



DRO200 DRO300

Operating Instructions

Digital Readout

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1

Fundamentals

1.1 About these instructions

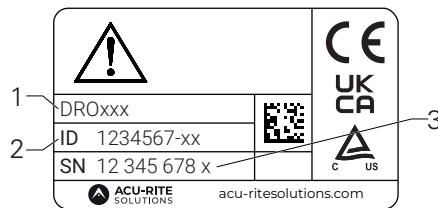
These instructions provide all the information and safety precautions needed for the safe operation of the product.

1.2 Information on the product

Product designation	Part number
DRO203 3 axes	1197250-xx
DRO203Q 3 axes for metrology applications	1358671-01
DRO303 3 axes with IOB 610/IB 2X/KT 130 connection	1197251-xx
DRO304 4 axes with IOB 610/IB 2X/KT 130 connection	1197251-xx

The ID label is provided on the back of the product.

Example:



- 1 Product designation
- 2 Part number
- 3 Index

Validity of the documentation

Before using the documentation and the product, you need to verify that the documentation matches the product.


- Compare the part number and the index indicated in the documentation with the corresponding data given on the ID label of the product
- > If the part numbers and indexes match, the documentation is valid



If the part numbers and indexes do not match so that the documentation is not valid, you will find the current documentation for the product at **www.acu-ritesolutions.com**.

1.3 Notes on reading the documentation

The table below lists the components of the documentation in the order of priority for reading.

 **WARNING**

Fatal accidents, personal injury or property damage caused by non-compliance with the documentation!

Failure to comply with the documentation may result in fatal accidents, personal injury or property damage.

- ▶ Read the documentation carefully from beginning to end
- ▶ Keep the documentation for future reference

Documentation	Description
Addendum	An addendum supplements or supersedes the corresponding contents of the Operating Instructions and, if applicable, of the Installation Instructions. If this document is included in the shipment, read it first before you proceed. All other contents of the documentation retain their validity.
Installation Instructions	The Installation Instructions contain all the information and safety precautions needed for the proper mounting and installation of the product. They are an excerpt from the Operating Instructions and are included in every shipment. This document has the second highest priority for reading.
Operating Instructions	The Operating Instructions contain all the information and safety precautions needed for the proper operation of the product according to its intended use. This document has the third highest priority for reading. This documentation can be downloaded from the download area at www.acu-ritesolutions.com . The Operating Instructions must be printed prior to commissioning the product.
Documentation of connected measuring devices and other peripherals	These documents are not included in delivery. They are shipped with the respective measuring devices and peripherals.

Would you like any changes, or have you found any errors?

We are continuously striving to improve our documentation for you. Please help us by sending your requests to the following e-mail address:

acu-ritesolutions@heidenhain.com

1.4 Storage and distribution of the documentation

The instructions must be kept in the immediate vicinity of the workplace and must be available to all personnel at all times. The operating company must inform the personnel where these instructions are kept. If the instructions have become illegible, the operating company must obtain a replacement from the manufacturer. If the product is given or resold to any other party, the following documents must be passed on to the new owner:

- Addendum, if supplied
- Installation Instructions
- Operating Instructions

1.5 Target group for the instructions

These instructions must be read and observed by every person who performs any of the following tasks:

- Mounting
- Installation
- Commissioning
- Setup, programming and operation
- Service, cleaning and maintenance
- Troubleshooting
- Removal and disposal

1.6 Notes in this documentation

Safety precautions

Comply with all safety precautions indicated in these instructions and in your machine tool builder's documentation!

Precautionary statements warn of hazards in handling the product and provide information on their prevention. Precautionary statements are classified by hazard severity and divided into the following groups:

⚠ DANGER
Danger indicates hazards for persons. If you do not follow the avoidance instructions, the hazard will result in death or severe injury .
⚠ WARNING
Warning indicates hazards for persons. If you do not follow the avoidance instructions, the hazard could result in death or serious injury .
⚠ CAUTION
Caution indicates hazards for persons. If you do not follow the avoidance instructions, the hazard could result in minor or moderate injury .
NOTICE
Notice indicates danger to material or data. If you do not follow the avoidance instructions, the hazard could result in things other than personal injury, like property damage .

Informational notes

Observe the informational notes provided in these instructions to ensure reliable and efficient operation of the product.

In these instructions, you will find the following informational notes:



The information symbol indicates a **tip**.
A tip provides important additional or supplementary information.



The gear symbol indicates that the function described **depends on the machine**, e.g.

- Your machine must feature a certain software or hardware option
- The behavior of the function depends on the configurable machine settings



The book symbol represents a **cross reference** to external documentation, e.g. the documentation of your machine tool builder or other supplier.

1.7 Symbols and fonts used for marking text

In these instructions the following symbols and fonts are used for marking text:

Format	Meaning
▶ ... > ...	Identifies an action and the result of this action Example: ▶ Press the enter key > The parameters are saved and the Job Setup menu is displayed
■ ... ■ ...	Identifies an item of a list Example: ■ Installation Setup ■ Job Setup
Bold	Identifies menus, screens, displays, keys, and soft keys Example: ▶ Press the Setup soft key > The Configuration Menu is displayed.

2

Safety

2.1 Overview

This chapter provides important safety information needed for the proper mounting, installation and operation of the product.

2.2 General safety precautions

General accepted safety precautions, in particular the applicable precautions relating to the handling of live electrical equipment, must be followed when operating the system. Failure to observe these safety precautions may result in personal injury or damage to the product.

It is understood that safety rules within individual companies vary. If a conflict exists between the material contained in these instructions and the rules of a company using this system, the more stringent rules take precedence.

2.3 Intended use

The products of the DRO203 and DRO300 series are advanced digital readouts for use on manually operated machine tools. In combination with linear and angle encoders, digital readouts of the DRO203 and DRO300 series display the position of the tool in more than one axis and provide further functions for operating the machine tool.

The DRO203Q is intended for use on optical comparators and measuring microscopes with up to 3 axis.

The products of the DRO200 and DRO300 series:

- must only be used in commercial applications and in an industrial environment
- must be mounted on a suitable stand or holder to ensure the correct and intended operation of the product
- are intended for indoor use in an environment in which the contamination caused by humidity, dirt, oil and lubricants complies with the requirements of the specifications



The products of the DRO200 and DRO300 series support the use of a wide variety of peripheral devices from different manufacturers. HEIDENHAIN cannot make any statements on the intended use of these devices. The information on their intended use, which is provided in the associated documentations, must be observed.

2.4 Improper use

When the product is used it must be ensured that no hazard to persons can result. If any such hazard exists, appropriate measures must be taken by the operating company.

In particular, the product must not be used in the following applications:

- Use and storage outside the specifications
- Outdoor use
- Use in potentially explosive atmospheres
- Use of the product as part of a safety function

2.5 Personnel qualification

The personnel for mounting, installation, operation, service, maintenance and removal must be appropriately qualified for this work and must have obtained sufficient information from the documentation supplied with the product and with the connected peripherals.

The personnel required for the individual activities to be performed on the product are indicated in the respective sections of these instructions.

The personnel groups that are responsible for mounting, installation, operation, maintenance and removal have different qualifications and tasks, which are specified as follows.

Operator

The operator uses and operates the product within the framework specified for the intended use. He is informed by the operating company about the special tasks and the potential hazards resulting from incorrect behavior.

Qualified personnel

The qualified personnel are trained by the operating company to perform advanced operation and parameterization. The qualified personnel have the required technical training, knowledge and experience and know the applicable regulations, and are thus capable of performing the assigned work regarding the application concerned and of proactively identifying and avoiding potential risks.

Electrical specialist

The electrical specialist has the required technical training, knowledge and experience and knows the applicable standards and regulations, and is thus capable of performing work on electrical systems and of proactively identifying and avoiding potential risks. Electrical specialists have been specially trained for the environment they work in.

Electrical specialists must comply with the provisions of the applicable legal regulations on accident prevention.

2.6 Obligations of the operating company

The operating company owns or leases the product and the peripherals. It is responsible that the intended use is complied with at all times.

The operating company must:

- Assign the different tasks to be performed on the product to appropriate, qualified, and authorized personnel
- Verifiably train personnel in the tasks they are allowed to perform and how to perform them
- Provide all materials and means necessary in order for personnel to complete the assigned tasks
- Ensure that the product is operated only when in perfect technical condition
- Ensure that the product is protected from unauthorized use

2.7 General safety precautions



The safety of any system incorporating the use of this product is the responsibility of the assembler or installer of the system.






The product supports the use of a wide variety of peripheral devices from different manufacturers. HEIDENHAIN cannot make any statements on the specific safety precautions to be taken for these devices. The safety precautions provided in the respective documentations must be observed. If no such information has been supplied, it must be obtained from the manufacturers concerned.

The specific safety precautions required for the individual activities to be performed on the product are indicated in the respective sections of these instructions.



2.7.1 Symbols in the instructions

The following safety symbols are used in this manual:

Symbol	Meaning
	Identifies information that warns of personal injury
	Identifies electrostatic sensitive devices (ESD)
	ESD wristband for personal grounding

2.7.2 Symbols on the product

The following symbols are used to identify the product:

Symbol	Meaning
	Observe the safety precautions regarding electricity and power connection before you connect the product
	Earth (ground) terminal as per IEC 60417 - 5017. Observe the information on installation.

2.7.3 Electrical safety instructions

WARNING

Hazard of contact with live parts when opening the product.

This may result in electric shock, burns or death.

- ▶ Never open the housing
- ▶ Only the manufacturer is permitted to access the inside of the product

WARNING

Hazard of dangerous amount of electricity passing through the human body upon direct or indirect contact with live electrical parts.

This may result in electric shock, burns or death.

- ▶ Work on the electrical system and live electrical components is to be performed only by trained specialists
- ▶ For power connection and all interface connections, use only cables and connectors that comply with applicable standards
- ▶ Have the manufacturer exchange defective electrical components immediately
- ▶ Regularly inspect all connected cables and all connections on the product. Defects, such as loose connections or scorched cables, must be removed immediately

NOTICE

Damage to internal parts of the product!

Opening the product will result in forfeiture of warranty and guarantee.

- ▶ Never open the housing
- ▶ Only the product manufacturer is permitted to access the inside of the product

3

**Transport and
storage**

3.1 Overview

This chapter contains all of the information necessary for the transportation and storage of the product and provides an overview of the items supplied and the available accessories for the product.

3.2 Unpacking

- ▶ Open the top lid of the box
- ▶ Remove the packaging materials
- ▶ Unpack the contents
- ▶ Check the delivery for completeness
- ▶ Check the delivery for damage

3.3 Items supplied and accessories

Items supplied

The following items are included in the shipment:

- Product
- Power cord (in 1197250-0x, 1197251-0x)
- Installation instructions
- Addendum (optional)

Further information: "Notes on reading the documentation", Page 17

Accessories

The following items are optionally available and can be ordered from HEIDENHAIN as additional accessories:

Accessories	Part number
Single-Pos stand For rigid mounting, inclination angle 20°	1197273-01
Multi-Pos holder For fastening on an arm, continuously tiltable and swivelable	1197273-02
Mounting frame For mounting to a panel	1197274-01
Cover For protection from dirt and debris	1197275-01
KT 130 edge finder For probing a workpiece (for setting reference points). Compatible with DRO300 products only.	283273-xx
IOB 610 For switching input and output functions. Compatible with DRO300 products only.	1197271-01
IB 2X For two additional axes. Compatible with DRO300 products only.	1197271-02
Y-cable For connecting a KT 130 edge finder and an IOB 610 or IB 2X. Compatible with DRO300 products only.	1226398-01
Connecting cable For connecting a KT 130 edge finder, an IOB 610, or an IB 2x. Compatible with DRO300 products only.	1226509-xx

3.4 In case of damage in transit

- ▶ Have the shipping agent confirm the damage
- ▶ Keep the packaging materials for inspection
- ▶ Notify the sender of the damage
- ▶ Contact the distributor or machine manufacturer for replacement parts



In case of damage in transit:

- ▶ Keep the packaging materials for inspection
- ▶ Contact HEIDENHAIN or the machine manufacturer

This applies also if damage occurred to requested replacement parts during transit.

3.5 Repackaging and storage

Repackage and store the product carefully in accordance with the conditions stated below.

Repackaging

Repackaging should correspond to the original packaging as closely as possible.

- ▶ Attach all mounting parts and dust protection caps to the product or repackage them in the same way they were originally shipped from the factory.
- ▶ Repackage the product such that it is protected from impact and vibration during transit
- ▶ Repackage the product such that it is protected from the ingress of dust or humidity
- ▶ Place all accessories that were included in the shipment in the original packaging

Further information: "Items supplied and accessories", Page 30

- ▶ Include the Addendum (if it was included in the items supplied), the Installation Instructions and the Operating Instructions

Further information: "Storage and distribution of the documentation", Page 18



If you return the product for repair to a service agency:

- ▶ Ship the product without accessories, without measuring devices and without peripherals

Storage of the product

- ▶ Package the product as described above
- ▶ Observe the specified ambient conditions
- ▶ Inspect the product for damage after any transport or longer storage times

4

Mounting

4.1 Overview

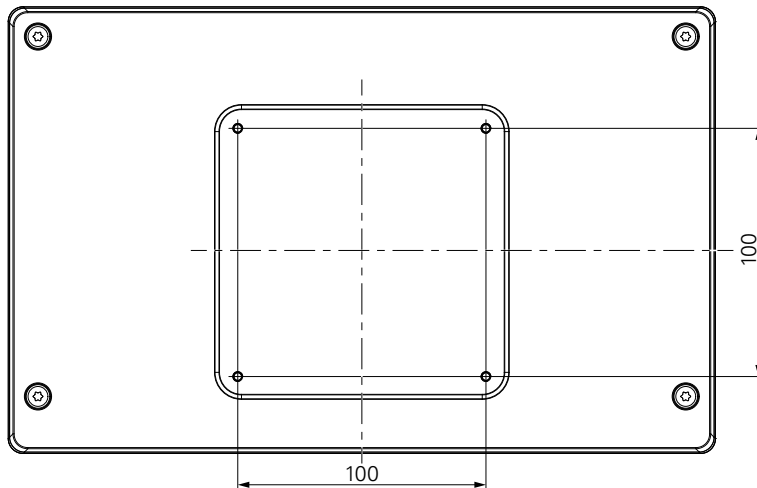
This chapter contains all of the information necessary for mounting the product.

i The following steps are only to be performed by qualified personnel.
Further information: "Personnel qualification", Page 25

4.2 Assembly

General mounting information

The receptacle for the mounting variants is provided on the rear panel. The connection is compatible with VESA standard 100 mm x 100 mm.



The material for attaching the mounting variants on the device is included in the accessories to the product.

You will also need the following:

- Torx T20 screwdriver
- 2.5 mm allen wrench
- 7 mm socket wrench
- Material for mounting on supporting surface

i The product must be mounted on a stand, a holder, or in a mounting frame to ensure the correct and intended operation of the product.

Routing the cables

i In the figures showing the mounting variants, you will find suggestions for routing the cables after mounting.

When mounting to a mounting variant:

- ▶ Bring the cables together
- ▶ Route the cables laterally to the connections as shown in the illustrations

4.3 Mounting on Single-Pos stand

The Single-Pos stand allows you to place the product on a surface at an inclination angle of 20° and secure the product to a surface.

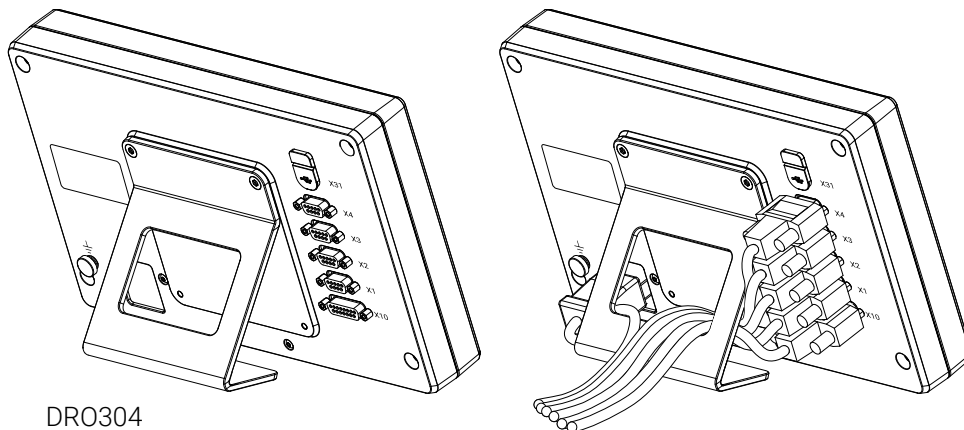
Mount the stand to the upper VESA 100 tapped holes on the rear panel of the product

- Use a Torx T20 screwdriver to tighten the countersunk head screws M4 x 8 ISO 14581 included in delivery
- Comply with the permissible tightening torque of 2.6 Nm

Secure the product against movement during operation

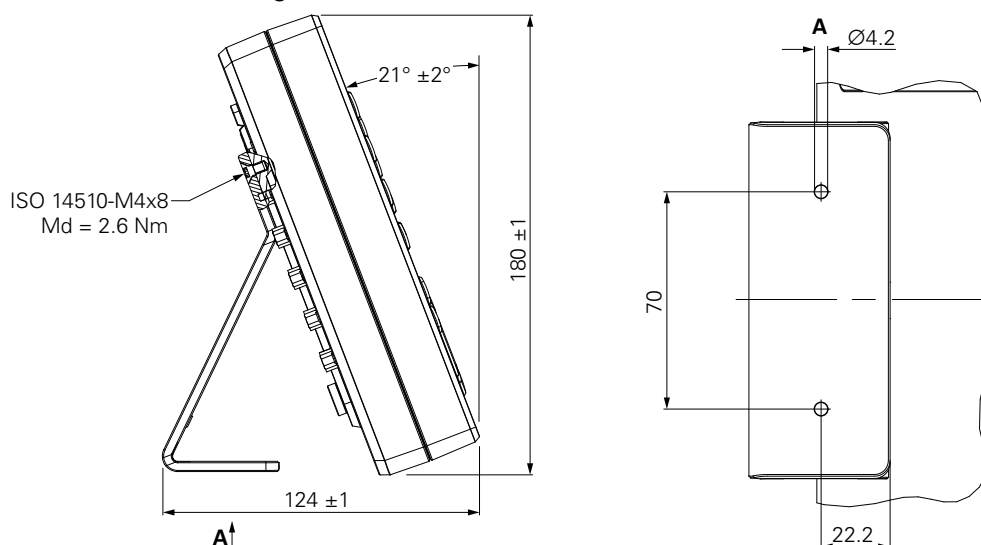
- Attach the supplied self-adhesive rubber pads to the bottom of the product
- If you do not screw the product to a surface, attach self-adhesive rubber pads to the bottom of the stand

i Attach the rubber pads to the stand only if you do not screw the product to a surface.



DRO304

Dimensions of the Single-Pos stand

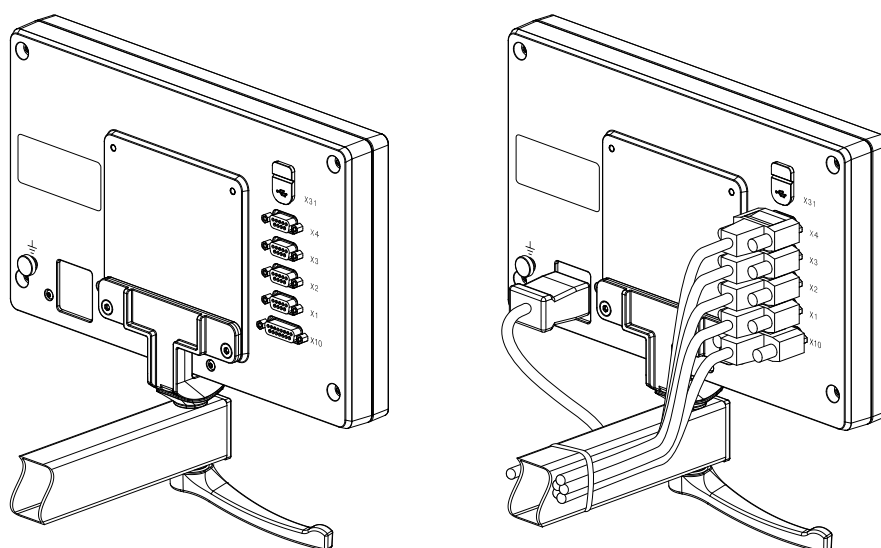


4.4 Mounting on Multi-Pos holder

Mount the holder to the bottom VESA 100 tapped holes on the rear panel of the product

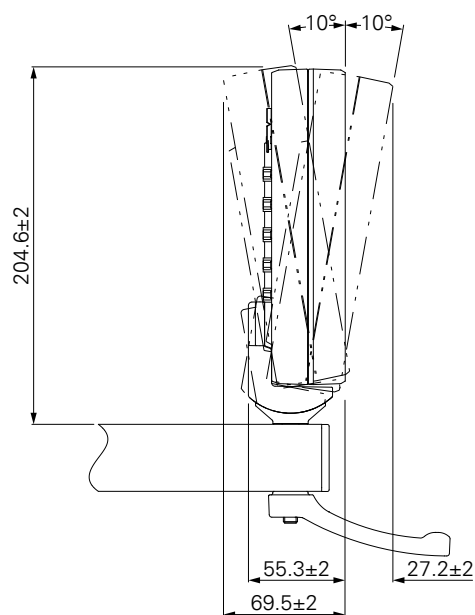
- Use a Torx T20 screwdriver to tighten the countersunk head screws M4 x 10 ISO 14581 (black) included in delivery
- Comply with the permissible tightening torque of 2.5 Nm

You can tilt and swivel the holder to an angle that allows you to comfortably view the readout.



DRO304

Dimensions of the Multi-Pos holder



4.5 Mounting in a mounting frame

The mounting frame allows you to mount the product in a panel.

Mount the rear plate of the frame to the VESA 100 tapped holes on the rear panel of the product

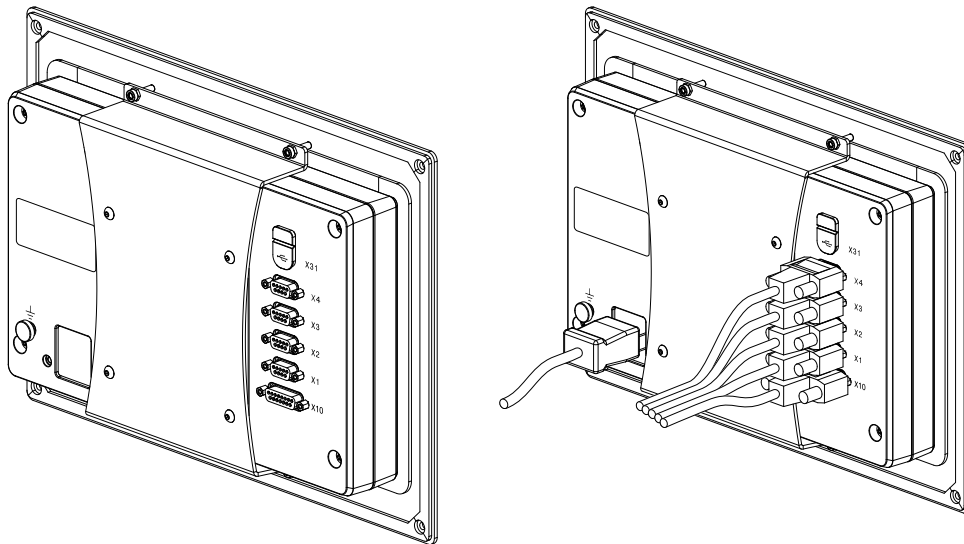
- ▶ Use a 2.5 mm allen wrench to tighten the screws M4 x 6 ISO 7380 included in delivery
- ▶ Comply with the permissible tightening torque of 2.6 Nm

Mount the rear plate and the product to the front plate of the frame

- ▶ Use a 7 mm socket wrench to tighten the nuts M4 ISO 10511 included in delivery
- ▶ Comply with the permissible tightening torque of 3.5 Nm

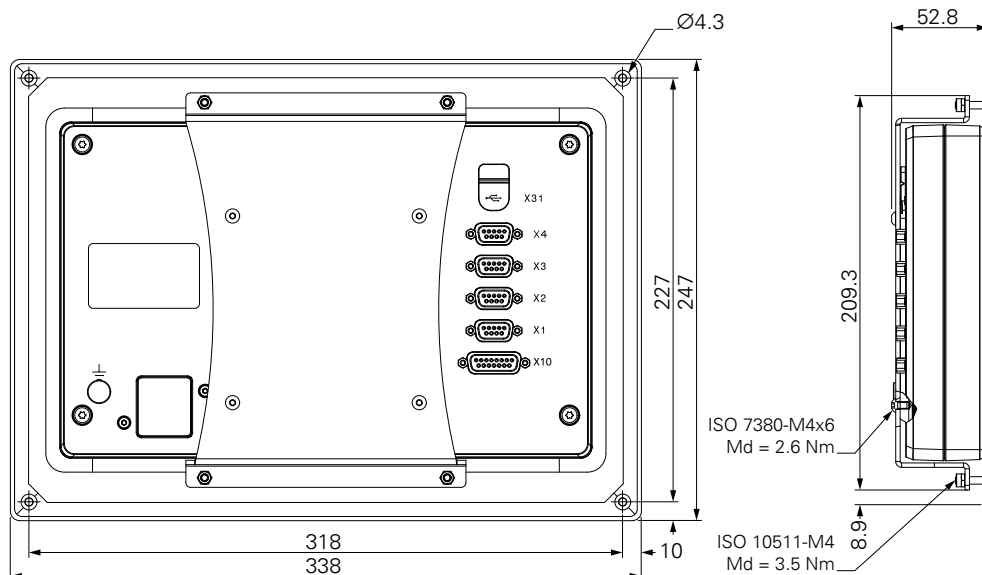
Mount the frame and readout in the panel

- ▶ Refer to the mounting instructions provided with the mounting frame for panel cutout and mounting information



DRO304

Dimensions of the mounting frame

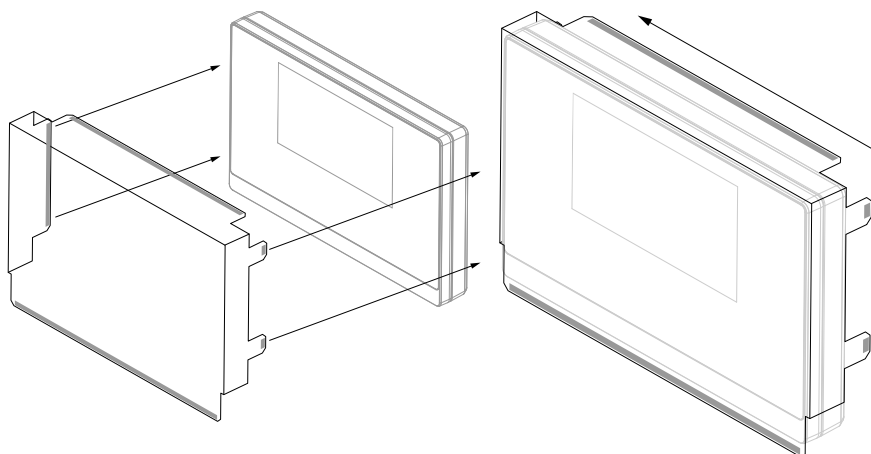


4.6 Mounting a cover

The cover protects the product from dirt and debris.

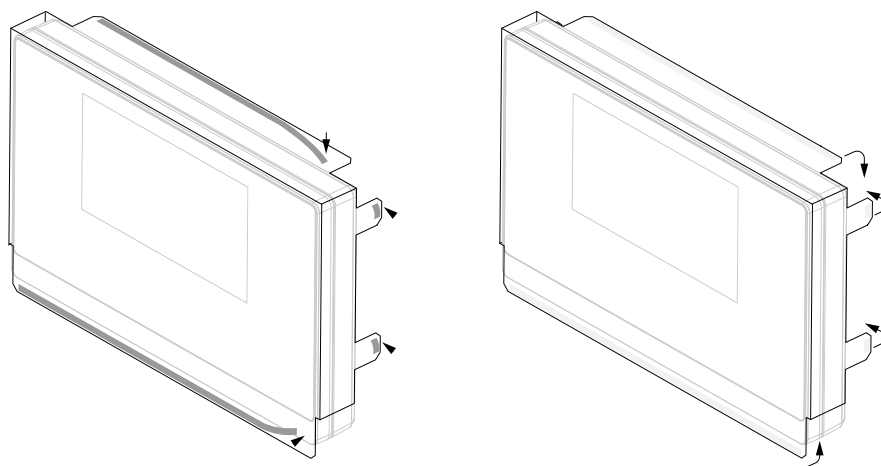
Place the cover on the product

- ▶ Place the cover over the product
- ▶ Align the cover and product on the right hand side, when viewing the front of the product



Mount the cover to the product

- ▶ Remove the adhesive strip protectors from the adhesive tabs
- ▶ Fold the adhesive tabs toward the product
- ▶ Press the adhesive tabs against the product securing the tab to the product



5

Installation

5.1 Overview

This chapter contains all the information necessary for installing the product.



The following steps must be performed only by qualified personnel.

Further information: "Personnel qualification", Page 25

5.2 General information

NOTICE

Engaging and disengaging connecting elements!

Risk of damage to internal components.

- ▶ Do not engage or disengage any connecting elements while the unit is under power

NOTICE

Electrostatic discharge (ESD)!

This product contains electrostatic sensitive components that can be destroyed by electrostatic discharge (ESD).

- ▶ It is essential to observe the safety precautions for handling ESD-sensitive components
- ▶ Never touch connector pins without ensuring proper grounding
- ▶ Wear a grounded ESD wristband when handling product connections

NOTICE

Incorrect pin assignment!

This may cause product malfunctions or damage to the product.

- ▶ Only assign pins or wires that are used

5.3 Product overview

The connections on the rear panel of the device are protected by dust protection caps from contamination and damage.

NOTICE

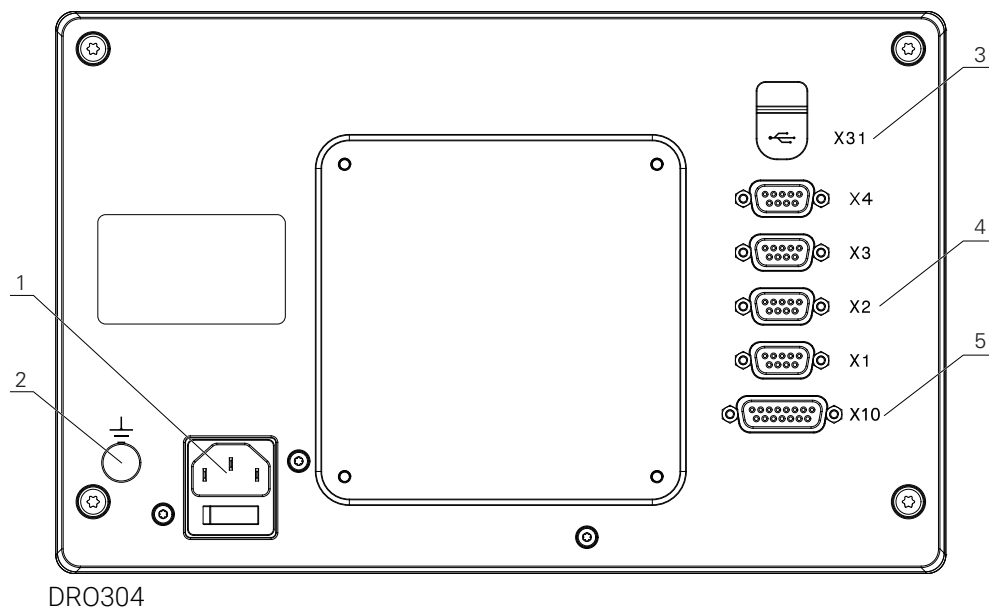
Contamination or damage may result if the dust protection caps are missing!

This may impair the proper functioning of the contacts or destroy them.

- ▶ Remove dust protection caps only when connecting measuring devices or peripherals
- ▶ If you remove a measuring device or peripheral, reattach the dust protection cap to the connection

i The type and number of connections may vary depending on the product version.

Rear panel without dust protection caps



Rear panel

- 1 Power switch and power connection
- 2 Earth (ground) terminal as per IEC 60471 - 5017
- 3 **X31**: USB 2.0 Hi-Speed connection (Type C) for USB mass storage device (beneath protective cover)
- 4 **X1 to X4**: Device variant with 9-pin D-sub connections for encoders with TTL interface
- 5 **X10**: 15-pin D-sub connection for touch probes and auxiliary devices (e.g. HEIDENHAIN touch probe, IOB 610, IB 2X). Available on DRO300 products only.

5.4 Connecting an encoder

- ▶ Remove and save the dust protection caps
- ▶ Route the cables depending on the mounting variant

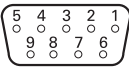
Further information: "Assembly", Page 34

- ▶ Connect the encoder cable tightly to the respective connection

Further information: "Product overview", Page 41

- ▶ If the cable connectors include mounting screws, do not overtighten them

Pin layout of X1 to X4

TTL								
								
1	2	3	4	5	6	7	8	9
NC	A+	A-	B+	B-	GND	DC 5 V	R-	R+

5.5 Connecting an accessory

- i** The following accessories can be connected to a DRO300 product:
- HEIDENHAIN KT 130
 - Acu-Rite Solutions IOB 610
 - Acu-Rite Solutions IB 2X

Further information: "Accessories", Page 31

- i** A cable is required to connect an accessory to a DRO300 product.
The following cables are available:
- Y-cable
 - Connecting cable

Further information: "Accessories", Page 31

- ▶ Remove and save the dust protection caps
- ▶ Route the cables depending on the mounting variant

Further information: "Assembly", Page 34

- ▶ Connect one end of the Connecting cable tightly to connection X10 and the other end to the accessory
- ▶ or

- i** The Y-Cable is for connecting a KT 130 and an IOB 610 or IB 2X to the product. An IOB 610 and IB 2X cannot be connected to the product at the same time.

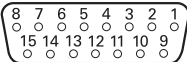
- ▶ Connect the single connector end of the Y-cable tightly to connection X10 and one of the double connector ends to the accessory

Further information: Data sheet provided with the connecting cable or Y-cable

Further information: "Product overview", Page 41

- ▶ Do not overtighten the cable connector mounting screws

Pin layout of X10

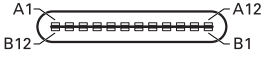
							
1	2	3	4	5	6	7	8
0 V	Probe ready	Signal low	/	/	DC 5 V	0 V	0 V
9	10	11	12	13	14	15	
Signal high	/	/	Value output contact	Probe input	Value output pulse	0 V	

5.6 Connecting a USB device

- ▶ Open the dust protection cap
- ▶ Connect the USB device to the respective connection

Further information: "Product overview", Page 41

Pin layout of X31

											
A1	A2	A3	A4	A5	A6	A7	A8	A9	A10	A11	A12
GND	TX1 +	TX1 -	VBUS	CC1	D +	D -	SBU1	VBUS	RX2 -	RX2 +	GND
B1	B2	B3	B4	B5	B6	B7	B8	B9	B10	B11	B12
GND	TX2 +	TX2 -	VBUS	CC2	D +	D -	SBU2	VBUS	RX1 -	RX1 +	GND

5.7 Connecting the line voltage

WARNING

Risk of electric shock!

Improper grounding of electrical devices may result in serious personal injury or death by electric shock.

- ▶ Always use 3-wire power cables
- ▶ Make sure the ground wire is correctly connected to the ground of the building's electrical installations

WARNING

Fire hazard from the use of power cables that do not meet the national requirements of the respective country in which the product is mounted.

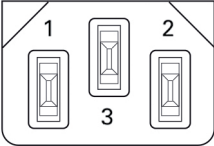

Improper grounding of electrical devices may result in serious personal injury or death by electric shock.

- ▶ Use only a power cable that meets at least the national requirements of the respective country in which the product is mounted

- ▶ Use a power cable that meets the requirements to connect the power connection to a 3-wire grounded power outlet

Further information: "Product overview", Page 41

Pin layout of the power connection

		
1	2	3
L/N	N/L	

6

Fundamentals of positioning

6.1 Overview

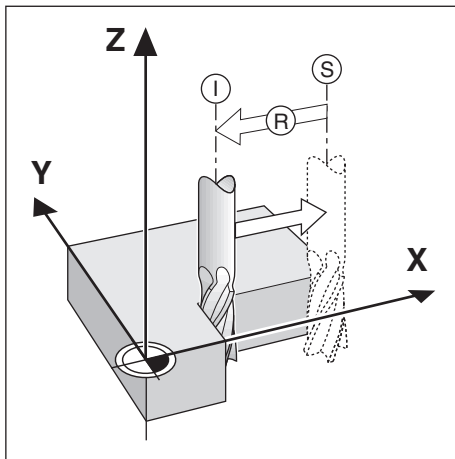
This chapter describes basic positioning information.

6.2 Datums

The workpiece drawing identifies a certain point on the workpiece (example: "a corner") as the absolute datum, and perhaps one, or more other points as relative datums.

The datum setting procedure establishes these points as the origin of the absolute, or relative coordinate systems. The workpiece, which is aligned with the machine axes, is moved to a certain position relative to the tool. The display is set to zero.

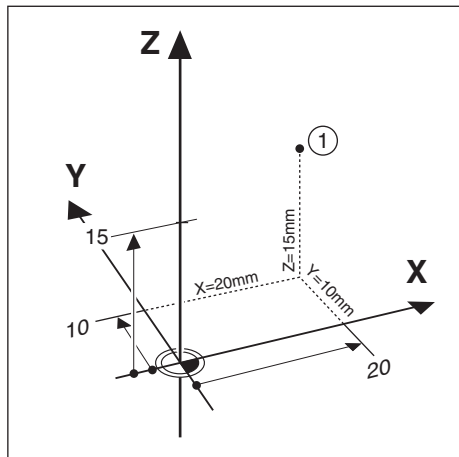
6.3 Actual position, nominal position, and Distance-To-Go



The position of the tool at any given moment is called the Actual Position **I**, while the position that the tool is to move to is called the Nominal Position **S**. The distance from the nominal position to the actual position is called the Distance-To-Go **R**.

6.4 Absolute workpiece positions

Each position on the workpiece is uniquely identified by its absolute coordinates.



Example: Absolute coordinates of position 1:

X = 20 mm

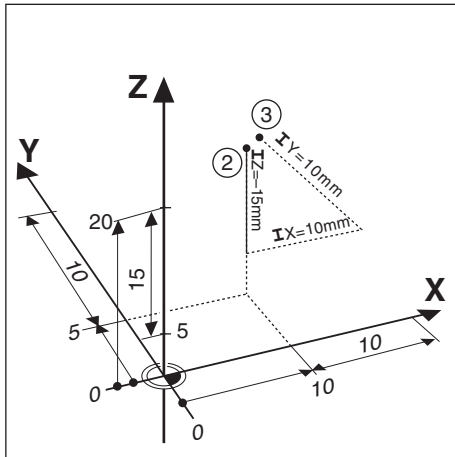
Y = 10 mm

Z = 15 mm

If you are drilling, or milling a workpiece according to a workpiece drawing with absolute coordinates, the tool is moving to the value of the coordinates.

6.5 Incremental workpiece positions

A position can also be referenced to the preceding nominal position. In this case the relative datum is always the last nominal position. Such coordinates are referred to as Incremental Coordinates. They are also called incremental, or chain dimensions, since the positions are defined as a chain of dimensions. Incremental coordinates are designated with the prefix **I**.



Example: Incremental coordinates of position **3** referenced to position **2**.

Absolute coordinates of position **2**:

X = 10 mm

Y = 5 mm

Z = 20 mm

Incremental coordinates of position **3**:

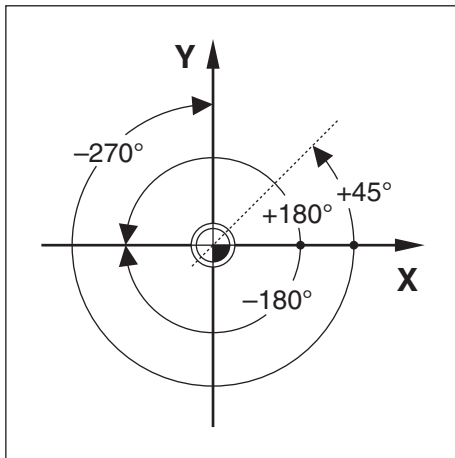
IX = 10 mm

IY = 10 mm

IZ = 15 mm

If you are drilling, or milling a workpiece according to a drawing with incremental coordinates, you are moving the tool by the value of the coordinates.

6.6 Zero angle reference axis



The Zero Angle Reference Axis is the 0.0° position. It is defined as one of the two axes in the plane of rotation. The following table defines the Zero Angle where the position of the angle is zero for the three possible planes of rotation.

For angular positions, the following reference axes are defined:

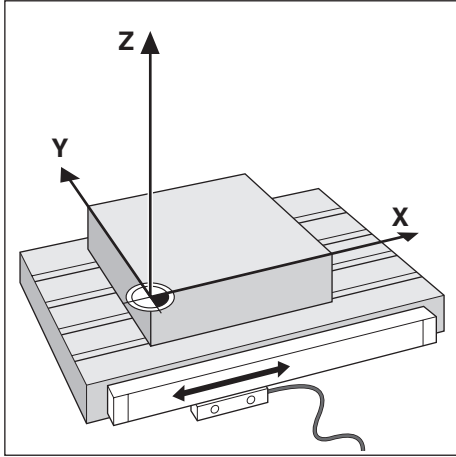
Plane	Zero Angle Reference Axis
XY	+X
YZ	+Y
ZX	+Z

Positive direction of rotation is counterclockwise if the working plane is viewed in the negative tool axis direction.

Example: Angle in the working plane X / Y

Plane	Zero Angle Reference Axis
$+45^\circ$... bisecting line between +X and +Y
$\pm 180^\circ$... negative X axis
-270°	... positive Y axis

6.7 Reading head position



The reading head position provides feedback to the product that converts the movement of the machine axes into electrical signals. The product constantly evaluates these signals, calculates the actual positions of the machine axes, and displays the positions as a numerical value on the display.

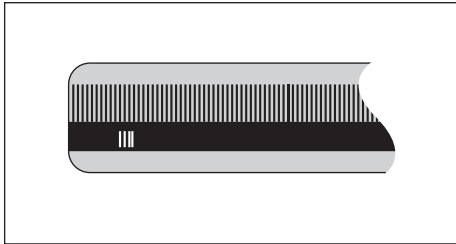
If there is an interruption in power, the calculated position will no longer correspond to the actual position. When power is restored, you can re-establish this relationship by using the reference marks on the encoder. This product provides the Reference Mark Evaluation Feature (REF).

6.8 Encoder reference marks

Encoders normally contain one or more reference marks which the Reference Mark Evaluation feature uses to re-establish datum positions after a power interruption. There are two main options available for reference marks:

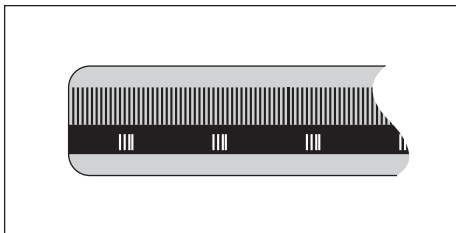
- Fixed reference marks
- Distance-coded reference marks

Fixed reference marks



Encoders that have one or more marks on fixed intervals have to re-establish the datums correctly. It is necessary to use the same exact reference mark, during the Reference Mark Evaluation routine, that was used when the datum was first established.

Position Trac (Distance-coded reference marks)



Encoders that have marks separated by a specific encryption pattern allow the product to use any two pair of marks along the length of the encoder to re-establish the prior datums. This configuration means that you only have to travel less than 20 mm anywhere along the encoder to re-establish the datums when the product is switched back on.



The established datums cannot be restored from one power cycle to the next if the reference marks were not crossed before the datums were set.

