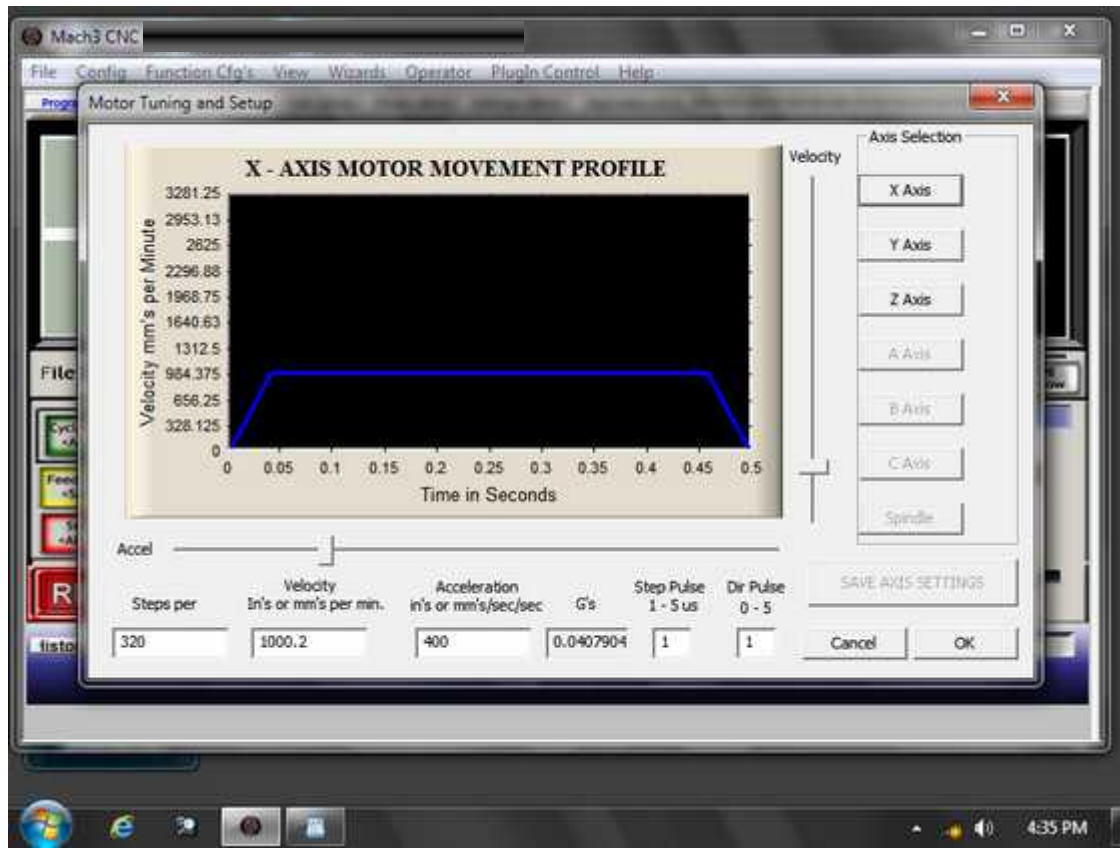
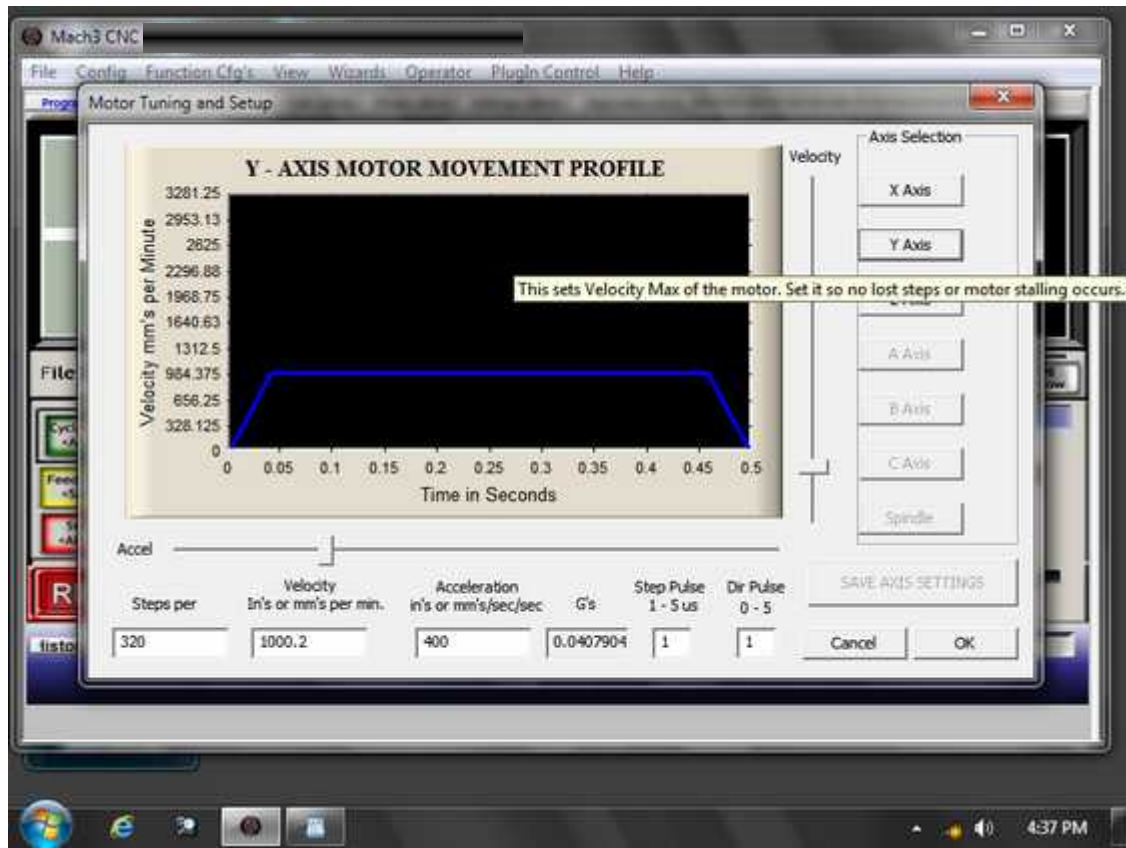


