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DIGITAL READOUTS

Operation Manual

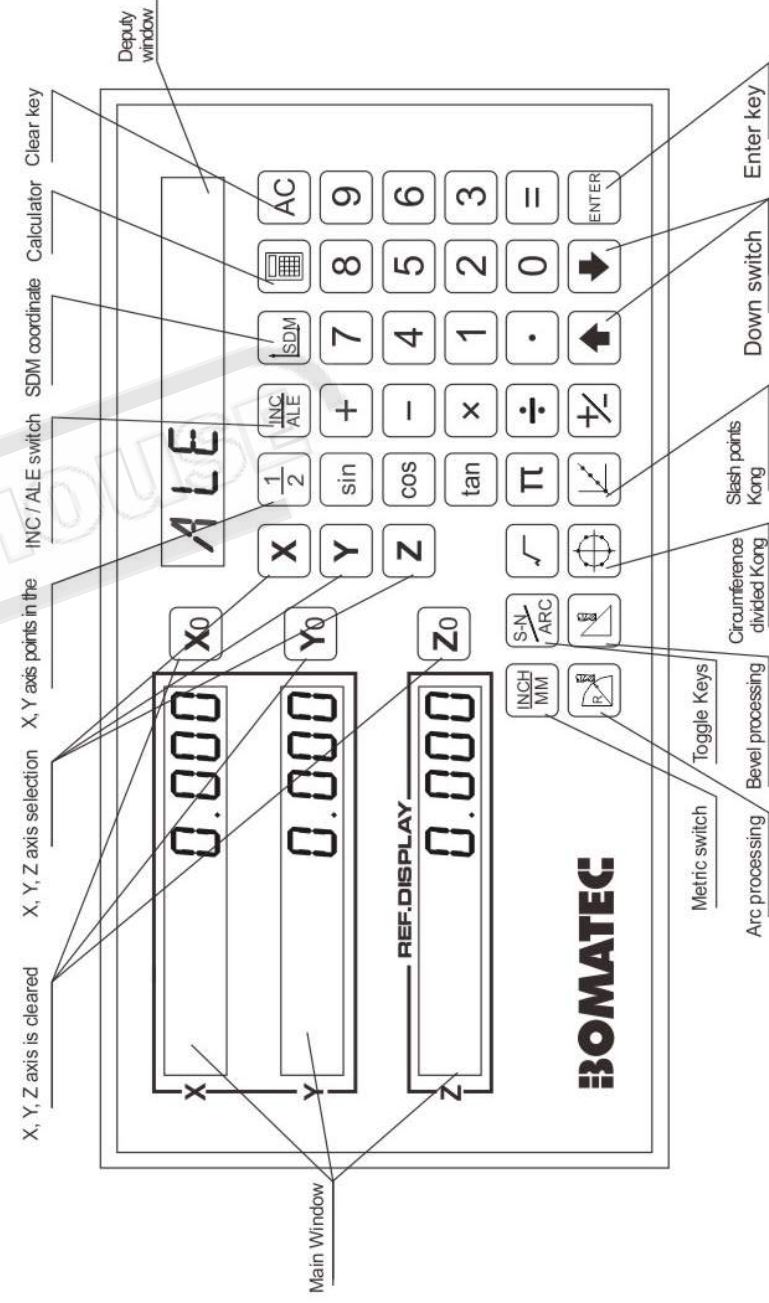
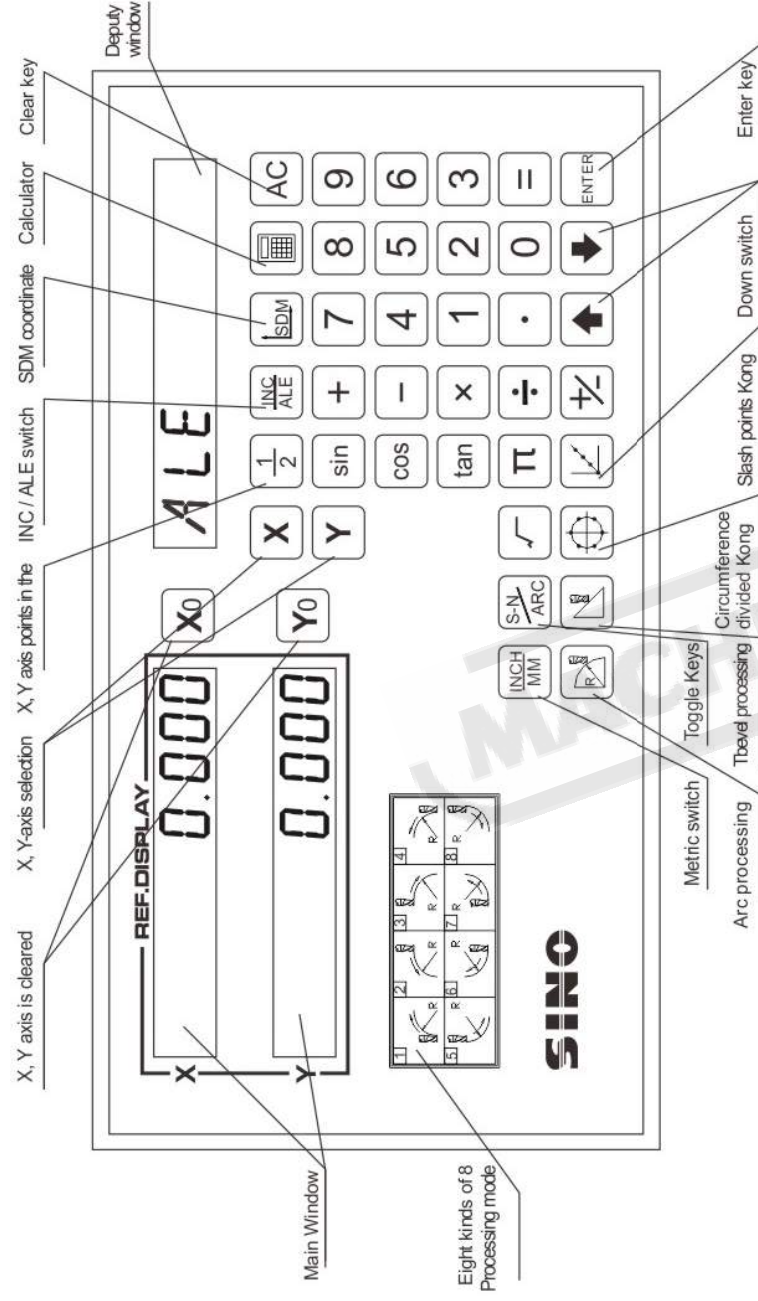
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Chapter 1. INTRODUCTION



1.3 Description of Key Function

XH USER'S MANUAL

	KEY MARK	KEY NAME	FUNCTION	WE6800-2	WE6800-3	WE6800-E
1		X/Y/Z-Zero	Zero selected axis.	No		
2		Axis Selection	Select axis to operate.	No		
3		Inch/Metric Switch	Toggle display unit between metric and inch.			
4		Center Finding	Half a display value of an axis.			
5		ALE/IINC Switch	Toggle between ALE/INC coordinate.			
6		RI Finding	Find the origin of the linear scale.			
7		Shrinkage	Toggle between shrinkage and unshrinkage.			
8		SDM Switch	Second data memory.			
9		Numeric Key	Enter number.			
10		Decimal Point	Enter decimal point.			
11		+/- Sign	Enter +/- sign.			
12		Enter	Confirm operation.			
13		Clearing	Cancel incorrect operation.			
14		Temporary Quit	1. Leave processing temporarily to return normal display state. 2. Enter auto edge detect function.		X	X
15		Temporary Quit	1. Leave processing temporarily to return normal display state. 2. Enter auto edge detection.	X		

XH USER'S MANUAL

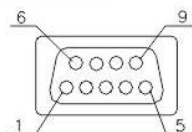
16		Calculator	Enter /quit calculating state.			
17		Shift	1 Calculate inverse trigonometric unction in calculating function. 2 Enter No. of SDM coordinate.			
18		Trigonometric Function	Calculate trigonometric or inverse trigonometric.			
19		Add: Decrease: Multiple: Divide	Operate adding: decreasing: multiplying: dividing.			
20		Radical Sign	Square root or square.			
21		Circumference Ratio	Enter circumference ratio.			
22		Equality Sign	Make calculating result.			
23		Set EDM	Set parameters of EDM.	X	X	
24		BHC	Process holes displayed equally on a circle.			
25		Start EDM	Enter EDM processing.	X	X	
26		ARC	Simple R cutting function			X
27		BHL	Process holes displayed equally on a line.			
28		SLOPE	Process a slope.			X
29		Lathe Function	Enter or exit lathe function.		X	X
30		Lathe Function	Enter or exit lathe function.	X		X
31		Item Selection	Stroll up or down to select.			

Note: -X|| indicates this model has no such a function.

1.4 Interface

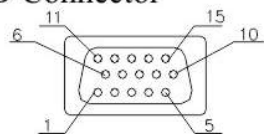
A Linear Scale Interface

1) 9PD Connector



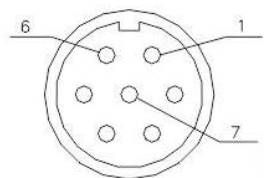
PIN	NAME	COLOR
1	+5V	RED
2	0V	BLK
3	A	BRW
4	B	YEL
5	RI	ORG

2) 15PD Connector



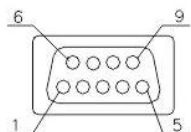
PIN	NAME	COLOR
1	+5V	RED
2	0V	BLK
3	A	BRW
4	B	YEL
5	RI	ORG

3) 7Pin Connector



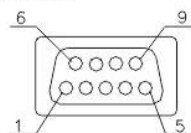
PIN	NAME	COLOR
1	OV	BLK
2	NC	
3	A	
4	B	YEL
5	+5V	RED
6	RI	ORG
7	FG	SHILD WIRE

B RS232 Interface



PIN	NAME	COLOR
1	NC	
2	TXD	YEL
3	RXD	ORG
4	NC	
5	GND	BRW

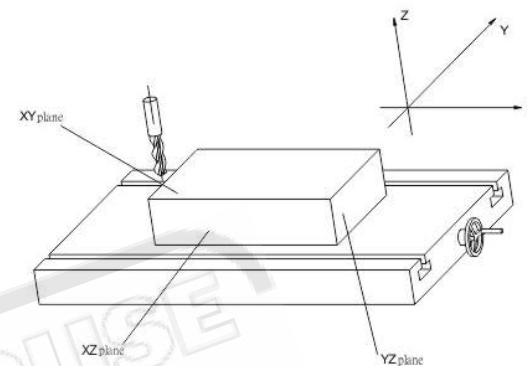
C EDM Interface



PIN	NAME	COLOR
1	NC	
2	COMMON	ORG
3	NORMAL CLOSE	BRW
4	NC	
5	IN+	RED
6	NORMAL OPEN	YEL
9	IN-	BLK

1.5 Coodfinat System

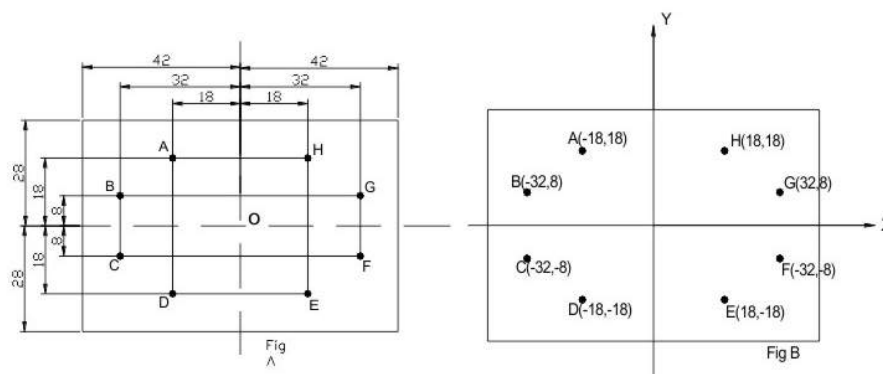
XH DRO is an instrument which can measure position of work piece when processing. Coordinate system must be definite first for more efficiency and accuracy.



In horizontal plane, the X axis is parallel with the operator; Y axis is perpendicular to X axis. Z-axis is perpendicular to horizontal plane. Positive direction of axis is set as the figure. It also can be changed as customer.

The value of one point position is the distance relative to the origin of coord inate.

For a work-piece as Figure A, the value of each point position is as the Figure B when point O is the origin of coordinate.



Chapter 2. BASIC OPERATION

2.1 Power on

Function: Power on then XH enter normal display state.

It can memorize the following parameter after power on.

- A. The scale position where power off;
- B. ALE/INC/SDM mode;
- C. Shrinkage is enabled or disable;
- D. Metric/Imperial mode;

The origin of the linear scale must be searched again if the scale is moved when power off.

Note: Normal display state

The state DRO automatically enters after on or exit from "STEUP".

In normal display state, X window, Y window and Z window displays the current value of X axis, Y axis and Z axis separately. The message window displays "ALE", "INC" or "SDM XXX" (indicate the Number of SDM coordinate, with a range of 000—999). When user switch among ALE/INC/SDM, MM/INCH or shrinkage / Un-shrinkage, DRO will not leave this state. When you enter CALCULATOR function, input data to X (or Y or Z) axis, function of searching the Reference point (RI) of the linear scale or special function (BHC: BHL: ARC: SLOPE PROCESSING and EDM function): DRO is not in the normal display state.

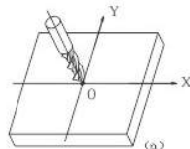
X - 10.0000 SDM 001
Y - 35.000
Z 0.0000

2.1 Power on

Function: Zero the designated axis in normal display state. Zeroing is used to set the current point as datum point.

