



Operation step Suddenly

SDM All clear away


The function is introduced: Eliminate consumer coordinate system
SDM300 Group The plain is interposed, Eliminate the queen, SDMCoordinate
system has to demonstrate value and ABS[™] coordinate system has to
demonstrate value equality.

Handle a step:

- 1、 Press TECH-2 KeyEnter the fundamental parameter → Press 
Choice arrives at “Clear SDM multiunit coordinate” →

Press 

0.000	← X	CLR SDM
0.000	← Y	

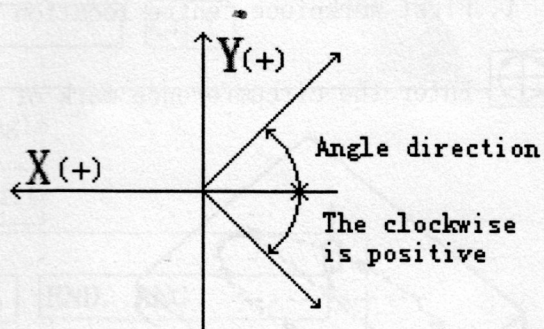
- 2、 When right window display “OVER”, Press  for exit.

0.000	← X	OVER.
0.000	← Y	



Circumference be allotted a hole

Function: TECH-2 The obvious form of number provides the convenient
circumference halving hole function, Person requires operation to import





The circumference radius
The circumference initiation angle

The circumference termination angle
 The halving hole number

TECH-2 English is pointed out

On the circumference the obvious form of number is calculated out just voluntarily, every divides the hole location from the middle , Every hole

location is set up for zero, Person needs operation press  or  , Which

and then the upper hole choosing to the circumference, the machine tool working table is swayed to zero , is the location being a hole's turn.

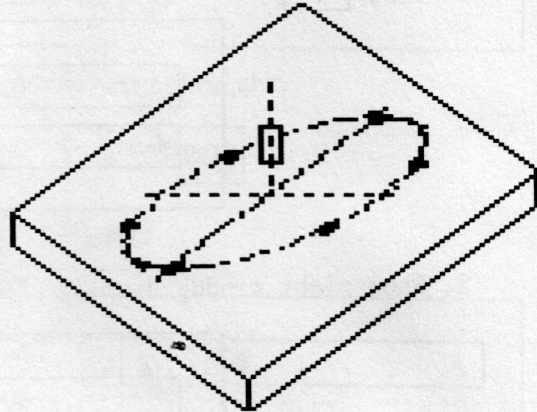
Handle a step

Example: Radius: ——— 30mm

Initiation angle: ——— 30°

End an angle: ——— 318°

Divide the hole number
 from the middle: ——— 6



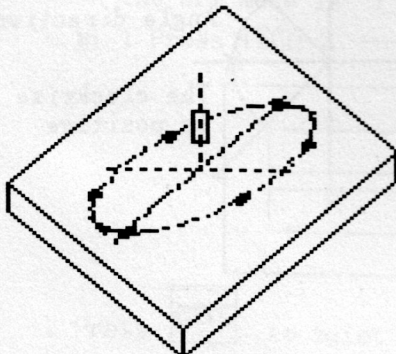
- Remarks:1 The central point location $X=0, Y=0$
 2 The halving hole hole number is that the angle divides till destination angle from starting point along the clockwise sense
 3 Think that the initiation angle is 0 , that the termination angle is 360 points , the input hole number ought to is $(N+1)$

Handle a step:

- 1、 First workpiece centre location is fixed for zero, then press



Enter the circumference mark of hole function



Handle a step

	← X	DIA
10.000	← Y	

2、 Import a radius (R: 30)

Press **3** **0** **ent**

	← X	DIA
10.000	← Y	

In the first place radius interposing

30.000	← X	DIA
	← Y	

3、 Import the initiation angle

Press **3** **0** **ent**

	← X	ST. ANG
45.000	← Y	

In the first place initiation angle interposing

30.000	← X	ST. ANG
	← Y	

4、 Import the termination angle

Press **3** **1** **8** **ent**

	← X	END. ANG
8.000	← Y	

In the first place initiation angle interposing

Handle a step

318.000	← X	END. ANG
	← Y	


5、Import the maximal hole number (Hole number)

Press **6** **ent**


	← X	NO. HOLE
5.000	← Y	

In the first place Maximal hole number interposing

- 12.990	← X	HOLE. . . . 1
- 7.500	← Y	

Enter treating directly, If treating is finished, Press  exit

Remarks:

- 1、Process the queen in entrance, Handle person press  The coordinate the which number holes queen to choosing, the machine tool working table being swayed arriving at is 0.000 Be the location owing a circumference a hole
- 2、Import process middle, YAxis scintillation that can not stay, Press **ent**
That the number displays a form is able to enter next step voluntarily
- 3、If operation person requires that the halfway is temporary remove from "the circumference mark of hole" function, When returning to regular ABS state, X, Y, coordinate show, Press **TAN** Withdraw from temporarily, Press **TAN** Return to circumference mark of hole state.