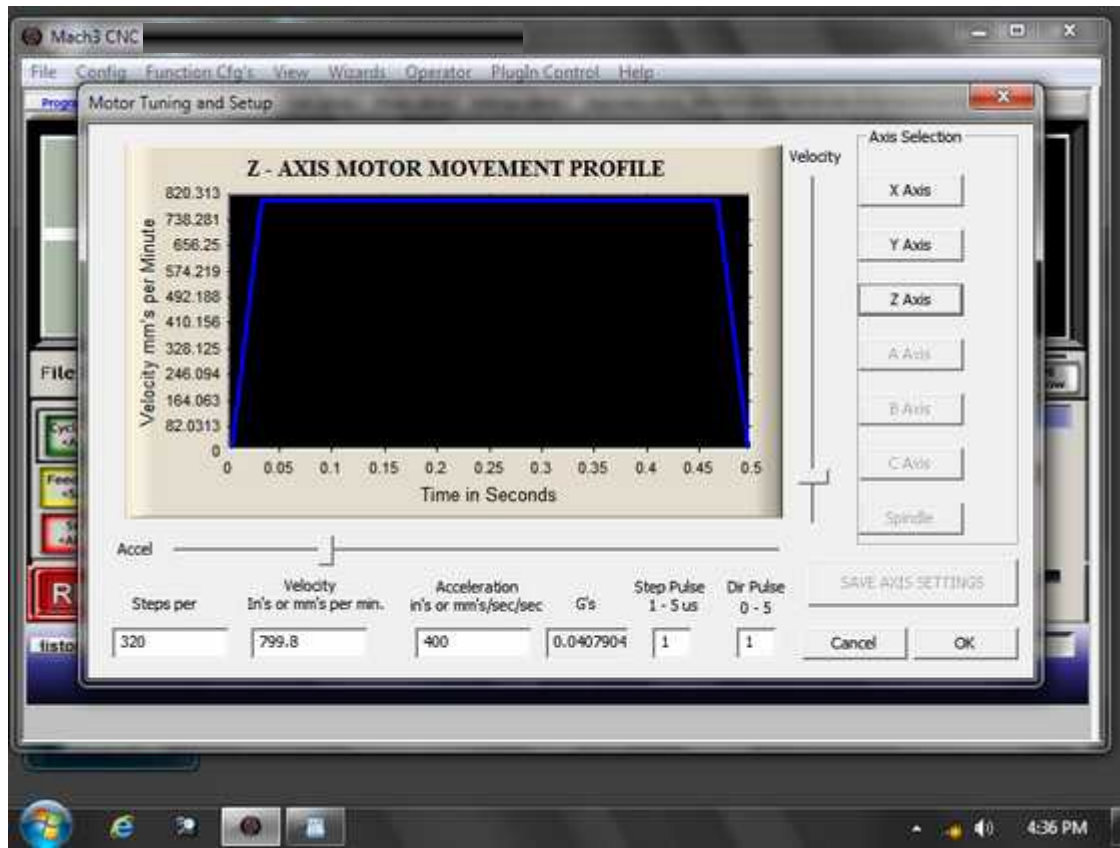
Screen Captures of MACH 3 Motor Tuning and Setup for my CNC Router as at March 2013