Note:

- 1 The axis can't be zeroed when DRO is in other states (for example: in the state of calculating function or in special function). DRO should return normal display state;
- 2 The axes can be zeroed in ALE/INC/SDM states;
- 3 When zero in ALE coordinate, INC display value is cleared simultaneously. Zeroing in INC coordinate has no effect on ALE and SDM display value.
- 4 Press the zero key of the same axis will cancel above zero operation if the scale kept still after zero.
- 5 zero is means that set the current point as the origin point of current axis.



Example 1: Set the point O (as the figure illustrated) as datum

STEPS:

1) Return normal display state;

2) Move the machine table; and align the lathe tool with point O.
The DRO displays as the right figure.

3) Press $\boxed{X_0}$ to zero X axis,

Press $\boxed{Y_0}$ to zero Y axis.

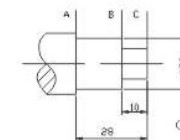
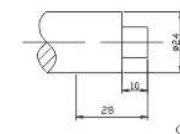
X - 23.560 ALE
Y - 45.670
↓
X - 0.000 ALE
Y - 0.000

2.3 PresetData to designed axis

Function: Preset a value to current position for a designed axis in normal display state.

- NOTES: 1 Axis can not be preset while the DRO is in other states (e.g. calculating function or special function). DRO should return normal display state before presetting data.
- 2 Axis can be preset in ALE/INC/SDM state.
- 3 In SDM state, input mode "0" means that the display value is equal to the enter value; input mode "1" means that the display value is equal to the negative of enter value.
- 4 The range of input value is that the minimum value to the maximum value which could be displayed in the designated window.

Example: Machine the work-piece from the figure (a) to figure(b), and the plane C is the datum and counting direction is right.



STEPS:

1. Move the machine table, and align the lathe tool to plane B.

2. Return normal display state;

3. Press $\boxed{X}$, "0" is flashing in X window, waiting for entering a data;

4. Press $\boxed{1} \boxed{0} \boxed{\pm}$ in turn, which means the preset data is "-10";
If incorrect value is inputted: press $\boxed{AC}$ to cancel and input again;

NOTE: If in SDM state and SDM input mode is "1", $\boxed{\pm}$ needn't be inputted. Otherwise $\boxed{\pm}$ must be inputted.

5. Press $\boxed{ENTER}$ to confirm the data that your input and end presetting it to X axis;

6. Moving the machine table until "-28.000" is displayed in X window. Now it is the position of plane A.

7. Y axis, Z axis can be preset in the same way.

X - 1234567

X - 0.0000

X - 10.0000

X - 28.0000

2.4 Toggle display unit between mm and inch

Function: Length can be displayed either in "mm" (metric) or "inch" (imperial) Display unit can be toggled between mm and inch.

Example: Display value toggle from mm to inch

STEPS:

1. DRO returns normal display state. The LED of INCH is off, which means the current unit is mm (metric);
2. Press , then the LED of INCH/mm is on, which means the display unit is inch now.

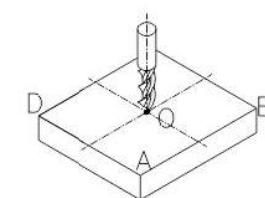
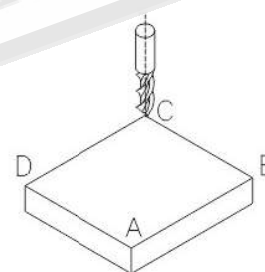
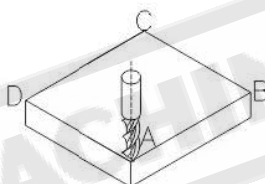
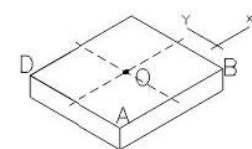
3. It is invalid to toggle between mm and inch while axis is encoder.

NOTE: If in imperial, the LED of INCH is on; and in metric unit, the LED of INCH is off.

X0 25400 ALE
Y0 50800



X0 10000 ALE
Y0 20000



2.5 Mid-point Calculation

Function: Set the center of work piece as datum by halving the displayed value.

Example: Set the center of rectangle as datum as the right figure.

STEPS:

1. Place the work piece on the machine table, with line AB parallel with X axis, line AD parallel to Y axis;

2. DRO returns normal display state, move machine table and align the lathe tool with point A;

Press  to zero X axis, press to  zero Y axis;

X0 0000 ALE
Y0 0000

3. Align lathe tool with point C by moving machine table;

Press ,  in turn to halve the X axis display value;

Press ,  in turn to halve the Y axis display value;

X0 60000 ALE
Y0 60000
↓
X0 30000 ALE
Y0 30000

4. Move the machine table until -0.0001 is displayed in X window and X window. The position (where the lathe tool is) is the work-piece's center.

X0 0000 ALE
Y0 0000

Note: 1. If you do other operation after axis half, please press ,  will cancel above operation, and X-axis display value return to normal.

2. It is invalid to mid-point calculation while axis is encoder.

2.6 Set the Shrinkage mode

Function: With this function, you can process the mould tools according to the dimension of the finished products without calculating dimension separately.
display value = actual value x shrink ratio.

STEPS:

A. unshrinkage → shrinking

1. DRO returns normal display state;

2. Press  and don't release. The Y window displays the current shrinkage ratio, the message window displays "SURE AGN", which means you need to confirm once again.

3. Press  to enter shrinkage state; press any other key to return former state.

X0 10000 ALE
Y0 20000



X0 0000 SURE AGN
Y0 0995 shrinkage ratio



X0 9950 ALE
Y0 19900

NOTE: I  should not be released and press  simultaneously to enter shrinkage state; LED of shrinkage flashes in shrinkage mode;

II You can view the shrink ratio by making use of this function: press  will display shrink ratio of Y axis; Then press any key can return normal state;

III The signal light of shrink ratio will flicker while in shrinkage.

B. shrinkage → unshrinking.

1. DRO returns normal display state;

2. Press , now DRO is in unshrinking mode, LED of shrinkage is off;

X0 9950 ALE
Y0 19900 → X0 10000 ALE
Y0 20000

2.7 Absolute / Incremental / 1000 groups SDM

Function: The XH series DRO has 3 display modes: the absolute mode (ALE); the incremental mode (INC) and 1000 groups Second Data Memory (SDM) with the range of 000 to 999.

1. Zero point of work-piece is set at the origin point of ALE coordinate;
2. The relative distance between datum of ALE and SDM remains unchanged when ALE datum is changed.
3. If one point in ALE is zeroed, the point in INC is zeroed automatically; yet if one point in INC is zeroed, the point in ALE will remain unchanged.

I. toggle among ALE/INC/SDM coordinate

These three display modes can be changed only in normal display state.

ALE → INC Press

INC → ALE Press

SDM → INC Press to enter ALE or INC. If in ALE: press again.

SDM → ALE Press to enter ALE or INC. If in INC: press again.

INC → SDM Press

ALE → SDM Press

II. Set the new number of SDM in SDM mode

STEPS:

1. Enter SDM mode;
2. Press (two axes DRO) or (three axes DRO), message window flashes, waiting for inputting a new number of SDM;
3. Enter a new number. for example, enter .
4. Confirm new SDM number.

Press (two axes DRO) or (three axes DRO), then the message window stops flashing and the number of SDM is changed to 666.

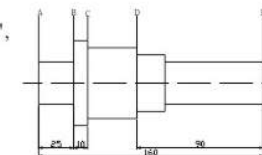
SDM 234
↓
SDM 666

III: Increase/Decrease the SDM number

DRO return normal display state with the display mode SDM, press to decrease the number of SDM by 1; press to increase the number of SDM by 1. Example: If the current SDM number is 777, and the message window displays "SDM 777", press , then the message window will display "SDM 776", which means the current SDM number is 776.

If the current SDM number is 777 and the message window displays "SDM 777",

press , then the message window will display "SDM 778", which means the current SDM number is 778.



If a work-piece as the figure is to be machined where the datum plane is plane E, the coordinate can be set as the following steps:

1. Return normal display state with ALE coordinate;
2. Move the machine table until the lathe tool is aligned with plane E, then zero X axis;
3. Move the machine table until the lathe tool is aligned with the plane D. Change SDM number to SDM 000, and press to zero X axis. Then the NO.000 SDM coordinate's datum is set at plane D.
4. Move the machine table until the lathe tool is aligned with plane C, press to change SDM to SDM 001, and then press to zero X axis, and the SDM 001 with the datum plane C is set.
5. Move the machine table until the lathe tool touches the plane B, the DRO will display as the right.
6. Move the machine table until the lathe tool touches the plane A, the DRO will display as the right.

0000 ALE

↓

- 9000 ALE

↓

0000 SDM 000

↓

- 35000 SDM 000

↓

0000 SDM 001

↓

- 10000 SDM 001

↓

- 35000 SDM 001

2.8 Clear All SDM Datum

Function: Clear the Datum of all SDM 0-999. After clearing, the display value in SDM coordinate is equal to the value in ALE coordinate.

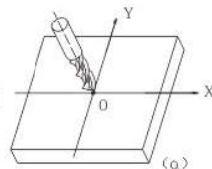
STEPS:

1. Return normal display state;
2. Press and simultaneously for 2 seconds, and the message window displays "CLSSDM" and flashes, which means it is clearing now. About ten seconds later, the clearing is completed and "CLS OK" is displayed in message window temporary and DRO return normal display state.

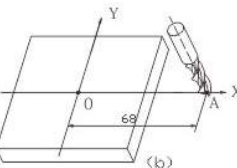
2.9 Search the Absolute Reference Point of Scale (RI)

Function: An absolute datum should be set when a work-piece is machined. There are two cases:

➤ When the machine table is going in high speed, the machine table can't stop immediately but continue going further because of inertia when power is off suddenly. There will be distance ΔL between the actual position and the position in the DRO memorize. That is to say the display value is not the actual value of the position when power is on again.



➤ If the machine table is moved without intention when DRO is off.



How to restore the preset ALE and correct display value?
These questions can be solved easily with this function of search RI.

STEPS:

1. DRO is set in ALE coordinate.
2. Press $\boxed{\text{RI}}$, then the message window displays "SEL AXIS";
3. Select the axis which need search RI. For instance: select Y axis, then press $\boxed{\text{Y}}$. "FD.Y REF" is displayed in message window, and Y window flashes.
4. Move the machine table. The buzzer sounds when RI is searched, then Y window stops flashing and displays the value of the current position, the DRO returns normal display state.

In the course of searching, press $\boxed{\text{AC}}$ to quit this operation.

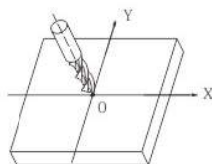


The machine table is moved when DRO is off. How to restore the former absolute ALE coordinate and correct display value?

Take XH-2 as an example.

STEPS:

- 1) This operation (searching the absolute origin point of the scale) is necessary when a linear scale is installed or the default parameter is loaded. Or the ALE coordinate would not be restored.
- 2) Set the point O as the datum of ALE. (Move the machine



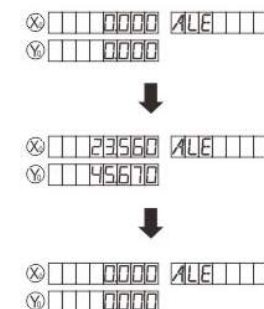
3) table until the lathe tool is aligned with point O, and zero the X axis, Y axis)

3) The machine table is moved when power is off;

4) Power on, switch to ALE coordinate. The DRO may be displays as the right.

5) Search the RI of X axis and Y axis. After RI is found, the ALE coordinate is restored.

6) Align the lathe tool with point O, "0.000" is displayed in X window and Y window, which means the point O is the origin and the ALE coordinate is restored.



NOTE:

- The linear scale has a RI every 50 mm. For the sake of search identical RI, move the scale around the red mark "Δ" to search RI.
- Setup correct RI mode is a premise.

2.10 Clear the Error message

If ERROR message is enabled, the message window will display "E1" if the signal of phase A and phase B of the linear scale changes at the same time; the message window will display "E2" if the linear scale runs too fast; the window will display "E3" if these two conditions occur simultaneously. When error information appears, the display value has an error of 1-2 count. So users need search RI to restore ALE coordinate. If you think that doesn't affect your work, press $\boxed{\text{AC}}$ to clear error message and continue your work.

Example: When signal of A phase and B phase is same in Y axis the window displays as the right figure.

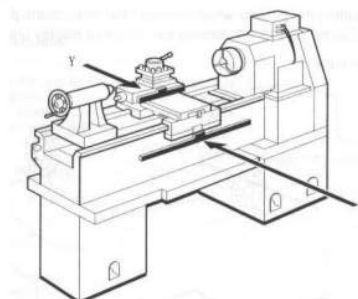


Press $\boxed{\text{AC}}$ to clear the error information. Y window displays the value, but it is error. The difference between the display value and the true value is about 1-2 times of resolution. For instance, the resolution of scale is 5μm; the difference is 5-10μm.



2.11 Lathe Function

As the right figure, if two scales are installed in one axis, the position of the work-piece should be the sum of these two values (X+Y) in this



direction. It is called lathe function.

- lathe mode 0: normal display (the lathe function is disabled).
- lathe mode 1: X window value = the value of X axis position + the value of Y axis position.
- lathe mode 2: X window value = the value of X axis position + the value of Z axis position.

STEPS:

- Set the lathe mode in initial system settings;
- In normal display state press $\boxed{X/Y}$ (three axes display) or $\boxed{X/Y}$ (two axes display) to enter lathe function. Then the LED of the lathe function will be on (If the lathe mode is 0, the lathe function is disabled and the LED is off);
- In lathe state, press $\boxed{X/Z}$ (three axes display) or $\boxed{X/Y}$ (two axes display) to exit the lathe function: and the LED turns off.

- A. If in normal display state: the value of the position is as the right.

