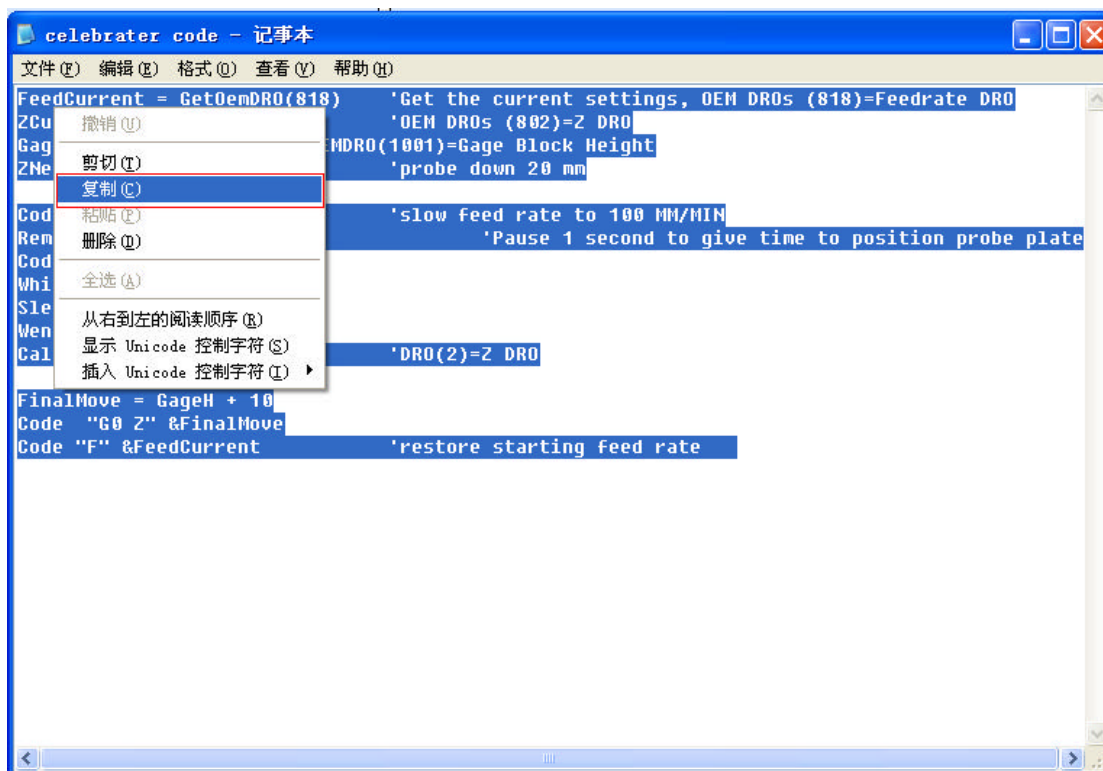
the notepad

then you will

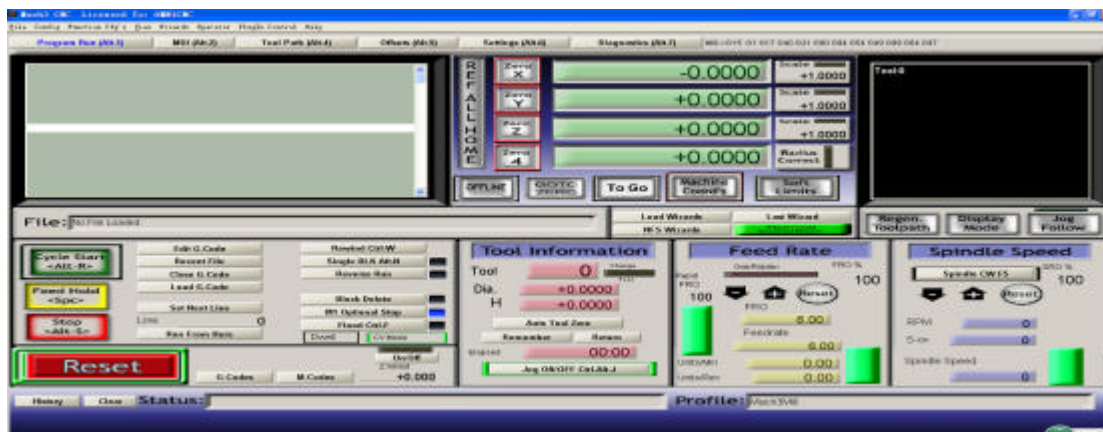
```
celebrater code - 记事本
文件(F) 编辑(E) 格式(O) 查看(V) 帮助(H)
FeedCurrent = GetOemDRO(818) 'Get the current settings, OEM DROs (818)=Feedrate DRO
ZCurrent = GetOemDRO(802) 'OEM DROs (802)=Z DRO
GageH = GetOemDRO(1001) 'OEM DROs (1001)=Gage Block Height
ZNew = ZCurrent - 100 'probe down 20 mm

Code "G90 Z0" 'slow feed rate to 100 MM/MIN
Rem Code "G4 P1" 'Pause 1 second to give time to position probe plate
Code "G21 Z" &ZNew
While 1:Showing()
Sleep(10)
Wend
Call SetDro (Z,GageH) 'DRO(2)=Z DRO
FinalMove = GageH + 10
Code "G0 Z" &FinalMove
Code "F" &FeedCurrent 'restore starting feed rate
```