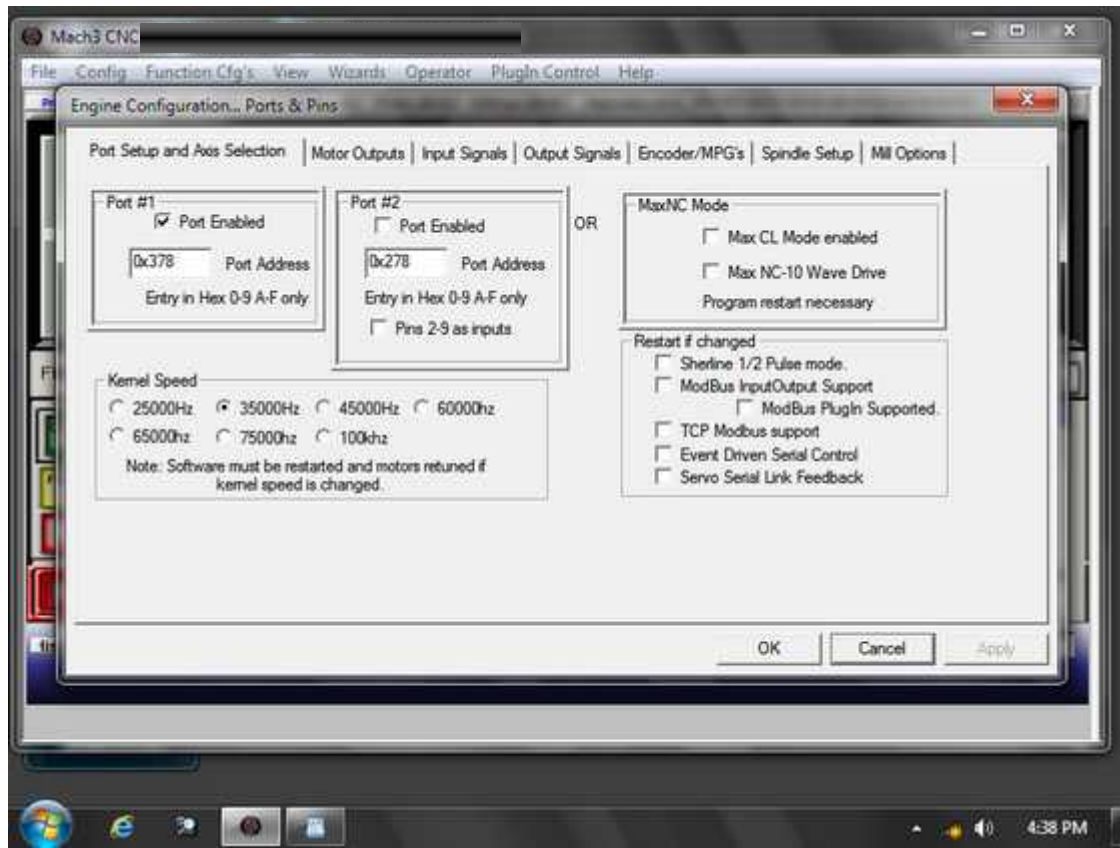
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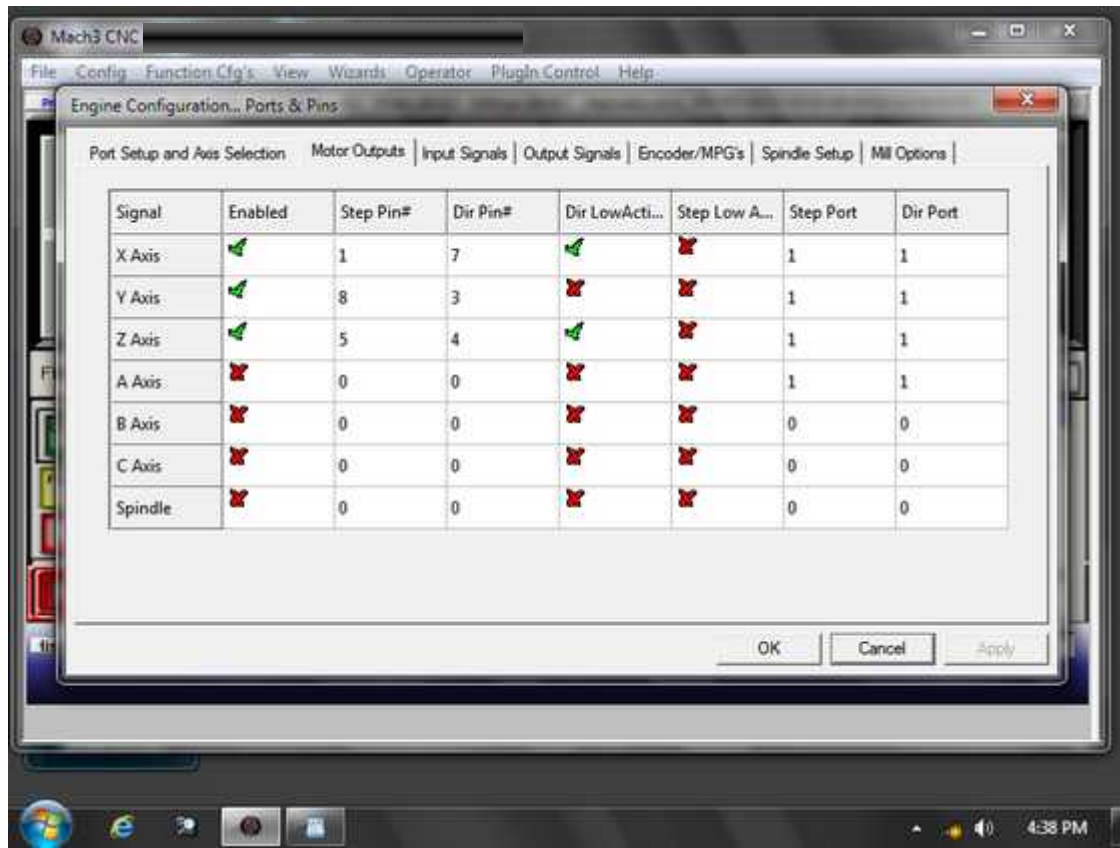