X	10000	ALE	
Y	20000		
Z	30000		

- B. In lathe mode 1, the DRO will display as the following:
X window display value = value of X axis position + value of Y axis position

X	30000	ALE	
Y	20000		
Z	30000		

- C. In lathe mode 2, the DRO will display as the following:
X window display value = value of X axis position + value of Z axis position

X	40000	ALE	
Y	20000		
Z	30000		

2.12 Filter display value

When machine a work-piece by grinder, the display value varies quickly due to the vibration of grinder. User can't see display value clearly. XH series DRO provides display value filter function to disable the quake change of display value.

STEP:

- Enter display value filter function.

In normal display state, press $\boxed{F}$ and $\boxed{ENTER}$ simultaneously, enter display value filter function.

- Exit display value filter function.

Press $\boxed{F}$, exit display value filter function.

Chapter 3. 1000 groups SDM coordinate

XH has three display modes: the absolute mode (ALE), the incremental mode (INC) and the 1000 groups second data memory (SDM 0—SDM 999).

ALE datum of the work-piece is set at the beginning of the processing and the 1000 group SDM is set relative to ALE coordinate.

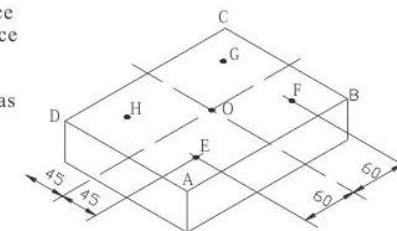
1000 group SDM coordinate can be divided into several segments, and every segment stores data of one work-piece. If one segment has 20 groups SDM coordinate, DRO can be divided into 50 segments and can store data of 50 work-pieces.

SDM 000 -----SDM 019 data of the first work-piece
SDM 020 -----SDM 039 data of the second work-piece
SDM 040 -----SDM 059 data of the third work-piece
.....
SDM 960 -----SDM 979 data of 49th work-piece
SDM 980 -----SDM 999 data of 50th work-piece

Example: The ALE datum is the center point O, the point E, F, G, H needed processing are set as datum of SDM 000—SDM 003.

Two ways to set SDM coordinates:

- Zeroing at the current point.
- Presetting datum of SDM coordinate.



3.1 Zeroing at the Current Point

At first set the center point of the work-piece as the origin of the ALE, then align the lathe tool with point E, F, G, H by moving the machine table and zero them. It is the position to process where the "0.00" appears in X window, Y window by moving the machine table whether in ALE or in SDM coordinate.

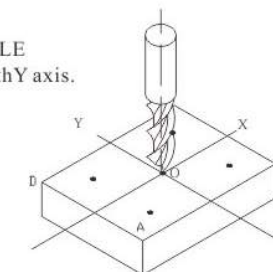
STEPS:

- Set the center of rectangular point O as the datum of ALE
Make line AB parallel with X axis; line AD parallel with Y axis.
When position lathe tool to point O
Zero X axis and Y axis in SDM 000;
Zero X axis and Y axis in SDM 001;
Zero X axis and Y axis in SDM 002;
Zero X axis and Y axis in SDM 003;

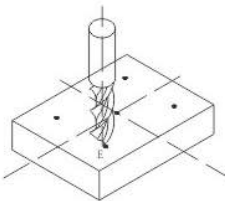
X	0000	ALE	
Y	0000		

- Set the point E as the datum of SDM 000.

SDM 000: align the lathe tool with point E and zero X axis, Y axis. DRO displays as the right.



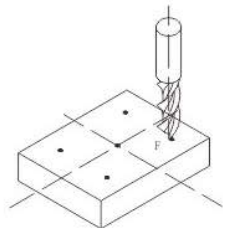
X	-160000	SDM 000
Y	-145000	

Press X_0 , Y_0 

↓

X	0	0	0	0	SDM	0	0	0
Y	0	0	0	0				

3. Set the point F as the datum of SDM 001.
In SDM 001, align the lathe tool with point F, then zero X axis, Y axis. DRO displays as the right:

Press X_0 , Y_0 

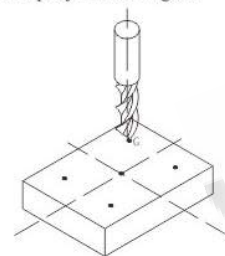
↓

X	0	0	6	0	0	SDM	0	0	1
Y	-	0	0	4	5				

↓

X	0	0	0	0	SDM	0	0	0
Y	0	0	0	0				

4. Set the point G as the origin of SDM 002.
In SDM 002, align the lathe tool with point G, and zero X axis, Y axis. DRO displays as the right.

Press X_0 , Y_0 

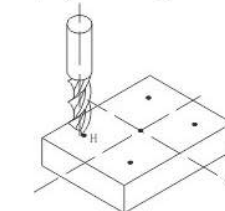
↓

X	0	0	6	0	0	SDM	0	0	2
Y	-	0	0	4	5				

↓

X	0	0	0	0	SDM	0	0	0
Y	0	0	0	0				

5. Set the point H as the origin of SDM 003.
In SDM 003, align the lathe tool with point H, and zero X axis, Y axis. DRO displays as the right.

Press X_0 , Y_0 

↓

X	0	0	6	0	0	SDM	0	0	3
Y	-	0	0	4	5				

↓

X	0	0	0	0	SDM	0	0	0
Y	0	0	0	0				

6. Machine the work-piece according to the preset SDM coordinate;

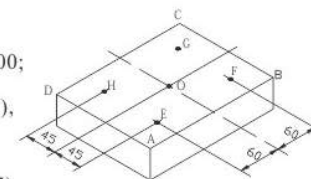
7. Machine another work-piece according to the same blueprint. You only need set the center point as the datum of ALE. It is not necessary to set SDM coordinate again, as SDM can be set automatically. Point E, F, G, and H is the zero point of SDM 000, SDM 001, SDM 002, and SDM 003 respectively. Point can be machined when enter corresponding SDM coordinate and "0.000" appears in screen by moving machine table. This function can save great plenty of time in production.

3.2 Preset datum of SDM Coordinate

Compared with the way of zeroing at current point, the another way (presetting datum of SDM coordinate) can set zero point of SDM more accurately and quickly without moving the machine table.

As the figure showed right, center point is the datum of ALE, the position of point E, F, G, H is (-60, -45), (60, -45), (60, 45), (-60, 45) in ALE coordinate.

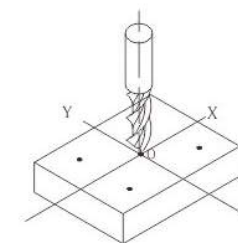
- A Enter SDM 000 and preset the position of point O as (60, 45), which means the point E is the datum of SDM 000;
B Enter SDM 001, preset the position of point O as (-60, 45), which means the point F is the datum of SDM 001;
C Enter SDM 002 and set the position of point O as (-60, -45), which means the point G is the datum of SDM 002;
D Enter SDM 003, preset the position of point O as (60, -45), which means the point H is the datum of SDM 003;



Pay attention that the preset value is negative to the actual value of position in ALE. If set "SDM DIR" as "1" in initial system settings, the caution is not necessary. The value DRO accepts is equal to the negative of the enter value.

STEPS:

1. Set "SDM DIR" as "1" in initial system settings;
2. Set the center point of the work-piece as the datum of ALE; Line AB is parallel to X axis, line AD is parallel to Y axis. Move machine table; align the milling cutter with point O. The machine table remain still while presetting;



X	0	0	0	0	ALE	0	0	0
Y	0	0	0	0				

- 3 Set point E as the datum of SDM 000;
Enter SDM 000.
The position of point E is (-60, -45), press.

3 Set point E as the datum of SDM 000;

Enter SDM 000.

The position of point E is(-60,-45), press.

X 6 0 $\frac{+}{-}$ ENTER in turn
Y 4 5 $\frac{+}{-}$ ENTER in turn



X 60000 SDM 000
Y 45000

4. Set point F as the datum of SDM 001;

Enter SDM 001.

The position of point F is (60,-45), press

X 6 0 ENTER in turn
Y 4 5 $\frac{+}{-}$ ENTER in turn



X 60000 SDM 001
Y 45000

5. Set point G as the datum of SDM 002;

Enter SDM 002.

The position of G is(60,45), press

X 6 0 ENTER in turn
Y 4 5 ENTER in turn



X 60000 SDM 002
Y 45000

6. Set point H as the datum of SDM 003;

Enter SDM 003

The position of point H is(-60,45), press

X 6 0 $\frac{+}{-}$ ENTER in turn
Y 4 5 ENTER in turn



X 60000 SDM 003
Y 45000

Chapter 4 SPECIAL FUNCTIONS

XH series DRO has special function as the following except measuring and positioning:

Bolt Hole Circle(BHC);

Bolt Hole Line(BHL);

ARC Processing(only for XH-Series);

Slope Processing (only for XH-Series);

Electrode discharging machining(EDM,only for XH Series);

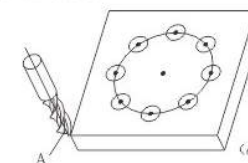
Please refer **Coordinate System** (in Chapter 1) before reading this section.

4.1 Bolt Hole Circle

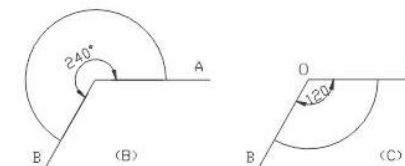
Functiondescription:

XH series DRO has the function of BOLT HOLE CIRCLE (BHC) . This function can simplify the pressing of multiple holes which are attributed equally around the circumference of a circle. The DRO will guide operator to enter the following parameters:

RADIUS	Radius of circle
ST.ANGLE	Starting angle that the center of the first hole on the circle
END.ANGLE	Ending angle that the center of the last hole on the circle
HOLE NUM	Hole number
DIRECT	Angle direction.

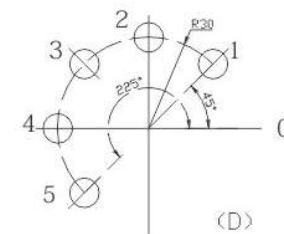


Angle has two directions: counterclockwise and clockwise. "0" indicates that it is counterclockwise from ST.ANGLE to END.ANGLE; "1" indicates it is clockwise from ST.ANGLE to END.ANGLE. As the following figure, the ST.ANGLE is 0°, END.ANG is 240°. The figure(B) illustrates the arc while angle direction is counterclockwise; figure(C) illustrates the arc while angle direction is clockwise.



As figure (D) illustrates, machine a hole every 45 deg from 0°~225°. Parameters are as the following:

RADIUS	20
ST.ANGLE	45
END.ANGLE	225
HOL NUM	5
DIRECT	0



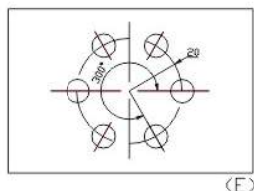
NOTE: If ST.ANGLE equals END.ANGLE, the holes are attributed equally around the whole circumference.

The positions of the hole center are calculated automatically after input all parameters.

Press $\downarrow$ or $\uparrow$ to choose the hole No. and move the machine table until the "0.000" appears in X window, Y window. It is the position to process a hole.

Example: Machine holes on circumference as the figure (E).

RADIUS	20mm
ST.ANGLE	0°
END.ANGLE	300°
HOLE NUM	6
DIRECT	0

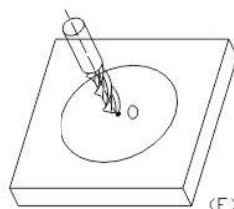


STEPS:

1. Set display unit to metric in normal state;
Move the machine table until the machine tool is aligned with the center of the circle, then zero X axis, Y axis.

2. Press to enter Bolt Hole Circle function.

If all parameters have been set, press to process directly.



3. Input radius

Y window displays the formerly preset radius; message window displays "RADIUS". Press in turn.

X0	00000	RADIUS
Y0	50000	former preset radius

X0	00000	RADIUS
Y0	20000	

X0	00000	ST.ANGLE
Y0	20000	former starting angle

NOTE:

If "0" is inputted as the radius, the DRO will be requested to input again.

If incorrect parameter has been input and you haven't pressed , press to cancel and input again; if you have pressed and begin to set another parameter, you should press to return RADIUS set and input again. Other parameters can be dealt with in the same way.

4. Input ST.ANGLE

Message window displays "ST.ANGLE"; Y window displays the former preset starting angle.

Press in turn;

X0	00000	ST.ANGLE
Y0	00000	

X0	00000	END.ANGLE
Y0	100000	former ending angle

5. Input ending angle

Message window displays "END.ANGLE"; Y window displays the former angle.

Press in turn.

X0	00000	END.ANGLE
Y0	300	former ending angle

6. Input the number of hole.

Message window displays "HOLE NUM"; Y window displays the former number.

Press in turn.

X0	00000	HOLE NUM
Y0	00000	6

NOTE: If "0" or "1" is inputted as the number of holes, the DRO will point out this mistake and remind inputting again.

X0	00000	DIRECT
Y0	00000	1

7. Input angle direction.

Message window displays "DIRECT", Y window displays the former preset direction;

Press in turn;

X0	00000	DIRECT
Y0	00000	0

8. Message window displays "HOLE 1";

It is the position of the first hole to punch where the "0.000" is displayed in X window and Y window by moving the machine table.

X0	00000	HOLE 1
Y0	00000	

9. After finishing the first hole, press .

Message window displays "HOLE 2";

Move the machine table, the "0.000" is displayed in X window and Y window. It is the position of the second hole.

X0	00000	HOLE 2
Y0	00000	

NOTE: Press or to change holes number.

X0	00000	HOLE 6
Y0	00000	

10. Process the holes 3rd -6th in the same way.

11. After processing all holes, press to return normal display state.

NOTE: In the course of BOLT HOLE CIRCLE processing, pressing (three axes display) or (two axes display) can leave BOLT HOLE CIRCLE function temporarily and return normal display state in order to check the position. And press (three axes display) or (two axes display) again to return BOLT HOLE CIRCLE function.

4.2 Bolt Hole Line

Function: XH series DRO provides BOLT HOLE LINE(BHL) function. This function can simplify the processing multiple holes whose centers are attributed equally on one line.