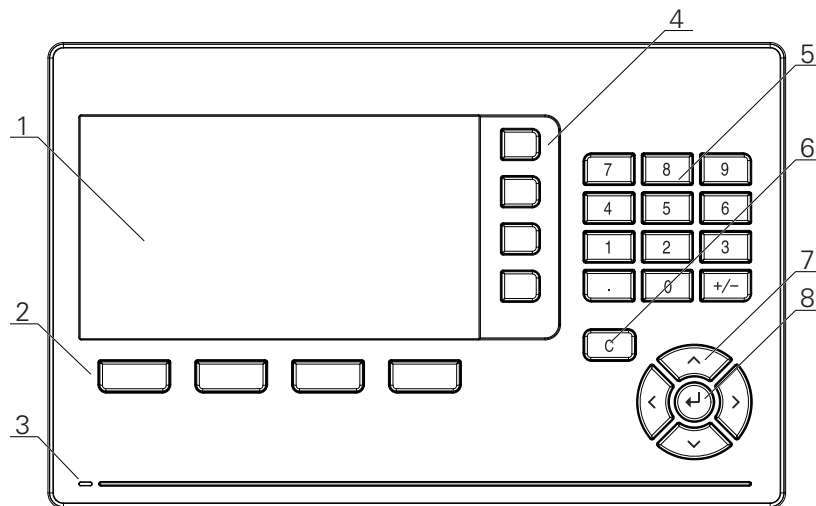
7

Basic operation

7.1 Overview

This chapter describes the product's operating elements and user interface as well as its basic functions.

7.2 Front panel and keys



- 1 Display
- 2 Soft keys
- 3 Power indicator LED
- 4 Axis keys
- 5 Numeric keys
- 6 Clear key
- 7 Arrow keys
- 8 Enter key

Keys	Function
Axis	Press an axis key to Set or Zero the axis. Refer to the Status Bar for the current Set/Zero state.
Soft keys	Soft key labels show milling or turning functions. Press the corresponding soft key directly below each label to select a function.
Numeric	Press a numeric key to enter the corresponding value in a field
Arrow	Press the arrow keys to navigate the menus Press the left and right arrow keys to move through the soft key selectable functions
Enter	Press the enter key to confirm a selection and return to the previous screen
C	Press the C key to clear entries and error messages, or return back to the previous screen

7.3 Switch-on/Switch-off

7.3.1 Switch-on



Before using the product, you need to perform the commissioning steps. Depending on the purpose of use, you may have to configure additional setup parameters.

Further information: "Commissioning", Page 69

To switch-on the product:

- ▶ Turn the power switch on
The power switch is on the rear side of the unit
- > The unit powers up. This can take a moment.
- > The first-time configuration screen will appear if this is the first time turning on the product or after resetting factory default settings
- ▶ Press the **Installation Guide** soft key to go to the **Installation Guide**
or
- ▶ Press any key to continue to the display

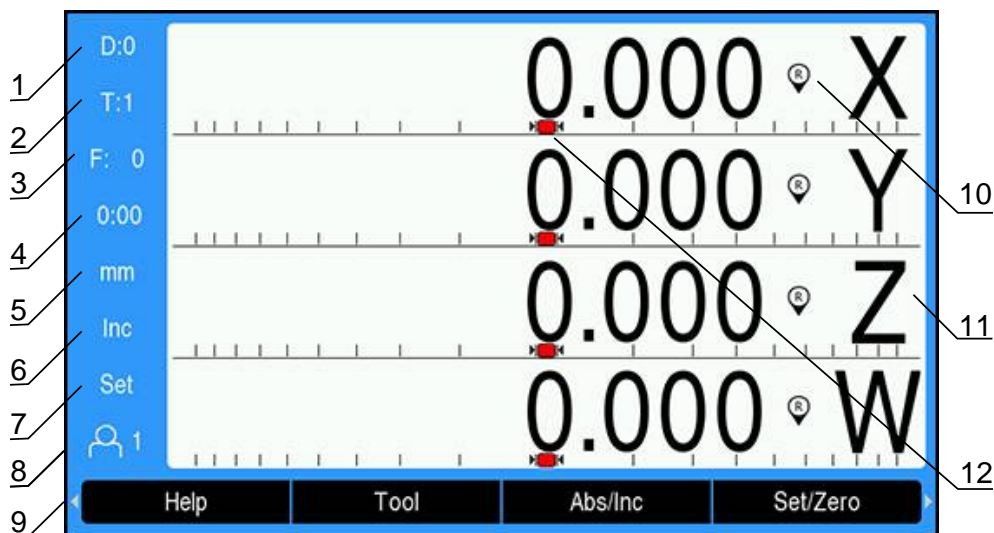
7.3.2 Switch-off

To switch-off the product:



- ▶ Turn the power switch off
The power switch is on the rear side of the unit
- > The unit powers down

7.4 User interface

7.4.1 Display layout



- 1 Datum
- 2 Tool
- 3 Feed rate
- 4 Stopwatch
- 5 Unit of measure
- 6 Operating mode
- 7 Set/Zero
- 8 User
- 9 Soft keys
- 10 Reference mark indicator
- 11 Axis labels
- 12 Graphic positioning aid

Feature	Function
Status bar	Displays the current datum, tool, feed rate, stopwatch time, unit of measure, operating mode status, set/zero setting, and the current user
Display area	Indicates the current position of each axis. Also shows forms, fields, instruction boxes, error messages, and help topics
Axis labels	Indicates axis for corresponding axis key
Reference mark indicator	Indicates current reference mark status <ul style="list-style-type: none">  Reference marks are established. A flashing indicator represents that reference mark detection is enabled, but the reference marks have not yet been established.  Reference marks are not established
Soft keys	Indicate various functions based on the current operating mode or menu
Graphic positioning aid	Indicates the Distance-To-Go

7.4.2 Soft keys

There are multiple pages of soft key functions to select when in one of the operating modes.

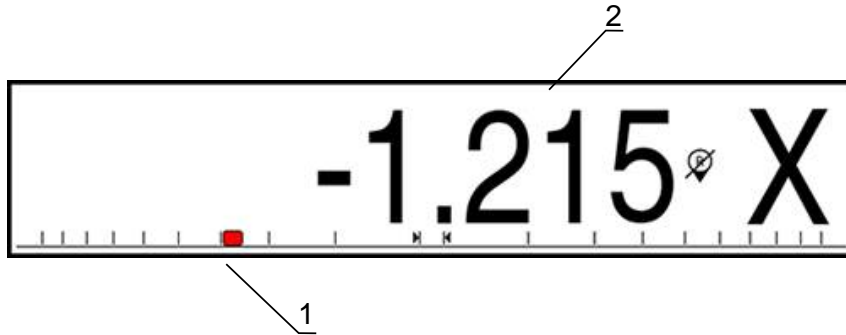
To navigate the soft key pages:

- Press the **left** or **right arrow** key to cursor through each page

Soft key	Function
Help	Press the Help soft key to open the operating instructions
Tool	Press the Tool soft key to open the Tool Table
Abs/Inc	Press the Abs/Inc soft key to toggle between Actual Value (Absolute) and Distance-To-Go (Incremental) modes
Set/Zero	Press the Set/Zero soft key to toggle between Set and Zero functions. Used with individual axis keys.
Datum	Press the Datum soft key to open the Datum form and set the datum for each axis
Preset	Press the Preset soft key to open the Preset form. This form is used to set a nominal position. This is a Distance-To-Go (Incremental) function.
1/2	Press the 1/2 soft key to divide the current position by two. Available in Mill application only.
Features	Press the Features soft key to select the Circle Pattern or Linear Pattern table
Rad/Dia	Press the Rad/Dia soft key to toggle between diameter and radius measurements. Available in Turn application only.
Setup	Press the Setup soft key to access the Configuration menu
Enable Ref	Press the Enable Ref soft key when you are ready to identify a reference mark
Calc	Press the Calc soft key to open the calculator
inch/mm	Press the inch/mm soft key to toggle between inch and millimeter units of measure
Disable Ref	Press the Disable Ref soft key when you want to cross over a reference mark and have the system ignore the reference mark
No Ref	Press the No Ref soft key to exit the reference mark evaluation routine and work without reference marks
Program	Press the Program soft key to select the program Mode
Send Position	Press the Send Position soft key to transmit the current position over the USB connection to a USB mass storage device or PC. The position values will be transmitted in either Actual Value or Distance-To-Go mode, whichever is currently visible.

7.4.3 Graphic positioning aid

When positioning to the next nominal position, the product assists you by displaying the Distance-To-Go as well as a graphic positioning aid ("traversing to zero"). A scale is shown underneath each axis you traverse to zero. The graphic positioning aid is a small square that symbolizes the axis slide.



- 1 Graphic positioning aid (axis slide)
- 2 Distance-To-Go

The positioning aid moves across the scale when the axis slide is within a range of the nominal position. The default range is ± 5 mm and can be changed in the **Graphic Pos Aid** menu.

Further information: "Graphic positioning aid", Page 98

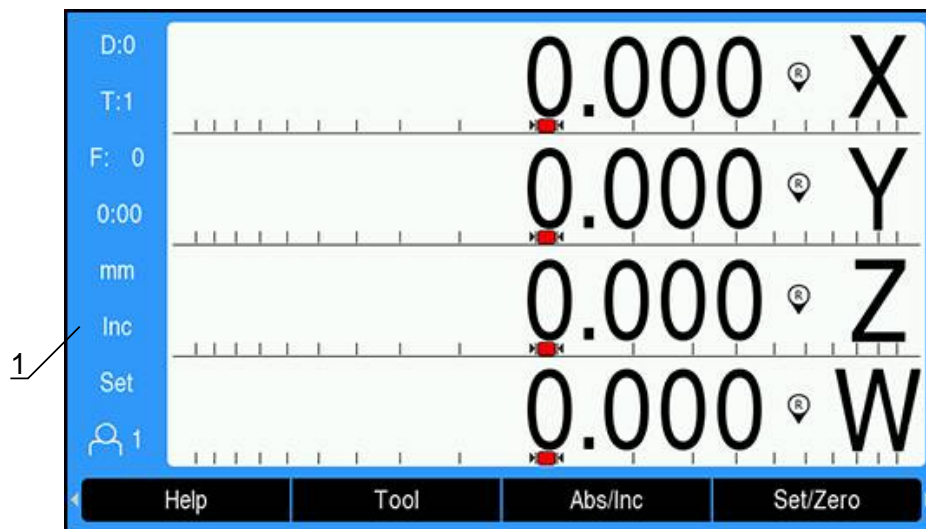
7.4.4 Operating modes

The product has two operating modes:

- Distance-To-Go (Incremental)
- Actual Value (Absolute)

Distance-To-Go mode (Incremental)

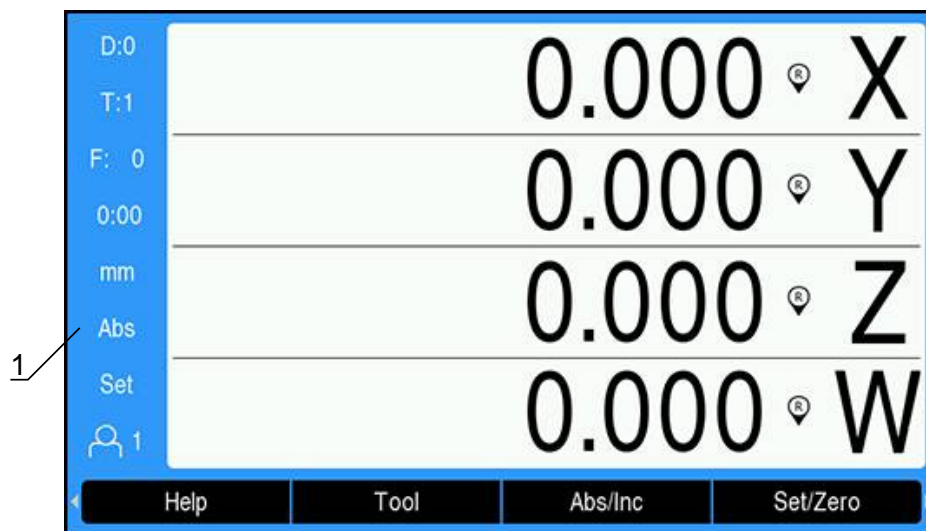
The Distance-To-Go mode enables you to approach nominal positions by zeroing the axes and traversing to a position based on its distance from the zeroed position.



- 1 Distance-To-Go mode (Inc)

Actual Value mode (Absolute)

The Actual Value mode always displays the current actual position of the tool, relative to the active datum. In this mode, all moves are done by traveling until the display matches the nominal position that is required.



1 Actual Value mode (Abs)

Changing the operating mode

To change the operating mode:

- ▶ Press the **Abs/Inc** soft key to toggle between operating modes

7.4.5 Stopwatch

On the DRO screen the **Stopwatch** shows the minutes and seconds until 59:59 is reached, then displays hours and minutes. The **Stopwatch** shows elapsed time. The clock starts timing from 0:00.

The **Stopwatch** can also be operated from the **Job Setup** menu.

Further information: "Stopwatch", Page 99

Starting and stopping the Stopwatch

To start or stop the **Stopwatch**:

- ▶ Press the . (decimal) key on the numeric key pad to start or stop the **Stopwatch**
- > The elapsed time field in the status bar shows the total accumulated time

Resetting the Stopwatch

To reset the **Stopwatch**:

- ▶ Press the 0 (zero) key on the numeric keypad to reset the **Stopwatch** time

7.4.6 Calculator

The **Calculator** is capable of handling everything from simple arithmetic to complex trigonometry and RPM calculations.

Using the Standard/Trig Calculator

To open the **Calculator**:

- ▶ Press the **Calc** soft key
- ▶ Press the **Standard/Trig** soft key

Trig functions contain all trig operators as well as, square and square root. Whenever you are calculating the SIN, COS, or TAN of an angle, enter the angle first and then press the appropriate soft key.

When you need to enter more than one calculation into a numeric field, the calculator will perform multiplication and division before it performs addition and subtraction.

Ex. If you were to enter $3 + 1 \div 8$, the calculator will divide one by eight, then add three for an answer of 3.125.



Angle values use the current angle format selection of decimal degrees, or radians.

Using the Rpm Calculator

The **Rpm Calculator** is used to determine the **rpm** (or surface cutting speed) based on a specified tool (part, for turning applications) diameter. The values shown are only an example. Consult your tool manufacturer's manual to verify spindle speed ranges per tool.

To use the **Rpm Calculator**:

- ▶ Press the **Calc** soft key
- ▶ Press the **rpm** soft key to open the **Rpm Calculator** form

The **Rpm Calculator** requires a tool **Diameter** for **Mill** applications. The **Diameter** value will default to the current tool's **Diameter**. If there is no last value entered in this power cycle, the default value is 0.


- ▶ Use the numeric key pad to enter a **Diameter** value
- ▶ If a **Surface Speed** value is required, enter the value using the numeric key pad

When a **Surface Speed** value is entered, the associated **rpm** value will be calculated.

- ▶ Press the **Units** soft key to show the **Units** as inch or mm
- ▶ Press the **C** key to close the **Rpm Calculator** and save the current data

7.4.7 Help

Integrated operating instructions provide context-sensitive **Help** when operating the product.



The operating instructions may take a moment to load the first time they are opened:

- After uploading a new operating instructions file
- After changing the user interface language

The message **Loading file. Please wait ...** will display while the operating instructions load.

- To open the operating instructions:
- ▶ Press the **Help** soft key
 - The operating instructions will open to the section that covers the current feature or function being used on the product.
- The following key functions are available in **Help**:

Key	Function
First axis	Press the First axis key to open the table of contents
Up arrow	Press the Up arrow key to navigate back in the operating instructions
Down arrow	Press the Down arrow key to navigate forward in the operating instructions
Right arrow	Press the Right arrow key to highlight the first link on a page If a link is already highlighted: Press the Right arrow key to highlight the next link on a page
Left arrow	Press the Left arrow key to highlight the last link on a page If a link is already highlighted: Press the Left arrow key to highlight the previous link on a page
enter	Press the enter key to navigate to a link that is highlighted
C	Press the C key to remove a highlight from a link If no links are highlighted: Press the C key to exit Help

7.4.8 Data input forms

Information required for various operational functions and setup parameters are entered through data input forms. These forms will appear after selecting features that require additional information. Each form provides specific fields for entering the required information.

Confirming changes

- To confirm changes:
- ▶ Press the **enter** key to apply the selected parameter changes

Canceling changes

- To cancel changes:
- ▶ Press the **C** key to return to the previous screen without saving changes

7.4.9 Reference mark evaluation

The Reference Mark Evaluation feature automatically re-establishes the relationship between axis slide positions and display values that was last defined by setting the datum.

The reference mark indicator will flash for each axis with an encoder that has reference marks. The indicator will stop flashing after crossing over the reference marks.

Activating reference marks



1 Reference marks enabled

To activate reference marks:

- ▶ Cross over the reference marks for each axis to activate the reference
- > After a successful reference mark evaluation, the indicator will stop flashing

Working without reference marks

The product can also be used without crossing over the reference marks.



1 Reference marks disabled

To work without reference marks:

- ▶ Press the **No Ref** soft key to exit the reference mark evaluation routine, and continue
- > After disabling reference marks the indicator will have a forward slash through it, signifying that the reference marks have been disabled

Re-enabling reference marks

Reference marks can be enabled any time after they have been disabled

To re-enable reference marks:

- ▶ Press the **Enable Ref** soft key to activate the reference mark evaluation routine



If an encoder is setup without reference marks the reference indicator will not be displayed. A datum set from the axis will be lost once power is turned off.

7.4.10 Selecting a specific reference mark

The product provides the ability to select a specific reference mark on an encoder. This is important when using encoders with fixed reference marks.

To select a specific reference mark:

- ▶ Press the **Disable Ref** soft key
- > The evaluation routine is paused. Any reference marks that are crossed during encoder movement are ignored.
- ▶ Cross over undesired reference marks
- ▶ Press the **Enable Ref** soft key
- > The next reference mark that is crossed will be selected.
- ▶ Cross the desired reference mark
- ▶ Repeat this process for all desired reference marks
- ▶ Press the **No Ref** soft key to cancel out of routine after all desired axes are established
- > Only the axes that are needed require crossing over the reference marks. If all reference marks have been found the product will return to the DRO display screen automatically.



The product does not store datum points if the reference marks are not crossed. The relationship between axis slide positions and display values will not be re-established after a power interruption or switch-off.

7.4.11 Error messages

If an error occurs while working with the product, a message will appear on the display, and provide an explanation of what caused the error.

Further information: "What to do if...", Page 283

To clear an error message:

- ▶ Press the **C** key
- > The error message will be cleared and normal operation can continue

7.4.12 Setup menus

The product has two menus for setting up operating parameters:

- **Installation Setup**
- **Job Setup**

Installation Setup

The **Installation Setup** menu is used to establish encoder, display, and communication parameters.

Further information: "Installation Setup", Page 72

To access the **Installation Setup** menu:

- ▶ Press the **Setup** soft key
- ▶ Select **Installation Setup**
- > The **Installation Setup** options are displayed

Job Setup

The **Job Setup** menu is used to accommodate specific machining requirements for each job.

Further information: "Job Setup", Page 93

To access the **Job Setup** menu:

- ▶ Press the **Setup** soft key
- ▶ Select **Job Setup**
- > The **Job Setup** options are displayed

7.5 User Management

The **User Management** menu provides a **Supervisor Login** and **User Job Settings** management.

7.5.1 Supervisor Login

The **Supervisor Login** allows you to manage users in the **User Management** menu and to modify configuration parameters in the **Installation Setup** menu.

Further information: "Installation Setup", Page 72

To login as a supervisor:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence:
 - **User Management**
 - **Supervisor Login**
- ▶ Enter the **Passcode** '8891'
- ▶ Press the **enter** key

7.5.2 User Job Settings

When **Job Setup** parameters are configured they are automatically saved under the selected user.

Further information: "Job Setup", Page 93

Selecting a User

To select a **User**:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence:
 - **User Management**
 - **User Job Settings**
- ▶ Use the **up** and **down arrow** keys to highlight **Load** for the desired **User**
- ▶ Press the **enter** key
- > The selected **User** is displayed in the status bar
- ▶ Press the **C** key twice to return to the DRO screen

Saving User Job Settings

To save **User Job Settings**:

- ▶ Select a **User**
- ▶ Configure **Job Setup** parameters for the user
Further information: "Job Setup", Page 93
- > The **Job Setup** parameters are automatically saved for the selected user.
- ▶ Select another **User** and repeat these steps until all of your required users have been setup

Supervisor level User Job Settings

A supervisor can create a default set of **Job Setup** parameters and use the settings to reset user configurations.

Further information: "Supervisor Login", Page 67

Creating a default set of Job Setup parameters

To create default **User Job Settings**:

- ▶ Select **User-0**
- ▶ Configure **Job Setup** parameters for **User-0**
Further information: "Job Setup", Page 93
- > The **Job Setup** parameters are automatically saved for the user

Resetting User Job Settings

To reset an individual **User**:

- ▶ Select a **User**
- ▶ Press the **right arrow** key to open the drop-down menu
- ▶ Press the **down arrow** key to highlight **Reset**
- ▶ Press the **enter** key to select **Reset**
- ▶ Press the **enter** key to reset the **Job Setup** parameters for the selected user to the **User-0** settings

To reset **All Users**:

- ▶ Select **All Users**
- ▶ Press the **enter** key to reset the **Job Setup** parameters for all users to the **User-0** settings

8

Commissioning

8.1 Overview



Make sure that you have read and understood the "Basic Operation" chapter before performing the activities described in this section.

Further information: "Basic operation", Page 55



The following steps are only to be performed by qualified personnel.

Further information: "Personnel qualification", Page 25

During the commissioning process the product is configured for use.

Parameters that are changed during the commissioning process can be reset to the factory defaults.

Further information: "Factory defaults", Page 85

Backing up the configuration

Configuration data can be backed up after commissioning. The configuration data can be reused for equivalent products.

Further information: "Configuration parameters", Page 72

8.2 Installation Guide

An **Installation Guide** is provided the first time you switch-on the product. This guide will step you through common commissioning parameters.

Information about specific parameters included in the **Installation Guide** can be found in the Settings section of these instructions.

Further information: "Settings", Page 265



The **Installation Guide** provides configuration options for the following parameters:

- | | | |
|---------------------------|-----------------------------|--------------------------------|
| ■ Language | ■ Encoder Setup | ■ Display Configuration |
| ■ Readout Settings | ■ Encoder Type | ■ Display Resolution |
| ■ Application | ■ Encoder Resolution | ■ Label |
| ■ Number of Axes | ■ Reference Mark | ■ Display Color Scheme |
| | ■ Count Direction | ■ Color Mode |
| | ■ Error Monitor | |

Opening the Installation Guide

To access the **Installation Guide** from the first-time startup screen:

- ▶ Press the **Installation Guide** soft key
- > The **Installation Guide** opens

Navigating the Installation Guide

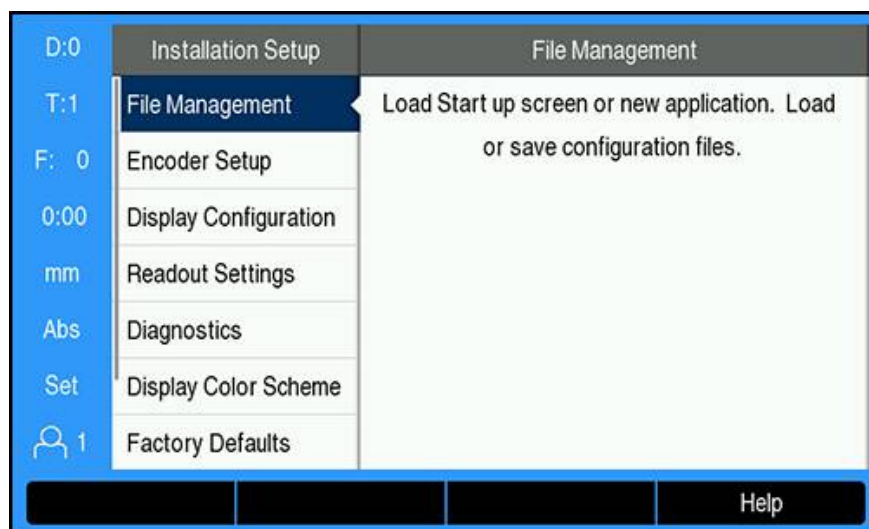
- ▶ Press the **right arrow** key to open a parameter drop-down menu
- ▶ Press the **up** or **down arrow** key to highlight a parameter option
- ▶ Press the **enter** key to select an option
- ▶ Press the **Next** soft key to advance to the next parameter
- or
- ▶ Press the **Previous** soft key to go back to a previous parameter
- ▶ Repeat these steps until all parameters have been set

8.3 Installation Setup

Further information: "Settings", Page 265

i **Installation Setup** parameters must be configured only by qualified personnel.

Further information: "Personnel qualification", Page 25



To access the Installation Setup menu:

- ▶ Press the **Setup** soft key
- ▶ Use the **up** or **down arrow** key to highlight **Installation Setup**
- ▶ Press the **right arrow** key
- > The **Installation Setup** menu is displayed

8.3.1 File management

Configuration parameters

The configuration of the product can be backed up as a file to make it available after a reset to the factory default settings or for installation on multiple products. A file with the following properties needs to be stored on the product for this purpose:

- File format: DAT
- File name: config.dat

Importing configuration parameters

To import configuration parameters:

- ▶ Insert a USB memory device containing the .dat file into the USB connection
- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **File Management**
 - **Configuration Parameters**
- ▶ Press the **Import** soft key
- ▶ Press the **enter** key to initiate importing the configuration parameters
- ▶ A pop-up warning informs you that the current parameter settings will be overwritten
- ▶ Press the **enter** key to import the configuration parameters and return to the **File Management** menu
- or
- ▶ Press the **C** key to cancel

Exporting configuration parameters

To export configuration parameters:

- ▶ Insert a USB memory device into the USB connection
- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **File Management**
 - **Configuration Parameters**
- ▶ Press the **Export** soft key
- ▶ Press the **enter** key to initiate exporting the configuration parameters
- ▶ A pop-up warning informs you that the current parameter settings will be exported to the attached USB memory device



The config.dat file on the USB memory device will be overwritten.

- ▶ Press the **enter** key to export the configuration parameters and return to the **File Management** menu
- or
- ▶ Press the **C** key to cancel

Segmented LEC Table

- File format: DAT
- File name: sllec_1.dat (axis 1), sllec_2.dat (axis 2), sllec_3.dat (axis 3), sllec_4.dat (axis 4)

Importing a Segmented LEC Table

To import a **Segmented LEC Table**:

- ▶ Insert a USB memory device containing the .dat file into the USB connection
- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **File Management**
 - **Segmented LEC Table**
- ▶ Press the **Import** soft key
- ▶ Press the **enter** key to initiate importing the table
- A pop-up warning informs you that the current table will be overwritten
- ▶ Press the **enter** key to import the table and return to the **File Management** menu or
- ▶ Press the **C** key to cancel

Exporting a Segmented LEC Table

To export a **Segmented LEC Table**:

- ▶ Insert a USB memory device into the USB connection
- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **File Management**
 - **Segmented LEC Table**
- ▶ Press the **Export** soft key
- ▶ Press the **enter** key to initiate exporting the table
- A pop-up warning informs you that the current table will be exported to the attached USB memory device
- ▶ Press the **enter** key to export the table and return to the **File Management** menu or
- ▶ Press the **C** key to cancel

Non-Linear EC Table



This feature is available on DRO203Q products only.

- File format: DAT
- File name: NLEC.dat

Importing a Non-Linear EC Table

To import a **Non-Linear EC Table**:

- ▶ Insert a USB memory device containing the .dat file into the USB connection
- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **File Management**
 - **Non-Linear EC Table**
- ▶ Press the **Import** soft key
- ▶ Press the **enter** key to initiate importing the table
- > A pop-up warning informs you that the current table will be overwritten
- ▶ Press the **enter** key to import the table and return to the **File Management** menu or
- ▶ Press the **C** key to cancel

Exporting a Non-Linear EC Table

To export a **Non-Linear EC Table**:

- ▶ Insert a USB memory device into the USB connection
- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **File Management**
 - **Non-Linear EC Table**
- ▶ Press the **Export** soft key
- ▶ Press the **enter** key to initiate exporting the table
- > A pop-up warning informs you that the current table will be exported to the attached USB memory device
- ▶ Press the **enter** key to export the table and return to the **File Management** menu or
- ▶ Press the **C** key to cancel

Tool Table

- File format: DAT
- File name: tool_mill.dat (**Mill** application), tool_turn.dat (**Turn** application)

Importing a Tool Table

To import a **Tool Table**:

- ▶ Insert a USB memory device containing the .dat file into the USB connection
- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **File Management**
 - **Tool Table**
- ▶ Press the **Import** soft key
- ▶ Press the **enter** key to initiate importing the table
- > A pop-up warning informs you that the current table will be overwritten
- ▶ Press the **enter** key to import the table and return to the **File Management** menu or
- ▶ Press the **C** key to cancel

Exporting a Tool Table

To export a **Tool Table**:

- ▶ Insert a USB memory device into the USB connection
- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **File Management**
 - **Tool Table**
- ▶ Press the **Export** soft key
- ▶ Press the **enter** key to initiate exporting the table
- ▶ A pop-up warning informs you that the current table will be exported to the attached USB memory device
- ▶ Press the **enter** key to export the table and return to the **File Management** menu or
- ▶ Press the **C** key to cancel

Operating Instructions

The product's **Operating Instructions** can be loaded onto the product and viewed using the **Help** function.

Operating Instructions can be loaded to the product in multiple languages. The product will look for the operating instructions in the **Language** selected in the **Job Setup** menu when loading the file from a USB memory device.



An error will be displayed if the operating instructions are not found on the USB memory device in the selected **Language**.

The **Operating Instructions** can be downloaded from the download area at www.acu-ritesolutions.com.

A file with the following properties needs to be loaded onto the product:

- File format: mPub
 - File name: DRO200_300_xx.mpub¹⁾
- ¹⁾ xx: corresponds to the ISO 639-1 two-letter code

To load the **Operating Instructions**:

- ▶ Select the desired **Language** if it is different than the currently selected language
- ▶ **Further information:** "Language", Page 105
- ▶ Insert a USB memory device containing the **Operating Instructions** mPub file into the USB connection
- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **File Management**
 - **Operating Instructions**
- ▶ Press the **Load** soft key
- ▶ Press the **enter** key to initiate loading the **Operating Instructions**
- ▶ A pop-up warning informs you that the **Operating Instructions** will be loaded
- ▶ Press the **enter** key to load the **Operating Instructions** or
- ▶ Press the **C** key to cancel

Power-up Screen

You can define an OEM-specific **Power-up Screen**, e.g. the company name or logo, which will be displayed when the product is switched on. An image file with the following properties needs to be stored on the product for this purpose:

- File format: 24-Bit Bitmap
- Image size: 800 x 480 px
- File name: OEM_SplashScreen.bmp

Importing a power-up screen

To import a power-up screen:

- ▶ Connect a USB mass storage device containing the OEM_SplashScreen.bmp file to the USB port of the product
- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **File Management**
 - **Power-up Screen**
- ▶ Press the **Import** soft key
- ▶ Press the **enter** key to initiate loading the power-up screen
- > A pop-up warning informs you that the power-up screen will be imported
- ▶ Press the **enter** key to import the power-up screen and return to the **File Management** menu
- or
- ▶ Press the **C** key to cancel

Exporting a power-up screen

To export a power-up screen:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **File Management**
 - **Power-up Screen**
- ▶ Press the **Export** soft key
- ▶ Press the **enter** key to initiate exporting the power-up screen
- > A pop-up warning informs you that the current power-up screen will be exported to the attached USB memory device



The OEM_SplashScreen.bmp file on the USB memory device will be overwritten.

- ▶ Press the **enter** key to export the power-up screen and return to the **File Management** menu
- or
- ▶ Press the **C** key to cancel

Service File

The product saves event data that may be used for analysis at a later time. You may be asked to provide this data, by exporting a **Service File**, in the event that your product requires service.

Exporting a Service File

To export a **Service File**:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **File Management**
 - **Service File**
- ▶ Press the **Export** soft key
- ▶ Press the **enter** key to initiate exporting the file
- A pop-up warning informs you that the file will be written to the USB mass storage device
- ▶ Press the **enter** key to export the file and return to the **File Management** menu or
- ▶ Press the **C** key to cancel

Clearing the Service File data

HEIDENHAIN recommends maintaining the maximum amount of free space available in the internal memory, by clearing the saved data, after exporting a **Service File**.

To clear the service file data:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **File Management**
 - **Service File**
- ▶ Press the **Clear** soft key
- ▶ Press the **enter** key to initiate clearing the history
- A pop-up warning informs you that the history will be lost
- ▶ Press the **enter** key to clear the data and return to the **File Management** menu or
- ▶ Press the **C** key to cancel

Product Software

To install a **Product Software** update:

- ▶ Insert a USB memory device containing the **Product Software** file into the USB connection
- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **File Management**
 - **Product Software**
- ▶ Press the **Install** soft key
- ▶ Press the **enter** key to initiate installing the software update
- > A pop-up warning informs you that the software update will be installed
- ▶ Press the **enter** key to install the software update
- > The product will restart
- or
- ▶ Press the **C** key to cancel

8.3.2 Encoder Setup

Encoder Setup parameters are used to configure each encoder input.



The adjustment procedure is the same for each axis. The following section describes the configuration of one axis. Repeat the procedure for each axis.

To set up an encoder:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **Encoder Setup**
- ▶ Select the encoder to set up:
 - **X1**
 - **X2**
 - **X3**
 - **X4**
- ▶ The **Encoder Setup** parameters are displayed for the selected axis
- ▶ Select the **Encoder Type**:
 - **Linear**
 - **Rotary**
 - **Rotary (Linear)**: a rotary encoder connected to a leadscrew
- ▶ Press the **µm/inch** soft key to select the desired **Resolution** unit of measure
 - **µm**
 - **inch**
- ▶ Select the desired **Resolution**:



The **Resolution** can also be established by moving the axis in either direction.

- ▶ Press the **enter** key to confirm the selection
- ▶ Select the desired **Reference Mark** type:
 - **None**: no reference signal
 - **Single**: single reference mark
 - **Position Trac**: an encoder with the Position-Trac feature
 - **P-Trac (ENC 250)**: an ENC 250 encoder with the Position-Trac feature
 - **EverTrack**: an encoder with the EverTrack feature
 - **LMF**: an LMF encoder with reference marks
- ▶ Press the **enter** key to confirm the selection
- ▶ Select the desired **Count Direction**:
 - **Negative**
 - **Positive**

When the encoder's count direction matches the operators count direction, select **Positive**. When they do not match, select **Negative**.



The **Count Direction** can also be established by moving the axis in the positive direction.

- ▶ Press the **enter** key to confirm the selection
- ▶ Select **On** or **Off** in the **Error Monitor** parameter to enable or disable monitoring of counting errors
- ▶ Press the **enter** key to confirm the selection
- ▶ Press the **enter** key to save the **Encoder Setup** parameter changes and return to the **Installation Setup** menu
- or
- ▶ Press the **C** key to cancel

Teaching rotary encoder resolution



This feature is available on DRO203Q products only.

To teach rotary encoder resolution:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **Encoder Setup**
- ▶ Select the encoder to set up:
 - X1
 - X2
 - X3
- ▶ Select the **Encoder Type**:
 - **Rotary**
- ▶ Press the **down arrow** key
- ▶ Select **Resolution**
- ▶ Press the **Teach** soft key to open the Teach Encoder Resolution form
- ▶ Enter the desired calibration Angle (ex. 180 degrees)
- ▶ Press the **down arrow** key
- ▶ Position the axis at 0 degrees
- ▶ Press the **Teach** soft key to start the calibration
- ▶ Rotate the axis the calibration angle
- ▶ Press the **Finish** soft key to complete the calibration
- ▶ Press the **enter** key to save the encoder resolution and return to the **Encoder Setup** menu
- or
- ▶ Press the **C** key to cancel

8.3.3 Display Configuration

Display Configuration parameters are used to configure the way axes information is shown on the display.



The adjustment procedure is the same for each axis display. The following section describes the configuration of one axis display. Repeat the procedure for each axis display.

To configure an axis display:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **Display Configuration**
- ▶ Select the axis display to set up:
 - **Display 1**
 - **Display 2**
 - **Display 3**
 - **Display 4**
- ▶ The **Display Configuration** parameters are displayed for the selected axis display
- ▶ Select the desired **Display Resolution**
Display Resolution options vary based on the encoders connected to the product.
- ▶ Press the **enter** key to confirm the selection
- ▶ Select a **Label** for the axis display or **Off** to turn off the selected axis display:

■ Off	■ A
■ X	■ B
■ Y	■ C
■ Z	■ S
■ U	■ T
■ V	■ Q
■ W	
- ▶ Press the **enter** key to confirm the selection
- ▶ Select **Off** or **On** to enable or disable a **Subscribe** zero being displayed after the axis label
- ▶ Press the **enter** key to confirm the selection
- ▶ Select the desired input for the axis display in the **Input 1** parameter:
 - **X1**
 - **X2**
 - **X3**
 - **X4**
- ▶ Press the **enter** key to confirm the selection
- ▶ Select **+** or **-** in the **Couple Operation** parameter to couple a second input with the first:
 - **+**
 - **-**
 - **Off**
- ▶ Press the **enter** key to confirm the selection
- ▶ Select the desired input to couple with **Input 1** in the **Input 2** parameter:

- **Not Defined**
- **X1**
- **X2**
- **X3**
- **X4**
- ▶ Press the **enter** key to confirm the selection
- ▶ Press the **enter** key to save the **Display Configuration** parameter changes and return to the **Installation Setup** menu
- or
- ▶ Press the **C** key to cancel

8.3.4 Readout Settings

Readout Settings parameters are used to set **Application**, axes, and **Position Recall** requirements.

To configure the readout:

- ▶ Press the **Setup** soft key
 - ▶ Open in the sequence
 - **Installation Setup**
 - **Readout Settings**
 - ▶ Select the **Application**
 - **Mill**
 - **Turn**
 - **EDM**
 - ▶ Select the **Number of Axes**:
 - **1**
 - **2**
 - **3**
 - **4**
 - ▶ Press the **enter** key to confirm the selection
 - ▶ Select **On** or **Off** to enable or disable **Position Recall**
- Position Recall** will store the last position of each axis when power was turned off, and then redisplay that position once power is turned back on.



Any movement that occurs while power is off will be lost. Whenever power has been off it is recommended to re-establish workpiece datums using the reference mark evaluation procedure.

Further information: "Reference mark evaluation", Page 64

- ▶ Press the **enter** key to confirm the selection
- ▶ Press the **enter** key to save the **Readout Settings** parameter changes and return to the **Installation Setup** menu
- or
- ▶ Press the **C** key to cancel

8.3.5 Diagnostics

The **Diagnostics** feature provides a way to test the keypad and display.

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **Diagnostics**

Keypad Test

An image of the keypad provides an indication when a key is pressed and released.

To test the keypad:

- ▶ Press each key to test
- ▶ A key that is operating properly will turn green in the **Diagnostics** screen when pressed on the keypad, and change to gray when released.
- ▶ Press the **C** key two times to exit the keypad test

Display Test

To test the display:

- ▶ Press the **enter** key to cycle through the available colors

8.3.6 Display Color Scheme

Display Color Scheme parameters are used to set the **Color Mode** of the product. Select the **Color Mode** that makes the display easiest to view in your workspace lighting conditions.

To select a color scheme:

- ▶ Press the **Setup** soft key
 - ▶ Open in the sequence
 - **Installation Setup**
 - **Display Color Scheme**
 - ▶ Select the **Color Mode**:
 - **Day**: the color scheme is set to **Day** and cannot be selected by the user
 - **Night**: the color scheme is set to **Night** and cannot be selected by the user
 - **User Selectable**: the color mode can be selected by the user from the **Job Setup** menu
 - ▶ Press the **enter** key to confirm the selection
 - ▶ Press the **enter** key to save the **Display Color Scheme** parameter changes and return to the **Installation Setup** menu
- or
- ▶ Press the **C** key to cancel

8.3.7 Factory defaults

Parameter changes made in the **Job Setup** and **Installation Setup** menus can be reset to the factory default settings. All parameters will be reset.

Further information: "Settings", Page 265

To reset parameters to factory default settings:


- ▶ Press the **Setup** soft key
 - ▶ Open in the sequence
 - **Installation Setup**
 - **Factory Defaults**
 - **Reset Settings**
 - ▶ Press the **Yes/No** soft key and select **Yes**
 - ▶ Press the **enter** key to initiate resetting the product to the factory default settings
 - ▶ A warning window will appear to confirm the reset
 - ▶ Press the **enter** key to reset parameters to the factory default settings
- The product will restart.
- or
- ▶ Press the **C** key to cancel the reset


8.3.8 Error Compensation

Error Compensation is used to compensate for encoder and machine travel variations with error correction coefficients. Coefficients are determined by comparing actual measurements of a standard to the nominal values.

For machine tools, the distance a cutting tool travels, measured by an encoder, can in certain cases differ from the actual tool travel. This error can occur due to ball screw pitch error, or deflection and tilting of axes. Errors can be determined with a reference measurement system, such as gauge blocks.

The product provides the ability to compensate for linear errors, and each axis can be programmed separately with the appropriate compensation.

 Error compensation is only available when using linear encoders.

 The adjustment procedure is the same for each axis. The following section describes the configuration of one axis. Repeat the procedure for each axis.

Configuring Linear Error Compensation

Linear Error Compensation (LEC) can be applied, if the results of a comparison with a reference standard show a linear deviation over the whole measuring length. In this case the error can be compensated by the calculation of a single correction factor.

To calculate the correction factor use this formula:

Correction factor **LEC** = $((S - M) / M) \times 10^6$ ppm with:

S = measured length with a reference standard

M = measured length with device at axis

Example:

If the length of the standard you used is 500 mm, and the measured length along the X-axis is 499.95, then the LEC for the X-axis is 100 parts per million (ppm).

LEC = $((500 - 499.95) / 499.95) \times 10^6$ ppm = **100 ppm** (rounded to the nearest whole number).

To configure LEC:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **Error Compensation**
- ▶ Select the input to configure:
 - **X1**
 - **X2**
 - **X3**
 - **X4**
- ▶ Enter the compensation factor using the numeric keypad
- ▶ Repeat these steps for each axis you want to configure
- ▶ Press the **enter** key to save the **Error Compensation** parameter changes and return to the **Installation Setup** menu
- or
- ▶ Press the **C** key to cancel

Configuring LEC automatically

The correction factor may be calculated automatically using a standard gauge block.

To configure LEC automatically:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **Error Compensation**
- ▶ Select the input to configure:
 - **X1**
 - **X2**
 - **X3**
- ▶ Select **Linear** to configure LEC for the input
- ▶ Press the **enter** key to confirm the selection
- ▶ Press the **Auto Calc** soft key to begin teaching the LEC factor
- ▶ Touch one edge of the standard with the tool
- ▶ Press the **Teach Edge 1** soft key
- ▶ Touch the opposite edge of the standard with the tool
- ▶ Press the **Teach Edge 2** soft key
- ▶ Enter the length of the standard in the **Actual** field
- ▶ Press the **enter** key to confirm the entered value
- ▶ Repeat these steps for each axis you want to configure with linear error compensation
- ▶ Press the **enter** key to save the **Error Compensation** parameter changes and return to the **Installation Setup** menu
- or
- ▶ Press the **C** key to cancel

Configuring Segmented LEC

Segmented LEC should be applied if the results of the comparison with a reference standard show an alternating, or oscillating deviation. The required correction values are calculated, and entered in a table. The product supports up to 200 points per axis. The error value between two entered adjacent correction points is calculated with linear interpolation.



Segmented LEC is only available on scales with reference marks. If Segmented LEC has been defined, no error compensation will be applied until the reference marks have been crossed.

Segmented LEC setup

The encoder has an inherent count direction. This may not reflect the user defined count direction and is only required for determining Segmented LEC.



Single reference mark encoders must cross the same reference mark each time the product is powered on.

To establish the inherent count direction for any installed encoder on a given axis, complete the following:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **Encoder Setup**
- ▶ Select the input to configure:
 - **X1**
 - **X2**
 - **X3**
- ▶ Select **Count Direction**
- ▶ Press the **Positive/Negative** soft key and select **Positive**
- ▶ Press the **enter** key to confirm the entered value
- ▶ Press the **enter** key to save the parameter changes
- ▶ Press the **C** key three times to return to the main display
- ▶ Move the axis that the encoder is mounted on and note the direction of movement required for the positive direction
- > The encoder's inherent count direction is now established.