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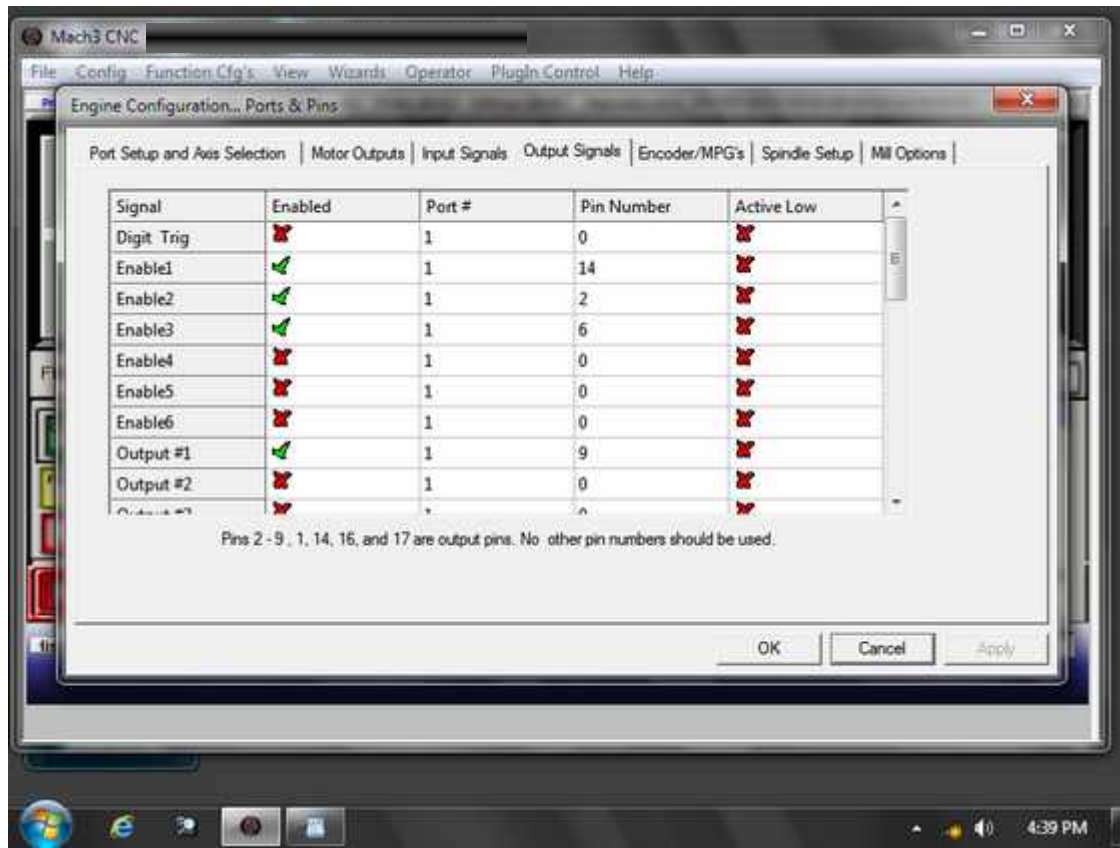
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