see this code ,just
copy this code,like the following picture shows



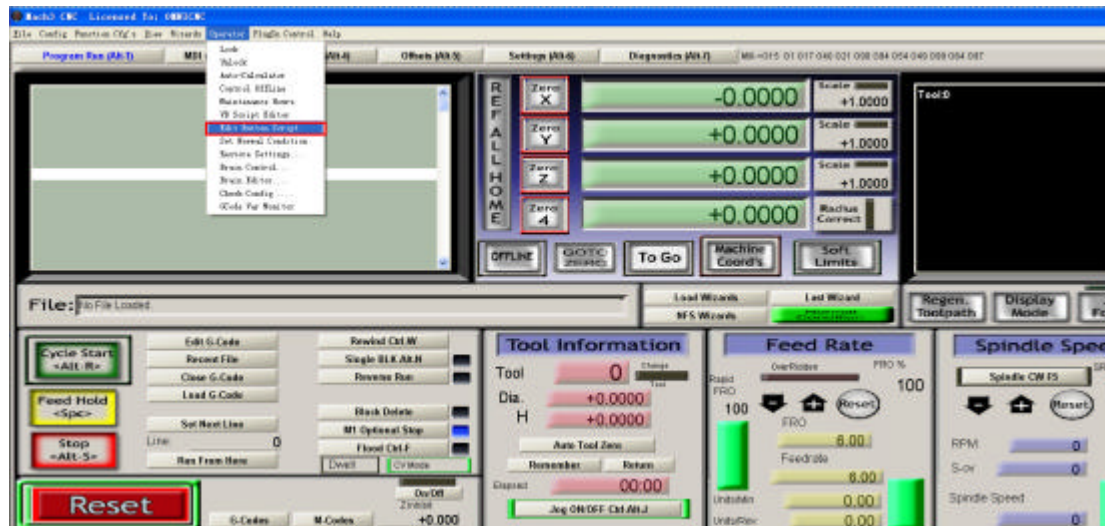
Secondly ,open mach3 software



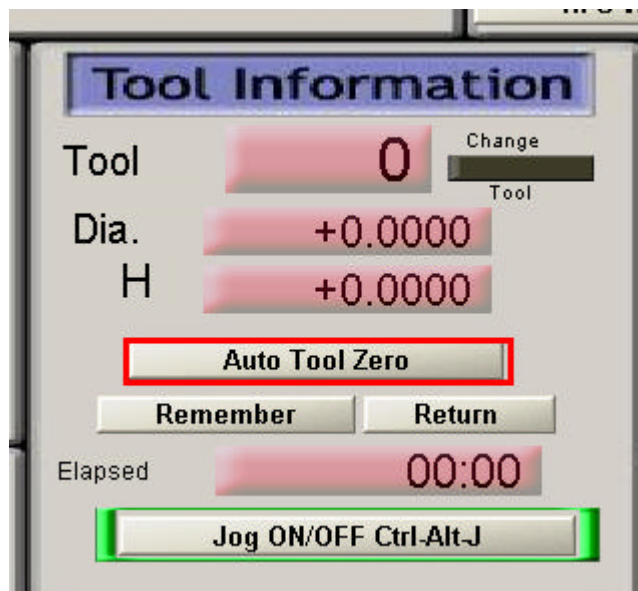
Chik the operator in the top of the mach3



