SR-100 SETUP GUIDE

Powering up the mill

1. Turn on the compressed air valve located at the rear of machine
2. Set main power breaker to on position
3. Release "E-stop" button
4. Insert USB memory stick
5. Push "green power" button to turn on mill
6. Push "power up restart" button to home XYZ

Warming up the mill

1. Push "cycle start" button
2. Push "cancel" button
3. Push "cycle start" button to start warmup routine

Setting your part zero

1. Push "second home" located on side of machine
2. Push "hand jog" button
3. Use x and y increment buttons to locate your x and y part zero
4. Push "offset" twice
5. Use jog handle to select g54 to edit x and y coordinates
6. Push "part zero set" twice, once for the x axis and once for the y axis
7. Push "home G28"

Loading and starting your job

1. Push "list program"
2. Navigate using "up" and "down cursor arrows" to highlight "USB device"
3. Push "right cursor arrow" to access files on USB
4. Select your file with extension .nc
5. Push "select program"
6. Push 'setng/graph" twice to enter graphics mode
7. Push "cycle start" to run job in graphics mode
8. When job is complete "M30 found" will be displayed
9. Push "setng/graph" once to exit graphics mode
10. Push "cycle start" to start job

Setting your tool zero

1. Push "hand jog"
2. Jog in X and Y to clean location on table
3. Load appropriate tool into spindle
4. Jog in Z close to table surface
5. Place wax paper under bit
6. Jog in Z to friction fit
7. Push "offset" once (tool geometry screen)
8. Select appropriate tool with cursor
9. Push "Tool offset measure" to zero that tool