The following parameters are needed to be input:

LINE DIS Line distance (distance between the center of first hole and the center of the last hole)

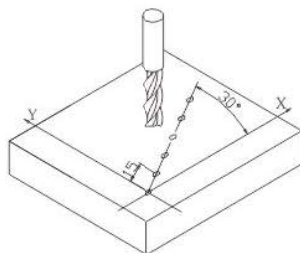
LINE ANG Line angle (angle between the line and the positive X axis)

HOLE NUM Number of holes

DRO will calculate the positions of the hole after all the parameters have been entered. Press  or  to select the No. of hole and move the machine until "0.000" is displayed in X window and Y window. It is the position of hole to machine.

Example:

LINE DIS 150mm
LINE ANG 30°
HOLE NUM 6



STEPS:

1. Set display unit to metric and the shrinkage is not taken into consideration.

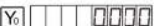
Move the machine table until the machine tool is aligned with the center point of the first hole, and zero X axis, Y axis.

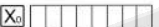
2. Press  to enter BOLT HOLE LINE function; If all parameters have been entered, press  to start processing directly.

3. Input line distance.

Y window displays the former preset line distance, and the message window displays "LINE DIS".

Press  in turn;

X0  0000 SDM 001
Y0  0000

X0  LINE DIS
Y0  20000 former preset distance

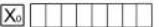
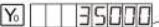
X0  LINE DIS
Y0  150 former preset distance

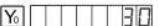
NOTE: If "0" is input as the line distance: the DRO will not accept and remind the operator to input again.

4. Input line angle.

The message window displays "LINE ANG"; Y window displays the former preset line angle.

Press  in turn.

X0  LINE ANG
Y0  35000 former preset angle

X0  LINE ANG
Y0  30

5. Input the number of hole.

Message window displays "HOLE NUM", Y window displays the former preset hole number.

Press  in turn, processing begins.

X0  HOLE NUM
Y0  10 former preset hole number

NOTE: If "0" or "1" is input as hole number, DRO will not accept and remain user to input again.

6. Message window displays "HOLE 1";

Move the machine table until "0.000" appears in X window and Y window, it is the center of the first hole to punch.

7. After finishing the first hole, press , and the message window displays "HOLE 2";

Move the machine table until "0.000" appears in X and Y window, and then you can punch the second hole at this point.

NOTE: Press  or  to transform among holes.

8. Process the holes 3rd–6th in the same way.

9. Press to  return normal display state when finishing processing.

NOTE:

In the course of BHL processing, you can press  (three axes display) or  (two axes display) to leave this function temporarily and return normal display of X, Y, Z axis in order to check the position which the DRO calculated. Then press  (three axes display) or  (two axes display) again to return BHL function.

X0  HOLE NUM
Y0  6
X0  HOLE 1
Y0  0000
X0  HOLE 2
Y0  0000
X0  HOLE 6
Y0  0000

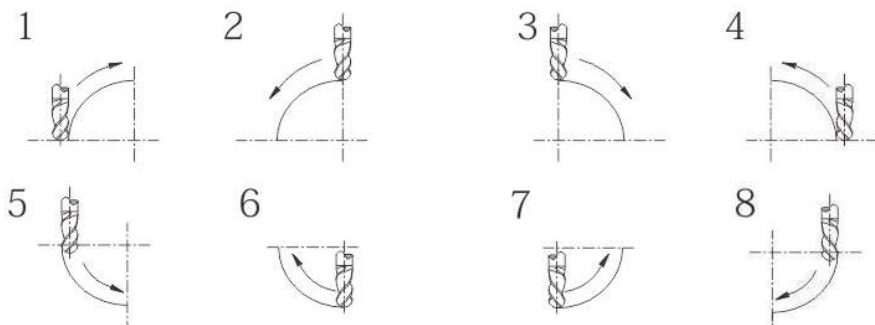
4.3 ARCProcessing

This function is only for XH Series.

It is wasteful to use numerical control lathe to process arc in the simple product or small production. This function makes it convenient to process arc with normal lathe. Parameter "MAX CUT" is the arc length each process. The smaller the MAX CUT, the more smooth the arc plane and the longer processing time.

A. Process XZ, YZ plane

There are 8 modes as the following when processing arc in XZ or YZ plane:



Milling cutter may be flat-bottomed or arc-bottomed. If flat-bottomed, set the tool diameter as 0;

B. Process XY plane

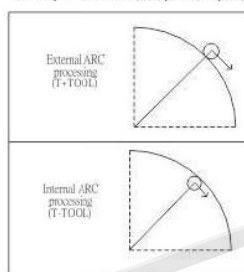
DRO provides the above 8 modes in processing XY plane. The milling cutter is perpendicular to the machine plane. DRO has internal ARC processing and external ARC processing for each type:

External T+TOOL:

Internal T-TOOL:

Set the tool radius according to the actual milling cutter when process XY plane.

Tool compensation direction (when process XY plane)



Enter the following data for ARC processing:

TYPE 1-8	Mode of the ARC processing
* T+TOOL / T-TOOL	Selection between T+TOOL/T-TOOL (This parameter is only for XY plane)
RADIUS	The radius of ARC that is to be processed
TOOL DIA	Tool diameter
MAX CUT	Feed step

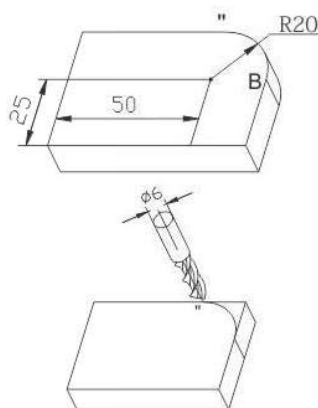
Example 1:

Process an arc AB of 90° from point A to point B as the figure.

Parameters are as the following:

Machine plane	XY
ARC mode type	3
T+TOOL	
RADIUS	20mm
TOOL DIA	6mm
MAX CUT	0.5mm

Shrinkage is not taken into consideration.



STEPS:

1. Set display unit is metric, and the LED of the shrinkage is off.
2. Move the machine table until the lathe tool is aligned with point A, then zero X axis and Y axis;
3. Enter ARC processing state;
Press to enter ARC processing state.
If all parameters have been set: press to process directly.
4. Select machine plane;
Press to select XY.

NOTE: indicates XY plane;
 indicates YZ plane;
 indicates ZX plane;

You can also press (two axes display) or (three axes display) to switch plane among XY plane, YZ plane and ZX plane.

5. Select processing mode:

Message window displays -TYPE 1"8", and Y window displays the former processing mode;
Press in turn to select mode 3, and then enter ARC type;

6. Select T+TOOL mode:

Press to select the external arc processing;

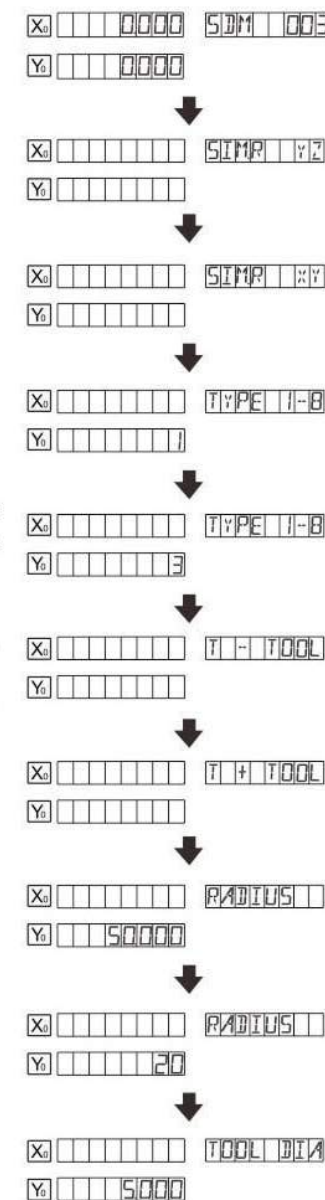
NOTE:

- indicates T+TOOL mode (external arc processing);
- indicates T-TOOL mode (internal arc processing).

7. Set ARC radius

Message window displays "RADIUS", and Y window displays the former arc radius;
Press in turn to input the arc radius.

NOTE: If "0" as the arc radius is input: the DRO will display error message and wait another number.



INCL: Set machine plane XY, YZ or XZ plane
 INCL.ANG: the inclination angle of the slope
 MAX CUT: the slope length each time processing

Note:

Z STEP and MAX.CUT are defined as the figure.

DRO will calculate the position of each processing on the slope automatically when all parameters have been input.

Press or to select the processing point and process until "0.000" appears in the window.

Example 1:

Process the slope AB as the figure. The parameters are as following:

I NCLE: XZ
 I NCL.ANG 45°
 MAX. CUT 1.2mm

STEPS:

1. Set display unit to metric;
Set the SLOPMODE 1 in initial system settings.

Note: If the third parameter isn't Z STEP, set the SLOP.MODE 0.

Move the machine table until the lathe tool is aligned with the starting point A, then zero X axis and Z axis.

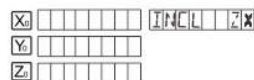
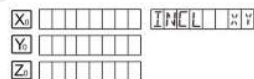
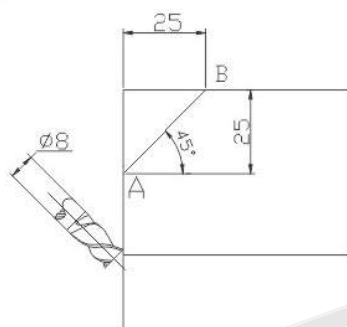
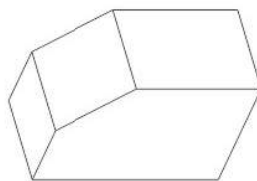
Press , in normal display state.

2. Press to enter slop processing
Press to start processing directly if all parameter have been set.

3. Select machine plane.

Press in turn to select the XY plane.

Note: Press indicates XY plane;
 Press indicates YZ plane;
 Press indicates ZX plane;



You can also press (two axes display) or (three axes display) to switch among XY plane, YZ plane or ZX plane.

4. Enter I NCL.ANG.

Message window displays "INCL ANG"; Y window displays the former INCL.ANG.

Press in turn.

5. Enter MAX.CUT.

Message window displays "MAX CUT"; Y window displays the former MAX.CUT.

Press in turn;

NOTE: If "0" is inputted as MAX CUT, DRO will not accept and wait for another data.

6. Processing

Message window displays "POIN 1";

Process stop when the "0.000" appears; then press to process the next point.

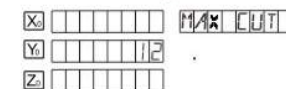
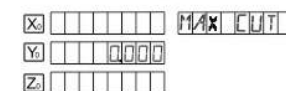
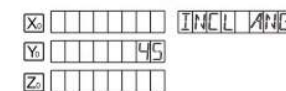
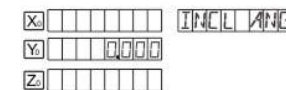
7. Press or to select point.

8. Press to return normal display state after processing is over.

Note: For XH Series, it is not installed with Z-axis, please press or to simulate position of Z-axis, simulate moving to the former process point, and simulate moving to the next process point.

Steps:

- 1: Set Z axis dial in internal system setup;
- 2: Before machining, align the start point Z point with lathe, then set Z axis as "0.000";
3. While machining XZ plane, X window display position of X axis, X axis is finished when "0.000" appears in X window; In Y window, the former 2 number indicates number of dial, and the following 5 number indicates scale number of dial, which means that machining to this scale for current point.
While machining YZ plane, Y window display position of Y axis, and when this window displays "0.000", which indicates the machining is finished in Y direction; In X window, the former 2 number indicates number of dial, and the following 5 number indicates scale number of dial, which means that machining to this scale for current point.



In slope processing, operator can press  (three axes) or  (two axes) to exit, return to normal display, making use of this you can confirm position of DRO. And then press  (three axes) or  (two axes) return to slope processing.

4.5 Auto Edge Detection

Function:

- Searching border automatically;
- Measuring dimension of work-piece;
- Searching for the center of work-piece.

NOTE: This is an additional function. It needs additional pay.

Example:

Radius of EDGE DETECTOR 5 mm
Work-piece dimension on X axis 65 mm
Measure by using the linear scale installed at X axis.

STEPS:

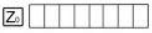
1. Set display unit to metric.

2. Press  (three axes display) or  (two axes display) to enter AUTO EDGE DETECTION. Message window displays "SEL AXIS"; Y window displays the radius of the edge detector; the sign of the value displayed is the sign when the detector touches the first edge.

X  SEL AXIS
Y  1000
Z 

3. Input the radius and sign of the detector.

Press    in turn, and then the Y window displays "-5.000".

X  SEL AXIS
Y  -5000
Z 

NOTE: You can skip this step if the diameter is set well.

4. Select axis, take X axis for example.

Press  to select X axis.

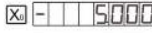
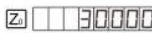
"0.000" flashes in X window, waiting for detecting edge.

Y window, Z window display the value of the current position.

Press  to select Y axis; press  to select Z axis in the same way.

X  SCH 00
Y  20000
Z 

5. Move the EDGE DETECTOR to touch the first edge, then the X window will display the position of the detector with "-5.000". The displayed value in X window is the measure value. You can touch the edge many times.

X  -5000 SCH 00
Y  20000
Z 



6. Move the EDGE DETECTOR to touch another edge. The X window will show the length of the work-piece with "65.000";

X  65000 SCH 00
Y  20000
Z 

7. Press  to exit this function. Move the EDGE DETECTOR until the X window displays "0.000", which means that this position is the center of the work-piece at the X axis direction.

NOTE: 1. Pressing  (three axes display) or  (two axes display) will exit this function when in EDGE DETECTION function.

2. If you detect edge only, you needn't do step 6 and 7.

3. If do not find the center point, you needn't do step 7.

Chapter 5 EDM (ELECTRICAL DISCHARGE MACHINING)

Note: Only XH Series provides EDM function.

DRO will send out a signal and machining will stop as soon as the display value is equal to the expectant.