Starting a Segmented LEC table

To start a Segmented LEC table:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **Error Compensation**
- ▶ Select the input to configure:
 - **X1**
 - **X2**
 - **X3**
- ▶ Select **Segmented** to configure Segmented LEC for the input
- ▶ Press the **enter** key to confirm the selection
- ▶ Press the **Create Table** soft key to begin creating the table

All correction points (up to 200) are equally spaced from the start point.
- ▶ Enter the **Number of points**
- ▶ Press the **down arrow** key
- ▶ Enter the **Spacing of Points**
- ▶ Press the **down arrow** key

The start point is measured from the encoder's reference point.
If this distance is known:
- ▶ Enter the **Start Point** distance

or

If this distance is not known:
- ▶ Move to the location of the start point
- ▶ Press the **Teach** soft key
- ▶ Press the **enter** key to confirm the entered values
- A pop-up warning informs you that creating a new table will clear any existing error points
- ▶ Press the **enter** key to save the table and return to the **Error Compensation** menu
- ▶ Repeat these steps for each axis you want to create a Segmented LEC table

Configuring a Segmented LEC table

- ▶ Press the **Edit Table** soft key to view the table entries
- ▶ Press the **up** or **down arrow** keys or the **numeric** keys to move to the correction point to be added or changed
- ▶ Press the **right arrow** key
- ▶ Enter the known deviation which exists at this point
- ▶ Press the **enter** key
- ▶ Repeat these steps for each point that requires a correction point
- ▶ Press the **enter** key to exit the table and return to the **Error Compensation** menu

Configuring Non-Linear Error Compensation (NLEC)



This feature is available on DRO203Q products only.

NLEC minimizes or eliminates the small inaccuracies in the XY measurement plane due to machine irregularities and encoder non-linearity. Error correction coefficients are obtained by measuring a certified calibration grid. The product supports up to a 30 x 30 point grid. The actual values are compared to nominal grid values by the DRO. When NLEC is enabled, the corrections are applied across the measured area of the X and Y measurement plane.

NLEC can be performed using one of two methods:

- Measuring points on a calibration grid
- Importing NLEC table data



NLEC is only available on encoders with reference marks. If NLEC has been defined, no error compensation will be applied until the reference marks have been crossed.

Non-Linear EC Setup

- ▶ Position the standard artifact along the measurement axis
- ▶ Align the artifact as closely as possible to the axis
- ▶ Measure a **Skew**. **Further information:** "Aligning the part to a measurement axis", Page 166.
- ▶ Create a datum at the 1, 1 point of the calibration grid. **Further information:** "Establishing a datum", Page 167.

Starting a Non-Linear EC table

To start a Non-Linear EC table:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **Error Compensation**
- ▶ Select the input to configure:
 - **X1**
 - **X2**
- ▶ Select **Non-Linear EC**
- ▶ Press the **enter** key to confirm the selection
- ▶ Press the **Create Table** soft key

All correction points are equally spaced from the start point.
- ▶ Enter the **Number of points (X)**
- ▶ Press the **down arrow** key
- ▶ Enter the **Number of points (Y)**
- ▶ Press the **down arrow** key
- ▶ Enter the **Spacing of Points (X)**
- ▶ Press the **down arrow** key
- ▶ Enter the **Spacing of Points (Y)**
- ▶ Press the **down arrow** key

The start point is measured from the encoder's reference point.
If this distance is known:
- ▶ Enter the **Start Point (X)** distance
- ▶ Press the **down arrow** key
- ▶ Enter the **Start Point (Y)** distance
- or

If this distance is not known:
- ▶ Move to the location of the start point
- ▶ Press the **Teach** soft key
- ▶ Press the **down arrow** key to highlight the **Start Point (Y)** field
- ▶ Press the **Teach** soft key
- ▶ Press the **enter** key to confirm the entered values
- > A pop-up warning informs you that creating a new table will clear any existing Non-Linear EC table data
- ▶ Press the **enter** key to save the table and return to the **Error Compensation** menu

Configuring a Non-Linear EC table

- ▶ Press the **Edit Table** soft key to edit or view the table entries
- ▶ Press the **up** or **down arrow** key or use the **numeric** keys to move to the desired X grid point to be changed
- ▶ Press the **Previous Y** or **Next Y** soft key to move to the desired Y grid point to be changed
- ▶ Press the **right arrow** key to open the **Non-Linear EC Correction Point** form
- ▶ Measure the point on the grid
- ▶ Enter the **Actual (X)** position or press the **Teach** soft key
- ▶ Press the **down arrow** key
- ▶ Enter the **Actual (Y)** position or press the **Teach** soft key
- ▶ Press the **enter** key to confirm the values and return to the table
- ▶ Repeat these steps for each grid point
- ▶ Press the **enter** key to exit the table and return to the **Error Compensation** menu

8.3.9 Backlash compensation

When using a rotary encoder with a lead screw, a change in direction of the table might cause an error in the displayed position due to clearances within the lead screw assembly. This clearance is referred to as backlash. This error can be compensated for by inputting the amount of backlash within the lead screw into the Backlash Compensation feature.


If the rotary encoder is ahead of the table (displayed value is greater than the table's true position), this is called positive backlash, and the value entered should be the positive value of the amount of error.

No Backlash Compensation is 0.000.

To specify backlash compensation:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **Backlash Comp.**
- ▶ Select the input to configure:
 - **X1**
 - **X2**
 - **X3**
 - **X4**
- ▶ Press the **On/Off** soft key and select **On**
- ▶ Enter the backlash compensation value
- ▶ Repeat these steps for all axes that require backlash compensation
- ▶ Press the **enter** key to save the backlash compensation values and return to the **Installation Setup** menu
- or
- ▶ Press the **C** key to cancel


8.3.10 Spindle settings

 This feature is available on DRO300 products only.

Spindle Settings options are available when an IOB 610 is connected to a DRO300 product. Refer to the IOB 610 operation section for configuration information.

Further information: "Spindle Speed control", Page 216


8.3.11 Switching outputs

 This feature is available on DRO300 products only.

Switching Outputs options are available when an IOB 610 is connected to a DRO300 product. Refer to the IOB 610 operation section for configuration information.

Further information: "Output settings", Page 213

8.3.12 CSS settings

 This feature is available on DRO300 products only.

CSS Settings options are available when an IOB 610 is connected to a DRO300 product. Refer to the IOB 610 operation section for configuration information.

Further information: "CSS control settings", Page 228

8.4 Job Setup

The **Job Setup** menu is used to establish specific machining requirements for each job.

8.4.1 Units

Units parameters are used to specify the preferred display units and format. You can also select the unit of measure by pressing the **inch/mm** key in either operating mode.

To set the unit of measure:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **Units**
- ▶ Select the **Linear** units of measure:
 - **inch**
 - **mm**
- ▶ Press the **enter** key to confirm the selection
- ▶ Select the **Angular** units of measure:
 - **Decimal Degrees**
 - **Radians**
 - **DMS**: Degrees, Minutes, Seconds
- ▶ Press the **enter** key to confirm the selection
- ▶ Select the **Angle Display** (available on DRO203Q products only)
 - **-360° ... +360°**
 - **0° ... 360°**
 - **-180° ... +180°**
- ▶ Press the **enter** key to confirm the selection
- ▶ Select the **Display Mode** (available on DRO203Q products only)
 - **Cartesian**
 - **Polar**
- ▶ Press the **enter** key to confirm the selection
- ▶ Press the **enter** key to save the **Units** parameter changes and return to the **Job Setup** menu

or
- ▶ Press the **C** key to cancel

8.4.2 Measure



This feature is available on DRO203Q products only.

Measure parameters are used to specify the preferred parameters for measuring part features.

To set the Measure parameters:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **Measure**
- ▶ Select the **Annotation** type
 - **Fixed**
 - **Free**
- ▶ Press the **enter** key to confirm the selection
- ▶ Select the number of points **Required for Point**
 - 1 or 2
- ▶ Press the **enter** key to confirm the selection
- ▶ Select the number of points **Required for Line**
 - 2 - 30
- ▶ Press the **enter** key to confirm the selection
- ▶ Select the number of points **Required for Circle**
 - 3 - 30
- ▶ Press the **enter** key to confirm the selection
- ▶ Select the **Distances** type
 - **Signed**
 - **Abs**
- ▶ Press the **enter** key to confirm the selection
- ▶ Press the **enter** key to save the **Measure** parameter changes and return to the **Job Setup** menu
- ▶ or
- ▶ Press the **C** key to cancel


8.4.3 Scale Factor

Scale Factor is used to scale a part up or down. A scale factor of 1.0 creates a part with the exact size as dimensioned on a print. A scale factor >1 "grows" the part, and <1 "shrinks" the part.



The **Scale Factor** setting range is ± 0.100 to 100.000

Settings are retained on a power cycle.

When the **Scale Factor** is a value other than 1, the scaling symbol  is shown on the axis display.

To set a **Scale Factor**:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **Scale Factor**
- ▶ Select the axis to configure
- ▶ Press the **On/Off** soft key and select **On**
- ▶ Enter the **Scale Factor** value
- ▶ Repeat these steps for all axes that require a **Scale Factor**
- ▶ Press the **enter** key to save the values and return to the **Job Setup** menu
- or
- ▶ Press the **C** key to cancel

Mirroring a part

A **Scale Factor** of -1.00 will produce a mirror image of the part. You can both mirror and scale a part at the same time.

8.4.4 Edge Finder



This feature is available on DRO300 products only.

Edge Finder parameters are used to setup the KT-130 edge finder.

Diameter and **Length Offset** values are in the **Units** selected in the form.

To set up an **Edge Finder**:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **Edge Finder**
- ▶ Enter the **Diameter** using the numeric keypad
- ▶ Enter the **Length Offset** using the numeric keypad
- ▶ Select the **Units**:
 - **inch**
 - **mm**
- ▶ Press the **enter** key to confirm the selection
- ▶ Press the **enter** key to save the **Edge Finder** parameter changes and return to the **Job Setup** menu
- or
- ▶ Press the **C** key to cancel

8.4.5 Diameter Axes

Diameter Axes parameters are used to set which axes can display radius or diameter values.

To setup the display of radius or diameter values:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **Diameter Axes**
- ▶ Select the desired axis to setup
- ▶ Press the **On/Off** soft key and select **On** to enable the display of radius or diameter values for the selected axis
- ▶ Repeat these steps for each axis to enable
- ▶ Press the **enter** key to save the **Diameter Axes** parameter changes and return to the **Job Setup** menu
- or
- ▶ Press the **C** key to cancel

8.4.6 Measured value out.



This feature is available on DRO300 products only.

Measured value out. is used to enable data output during probing operations.

When **Data Output Probing** is enabled, measurement data is output when a probe operation is completed. Probe measurement values, while doing probe operations within the set datum function, can be sent over the USB port to a USB mass storage device.

To enable **Measured value out.**:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **Measured value out.**
- ▶ Press the **On/Off** soft key to enable **Data Output Probing**
- ▶ Press the **enter** key to save the **Measured value out.** parameter changes and return to the **Job Setup** menu
 - or
 - ▶ Press the **C** key to cancel

8.4.7 Graphic positioning aid

Graphic positioning aids are displayed below each axis in Distance-To-Go (Inc) mode. Each axis has its own range that can be set.

Further information: "Graphic positioning aid", Page 60

To configure graphic positioning aid settings:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **Graphic Pos Aid**
- ▶ Select the desired axis to setup
 - The default range setting is 5.000 mm.
- ▶ Press the **On/Off** soft key to select **On** and use the default range setting
 - or
 - ▶ Enter a range setting using the numeric keypad
 - ▶ Repeat the process for each axis you would like to set
 - ▶ Press the **enter** key to save the **Graphic Pos Aid** parameter changes and return to the **Job Setup** menu
 - or
 - ▶ Press the **C** key to cancel

8.4.8 Status Bar Settings

The Status Bar is the segmented bar at the side of the display that shows the current **Datum**, **Tool**, **Feed Rate**, **Stopwatch** time, **Units**, operating mode status, **Set/Zero** setting, and the **Current User**.

To configure the status bar settings:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **Status Bar Settings**
- ▶ Select a parameter
- ▶ Press the **On/Off** soft key to enable or disable the selected option from being displayed in the status bar
- ▶ Repeat for each option you would like to enable or disable
- ▶ Press the **enter** key to save the **Status Bar Settings** parameter changes and return to the **Job Setup** menu
- or
- ▶ Press the **C** key to cancel

8.4.9 Stopwatch

The **Stopwatch** shows the hours, minutes, and seconds elapsed time. The clock starts timing from 00:00:00.

The **Stopwatch** can also be operated in the DRO screen using the numeric keypad.

Further information: "Stopwatch", Page 61

Accessing the Stopwatch controls

To access the controls:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **Stopwatch**

Starting and stopping the Stopwatch

To start or stop the **Stopwatch**:

- ▶ Press the **Start/Stop** soft key to start or stop the **Stopwatch**
- ▶ The **Elapsed Time** field shows the total accumulated time

Resetting the stopwatch

To reset the **Stopwatch**:

- ▶ Press the **Reset** soft key to reset the stopwatch time

8.4.10 Skew Compensation for Mill applications



This feature is available on DRO300 products only.

Skew Compensation allows you to drill holes on a workpiece without aligning the workpiece on the machine. Use this feature only for drilling holes.

When skew compensation is activated, the skew icon **S** is displayed on the right side of the axis display.

To configure **Skew Compensation**:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **Skew Compensation**
- ▶ Press the **On/Off** soft key to enable **Skew Compensation**
- ▶ Highlight the **Angle** field
- ▶ Enter the skew angle using the numeric keypad if it is known
or



The skew angle is learned by touching off two points along one side. When using the edge finder, the location of the edge is captured automatically.

- ▶ Touch a point on an edge with an edge finder, or touch a point and press the **Teach** soft key if probing with a tool
- ▶ Touch a second point on the same edge with an edge finder, or touch a second point and press the **Teach** soft key if probing with a tool

8.4.11 Remote Switch



This feature is available on DRO300 products only.

The remote switch sets the parameters so the external switch (pendant, or foot switch) can be enabled to perform any or all of the following functions:

- **Data Output:** send position information over the USB port to a USB mass storage device when the switch is closed
- **Zero:** zero an axis when the switch is closed
- **Next:** advance to the next hole in a hole pattern or next step in a program when the switch is closed

To setup the **Remote Switch**:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **Remote Switch**
- ▶ Press the **On/Off** soft key and select **On**, to enable **Data Output**
- ▶ Highlight the **Zero** field
- ▶ Press an axis key to enable zeroing of the axis when the switch is closed. More than one axis can be selected.
- ▶ Highlight the **Next** field
- ▶ Press the **On/Off** soft key and select **On**, to enable advancing to the next hole in a hole pattern or next step in a program when the switch is closed
- ▶ Press the **enter** key to save the **Remote Switch** parameter changes and return to the **Job Setup** menu
- or
- ▶ Press the **C** key to cancel

8.4.12 DRO View Settings



This feature is available on DRO300 products only.

The product has the ability to define up to three DRO display configurations (views). Each view defines which axes displays appear on the screen when the view is selected.

With three views available, one may be set to all available axes, and the others may be a subset of the axes.



Axis keys correspond to the axes being displayed in the current DRO view. If only two axes are being displayed, and there are more axis keys (3 or 4), then only the top two keys will function. Unmatched keys are ignored.

When two or more DRO views are configured, the DRO mode includes a **View** soft key which is used to toggle between **DRO 1**, **DRO 2**, and **DRO 3** views. The current view is indicated on the soft key.

Multiple DRO views are only available when the full screen DRO is displayed. In screens where the small DRO is displayed, all axes positions are displayed and multiple DRO views are not available.

When running a program or a single cycle pattern, the large DRO uses the current DRO view that is selected. The view with the graphic and small DRO will show all available axes.


To setup the **DRO View Settings**:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **DRO View Settings**
- ▶ Highlight the **DRO** view field you would like to configure
 - **DRO 1**
 - **DRO 2**
 - **DRO 3**
- ▶ Press an axis key to add the axis to the selected view. If an axis key is pressed for an axis that is already included, the axis will be removed.
- ▶ Repeat the last two steps for all views you would like to configure
- ▶ Press the **enter** key to save the **DRO View Settings** parameter changes and return to the **Job Setup** menu
- or
- ▶ Press the **C** key to cancel

8.4.13 Display Settings

Display Settings parameters are used to adjust the appearance of the display.

To configure **Display Settings**:

- ▶ Press the **Setup** soft key
 - ▶ Open in the sequence
 - **Job Setup**
 - **Display Settings**
 - ▶ Use the **left** or **right arrow** key to adjust the **Brightness** level of the display
The display brightness can also be adjusted using the **up** and **down arrow** keys when the product is in either operating mode.
 - ▶ Select the time in minutes that the display is idle before the **Display Saver (min)** is activated and the display is switched off:
 - **Off**
 - **10**
 - **30**
 - ▶ Press the **enter** key to confirm the selection
 - ▶ Press the **Day/Night** soft key to select the desired **Color Mode**:
 - **Night**
 - **Day**
 - ▶ Select how the axis that is in motion is displayed:
 - **Normal**: All axes are displayed normal
 - **Dynamic Zoom**: The axis in motion is displayed larger than axes not in motion
 - **Highlight**: In **Day** mode axes in motion are displayed in black, axes not in motion are displayed in gray. In **Night** mode axes in motion are displayed in white, axes not in motion are displayed in gray.
-  If **Dynamic Zoom** or **Highlight** is selected, the feature can be toggled on and off from the DRO screen.
To toggle the feature:

 - ▶ Press the **+/-** key
- ▶ Press the **enter** key to confirm the selection
 - ▶ Enter the number of seconds, in the **Zoom Timeout (sec)** field, that **Dynamic Zoom** or **Highlight** stays active after axis movement has stopped
 - ▶ Press the **enter** key to save the **Display Settings** parameter changes and return to the **Job Setup** menu
or
 - ▶ Press the **C** key to cancel

8.4.14 Print



This feature is available on DRO203Q products only.

Print parameters are used to specify the preferred parameters for formatting data for output via USB to a mass storage device or PC.

To set the **Print** parameters:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **Print**
- ▶ Select the **Print Label** parameter
 - **No**
 - **Yes**
- ▶ Press the **enter** key to confirm the selection
- ▶ Select the **Print Units** parameter
 - **No**
 - **Yes**
- ▶ Press the **enter** key to confirm the selection
- ▶ Select the **Post Line** parameter
 - **LF Only (10)**
 - **CR / LF (13 10)**
- ▶ Press the **enter** key to confirm the selection
- ▶ Press the **enter** key to save the **Print** parameter changes and return to the **Job Setup** menu
- ▶ or
- ▶ Press the **C** key to cancel

8.4.15 System Information

The **System Information** screen provides product and software information.

Available information:

- **Product Name**
- **Product ID**
- **Serial Number**
- **Software Version**
- **Bootloader Version**
- **FPGA Version**
- **Board ID**

To access **System Information**:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **System Information**
- ▶ Press the **enter** key
- > The **System Information** screen is displayed
- ▶ Press the **C** key to exit **System Information**

8.4.16 Language

The **Language** parameter is used to select the language for the user interface. The default language is English.

To change the Language:

- ▶ Press the **Setup** soft key
 - ▶ Open in the sequence
 - **Job Setup**
 - **Language**
 - ▶ Select the desired language
 - ▶ Press the **enter** key to confirm the selection
 - ▶ Press the **enter** key to save the **Language** parameter change and return to the **Job Setup** menu
- or
- ▶ Press the **C** key to cancel

9

**Milling specific
operations**

9.1 Overview

This chapter describes operations and soft key functions specific to milling applications.

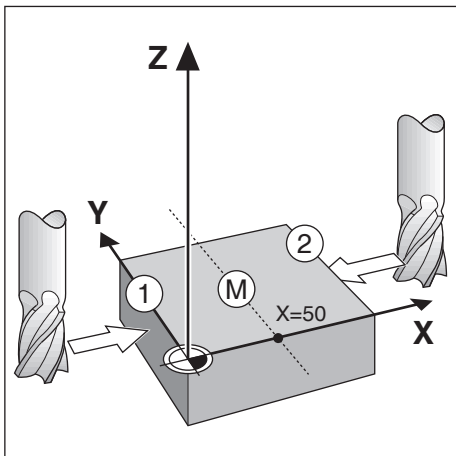
i Make sure that you have read and understood the "Basic Operation" chapter before performing the activities described in this section.
Further information: "Basic operation", Page 55

9.2 1/2 soft key

The **1/2** soft key is available when the product is setup for milling applications and is used to find the centerline (or midpoint) between two locations along a selected axis of a workpiece. This can be performed in either Actual Value or Distance-To-Go mode.

i This feature will change datum locations when in Actual Value mode.

Example: Finding the midpoint along a selected axis



X dimension: X = 100 mm

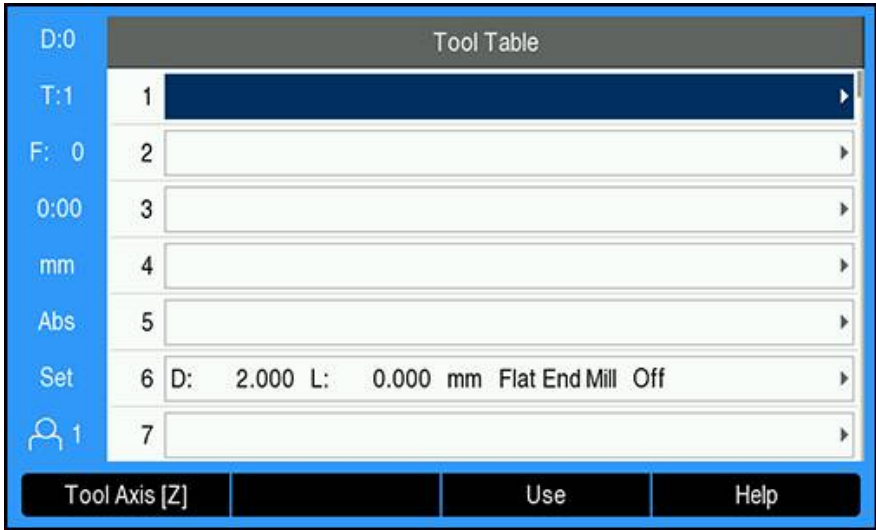
Midpoint: 50 mm

To find the midpoint:

- ▶ Move the tool to the first point
 The **Set/Zero** soft key must be set to **Zero**.
- ▶ Press the **X axis** key
- ▶ Move to the second point
- ▶ Press the **1/2** soft key
- ▶ Press the **X axis** key
- ▶ Move the tool until zero is reached
- > This is the midpoint location

9.3 Tool Table

The **Tool Table** is used to store diameter and length offset information for tools.
The DRO203 **Tool Table** can store information for up to 16 tools.
The DRO300 **Tool Table** can store information for up to 100 tools.



Opening the Tool Table

- To open the **Tool Table**:
- ▶ Press the **Tool** soft key

Selecting a Tool

- To select a **Tool**:
- ▶ Use the **up** or **down arrow** key to highlight a tool or
 - ▶ Enter the tool number using the numeric key pad
 - ▶ Press the **right arrow** key or
 - ▶ Press the **enter** key
 - > The tool form for the selected tool is displayed

9.3.1 Soft keys

The following soft keys are available in the **Tool Table** form or in the individual tool data form:

Soft key	Function
Tool Axis	Press the Tool Axis soft key to toggle and select which axis the tool length offsets will affect. The tool's diameter values will subsequently be used to offset the remaining two axes.
Teach	Press the Teach soft key to automatically enter the tool offset length. This key is only available in the Length field.
Clear	Press the Clear soft key to remove a tool from the table
Use	Press the Use soft key to select the highlighted tool from the table
Help	Press the Help soft key to access Tool Table specific help

9.3.2 Importing and exporting

A **Tool Table** can be imported from an existing file or exported for backup and future use.

Further information: "Tool Table", Page 75

9.3.3 Tool compensation

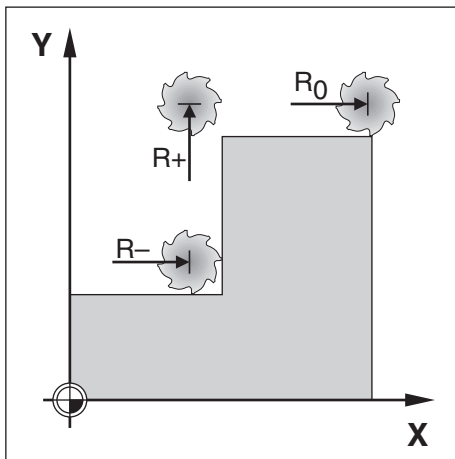
Tool compensation allows you to enter workpiece dimensions directly from the drawing.

Radius compensation

Tool radius compensation is calculated based on the value entered in the **Diameter** field in the **Tool** form.

R represents the tool radius. The displayed distance-to-go is automatically lengthened **R+**, or shortened **R-** by the value of the tool radius.

Further information: "Presetting a target position", Page 123



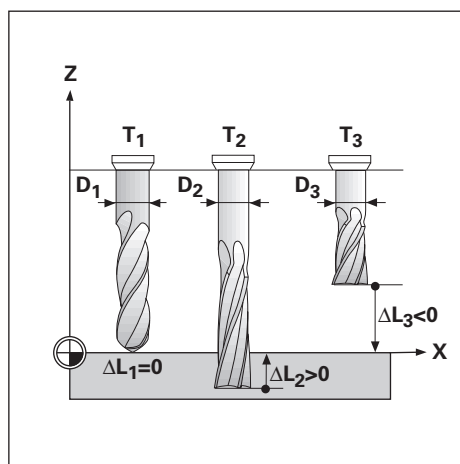
Length offset

Tool length offset is calculated based on the value entered into the **Length** field in the **Tool** form. The length offset can be entered as a known value or the product can teach the offset.

Further information: "Entering tool data", Page 112

The tool length is the difference in length ΔL between the tool and the reference tool. The length difference is indicated with the " Δ " symbol. The reference tool is indicated by T1.

- If the tool is **longer** than the reference tool: $\Delta L > 0$ (+)
- If the tool is **shorter** than the reference tool: $\Delta L < 0$ (-)



9.3.4 Entering tool data

D:0		Tool (1)		Position	
T:1	Diameter	<input type="text" value="4.500"/>	X	<input type="text" value="0.000"/>	
F: 0	Length	<input type="text" value="0.000"/>	Y	<input type="text" value="0.000"/>	
0:00	Units	<input type="text" value="mm"/>	Z	<input type="text" value="0.000"/>	
mm	Type	<input type="text" value="Flat End Mill"/>	W	<input type="text" value="0.000"/>	
Abs	Spindle Dir	<input type="text" value="Off"/>			
Set	Spindle Speed	<input type="text" value="0"/>			
<div> <input type="button" value="1"/> <input type="button" value="Help"/> </div>					

To enter data into a **Tool** form:

- ▶ Press the **Tool** soft key
- ▶ Use the **up** or **down arrow** key to highlight the desired tool
or
- ▶ Enter the tool number using the numeric keypad
- ▶ Press the **Enter** key
- ▶ The **Tool** form for the selected tool is displayed
- ▶ Enter the tool **Diameter**
- ▶ Enter the tool **Length**
or
- ▶ Press the **Teach** soft key and follow the procedure for **Teaching length offset** described in this section.
- ▶ Select the tool **Units**
 - **inch**
 - **mm**
- ▶ Select the tool **Type**
 - **Not Defined**
 - **Ball End Mill**
 - **Boring Head**
 - **Broach**
 - **Carbide Mill**
 - **Counter Bore**
 - **Counter Sink**
 - **Drill**
 - **Engraving Tip**
 - **Flat End Mill**
 - **Fly Cutter**
 - **Pilot Drill**
 - **Reamer**
 - **Roughing Mill**
 - **Shell End Mill**
 - **Special Mill**
 - **Tap**

Spindle data is required when **Spindle Speed** control has been installed. Available on the DRO300 only.

Further information: "Spindle Speed control operation", Page 222

- ▶ Press the **enter** key to save the tool changes and return to the **Tool Table**

Teaching length offset

It is also possible to have the product determine an offset. This method involves touching the tip of each tool to a common reference surface. This allows the product to determine the difference between the length of each tool.

i Only the tools set using the same reference surface may be changed without having to reset the datum.

i If the tool table already contains tools in which the length has been set, the reference surface should first be established using one of them. If not, you will not be able to switch between the new tools and the existing tools without having to re-establish the datum. Before adding the new tools, select one of the tools from the tool table. Touch the tool to a reference surface and set the datum to 0

To teach **Length Offset**:

- ▶ Move the tool until its tip is touching the reference surface
- ▶ Press the **Teach** soft key
- ▶ The product will calculate an offset relative to the reference surface
- ▶ Repeat the procedure for each additional tool using the same reference surface

9.3.5 Selecting a tool

Before you start machining, select the tool you are using from the **Tool Table**. The product then takes into account the stored tool data when working with tool compensation.

To select a tool:

- ▶ Press the **Tool** soft key
- ▶ Use the **up** or **down arrow** keys to highlight the tool you want to select
- ▶ Press the **Use** soft key
- ▶ Verify in the status bar that the correct tool was selected

9.4 Setting a datum

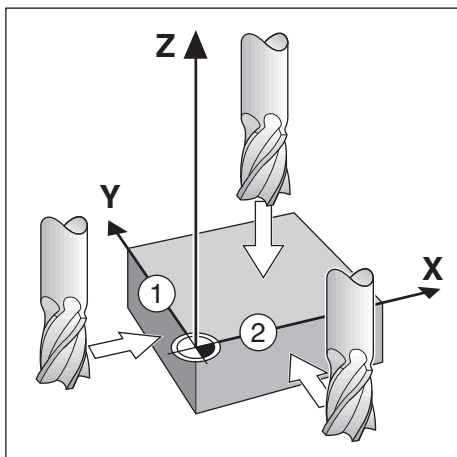
Datum settings define the relationships between the axis positions and the display values.

The easiest way to set datum points is to use the probing function when probing the workpiece with the edge of a tool.

Datum points can also be set by touching the edges of the workpiece, one after the other with a tool, and manually entering the tool positions as datum points.

The datum table can hold up to 10 datum points. In most cases this will eliminate from having to calculate the axis travel when working with complicated workpiece drawings containing several datums.

9.4.1 Setting a workpiece datum without using the probing function



D:0	Datum		Position	
T:1	Datum Number	0	X	0.000
F: 0	X	1.500	Y	0.000
0:00	Y	1.500	Z	0.000
mm	Z	0.000	W	0.000
Abs	W			
Set	Enter new actual position of tool or press Probe.			
1				
Probe		Calc		Help

- Axis sequence in this example: X - Y - Z
To set a datum without the probing function:
- ▶ Press the **Datum** soft key
- ▶ Enter the **Datum Number**
- ▶ Highlight the X axis field
- ▶ Touch the workpiece at edge **1**
- ▶ Enter the position of the tool center (X = 1.5 mm)
- ▶ Highlight the Y axis field
- ▶ Touch the workpiece at edge **2**
- ▶ Enter the position of the tool center (Y = 1.5 mm)
- ▶ Highlight the Z axis field
- ▶ Touch the workpiece surface
- ▶ Enter the position of the tool tip (Z = 0 mm) for the Z coordinate of the datum
- ▶ Press the **enter** key

9.4.2 Probing with a tool

A tool or non-electrical edge finder can be used to set datum points.

The following probing functions are available:

- Workpiece edge as datum: **Edge** soft key
- Centerline between two workpiece edges: **Center Line** soft key
- Center of a hole or cylinder: **Circle Center** soft key

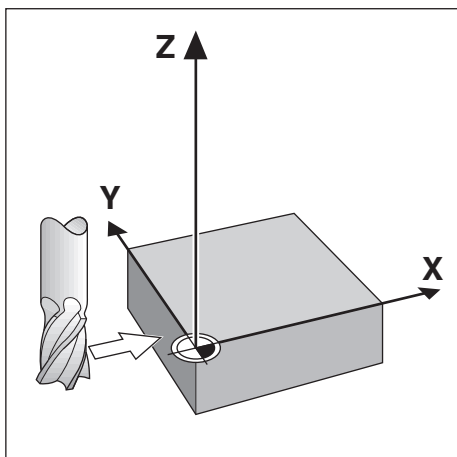
In all probing functions the product takes into account the current tool's tip diameter.

Canceling a probing function

To cancel a probing function while it is active:

- ▶ Press the **C** key

Probing an Edge with a tool



D:0	Datum		Position	
T:1	Datum Number	0	X	0.000
F: 0	X		Y	0.000
0:00	Y		Z	0.000
mm	Z		W	0.000
Abs	W			
Set	Select the probe function.			
1				

Edge
Center Line
Circle Center
Help

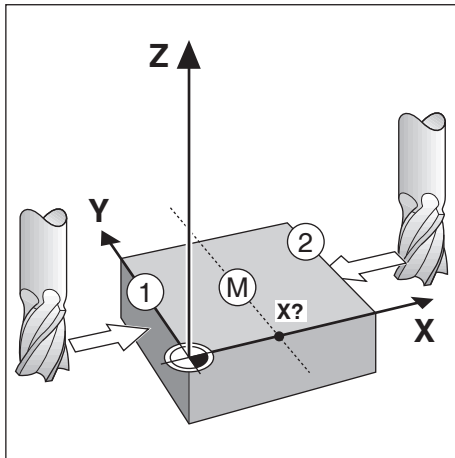
To probe an edge with a tool:

- ▶ Set the active tool to the tool that will be used to set the datum
- ▶ Press the **Datum** soft key
- ▶ Enter the **Datum Number**
- ▶ Highlight the **X** axis field
- ▶ Press the **Probe** soft key
- ▶ Press the **Edge** soft key
- ▶ Touch the workpiece edge
- ▶ Press the **Teach** soft key

The **Teach** soft key is useful when determining tool data by touching the workpiece in the absence of an edge finder with feedback. To avoid losing the position value when the tool is retracted, press the **Teach** soft key to store the value while it is in contact with the workpiece edge. The location for the touched edge will take into account the diameter of the tool in use (T:1, 2...), and the last direction the tool was moved prior to pressing the **Teach** soft key.

- ▶ Retract the tool from the workpiece
- ▶ Enter the position of the workpiece edge
- ▶ Press the **enter** key

Probing a Center Line with a tool

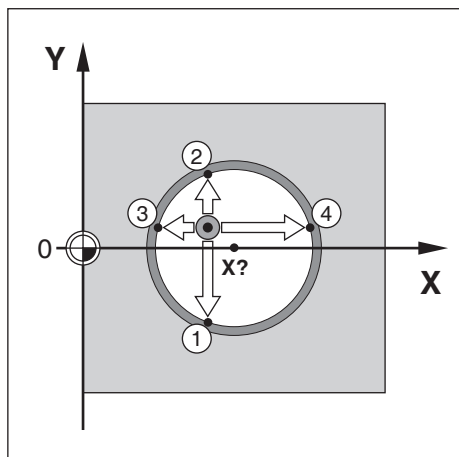


D:0	Datum		Position	
T:1	Datum Number	0	X	0.000
F: 0	X		Y	0.000
0:00	Y		Z	0.000
mm	Z		W	0.000
Abs	W			
Set	Move to the first edge or press Teach.			
1				
		Teach		Help

To probe a centerline with a tool:

- ▶ Set the active tool to the tool that will be used to set the datum
- ▶ Press the **Datum** soft key
- ▶ Enter the **Datum Number**
- ▶ Highlight the **X** axis field
- ▶ Press the **Probe** soft key
- ▶ Press the **Center Line** soft key
- ▶ Touch the first workpiece edge **1**
- ▶ Press the **Teach** soft key
- ▶ Touch the second workpiece edge **2**
- ▶ Press the **Teach** soft key
- > The datum is set to 0.000 and the distance between the edges is displayed
- ▶ Retract the tool from the workpiece
- ▶ Enter the position of the workpiece centerline
- ▶ Press the **enter** key

Probing a Circle Center with a tool



D:0	Datum		Position	
T:1	Datum Number	0	X	0.000
F: 0	X		Y	0.000
0:00	Y		Z	0.000
mm	Z		W	0.000
Abs	W			
Set	Move to the first edge or press Teach.			
1				
		Teach		Help

To probe a **Circle Center** with a tool:

- ▶ Set the active tool to the tool that will be used to set the datum
- ▶ Press the **Datum** soft key
- ▶ Enter the **Datum Number**
- ▶ Highlight the **X** axis field
- ▶ Press the **Probe** soft key
- ▶ Press the **Circle Center** soft key
- ▶ Touch the first workpiece edge **1**
- ▶ Press the **Teach** soft key
- ▶ Touch the second workpiece edge **2**
- ▶ Press the **Teach** soft key
- ▶ Touch the third workpiece edge **3**
- ▶ Press the **Teach** soft key
- ▶ Touch the fourth workpiece edge **4**
- ▶ Press the **Teach** soft key
- The **X** and **Y** datums are set to 0.000 and the diameter of the circle is displayed.
- ▶ Retract the tool from the workpiece
- ▶ Enter the **X** and **Y** axis position of the circle center
- ▶ Press the **enter** key

9.4.3 Probing with an edge finder



This feature is available on DRO300 products only.

An electrical edge finder can be used to set datum points.

The following probing functions are available:

- Workpiece edge as datum: **Edge** soft key
- Centerline between two workpiece edges: **Center Line** soft key
- Center of a hole or cylinder: **Circle Center** soft key

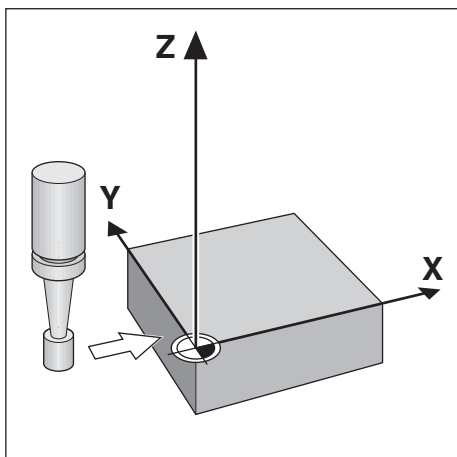
In all probing functions the product takes into account the edge finder's tip diameter.



The edge finder's dimensional characteristics must first be setup in order to perform probing.

Further information: "Edge Finder", Page 97

Probing an Edge with an edge finder

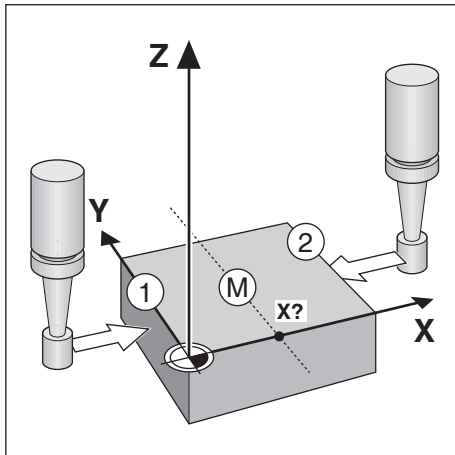


D:0	Datum		Position	
T:1	Datum Number	<input type="text" value="0"/>	X	<input type="text" value="0.000"/>
F: 0	X	<div style="background-color: #003366; width: 100px; height: 1.2em;"></div>	Y	<input type="text" value="0.000"/>
0:00	Y	<input type="text"/>	Z	<input type="text" value="0.000"/>
mm	Z	<input type="text"/>	W	<input type="text" value="0.000"/>
Abs	W	<input type="text"/>		
Set	Move to the edge or press Teach.			
1				
		Teach		Help

To probe an **Edge** with an edge finder:

- ▶ Press the **Datum** soft key
- ▶ Enter the **Datum Number**
- ▶ Highlight the **X** axis field
- ▶ Press the **Probe** soft key
- ▶ Press the **Edge** soft key
- ▶ Touch the workpiece edge
- ▶ Retract the edge finder from the workpiece
- ▶ Enter the position of the workpiece edge
- ▶ Press the **enter** key

Probing a Center Line with an edge finder

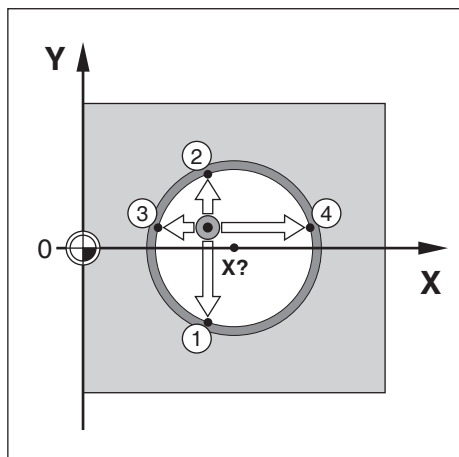


D:0	Datum		Position	
T:1	Datum Number	0	X	0.000
F: 0	X		Y	0.000
0:00	Y		Z	0.000
mm	Z		W	0.000
Abs	W			
Set	Move to the first edge or press Teach.			
1				
		Teach		Help

To probe a **Center Line** with an edge finder:

- ▶ Press the **Datum** soft key
- ▶ Enter the **Datum Number**
- ▶ Highlight the **X** axis field
- ▶ Press the **Probe** soft key
- ▶ Press the **Center Line** soft key
- ▶ Touch the first workpiece edge **1**
- ▶ Touch the second workpiece edge **2**
- > The datum is set to 0.000 and the distance between the edges is displayed
- ▶ Retract the edge finder from the workpiece
- ▶ Enter the position of the workpiece centerline
- ▶ Press the **enter** key

Probing a Circle Center with an edge finder



D:0	Datum		Position	
T:1	Datum Number	0	X	0.000
F: 0	X		Y	0.000
0:00	Y		Z	0.000
mm	Z		W	0.000
Abs	W			
Set	Move to the first edge or press Teach.			
1				
		Teach		Help

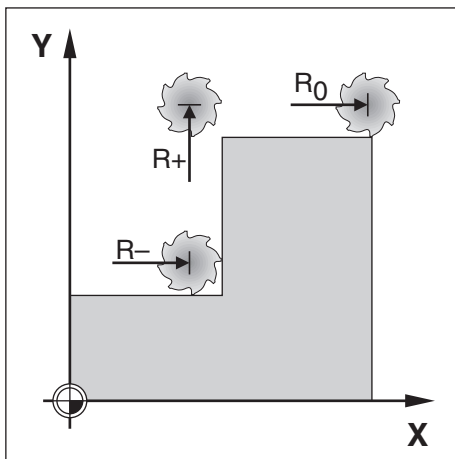
To probe a **Circle Center** with a tool:

- ▶ Press the **Datum** soft key
- ▶ Enter the **Datum Number**
- ▶ Highlight the **X** axis field
- ▶ Press the **Probe** soft key
- ▶ Press the **Circle Center** soft key
- ▶ Touch the first workpiece edge **1**
- ▶ Touch the second workpiece edge **2**
- ▶ Touch the third workpiece edge **3**
- ▶ Touch the fourth workpiece edge **4**
- > The **X** and **Y** datums are set to 0.000 and the diameter of the circle is displayed.
- ▶ Retract the edge finder from the workpiece
- ▶ Enter the **X** and **Y** axis position of the circle center
- ▶ Press the **enter** key

9.5 Presetting a target position

The **Preset** function allows you to indicate the nominal (target) position for the next move. Once the new nominal position information is entered the display will switch to Distance-To-Go mode and show the distance between the current position and the nominal position. You now only need to move the table until the display is zero and you will be at the required nominal position. The information for the location of the nominal position can be entered as an absolute move from the current datum zero or as an incremental move from the current nominal position.

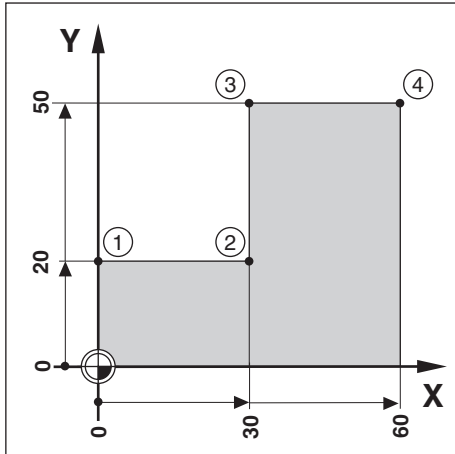
Presetting also allows you to indicate which side of the tool will be doing the machining at the nominal position. The **R +/-** soft key in the **Preset** form defines the offset that will be in effect during the move. **R+** indicates that the center line of the current tool is in a more positive direction than the edge of the tool. **R-** indicates that the center line is in a more negative direction than the edge of the current tool. Using **R +/-** offsets automatically adjusts the distance-to-go value to account for the diameter of the tool.



9.5.1 Absolute distance preset

Example

Milling a shoulder by traversing to display value zero using absolute position.