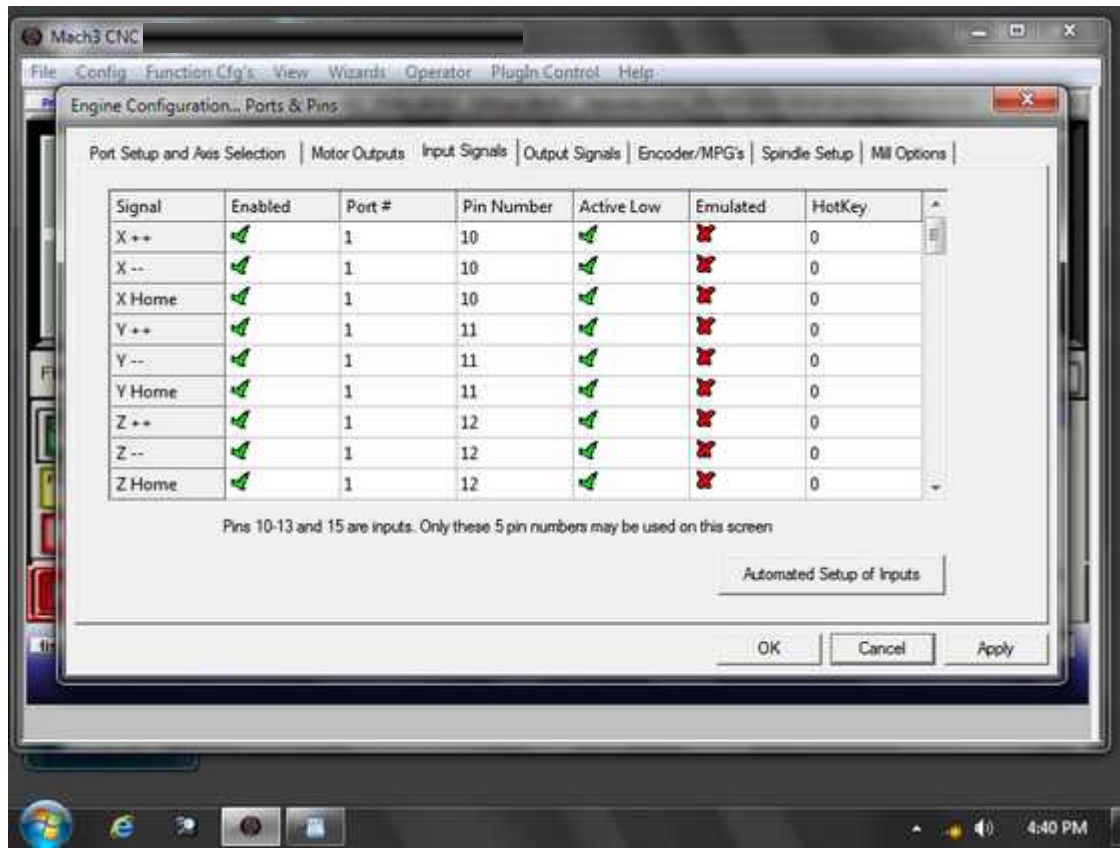
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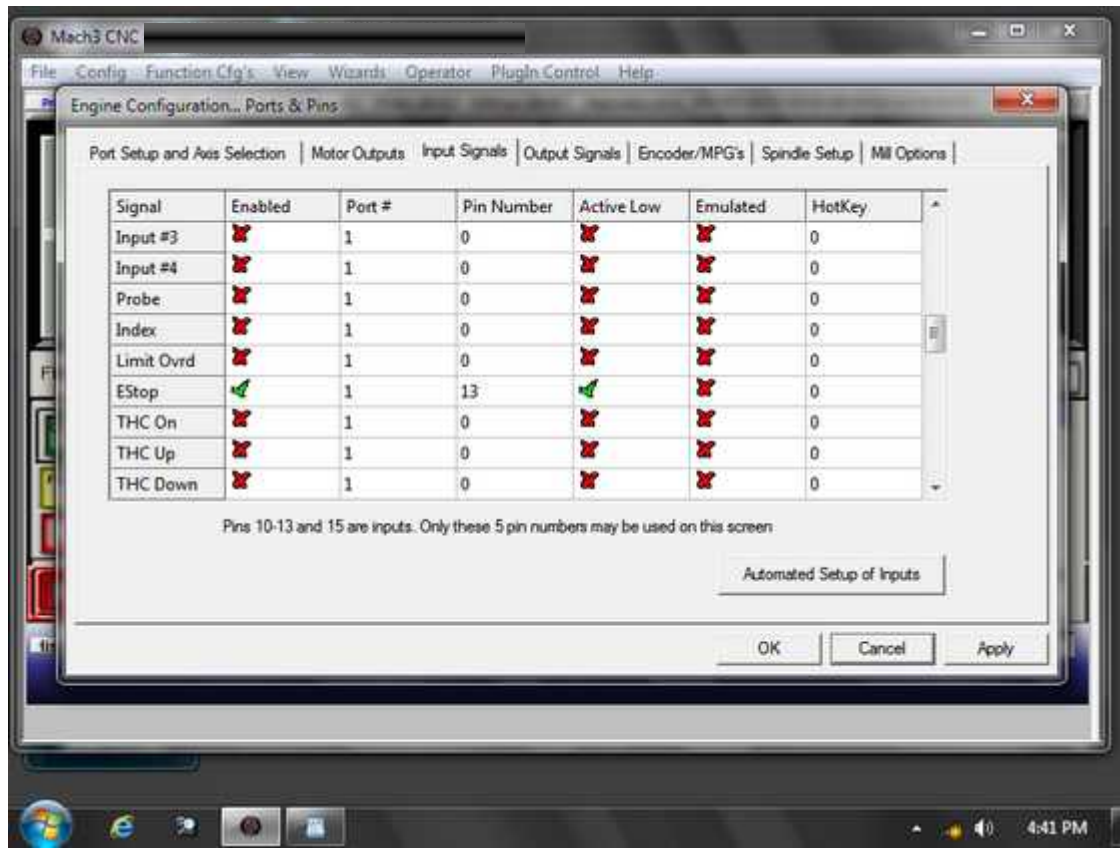
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