XH series is equipped with 7 EDM modes:

- MODE 1 manual mode 1
- MODE 2 automatic mode 1
- MODE 3 manual mode 2
- MODE 4 manual mode 3
- MODE 5 manual mode 4
- MODE 6 automatic mode 2
- MODE 7 automatic mode 3

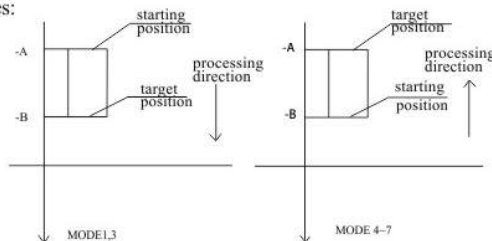


Fig 1 : Difference among EDM modes

EDM mode is set in initial system settings.

NOTES: Pay attention to the relay mode.

Table 1: the difference between 7EDM modes:(X:Nohave;√:Have; ↑ :Up; ↓ :Down)

EDM MODE	Edge detect	Direction of machining as depth is minus	Exit EDM after machine first hole	Z axis direction
1	X	↓	√	↓
2	√	No minus depth	X	↓
3	X	↓	X	↓
4	X	↑	√	↓
5	X	↑	X	↓
6	√	↓ (No plus depth)	X	↑
7	√	↓	X	↑

Positive direction of Z axis is down except mode 6: which means the display value will increase with the increasing depth during machining.

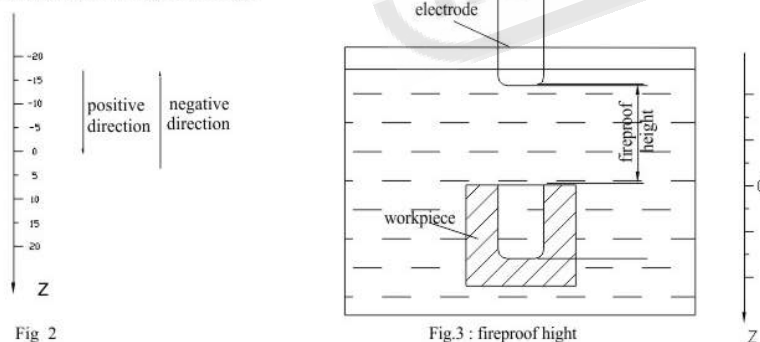


Fig 2

Fig.3 : fireproof hight

XH Series provides fireproof function. During EDM, charcoal will be produced on the machined surface. With accumulating charcoal, the electrode will be beyond liquid level, which could lead a fire. If fireproof height is set, EDM will stop, the DRO will send an alarm and fire is avoided.

5.1 Setting EDM Parameters

The following parameters must be set before EDM is done:

- A Depth of machining (EDM D EEP)
- B Fir eproof height (EDM HOME)
- C Electrode compensation (EDM.COMP if DEEP COMP is active)
- D EDM mode (EDM M ODE)
- E Relay mode (RELAY MODE)
- F Disable/Enable electrode compensation (D EEP.COMP)

A, B, C can be set by pressing  in normal display state; D, E, F can be set in initial system settings, and they are modified rarely. If the DEEP.COM is set as op, electrode compensation is not taken into consideration; if it is set as op, the value of electrode compensation can be set in parameter setting, and electrode compensation should be taken into consideration during machining.

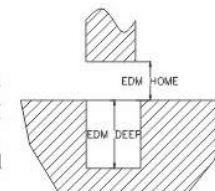


Fig. 4 : EDM DEEP

Example:

EDM depth (EDM D EEP)	156.1mm
Fireproof height (EDM HOME)	3.0mm
Electrode compensation (EDM.COMP)	0.1mm

STEPS:

- Set EDM COMP as 01p in initial system settings to enable electrode compensation;

- Return normal display state, and then set display unit is to metric;

- Input EDM parameters.

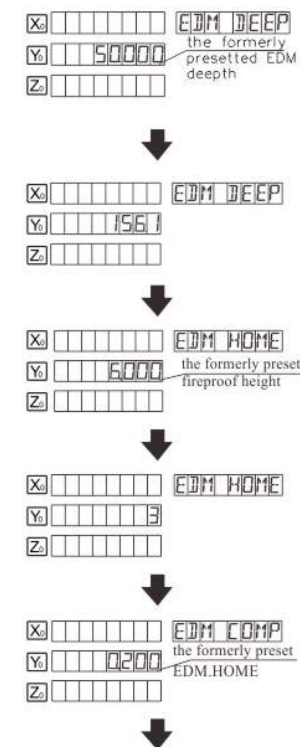
Press , the Y window displays the former depth;
Input depth by pressing **1 5 6 . 1** **ENTER** in turn;

- The Y window displays the former fireproof height;
Input the fireproof height.

Press **3** **ENTER** ;

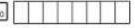
- The Y window displays the value of former electrode compensation;

Input the new value.



Press **0** **.** **1** **ENTER** in turn;

6: Press  to return normal display state.

X  EDM COMP
Y  0.1
Z 
↓
X  EDM COMP
Y  0.100
Z 

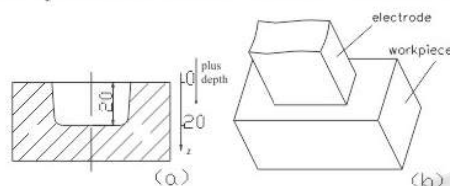
5.2 EDMmachining

Return normal display state; then press  to start machining after all EDM parameters have been set. XH series provides 6 EDM modes to deal with different requirements.

5.2.1 Example for Mode 1 with plus depth

Process a work piece as figure (a): Z axis positive direction is down. Parameters are as following:

EDM DEEP	20 mm
EDM HOME	5mm;
EDM COMP	0.1 mm;

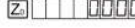


STEPS:

- Set the following parameters in initial system settings;
 - EDM MODE is set as 1;
 - RELY.MODE is set as 0;
 - DEEP.COMP is set as 1, which means the DEEPCOMP is active;
- Return normal display state with the following settings;
 - Display unit is metric;
 - Shrinkage is not taken into consideration;
- Set parameters in EDM function:
 - EDM.DEEP 20mm
 - EDM.HOME 5mm
 - EDM.COMP 0.1mm;

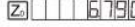
- Move the electrode until it touches the machining plane, as figure (b).

Press **Z0** to zero Z axis display value;

X  20.100 EDM RUN
Y  0000 start machining
Z  0000

- Starting machining.

Press , X window displays the expectant = EDM.DEEP + EDM.COMP, Y window displays the current machined depth,

X  20.100 EDM RUN
Y  0.120 in machining
Z  0.6790

Z window displays the current position of electrode, Message window displays "EDM RUN";

- When Z window displays value = EDM.DEEP + EDM.COMP = 20.1, the buzzer will sound and message window will display "BACKWARD", and then the machining stops and the electrode withdraws.

The actual machined depth is 20mm when Z window displays value = EDM.DEEP + EDM.COMP = 20.1 because of electrode wear.

During electrode withdrawing, Z window displays the current position of electrode, X window displays the preset value (EDM.DEEP + EDM.COMP), Y window displays the formerly preset depth;

The DRO will quit EDM and return normal display state when the electrode withdraws higher than the fireproof height;

The DRO will exit EDM automatically if the electrode doesn't withdraw in 25 seconds.

The LED of  will flash if EDM.COMP is active during machining;

Pressing  can exit EDM in the course of EDM machining;

Note: In the course of EDM, by pressing  or , the operator can temporarily quit EDM function and return normal display state in order to watch the position of X, Y, Z axis. Press  or  again to return EDM function.

5.2.2 Example for Mode 1 with Minus Depth

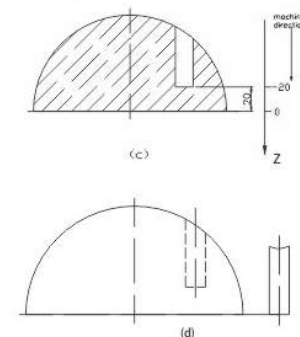
Machine the work-piece as figure (c), Z axis positive direction is down. Parameters as following:

Parameters as following:

EDM.DEEP	-20 mm;
EDM.HOME	55mm;

STEPS:

- Set the following parameters in initial system settings;
 - EDM MODE is 1;
 - RELY.MODE is 0;
 - DEEP.COMP is 0, electrode compensation is disabled;



2. Return normal display state with the following settings:

- Display unit is metric;
- Shrinkage is not taken into consideration;

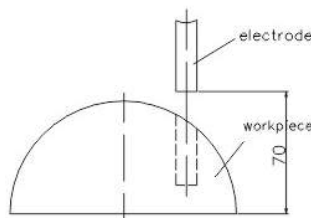
3. Set the parameters in EDM function;

- EDM.DEEP -20mm
- EDM.HOME 55mm

4. Move the electrode until it touches the machining planes as figure (d),

Press  to zero z axis;

Move the electrode to the position as figure (e).



(c)

X: -20000 EDM RUN
Y: -70000 start machine
Z: -170000

X: -20000 EDM RUN
Y: -30000
Z: -134960 in processing

X: -20000 EDM RUN
Y: -20000 EDM end
Z: -120000

X: -20000 BACKWARD
Y: -20000 electrode begin withdrawing
Z: -120000

X: -20000 BACKWARD
Y: -20000 electrode in withdrawing
Z: -130000

X: 00000 EDM 0000
Y: 00000
Z: -170000

5. Starting EDM.

Press ,

X window displays the expectant

= EDM.DEEP + EDM.COMP,

Y window displays the current machined depth;

Z window displays the current position of the electrode,

Message window displays "EDM RUN";

6. When Z axis displays the value = EDM.DEEP = -20.000, the buzzer sounds, message window displays "BACKWARD". Then the machining stops and the electrode withdraw;

During withdrawing the electrode, Z window displays the current position of the electrode, X window displays the preset EDM deep and Y window displays the machined depth;

The DRO will exit the EDM function and return normal display state if the electrode doesn't withdraw in 25 seconds;

The DRO will quit the EDM function when the electrode beyond the fireproof height (EDM.HOME).

Press  to exit the EDM function during machining;

5.2.3 Example for Mode 2

DRO must be connected with the edge detector sensor. Press  to enter EDM, Z axis is zeroed automatically and machining begins when the electrode touches the machining plane. As soon as process to the expected depth, the relay sends out a signal to withdraw the electrode and stop EDM machining. When the electrode beyond fireproof height, move the machine table to next hole to machine another hole without pressing . Mode 2 can process multiple holes conveniently.

Characteristics for MODE 2:

- The DRO connected with sensor which can detect edge and zero display value automatically.
- The DRO needn't exit EDM to machine next hole.
- EDM.DEEP can't be minus;
- Z axis positive direction and machining direction is down;
- The electrode waste is very small and negligible;

Process six holes in one work-piece as figure (f) Z axis direction is down.

Parameters are as following:

A. EDM.DEEP 20.1 mm

B. EDM.HOME 5mm;

Take the mode of detecting and zeroing Z axis automatically.

STEPS:

1. Set the following parameters in initial system settings:

- ① EDM MODE is set 2;
- ② RELY.MODE is set 0;
- ③ DEEP.COMP is set 0, electrode compensation is disabled;

2. Enter the normal display state with the following setting:

- ① Display unit is metric;
- ② Shrinkage is not taken into consideration;

3. Set parameters;

- ① EDM.DEEP 20.100mm
- ② EDM.HOME 5mm

4. Press , the DRO will display as the right.

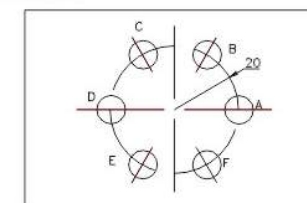
5. By moving the electrode until it touched the machining plane, the z axis will be zeroed automatically.

6. Start EDM

X window displays the expectant = EDM.DEEP;

Y window displays the current machined depth;

Z window displays the current position of the electrode, Message window displays "EDM RUN";



X: 20.100 SCH 00
Y: 00000
Z: -17560

X: 20.100 EDM RUN
Y: 00000 start machining
Z: 00000

X: 20.100 EDM RUN
Y: 8.120 in machining
Z: -16790

X: 20.100 EDM RUN
Y: 20.100 EDM end
Z: 20.100

7. When the Z window displays value= EDM.DEEP= 20.1, the buzzer sounds and the message window displays "BACKWARD", and then the machining stops and the electrode withdraw;

During the electrode withdrawing:

Z window displays the current position of the electrode;
X window displays value=EDM.DEEP+EDM.COMP;
Y window displays the formerly machined depth.

If the electrode doesn't exit in 25 seconds, the DRO will enter the steps to machine another hole by repeating steps 5-7.

If the electrode beyond the fireproof height (EDMHOME), the DRO will enter the steps to process another hole by repeating steps 5~7.

Press to exit EDM when machining completes.

Press to exit EDM during machining.

Note: The LED for flashes during machining if DEEP.COMP is enabled.

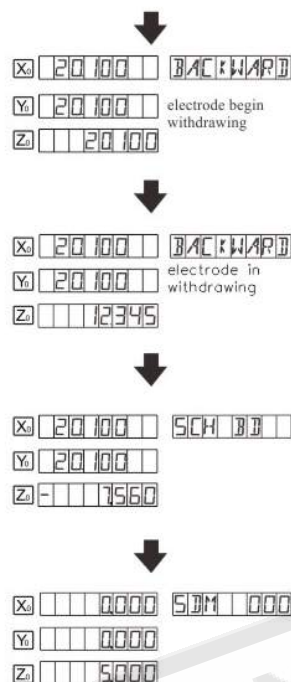
5.2.4 Example for Mode 3

Compared with Mode 1 Mode 3 hasn't the function of fireproof height. DRO can exit EDM only when the electrode goes down again. The datum will not change because z axis is not zeroed again to machine next hole. This mode is only used in case of the electrode waste is too small where waste to be neglected.