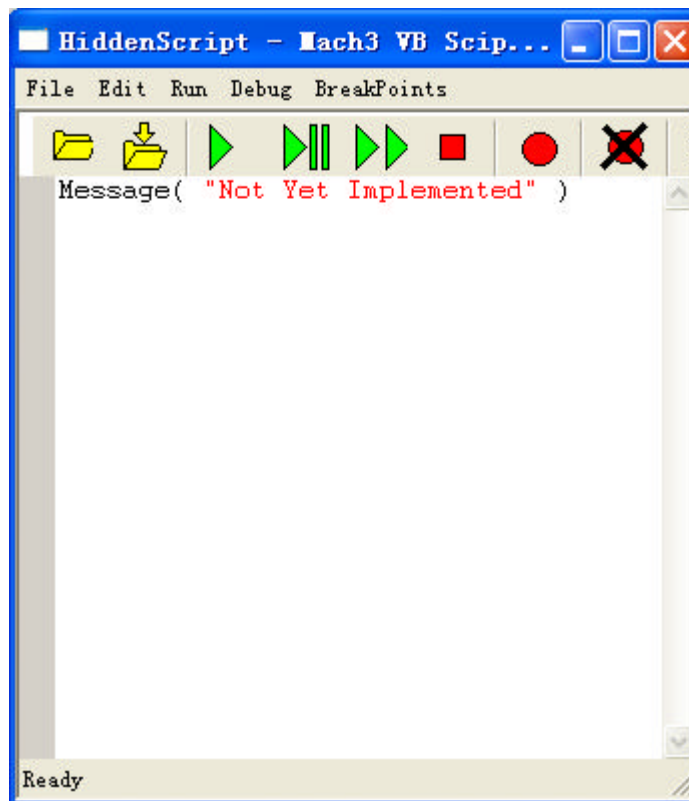
Then you will see this face



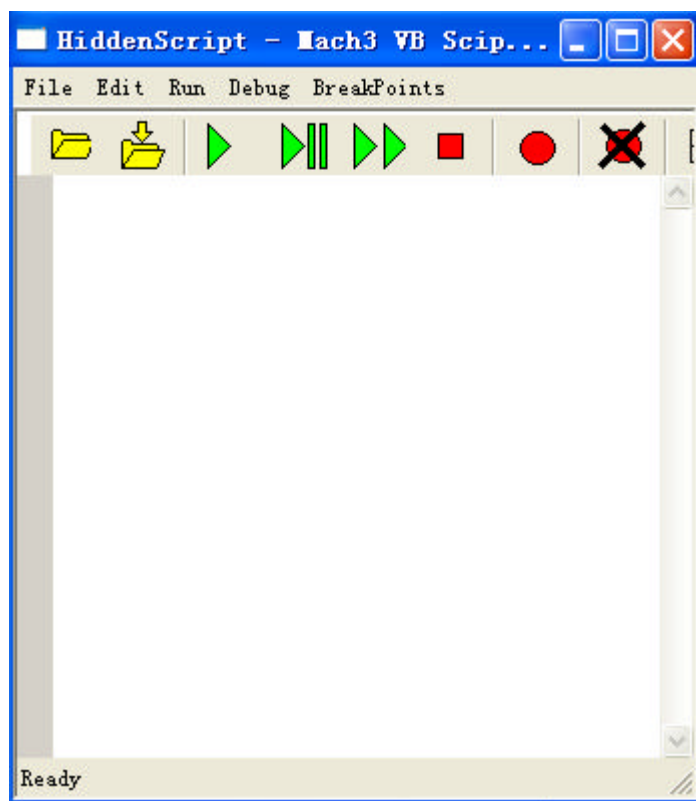
Click the **Edit Button Script**, then you will see the next face



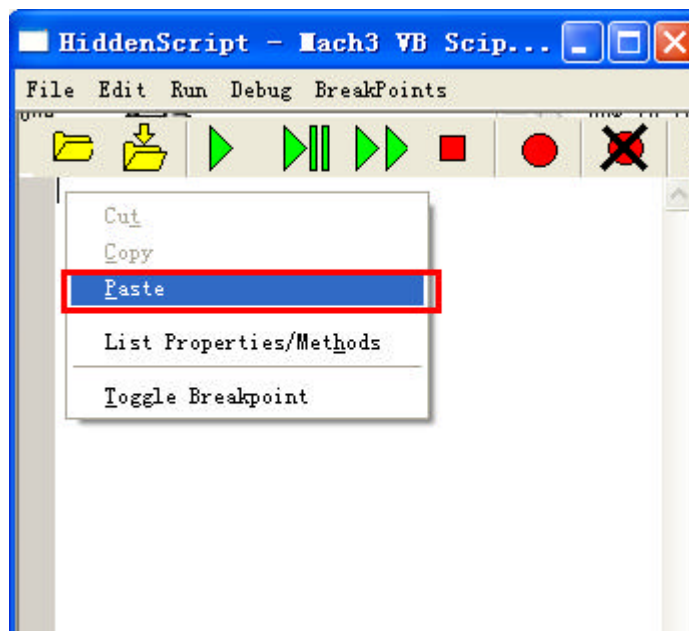
Click **Auto Tool Zero**, you will see this window