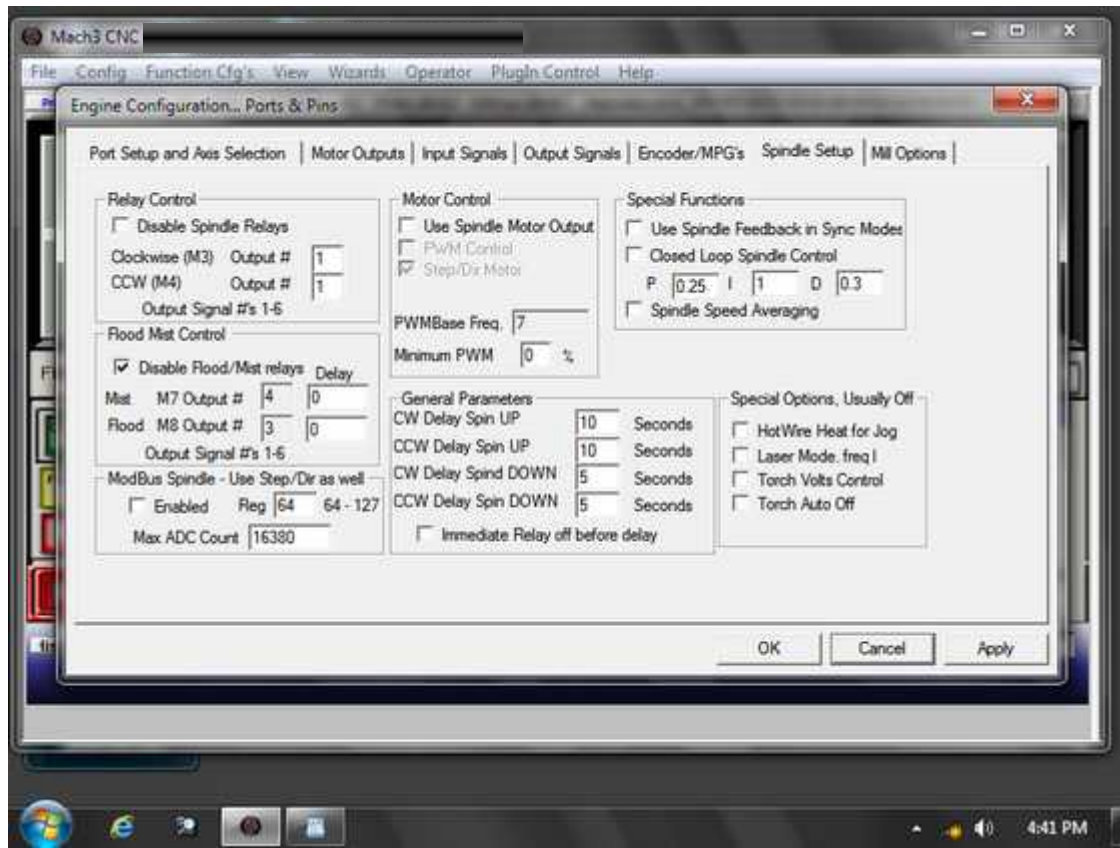
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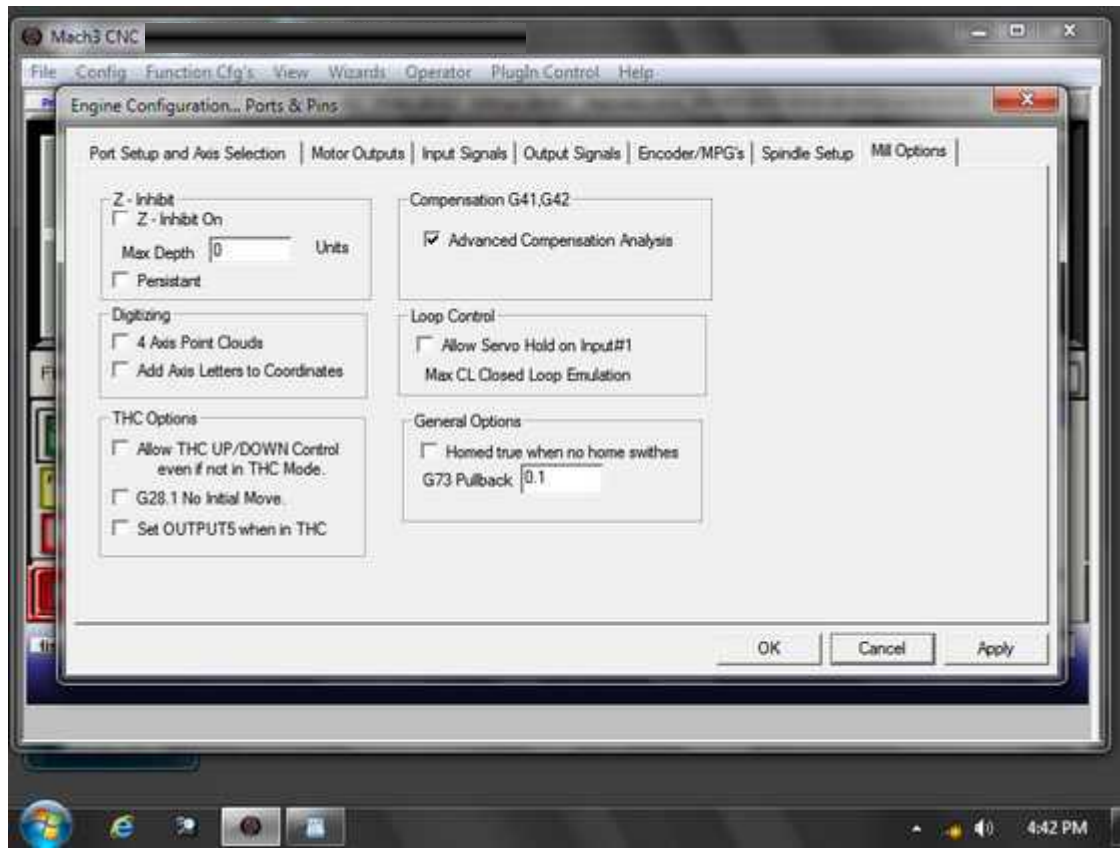
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Screen Captures of MACH 3 Motor Tuning and Setup for my CNC Router as at March 2013