D:0	Preset				Position			
T:1	X	R0	R+	R-	I	12.500	X	0.000
F: 0	Y	R0	R+	R-	I	6.35	Y	0.000
0:00	Z				I		Z	0.000
mm	W				I		W	0.000
Abs								
Set								
1								

R +/-
I
Calc
Help

The coordinates are entered as absolute dimensions; the datum is the workpiece zero. Using this figure example:

- Corner 1: X = 0 / Y = 20
- Corner 2: X = 30 / Y = 20
- Corner 3: X = 30 / Y = 50
- Corner 4: X = 60 / Y = 50



Press the **Preset** soft key, then an axis key to recall the last entered preset value for that axis.

Preparation

- ▶ Select the tool with the appropriate tool data
- ▶ Pre-position the tool to an appropriate location (such as X = Y = -10)
- ▶ Move the tool to milling depth
- ▶ Press the **Preset** soft key
- ▶ Press the **Y axis** key

Alternative method one

- ▶ Press the **Set/Zero** soft key so that you are in **Set** mode
- ▶ Press the **Y axis** key
- ▶ Enter the nominal position value for corner point **1**: Y = 20
- ▶ Select **R +** with the **R +/-** soft key
- ▶ Press the **enter** key
- ▶ Traverse the **Y** axis until the display value is zero
- > The square in the graphical positioning aid is now centered between the two center marks.
- ▶ Press the **Preset** soft key
- ▶ Press the **X axis** key

Alternative method two

- ▶ Press the **Set/Zero** soft key so that you are in **Set** mode
 - ▶ Press the **X axis** key
 - ▶ Enter nominal position value for corner point **2**: X = 30
 - ▶ Select **R -** with the **R +/-** soft key
 - ▶ Press the **enter** key
 - ▶ Traverse the **X** axis until the display value is zero
 - > The square in the near zero warning is now centered between the two center marks
- Presets can be entered in the same manner for corners **3** and **4**.

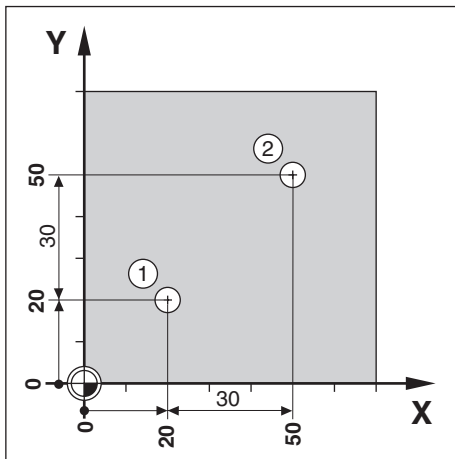
9.5.2 Incremental distance preset

Example

Drilling by traversing to display value zero with incremental positioning.

i Enter the coordinates in incremental dimensions. These are indicated in the following (and on the screen) with a preceding I (Incremental). The datum is the workpiece zero.

- Hole **1** at: $X = 20 / Y = 20$
- Distance from hole **1** to hole **2**: $XI = 30 / YI = 30$
- Hole depth: $Z = -20$
- Operating mode: Distance-To-Go (Inc)



To preset the location for hole **1**:

- ▶ Press the **Preset** soft key
- ▶ Press the **X axis** key
- ▶ Enter the nominal position value for hole **1**: $X = 20$ and ensure no tool radius is active

Note that these presets are Absolute Presets.

- ▶ Press the **down arrow** key
- ▶ Enter the nominal position value for hole **1**: $Y = 20$
- ▶ Ensure no tool radius compensation is showing
- ▶ Press the **down arrow** key
- ▶ Enter the nominal position value for the hole depth: $Z = -20$
- ▶ Press the **enter** key
- ▶ Drill hole **1**: Traverse the **X**, **Y**, and **Z** axis until the display value is zero
- The square in the graphical positioning aid is now centered between the two center marks
- ▶ Retract the drill

To preset the location for hole **2**:

- ▶ Press the **Preset** soft key
- ▶ Press the **X axis** key
- ▶ Enter the nominal position value for hole **2**: $X = 30$
- ▶ Press the **I** soft key to mark your input as an incremental dimension
- ▶ Press the **Y axis** key
- ▶ Enter the nominal position value for hole **2**: $Y = 30$

- ▶ Press the **I** soft key to mark your input as an incremental dimension
- ▶ Press the **enter** key
- ▶ Traverse the **X** and **Y** axes until the display value is zero
- ▶ The square in the graphical positioning aid is now centered between the two center marks
To preset the **Z** axis:
 - ▶ Press the **Preset** soft key
 - ▶ Press the **Z axis** key
 - ▶ Press the **enter** key to use the last entered preset
 - ▶ Drill hole **2**: Traverse the Z axis until the display value is zero
- ▶ The square in the near zero warning is now centered between the two center marks
- ▶ Retract the drill

9.6 Features

Pressing the **Features** soft key provides access to the **Circle Pattern**, **Linear Pattern**, **Incline Mill**, and **Arc Mill** milling features.

The **Circle Pattern** and **Linear Pattern** features provide ways to calculate and machine various hole patterns. The **Incline Mill** and **Arc Mill** features provide ways to machine a flat diagonal surface (**Incline Mill**), or a rounded surface (**Arc Mill**) using a manual machine.



Defined patterns are remembered when power is cycled.

The following milling **Features** soft keys are available:

Soft key	Function
Circle Pattern	Press the Circle Pattern soft key to access the Circle Pattern table
Linear Pattern	Press the Linear Pattern soft key to access the Linear Pattern table
Incline Mill	Press the Incline Mill soft key to access the Incline Mill form
Arc Mill	Press the Arc Mill soft key to access the Arc Mill form

9.6.1 Circle and linear patterns

This section describes the circle and linear pattern tables and capabilities. The product provides storage of ten user definable patterns each for circle and linear. Once patterns are defined, they are remembered when power is cycled. They can be recalled, and executed from the DRO, or from a program.

To access the **Circle Pattern** table or **Linear Pattern** table:

- ▶ Press the **Features** soft key
- > The **Circle Pattern** and **Linear Pattern** soft keys are shown
- ▶ Press the **Circle Pattern** soft key to access the **Circle Pattern** table
or
- ▶ Press the **Linear Pattern** soft key to access the **Linear Pattern** table
- > The corresponding hole pattern table will open

The following soft keys are available while in the **Circle Pattern** and **Linear Pattern** tables.

Function	Soft key
New	Press the New soft key to create a new circle or linear pattern
Edit	Press the Edit soft key to edit an existing pattern
Clear	Press the Clear soft key to delete an existing pattern
Run	Press the Run soft key to execute a pattern
Help	Press the Help soft key for additional information about the pattern

Circle and linear hole patterns

Required Circle Pattern information

D:0		Circle Pattern (1)		Position	
T:1	Type	Full		X	0.000
F: 0	Holes	1		Y	0.000
0:00	X Center	0.000		Z	0.000
mm	Y Center	0.000		W	0.000
Abs	Radius	0.000			
Set	Start Angle	0.0000°			
1	End Angle	0.0000°			
<div> <div></div> <div></div> <div></div> <div>Help</div> </div>					

- **Type:** type of pattern, **Full** or **Segment**
- **Holes:** number of holes in the pattern
- **X Center:** X axis location of the center of the hole pattern
- **Y Center:** Y axis location of the center of the hole pattern
- **Radius:** radius of the pattern
- **Start Angle:** angle between X axis and the first hole
- **End Angle:** angle between the X axis and the last hole
- **Z Depth:** the target depth for drilling in the tool axis

Required Linear Pattern information

D:0	Linear Pattern (1)		Position	
T:1	Type	Array ▾	X	0.000
F: 0	X First Hole	0.000	Y	0.000
0:00	Y First Hole	0.000	Z	0.000
mm	Holes Per Row	1	W	0.000
Abs	Hole Spacing	0.000		
Set	Angle	0.0000°		
1	Z Depth			

Help

- **Type:** type of pattern, **Array** or **Frame**
- **X First Hole:** X axis location of the first hole of the pattern
- **Y First Hole:** Y axis location of the first hole of the pattern
- **Holes Per Row:** number of holes in each row of a pattern
- **Hole Spacing:** the spacing between each hole in a row
- **Angle:** the angle or rotation of the pattern
- **Z Depth:** the target depth for drilling in the tool axis
- **Number of Rows:** the number of rows in the pattern
- **Row Spacing:** the spacing between each row of the pattern

The **Circle Pattern** or **Linear Pattern** table is used to define up to ten different circle hole patterns (Full or Segment) and ten different linear hole patterns (Array or Frame).

Creating and editing a pattern

To create or edit a pattern in the table:

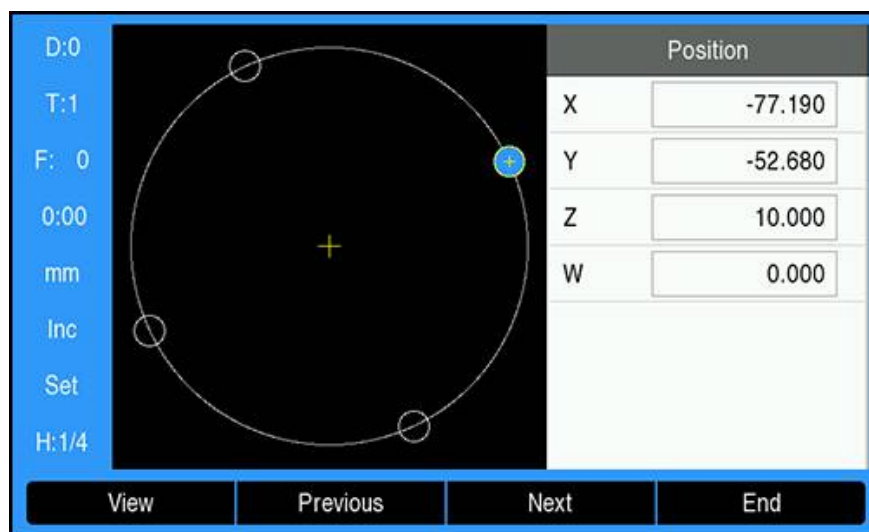
- ▶ Press the **Features** soft key
- ▶ Press the **Circle Pattern** or **Linear Pattern** soft key
- > The pattern table will show any patterns that have been previously defined
- ▶ Press the **up** or **down arrow** keys to highlight a table entry
- ▶ Press the **New** soft key to create a new entry or press the **Edit** soft key to edit an existing entry
- or
- ▶ Press the **enter** key
- > The pattern form is opened
- ▶ Enter the information to define the pattern
- ▶ Press the **enter** key
- > The pattern will be entered into the appropriate table. It can now be modified, executed, or referred to from a program.

Deleting a pattern

To delete a pattern from the table:

- ▶ Press the **Features** soft key
- ▶ Press the **Circle Pattern** or **Linear Pattern** soft key
- ▶ Press the **up** or **down arrow** keys to highlight the pattern you would like to delete
- ▶ Press the **Clear** soft key
- ▶ Press the **enter** key to confirm deleting the pattern from the table

Running a pattern



To run a pattern:

- ▶ Press the **Features** soft key
- ▶ Press the **Circle Pattern** or **Linear Pattern** soft key
- ▶ Press the **up** or **down arrow** keys to highlight the pattern you would like to run
- ▶ Press the **Run** soft key
- The product calculates the positions of the holes and can also provide a graphical view of the hole pattern

The following soft keys are available while running a pattern:

Soft key	Function
View	Press the View soft key to select the graphic view of the pattern.
Previous	Press the Previous soft key to select the previous hole in the pattern
Next	Press the Next soft key to select the next hole in the pattern
End	Press the End soft key to end execution of the pattern



Press the **View** soft key to toggle the views between Distance-to-Go (Inc) positions, graphic view, and Actual Value (Abs) positions.



The diameter of the active tool is displayed when in the graphic view.

Example: Entering data and running a circle pattern

D:0	Circle Pattern (1)		Position	
T:1	Type	Full	X	0.000
F: 0	Holes	4	Y	0.000
0:00	X Center	50.000	Z	0.000
mm	Y Center	40.000	W	0.000
Abs	Radius	30.000		
Set	Start Angle	25.0000°		
1	End Angle	295.0000°		
Help				

Entering the data:

- ▶ Press the **Features** soft key
- ▶ Press the **Circle Pattern** soft key
- ▶ Press the **up** or **down arrow** keys to select pattern **1**
- ▶ Press the **enter** key
- ▶ Select **Full** in the **Type** field
- ▶ Press the **down arrow** key to move to the next field
- ▶ Enter 4 for the number of **Holes**
- ▶ Enter 50 mm for the **X Center** location
- ▶ Enter 40 mm for the **Y Center** location
- ▶ Enter 125 mm for the **Radius** of the circle pattern
- ▶ Enter 25° for the **Start Angle**
- ▶ The **End Angle** is 295° and cannot be changed because the **Type** is **Full**
- ▶ Enter a **Z Depth** of -10 mm
 - The depth of the hole is optional and may be left blank
- ▶ Press the **enter** key
- ▶ The **Circle Pattern Table** now shows the pattern that was just defined as pattern **1**

D:0	-77.190	X
T:1	-52.680	Y
F: 0	10.000	Z
0:00	0.000	W
mm		
Inc		
Set		
H:1/4		
View Previous Next End		

Running the pattern:

- ▶ Press the **Run** soft key
- ▶ The Distance-To-Go view is displayed
- ▶ Move to the hole, move the **X** and **Y** axis until their display values show 0.0
- ▶ Drill (Z depth): If a depth was entered into the pattern, move **Z** until it's display value shows 0.0. otherwise, drill to the desired depth
- ▶ Press the **Next** soft key
- ▶ Continue to drill the remaining holes in the same manner
- ▶ When the pattern is complete, press the **End** soft key

9.6.2 Incline and arc milling

The incline and arc milling features provide ways to machine a flat diagonal surface (incline milling) or a rounded surface (arc milling) using a manual machine. The product provides storage of ten user definable Incline Mill features and ten Arc Mill features. Once the features are defined, they are remembered when power is cycled. They can be recalled, and executed from the DRO, or from a program.

To access the **Incline Mill** or **Arc Mill** table:

- ▶ Press the **Features** soft key
- > The **Incline Mill** and **Arc Mill** soft keys are shown
- ▶ Press the **Incline Mill** soft key to access the **Incline Mill** table
- or
- ▶ Press the **Arc Mill** soft key to access the **Arc Mill** table
- > The corresponding mill table will open

The following soft keys are available while in the **Incline Mill** and **Arc Mill** tables.

Function	Soft key
New	Press the New soft key to create a new Incline Mill or Arc Mill feature
Edit	Press the Edit soft key to edit an existing milling feature
Clear	Press the Clear soft key to delete an existing milling feature
Run	Press the Run soft key to execute a milling feature
Help	Press the Help soft key for additional information about the milling feature

Incline and arc milling features

Required Incline Mill information

D:0	Incline Mill (1)		Position	
T:1	Plane	XY	X	0.000
F: 0	X Start	0.000	Y	0.000
0:00	Y Start	0.000	Z	0.000
mm	X End	0.000	W	0.000
Abs	Y End	0.000		
Set	Step	0.000		
1				

Help

- **Plane:** the plane to be milled
- **X Start:** X axis start point
- **Y Start:** Y axis start point
- **X End:** X axis end point
- **Y End:** Y axis end point
- **Step:** The distance between each pass or each **Step** along the line



The **Step** size is optional. If the value is zero, the operator decides at run-time how far to move between each **Step**.

Required Arc Mill information

D:0	Arc Mill (1)		Position	
T:1	Plane	XY	X	0.000
F: 0	X Center	0.000	Y	0.000
0:00	Y Center	0.000	Z	0.000
mm	X Start	0.000	W	0.000
Abs	Y Start	0.000		
Set	X End	0.000		
1	Y End	0.000		

[Help](#)

- **Plane:** the plane to be milled
- **X Center:** X axis center point
- **Y Center:** Y axis center point
- **X Start:** X axis start point
- **Y Start:** Y axis start point
- **X End:** X axis end point
- **Y End:** Y axis end point
- **Step:** The distance along the circumference of the arc between each pass, or **Step** along the arc's contour



The **Step** size is optional. If the value is zero, the operator decides at run-time how far to move between each **Step**.

The **Incline Mill** or **Arc Mill** table is used to define up to ten different milling patterns.

Creating and editing a milling feature

To create or edit a feature in the table:

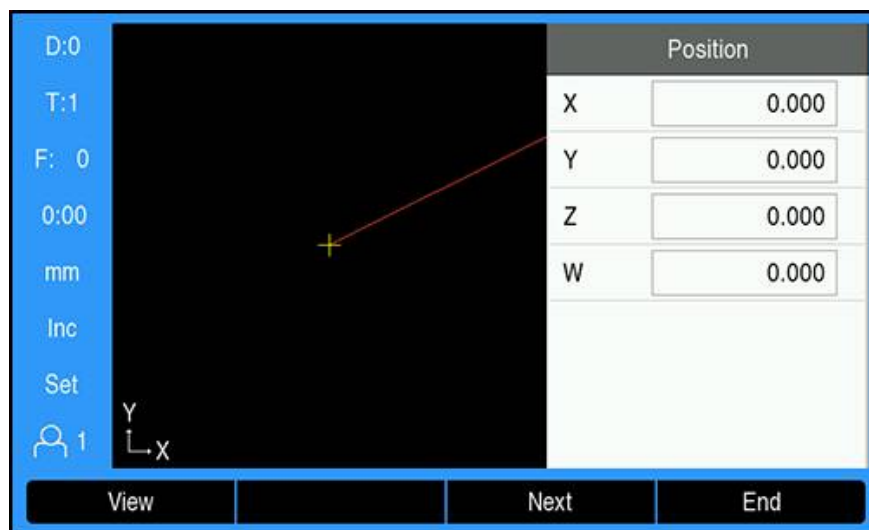
- ▶ Press the **Features** soft key
- ▶ Press the **Incline Mill** or **Arc Mill** soft key
- > The feature table will show any features that have been previously defined
- ▶ Press the **up** or **down arrow** key to highlight a table entry
- ▶ Press the **New** soft key to create a new entry or press the **Edit** soft key to edit an existing entry
- or
- ▶ Press the **enter** key
- > The feature form is opened
- ▶ Enter the information to define the feature
- ▶ Press the **enter** key
- > The feature will be entered into the appropriate table. It can now be modified, executed, or referred to from a program.

Deleting a feature

To delete a feature from the table:

- ▶ Press the **Features** soft key
- ▶ Press the **Incline Mill** or **Arc Mill** soft key
- ▶ Press the **up** or **down arrow** keys to highlight the feature you would like to delete
- ▶ Press the **Clear** soft key
- ▶ Press the **enter** key to confirm deleting the feature from the table

Running a feature



To run a feature:

- ▶ Press the **Features** soft key
- ▶ Press the **Incline Mill** or **Arc Mill** soft key
- ▶ Press the **up** or **down arrow** key to highlight the feature you would like to run
- ▶ Press the **Run** soft key
- The display switches to the incremental DRO view, showing the incremental distance from the start point

The following soft keys are available while running a pattern:

Soft key	Function
View	Press the View soft key to select the incremental DRO, contour view of feature, or absolute DRO
Previous	Press the Previous soft key to return to the previous pass
Next	Press the Next soft key to advance to the next pass
End	Press the End soft key to end execution of the milling operation

The tool radius compensation is applied based on the radius of the current tool. If the plane selection involves the tool axis, the tool tip is assumed to have a ball end.

- ▶ Move to the start point and make a plunge cut or the first pass across the surface
- ▶ Press the **Next** soft key to continue with the next step along the contour
- The incremental display shows the distance from the next pass along the line, or arc's contour
- ▶ To follow the contour, move the two axes in small steps, keeping the X, and Y positions as close to zero (0.0) as possible
- When no step size is specified, the incremental display always shows the distance from the closest point on the arc
- ▶ Press the **View** soft key to toggle through the three available views (incremental DRO, contour, and absolute DRO)

The contour view shows the position of the tool relative to the milling surface. When the cross hair representing the tool is on the line representing the surface, the tool is in position. The tool cross hair remains fixed in the center of the graph. As the table is moved, the surface line moves.

- ▶ Press the **End** soft key to exit the milling operation



The tool offset direction (**R+** or **R-**) is applied based on the tool position. The operator must approach the contour surface from the appropriate direction for tool compensation to be correct.

9.7 Z/W coupling



This feature is available on DRO300 products only.

The **Mill** application provides a quick method for coupling the Z and W axes positions on a 4 axis system. The display can be coupled in either the Z or W displays.

Display the coupled position on the Z axis

To couple the Z and W axes and have the result displayed on the Z display:

- ▶ Press and hold the **Z** axis key approximately 2 seconds
- > The sum of the Z/W positions will be displayed on the Z display and the W display will be blank

Display the coupled position on the W axis

To couple the Z and W axes and have the result displayed on the W display:

- ▶ Press and hold the **W** axis key approximately 2 seconds
- > The sum of the Z/W positions will be displayed on the W display and the Z display will be blank

Disabling Z/W Coupling

To disable Z/W Coupling

- ▶ Press the axis key of the display that is blank
- > The individual Z and W display positions will be restored

10

**Turning specific
operations**

10.1 Overview

This chapter describes operations and soft key functions specific to turning applications.



Make sure that you have read and understood the "Basic Operation" chapter before performing the activities described in this section.

Further information: "Basic operation", Page 55

10.2 Tool display icon

The \varnothing icon is used to indicate that the displayed value is a diameter value. No icon visible indicates that the display is a radius value.

10.3 Tool table

The DRO203 can store the dimensional offsets for up to 16 tools. The DRO300 can store the dimensional offsets for up to 100 tools.

When you change a workpiece and establish a new datum, all tools are automatically referenced from the new datum.

10.3.1 Importing and exporting

A **Tool Table** can be imported from an existing file or exported for backup and future use.

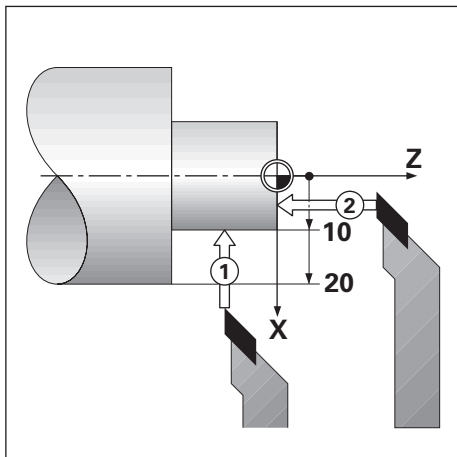
Further information: "Tool Table", Page 75

10.3.2 Setting tool offsets

Before you can use a tool, you must enter its offset (the cutting edge position). Tool offsets can be set using the **Tool/Set** or **Lock Axis** feature.

Tool/Set

The **Tool/Set** feature can be used to set a tool's offset using a tool when the diameter of the workpiece is known.



To set a tool offset using **Tool/Set**:

- ▶ Touch the known diameter in the X axis **1**
- ▶ Press the **Tool** soft key
- ▶ Highlight the desired tool
- ▶ Press the **enter** key
- ▶ Highlight the **X** axis field
- ▶ Enter the position of the tool tip, for example, X=10



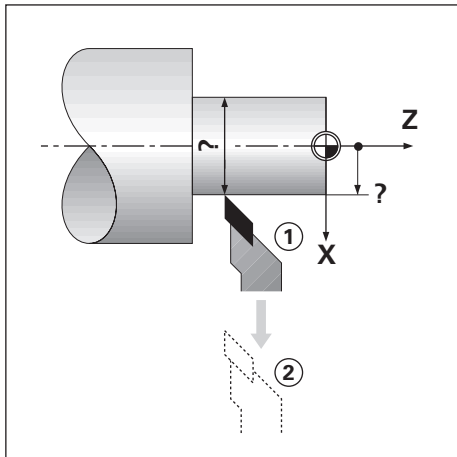
Remember to ensure the product is in diameter display mode \varnothing if the input is a diameter value.

- ▶ Touch the workpiece face with the tool **2**
- ▶ Highlight the **Z** axis field
- ▶ Set the position display for the tool tip to zero, Z=0
- ▶ Press the **enter** key

Lock Axis

The **Lock Axis** feature can be used to set a tool's offset when a tool is under load and the diameter of the workpiece is not known.

The **Lock Axis** feature is useful when determining tool data by touching the workpiece. To avoid losing the position value when the tool is retracted to measure the workpiece, this value can be stored by pressing the **Lock Axis** soft key.



To set a tool offset using **Lock Axis**:

- ▶ Press the **Tool** soft key
- ▶ Highlight the desired tool
- ▶ Press the **enter** key
- ▶ Press the **X axis** key
- ▶ Turn a diameter in the X axis
- ▶ Press the **Lock Axis** soft key while the tool is still cutting
- ▶ Retract from the current position
- ▶ Turn the spindle off and measure the workpiece diameter
- ▶ Enter the measured diameter or radius

Remember to ensure the product is in diameter display mode Ø if you input a diameter value.

- ▶ Press the **enter** key

10.3.3 Selecting a tool

Before you start machining, select the tool you are using from the **Tool Table**.

The product then takes into account the stored tool data when working with tool compensation.

To select a tool:

- ▶ Press the **Tool** soft key
- ▶ Use the **up** or **down arrow** keys to highlight the tool you want to select
- ▶ Press the **Use** soft key
- ▶ Verify in the status bar that the correct tool was selected

10.4 Setting a datum

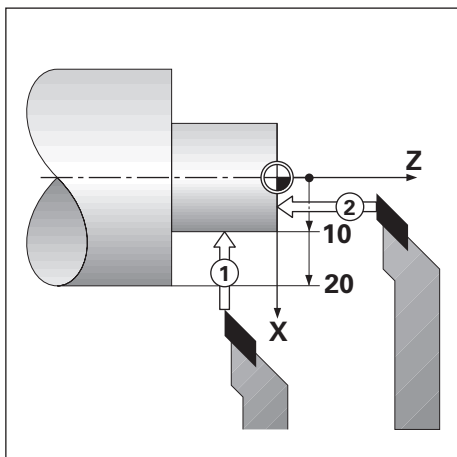
Datum settings define the relationships between the axis positions and the display values.

For most lathe operations there is only one X-axis datum, the center of the chuck, but it may be helpful to define additional datums for the Z-axis.

The datum table can hold up to 10 datum points.

The recommended way to set datum points is to touch a workpiece at a known diameter, or location, then enter that dimension as the value that the display should be showing.

10.4.1 Setting a datum manually



D:0	Datum		Position	
T:1	Datum Number	0	X	0.000 Ø
F: 0	X	10.000 Ø	Z ₀	0.000
0:00	Z ₀	0.000	Z	0.000
mm	Z			
Abs	Face part then press Lock Axis or enter the tool position.			
Set				
1				
Lock Axis		Calc		Help

To set a datum manually:

- ▶ Press the **Datum** soft key
- ▶ Enter the **Datum Number**
- ▶ Highlight the **X** axis field
- ▶ Touch the workpiece at point **1**
- ▶ Press the **Lock Axis** soft key
- or
- ▶ Enter the radius or diameter of the workpiece at that point

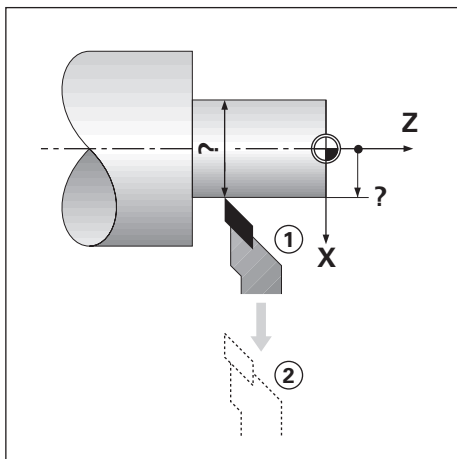


Remember to ensure the product is in diameter display mode Ø if you input a diameter value.

- ▶ Highlight the **Z** axis field
- ▶ Touch the workpiece surface at point **2**
- ▶ Press the **Lock Axis** soft key
- or
- ▶ Enter the position of the tool tip (Z= 0) for the Z coordinate of the datum
- ▶ Press the **enter** key

10.4.2 Setting a datum using the Lock Axis function

The **Lock Axis** function is useful for setting a datum when a tool is under load, and the diameter of the workpiece is not known.



D:0	Datum		Position	
T:1	Datum Number	0	X	0.000 Ø
F: 0	X	Ø	Z ₀	0.000
0:00	Z ₀		Z	0.000
mm	Z			
Abs	Turn diameter then press Lock Axis or enter the tool position.			
Set				
1				
Lock Axis		Calc		Help

To set a datum using the **Lock Axis** function

- ▶ Press the **Datum** soft key
- ▶ Enter the **Datum Number**
- ▶ Highlight the **X** axis field
- ▶ Turn a diameter in the X axis
- ▶ Press the **Lock Axis** soft key while the tool is still cutting
- ▶ Retract from the current position
- ▶ Turn the spindle off, and measure the workpiece diameter
- ▶ Enter the measured diameter, for example, 40 mm
- ▶ Press the **enter** key

10.5 Taper Calculator

Use the **Taper Calculator** to calculate taper angle.

Calculate tapers by entering dimensions from a print, or by touching a tapered workpiece with a tool, or edge finder.

Calculating a taper with known diameters and length

Taper Calculator		Position	
D:0	Diameter 1	10.0000	X 0.000 Ø
T:1	Diameter 2	12.0000	Z ₀ 0.000
F: 0	Length	20.0000	Z 0.000
0:00	Angle	2.8624°	
mm			
Abs			
Set			
1			

Help

Requirements for taper calculation using diameters (**Diameter 1**, **Diameter 2**) and **Length**:

- Starting diameter
- End diameter
- Length of the taper

To calculate a taper with the known diameters and length:

- ▶ Press the **Calc** soft key
- > The soft key selections change to include taper calculator functions
- ▶ Press the **Taper: D1/D2/L** soft key
- ▶ Enter the first diameter in the **Diameter 1** field and press the **enter** key
- or
- ▶ Touch the tool to one point and press the **Teach** soft key
- ▶ Enter the second diameter in the **Diameter 2** field and press the **enter** key
- or
- ▶ Touch the tool to the second point and press the **Teach** soft key
- The taper angle is automatically calculated when using the **Teach** soft key
- ▶ When entering data with the numeric keypad, enter the **Length**
- ▶ Press the **enter** key
- > The taper angle will appear in the **Angle** field

Calculating a taper with known change in radius and length

Taper Calculator			Position	
D:0	Entry 1	1.0000	X	0.000 Ø
T:1	Entry 2	8.0000	Z ₀	0.000
F: 0	Ratio	1 : 8.0000	Z	0.000
0:00	Angle	7.1250°		
mm				
Abs				
Set				
1				

Help

Taper ratio calculation requirements:

- Change in the radius of the taper
 - Length of the taper
- To calculate a taper using the change in radius and length of the taper:
- ▶ Press the **Calc** soft key
 - > The soft key selections change to include taper calculator functions
 - ▶ Press the **Taper: Ratio** soft key
 - ▶ Enter the change in radius across the taper into the **Entry 1** field
 - ▶ Highlight the **Entry 2** field
 - ▶ Enter the length across the taper into the **Entry 2** field
 - ▶ Press the **enter** key
 - > The calculated **Ratio** and **Angle** will be displayed in their respective fields.

10.6 Presets

Preset functionality has been explained previously in this manual.

Further information: "Presetting a target position", Page 123

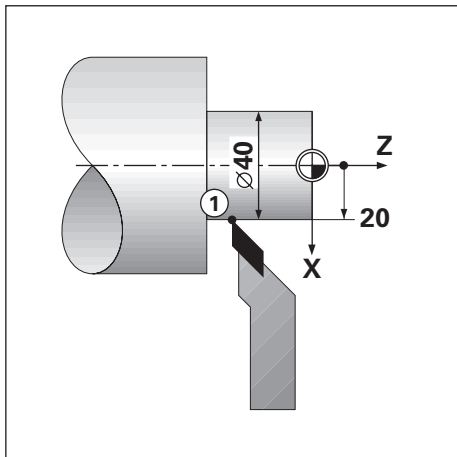
The explanation, and examples on those pages are based on a mill application. The basics of those explanations are the same for turning applications with two exceptions; Tool Diameter Offsets (R+/-), and Radius vs. Diameter inputs.

Tool diameter offsets have no applications with turning tools, so this functionality is not available while doing turning presets.

Input values can be either radius or diameter values. It is important to be sure the units you are entering for the preset agree with the state that the display is currently using. A diameter value is shown with a Ø symbol. The state of the display can be changed using the **Rad/Dia** soft key (available in both operating modes).

10.7 Diameter and radius measurements

Drawings for lathe parts usually give diameter values. The product can display either the diameter or the radius. When the diameter is being displayed, the diameter symbol \varnothing is shown next to the position value.



Example:

- Radius display, position 1, $X = 20$
- Diameter display, position 1, $X = \varnothing 40$

Activating diameter and radius measurements for an axis

Further information: "Diameter Axes", Page 97

Switching between radius and diameter measurements



The **Rad/Dia** soft key is only available when the **Application** is set to **Turn**.

Further information: "Readout Settings", Page 83

To toggle between radius and diameter measurements:

- Press the **Rad/Dia** soft key

10.8 Vectoring

Vectoring breaks down the movement of the compound axis into the crossfeed or longitudinal axes. If you are turning threads, for example, vectoring lets you see the diameter of the thread in the X-axis display, even though you are moving the cutting tool with the compound axis handwheel. With vectoring enabled, you can preset the desired radius or diameter in the X-axis, so that you can “machine to zero”.

i When vectoring is used, the top slide (compound) axis encoder must be assigned to the bottom display axis. The crossfeed component of movement of the axis will then be shown in the top display axis. The longitudinal component of movement of the axis will be shown in the middle display axis.



To enable vectoring:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **Vectoring**
- ▶ Press the **On/Off** soft key and select **On** to enable **Vectoring**
- ▶ Highlight the **Angle** field
- ▶ Enter the angle between the longitudinal slide and top slide with 0° indicating the top slide is moving parallel to the longitudinal slide
- ▶ Press the **enter** key to save the **Vectoring** parameter changes and return to the **Job Setup** menu

10.9 Z coupling

The **Turn** application provides a quick method for coupling the Z₀ and Z axes positions on a 3 or 4 axis system. The display can be coupled in either the Z₀ or Z displays.

Moving either Z₀ or Z inputs will update the coupled Z position.

The coupling is preserved in between power cycles.



The reference mark for both encoders must be found in order to recall the previous datum when a position is coupled.

Display the coupled position on the Z₀ axis

To couple the Z₀ and Z axes, and have the result displayed on the Z₀ display:

- ▶ Press and hold the Z₀ key approximately 2 seconds
- > The sum of the Z positions will be displayed on the Z₀ display and the Z display will be blank

Display the coupled position on the Z axis

To couple the Z₀, and Z axes and have the result displayed on the Z display:

- ▶ Press and hold the Z key for approximately 2 seconds
- > The sum of the Z positions will be displayed on the Z display and the Z₀ display will be blank

Coupling the Z₀ and Z axes positions can also be done from the **Display Configuration** menu.

Further information: "Display Configuration", Page 82

Disabling Z coupling

To disable Z coupling:

- ▶ Press the axis key for the display that is blank
- > The Z₀ and Z displays will be restored

10.10 Thread Cycle



This feature is available on DRO300 products only.



The **Thread Cycle** feature requires a rotary encoder to be installed to the lathe thread cutting leadscrew.

The **Thread Cycle** feature simplifies and enhances thread cutting on a lathe. The product provides one user definable **Thread Cycle** which can be recalled and executed from the DRO at any time during operation, and is remembered when the power is cycled.

Before the **Thread Cycle** feature can be used, **Thread Cycle** settings must be defined.

Encoder Setup

i To use the **Thread Cycle** feature on a 3 axes system, the rotary encoder must be installed on the last axis. For a 4 axes system, the encoder must be installed on the third or fourth axis.

To set up the rotary encoder:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **Encoder Setup**

D:0	Installation Setup	Encoder Setup
T:1	File Management	X1
F: 0	Encoder Setup	X2
0:00	Display Configuration	X3
mm	Readout Settings	X4
Abs	Diagnostics	
Set	Display Color Scheme	
1	Factory Defaults	

Help

- ▶ Select the axis that the rotary encoder is connected to
- ▶ Press the **enter** key to display the axis data input form

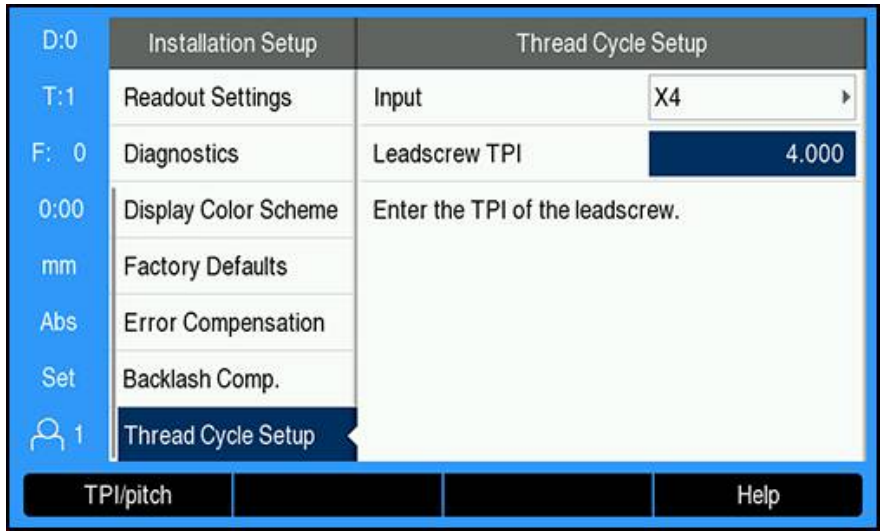
D:0	Installation Setup	X4	
T:1	File Management	Encoder Type	Rotary
F: 0	Encoder Setup	Resolution (/rev)	250.0
0:00	Display Configuration	Reference Mark	None
mm	Readout Settings	Count Direction	Positive
Abs	Diagnostics	Error Monitor	On
Set	Display Color Scheme		
1	Factory Defaults		

Linear/Rotary Help

- ▶ Press the **Linear/Rotary** soft key to select **Rotary** in the **Encoder Type** field
- ▶ Define the remaining **Encoder Setup** parameters
Further information: "Encoder Setup", Page 80
- ▶ Press the **enter** key to save the setting
- ▶ Press the **C** key to return to the **Installation Setup** menu

Thread Cycle Setup

To define the **Thread Cycle Setup**:



- ▶ Select **Thread Cycle Setup** from the **Installation Setup** menu
- ▶ Press the **enter** key to display the **Thread Cycle Setup** menu
- ▶ Select the **Input** axis that was specified for the rotary encoder
- ▶ Press the **enter** key to save the setting
- ▶ Enter the leadscrew threads per inch in the **Leadscrew TPI** field
or
- ▶ Press the **TPI/pitch** soft key to display the **Leadscrew pitch** field and enter the leadscrew pitch in mm
- ▶ Press the **enter** key to save the settings
- ▶ Press the **C** key twice to return to the DRO screen

Thread Cycle parameters

Once the rotary encoder axis has been defined and the **Thread Cycle Setup** is complete, the **Thread Cycle** parameters can be defined.

To define the **Thread Cycle** parameters:

Thread Cycle		Position	
T:1	X Start Point	15.000 Ø	X 34.650 Ø
F: 0	Z ₀ Start Point	0.000	Z ₀ 53.265
0:00	X End Point	13.500 Ø	Z 0.000
mm	Z ₀ End Point	-40.000	T 0.000°
Abs	Number of Passes	3	
Set	Enter the coordinates of the start point.		

1

Teach Calc Help

- ▶ Press the **Thread Cycle** soft key from the DRO screen to open the **Thread Cycle** form
- ▶ The axes will be in the same mode as what the relative axis is set to: **Radius** or **Diameter**
- ▶ Enter the **X Start Point** coordinate
- ▶ Enter the **Z₀ Start Point** coordinate
Typically 0.0 is the normal starting position
- ▶ Enter the final cut thread diameter in the **X End Point** field
This is the smaller OD for external threads, and the larger ID for internal threads
- ▶ Enter the end point of the thread (thread length) in the **Z₀ End Point** field
- ▶ Enter the number of normal passes in the **Number of Passes** field
or
- ▶ Press the **Number/Depth** soft key and enter the depth of a normal pass in the **Depth of Passes** field
- ▶ Press the **down arrow** key
- ▶ Additional options are displayed
- ▶ Enter the depth of the **Finish Pass**, or leave blank if no finish pass is desired



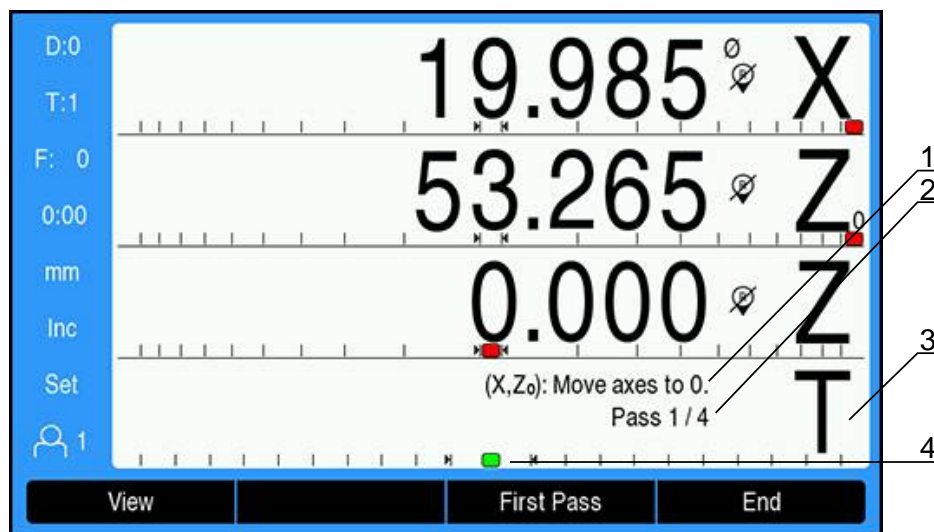
The **Finish Pass** is in addition to the number of normal passes entered, and is included in the total cut depth

- ▶ Enter the number of threads per inch in the **Threads TPI** field
or
- ▶ Press the **TPI/pitch** soft key
- ▶ Enter the **Threads pitch** in mm
The **Thread Side** field displays whether the thread is **Inside** or **Outside**.
- ▶ Press the **enter** key to save the settings and exit the **Thread Cycle** form
- ▶ The **Thread Cycle** program will display
- ▶ Press the **C** key to return to the DRO screen

Additional soft keys available while in the **Thread Cycle** form:

Function	Soft Key
Teach	Press the Teach soft key to set the start and end points
Calc	Press the Calc soft key to display the calculator functions
Help	Press the Help soft key for additional information about the Thread Cycle feature

Thread Cycle program



- 1 Instructional message
- 2 Pass number
- 3 Thread Bar display area
- 4 Thread Bar graphic positioning aid

While running a **Thread Cycle**, an instructional message and the **Pass** number display in the Thread Bar display area. The Thread Bar graphic positioning aid displays the rotation of the leadscrew relative to an established mark. This mark is established when the **First Pass** is initially executed. All subsequent passes can now be engaged using the Thread Bar graphic positioning aid when located at the center mark.

The following soft keys are available while running a **Thread Cycle** program:

Function	Soft Key
View	Press the View soft key to view the actual tool location during machining
First Pass	Press the First Pass soft key to start the first pass
Next Pass	Press the Next Pass soft key to display the next instruction
Start Pass	Press the Start Pass soft key to start the next pass
Previous Pass	Press the Previous Pass soft key to restart the procedure
Finish Pass	Press the Finish Pass soft key to start the last programmed pass
End	Press the End soft key to exit the program and return to the DRO screen

To run a **Thread Cycle** program:

- ▶ Start the spindle
- ▶ Press the **Thread Cycle** soft key to open the form
- ▶ Once all data is defined, press the **enter** key to start the program
- > The message **Move axes to 0.** is displayed
- ▶ Move the longitudinal axis to zero
- ▶ Move the cross feed axis to zero
- > The message **Press First Pass** is displayed

Running the **First Pass**

- ▶ Press the **First Pass** soft key
- > The message **Ready to engage thread lever** is displayed



Do not move the carriage manually after pressing the **First Pass** soft key. Allow the leadscrew to move the carriage so the thread engagement location can be determined accurately.