Process the work-piece as figure (F) in 5.2.3, Z axis direction is down;
EDM.DEEP 20.100mm

STEPS:

- Set the following parameters in initial system settings;
 - EDM MODE is set 3;
 - RELY.MODE is set 0;
 - DEEP.COMP is set 0, depth compensation is disabled;
- Return normal display state with the following setting;
 - Display unit is metric;
 - Shrinkage is not taken into consideration
- Set parameters in EDM;
 - EDM.DEEP 20.100mm



4. Move the electrode until it touches the machining plane as the figure (b), press to zero z axes;

5. Start EDM. Press ,
X window displays the expectant= EDM.DEEP=20.100,
Y window displays the current machined depth;
Z window displays the current position of electrode;
Message window displays "EDM RUN";

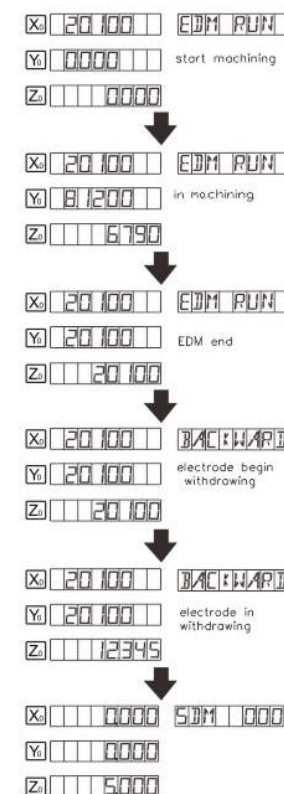
6. When the Z window displays value= EDM.DEEP= 20.100, the buzzer sounds and the message window displays "BACKWARD", then the machining stops and the electrode withdraws.

During the electrode withdrawing:

Z window displays the current position of electrode;
X window displays the preset EDM.DEEP;
Y window displays the former machined depth.

Press to process next hole by repeating the steps 5-6 if the electrode withdraws above datum.

7. Machining is finished, and the electrode goes back to a certain height. Press , MM axis display "EDM RUN".
Press to exit EDM.

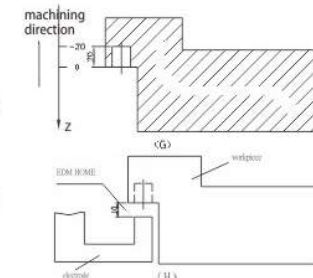


5.2.5 Example for Mode 4 with Minus Depth

MODE 4 has the same steps as MODE 1 and MODE 5 has the same steps as MODE 3. The difference between mode 4 and mode 1, mode 5 and mode 3 is the machining direction when the EDM.DEEP is minus. This difference is shown in table (1). Machine a work-piece as figure (G).

STEPS:

- Set the following parameters in initial system settings;
 - EDM MODE is set as 4;
 - RELY.MODE is set as 0;
 - DEEP.COMP is set as 0, which means DEEP.COM
 - P is disabled;
- Return the normal display state with the following



setting;

- Display unit is metric;
- Shrinkage is not taken into consideration.

3. Set the following parameters in EDM function;

- EDM.DEEP -20mm
- EDM.HOME 10mm

Height of withdrawing is defined as the figure(H)DRO will exit EDM if electrode is below EDM HOME.

4. Move the electrode until it touches the machining plane as figure(I).

Press **[Z0]** to zeroing Z axis;

5. Start EDM.

Press **[FWD]**, then

X window displays the expectant = EDM.DEEP + EDM.COMP;

Y window displays the current machined depth;

Z window displays the current position of electrode

Message window displays "EDM RUN";

6. When the Z window displays the value = EDM.DEEP = -20.000, the buzzer sounds and the message window display "BACKWARD". Then the machining stops and the electrode withdraw.

During withdrawing electrode:

Z window displays the current position of electrode;

X window displays the preset EDM.DEEP;

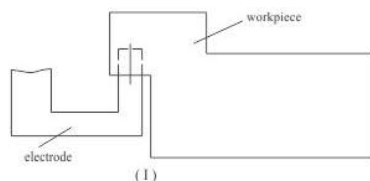
Y window displays the former machined depth;

The DRO will quit EDM and return normal display state automatically if the electrode doesn't exit in 25 seconds.

The DRO will quit EDM function and return normal display state when the electrode withdraw exceeds the height of the withdrawing.

Press **[FWD]** to quit during the machining;

Note: Mode 5 and mode 4 is same if depth is minus. The step of mode 5 is same with mode 2.



(1)

X	-20000	EDM RUN
Y	00000	start machining
Z	10000	

X	-20000	EDM RUN
Y	-10000	in machining
Z	-4560	

X	-20000	EDM RUN
Y	-20000	EDM end
Z	-20000	

X	-20000	BACKWARD
Y	-20000	electrode begin going back
Z	-20000	

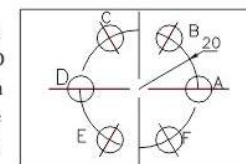
X	-20000	BACKWARD
Y	-20000	in withdrawing
Z	-10000	

X	0000	SDM 000
Y	0000	
Z	-10000	

5.2.6 Example for Mode 6

The operate step and machined work-piece of MODE 6 is the same as MODE 2. The difference between them is Z axis positive direction: in MODE 2, the Z axis' positive direction is down, EDM.DEEP is plus when machining down; in MODE 6, the Z axis' positive direction is up, EDM.DEEP is minus when machining down.

The DRO must be connected with the sensor that can detect edge and zero Z axis' display value automatically. Pressing **[FWD]** to enter EDM function, the display value of Z axis is zeroed and machining began when the electrode touches the machining plane. When the display value of Z axis equals to or larger than the expected depth, the relay sends out a signal to withdrawing the electrode; if the electrode beyond the fireproof height, move the machine table to next hole to machining another hole without pressing **[FWD]**. Mode 6 can process multiple holes quickly.



Running conditions for MODE 6:

- The DRO must be connected with the sensor of an electric edge detector if you want to use automatically detect edge function;
- The DRO doesn't exit EDM after one hole is machined;
- EDM.DEEP can't be plus;
- Z axis direction is up and machining direction is down;
- The electrode wear is very small and can be neglected;

Process six holes in one work-piece as figure (J), Z axis direction is up. Parameters are as following:

EDM.DEEP 20 mm
EDM.HOME 5mm;

STEPS:

1. Set the following parameters in initial system settings;
 - EDM MODE is set 6;
 - RELY.MODE is set 0;
 - DEEP.COMP is set 0: depth compensation is disabled;

2. Return normal display state with the following setting;

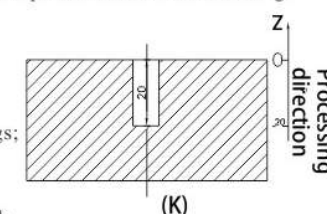
- The display unit is metric;
- Shrinkage is not taken into consideration.

3. Set the parameters in EDM function:

- EDM.DEEP 20.000mm
- EDM.COMP 5mm

4. Press **[FWD]**, enter the EDM function.

5. The DRO displays as the right.



X	-20000	SCH 000
Y	00000	
Z	17560	

X	-20000	EDM RUN
Y	00000	start machining
Z	00000	

Move the electrode until it touches the machining plane as figure (K); display value of z axis is zeroed automatically.

6. Start machining;

X window displays the expectant=EDM.DEEP;
Y window displays the current machined depth;
Z window displays the current position of the electrode;
Message window displays "EDM RUN";

7. When Z window displays the value= EDM.DEEP= 20.000, the buzzer sounds and the message window displays "BACKWARD", and then the machining stops and the electrode withdraw.

During withdrawing electrode :

Z window displays the current position of the electrode;
X window displays the preset value=EDM.DEEP+ EDM.COMP;
Y window displays the formerly preset depth;

If the electrode doesn't exit in 25 seconds; the DRO will machine another hole by repeating steps 5~7.

When the electrode withdraw beyond fireproof (EDM. HOME), the DRO will machine another hole by repeating steps 5~7.

Press  to quit EDM when machining completes.

Press  to quit EDM during machining.

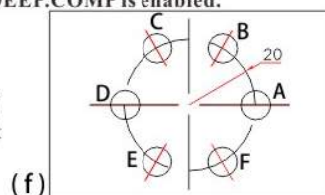
Note: The LED for  flashes during machining if DEEP.COMP is enabled.

5.2.7 Example for Mode 7

The operate step and machined work-piece of MODE7 is alike as MODE 5. The difference is that DRO must detect edgewise entering EDM function in MODE 7.

Process work-piece as figure (f): Z axis direction is down. Parameters are as following:

EDM.DEEP 20.100mm
EDM.HOME 5.000mm;



STEPS:

- Set the following parameters in initial system settings;
 - EDM MODE is set 7;
 - RELY.MODE is set 0;
 - DEEP.COMP is set 0, depth compensation is disabled;

- Return normal display state with the following setting;
 - The display unit is metric;
 - Shrinkage is not taken into consideration.

- Set the parameters in EDM function:
 - EDM.DEEP 20.100mm
 - EDM.COMP 5mm

- Press , the DRO displays as the right.

Move the electrode until it touches the machining plane, display value of Z axis is zeroed automatically.

Or you can zero the Z axis by press the key .

Press , X window displays the expectant = EDM.DEEP = 20.100,

Y window displays the current machined depth;

Z window displays the current position of the electrode;

Message window displays "EDM RUN";

- When Z window displays the value= EDM.DEEP= 20.100, the buzzer sounds and the message window displays "BACKWARD", and then the machining stops and the electrode withdraw.

During withdrawing electrode :

Z window displays the current position of the electrode;

X window displays the preset value = EDM.DEEP+ EDM.COMP;

Y window displays the formerly preset depth;

When the electrode beyond fireproof height (EDM. HOME), the message window displays "EDM RUN" and the DRO will machine the next hole by repeating steps 4.

- Press  to quit EDM when machining completes which in Message window displays "EDM RUN".

X -20000 EDM RUN
Y 0000
Z 0000
SCH 000

X -20000 EDM RUN
Y 0000 start machining
Z 0000

X -20000 EDM RUN
Y -8.120 in machining
Z -006790

X -20000 BACKWARD
Y -20000 electrode begin going back
Z -0020000

X -20000 BACKWARD
Y -20000 going back
Z -002345

X 20.100 SCH 000
Y 20.100
Z -0017560

X 0000 SCH 000
Y 0000
Z 0000

5.3 Combination of BHC:BHL and EDM Function

XH Series can use EDM to machine holes when in BHC or BHL function.

Example: Process 6 holes with depth of 20mm as the figure(L) showing.

STEPS:

1. Set the following parameters in initial system setting:

EDM.MODE = 1;

RELAY.MODE = 0;

EDM.COMP = 0;

2. Set EDM.DEEP= 20mm; EDM.HOME =3mm;

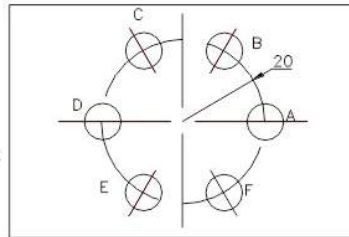
3. Set point O as datum in user coordinate system;

4. Press  to enter BHC function and set parameters:

ST.ANGLE=0°; END.ANGLE=0°;

RADIUS=20mm; HOLE.NUM=6;

DIRECTION=0;



5. After all parameter set, the message window will display "HOLE 1". Move the machine table until "0.000" displays in X, Y window; it is the position of point A. And then press  to enter EDM function to process hole A. After hole A is machined, DRO returns BHC.

6. Process hole B.

Press  and the message window will display "HOLE 2". Move the machine table until "0.000" displays in X, Y window; it is the position of point B. And then press  to enter EDM function to process hole B. After hole B is machined, DRO returns BHC.

7. Process hole C, D, E, F in the same way.

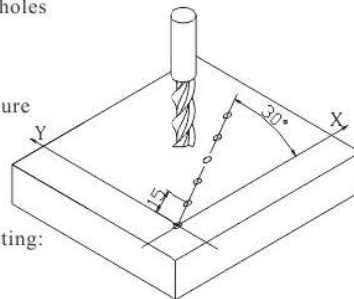
Press  to return normal display state when all holes finished.

Example 2: Process 6 holes with depth 10mm as the figure showing.

STEPS:

1. Set the following parameters in initial system setting:

EDM MODE = 1,



RELAY MODE = 0,

EDM COMP = 0;

2. Set EDM.DEEP 10mm; EDM.HOME 3mm;

3. Set the point O as datum for user coordinate system;

4. Press  to enter BHL function and set parameters:
LINE.DIS=150mm; LINE.ANG=30
HOLE.NUM=6

5. After all parameter setting, the message window will display "HOLE 1". Move the machine table until "0.000" displays in X, Y window; it is the position of centre of the first hole. And then press  to enter EDM function to process hole 1. After hole 1 is machined, DRO returns BHC.

6. Press hole 2;

Press  and the message window will display "HOLE 2". Move the machine table until "0.000" displays in X, Y window; it is the position of centre of the second hole. And then press to  enter EDM function to process hole 2. After hole 2 is machined, DRO returns BHL.

7. Process other holes in the same way.

Press  to return normal display state when all holes are machined.

Chapter 6 CALCULATOR FUNCTION

XH provides arithmetic operation such as plus, minus, multiply and divide, which convenient for operator to processing work piece according to the drawing.

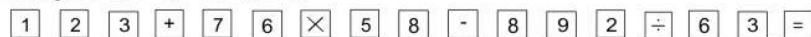
6.1 Enter and exit Calculator Function

In normal display state: press  to enter calculator function

In calculator state: press  to exit calculator function

6.2 Calculating Example

Example 1: $123 + 76 \times 58 - 892 / 63$



Example 2: $358 + 456 \times \sin^{-1}(-0.5)$



Note:

1. If incorrect data is inputted, press  to cancel and input again.
2. Error would occur when calculating incorrectly, such as "0" is used as divisor or proceeding arcsine when absolute value is more than 1. In this case, the message window will display "ERR..." You can cancel this error message by pressing  and input data again.
3. The absolute value of inputted data and calculated result should be in the range of 0.000001 to 9999999, otherwise it can't be displayed.