General Logic Configuration

G20,G21 Control

☐ Lock DR0's to setup units

Tool Change

☒ Ignore Tool Change

☐ Stop Spindle: Wait for Cycle Start

☐ AutoTool Changer

Angular Properties

Unchecked for Linear

☒ A-Axis is Angular

☒ B-Axis is Angular

☒ C-Axis is Angular

Pgm End or M30 or Rewind

☐ Turn off all outputs

☒ E-Stop the system

☒ Perform G92.1

☐ Remove Tool Offset

☒ Radius Comp Off

☒ Turn Off Spindle

M01 Control

☒ Stop on M1 Command

Serial Output

ComPort # BaudRate

☒ 8-Bit 1 Stop ☐ 7 Bit 2-Stop

Program Safety

☐ Program Safety Lockout

This disables program translation while the External Activation #1 input is activated.

Editor

GCode Editor

Startup Models

☐ Use Init String on ALL "Resets"

Initialization String

Motion Mode

☒ Constant Velocity ☐ Exact Stop

Distance Mode

☒ Absolute ☐ Inc

U Mode

☐ Absolute ☒ Inc

Active Plane of Movement

☒ X-Y ☐ Y-Z ☐ X-Z

Jog Increments in Cycle Mode

Position 1

Use S99 to indicate a

Continuous Jog selection

Position 10:

Shuttle Wheel Setting

Shuttle Accel.

Seconds

General Configuration

☐ Z is 2.5D on Output #5

☒ Home Sw. Safety

LookAhead Lines

☐ Ignore M calls while loading

☐ M9- Execute after Block

☐ UDP Pendant Control

☐ Run Macro Pump

☐ ChargePump On in EStop

☒ Persistent Jog Mode.

☒ FeedOverride Persist

☐ No System Menu in Mach3

☐ Use Key Clicks

☐ Home Slave with Master Axis

☐ Include TLD in Z from G31

☒ Lock Rapid FRD to Feed FRD

Rotational

☐ Rot 360 rollover

☐ Ang Short Rot on G0

☒ Rotational Soft Limits

Screen Control

☒ Hi-Res Screens

☒ Boxed DR0's and Graphics

☒ Auto Screen Enlarge

☒ Flash Errors and comments.

Inputs Sig

Debounce

Index Deb

Disable Gc

☐ G04 Dwell

☒ Use Watch

☐ Debug Thi

☒ Enhanced

☐ Allow Wav

☐ Allow Spee

☐ Set Charge

☐ Use OUTP

☐ No FRD or

CV Control

☐ Plasma Mo

☐ CV Dist Tol

☐ G100 Adap

☐ Stop CV or

Axis DR0 Proper

☐ Tool Sele

☒ Optional

☒ Persister

☒ Persister

☐ Copy G5

Screen Captures of MACH 3 Motor Tuning and Setup for my CNC Router as at March 2013

Editor

GCode Editor

\\winNT\Notepad.exe

Startup Models

☐ Use Init String on ALL "Resets"

Initialization String

G80

Motion Mode

☒ Constant Velocity ☐ Exact Stop

Distance Mode

☒ Absolute ☐ Inc

UJ Mode

☐ Absolute ☒ Inc

Active Plane of Movement

☒ X-Y ☐ Y-Z ☐ X-Z

Jog Increments in Cycle Mode

Position 1	1
	0.1
	0.01
	0.001
Use 999 to indicate a	0.0001
Continuous Jog selection	1
	0.1
	0.01
	0.001
Position 10	0.0001

Shuttle Wheel Setting

Shuttle Accel

0.25 Seconds

Inputs Signal Debouncing/Noise rejection

Debounce Interval

0 x 40us

Index Debounce

0

General Configuration

☐ Z is 2.50 on Output #6

☒ Home Sw. Safety

LookAhead

20 Lines

☐ Ignore M calls while loading

☐ M9: Execute after Block

☐ UDP Pendant Control

☐ Run Macro Pump

☐ ChargePump On in EStop

☒ Persistent Jog Mode

☒ FeedOverride Persist

☐ No System Menu in Mach3

☐ Use Key Clicks

☐ Home Slave with Master Axis

☐ Include TLO in Z from G31

☒ Lock Rapid FRO to Feed FRO

Rotational

☐ Rot 360 rollover

☐ Ang Short Rot on G0

☒ Rotational Soft Limits

Screen Control

☒ Hi-Res Screens

☒ Boxed DRO's and Graphics

☒ Auto Screen Enlarge

☒ Flash Errors and comments

Disable Gouge/Concavity Checks

☐ G04 Dwell in ms

☒ Use WatchDogs

☐ Debug This Run

☒ Enhanced Pulsing

☐ Allow Wave Files

☐ Allow Speech

☐ Set Charge Pump to 5KHz - Laser Stndby

☐ Use OUTPUT20 as Dwell Trigger

☐ No FRO on Queue

10 Turn Manual Spindle Incr.

10 Spindle OV increment

CV Control

☐ Plasma Mode

☐ CV Dist Tolerance

180 Units

☐ G100 Adaptive NutsCV

☐ Stop CV on angles >

0 Degrees

Axis DRO Properties

☐ Tool Selections Persistent

☒ Optional Offset Save

☒ Persistent Offsets

☒ Persistent DROs

☐ Copy G54 from G53.253 on startup

OK