- ▶ Watch the machine dial and engage the lever for the first pass on the appropriate number
- ▶ Keep your hand on the lever while the carriage is moving
- > The longitudinal axis will move towards zero

Running the remaining passes

- ▶ Disengage the lever and back off the cross feed at the same time when the DRO reads 0.0
- ▶ With the lever disengaged, press the **Next Pass** soft key
- ▶ Move the axes back to the start position. Move Z to 0.0, then move X to 0.0
- > The message **Press Start Pass** will display
- ▶ When ready, press the **Start Pass** soft key
- > The message **Engage Lever** will display
- ▶ Watch the Thread Bar Indicator and engage the lever when the indicator turns green
- ▶ Repeat this procedure until all normal passes are completed
- > If a finish pass step was created, the **Finish Pass** soft key will appear

Running the **Finish Pass**

- ▶ Press the **Finish Pass** soft key, and execute the same as the previous passes
- ▶ Press the **End** soft key to exit the program and return to the DRO screen



If a false start occurs at any time, disengage the lever and back off the cross feed at the same time. Press the **Previous Pass** soft key to restart the procedure.

11

**Metrology specific
operations**

11.1 Overview

This chapter describes operations and soft key functions specific to the DRO203Q product.

i Make sure that you have read and understood the "Basic Operation" chapter before performing the activities described in this section.
Further information: "Basic operation", Page 55

Metrology functionality can be used with optical comparators, toolmaker's microscopes, or video measurement systems as part of in-line production or in final quality inspection.

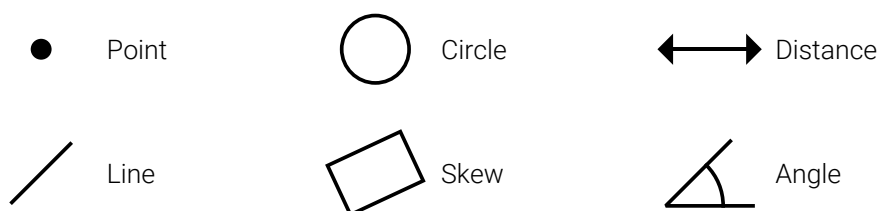
The following functions are available:

- Two datums for absolute and incremental measurements
- Axis zero and preset keys for establishing datums
- Linear, Segmented, and Non-Linear Error Compensation
- Skew compensation for part alignment
- Feature measurements can include:
 - Dimensional measurements of geometric part features
 - Creation of features by entering dimensional data
 - Construction of new features from existing features
 - Applying tolerances
- Measuring, creating, and constructing of the following feature types:
 - Point ■ Circle ■ Distance
 - Line ■ Skew ■ Angle
- Measurement results sent to a USB mass storage device or PC

Part features

A measured geometry is referred to as a feature.

There are six feature types:



Each feature type has different dimensional information. For example, a circle has a center point position and a radius, a point has a position, and an angle has degrees.

Features are measured by probing data points that characterize the dimensional geometry of the part. For example, several points probed around the circumference of a circle results in a numeric and a graphic representation of the circle geometry.

Data points are probed with crosshairs.

To probe a data point:

- ▶ Move the stage to position the crosshairs over the desired feature point
- ▶ Press the **enter** key
- > The probed point will be added to the points required for the feature being measured

Further information: "Measuring part features", Page 173.

11.2 Display screens and soft key layout

The following display screens are used in the metrology application:



- **DRO screen** displays current position of axes
- **Feature measurement screen** displays the feature type and points collected
- **Feature evaluation screens** can be toggled to show all measurement results or the collected points

DRO screen

The metrology application DRO screen displays the information described below.



- 1 Status bar
- 2 Feature list
- 3 Axis labels
- 4 Reference mark indicator
- 5 Skew indicator
- 6 Soft keys

Feature	Function
Status bar	Displays the current datum and unit of measure
Feature list	Displays a list of the measured, created, and constructed part features. Each feature is identified by a number and an icon representing its feature type. Up to 100 features can be added to the feature list.
Axis labels	Indicates axis for corresponding axis key
Reference mark indicator	Indicates current reference mark status  Reference marks are established. A flashing indicator represents that reference mark detection is enabled, but the reference marks have not yet been established.  Reference marks are not established
Skew indicator	Indicates the part is aligned to a measurement axis
Soft keys	Indicate various functions based on the current operating mode or menu

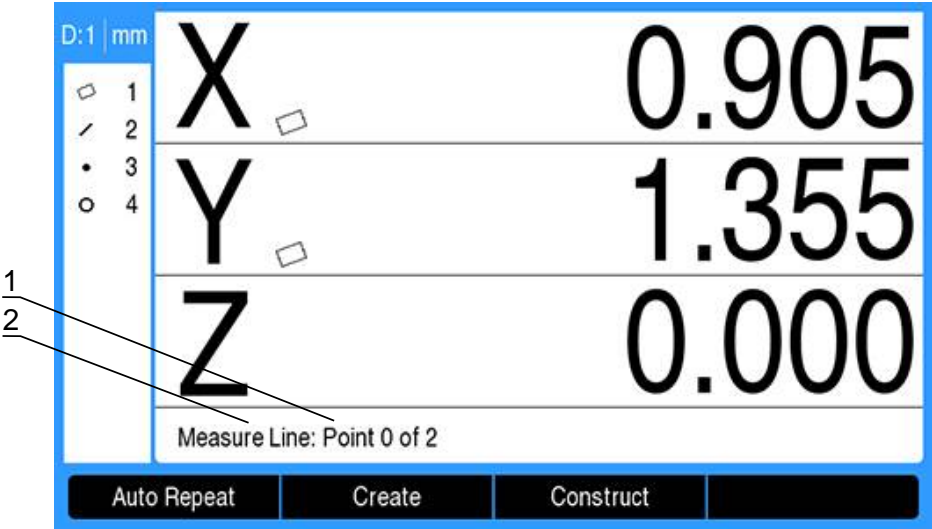
Soft keys

The following soft keys are available in the metrology DRO screen:

Soft key	Function
Measure	Press the Measure soft key to start measuring a feature. Further information: "Measuring part features", Page 173.
Clear All	Press the Clear All soft key to clear all features and datums. Further information: "Deleting part features", Page 189.
Send	Press the Send soft key to display the Send All and Send Position soft keys
Send All	Press the Send All soft key to transmit all feature data over the USB connection to a USB mass storage device or PC
Send Tolerance	Press the Send Tolerance soft key to transmit the tolerance data for all features with a tolerance over the USB connection to a USB mass storage device or PC
Send Position	Press the Send Position soft key to transmit the current position over the USB connection to a USB mass storage device or PC
Datum[1]	Press the Datum[1] soft key to select Datum 1
Datum[2]	Press the Datum[2] soft key to select Datum 2
Preset	Press the Preset soft key to set the position of the current datum. Further information: "Presetting the datum", Page 172.
1/2	Press the 1/2 soft key to divide the current position by two
Help	Press the Help soft key to open the operating instructions
Setup	Press the Setup soft key to access the Configuration menu
Enable Ref	Press the Enable Ref soft key when you are ready to identify a reference mark
inch/mm	Press the inch/mm soft key to toggle between inch and millimeter units of measure

11.2.1 Feature measurement screen

The feature measurement screen is displayed after initiating a feature measurement and displays the information shown below, in addition to the information displayed on the DRO screen.



- 1 Number of collected data points
- 2 Feature type being measured

Further information: "Measuring part features", Page 173.

Soft keys

The following soft keys are available in the feature measurement screen:

Soft key	Function
Auto Repeat	Press the Auto Repeat soft key to measure several features of the same feature type. Further information: "Measuring a series of features", Page 179.
Create	Press the Create soft key to open the feature form and enter data to create the specified feature type. Further information: "Creating part features", Page 180.
Construct	Press the Construct soft key to initiate construction of a new feature from existing features in the feature list. Further information: "Constructing part features", Page 182.
Finish	Press the Finish soft key to complete a feature measurement. Only available when Free annotation is selected. Further information: "Selecting annotation", Page 165.
End	Press the End soft key to cancel the current measurement

Returning to the DRO screen

To return to the DRO screen:

- ▶ Press the **C** key to return to the feature measurement selection soft keys
- ▶ Press the **C** key a second time to return to the DRO screen

11.2.2 Feature evaluation screens and soft keys

There are two feature evaluation screens:

- The feature dimensions screen
- The feature graphic screen

Feature dimensions evaluation screen

The feature dimensions evaluation screen is displayed after measuring or recalling a part feature. **Further information:** "Measuring part features", Page 173, **Further information:** "Recalling feature data", Page 187.

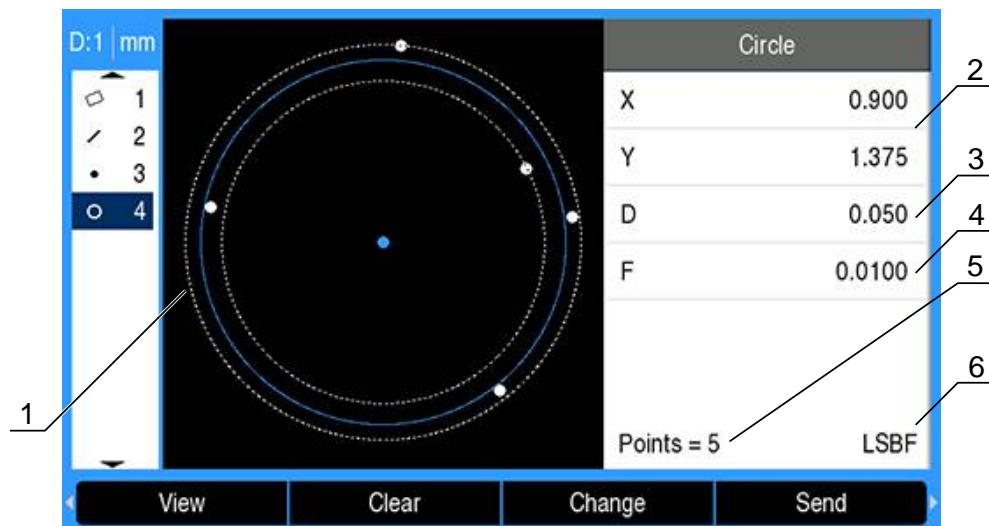
The feature dimensions evaluation screen displays the information described below, in addition to the information displayed on the DRO screen.



- 1 Geometric and dimensional values such as diameter, length, or angle
- 2 Number of data points used to define a measured feature, number of parent features used if the feature was constructed, or that the feature was created
- 3 Feature position
- 4 Form error

Feature graphic evaluation screen

The feature graphic evaluation screen displays the information described below, in addition to the information displayed on the DRO screen.



- 1 Graphic view of the feature with data points measured, constructed, or created to form the feature
- 2 Feature position
- 3 Geometric and dimensional values such as diameter, length, or angle
- 4 Form error
- 5 Number of data points used to define a measured feature, number of parent features used if the feature was constructed, or that the feature was created
- 6 The fit algorithm applied to the feature if applicable

Further information: "Evaluating part features", Page 187.

Soft keys

The following soft keys are available in the feature evaluation screens:

Soft key	Function
View	Press the View soft key to toggle between the feature dimensions and the feature graphic screen
Clear	Press the Clear soft key to delete the currently selected feature from the feature list
Change	Press the Change soft key to show alternative fit algorithms for the current feature. ex. LSBF (least squares best fit) and ISO.
Send	Press the Send soft key to access the soft keys to transmit feature data over the USB connection to a USB mass storage device or PC
Send Feature	Press the Send Feature soft key to send all data for the highlighted feature
Send 2	Press the Send 2 soft key to send current X and Y data
Send 3	Press the Send 3 soft key to send current X and Y data, and the feature's Z/Q, angle, diameter, or length data
Send X	Press the Send X soft key to send the X-axis value
Send Y	Press the Send Y soft key to send the Y-axis value
Send Z	Press the Send Z soft key to send the Z-axis value
Send Q	Press the Send Q soft key to send the Q-axis value
Send D	Press the Send D soft key to send the diameter value
Send r	Press the Send r soft key to send the radius value
Send F	Press the Send F soft key to send the form error data
Send <	Press the Send < soft key to send the current angle
Send L	Press the Send L soft key to send the length value

Soft key	Function
Rad/Dia	Press the Rad/Dia soft key to toggle between diameter or radius if dimension is displayed
Length/Z	Press the Length/Z soft key to toggle between the distance length or the current Z position
< 1	Press the < 1 soft key to display the line feature's angle
< 2	Press the < 2 soft key to display the line feature's second angle (based on the Angle Display setting)
Tolerance	Press the Tolerance soft key to display the tolerance soft keys that apply for the selected feature. Further information: "Tolerancing", Page 190.

Toggling the feature evaluation screens

To toggle between the two feature evaluation screens:

- Press the **View** soft key

Returning to the feature measurement and DRO screen

To return to the feature measurement soft keys:

- Press the **C** key to return to the feature measurement selection soft keys

To return to the DRO screen:

- Press the **C** key a second time to return to the DRO screen

11.3 Preparing to measure

11.3.1 Establishing machine zero

A repeatable machine zero is required for the product to apply a calibration chart to the machine geometry correctly.



It is not recommended to use the machine without active calibration. This would lead to unknown position errors.

Usually the calibration is based on referencing via reference marks on the encoders.

To establish machine zero after power-up:

- Move the stage to have the reference mark crossings recognized on each axis
If the machine zero is determined via hard stops:
- For each axis, move the stage to the hard-stop reference position and press the corresponding axis key

11.3.2 Selecting annotation

Annotation determines the number of data points collected for each feature type.

There are two annotation types:

- **Fixed**
- **Free**

Fixed annotation

Fixed annotation requires a previously specified number of points for each feature type. **Further information:** "Measure", Page 95.

The number of points collected and the required points are shown in the lower left corner of the display. As points are entered, the number of collected points increases. The system automatically completes the measurement and displays the feature dimensions after the last required point is entered.

Free annotation

Free annotation allows you to determine the number of points required for each feature. The total number of points collected and the minimum number of points required are shown in the lower left corner of the display. As points are entered, the number of collected points increases. When all of the required points are collected, press the **Finish** soft key to complete the measurement.

Selecting the annotation type:

To select the annotation type:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **Measure**
- ▶ Select the **Annotation** type
 - **Fixed**
 - **Free**
- ▶ Press the **enter** key to confirm the selection
- ▶ Press the **enter** key to save the **Measure** parameter changes and return to the **Job Setup** menu

11.3.3 Aligning the part to a measurement axis

Accurate measurements require the part to be perfectly aligned along a measurement axis. Misaligned parts result in cosine measurement errors. Measure a **Skew** to convert machine coordinates to part coordinates and compensate for part misalignment. Measure a **Skew** each time a new part is mounted on the measuring system.

A **Skew** can be measured on a part edge, demonstrated in the example below. A Skew can also be measured on part features other than an edge. For example, a line constructed between the centers of two holes could be aligned to a measurement axis if desired.

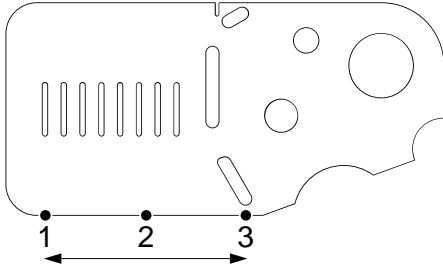


The Skew edge or line must be oriented within 45 degrees of the measurement axis.

To measure a Skew:

- ▶ Press the **Measure** soft key
- ▶ Press the **Skew** soft key
- ▶ Probe a minimum of two points on a straight edge of the part, along a major measurement axis. Probing more points will improve accuracy.

In the example shown here, the part is aligned to the X-axis by probing three points along the bottom edge of the part.



The part could alternately be aligned along a vertical edge to the Y-axis.

11.3.4 Establishing a datum

Establish a reference datum once the part is aligned.

Two datums can be created. Typically, datum 1 is a zero reference and used as an absolute or primary datum, while datum 2 is used as an incremental or temporary datum.

Datums can be set to zero or can be preset to specified values.

Two methods can be used to establish a datum:

- Zero or preset the X and Y axes on a point or on the center point of a circle
- Zero or preset the X and Y axes on a point constructed from parent features

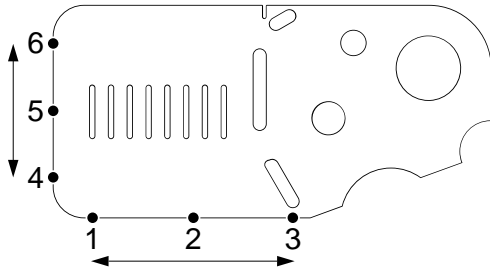
While a datum can be created from a probed point or from the center point of a probed circle, it is more commonly created from a point that has been constructed from important parent features, such as the skew alignment line and a second part edge line. An example of a datum created from a constructed point is shown here.



A brief example of constructing a Point is shown here. Constructions and the feature measurements necessary for constructions are discussed in detail later in this chapter. **Further information:** "Constructing part features", Page 182.

Measuring a skew and part edge line for point construction

Measure a skew alignment line along the bottom of the part and measure a line on the left side of the part. These lines will be used to construct a point used for a datum.



Measure a Skew to align the X-axis on the bottom edge

- ▶ Press the **Measure** soft key
- ▶ Press the **Skew** soft key
- ▶ Probe 3 points along the bottom edge (points **1**, **2**, and **3**)
- ▶ Press the **Finish** soft key to complete the measurement

Measure a line along the left edge

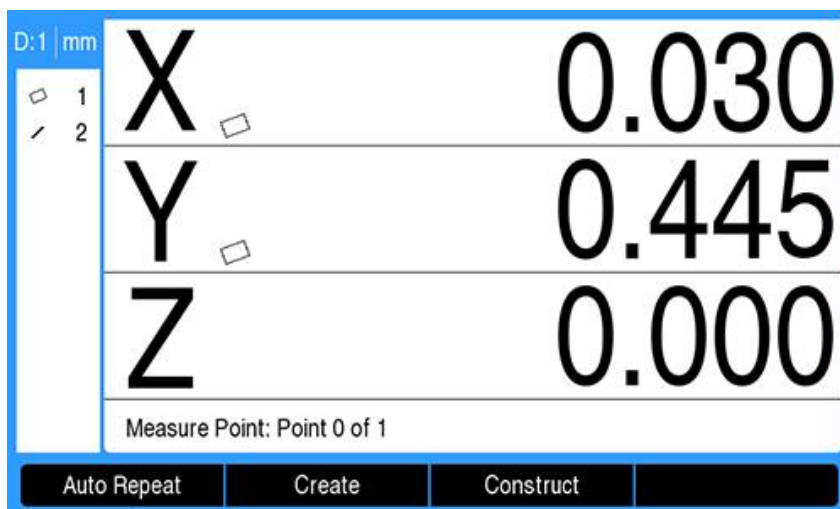
- ▶ Press the **Measure** soft key
- ▶ Press the **Line** soft key
- ▶ Probe 3 points along the left edge (points **4**, **5**, and **6**)
- ▶ Press the **Finish** soft key to complete the measurement
- > The skew and left edge lines are shown in the feature list

Constructing a datum point from the skew and line features

Construct a point from the skew and the left edge line to create a datum.

To construct a point for the datum:

- ▶ Press the **Measure** soft key
- ▶ Press the **Point** soft key
- > The Measure Point screen is displayed



- ▶ Press the **Construct** soft key
- ▶ Use the **up** or **down arrow** key to highlight the line created in "Measuring a skew and part edge line for point construction"
- ▶ Press the **enter** key
- ▶ Use the **up** or **down arrow** key to highlight the skew created in "Measuring a skew and part edge line for point construction"
- ▶ Press the **enter** key
- > The features are selected



- ▶ Press the **Finish** soft key to construct the point
- > The point is constructed and is added to the feature list



Zeroing the datum

This example creates a zero reference datum from the point feature created in "Constructing a datum point from the skew and line features".

To zero the datum:

- ▶ Use the **up** or **down arrow** key to highlight the point created in "Constructing a datum point from the skew and line features"
- > The point is highlighted



- ▶ Press the **X axis** key to zero the X axis
- ▶ Press the **Y axis** key to zero the Y axis
- > The point is zeroed as a datum



Presetting the datum

Datums can be zeroed or preset. This example creates a preset reference datum.

To preset a datum:

- ▶ Press the **Preset** soft key
- ▶ Press the desired Axis key and enter the preset value for the axis
- ▶ Press another Axis key if desired and enter the preset value for that axis
- > The preset values are entered

D:1 mm		Preset		Position	
1	X	1.000	X	-0.020	
2	Y	2.000	Y	0.055	
3	Z	3	Z	0.000	
Enter the preset value for the axis.					
Recall				Help	

- ▶ Press the **enter** key to preset the datum to the specified values
- > The point is preset as a datum

D:1 mm			
1	X	1.000	
2	Y	2.000	
3	Z	3.000	
Measure		Clear All Send	

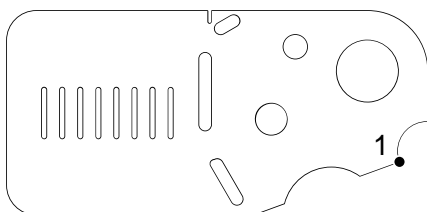
11.4 Measuring part features

11.4.1 Measuring a point

A point is the simplest feature to measure. Only one data point is required to define the location of a point. A maximum of 30 points can be probed and will be averaged by the system to define a single point.

To measure a point:

- ▶ Press the **Measure** soft key
- ▶ Press the **Point** soft key
- > The Measure Point screen is displayed
- ▶ Move the stage to position the crosshairs over the desired point location
- ▶ Press the **enter** key
- > A point is probed on the part



- ▶ If Annotation is set to **Free**, press the **Finish** soft key to complete the measurement
- > The point position is shown and the point feature is added to the feature list



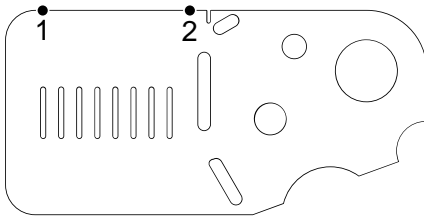
- ▶ Press the **C** key to return to the feature measurement selection soft keys
- ▶ Press the **C** key a second time to return to the DRO screen

11.4.2 Measuring a line

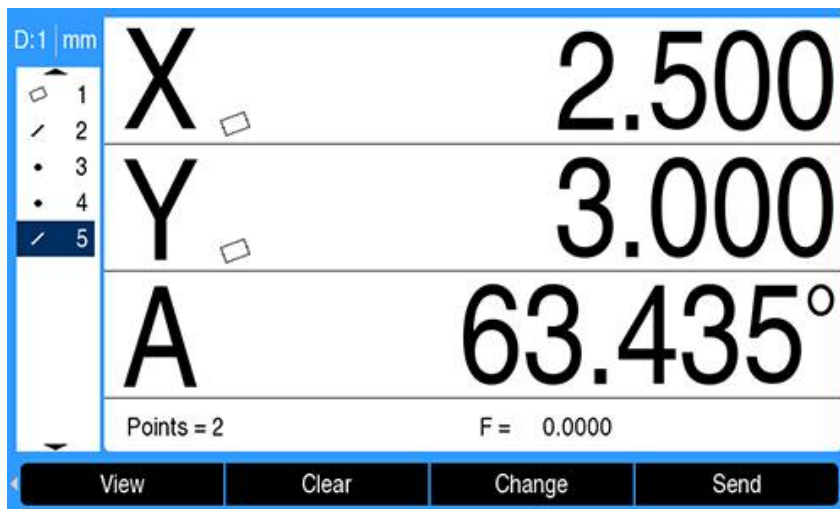
A minimum of 2 points are required to measure a line. A maximum of 30 points can be probed and will be processed by a fit algorithm to define the line.

To measure a line:

- ▶ Press the **Measure** soft key
- ▶ Press the **Line** soft key
- > The Measure Line screen is displayed
- ▶ Move the stage to position the crosshairs over an end point of the line
- ▶ Press the **enter** key
- ▶ Move the stage to position the crosshairs over the other end point of the line
- ▶ Press the **enter** key
- ▶ If Annotation is set to **Free**, press the **Finish** soft key to complete the measurement
- > A line is probed on the part



- > The line position and angle are shown and the line feature is added to the feature list



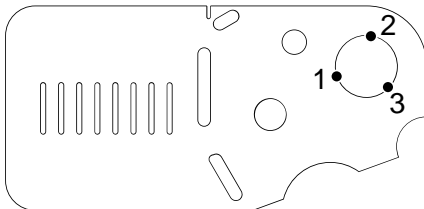
- ▶ Press the **left** or **right** arrow key, then press the **<1** or **<2** soft key for the line's angle or the line's second angle (based on **Angle Display** setting) if desired
 - ▶ Press the **Change** soft key to change the line fit algorithm if desired
- Line fit algorithm types:
- **LSBF**: Fit determined by minimizing the sum of the squared point deviations from the form fit
 - **ISO**: Fit determined by minimizing the form deviation
- ▶ Press the **C** key to return to the feature measurement selection soft keys
 - ▶ Press the **C** key a second time to return to the DRO screen

11.4.3 Measuring a circle

A minimum of 3 points are required to measure a circle. A maximum of 30 points can be probed and will be processed by a fit algorithm to define the circle.

To measure a circle:

- ▶ Press the **Measure** soft key
- ▶ Press the **Circle** soft key
- > The Measure Circle screen is displayed
- ▶ Move the stage to position the crosshairs over a point on the circumference of the circle
- ▶ Press the **enter** key
- ▶ Move the stage to position the crosshairs over two other points evenly distributed around the circumference, pressing the **enter** key to collect each point
- ▶ If Annotation is set to **Free**, press the **Finish** soft key to complete the measurement
- > A circle is probed on the part



- > The circle position and diameter are shown and the circle feature is added to the feature list



- ▶ Press the **left** or **right arrow** key, then press the **Rad/Dia** soft key to toggle the display between diameter and radius measurements if desired
- ▶ Press the **Change** soft key to change the circle fit algorithm if desired

Circle fit algorithms include:

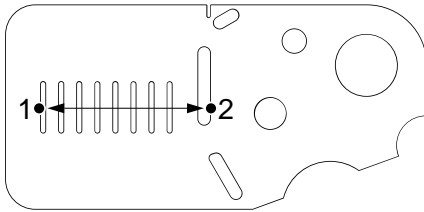
- **LSBF**: Fit determined by minimizing the sum of the squared point deviations from the form fit
- **ISO**: Fit determined by minimizing the form deviation
- **Outer**: Yields the biggest circle
- **Inner**: Yields the smallest circle.
- ▶ Press the **C** key to return to the feature measurement selection soft keys
- ▶ Press the **C** key a second time to return to the DRO screen

11.4.4 Measuring a distance

Two points are required to measure a distance.

To measure a distance:

- ▶ Press the **Measure** soft key
- ▶ Press the **right arrow** key
- ▶ Press the **Distance** soft key
- > The Measure Distance screen is displayed
- ▶ Move the stage to position the crosshairs over the first of the two points
- ▶ Press the **enter** key
- ▶ Move the stage to position the crosshairs over the second of the two points
- ▶ Press the **enter** key
- ▶ If Annotation is set to **Free**, press the **Finish** soft key to complete the measurement
- > A distance is probed on the part



- > The X, Y, and vector distances are shown and the distance feature is added to the feature list

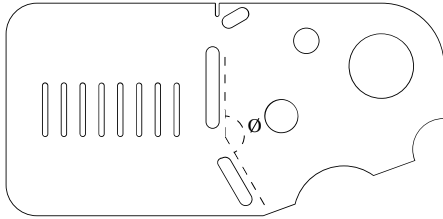


- ▶ Press the **left** or **right arrow** key, then press the **Length/Z** soft key to toggle the display between the vector distance (L) and the Z height if desired.
Z-axis height is not used in the calculation of vector distance.
- ▶ Press the **C** key to return to the feature measurement selection soft keys
- ▶ Press the **C** key a second time to return to the DRO screen

11.4.5 Measuring an angle

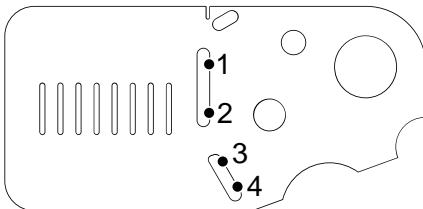
A minimum of 2 points per leg are required to measure an angle. A maximum of 30 points can be probed on each leg.

In this example slot features form an angle (ϕ) on the part.

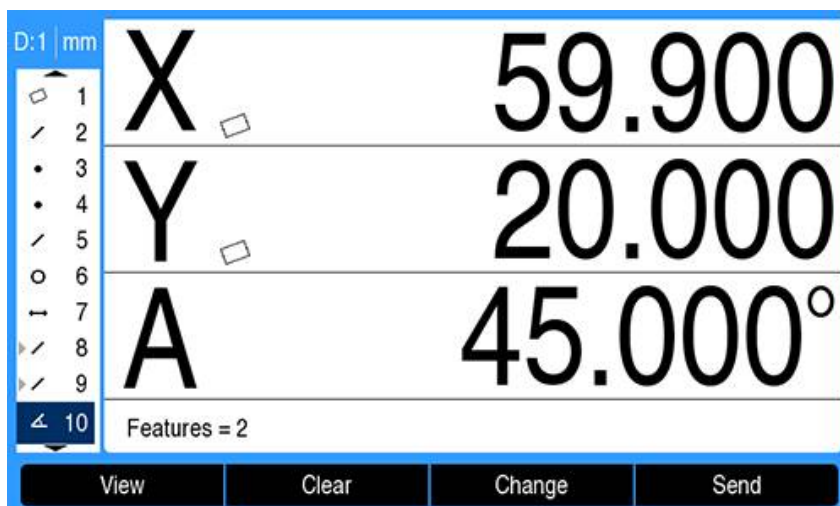


To measure an angle:

- ▶ Press the **Measure** soft key
- ▶ Press the **right arrow** key
- ▶ Press the **Angle** soft key
- > The Measure Angle screen is displayed
- ▶ Move the stage to position the crosshairs over a minimum of two points evenly distributed on one angle leg, pressing the **enter** key to collect each point
- ▶ Press the **Finish** soft key to complete the measurement of the first leg
- ▶ Move the stage to position the crosshairs over a minimum of two points evenly distributed on the second angle leg, pressing the **enter** key to collect each point
- ▶ If Annotation is set to **Free**, press the **Finish** soft key to complete the angle measurement
- > The two legs of the angle are probed on the part


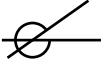
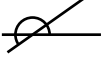
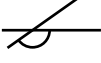


- > The angle and angle vertex position are shown. The angle feature and two angle leg features are added to the feature list.



- ▶ Press the **Change** soft key to change the angle type if desired

Angle types:

-  **<1**: Included angle <1
-  **360 - <1**: 360 degrees - included angle
-  **180 + <1**: 180 degrees + included angle
-  **180 - <1**: 180 degrees - included angle

- ▶ Press the **C** key to return to the feature measurement selection soft keys
- ▶ Press the **C** key a second time to return to the DRO screen

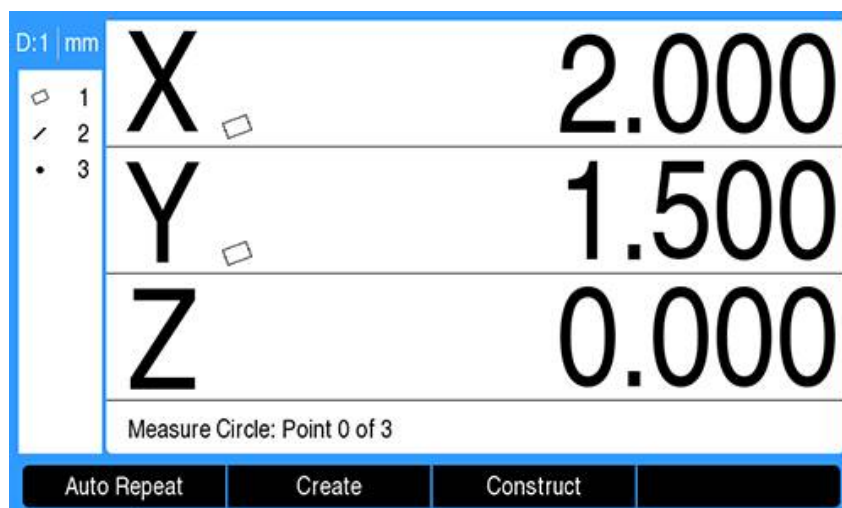
11.4.6 Measuring a series of features

The Auto Repeat function can be used to measure a series of features of the same type, without having to repeat feature type selection soft key sequences.

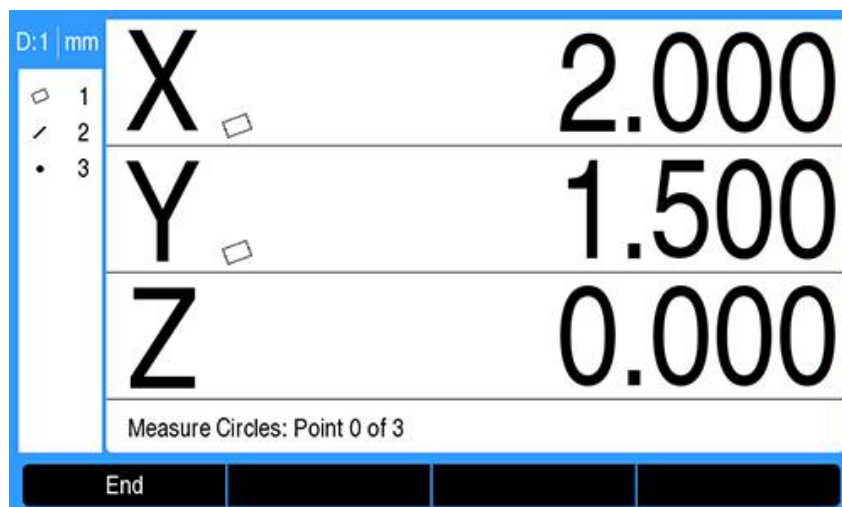
To measure a series of the same feature type:

- ▶ Press the **Measure** soft key
- ▶ Press the desired feature type soft key
- ▶ Press the **Auto Repeat** soft key
- ▶ Probe the required data points of the first feature
- ▶ Press the **Finish** soft key
- ▶ Repeat probing the required data points and pressing the **Finish** soft key until all of the required features are measured
- ▶ Press the **End** soft key to complete measuring the series of features

When Auto Repeat is selected, a Measure feature screen becomes a Measure features screen. For example, the Measure Circle screen becomes the Measure Circles screen as shown below.



Measure circle screen



Measure circles screen

Use **Auto Repeat** and **Fixed** annotation to speed up repetitive measurements. Without **Auto Repeat**, the measurement of a dozen circles using **Free** annotation requires you to press the **Circle** soft key before measuring each circle and the **Finish** soft key after each measurement.

The same measurements using **Auto Repeat** and **Fixed** annotation require you to press the **Circle** soft key and then the **Auto Repeat** soft key before and the **Finish** soft key once after measuring all 12 circles. Pressing the **End** soft key turns off auto repeat.

11.5 Creating part features

The Create part feature function can be used to create features that are not found on the part geometry. These features can be used as reference points for inspection purposes. For example, in order to measure a feature that refers to a point off the part geometry, you can create the reference point.

Created features are the same as measured features except that created features are geometrically perfect, so form error values do not apply.

Created features are not the same as constructed features. Created features are defined by you, constructed features are built from previously measured or created parent features. **Further information:** "Constructing part features", Page 182.

To create a feature:

- ▶ Press the **Measure** soft key
- ▶ Press the desired feature soft key
- ▶ Press the **Create** soft key
- ▶ Enter the required feature data
- ▶ Press the **enter** key
- > The created feature is added to the feature list

Example

To create a circle:

- ▶ Press the **Measure** soft key
- ▶ Press the **Circle** soft key
- ▶ The Measure Circle screen is displayed

D:1 mm			
1	X		0.200
2	Y		0.200
3	Z		0.000
Measure Circle: Point 0 of 3			
Auto Repeat		Create	Construct

- ▶ Press the **Create** soft key
- ▶ Enter the circle position and diameter (or radius) values
- ▶ The circle position and diameter values are entered

D:1 mm		Create Circle		Position	
1	X		1.500	X	0.200
2	Y		1.500	Y	0.200
3	Z		0.000	Z	0.000
4	Diameter		0.750		
5					
Rad/Dia				Help	

- ▶ Press the **enter** key
- ▶ The new circle is shown on the feature dimensions evaluation screen and added to the feature list



11.6 Constructing part features

New features can be constructed from measured, created, or other constructed features in the features list. Constructions are frequently used to perform skew alignments, set datums, and measure relationships between parent features.

Constructed features are the same as measured features, they can have form errors, and tolerances can be applied.

i If a construction is requested that does not include the required parent features or is not supported, an error message is displayed indicating "Construction Failed".

To construct a feature:

- ▶ Press the **Measure** soft key
- ▶ Press the desired feature soft key
- ▶ Press the **Construct** soft key
- ▶ Highlight a required parent feature
- ▶ Press the **enter** key to select it
- ▶ Continue highlighting and selecting parent features until all of the required features are selected
- ▶ Press the **Finish** soft key
- ▶ The constructed feature is added to the feature list

Example

In this example, a new point feature is constructed from two parent circle features:

- ▶ Press the **Measure** soft key
- ▶ Press the **Point** soft key
- > The Measure Point screen is displayed

D:1 mm	
○ 1	X 0.000
○ 2	Y 0.000
	Z 0.000
Measure Point: Point 0 of 1	
<div>Auto Repeat Create Construct</div>	

- ▶ Press the **Construct** soft key
- > The last feature in the feature list is highlighted
- ▶ If the last feature in the feature list is not one of the required parent features, press the **up arrow** key until the first parent feature is highlighted
In this example, the first parent circle feature is at the bottom of the feature list.
- > The first circle feature is highlighted **1**

D:1 mm	
○ 1	X 2.000
○ 2	Y 1.500
	D 0.500
Created	
<div>View Finish</div>	

- ▶ Press the **enter** key to select the highlighted feature
- > The first circle feature is selected as a parent feature. An arrow will appear next the feature **1** in the feature list indicating that it has been selected as a parent feature.



- ▶ Continue highlighting and pressing **enter** to select features, until all of the required parent features are selected
- > In this example, the second circle feature is highlighted **1**



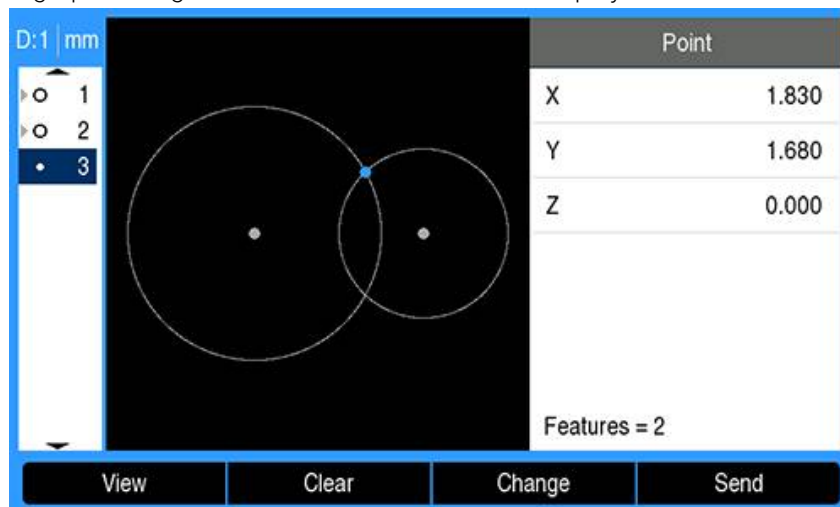
- > The second circle feature is selected **1** as a parent feature



- ▶ Press the **Finish** soft key to construct the new feature
- > The new point feature **1** is shown at the bottom of the feature list



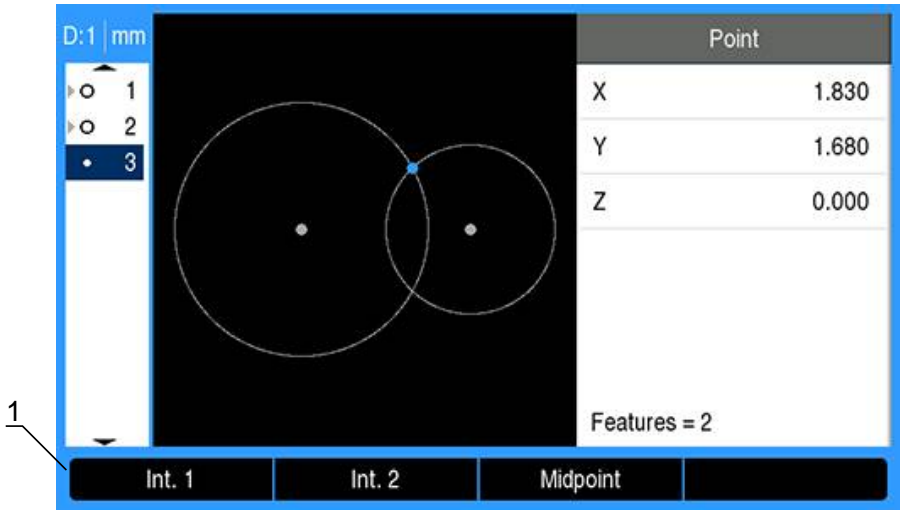
- ▶ Press the **View** soft key to toggle between a graphic image of the feature construction and the feature dimensions
- > A graphic image of the constructed feature is displayed



In this example the image shows that the **Int. 1** point was constructed at the top intersection of the two circle circumferences.

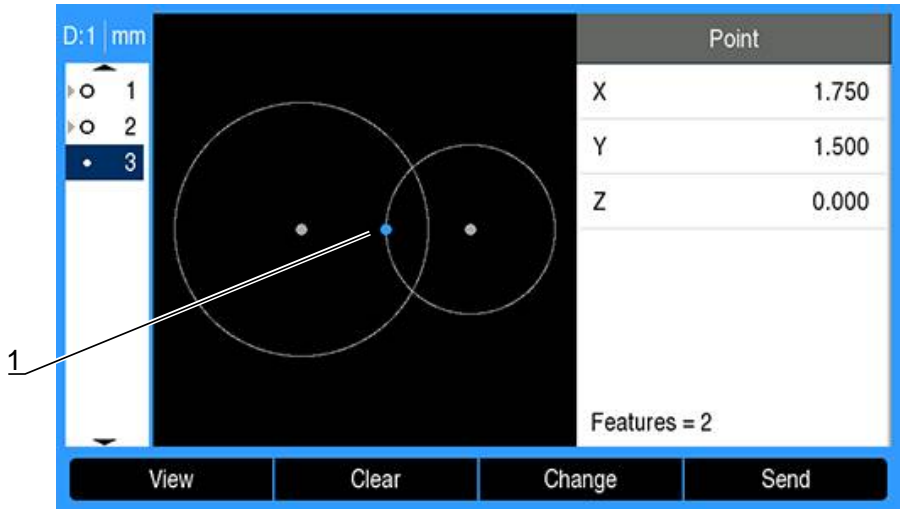
- ▶ Press the **Change** soft key to show alternative point features that can be constructed from the two parent circle features

> Alternative construction soft keys **1** are displayed






















- ▶ Press the desired construction alternative soft key to change the feature construction type
In this example the **Midpoint** point feature was selected, and the point is constructed at the midpoint between the two circle center points.

> The Point feature is changed to Midpoint **1**



More feature construction examples

A collection of some typical feature constructions are shown here graphically as examples. Many more constructions are possible.

Feature	Parent features	Feature	Parent features			
Point		Two lines: intersection	Line		Points: Best fit	
		Line and circle: intersection			Line and circle: perpendicular	
		Two circles: intersection			Two lines: bisector	
		Two points: mid point			Line and distance: offset	
		Point and circle: mid point	Circle		Multiple circles: best fit	
		Distance and point: offset			Circle and distance: offset	
		Circle: center point		Distance		Two points: point to point
		Line and point: perpendicular				Circle and circle: center to center
Angle		Line and datum: perpendicular			Point and line: perpendicular	
					Two lines: vertex	

11.7 Evaluating part features**Recalling feature data**

A part feature can be recalled to evaluate its feature data.

To recall a feature:

- ▶ Use the **up** or **down arrow** keys to highlight a feature
- ▶ Or
- ▶ Enter the feature number using the numeric key pad
- > The feature dimensions screen is displayed

Further information: "Feature evaluation screens and soft keys", Page 161.