6.3 Transferring the Calculated Results to Selected Axis

After calculating is finished, user can

After calculating is finished, user can

press  to transfer the calculated result to X axis, then the X window will display this value;

press  to transfer the calculated result to Y axis, then the Y window will display this value;

press  to transfer the calculated result to Z axis, then the Z window will display this value;

6.4 Transferring the Current Display Value in Window to Calculator

In calculator state:

Press  to transfer the display value in X window to calculator.

Press  to transfer the display value in Y window to calculator.

Press  to transfer the display value in Z window to calculator.

Chapter 7 INITIAL SYSTEM SETTINGS

Function:

Set various parameters according to actual operation.

Parameter Items:

SEL SYS	Setting the number of linear scale
DIRECT	Setting positive direction for counter
LIN COMP	Setting linear compensation
R OR D	Radius/Diameter Mode
Z DIAL	Setting Z axis Dial
RESOLUTE	Setting the resolution of scale
RELAY.MODE	Setting relay mode
EDM MODE	Setting EDM mode
SDM DIR	Setting the input mode of SDM
ERROR	Enable / Disable error message display
SHRINK	Setting shrinkage ratio
DEEP.COMP	Enable/Disable the electrode compensation
SLOP.MODE	Setting the slope machining mode
LATH.MODE	Setting the lathe mode
RI MODE	Setting RI mode
AUTO. SCH	Detecting the edge automatically or not
AXIS.TYPE	Setting the type of axis
STEP.MODE	Select the step mode in ARC processing
ANGLE.MODE	Select the angle display mode
ANGLE.TYPE	Select the angle display type
ALL CLS	Clearing all customer settings

NOTE: what you have changed (except "ALL.CLS") would not be saved if you quit "SETUP" (initial system settings) without selecting "EXIT" item.

7.1 Enter/Exit Initial System Settings

Press **ENTER** to enter initial system setting after DRO powers on in 1 second: then "SETUP" displays in message window.

Press or to select the item you want to change.

If you want to quit initial settings: press  or  until "EXIT" appears in message window and press .

X_0 Y_0 Z_0 SETUP

X ₀							
Y ₀							
Z ₀							

7.2 Setting the type of DRO

Because XH series DROs (two axes or three axes DRO) share the same software and their functions have some differences. DRO type must be set before use. ALL CLS has no effect on type of DRO.

1. Enter "SETUP" and press  or  until "SEL SYS" appears in message window;
2. Press , then Y window displays "2" or "3".
"2" means the DRO type is XH-2;
"3" means the DRO type is XH-3.
3. If press , Y window displays "2";
If press , Y window displays "3";
4. Press  to save your selection and exit this item;
Press  to cancel your operation and exit this item;

X ₉	[] [] [] [] [] [] []	S E L S Y S
Y ₆	[] [] [] [] [] [] []	
Z ₈	[] [] [] [] [] [] []	

X ₀							INPUT NUM
Y ₀						2	
Z ₀							

X ₀								INPUT NUMBER
Y ₀							3	
Z ₀								

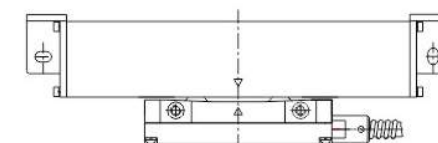
[illegible]

7.3 Setting Positive Direction for Counter

If the linear scale is installed as the figure

(facing operators):

Direction "0" means the display value will increase when scale moves from right to left and decrease when scale moves from left to right.



Direction "1" means the display value will increase when scale moves from left to right and decrease when scale moves from right to left.

The counting direction of the scale is set by the erector, and the operator had better not change it.

Default: 0

STEPS:

1. Enter "SETUP" and then press  or  until "DIRECT" appears in message window.

2. Press **ENTER** to enter direction setup;
X window, Y window and Z window display "0" or

X ₀							DIRECT		
Y ₀									
Z ₀									

[illegible]

"1" separately. "0" means the opposite counter direction for "1", in other words, "0" means A signal exceed B signal and the counts increase during counting. Vice bversa. Message window displays "SEL AXIS", which means the next step is to select axis.

3. Select axis

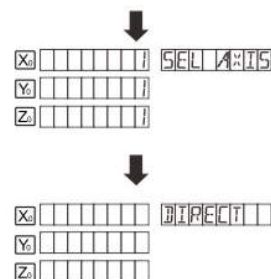
Press **X** to change X axis counting direction;

Press **Y** to change Y axis counting direction;

Press **Z** to change Z axis counting direction;

4. Press **ENTER** to confirm your selection and exit.

Press **AC** to cancel your change and exit.



7.4 Setting Linear Compensation

Definition

Linear error: There is always an error between actual measure value and standard value. If it is distributed around the scale travel linearly, the error is defined as linear error. For example, the scale valid length is 400mm. if the measure value is 400mm and the standard value is 400.040mm: There is a ΔL of 40 μ m. If 40 μ m is distributed around the scale linearly, there is a ΔL of 10 μ m when the scale travels 100mm; a ΔL of 20 μ m when the scale travels 200mm; a ΔL of 30 μ m when the scale travels 300mm.

Linear compensation: Compensate the linear error to make display value equals to standard value.

NOTES: The linear compensation is set by erector. Operator had better not change it, or the accuracy of linear scale will be worse.

Default coefficient: 0

The calculation of compensation coefficient:

$$\text{coefficient} = \frac{(\text{measurement} - \text{standard value}) \times 1000,000}{\text{standard value}}$$

Example:

Measurement 400.000mm

Standard value 400.040mm

Compensation value $(400.000 - 400.040) \times 1000,000 / 400 = -100$

Unit: μ m/m;

Set linear error compensation: X axis is 100; Y axis is 50; Z axis is -100.

STEPS:

1. Enter "SETUP", then press **↑** or **↓** until message window displays "LIN COMP".

2. Press **ENTER**

X window, Y window, Z window displays the former linear error compensation coefficient separately. Message window displays "SEL AXIS" which indicates that the next step is to select axis.

3. Select axis

Press **X** to select X axis.

Note: Press **X to select X axis. Data in X window flashes which indicating that you can input the linear error compensation for X axis;**

Press **Y to select Y axis. Data in Y window flashes which indicating that you can input the linear error compensation for Y axis;**

Press **Z to select Z axis. Data in Z window flashes which indicating that you can input the linear error compensation for Z axis;**

Message window displays "ENTR.PPM", indicating it is waiting for a data to be inputted.

4. Press **1 0 0 ENTER** in turn;

If incorrect number is input, press **AC** to cancel and input again.

5. Input the error compensation coefficient for Y axis;

Press **Y 5 0 ENTER** in turn;

Input the error compensation coefficient for Z axis;

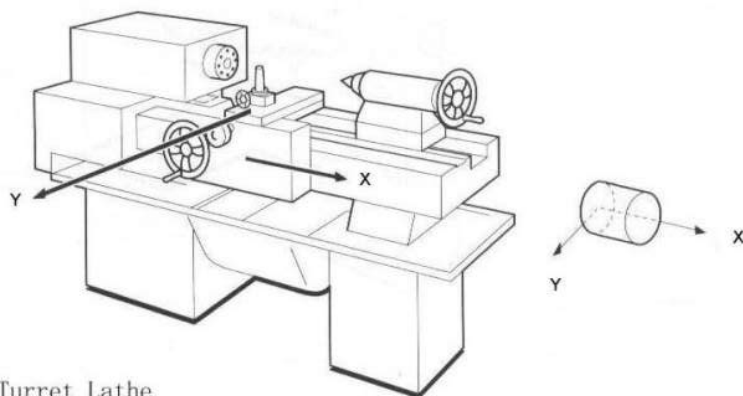
Press **Z 1 0 0 $\frac{1}{2}$ ENTER** in turn.

6. Press **ENTER** to confirm your setting and exit linear error compensation setup.

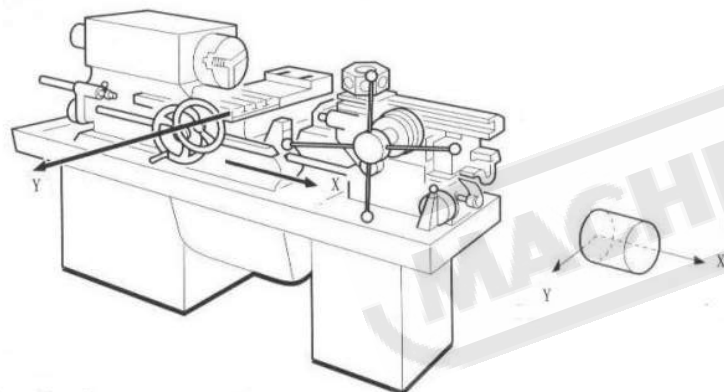


7.5 Toggle Between R/D Display Mode

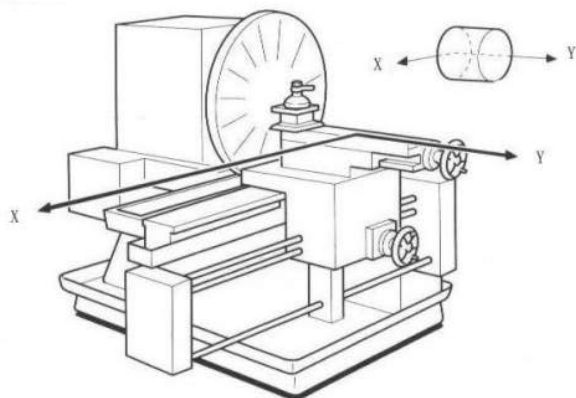
Center Lathe



Turret Lathe



Face Lathe



In common case, the display value is the distance between lathe tools and the coordinate origin. This display mode is called MODE R. When process cylinder given diameter measurement, diameter is the double distance between lathe tool and coordinate datum. The DRO will display the diameter in MODE D

Default mode: mode R.

STEPS:

1. Enter "SETUP" and press or until the message window displays "R OR D";
 2. Press

X window, Y window and Z window displays "0" or "1" separately.

"0" is mode R, which means the display value equals the actual measurement. "1" is mode D where the display value equals the double actual measurement.

Message window displays "SEL AXIS", which indicates the next step is to select axis;
 3. Select axis

Press to change the R/D mode of X axis;

Press to change the R/D mode of Y axis;

Press to change the R/D mode of Z axis;
 4. Press to save your change and exit;
- Press to save your change and exit;

X000000 R OR D
Y000000
Z000000



X000000 SEL AXIS
Y000000
Z000000



X000000 SEL AXIS
Y000000
Z000000



X000000 R OR D
Y000000
Z000000

7.6 Setting Z axis Dial

Z axis Dial should be set if Z axis is emulated for WE6800-2 and only install linear scale for X, Y axis.

Z axis Dial means the distance the Z axis travels when screw runs a revolution.

Default value: 2.5mm

Set Z axis Dial 2.4 mm:

1. Enter "SETUP", then press or until message window displays "Z DIAL";
2. Press

Y window displays the former Z axis Dial;

Message window displays "Z DIAL";

X000000 Z DIAL
Y000000



X000000 Z DIAL
Y000000

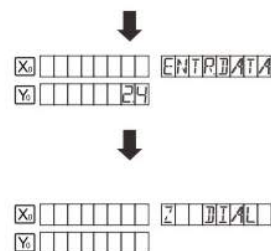


3. Input the Z axis Dial;

Press **[2] [.] [4]** in turn to input Z axis Dial;

If incorrect data has been inputted, press **[AC]** to cancel and input again;

If a minus has been inputted, the DRO will accept its absolute value instead.

4. Press **[ENTER]** to confirm your setting and exit Z DIAL setup.

7.7 Setting the Resolution of Scale

Different scale has different resolution. WE6800 DRO can connect with 10 kinds of scale, and these resolutions are 0.05μm, 0.1μm, 0.2μm, 0.5μm, 1μm, 2μm, 5μm, 10μm, 20μm, 50μm. The resolution must be set to match the linear scale. This parameter is set by erector, operator had better not change it.

Default resolution: 5μm

Set the resolution of X axis, Y axis, Z axis as 1μm.

STEPS:

1. Enter "SETUP" and press **[↑]** or **[↓]** until "RESOLUTE" appears in message window;



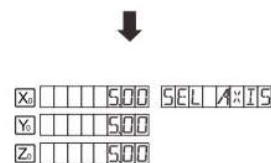
2. Press **[ENTER]**,

X window, Y window and Z window displays the former resolution of each axis separately. Message window displays "SEL AXIS", which indicates the next step is to select axis.



3. Select axis.

Press **[X]** to change the resolution of X axis, then data in X windows flashes.



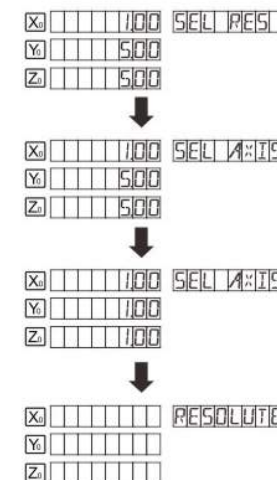
Press **[Y]** to change the resolution of Y axis, then data in Y windows flashes.



Press **[Z]** to change the resolution of Z axis, then data in Z windows flashes.



4. Press **[↑]** or **[↓]** to scroll through 0.05, 0.10, 0.20, 0.50, 1.00, 2.00, 5.00, 10.00, 20.00, 50.00. Press **[ENTER]** to select "1.00" when it appears and return "SEL.RXIS" state. Press **[AC]** to cancel your selection.

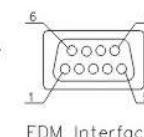


5. Set the resolution of Y axis: Z axis by repeating step 3-4.

6. Press **[ENTER]** to exit "RESOLUTE" setup.

7.8 Setting Relay Mode

The relay will send out an ON/OFF signal when process to target position. EDM.Relay interface has three pins: common, normal close and normal open. XH series provides four Relay modes. Operator can set it according to your circuit.