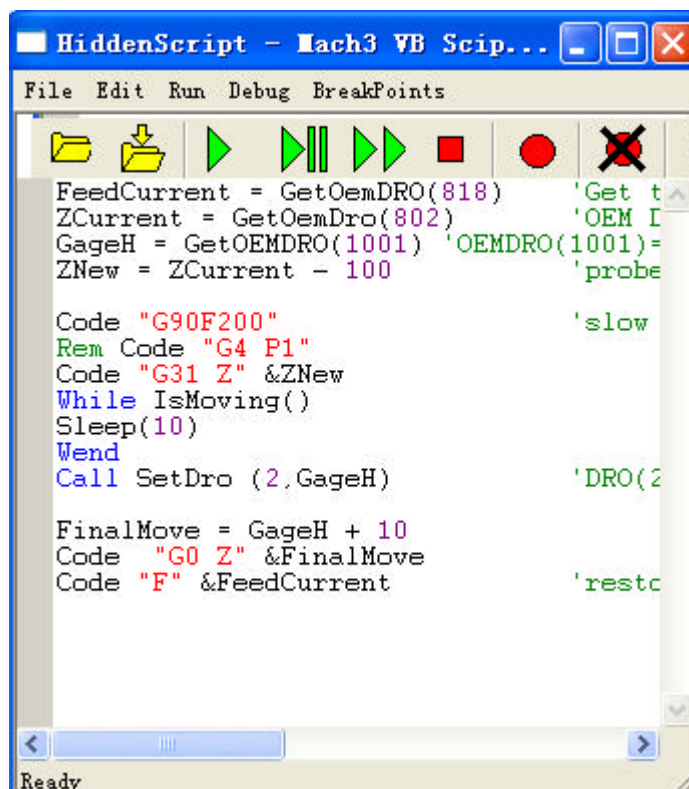
Just delete the word `Message("Not Yet Implemented")` ,when you delete them you will see the following part



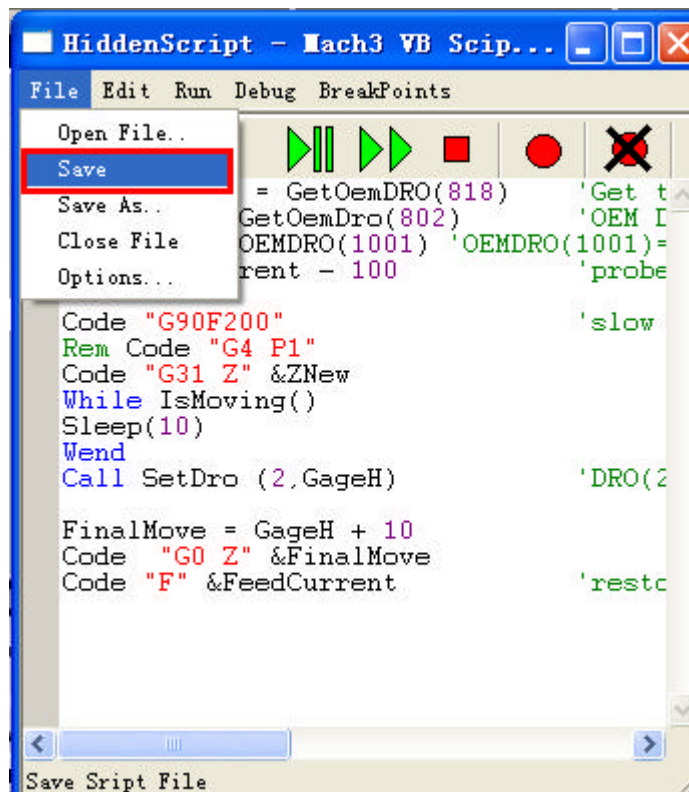
Then paste the word we copied before



The following picture is the copied file



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



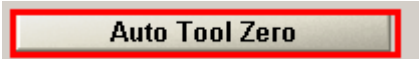
,when you save this ,just close this window.