11.8 Sending data to a USB storage device or a PC

Feature and position data can be transmitted to a USB mass storage device or to a PC via the USB connection. The data is transmitted as a .txt file labeled QCPRINT.txt. New data is appended to the end of the QCPRINT.txt file when sent.

Transmitting position data

To transmit position data:

From the DRO screen:

- ▶ Press the **Send** soft key
- ▶ Press the **Send Position** soft key
- > The current position data is sent to the `QCPRINT.txt` file

Transmitting all feature data

To transmit data for all features in the feature list:

From the DRO screen:

- ▶ Press the **Send** soft key
- ▶ Press the **Send All** soft key
- > The feature data for all features in the feature list is sent to the `QCPRINT.txt` file

Transmitting all tolerance data

To transmit data for all features with a tolerance in the feature list:

From the DRO screen:

- ▶ Press the **Send** soft key
- ▶ Press the **Send Tolerance** soft key
- > The tolerance data for all features with a tolerance is sent to the `QCPRINT.txt` file

Transmitting individual feature data

To transmit data for individual features:

- ▶ Use the **up** or **down arrow** keys to highlight a feature in the feature list
- ▶ Press the **Send** soft key
- ▶ Press the soft key that corresponds to the information that you want to transmit
 - **Send Feature**: Sends all data for the highlighted feature
 - **Send 2**: Sends the current X and Y data
 - **Send 3**: Sends the current X and Y data, and the feature's Z/Q, angle, diameter, or length data
 - **Send X**: Sends the X-axis value
 - **Send Y**: Sends the Y-axis value
 - **Send Z**: Sends the Z-axis value
 - **Send Q**: Sends the Q-axis value
 - **Send D**: Sends the diameter value
 - **Send r**: Sends the radius value
 - **Send F**: Sends the form error data
 - **Send <**: Sends the angle value
 - **Send L**: Sends the length value

11.9 Deleting part features

Deleting a part feature

An unneeded part feature can be removed from the feature list.

To delete a part feature:

- ▶ Use the **up** or **down arrow** key to highlight a feature
- ▶ Press the **Clear** soft key
- > A pop-up warning informs you that the feature will be deleted
- ▶ Press the **enter** key to continue
- > The highlighted feature is removed from the feature list
- or
- ▶ Press the **C** key to cancel

Deleting all part features

All part features can be cleared at one time from the feature list.

To delete all part features:

- ▶ Press the **Clear All** soft key
- > A pop-up warning informs you that the all features, datums and skew will be deleted
- ▶ Press the **enter** key to continue
- > All part features are removed from the feature list and all datums are cleared
- or
- ▶ Press the **C** key to cancel

11.10 Tolerancing

Feature tolerances

The following tolerances are available.

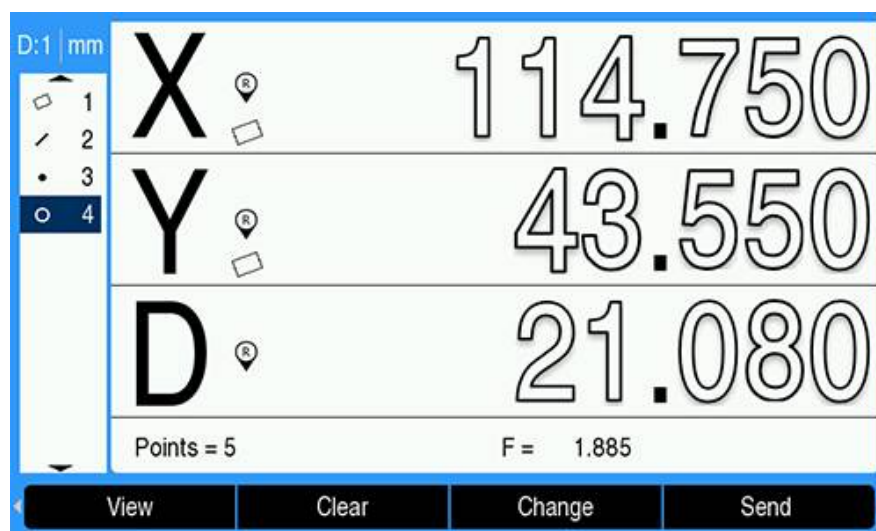
Feature type	Tolerance	
Point	Position	Bidirectional position
		True position
Line	Position	Bidirectional position
		True position
	Form	
	Orientation	Angle
		Perpendicularity
		Parallelism
Circle	Position	Bidirectional position
		True position
		LMC: Least material condition
		MMC: Maximum material condition
	Form	
	Runout	
	Concentricity	
Distance	Width	
Angle	Angle	

Applying a tolerance

The method of applying tolerances is identical for all feature types. To apply a tolerance:

- ▶ Highlight a feature in the feature list using the **up** or **down arrow** key
- ▶ Press the **left** or **right arrow** key to display the **Tolerance** soft key
- ▶ Press the **Tolerance** soft key to display the tolerance soft keys
- ▶ Press the soft key corresponding to the desired tolerance type
- ▶ A new screen will be displayed containing data fields for nominal and tolerance values.
- ▶ Enter the nominal and tolerance values
- ▶ Press the **Finish** soft key to display the tolerance results
- ▶ Press the **Finish** soft key again to return to the DRO screen

Measurements that fail are indicated by outlined characters in the DRO screen.



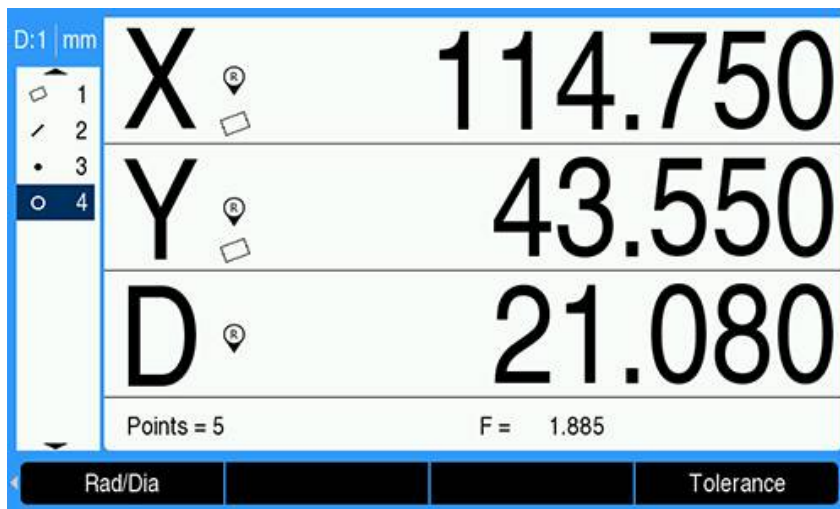
Applying a tolerance example

In this example, a Form tolerance is applied to a circle feature.

- Use the **up** or **down arrow** key to highlight the desired feature in the feature list. In this example, the circle feature is highlighted



- Press the **left** or **right arrow** key to display the **Tolerance** soft key



- Press the **Tolerance** soft key to display circle feature tolerance options
 - Pos (Position)
 - Form
 - Runout
 - Con (Concentricity)

D:1 | mm

1

2

3

4

X

Y

D

114.750

43.550

21.080

Points = 5

F = 1.885

Pos

Form

Runout

Con

- ▶ Press the soft key corresponding to the desired tolerance type to display the data entry screen
In this example, the **Form** soft key was pressed and the data entry screen for specifying the roundness tolerance is displayed. Initially, the tolerance data field (**Tolerance Zone**) contains the measured deviation from ideal roundness.

D:1 | mm

1

2

3

4

Tolerance

Form

Tolerance Zone

1.885

X

Y

D

F

114.750

43.550

21.080

1.885

Points = 5

LSBF

Help

Finish

- ▶ Enter the desired nominal tolerance values into the data fields provided
In this example of a circle form tolerance, only the roundness tolerance field is provided, and a tolerance is entered.

D:1 | mm

1

2

3

4

Tolerance

Form

Tolerance Zone

2.000

X

Y

D

F

114.750

43.550

21.080

1.885

Points = 5

LSBF

Help

Finish

- ▶ Press the **Finish** soft key to display the tolerance result
 - > The tolerance and actual values are displayed
- In this example, the tolerance value was greater than the actual value and the tolerance passed. A checkmark is shown to indicate a passed test.

D:1 mm		Circle 4 - Tolerance Passed		Circle	
1	Tolerance Type	Form	X	114.750	
2	Tolerance Zone	2.000	Y	43.550	
3					
4	Actual	1.885	✓	D	21.080
				F	1.885
				Points = 5	LSBF
Edit				Finish	

- ▶ Press the **Finish** soft key again to return to the DRO screen

12

Programming

12.1 Overview



This feature is available on DRO300 products only.

The basic machining operations available in the DRO mode (i.e. tool selection, preset, hole patterns) can also be used to create a program. A program is a sequence of one or more machining operations. Programs can be executed a number of times and saved for later use.

Each machining operation is a separate step in the program. A program can have up to 250 steps. The program listing shows the step numbers, and the associated machining operations.

Programs are saved to internal storage, which is not lost when power is off. The readout can hold up to 10 programs in internal storage. Programs can also be saved to external storage on a PC using the **Export** and **Import** functions.

Program	
1	001
2	
3	
4	
5	
6	
7	

Readout Settings: D:0, T:1, F: 0, 0:00, mm, Abs, Set

Buttons: Edit, Clear, Run, Help

Opening Program mode

To open **Program** mode:

- ▶ Press the **Program** soft key
- > A listing of the **Program** (or a blank listing) is displayed

12.2 Creating a new Program

To create a new **Program**:

- ▶ Highlight the program number where you want to make a new program
- > If the program number is available the **New** soft key will be displayed
- ▶ Press the **New** soft key
- ▶ Enter a **Program Name**
- ▶ Press the **Save** soft key
- ▶ The new **Program** is created and the first step in the program is shown highlighted

12.3 Creating features in a program

Features are inserted into a **Program** and are used to create steps in the **Program**.

To access the available **Features**:

- ▶ Press the **Features** soft key
- > The following **Features** are available:
 - **Tool**
 - **Datum**
 - **Preset**
 - **Position**
 - **Circle Pattern**
 - **Linear Pattern**
- ▶ Press the **left** or **right arrow** key to toggle through the soft keys

12.3.1 Creating a Tool step

The **Tool** step is used to select the tool, from the **Tool Table**, that will be used by the subsequent steps in the program.

To select a **Tool**:

- ▶ Press the **Tool** soft key
- ▶ Highlight the desired **Tool** in the **Tool Table**
- ▶ Press the **Use** soft key
- > The step that was highlighted in the program will become a **Tool** step

12.3.2 Creating a Datum step

The **Datum** step is used to select the datum to be used by subsequent steps in the program.

To select a **Datum**:

- ▶ Press the **Datum** soft key
- ▶ Enter the desired **Datum** number
- ▶ Press the **enter** key
- > The step that was highlighted in the program will become a **Datum** step

12.3.3 Creating a Preset step

The **Preset** step is used to enter the nominal (target) position to move to from within a program.

To enter a **Preset**:

- ▶ Press the **Preset** soft key
- ▶ Select the desired information
- ▶ Press the **enter** key
- > The step that was highlighted in the program will become a **Preset** step

12.3.4 Creating a Position step

This feature is available in the **Mill** application only.

The **Position** step is used to enter the nominal (target) position to move to “for the machine and tool axes” (X, Y, & Z) from within a program.

To create a **Position** step:

- ▶ Press the **Position** soft key
- ▶ Enter the nominal positions for the machine axes
- ▶ Enter the depth for the tool axis (optional)
- ▶ Press the **enter** key
- > The step that was highlighted in the program will become a **Position** step

12.3.5 Creating a Circle Pattern step

This feature is available in the **Mill** application only.

The **Circle Pattern** step is used to specify the parameters of a circle pattern from within a program.

To create a **Circle Pattern** step:

- ▶ Press the **Circle Pattern** soft key
- ▶ Press the **up** or **down arrow** keys to select the desired pattern
- ▶ Press the **Use** soft key
- > The step that was highlighted in the program will become a **Circle Pattern** step

Modifying a pattern

To modify the selected pattern:

- ▶ Press the **enter** key
- or
- ▶ Press the **Edit** soft key
- ▶ Enter the new pattern parameters in the **Circle Pattern** form
- ▶ Press the **enter** key

12.3.6 Creating a Linear Pattern step

This feature is available in the **Mill** application only.

The **Linear Pattern** step is used to specify the parameters of a linear pattern from within a program.

To create a **Linear Pattern** step:

- ▶ Press the **Linear Pattern** soft key
- ▶ Press the **up** or **down arrow** keys to select the desired pattern
- ▶ Press the **Use** soft key
- > The step that was highlighted in the program will become a **Linear Pattern** step

Modifying a pattern

To modify the selected pattern:

- ▶ Press the **enter** key
- or
- ▶ Press the **Edit** soft key
- ▶ Enter the new pattern parameters in the **Linear Pattern** form
- ▶ Press the **enter** key

12.4 Editing steps

Selecting a step

To select a specific step in the program:

- ▶ Use the numeric keypad and enter the desired step number (ex. 5)
- ▶ Press the **enter** key
- > The highlighted step is moved to the desired position in the program

Inserting a step

To insert a step:

- ▶ Highlight the step below where you want to insert the new step
- ▶ Press the **Features** soft key
- ▶ Select the desired feature
- > The highlighted step and all of the following steps are shifted down one step in the program listing, and the new step is inserted at the highlighted step

Editing a step

To edit a step:

- ▶ Highlight the step you would like to edit
- ▶ Press the **enter** key
- ▶ The options for the highlighted step are displayed and can be edited

Clearing a step

To clear a step from the program:

- ▶ Highlight the step you would like to clear
- ▶ Press the **Clear** soft key
- > A pop-up warning informs you that the current step will be cleared from the program



When a step is cleared from the program, all of the steps following the cleared step are shifted up one step in the listing

- ▶ Press the **enter** key to clear the step from the program
- ▶ or
- ▶ Press the C key to cancel

Exploding a step

A **Circle Pattern** or a **Linear Pattern** step can be expanded into individual **Position** steps.

To **Explode** a step:

- ▶ Highlight a **Circle Pattern** or a **Linear Pattern** step
- ▶ Press the **Explode** soft key
- > The pattern is expanded in the **Program** into individual **Position** steps. All of the following steps are shifted down in the program listing.

12.5 Editing a Program

To edit a **Program**:

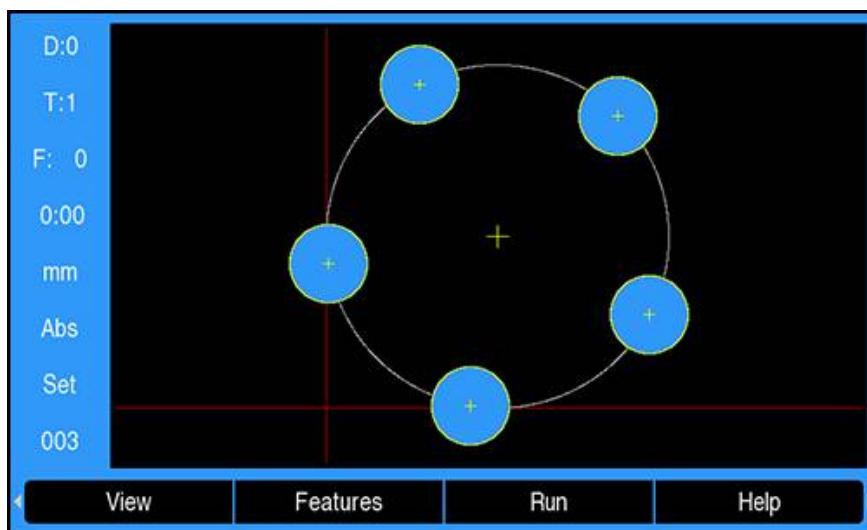
- ▶ Highlight the **Program** you want to edit
- ▶ Press the **Edit** soft key
- ▶ Edit the steps in the **Program** you would like to change
- ▶ **Further information:** "Editing steps", Page 198
- > Changes are automatically saved in the **Program**

12.6 Opening the graphical view

The **View** soft key is used to toggle between the program listing with the DRO (Absolute) positions and a graphical view of the part program.

When **Program** mode is selected, the view defaults to the program listing view.

D:0	001		Position	
T:1	1	Tool 1	X	0.000
F: 0	2	Datum 2	Y	0.000
0:00	3	Circle Pattern	Z	0.000
mm	4		W	0.000
Abs				
Set				
<div><div>View</div><div>Features</div><div>Run</div><div>Help</div></div>				



Graphical view features:

- **Datum, Position, Circle Pattern, and Linear Pattern** steps have a graphical view
- Features of the part are scaled to the size of the window
- The datum is drawn as a vertical and horizontal line representing the (0,0) location
- The position and holes of a hole pattern are drawn as circles
- The diameter of the programmed tool is used to draw the holes

Opening the graphical view

To open the graphical view:

- Press the **View** soft key

12.7 Running a program

To run a program:

- ▶ Use the **up** or **down arrow** keys to highlight the program step to begin running
- ▶ or
- ▶ Use the numeric key pad to select the program step to begin running
- ▶ Press the **Run** soft key
- ▶ The Distance-To-Go view is displayed and the **Run** soft keys are shown. The number of the current step being executed is also displayed on the status bar.


The following soft keys are available when running a program:

Soft key	Function
View	Press the View soft key to see the graphical view of a circle or linear pattern that is being run
Previous	Press the Previous soft key to go to the previous step or hole in a program
Next	Press the Next soft key to go to the next step or hole in a program
End	Press the End soft key to end running a program

13

**Measured value
output**

13.1 Overview

 This feature is available on DRO300 products only.

The remote switch (pendant or footswitch) will transmit the currently displayed values in either Actual Value or Distance-To-Go mode, whichever is currently visible.

13.2 Data output using an edge finder

In the next three examples, measured value output is started with a switching signal from the edge finder. Data output to a USB mass storage device can be turned on, or off in the **Measured value out.** settings.

Further information: "Measured value out.", Page 98

Example 4

Probing function Edge Y = -3674.4498 mm

Y		:	-	3674	.	4498		R	<CR>	<LF>
1	2	3	4	5	6	7	8	9	10	11

- 1 Coordinate axis
- 2 (2) Blank Spaces
- 3 Colon
- 4 +/- sign, or Blank Space
- 5 2 to 7 places before the decimal point
- 6 Decimal point
- 7 1 to 6 places after the decimal point
- 8 Unit: blank space for mm, " for inches
- 9 **R** for radius, **D** for diameter display
- 10 Carriage return
- 11 Blank line (Line Feed)

Example 5

Probing function Centerline

Coordinate of centerline on X axis CLX = + 3476.9963 mm (**C**enter **L**ine **X** axis)

Distance between the probed edges DST = 2853.0012 mm (**D**istance)

CLX	:	+	3476	.	9963		R	<CR>	<LF>
DST	:		2853	.	0012		R	<CR>	<LF>
	1	2	3	4	5	6	7	8	9

- 1** Colon
- 2** +/- sign, or Blank Space
- 3** 2 to 7 places before the decimal point
- 4** Decimal point
- 5** 1 to 6 places after the decimal point
- 6** Unit: blank space for mm, " for inches
- 7** **R** for Radius, **D** for Diameter display
- 8** Carriage return
- 9** Blank line (Line Feed)

Example 6

Probing function Circle Center

First center point coordinate, e.g. CCX = -1616.3429 mm. Second center point coordinate, e.g. CCY = +4362.9876 mm, (**C**ircle **C**enter **X** axis, **C**ircle **C**enter **Y** axis; coordinates depend on working plane).

Circle diameter DIA = 1250.0500 mm

CCX	:	-	1616	.	3429		R	<CR>	<LF>
CCY	:	+	4362	.	9876		R	<CR>	<LF>
DIA	:		1250	.	0500		R	<CR>	<LF>
	1	2	3	4	5	6	7	8	9

- 1** Colon
- 2** +/- sign, or Blank Space
- 3** 2 to 7 places before the decimal point
- 4** Decimal point
- 5** 1 to 6 places after the decimal point
- 6** Unit: blank space for mm, " for inches
- 7** **R** for Radius, **D** for Diameter display
- 8** Carriage return
- 9** Blank line (Line Feed)

14

External operation

14.1 External operation

The product can be operated over the USB data interface from a host application. Special commands available: <Ctrl>B 'Send Current Position', <Ctrl>P 'Send Screen Capture'.

The following key commands are available:

Format	
<ESC>TXXXX<CR>	Key is pressed
<ESC>AXXXX<CR>	Output of screen contents
<ESC>SXXXX<CR>	Special functions
Sequence of commands	Function
<ESC>T0000<CR>	0 key
<ESC>T0001<CR>	1 key
<ESC>T0002<CR>	2 key
<ESC>T0003<CR>	3 key
<ESC>T0004<CR>	4 key
<ESC>T0005<CR>	5 key
<ESC>T0006<CR>	6 key
<ESC>T0007<CR>	7 key
<ESC>T0008<CR>	8 key
<ESC>T0009<CR>	9 key
<ESC>T0100<CR>	C key
<ESC>T0101<CR>	+/- key
<ESC>T0102<CR>	. (decimal) key
<ESC>T0104<CR>	enter key
<ESC>T0109<CR>	Axis Key 1
<ESC>T0110<CR>	Axis Key 2
<ESC>T0111<CR>	Axis Key 3
<ESC>T0112<CR>	Axis Key 4 (Available on DRO304 products only)
<ESC>T0114<CR>	Soft key 1
<ESC>T0115<CR>	Soft key 2
<ESC>T0116<CR>	Soft key 3
<ESC>T0117<CR>	Soft key 4
<ESC>T0135<CR>	Left arrow key
<ESC>T0136<CR>	Right arrow key
<ESC>T0137<CR>	Up arrow key
<ESC>T0138<CR>	Down arrow key
<ESC>A0000<CR>	Send device identification
<ESC>A0200<CR>	Send actual position

Sequence of commands	Function
<ESC>S0000<CR>	Reset device
<ESC>S0001<CR>	Lock keypad
<ESC>S0002<CR>	Release keypad

15

**Operating the
IOB 610**

15.1 Setup

When an IOB 610 is connected to a DRO300 product, Spindle functions for **Mill** applications, Constant Surface Speed **CSS** functions for **Turn** applications, and **EDM** functions are available.

Configuring the DRO

- ▶ Connect the IOB 610 to a DRO300 product
- > The DRO will automatically recognize when the IOB is connected
Further information: "Connecting an accessory", Page 43
- ▶ Configure the product for **Mill** applications to use **Spindle Settings** and **Switching Outputs** options
Further information: "Readout Settings", Page 83
- > The **Spindle Settings** and the **Switching Outputs** menus will display under **Installation Setup**
or
- ▶ Configure the product for **Turn** applications to use **CSS Settings** and **Switching Outputs** options
Further information: "Readout Settings", Page 83
- > The **CSS Settings** and the **Switching Outputs** menus will display under **Installation Setup**
or
- ▶ Configure the product for **EDM** applications
Further information: "Readout Settings", Page 83
- > The **edm setup**, **edm on/off**, and **dro/edm** soft keys will display in the soft key area.

15.2 Switching functions



Switching Outputs cannot be used for coupled axes or for axes with backlash compensation.

15.2.1 Switching inputs

The IOB 610 provides four inputs that are used to zero the actual value of the assigned axis. A low-to-high transition at the input causes the value for that axis to be set to zero.

15.2.2 Switching Outputs

Switching Outputs consist of integrated relays available for generic use. The number of outputs available is dependent on the configuration options chosen:

Mill Application

- 10 **Switching Outputs** are available when **Spindle Speed** control (**rpm**) is **Disabled**
- 5 **Switching Outputs** are available when **rpm** is **Enabled**

Further information: "Spindle Speed control settings", Page 219

Turn Application

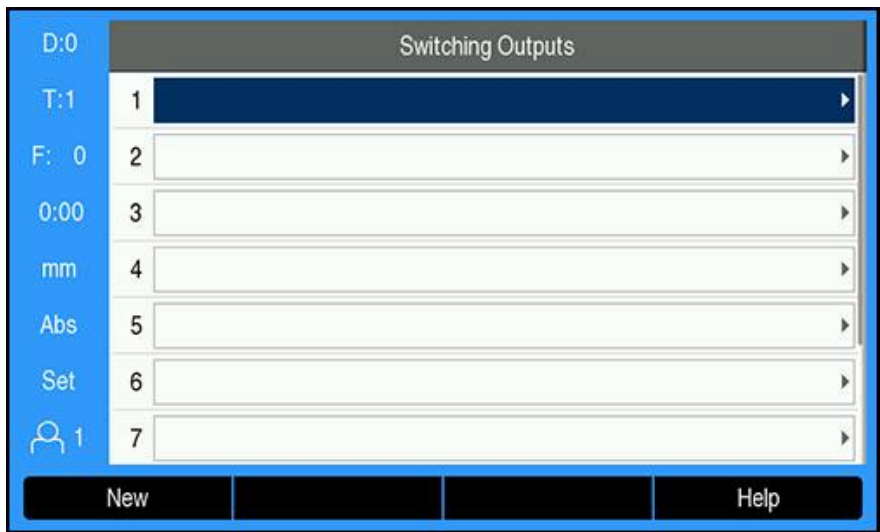
- 10 **Switching Outputs** are available when constant surface speed (**CSS**) is **Disabled**
- 5 **Switching Outputs** are available when **CSS** is **Enabled**

Further information: "CSS control settings", Page 228

Output settings

Switching Outputs can be configured to activate when a position display reaches a specific value or within a specified range of zero.

Accessing the Switching Outputs table



- To access the **Switching Outputs** settings:
- ▶ Press the **Setup** soft key
 - ▶ Open in sequence:
 - **Installation Setup**
 - **Switching Outputs**
 - > The **Switching Outputs** table which stores output configurations will be displayed

Configuring an output

D:0	Installation Setup	Output Settings (1)	
T:1	Display Color Scheme	Axis	X
F: 0	Factory Defaults	Condition	Off
0:00	Error Compensation	Switch Point (Abs)	0.000
mm	Backlash Comp.	Type	Point
Abs	Thread Cycle Setup	Relay Output	On
Set	CSS Settings	Relay Mode	Continuous
1	Switching Outputs		

Help

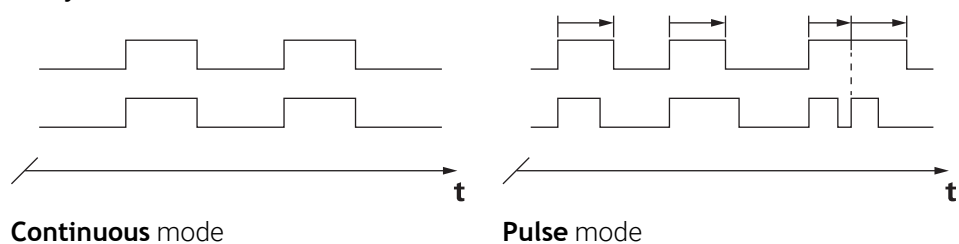
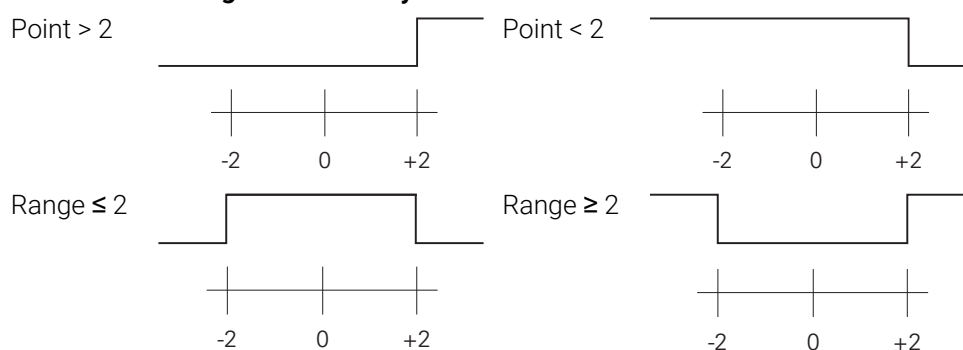
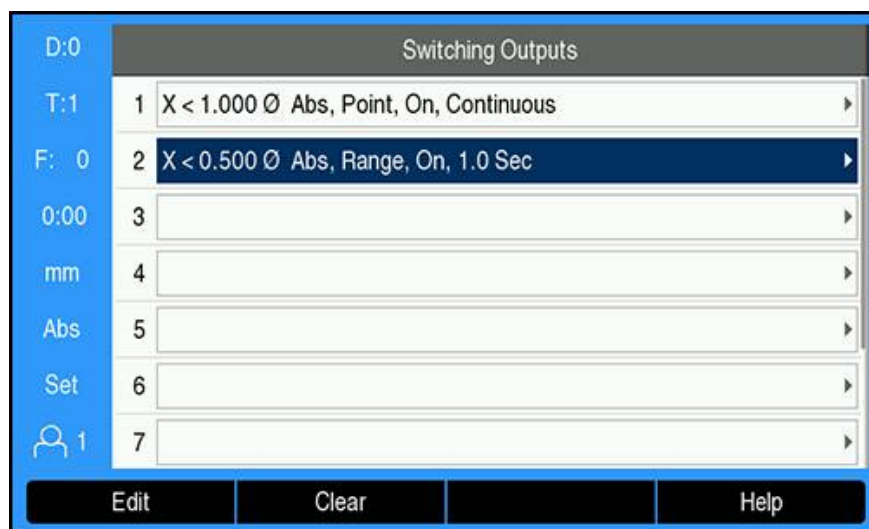
To set or change the configuration of an output:

- ▶ Select the output using the **arrow** keys or the **numeric** keypad
- ▶ Press the **enter** key
- > The **Output Settings** options are displayed:
- ▶ Assign an **Axis** to the output
- ▶ Select the required **Condition** at which the relay is activated:
 - **Off**
 - **<**
 - **<=**
 - **>=**
 - **>**
- ▶ Select the **Switch Point** to specify the axis position by pressing the **Abs/Inc** soft key and set the position display value using the **numeric** key pad
 - **Abs** (Actual Value)
 - **Inc** (Distance-To-Go)
- ▶ Select the settings **Type**:
 - **Point** on the axis
 - **Range** about zero
- ▶ Select the **Relay Output** to turn the relay **On** or **Off** when the switching condition is met
- ▶ Select the **Relay Mode** to activate a cycle:
 - **Continuous**
 - **Pulse**

In **Pulse** mode, the relay is activated (**On** or **Off**) for a specified period of time. After the period has timed out, the relay is deactivated. The pulse time can be set to 0.1 to 999.9 seconds.



The time period begins whenever the switching condition transitions from "false" to "true". If the switching conditions transitions to "true" before the period has timed out, the timer will start over.

Relay modes**Possible switching states of relays****Clearing an output**

To clear an output:

- ▶ Highlight the switching output relay that is to be cleared by using the **arrow** keys or the **numeric** keypad
- ▶ Press the **Clear** soft key
- ▶ Press the **enter** key to confirm
- ▶ The output relay settings will be cleared


15.3 Spindle Speed control

i **Spindle Speed** control is only available for milling systems. If the DRO300 is configured for a turning system, then no **Spindle Settings** will be displayed.

i The **Spindle Settings** option in the **Installation Setup** menu will only appear if the IOB 610 is detected.

Spindle Speed control is used to automatically set the spindle speed on a mill.

15.3.1 Installation Setup

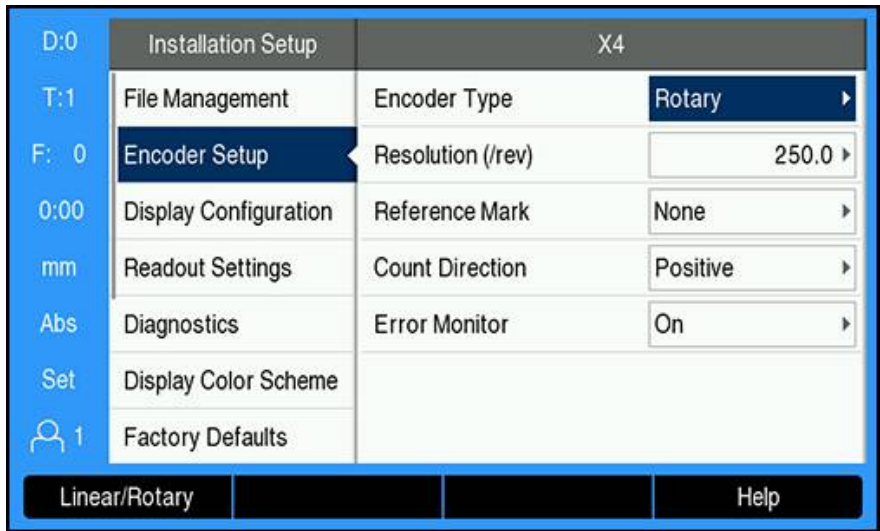


In order to use the **Spindle Speed** control, the DRO must be set to **Mill**, the last axis must be configured as a **Rotary** encoder, the last display must be set to **Speed (rpm)**, and the **Status** setting must be set to **Enabled**.

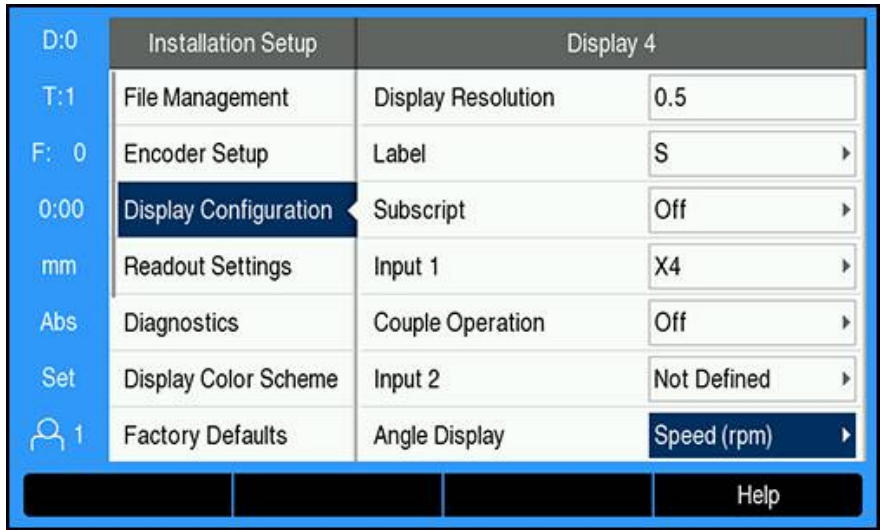
To set the DRO to **Mill Application**, refer to the "Configuring the DRO" section in the manual.

Further information: "Setup", Page 212

To set the **Encoder Type** to **Rotary**:

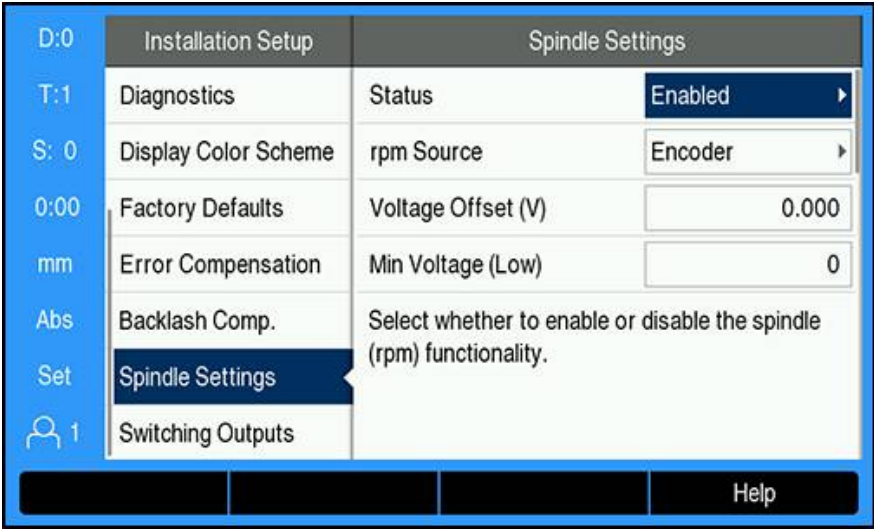


- ▶ Press the **Setup** soft key
 - ▶ Open in the sequence:
 - **Installation Setup**
 - **Encoder Setup**
 - The last encoder
 - **Encoder Type**
 - ▶ Select **Rotary**
 - ▶ Press the **enter** key to save the setting
- To set the **Display Configuration** to **Speed (rpm)**:



- ▶ Return to the **Installation Setup** screen
- ▶ Open in the sequence:
 - **Display Configuration**
 - The last display
 - **Angle Display**
- ▶ Select **Speed (rpm)**
- ▶ Press the **enter** key to save the selection

To set the **Spindle Speed** control to **Enabled**:




- ▶ Return to the **Installation Setup** screen
- ▶ Open in the sequence:
 - **Spindle Settings**
 - **Status**
- ▶ Select **Enabled**
- ▶ Press the **enter** key to save the selection
- or
- ▶ Press the **C** key to cancel and return to the previous screen without saving changes

15.3.2 Spindle Speed control settings


To configure the **Spindle Speed** control settings:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence:
 - **Installation Setup**
 - **Spindle Settings**
- ▶ Press the **up** or **down arrow** keys to select a setting

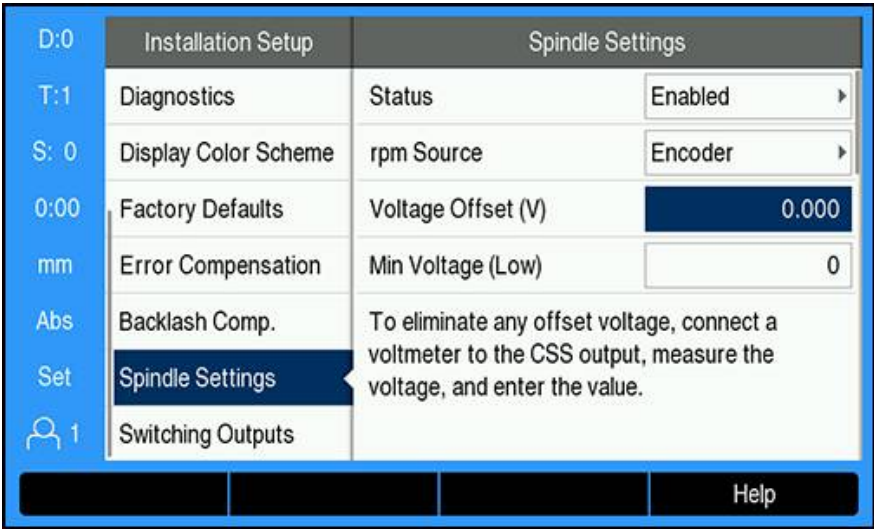


Additional settings that are not initially visible on the **Spindle Settings** form must be accessed using the **down arrow** key.

- ▶ Select the **Status** of the spindle (rpm) functionality:
 - **Enabled**
 - **Disabled**
- ▶ Select the **rpm Source**:
 - **Encoder**
 - **Calculated**: the software will calculate the speed as a replacement for a rotary encoder


D:0	Installation Setup	Spindle Settings	
T:1	Diagnostics	Status	Enabled ▶
S: 0	Display Color Scheme	rpm Source	Encoder ▶
0:00	Factory Defaults	Voltage Offset (V)	0.000
mm	Error Compensation	Min Voltage (Low)	0
Abs	Backlash Comp.	Select whether the speed (rpm) is determined from a rotary encoder or calculated internally.	
Set	Spindle Settings		
 1	Switching Outputs		
		Help	

- ▶ Enter the **Voltage Offset** which is added to the calculated DAC output to adjust for any inherent offset in the DAC output.

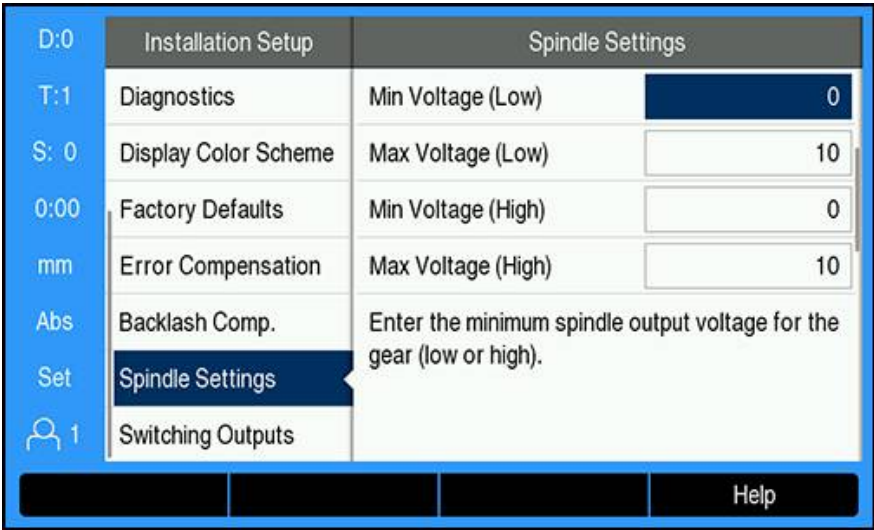


To determine the **Voltage Offset**:

- ▶ Measure the actual voltage at the DAC output using a voltmeter
- ▶ Enter the opposite of the actual voltage in the **Voltage Offset** setting to adjust for any offset and bring the DAC output back to 0 V

 The **Voltage Offset** setting range is limited to -0.2 V to +0.2 V

- ▶ Enter the **Min and Max Voltage** to establish the relationship between the DAC output signal (+0 V to +10 V) and the spindle speed for each gear (**Low** and **High**)



- ▶ Enter the **V - rpm** for each gear (Low and High)
- ▶ The spindle speed will then be calculated using the DAC output S_{out} linear relationship to determine the corresponding output voltage V_{out} using the formula: $V_{out} = 10 \cdot (S_{out} - S_0) / (S_{10} - S_0) + V_{Offset}$

D:0	Installation Setup	Spindle Settings	
T:1	Diagnostics	0V - rpm (Low)	0
S: 0	Display Color Scheme	10V - rpm (Low)	9999
0:00	Factory Defaults	0V - rpm (High)	0
mm	Error Compensation	10V - rpm (High)	9999
Abs	Backlash Comp.	Enter the expected speed (rpm) for the displayed voltage and gear (low or high).	
Set	Spindle Settings		
1	Switching Outputs		

Help

To determine the **V - rpm**:

- ▶ Enter the expected speed (rpm) for the displayed voltage and gear (Low and High) to set the physical limits of the machine
- ▶ The **S:** field on the status bar will display the current spindle speed in rpm
- ▶ Enter the **Min** and **Max Run rpm** allowed for each gear (Low and High)

D:0	Installation Setup	Spindle Settings	
T:1	Diagnostics	Min Run rpm (Low)	0
S: 0	Display Color Scheme	Max Run rpm (Low)	9999
0:00	Factory Defaults	Min Run rpm (High)	0
mm	Error Compensation	Max Run rpm (High)	9999
Abs	Backlash Comp.	Enter the minimum speed (rpm) allowed while running.	
Set	Spindle Settings		
1	Switching Outputs		

Help

- ▶ Press the **enter** key to save the settings and exit the form
or
- ▶ Press the **C** key to exit without saving the changes

15.3.3 Spindle Speed control operation

To operate the **Spindle Speed** control, the spindle parameters in the **Tool Table** menu must be programmed.

Accessing the Tool Table

- To access the **Tool Table** and enter **Tool** specifications:
- ▶ Press the **Tool** soft key
- ▶ Use the **up** or **down arrow** key to highlight the desired tool
or
- ▶ Use the **numeric** keypad to enter the tool number

The screenshot shows the 'Tool Table' menu. On the left, there are status indicators: 'D:0', 'T:1', 'F: 0', '0:00', 'mm', 'Abs', 'Set', and a user icon '1'. The main area is a table with 7 rows. Row 1 is highlighted and contains: '1 D: 4.500 L: 0.000 mm Flat End Mill Forward'. Rows 2-5 are empty. Row 6 contains: '6 D: 2.000 L: 0.000 mm Flat End Mill Off'. Row 7 is empty. At the bottom, there are four buttons: 'Tool Axis [Z]', 'Clear', 'Use', and 'Help'.