Normal close and common pin:

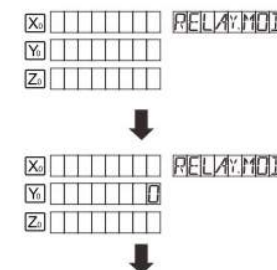
PIN	NAME	COLOR
1	NC	
2	COMMON	ORG
3	NORMAL CLOSE	BRW
4	NC	
5	IN+	RED
6	NORMAL OPEN	YEL
9	IN-	BLK

MODE	Power ON	ENTER EDM	PROCESS TO TARGET POSITION	EXIT EDM	Power off
1	close	close	open	close	open
2	open	open	close	open	open
3	close	open	close	close	open
4	open	close	open	open	open

Default value: MODE 2.

STEPS:

1. Enter "SETUP", then press **[↑]** or **[↓]** until the message window displays "RELAY.MOD";



2. Press **[ENTER]**, then the Y window displays "0" or "1";

3. Press or to set the RELAY MODE.

X RELAY MODE
Y
Z

4. Press to confirm your setting and exit

"RELAY.MODE";

Press to cancel your change and exit

"RELAY.MODE".

X RELAY MODE
Y
Z

7.9 Setting the EDM Mode

XH series provides 7 EDM modes. For detail information, please refer to chapter five. EDM mode must be set before EDM machining.

Default mode: MODE 1.

Set the EDM mode to mode 3.

STEPS:

1. Enter "SETUP" then press or until message window displays "EDM MODE";

X EDM MODE
Y
Z

2. Press , then Y window displays the former EDM mode;

X SEL MODE
Y
Z

3. Press to change the mode;
Press the number key which you want to set the mode.

X SEL MODE
Y
Z

4. Press to confirm your setting and exit
"EDM.MODE" setup.

X EDM MODE
Y
Z

Press to cancel your change and exit "EDM.MODE" setup;

7.10 Setting the Input Mode in SDM Coordinate

XH series DRO provides two inputting data mode in SDM coordinate:

MODE 0 (Normal inputting mode): the data the DRO accept equals the inputted data;

MODE 1 (Special inputting mode): the data the DRO accept equals the negative of the inputted number.

Example: Set SDM mode 1.

1. Enter "SETUP" then press or until the message window displays "SDM DIR";

X SDM DIR
Y
Z

2. Press , Y window displays the former SDM mode;

X SDM DIR
Y
Z

3. Press to set the SDM mode 1;

NOTE: press to set the SDM mode 0.

X SDM DIR
Y
Z

4. Press to confirm your setting and exit
"SDM.MODE".

X SDM DIR
Y
Z

Press to cancel your change and exit "SDM.MODE".

7.11 Enable / Disable ERROR Signal

XH serial DRO provides the function of checking whether the counting signal is normal or not.

It can display the ERROR information if some error occurs in counting signal. User can enable or disable this function.

"0" means no error information will be displayed and the DRO continue to work when there is some wrong with linear scale or encoder.

"1" means error information will be displayed when error occurs.

Default setting: 0 (disable display error message).

Example: Enable display ERROR message.

STEPS:

1. Enter "SETUP" then press or until "ERROR" message window displays "SDM DIR";

X ERROR
Y
Z

2. Press , Y window displays the former "0";

X ERROR
Y
Z

3. Press to change it to enable error message;

X ERROR
Y
Z

Note: press to change to disable error message.

7.15 Setting Lathe Mode

Lathe mode 0: Disable lathe function;

Lathe mode 1: X window display value = the position of X axis + the position of Y axis;

Lathe mode 2: X window display value = the position of X axis + the position of Z axis;

Default mode: disable lathe mode.

Set the lathe as mode 1.

STEPS:

1. Enter "SETUP" and press  or  until the message window displays "LATH.MODE";

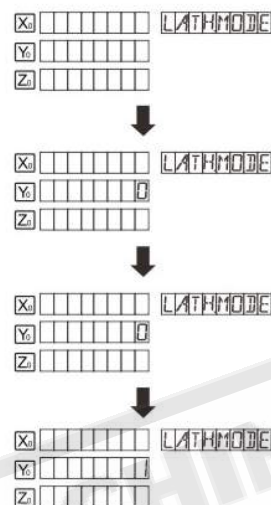
2. Press ,
then the Y window displays the former lathe mode;

3. Set the new lathe mode;

Press 

Note: press  or  or  to change the lathe mode.

4. Press  to confirm your change and exit "LATH.MODE".



7.16 Setting RI MODE

XH series provides 8 RI modes: mode 1 to mode 8, every mode has its corresponding wave of A, B and RI.

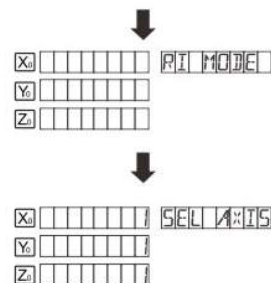
Default mode: MODE 1

Set RI MODE 5 for X axis .

STEPS:

1. Enter "SETUP", then press  or  until the message window displays "RI MODE";

2. Press ,
X window, Y window and Z window displays the former RI mode respectively, message window displays "SEL AXIS" which indicating the next step is to select axis;



3. Select axis;

Press  to change RI mode of X axis. The number in X window flashes;

Press  to change RI mode of Y axis, and the data in Y window flashes;

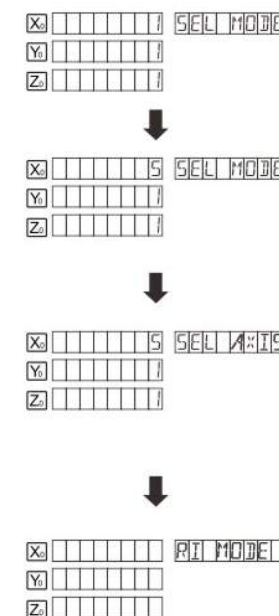
Press  to change RI mode of Z axis, and the data in Z window flashes;

4. Press  or  then "1", "2", "3", "4", "5", "6", "7", "8" will be displayed in turn;

When "5" is displayed in message window, press  to change RI mode and return "SEL.AXIS" state.

Press  to cancel your selection and return "SEL.AXIS" state.

5. Press , to exit "RI.MODE" setup.



7.17 Enable/Disable Edge Detection

Function: XH series DRO can zero Z axis display value in normal display state when an external signal is detected if edge detection is enabled

0: Edge detection is disabled, The DRO doesn't zero Z axis display value in normal display state when external signal detected.

1: Edge detect is enable. The DRO zeroes Z axis display value in normal display state when an external signal is detected.

Default value: 0 (edge detection is disable)

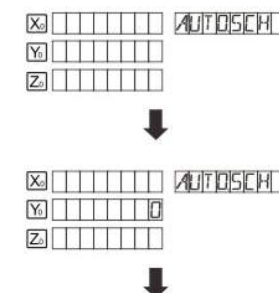
Example: Enable edge detection

STEPS:

1. Enter "SETUP", then press  or  until message window displays "AUTO.SCH";

2. Press , then Y window will display the former setting;

3. Press , to enable edge detects;



Note: press **0** to disable edge detects

X										AUTOSCH
Y										
Z										



X										AUTOSCH
Y										
Z										

4: Press **ENTER** to confirm your selection and exit.

7.18 Toggle between Linear Scale and Rotary Encoder

Both linear scale and rotary encoder can be installed in any axis. The linear scale is used to measure distance; the rotary encoder is used to measure angle.

Default: linear scale.

Set rotary encoder in Z axis.

STEPS:

1. Enter "SETUP" and press **↑** or **↓** until the message window displays "AXIS.TYPE";

X										AXIS TYPE
Y										
Z										



2. Press **ENTER**:

X, Y, Z window displays the former type.

"LINEA" means linear scale.

"ENCODE" means rotary encoder.

Message window displays "SEL AXIS", which means the next step is to select axis.

X										SEL AXIS
Y										
Z										



3. Set Z axis are installed with rotary

Press **Z** until display in Z window is "ENCODE";

X										SEL AXIS
Y										
Z										



X										AXIS TYPE
Y										
Z										

4. Press **ENTER** to confirm your new set and exit.

Press **AC** to cancel your new set and exit.

7.19 Step Mode of ARC

In ARC function, if the plane is not XY, you can setup the step mode. There are two modes. Mode 0 is Z STEP mode and Mode 1 is MAX CUT mode.

Default setting: Z STEP.

For example, set the mode as STEP mode.

STEPS:

1. Enter "SETUP" and press **↑** or **↓** until the message window displays "STEP. MODE";

X										STEP MODE
Y										
Z										



X										SEL MODE
Y										
Z										



X										SEL MODE
Y										
Z										



X										STEP MODE
Y										
Z										

2. Press **ENTER**

Y window displays the former setting.

"0" means Z STEP;

"1" means MAX CUT;

The message window displays "SEL MODE", which means selecting step mode of ARC next step.

3. Set mode as STEP mode.

Press **1**, then Y window displays the changed mode.

4. Press **ENTER** to confirm your change and exit "STEP.MODE".

Press **AC** to cancel your new set and exit.

7.20 Angle Display Mode

XH series provides 3 angle display modes. In Mode 1, the angle is in the range of 0° to 360° ; in mode 2, the angle is in the range of -360° to 360° ; and in mode 3, the angle is in the range of -180° to 180° . Default mode: MODE 1.

Set the EDM mode as mode 2.

STEPS:

1. Enter "SETUP", then press **↑** or **↓** until message window displays "ANGL. MODE";

X										ANGL MODE
Y										
Z										



2. Press **ENTER**, then Y window displays the former angle mode;

The message window displays "SEL MODE", which means to select angle display mode next step.

X										SEL MODE
Y										
Z										



X										SEL MODE
Y										
Z										



3. Set the angle display mode as mode 2.

Press **2** then the Y window displays the changed mode;

4. Press **ENTER** to confirm your setup and exit "ANGLE.MODE" setup.

X0										ANGLMODE
Y0										
Z0										

Press **AC** to cancel your change and exit "ANGL.MODE" setup;

7.21 Angle display type

There are two angle display types for XH series.
 TYPE 0: indicate angle display is DD.
 TYPE 1: indicate angle display is DMS.
 Default value: TYPE 0.

Set the angle display type as DMS.

Steps:

- 1: First enter "SETUP", press **↑** or **↓** until the message window display "ANGE.TYPE".

X0										ANGLTYPE
Y0										
Z0										

- 2: Press **ENTER**
 Y window display the former setup.
 Z window display the former angle mode is DD.

X0										ANGLTYPE
Y0										0
Z0										- - - - -

- 3: Set the angle display mode as MODE1.
 Press **1**, Y window display the changed mode,
 Z window display current mode is DMS

X0										ANGLTYPE
Y0										1
Z0										- - - - -

- 4: Press **ENTER**, the new setup has been saved and exit this setup.
 Press **AC**, exit this setup and the setup unsaved.

X0										ANGLTYPE
Y0										
Z0										

7.22 Load default setup

Function: Clear all data except the linear compensation and DRO type. DRO will load default setup for all parameters. After loading default setup, user must search RI once to enable resuming ALE datum function; otherwise to resume the datum by RI is unable.

STEPS:

1. Enter "SETUP", then press **↑** or **↓** until the message window displays "ALL CLS";

X0										ALLCLS
Y0										0
Z0										

2. Press **ENTER** and message windows display "PASSWORD" indicating the operator to input password. At this moment, there are two selections:

- A Press **AC** to quit "ALL.CLS";
 B Enter the correct password to clear all parameters and load default setup;

X0										PASSWORD
Y0										0
Z0										

3. Input the password;

Press **1 9 9 9 ENTER** in turn to load default value.

The message window displays "WAITING", which means the clearing is going on.

X0										PASSWORD
Y0										1999
Z0										

X0										WAITING
Y0										
Z0										

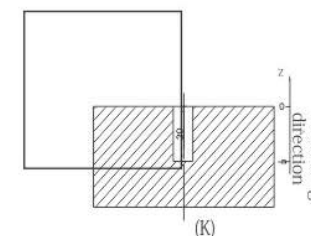
4. Return normal display state after loading default setup is finished.

X0										ALLCLS
Y0										
Z0										

The default setup for all parameters is as following:

- Counting direction is mode 0;
- The R/D is mode R ;
- Z DIAL = 2,5mm;
- Resolution = 5 μ m;
- EDM mode is MODE 1;
- Relay mode is mode 0;
- Shrinkage ration 1.000;
- Input mode in SDM as 0, display value = input value;
- Deep compensation is disabled;
- Lathe function is disabled;
- Slope machining parameter is Z step;
- RI MODE is mode 8;
- Disable the edge detection;
- Linear scale is installed for any axis;
- Angle display mode is mode 1: 0~360;
- Angle display type is 0: DD;
- ARC machining parameter is Z step.

Chapter 8 TROUBLE SHOOTING



The following are the easy solvent for troubleshooting. If they can not work: please contact with distributor for more service.

Trouble	Possible Reason	Solvent
No display	A The DRO isn't powered. B AC power voltage is not in the range of 100V to 240V.	A Check the fuse is OK or not. B Check the socket is loose. C Check the input power voltage is in the range of 100V to 240V.
Cover is charged	A Poor grounding is float B Leakage of electricity	Check the lathe and DRO are well grounded.
Display value is doubled	A Improper resolution B Display mode D	A Set proper resolution. B Set display mode R.
No counting	A Poor contact of scale B No scale signal output C Useless of counting function	Exchange scale and check again.
Display value is in disorder	Memory is disorder	A Clear system. B Check compensation is proper.
Erroneous counting	A Poor precision of lathe B Too fast run speed of the lathe C Proper scale precision D Improper resolution is set E Improper linear error compensation F Useless of scale	A Repair lathe. B Reduce the move speed of scale. C Reinstall scale. D Set proper resolution. E Set proper linear error compensation. F Repair or exchange linear scale.