Click the Reset button once

Or,you can restart the mach3.

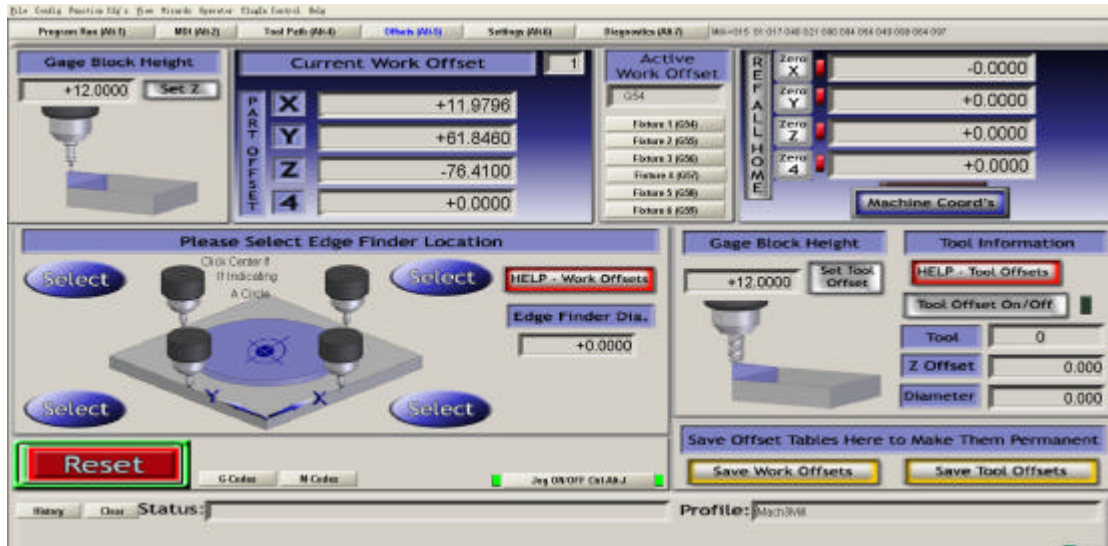
The next step is we use the calibrater to setting the tool.

Let the Z axis down some distance ,put the calibrater under the tool .then click this button  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.

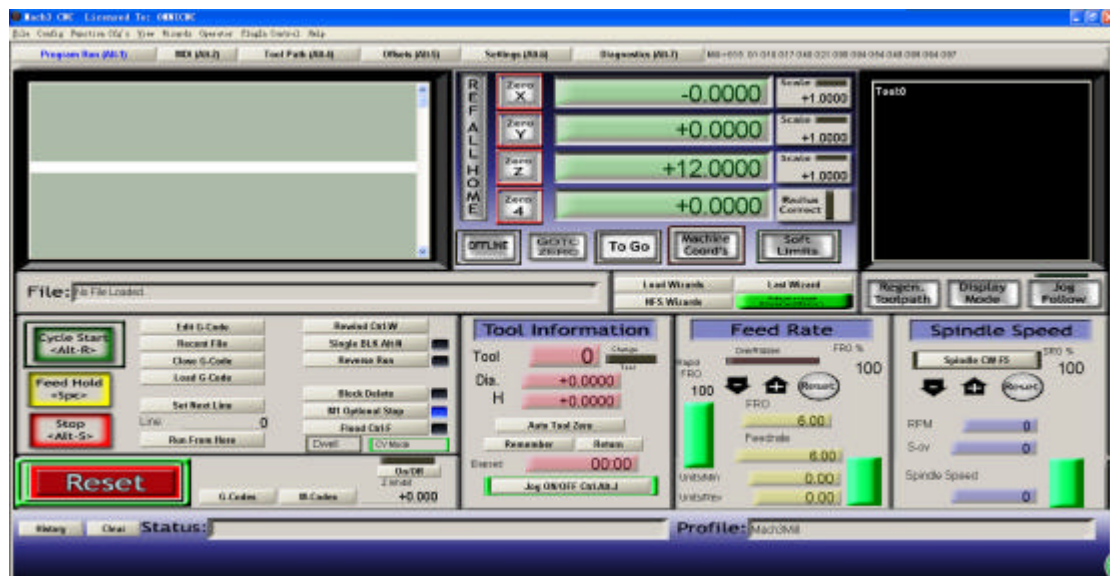
Then go to this face



Set Gage Block Height 12,then click



,back to this face



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