Tool Table	
1	D: 4.500 L: 0.000 mm Flat End Mill Forward
2	
3	
4	
5	
6	D: 2.000 L: 0.000 mm Flat End Mill Off
7	

- ▶ Press the **enter** key to display the **Tool** form for the selected tool

The screenshot shows the 'Tool (1)' form. On the left, there are status indicators: 'D:0', 'T:1', 'F: 0', '0:00', 'mm', 'Abs', 'Set', and a user icon '1'. The main area is a table with two columns: 'Tool (1)' and 'Position'. The 'Tool (1)' column has rows for 'Diameter' (0.000), 'Length' (0.000), 'Units' (mm), 'Type' (Not Defined), 'Spindle Dir' (Off), and 'Spindle Speed' (0). The 'Position' column has rows for 'X' (2.500), 'Y' (0.000), 'Z' (0.000), and 'W' (0.0). At the bottom, there are three buttons: 'Clear', 'Use', and 'Help'.

Tool (1)		Position	
Diameter	0.000	X	2.500
Length	0.000	Y	0.000
Units	mm	Z	0.000
Type	Not Defined	W	0.0
Spindle Dir	Off		
Spindle Speed	0		

- ▶ Enter the **Diameter** of the tool
- ▶ Select a **Spindle Dir** direction
 - **Forward**
 - **Reverse**
- ▶ Enter the **Spindle Speed**
or
- ▶ Calculate using the **rpm** calculator

Calculating the Spindle Speed

To automatically calculate the **Spindle Speed**:

- ▶ Use the **down arrow** key to highlight **Spindle Speed**
- ▶ Press the **rpm** soft key
- ▶ The **rpm** calculator menu is displayed

D:0	Tool (1)		Position	
T:1	Diameter	4.500	X	2.500
F: 0	Length	0.000	Y	0.000
0:00	Units	mm ▶	Z	0.000
mm	Type	Flat End Mill ▶	W	0.0
Abs	Spindle Dir	Forward ▶		
Set	Spindle Speed	140		
1				

Teach
rpm

Help

D:0	rpm		Position	
T:1	Diameter (mm)	4.5000	X	2.500
F: 0	Surface Speed (m/min)	2.0000	Y	0.000
0:00	Spindle Speed (rpm)	141.5	Z	0.000
mm			W	0.0
Abs				
Set				
1				

Units

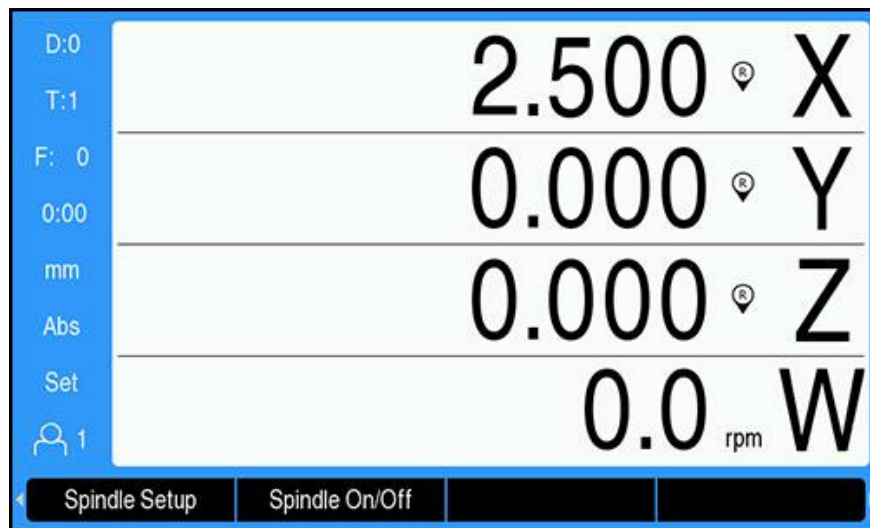
Help

If a **Diameter** was previously entered in the **Tool** menu, this value will display. If the **Diameter** displays a value of 0:

- ▶ Enter the tool **Diameter**
- ▶ Press the **enter** key to save the setting
- ▶ Enter the **Surface Speed**
- ▶ Press the **enter** key to save the setting
- ▶ The **Spindle Speed** is calculated and automatically loads into the tool table when exiting the **rpm** calculator
- ▶ Exit the **rpm** calculator by pressing the **C** key
- ▶ The **Tool** form for the selected tool is displayed
- ▶ Press the **enter** key to return to the **Tool Table** menu

Using the Spindle Speed control

To use the **Spindle Speed** control:



- ▶ Define all tool and spindle parameters in the **Tool Table** menu
- ▶ Highlight the **Tool** to be used in the **Tool Table**
- ▶ Press the **Use** soft key
- ▶ Toggle the **Spindle On/Off** soft key which is displayed on the fourth page of the soft key menu to **On**
- ▶ Adjust the **Spindle Speed** by using the **Speed +** and the **Speed -** soft keys

Using the Spindle Speed control within a program

Spindle Speed control can be used within a program for any program step that has a mill spindle tool defined for that step.

To use **Spindle Speed** control when running a program:

- ▶ Define the **Spindle Dir** and **Spindle Speed** fields for the tool



When the **Spindle Dir** and **Spindle Speed** fields have not been defined, the spindle control soft keys are not available

- ▶ When in program run, use the **left** or **right arrow** keys to display the spindle control soft keys (**Spindle Setup** and **Spindle On/Off**)
- ▶ Adjust the **Spindle Speed** by using the **Speed +** and the **Speed -** soft keys
- ▶ To return to the program soft keys from the spindle control, press the **left** or **right arrow** keys

15.4 Constant surface speed control

i The constant surface speed (**CSS**) control is only available for lathe (turning) systems. If the DRO300 is configured for a milling system, then no **CSS Settings** will be displayed.


i The **CSS Settings** option in the **Installation Setup** menu will only appear if the IOB 610 is detected.

The constant surface speed (**CSS**) mode maintains a constant surface cutting speed on a lathe.

The following functions are available:

- **CSS** mode: The DAC output signal provides constant surface speed by adjusting the spindle speed as the diameter (radius) of the workpiece changes
- Direct entry of spindle speed: The DAC output signal sets the spindle speed based on the value entered via the numeric keypad
- Speed limits: The user may set a safe operating range (minimum and maximum speeds) for spindle speed
- Gear selection: Four different gears can be specified for varying the relation between the actual speed and the DAC output signal

15.4.1 Installation Setup

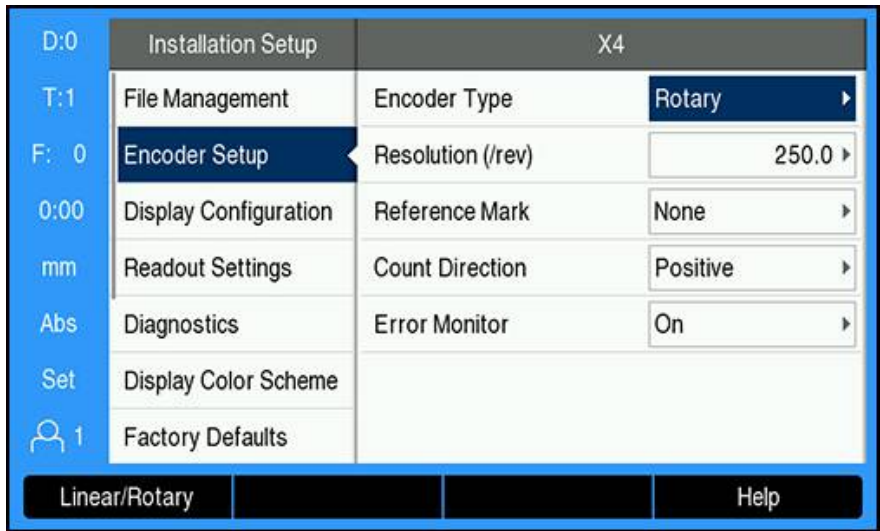


In order to use the **CSS** functionality, the DRO must be set to **Turn**, the last axis must be configured as a **Rotary** encoder, and the **Status** setting must be set to **Enabled**.

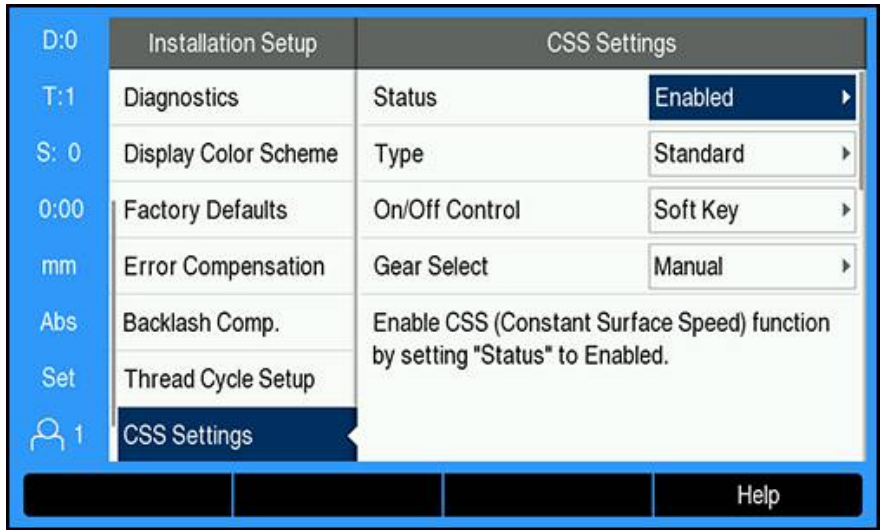
To set the DRO to **Turn Application**, refer to the "Configuring the DRO" section in the manual.

Further information: "Setup", Page 212

To set the **Encoder Type** to **Rotary**:



- ▶ Press the **Setup** soft key
 - ▶ Open in the sequence:
 - **Installation Setup**
 - **Encoder Setup**
 - The last encoder axis
 - **Encoder Type**
 - ▶ Select **Rotary**
 - ▶ Press the **enter** key to save the setting
- To set the **CSS** control to **Enabled**:




- ▶ Return to the **Installation Setup** screen
- ▶ Open in the sequence:
 - **CSS Settings**
 - **Status**
- ▶ Select **Enabled**
- ▶ Press the **enter** key to save the selection
or
- ▶ Press the **C** key to cancel and return to the previous screen without saving changes


15.4.2 CSS control settings

To configure the **CSS Settings**:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence:
 - **Installation Setup**
 - **CSS Settings**
- ▶ Press the **up** or **down arrow** keys to select a setting

 Additional settings that are not initially visible on the **CSS Settings** form must be accessed using the **down arrow** key.

- ▶ Select the **Status** of the **CSS** functionality:
 - **Enabled**
 - **Disabled**
- ▶ Select the **Type** of speed limit setting:
 - **Standard**: allows manual speed limit settings
 - **Limited**: restricts manual speed limit settings
- ▶ Select the **On/Off Control** setting to specify how the **CSS** is controlled:
 - **Soft Key**: controls the **CSS** from the readout soft keys
 - **External Signal**: controls the **CSS** through an external hardware signal
- ▶ Select the **Gear Select** setting to specify how the gear selection is controlled:
 - **Manual**: controls the gear selection through the **CSS/Direct rpm** form
 - **External Switch**: selects the current gear through external switches
- ▶ Enter the **Gear : rpm** which establishes the relationship between the DAC output signal and the spindle speed for each gear

D:0	Installation Setup	CSS Settings	
T:1	Diagnostics	Gear 1: rpm at 0V	0
S: 0	Display Color Scheme	Gear 1: rpm at 10V	9999
0:00	Factory Defaults	Gear 2: rpm at 0V	0
mm	Error Compensation	Gear 2: rpm at 10V	9999
Abs	Backlash Comp.	For the specified gear, enter the spindle speed (rpm) when the CSS output is at 0V or 10V.	
Set	Thread Cycle Setup		
 1	CSS Settings		
		Teach	Help

To determine the **Gear : rpm**:

- ▶ Enter the spindle speed (rpm) for each gear when the **CSS** output is at 0 V and at 10 V
- ▶ If the display configuration of the last axis is set to **Speed (rpm)**, the **rpm** fields in the **CSS Settings** form can be set to the current spindle speed by pressing the **Teach** soft key
- ▶ To set a specific spindle speed, the DAC output S_{Out} uses this linear relationship to determine the corresponding output voltage:

$$V_{Out} = 10 \cdot (S_{Out} - S_0) / (S_{10} - S_0) + V_{Offset}$$
- ▶ Enter the **Voltage Offset** to adjust for any inherent offset in the DAC signal

D:0	Installation Setup	CSS Settings	
T:1	Diagnostics	Gear 3: rpm at 10V	9999
S: 0	Display Color Scheme	Gear 4: rpm at 0V	0
0:00	Factory Defaults	Gear 4: rpm at 10V	9999
mm	Error Compensation	Voltage Offset (V)	0.000
Abs	Backlash Comp.	To eliminate any offset voltage, connect a voltmeter to the CSS output, measure the voltage, and enter the value.	
Set	Thread Cycle Setup		
1	CSS Settings		
		Help	

To determine the **Voltage Offset**:

- ▶ Measure the actual voltage at the DAC output using a voltmeter
- ▶ To adjust for any offset, enter the opposite of the actual voltage in the **Voltage Offset** setting to bring the DAC output back to 0 V. The offset range is limited to -0.2 V to +0.2 V.
- ▶ Press the **enter** key to save the settings and exit the form
or
- ▶ Press the **C** key to exit without saving the changes

15.4.3 CSS operation

i The **CSS/Direct rpm** setting will default to the **Off** position whenever the readout power is cycled and must be reselected in order to activate. No settings are lost when the power is cycled.

i If the **Gear Select** parameter in the **CSS Settings** menu is set to **External Switch**, the **Gear Selection** field in the **CSS/Direct rpm** menu will show the current gear selected based on external inputs and cannot be selected.

The operating parameters for **CSS** operating mode are set in the **CSS/Direct rpm** form.

To configure the **CSS/Direct rpm** control settings:

- ▶ Press the **CSS Setup** soft key to open the **CSS/Direct rpm** form

D:0		CSS/Direct rpm	Position	
T:1	Mode	CSS ▶	X	5.000 Ø
S: 0	Speed (m/min)	0	Z ₀	0.000
0:00	Gear Selection	1 ▶	Z	0.000
mm	Min rpm	0	S	0.0
Abs	Max rpm	9999		
Set	Select the current gear number.			
1				
Help				

- ▶ Select the operating **Mode**:
 - **Off**: when the spindle control is not needed
 - **CSS** (constant surface speed): maintains a constant surface speed that is entered in the **Speed** field. As the diameter of the part changes, the spindle speed will be adjusted.
 - **rpm** (Direct rpm): sets a specific spindle speed by entering the speed in the **Speed** field
- ▶ Enter the **Speed (m/min)** by using the **numeric** keypad when **CSS Mode** is selected
- or
- ▶ Enter the **Speed (rpm)** by using the **numeric** keypad when **rpm Mode** is selected
- ▶ Select the **Gear Selection** from the drop-down menu to manually choose which operating gear to use
- ▶ Enter the **Min rpm** and **Max rpm** by using the **numeric** keypad
- ▶ This establishes the minimum and maximum rpm of the controlled spindle speed and the DAC output will not be set to a speed above or below these limits
- ▶ Press the **enter** key to save settings and exit the form
- or
- ▶ Press the **C** key to exit without saving the changes

15.4.4 DAC output

i The **CSS On/Off** or the **rpm On/Off** soft key which enables **CSS** or **rpm** control will not appear if the operating **Mode** in the **CSS/Direct rpm** menu is set to **Off**.

i If the **On/Off Control** in the **CSS Settings** menu is set to **External Switch**, the **CSS** or **rpm** operation cannot be controlled by soft key. The soft key will show the current state, but pressing it will have no effect.

The DAC output to the spindle inverter drive is an open loop signal. The system does not monitor the actual spindle speed. The output signal is based solely on the inverter's speed input versus the input voltage profile.

Activating the DAC output



After selecting the operating **Mode** and entering its parameters in the **CSS/Direct rpm** menu, the DAC output must be enabled to begin controlling the spindle.

To activate the DAC output:

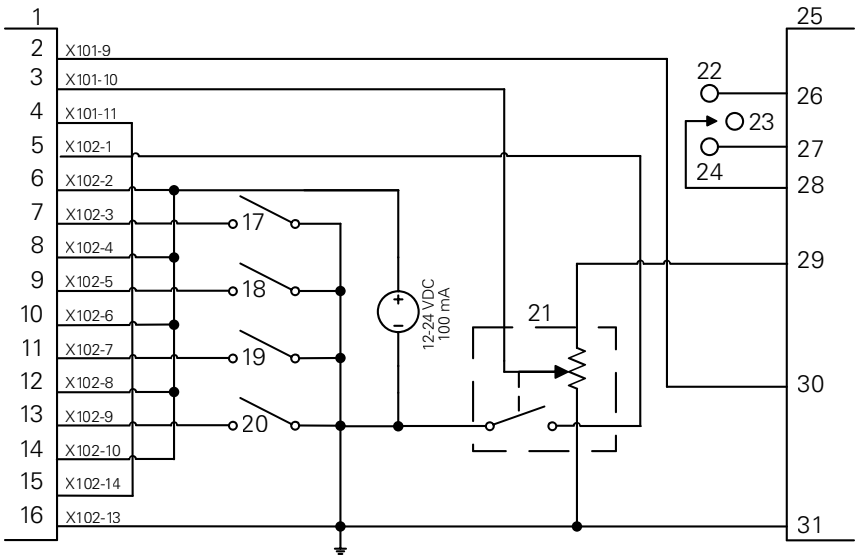
- ▶ Depending on the operating mode selected, press the **rpm On/Off** or the **CSS On/Off** soft key to **On** to enable the DAC output
- ▶ If **CSS** is active, the **CSS** icon appears next to the X-axis display

i If the entered surface speed or rpm cannot be maintained because the speed is outside the range for the current gear or outside the limits from the **CSS/Direct rpm** form, an arrow will appear after the **CSS** icon (**CSS↑** or **CSS↓**). The direction of the arrow indicates whether the speed is at the upper or lower limit.

- ▶ Press the **Speed +** or the **Speed -** to increase or decrease the current surface speed or spindle speed
- ▶ The value is increased or decreased by 5% each time the soft key is pressed

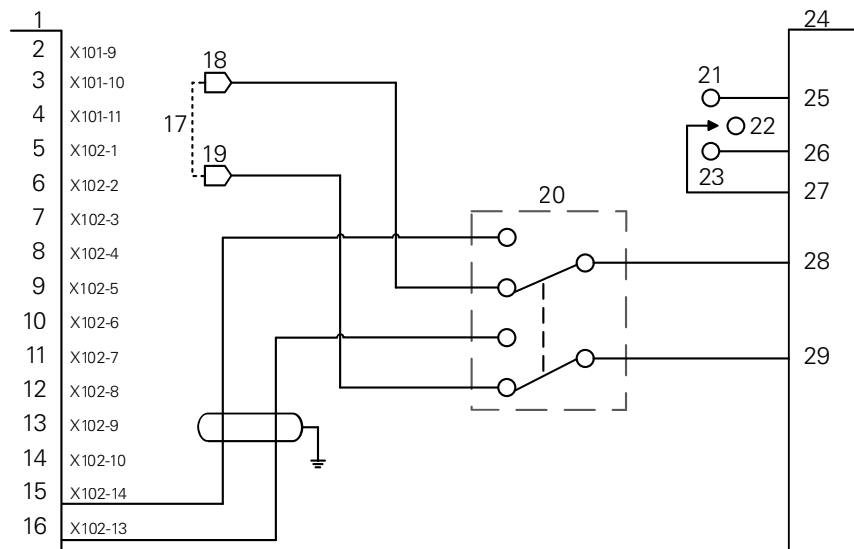
Connecting the IOB to the inverter of a lathe

Turning Application 1 - Automatic CSS/POT Control



Example of gear detection and switching to manual spindle speed control

1 CSS I/O	12 In 4+	23 OFF
2 Out 789	13 In 5-	24 REV
3 Out 7	14 In 5+	25 Inverter
4 Out 8	15 DAC Out	26 Forward
5 In 1-	16 GND	27 Reverse
6 In 1+	17 Gear 1	28 Input + Common
7 In 2-	18 Gear 2	29 Analog Supply
8 In 2+	19 Gear 3	30 Analog Input
9 In 3-	20 Gear 4	31 Analog Common
10 In 3+	21 Manual RPM	
11 In 4-	22 FWD	

Turning Application 2 - Manual CSS/POT Control

Example of switching to manual spindle speed control

1 CSS I/O	12 In 4+	23 REV
2 Out 789	13 In 5-	24 Inverter
3 Out 7	14 In 5+	25 Forward
4 Out 8	15 DAC Out	26 Reverse
5 In 1-	16 GND	27 Input + Common
6 In 1+	17 Machine POT	28 Analog Input
7 In 2-	18 V ref+	29 Analog Common
8 In 2+	19 V ref-	
9 In 3-	20 CSS/POT Selector	
10 In 3+	21 FWD	
11 In 4-	22 OFF	

15.5 Electrical discharge machining

The DRO300 provides simple control of EDM (electrical discharge machining) equipment through the use of three IOB 610 relay signals. The relays are energized or de-energized based on EDM settings and Z axis motion.



Spindle Speed Control and Constant Surface Speed are not supported when **Application** is set to **EDM**.

The Switching Outputs are limited to seven outputs when EDM is selected because three outputs are used for the EDM relays.

15.5.1 Relays

Three relays are used for EDM control:

- Retract
- Dwell
- Position Hold

When power is on to the system:

- The Retract output is energized (do not retract)
- The Dwell relay output is de-energized (do not dwell)
- The Position Hold relay is de-energized (position is not at or below the programmed target depth)

In the event of a power failure to the readout, all outputs revert to a relaxed state.

Retract relay

The Retract relay indicates to the control that the ram has reached the target depth. You can define how far the ram will retract from the target depth. The ram can be raised to a pre-determined **Z-Top Position** or a preset **Retract Distance** from the target depth.

The Retract relay:

- Stops burning and controls retracting the ram a specific distance above the target depth
- or
- Stops burning and controls retracting to the specific Z axis location
- If a reverse fault is detected, the retract relay is activated for 0.1 second to abort the cutting cycle

Dwell relay

The Dwell relay tells the control to hold at the **Target Depth** in order to obtain a better finish or to allow an orbiter to operate. You can set the dwell to a specified **Dwell Time** or with an optional spark detector, it can be set for a **Spark-out Time**.

The Dwell relay:

- Delays retract for a period of time
- or
- Delays retract until spark-out occurs to produce a better finish
- Used for operating auxiliary devices such as an orbiter

Position Hold relay

The Position Hold relay is active only while the Dwell relay is energized (in dwell state). It maintains the relative position of the ram with respect to the **Target Depth**. If the ram position is above the **Target Depth**, the position relay is de-energized (position ok). If the ram position moves below the **Target Depth**, the position relay is energized.

The Position Hold relay:

- Prevents the ram from going below the **Target Depth** during a Dwell cycle

15.5.2 Installation Setup

In order to use **EDM** functionality:

- The **Application** must be set to **EDM**
- The **EDM** axis (Z) must set to **Linear**
- **EDM Setup** must be configured

Selecting EDM mode

D:0	Installation Setup	Readout Settings	
T:1	File Management	Application	EDM ▶
F: 0	Encoder Setup	Number of Axes	3 ▶
0:00	Display Configuration	Position Recall	Off ▶
mm	Readout Settings		
Abs	Diagnostics		
Set	Display Color Scheme		
1	Factory Defaults		
		Help	

To set the DRO to **EDM** mode:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Installation Setup**
 - **Readout Settings**
 - **Application**
- ▶ Select **EDM**
- ▶ Press the **enter** key to confirm the selection
- ▶ Select the appropriate additional **Readout Settings** parameters
Further information: "Readout Settings", Page 83
- ▶ Press the **enter** key to save the **Readout Settings** parameter changes and return to the **Installation Setup** menu
 or
- ▶ Press the **C** key to cancel

Setting the encoder type

D:0	Installation Setup	X3	
T:1	File Management	Encoder Type	Linear ▶
F: 0	Encoder Setup	Resolution (µm)	5.0 ▶
O:00	Display Configuration	Reference Mark	Position Trac ▶
mm	Readout Settings	Count Direction	Positive ▶
Abs	Diagnostics	Error Monitor	On ▶
Set	Display Color Scheme		
1	Factory Defaults		
Linear/Rotary			Help

To set the **EDM Axis Encoder Type** to **Linear**:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence:
 - **Installation Setup**
 - **Encoder Setup**
 - **X3**
 - **Encoder Type**
- ▶ Select **Linear**
- ▶ Press the **enter** key to confirm the selection
- ▶ Select the appropriate additional **Encoder Setup** parameters
- ▶ **Further information:** "Encoder Setup", Page 80
- ▶ Press the **enter** key to save the **Encoder Setup** parameter changes and return to the **Installation Setup** menu
- or
- ▶ Press the **C** key to cancel

15.5.3 EDM Setup

D:0	EDM Setup		Position	
T:1	Target Depth	0.000	X	0.000
F: 0	Retract Distance	Off ▶	Y	0.000
0:00	Z-Top Position	Off ▶	Z	0.000
mm	Reverse Fault	Off ▶		
Abs	Dwell Time	Off ▶		
Set	Enter the target depth of the cut before dwelling or retracting.			
1				
Help				

To configure **EDM** settings:

- ▶ Press the **EDM Setup** soft key
- ▶ Press the **up** or **down arrow** keys to select a setting



Additional settings that are not initially visible on the **EDM Setup** form can be accessed using the **down arrow** key.

- ▶ Enter the **Target Depth** of the cut before dwelling or retracting
- ▶ Enter the **Retract Distance** above **Target Depth** to retract after completing the burn cycle
- ▶ Enter the **Z-Top Position** to retract to after completing the Burn cycle or press the **Teach** soft key
- ▶ Enter the **Reverse Fault** distance, the distance the ram may move above the maximum burn depth
- ▶ Enter the **Dwell Time**, the time to dwell at **Target Depth** before retracting
- ▶ Enter the **Spark-out Time**, the time to dwell at **Target Depth** after sparking stops, and before retracting
- ▶ Press the **enter** key to confirm the selection
- ▶ Press the **enter** key to save the **EDM Setup** parameter changes and exit the form or
- ▶ Press the **C** key to cancel

15.5.4 EDM operation

EDM relay control is active whenever **EDM** is enabled and the system is in the **DRO** or **EDM** display mode.

Setting the Z axis datum

EDM relay operations are disabled while in datum set or preset operations, if **EDM** is enabled. Relay operations are re-enabled when you return to the **DRO** or **EDM** display mode, the Z maximum depth is reset to Z current position, and the system is made ready for the next burn cycle.

The Z axis datum can be set from the **DRO** or **EDM** display mode.

To set the Z datum:

- ▶ Press the **Set/Zero** soft key to select **Set**
- ▶ Press the **Abs/Inc** soft key to select **Abs** display mode
- ▶ Press the Z axis key
- > The **Datum** form is opened with the cursor in the Z axis field.
- ▶ Enter the current position of the ram

or

The Z axis datum can be set by using the first spark to zero the position at the top of the part, if the optional Spark Detector is being used.

- ▶ Press the **Probe** soft key
- ▶ Press the **Edge** soft key
- ▶ Move the ram toward the part
- > The datum is zeroed at the top of the part when a spark is detected.

EDM display mode

The **EDM** display mode shows Z Axis information on three displays:

- Z current absolute position
- Z maximum depth reached
- Z target (retract) depth



- 1 Z current absolute position
- 2 Z maximum depth reached
- 3 Z target (retract) depth

To select **EDM** display mode:

- ▶ Press the **DRO/EDM** soft key to select the **EDM** display mode, when in the **DRO** display mode
- ▶ Press the **DRO/EDM** soft key again to return to the **DRO** display mode

- i** The Z Max position is reset to the current Z absolute position when:
- **EDM** is enabled
 - At the start of a Burn cycle
 - After the Z datum is **Set** or **Preset**
 - After clearing a Z miscount error

Enabling and disabling EDM

Disabled

When **EDM** is disabled:

- All relays are inactive
- The **EDM** icon flashes next to the Z current position in **EDM** display mode

- i** When **EDM** is disabled, no icon is displayed next to the Z axis in **DRO** display mode.

Enabled

When **EDM** is enabled:

- The Retract, Dwell, and Position Hold relays are active
- The **EDM** icon is displayed next to the Z current position in **DRO** or **EDM** display mode

When **EDM** is first enabled, if the axis is moving up, the **EDM** icon is displayed in red to indicate the burn cycle has not started.



1 Axis moving up, burn cycle not started

To enable or disable **EDM**:

- Press the **EDM On/Off** soft key from **DRO** or **EDM** display mode

EDM operation states

The EDM machining cycle involves sequencing through a series of states:

- Ready
- Burn
- Dwell (optional)
- Retract

Ready

The Ready state indicates the system is ready to start a Burn state. The system is placed in the Ready state when **EDM** is enabled or at the end of a Retract state.

While in the Ready state:

- The Retract relay is energized (do not retract)
- The Dwell relay is de-energized (not in dwell state)
- The Position relay is de-energized (not below target)
- Maximum depth tracks the ram's downward motion
- **Reverse Fault** detection is not monitored

Burn

The system transitions from the Ready state to the Burn state when the ram is above the **Target Depth** and has moved downward more than 20 encoder pulses. The maximum Z depth display is reset to the current absolute position at the beginning of the Burn state.

While in the Burn state:

- The Retract relay is energized (do not retract)
- The Dwell relay is de-energized (not in dwell state)
- The Position relay is de-energized (not below target)
- Maximum depth tracks the ram's downward motion
- If enabled, **Reverse Fault** detection is monitored

When **Target Depth** is reached, the system either retracts immediately or dwells at the depth. If either **Dwell Time** or **Spark-out Time** are enabled, the system transitions to the Dwell state. If both dwell parameters are disabled, the system transitions to the Retract state.

Dwell (optional)

The Dwell state is used to delay the Retract state. The delay may be for a fixed amount of time or until spark-out is detected.

While dwelling, the Position relay is used to hold the ram in position. The position is energized when Z is at or below **Target Depth**. It is de-energized when Z is above the target. The position is checked every 20 ms.

While in the Dwell state:

- The Retract relay is energized (do not retract)
- The Dwell relay is energized (in dwell state)
- The Position relay oscillates (de-energized when not at or below target, energized when at or below target) as the ram moves above or below the **Target Depth**
- Maximum depth tracks the ram's downward motion
- If enabled, the **Reverse Fault** detection is monitored

When Dwell timeout or Spark timeout occur:

- The Dwell relay is de-energized (not in dwell state)
- The Position relay is de-energized (not below target)
- After 100ms delay, the system is placed in the Retract state

Retract

The Retract relay is used to stop the Burn state (turn off power to the electrode) and retract the ram out of the part.

While in the Retract state:

- The Retract relay is de-energized (stop burn & retract) for minimum of 100 ms
- The Dwell relay is energized (not in Dwell state)
- The Position relay is de-energized (not below target)
- **Reverse Fault** detection is not monitored
- Retract fault detection is monitored
- Maximum depth tracks the ram's downward motion

When the ram retracts the programmed distance or reaches the **Z-Top Position** or neither retract parameter is enabled:

- The system is placed in the Ready state in preparation for the next Burn state

If a Retract fault is detected:

- The Retract state is aborted
- The system is placed in the Ready state

Fault detection

Reverse fault detection

Reverse Fault detection is monitored during the Burn and Dwell states when enabled in **EDM Setup**. It provides a safety measure to prevent the electrode from creeping up and out of the bath while burning.

If the ram creeps up above the maximum depth by more than the distance specified in the **Reverse Fault** field, a **Reverse Fault** is detected. The Retract relay is de-energized to abort the Burn state and the system is placed in the Ready state.

Retract fault detection

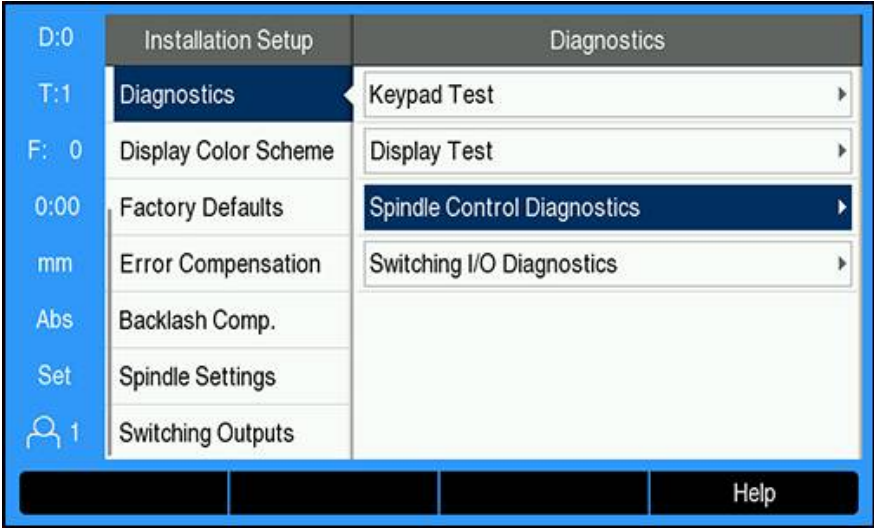
Retract Fault detection is monitored during the Retract state. The fault is generated if the ram stops moving for approximately one second before the location is reached or before the Retract state is completed.

If detected, the Retract state is aborted and the system is placed in the Ready state.

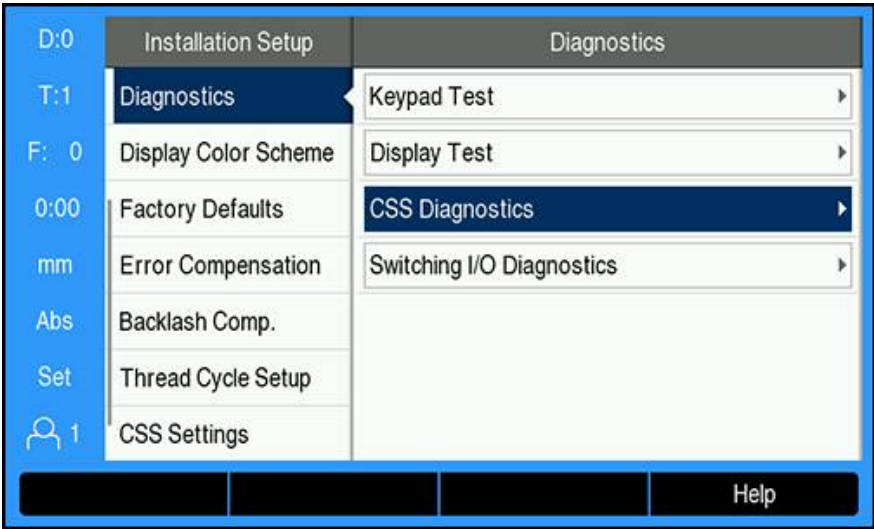
15.6 Diagnostics

When the IOB 610 is connected to the DRO300, the **Diagnostics** menu under **Installation Setup** provides further diagnostic possibilities. The information available varies depending on the configuration of the system, switching I/O, and the spindle or **CSS** functions.

- To access the **Diagnostics** menu:
- ▶ Press the **Setup** soft key
 - ▶ Select **Installation Setup**
 - ▶ Select **Diagnostics**
 - ▶ Press the **enter** key to display the **Diagnostics** menu
 - ▶ When **Spindle Speed** control is activated, the **Diagnostics** menu for spindle control will be displayed

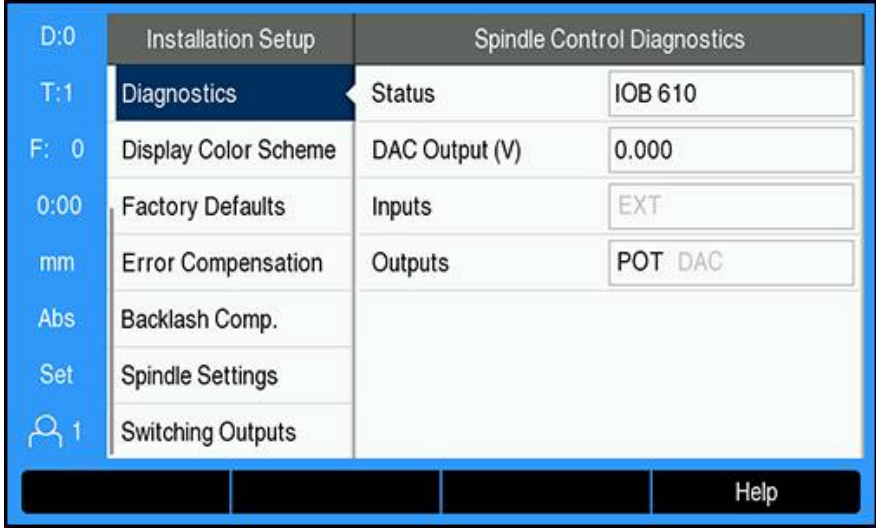


- or
- ▶ When **CSS** is activated, the **Diagnostics** menu for **CSS** will be displayed



Accessing Spindle Control Diagnostics

- ▶ Select **Spindle Control Diagnostics** in the **Diagnostics** menu
- ▶ Press the **enter** key to display **Spindle Control Diagnostics**:

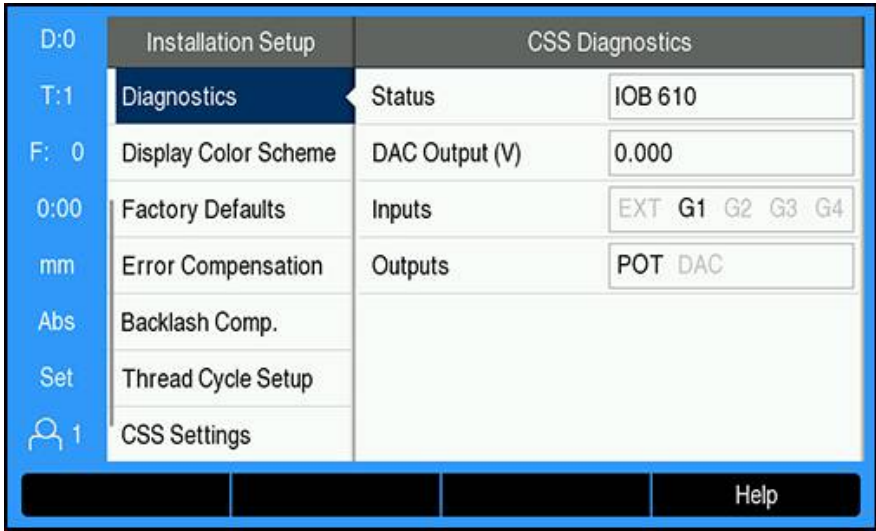


- **Status:** shows the state of the bus communication between the DRO and the IOB. If the field shows **Not Present** there is no communication with the IOB.
- **DAC Output (V):** shows the current value of the transmitted voltage. The value is between - 10 V and + 10 V at connector X101, pin 11.
- **Inputs:** shows the current state of the inputs
- **Outputs:** shows the current state of the relay outputs

i All currently active input and output relays are shown in black and currently inactive are shown in gray.

Accessing CSS Diagnostics

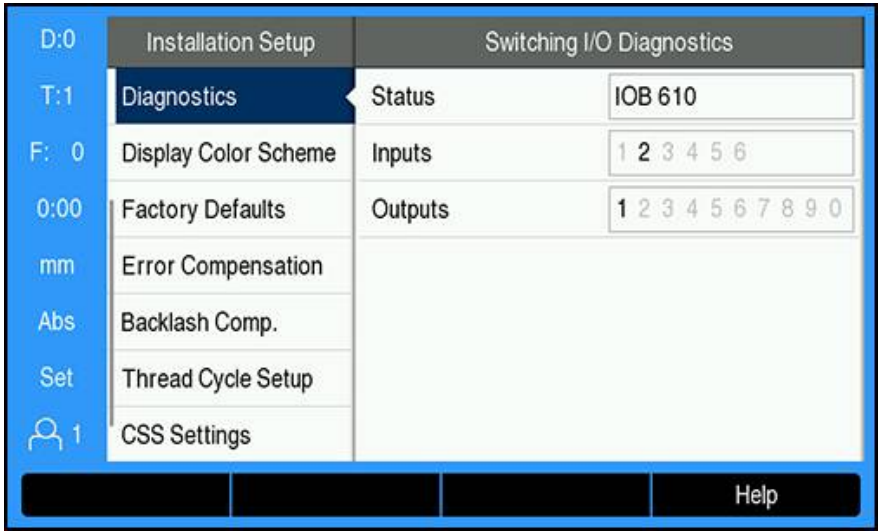
- ▶ Select **CSS Diagnostics** in the **Diagnostics** menu
- ▶ Press the **enter** key to display **CSS Diagnostics**:



- **Status:** shows the state of the bus communication between the DRO and the IOB. If the field shows **Not Present** there is no communication with the IOB.
- **DAC Output (V):** shows the current value of the transmitted voltage. The value is between - 10 V and + 10 V at connector X101, pin 11.
- **Inputs:** shows the current state of the inputs
- **Outputs:** shows the current state of the relay outputs

Accessing Switching I/O Diagnostics

- ▶ Select **Switching I/O Diagnostics** in the **Diagnostics** menu
- ▶ Press the **enter** key to display **Switching I/O Diagnostics**:



- **Status:** shows the state of the bus communication between the position display unit and the IOB 610. If the field shows **Not Present** there is no communication with the IOB.
- **Inputs:** shows the current state of the inputs
- **Outputs:** shows the current state of the relay outputs


The states of the inputs and relay outputs have the following meanings:

Inputs	Meaning	Connector	Pins
EXT (spindle only)	External switch is active	X102	1, 2
G1	Switch for gear 1 is active	X102	3, 4
G2	Switch for gear 2 is active	X102	5, 6
G3	Switch for gear 3 is active	X102	7, 8
G4	Switch for gear 4 is active	X102	9, 10
EST (Limited mode only)	E-Stop input is active	X102	3, 4
GC (Limited mode only)	Gear change is active	X102	5, 6
SPS (Limited mode only)	Spindle stop is active	X102	7, 8
Outputs	Meaning	Connector	Pin
POT	Potentiometer relay is active	X101	10
DAC	DAC output relay is active	X101	11

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Setting up the IB 2X

16.1 Overview

 This feature is available on DRO300 products only.

The IB 2X external unit provides two additional encoder connections when connected to a compatible digital readout.

16.2 Setup

Connecting to the DRO

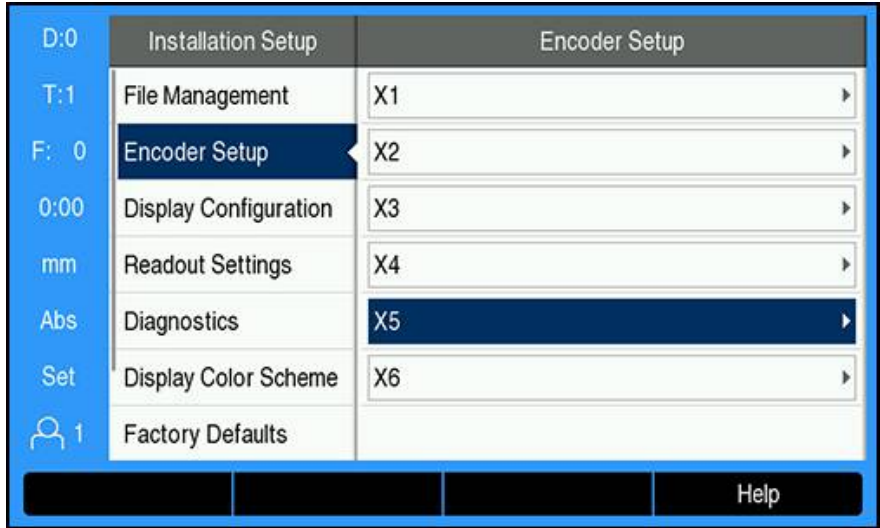
- ▶ Connect the IB 2X to a DRO300 product
 - > The DRO will automatically recognize when the IB 2X is connected
- Further information:** "Connecting an accessory", Page 43

Configuring the DRO

Encoders connected to the additional connections provided by the IB 2X need to be set up in the following menus:

- Encoder Setup
- Display Configuration
- DRO View Settings

Encoder Setup



 The two additional encoder connections provided by the IB 2X will display as **X5** and **X6** in the **Encoder Setup** menu regardless of how many encoder connections are available on the DRO.

The two additional encoder connections are displayed in the **Encoder Setup** menu.

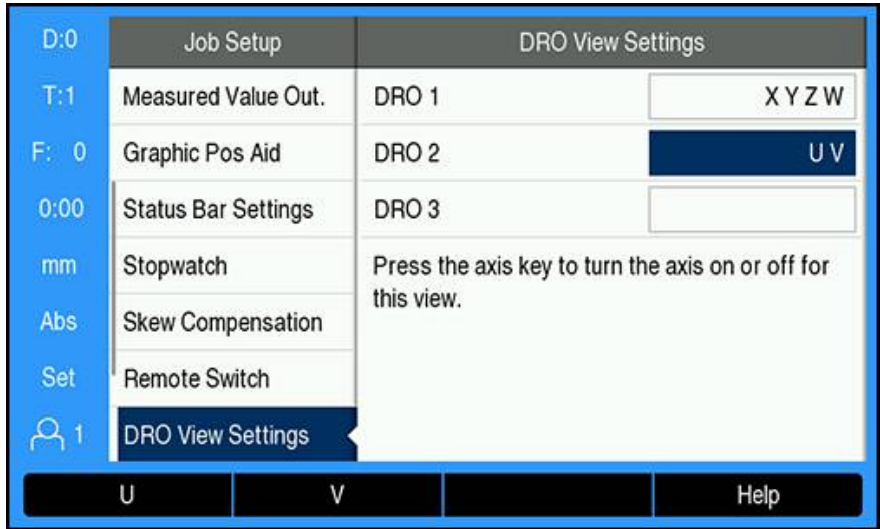
Further information: "Encoder Setup", Page 80

Display Configuration

D:0	Installation Setup	Display Configuration
T:1	File Management	Display 1 ▶
F: 0	Encoder Setup	Display 2 ▶
0:00	Display Configuration	Display 3 ▶
mm	Readout Settings	Display 4 ▶
Abs	Diagnostics	Display 5 ▶
Set	Display Color Scheme	Display 6 ▶
1	Factory Defaults	
		Help

Two additional displays are available in the **Display Configuration** menu.
Further information: "Display Configuration", Page 82

DRO View Settings



i The maximum number of axes able to be shown on a single DRO View is limited to the **Number of Axes** selected in the **Readout Settings** menu.
Further information: "Readout Settings", Page 83

To add an IB 2X connected encoder to a DRO View:

- ▶ Press the **Setup** soft key
- ▶ Open in the sequence
 - **Job Setup**
 - **DRO View Settings**
- ▶ Highlight the **DRO** view field you would like to configure
 - **DRO 1**
 - **DRO 2**
 - **DRO 3**
- ▶ Press the soft key associated with the **Label** for the axis you want to add to the selected view. If a soft key is pressed for an axis that is already included, the axis will be removed.
- ▶ Repeat the last two steps for all views you would like to configure
- ▶ Press the **enter** key to save the **DRO View Settings** parameter changes and return to the **Job Setup** menu
- or
- ▶ Press the **C** key to cancel

Further information: "DRO View Settings", Page 102

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Reference tables

17.1 Drill sizes to decimal inches

Size	Inches
1.00 mm	0.0394
60	0.0400
59	0.0410
1.05 mm	0.0413
58	0.0420
57	0.0430
1.10 mm	0.0433
1.15 mm	0.0453
56	0.0465
3/64	0.0469
1.20 mm	0.0472
1.25 mm	0.0492
1.30 mm	0.0512
55	0.0520
1.35 mm	0.0531
54	0.0550
1.40 mm	0.0551
1.45 mm	0.0571
1.50 mm	0.0591
53	0.0595
1.55 mm	0.0610
1/16	0.0625
1.60 mm	0.0630
52	0.0635
1.65 mm	0.0650
1.70 mm	0.0669
51	0.0670
1.75 mm	0.0689
50	0.0700
1.80 mm	0.0728
49	0.0730
1.90 mm	0.0748
48	0.0760
1.95 mm	0.0768
5/64	0.0781
47	0.0785
2.00 mm	0.0787

Size	Inches
2.05 mm	0.0807
46	0.0810
45	0.0820
2.40 mm	0.0827
2.15 mm	0.0846
44	0.0860
2.20 mm	0.0866
2.25 mm	0.0886
43	0.0890
2.30 mm	0.0906
2.35 mm	0.0925
42	0.0935
3/32	0.0938
2.40 mm	0.0945
41	0.0960
2.45 mm	0.0965
40	0.0980
2.50 mm	0.0984
39	0.0995
38	0.1015
2.60 mm	0.1024
37	0.1040
2.70 mm	0.1063
36	0.1065
2.75 mm	0.1083
7/64	0.1094
35	0.1100
2.80 mm	0.1102
34	0.1110
33	0.1130
2.90 mm	0.1142
32	0.1160
3.00 mm	0.1181
31	0.1200
3.10 mm	0.1220
1/8	0.1250
3.20 mm	0.1260
3.25 mm	0.1280
30	0.1285

Size	Inches
3.30 mm	0.1299
3.40 mm	0.1339
29	0.1360
3.50 mm	0.1378
28	0.1405
9/64	0.1406
3.60 mm	0.1417
27	0.1440
3.70 mm	0.1457
26	0.1470
3.75 mm	0.1476
25	0.1495
3.80 mm	0.1495
24	0.1520
3.90 mm	0.1535
23	0.1540
5/32	0.1562
22	0.1570
4.00 mm	0.1575
21	0.1590
20	0.1610
4.10 mm	0.1614
4.20 mm	0.1654
19	0.1660
4.25 mm	0.1673
4.30 mm	0.1693
18	0.1695
44/64	0.1719
17	0.1730
4.40 mm	0.1732
16	0.1770
4.50 mm	0.1772
15	0.1800
4.60 mm	0.1811
14	0.1820
13	0.1850
4.70 mm	0.1850
4.75 mm	0.1870
3/16	0.1875

Size	Inches
4.80 mm	0.1890
12	0.1890
11	0.1910
4.90 mm	0.1929
10	0.1935
9	0.1960
5.00 mm	0.1969
8	0.1990
5.10 mm	0.2008
7	0.2010
13/64	0.2031
6	0.2040
5.20 mm	0.2047
5	0.2055
5.25 mm	0.2067
5.30 mm	0.2087
4	0.2090
5.40 mm	0.2126
3	0.2130
5.50 mm	0.2165
7/32	0.2188
5.60 mm	0.2205
2	0.2211
5.70 mm	0.2244
5.75 mm	0.2264
1	0.2280
5.80 mm	0.2283
5.90 mm	0.2323
A	0.2340
15/64	0.2344
6.00 mm	0.2362
B	0.2380
6.10 mm	0.2402
C	0.2420
6.20 mm	0.2441
D	0.2460
6.25 mm	0.2461
6.30 mm	0.2480
E	0.2500

Size	Inches
1/4	0.2500
6.40 mm	0.2520
6.50 mm	0.2559
F	0.2570
6.60 mm	0.2598
G	0.2610
6.70 mm	0.2638
17/64	0.2656
6.75 mm	0.2657
H	0.2660
6.80 mm	0.2677
6.90 mm	0.2717
I	0.2720
7.00 mm	0.2756
J	0.2770
7.10 mm	0.2795
K	0.2810
9/32	0.2812
7.20 mm	0.2835
7.25 mm	0.2854
7.30 mm	0.2874
L	0.2900
7.40 mm	0.2913
M	0.2950
7.50 mm	0.2953
19/64	0.2969
7.60 mm	0.2992
N	0.3020
7.70 mm	0.3031
7.75 mm	0.3051
7.80 mm	0.3071
7.90 mm	0.3110
5/16	0.3125
8.00 mm	0.3150
O	0.3160
8.10 mm	0.3189
8.20 mm	0.3228
P	0.3230
8.25 mm	0.3248

Size	Inches
8.30 mm	0.3268
21/64	0.3281
8.40 mm	0.3307
Q	0.3320
8.50 mm	0.3346
8.60 mm	0.3386
R	0.3390
8.70 mm	0.3425
11/32	0.3438
8.75 mm	0.3445
8.80 mm	0.3465
S	0.3480
8.90 mm	0.3504
9.00 mm	0.3546
T	0.3580
9.10 mm	0.3583
23/64	0.3594
9.20 mm	0.3622
9.25 mm	0.3642
9.30 mm	0.3661
U	0.3680
9.40 mm	0.3740
9.50 mm	0.3740
3/8	0.3750
V	0.3770
9.60 mm	0.3780
9.70 mm	0.3819
9.75 mm	0.3839
9.80 mm	0.3858
W	0.3860
9.90 mm	0.3898
25/64	0.3906
10.00 mm	0.3937
X	0.3970
Y	0.4040
13/32	0.4062
Z	0.4130
10.50 mm	0.4134
27/64	0.4219

Size	Inches
11.00 mm	0.4331
7/16	0.4375
11.50 mm	0.4528
29/64	0.4531
15/32	0.4688
12.00 mm	0.4724
31/64	0.4844
12.50 mm	0.4921
1/2	0.5000
13.00 mm	0.5118
33/64	0.5156
17/32	0.5312
13.50 mm	0.5315
35/64	0.5469
14.00 mm	0.5512
9/16	0.5625
14.50 mm	0.5709
37/64	0.5781
15.00 mm	0.5906
19/32	0.5938
39/64	0.6094
15.50 mm	0.6102
5/8	0.6250
16.00 mm	0.6299
41/64	0.6406
16.50 mm	0.6496
21/32	0.6562
17.00 mm	0.6693
43/64	0.6719
11/16	0.6875
17.50 mm	0.6890
45/64	0.7031
18.00 mm	0.7087
23/32	0.7188
18.50 mm	0.7283
47/64	0.7344
19.00 mm	0.7480
3/4	0.7500
49/64	0.7656

Size	Inches
19.50 mm	0.7677
25/32	0.7812
20.00 mm	0.7874
51/64	0.7969
20.50 mm	0.8071
13/16	0.8125
21.00 mm	0.8268
27/32	0.8438
21.50 mm	0.8465
55/64	0.8594
22.00 mm	0.8661
7/8	0.8750
22.50 mm	0.8858
57/64	0.8906
23.00 mm	0.9055
29/32	0.9062
59/64	0.9219
23.50 mm	0.9252
15/16	0.9375
24.00 mm	0.9449
61/64	0.9531
24.50 mm	0.9646
31/32	0.9688
25.00 mm	0.9843
63/64	0.9844
1	1.0000

17.2 English tap drill sizes

Tap	Drill
2-56	50
2-64	50
4-40	43
4-48	42
6-32	36
6-40	33
8-32	29
8-36	29
10-24	26
10-32	21
1/4-20	7
1/4-28	3
5/16-18	F
5/16-24	I
3/8-16	5/16
3/8-24	Q
1/2-13	27/64
1/2-20	29/64
5/8-11	17/32
5/8-18	37/64
3/4-10	21/32
3/4-16	11/16
1-8	7/8
1-12	59/64

17.3 Metric tap drill sizes

Metric tap	Drill mm	~Drill inches
m1.5	1.25	-
m2	1.60	52
m3	2.50	40
m4	3.30	30
m5	4.20	19
m6	5.00	9
m8	6.70	17/64
m10	8.50	Q
m12	10.20	Y
m16	14.00	35/64
m20	17.50	11/16
m24	21.00	53/64

17.4 English recommended surface speeds

HSS

Material	BHN	ft/min
cast iron		
soft	120-220	100 - 80
medium	190-220	80 - 60
hard	220-260	60 - 30
crs & hrs*	100-275	110 - 65
soft alloy	125-225	100 - 90
hard alloy	225-425	100 - 20
cast stl	125-300	95 - 60
aluminum		800 - 500
brass		500 - 300
bronze		140 - 80
magnesium		-

*most low & medium carbon

Carbide

Material	BHN	ft/min
cast iron		
soft	120-220	400 - 360
medium	190-220	380 - 240
hard	220-260	240 - 120
crs & hrs*	100-275	440 - 260
soft alloy	125-225	400 - 360
hard alloy	225-425	400 - 80
cast stl	125-300	380 - 240
aluminum		1800 - 1000
brass		1000 - 600
bronze		275 - 180
magnesium		3000 - 500

*most low & medium carbon

17.5 Metric recommended surface speeds

HSS

Material	BHN	m/min
cast iron		
soft	120-220	30 - 25
medium	190-220	25 - 20
hard	220-260	20 - 10
crs & hrs*	100-275	35 - 20
soft alloy	125-225	30 - 28
hard alloy	225-425	30 - 6
cast stl	125-300	29 - 18
aluminum		240 - 150
brass		150 - 90
bronze		40 - 25
magnesium		-

*most low & medium carbon

Carbide

Material	BHN	m/min
cast iron		
soft	120-220	120 - 110
medium	190-220	115 - 70
hard	220-260	70 - 40
crs & hrs*	100-275	135 - 80
soft alloy	125-225	120 - 110
hard alloy	225-425	120 - 25
cast stl	125-300	115 - 70
aluminum		545 - 300
brass		300 - 180
bronze		80 - 55
magnesium		910 - 150

*most low & medium carbon

18

Settings

18.1 Overview

This chapter describes the settings options and the associated parameters for the product.

The basic settings options and parameters for commissioning are outlined in the respective chapter:

Further information: "Commissioning", Page 69

Function	Description
Job Setup	Set the individual job properties
Installation Setup	Set the installation setup properties

Activation

- Press the **Setup** soft key

18.2 Factory default settings

If individual settings that were changed during commissioning need to be reset to the default setting, you can look up the default for each adjustment parameter in this chapter.

If all settings need to be reset, you can restore the product to the default settings.

18.3 Job Setup

18.3.1 Units

Units settings are used to set the working units of measure for linear and angular dimensions.

Parameter	Explanation
Linear	The unit of measure used for linear measurements <ul style="list-style-type: none"> ■ inch or mm ■ Default setting: mm
Angular	The unit of measure used for angular measurements <ul style="list-style-type: none"> ■ Decimal Degrees, Radians, DMS ■ Default setting: Decimal Degrees
Angle Display	This feature is available on DRO203Q products only. The format used to display degrees in the metrology application. <ul style="list-style-type: none"> ■ -360° ... +360°, 0° ... 360°, -180° ... +180° ■ Default setting: 0° ... 360°
Display Mode	This feature is available on DRO203Q products only. The coordinate system used in the metrology application. <ul style="list-style-type: none"> ■ Cartesian, Polar ■ Default setting: Cartesian

18.3.2 Measure



This feature is available on DRO203Q products only.

Measure settings are used to set the parameters for measuring part features.

Parameter	Explanation
Annotation	The annotation type used to measure features <ul style="list-style-type: none"> ■ Fixed, Free ■ Default setting: Fixed
Required for Point	The number of data points required to measure a point <ul style="list-style-type: none"> ■ 1 or 2 ■ Default setting: 1
Required for Line	The number of data points required to measure a line <ul style="list-style-type: none"> ■ 2 - 30 ■ Default setting: 2
Required for Circle	The number of data points required to measure a circle <ul style="list-style-type: none"> ■ 3 - 30 ■ Default setting: 3
Distances	Select how measured distances are displayed <ul style="list-style-type: none"> ■ Signed or Abs ■ Default setting: Signed

18.3.3 Scale Factor

Scale Factor is used to scale a part up or down.

Parameter	Explanation
Any assigned display label ex. X , Y , or Z	<ul style="list-style-type: none"> ■ Off or On ■ Default setting: Off

18.3.4 Edge Finder

Edge Finder settings are used set the **Diameter**, **Length Offset**, and the working unit of measure for the connected **Edge Finder**. Available on DRO300 products only.

Parameter	Explanation
Diameter	Set the Edge Finder Diameter
Length Offset	Set the Edge Finder Length Offset
Units	The unit of measure used for the Diameter and Length Offset settings <ul style="list-style-type: none"> ■ Settings: inch or mm ■ Default setting: mm

18.3.5 Diameter Axes

Diameter Axes settings are used to set which display positions can be displayed as diameter values.

Parameter	Explanation
Any assigned display label ex. X , Y , or Z	<ul style="list-style-type: none"> ■ Off or On ■ Default setting: Off

18.3.6 Measured value out.

The **Measured value out.** setting is used to enable or disable the output of measurement data when a probe operation is complete. Available on DRO300 products only.

Parameter	Explanation
Data Output Probing	<ul style="list-style-type: none"> ■ Off or On ■ Default setting: Off

18.3.7 Graphic Pos Aid

Graphic Pos Aid settings are used to turn the graphic positioning display on or off, and set it's range.

Parameter	Explanation
Any assigned display label ex. X , Y , or Z	Turn the graphic positioning display on or off <ul style="list-style-type: none"> ■ Off, On, or enter a range ■ Default range setting: 5.000 mm

18.3.8 Status Bar Settings

Status Bar Settings are used to select which features are displayed in the Status Bar.

Parameter	Explanation
Datum	<ul style="list-style-type: none"> ■ Off or On ■ Default setting: On
Tool	<ul style="list-style-type: none"> ■ Off or On ■ Default setting: On
Feed Rate	Displayed in inch/min or mm/min depending on the selected unit of measure. <ul style="list-style-type: none"> ■ Off or On ■ Default setting: On
Stop Watch	<ul style="list-style-type: none"> ■ Off or On ■ Default setting: On
Current User	<ul style="list-style-type: none"> ■ Off or On ■ Default setting: On

18.3.9 Stopwatch

Stopwatch settings are used to operate the **Stopwatch**.

Parameter	Explanation
Status	Displays the current state <ul style="list-style-type: none"> ■ Settings: Stopped or Running ■ Default setting: Stopped
Elapsed Time	Displays the elapsed time that the stopwatch has been running <ul style="list-style-type: none"> ■ Default setting: 00:00:00

18.3.10 Skew Compensation (milling applications only)

Skew Compensation settings are used enable and set a skew angle for a workpiece. Available on DRO300 products only.

Parameter	Explanation
Status	Enable or disable the Skew Compensation feature <ul style="list-style-type: none"> ■ Off or On ■ Default setting: Off
Angle	Set the skew Angle if known or use the Teach function.

18.3.11 Remote Switch

The **Remote Switch** settings are used to set the functions that will be performed when the **Remote Switch** is closed. Available on DRO300 products only.

Parameter	Explanation
Data Output	Enable or disable the output of the current position to the USB mass storage device <ul style="list-style-type: none"> ■ Off or On ■ Default setting: Off
Zero	Enable or disable zeroing of axis display positions <ul style="list-style-type: none"> ■ Settings: Any assigned axis label. More than one axis can be selected. ■ Default setting: none
Next	Enable or disable moving to the next hole in a hole pattern, or next step in a program <ul style="list-style-type: none"> ■ Off or On ■ Default setting: Off

18.3.12 DRO View Settings

DRO View Settings are used to set the axes that are displayed in each of the three DRO views. Available on DRO300 products only.

Parameter	Explanation
DRO 1	<ul style="list-style-type: none"> Settings: Any assigned axis label. More than one axis can be selected. Default setting: Varies based on number of axes
DRO 2, DRO 3	<ul style="list-style-type: none"> Settings: Any assigned axis label. More than one axis can be selected. Default setting: none

18.3.13 Display Settings

Display Settings are used to adjust the appearance of the display.

Parameter	Explanation
Brightness	Set the brightness of the display <ul style="list-style-type: none"> Setting range: 10 % ... 100 % Default setting: 90 %
Display Saver (min)	Set how long the display can remain inactive, in minutes, before the display saver turns on <ul style="list-style-type: none"> Settings: Off, 10, 30 Default setting: 30
Color Mode	Set the color mode for varying ambient lighting conditions <ul style="list-style-type: none"> Settings: Night or Day Default setting: Day
Axes Displays	Set how the axis that is in motion is displayed <ul style="list-style-type: none"> Off Dynamic Zoom: The axis currently in motion is magnified on the display Highlight: The axis currently in motion is highlighted on the display. All other axes are grayed out. Default setting: Off
Zoom Timeout (sec)	Enter the time, in seconds, Dynamic Zoom or Highlight stays active after axis movement stops <ul style="list-style-type: none"> Setting range: 1 ... 10 Default value: 1

18.3.14 Print



This feature is available on DRO203Q products only.

Print settings are used to set the parameters for formatting data for output via USB to a mass storage device or PC.

Parameter	Explanation
Print Label	Enable or disable including descriptive labels with printed data <ul style="list-style-type: none">■ Yes, No■ Default setting: Yes
Print Units	Enable or disable including unit of measure labels with printed data <ul style="list-style-type: none">■ Yes, No■ Default setting: Yes
Post Line	Select if a line feed or a carriage return and line feed is inserted after each line of data <ul style="list-style-type: none">■ LF Only (10), CR / LF (13 10)■ Default setting: LF Only (10)

18.3.15 Vectoring

Vectoring settings are used to enable and configure the **Vectoring** feature.

Parameter	Explanation
Status	Enable or disable the Vectoring feature <ul style="list-style-type: none">■ Off or On■ Default setting: Off
Angle	Set the angle between the longitudinal slide and the top slide <ul style="list-style-type: none">■ Setting range: 0° - 360°

18.3.16 Language

The **Language** setting is used to select the language used for the user interface.

Parameter	Explanation
Language	<ul style="list-style-type: none">■ Settings: multiple languages■ Default setting: English

18.4 Installation Setup

18.4.1 File Management

File Management options are used to import, export, and install files on the product.

Parameter	Explanation
Configuration Parameters	Import or export a Configuration Parameters file ■ Options: Import or Export
Segmented LEC Table	Import or export a Segmented LEC Table file ■ Options: Import or Export
Tool Table	Import or export a Tool Table file ■ Options: Import or Export
Current Program	Import or export the Current Program file. Available on DRO300 products only. ■ Options: Import or Export
Operating Instructions	Install an Operating Instructions file ■ Options: Load
Power-up Screen	Import or export a Power-up Screen file ■ Options: Import or Export
Service File	Clear or export a Service File ■ Options: Clear or Export
Product Software	Install a Product Software file ■ Options: Install

18.4.2 Encoder Setup

Encoder settings are used to configure parameters for each encoder.

Parameter	Explanation
Encoder Type	■ Settings: Linear , Rotary , or Rotary (Linear) ■ Default setting: Linear
Resolution	■ Settings: varies based on Encoder Type
Reference Mark	■ Settings: None , Single , Position Trac , P-Trac (ENC 250) , EverTrack , LMF , Coded / 2000 ■ Default setting: varies based on Encoder Type
Count Direction	■ Settings: Negative or Positive ■ Default setting: Positive
Error Monitor	■ Off or On ■ Default setting: On

18.4.3 Display Configuration

Display settings are used to configure the resolution, labels, and inputs shown on the display.

Parameter	Explanation
Display Resolution	Settings vary based on encoder connected to the product
Label	<ul style="list-style-type: none"> ■ Settings: Off, X, Y, Z, U, V, W, A, B, C, S, T, Q ■ Default Setting: <ul style="list-style-type: none"> ■ Display 1: X ■ Display 2: Y ■ Display 3: Z ■ Display 4: W
Subscript	<ul style="list-style-type: none"> ■ Settings: Off or On ■ Default Setting: Off
Input 1	<ul style="list-style-type: none"> ■ Settings: X1, X2, X3, X4 ■ Default Setting: <ul style="list-style-type: none"> ■ Display 1: X1 ■ Display 2: X2 ■ Display 3: X3 ■ Display 4: X4
Couple Operation	<ul style="list-style-type: none"> ■ Settings: +, -, Off ■ Default Setting: Off
Input 2	<ul style="list-style-type: none"> ■ Settings: Not Defined, X1, X2, X3, X4 ■ Default Setting: Not Defined

18.4.4 Readout Settings

Readout Settings are used to configure the **Application**, **Number of Axes**, and **Position Recall**.

Parameter	Explanation
Application	<ul style="list-style-type: none"> Settings: Mill, Turn, EDM Default Setting: Mill
Number of Axes	<ul style="list-style-type: none"> Settings: 1, 2, 3, 4 Default Setting: 4
Position Recall	<ul style="list-style-type: none"> Settings: Off or On Default Setting: Off

18.4.5 Diagnostics

Diagnostics are used to test the keypad and the display.

Further information: "Diagnostics", Page 84

18.4.6 Display Color Scheme

The **Display Color Scheme** settings are used to select the **Color Mode** of the display and to set whether users can select the **Color Mode**.

Parameter	Explanation
Color Mode	<ul style="list-style-type: none"> Settings: Day, Night, User Selectable Default Setting: User Selectable

18.4.7 Factory Defaults

The **Factory Defaults** option is used to reset **Job Setup** and **Installation Setup** parameters to the default settings.

Parameter	Explanation
Reset Settings	<ul style="list-style-type: none"> Settings: No or Yes Default Setting: No

18.4.8 Error Compensation

Error Compensation provides a way to configure Linear, or Segmented Linear Error Compensation for each encoder.

Parameter	Explanation
X1, X2, X3, X4	Settings: Off, Linear, Segmented, Non-Linear EC (available on DRO203Q products only) Default setting: Off

18.4.9 Backlash compensation

Backlash Comp. is used to activate backlash compensation for rotary encoders.

Parameter	Explanation
X1, X2, X3, X4	<ul style="list-style-type: none"> Settings: Off, On Default setting: Off

18.4.10 Spindle Settings

Spindle Settings settings are used to set the DAC output range and offset voltage for the spindle. Available in the **Mill** application on DRO300 products connected to an IOB 610 only.

Parameter	Explanation
Status	Enable or disable the spindle (rpm) functionality <ul style="list-style-type: none"> Settings: Enabled or Disabled Default setting: Disabled
rpm Source	Select if the speed (rpm) is determined from a rotary encoder or calculated internally <ul style="list-style-type: none"> Settings: Encoder or Calculated Default setting: Encoder
Voltage Offset	Enter a voltage offset value <ul style="list-style-type: none"> Range: -0.200 V ... +0.200 V Default setting: 0.000
Min Voltage (Low)	Enter the minimum spindle output voltage for the low gear <ul style="list-style-type: none"> Default setting: 0
Max Voltage (Low)	Enter the maximum spindle output voltage for the low gear <ul style="list-style-type: none"> Default setting: 10
Min Voltage (High)	Enter the minimum spindle output voltage for the high gear <ul style="list-style-type: none"> Default setting: 0
Max Voltage (High)	Enter the maximum spindle output voltage for the high gear <ul style="list-style-type: none"> Default setting: 10
0V - rpm (Low)	Enter the expected speed (rpm) for the low gear at 0 V <ul style="list-style-type: none"> Default setting: 0
10V - rpm (Low)	Enter the expected speed (rpm) for the low gear at 10 V <ul style="list-style-type: none"> Default setting: 9999
0V - rpm (High)	Enter the expected speed (rpm) for the high gear at 0 V <ul style="list-style-type: none"> Default setting: 0
10V - rpm (High)	Enter the expected speed (rpm) for the high gear at 10 V <ul style="list-style-type: none"> Default setting: 9999
Min Run rpm (Low)	Enter the minimum speed (rpm) allowed while running in the low gear <ul style="list-style-type: none"> Default setting: 0
Max Run rpm (Low)	Enter the maximum speed (rpm) allowed while running in the low gear <ul style="list-style-type: none"> Default setting: 9999

Parameter	Explanation
Min Run rpm (High)	Enter the minimum speed (rpm) allowed while running in the high gear <ul style="list-style-type: none">Default setting: 0
Max Run rpm (High)	Enter the maximum speed (rpm) allowed while running in the high gear <ul style="list-style-type: none">Default setting: 9999

18.4.11 CSS Settings

CSS Settings are used to configure spindle control. Available in the **Turn** application on DRO300 products connected to an IOB 610 only.

Parameter	Explanation
Status	Enable or disable the CSS (Constant Surface Speed) function <ul style="list-style-type: none"> Settings: Enabled or Disabled Default setting: Disabled
Type	Select a manual speed limit settings Type <ul style="list-style-type: none"> Settings: Standard or Limited Default setting: Standard
On/Off Control	Select how the CSS mode is controlled <ul style="list-style-type: none"> Settings: Soft Key or External Signal Default setting: Soft Key
Gear Select	Select how to control gear selection <ul style="list-style-type: none"> Settings: Manual or External Switch Default setting: Manual
Gear 1: rpm at 0V	Enter the spindle speed (rpm) for gear 1 when the output is at 0V <ul style="list-style-type: none"> Default setting: 0
Gear 1: rpm at 10V	Enter the spindle speed (rpm) for gear 1 when the output is at 10V <ul style="list-style-type: none"> Default setting: 9999
Gear 2: rpm at 0V	Enter the spindle speed (rpm) for gear 2 when the output is at 0V <ul style="list-style-type: none"> Default setting: 0
Gear 2: rpm at 10V	Enter the spindle speed (rpm) for gear 2 when the output is at 10V <ul style="list-style-type: none"> Default setting: 9999
Gear 3: rpm at 0V	Enter the spindle speed (rpm) for gear 3 when the output is at 0V <ul style="list-style-type: none"> Default setting: 0
Gear 3: rpm at 10V	Enter the spindle speed (rpm) for gear 3 when the output is at 10V <ul style="list-style-type: none"> Default setting: 9999
Gear 4: rpm at 0V	Enter the spindle speed (rpm) for gear 4 when the output is at 0V <ul style="list-style-type: none"> Default setting: 0
Gear 4: rpm at 10V	Enter the spindle speed (rpm) for gear 4 when the output is at 10V <ul style="list-style-type: none"> Default setting: 9999
Voltage Offset	Enter a voltage offset value <ul style="list-style-type: none"> Range: -0.200 V ... +0.200 V Default setting: 0.000

18.4.12 Switching Outputs

The **Switching Outputs** settings are used to set the axis position conditions for the switching output relays. Available on DRO300 products connected to an IOB 610 only.

Parameter	Explanation
Axis	Select an axis for the output <ul style="list-style-type: none"> ■ Settings: Any assigned axis label ■ Default setting: X
Condition	Select the required Condition for activating the output <ul style="list-style-type: none"> ■ Settings: <, <=, >=, >, or Off ■ Default setting: Off
Switch Point	Enter the Switch Point value and select the position type <ul style="list-style-type: none"> ■ Default Switch Point value: 0.000 ■ Default position type: Abs
Type	Select whether the Condition refers to a Point on the axis or refers to a Range about zero <ul style="list-style-type: none"> ■ Settings: Point or Range ■ Default setting: Point
Relay Output	Select the relay operation that is performed when the Condition is met <ul style="list-style-type: none"> ■ Settings: On or Off ■ Default setting: On
Relay Mode	Select the Relay Mode <ul style="list-style-type: none"> ■ Settings: Continuous or Pulse ■ Default setting: Continuous

19

**Service and
maintenance**

19.1 Overview

This chapter describes the general maintenance work on the product:



This chapter contains a description of maintenance work for the product only.

Further Information: Manufacturer's documentation for the respective peripheral devices

19.2 Cleaning

NOTICE

Cleaning with sharp-edged objects or aggressive cleaning agents

Improper cleaning will cause damage to the product.

- ▶ Never use abrasive or aggressive cleaners, and never use strong detergents or solvents
 - ▶ Do not use sharp-edged objects to remove persistent contamination
-
- ▶ Use only a cloth dampened with water and a mild detergent for cleaning the exterior surfaces
 - ▶ Use a lint-free cloth and a commercially available glass cleaner to clean the screen

19.3 Maintenance schedule

The product is largely maintenance-free.

NOTICE

Operating defective products

Operating defective products may result in serious consequential damage.

- ▶ Do not operate or repair the product if damaged
- ▶ Replace defective products immediately or contact an authorized service agency



The following steps are only to be performed by electrical specialists.

Further information: "Personnel qualification", Page 25

Personnel requirement

Maintenance step	Interval	Corrective action
▶ Check all labels and symbols provided on the product for readability	Annually	▶ Contact an authorized service agency
▶ Inspect electrical connections for damage and check their function	Annually	▶ Replace defective cables. Contact an authorized service agency if required.
▶ Check power cables for faulty insulation and weak points	Annually	▶ Replace power cables according to the specification

19.4 Resuming operation

When operation is resumed, e.g. when the product is reinstalled after repair or when it is remounted, the same measures and personnel requirements apply as for mounting and installing the product.

Further information: "Mounting", Page 33

Further information: "Installation", Page 39

When connecting the peripheral devices (e.g. encoders), the operating company must ensure safe resumption of operation and assign authorized and appropriately qualified personnel to the task.

Further information: "Obligations of the operating company", Page 26

19.5 Resetting to the factory defaults

You can reset the settings of the product to the factory defaults, if required.


- ▶ Press the **Setup** soft key
- ▶ Use the arrow keys to select the sequence
 - **Installation Setup**
 - **Factory Defaults**
 - **Reset Settings**
 - **Yes**
- ▶ Press the **enter** key

20

What to do if...

20.1 Overview

This chapter describes the causes of faults or malfunctions of the product and the appropriate corrective actions.




Make sure that you have read and understood the "Basic Operation" chapter before performing the activities described in this section.
Further information: "Basic operation", Page 55

20.2 Malfunctions

If faults or malfunctions that are not listed in the "Troubleshooting" table below occur during operation, refer to the machine tool builder's documentation or contact an authorized service agency.

20.3 Troubleshooting



The following troubleshooting steps must be performed only by the personnel indicated in the table.
Further information: "Personnel qualification", Page 25

Fault	Cause of fault	Correction of fault	Personnel
Status LED remains dark after switch-on.	There is no supply voltage	► Check the power cable	Electrical specialist
	The product does not function properly	► Contact an authorized service agency	Qualified personnel
The position display does not count the axis position even though the encoder is moving.	Incorrect connection of the encoder	► Correct the connection ► Contact the encoder manufacturer's service agency	Qualified personnel
The position display miscounts the axis position.	Incorrect settings of the encoder	► Check the encoder settings	Qualified personnel
The connected USB mass storage device is not detected.	Defective connection	► Check the correct position of the USB mass storage device in the port	Qualified personnel
	The type or formatting of the USB mass storage device is not supported	► Use another USB mass storage device	Qualified personnel


21

**Removal and
disposal**

21.1 Overview

This chapter provides information about the removal and disposal of the product. This information includes requirements to be complied with in respect of environmental-protection laws.

21.2 Removal



Removal of the product is to be performed only by qualified personnel.
Further information: "Personnel qualification", Page 25

Depending on the connected peripherals, the removal may need to be performed by an electrical specialist.
In addition, the same safety precautions that apply to the mounting and installation of the respective components must be taken.


Removing the product

To remove the product, follow the installation and mounting steps in the reverse order.

Further information: "Installation", Page 39

Further information: "Mounting", Page 33

21.3 Disposal



NOTICE

Incorrect disposal of the product!

Incorrect disposal of the product can cause environmental damage.

- ▶ Do not dispose of electrical waste and electronic components in domestic waste
- ▶ The integrated backup battery must be disposed of separately from the product
- ▶ Forward the product and the backup battery to recycling in accordance with the applicable local disposal regulations

▶ If you have any questions about the disposal of the product, please contact a HEIDENHAIN service agency

22

Specifications

22.1 Product specifications

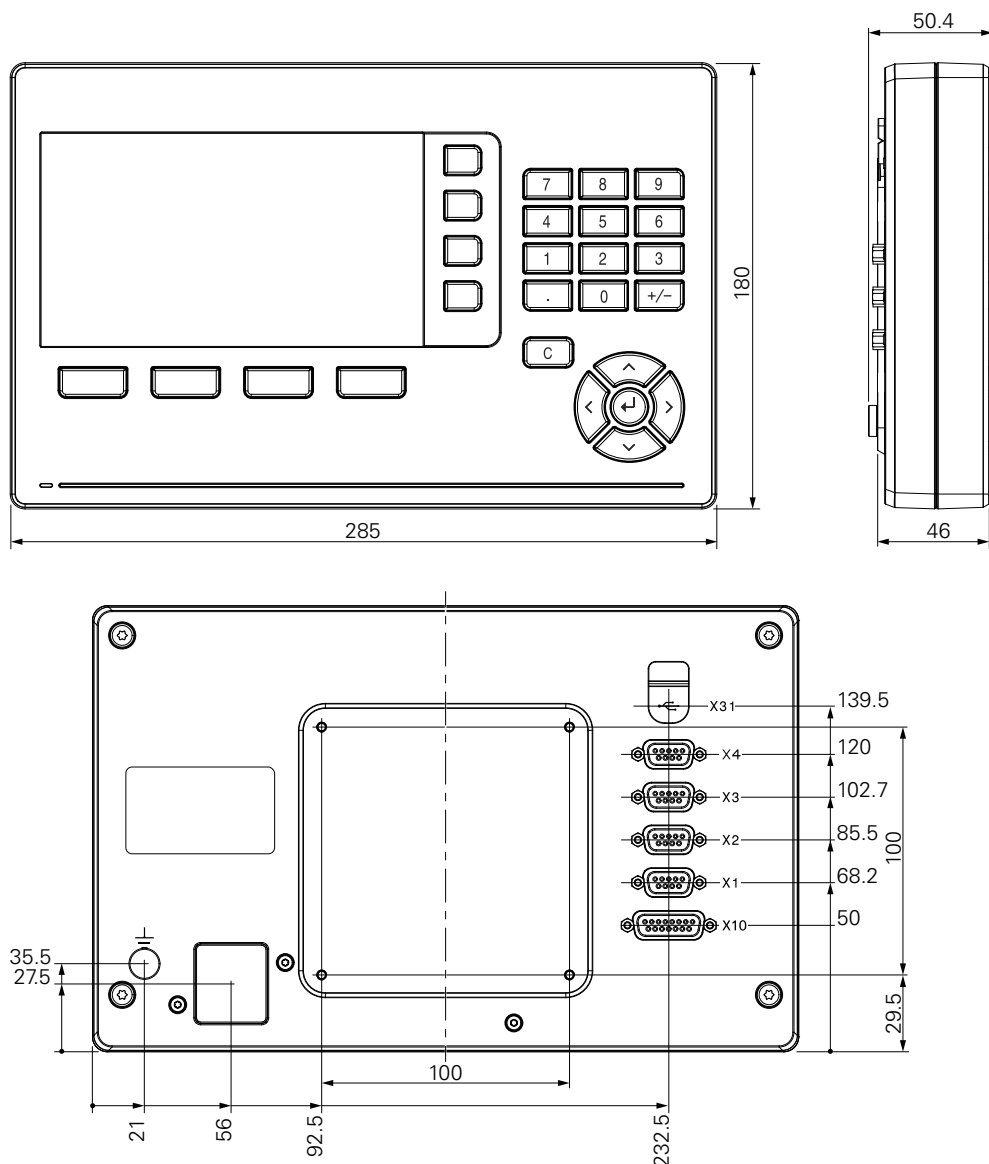
Product	
Housing	Die cast aluminum
Housing dimensions	285 mm x 180 mm x 46 mm
Fastener system, mating dimensions	VESA MIS-D, 100 100 mm x 100 mm
Display	
Visual display unit	<ul style="list-style-type: none"> ■ LCD Widescreen (15:9) color screen 17.8 cm (7") ■ 800 x 480 pixels
User interface	Graphical user interface (GUI) with keypad
Electrical data	
Power supply	<ul style="list-style-type: none"> ■ AC 100 V ... 240 V (± 10 %) ■ 50 Hz ... 60 Hz (± 5 %) ■ Input power max. 30 W
Buffer battery	Lithium battery type CR2032; 3.0 V
Overvoltage category	II
Number of encoder inputs	3 or 4
Encoder interfaces	TTL: Max. current 300 mA max. input frequency 500 kHz
KT 130, IOB 610, IB 2X interface	DC 5 V (± 5 %)
Data interface	USB 2.0 Hi-Speed (Type C), max. current 500 mA
Ambient conditions	
Operating temperature	0 °C ... 45 °C
Storage temperature	-20 °C ... 70 °C
Relative air humidity	10 % ... 80 % r.H., non-condensing
Altitude	≤ 2000 m
General information	
Directives	<ul style="list-style-type: none"> ■ EMC Directive 2014/30/EU ■ Low Voltage Directive 2014/35/EU ■ RoHS Directive 2011/65/EU
Pollution degree	2

General information

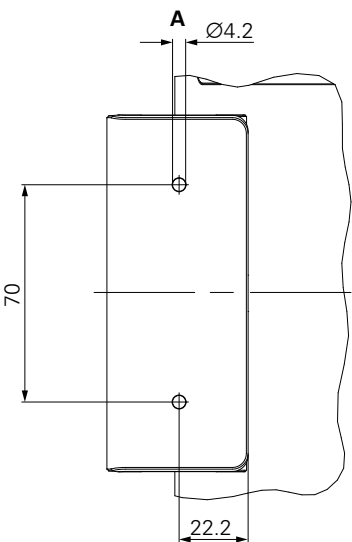
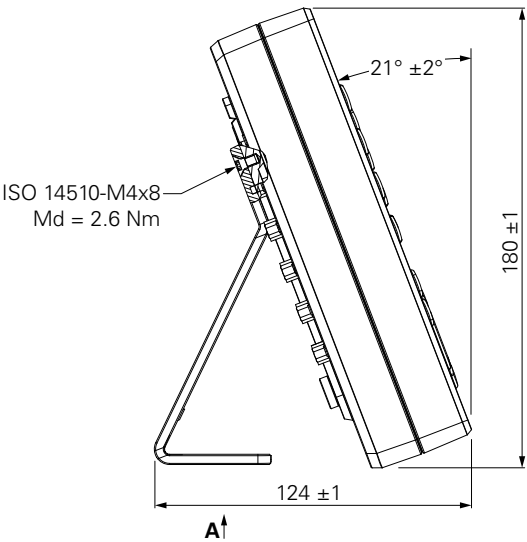
Protection EN 60529	<ul style="list-style-type: none"> ■ Front panel and side panels: IP 54 ■ Rear panel: IP 40
Mass	<ul style="list-style-type: none"> ■ 1.9 kg ■ With Single-Pos stand: 2.0 kg ■ With Multi-Pos holder: 2.3 kg ■ With Mounting frame: 3.3 kg

22.2 Product dimensions and mating dimensions

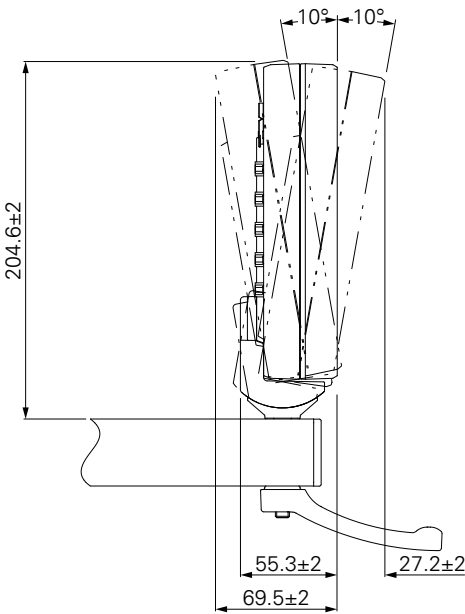
All dimensions in the drawings are in millimeters.



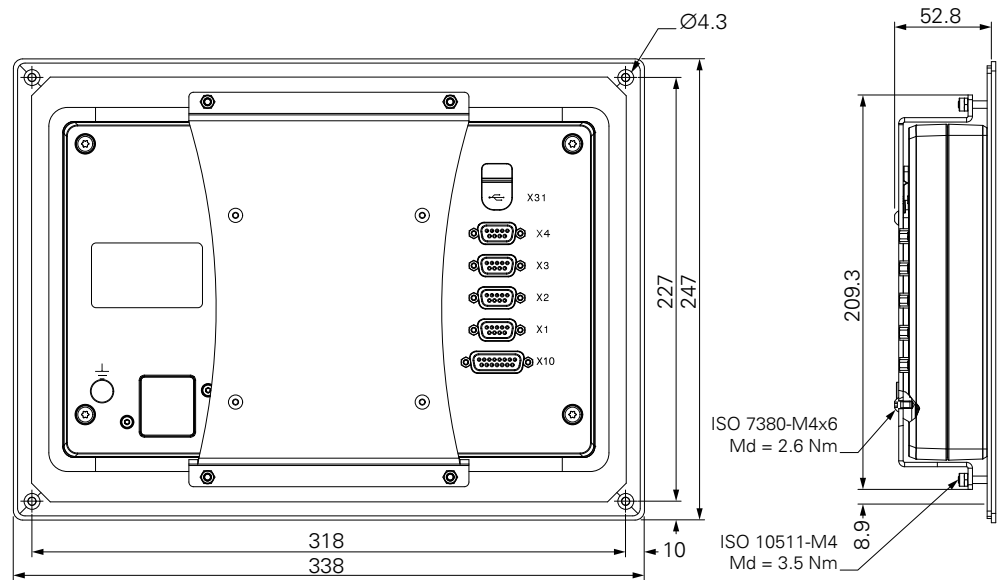
Product dimensions with Single-Pos stand



Product dimensions with Multi-Pos holder



Product dimensions with mounting frame



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