Operation step  Suddenly

SDM All clear away

The function is introduced: Eliminate consumer coordinate system
SDM300 Group The plain is interposed, Eliminate the queen, SDM Coordinate 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 ent

```
0.000 <-> X  CLR SDM
0.000 <-> Y
```

2. When right window display “OVER”, Press ce 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

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X(+)
```

Angle direction

The clockwise is positive

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 或 , 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
2. Import a radius (R: 30)

Press 3 0 ent

3. Import the initiation angle

Press 3 0 ent

4. Import the termination angle

Press 3 1 8 ent

In the first place radius interposing

In the first place initiation angle interposing

In the first place initiation angle interposing
Handle a step

5. Import the maximal hole number (Hole number)

Press 6 ent

In the first place Maximal hole number interposing

- 12.990 \( \leftrightarrow \) X HOLE...1
- 7.500 \( \leftrightarrow \) Y

Enter treating directly. If treating is finished, Press exit

Remarks:
1. Process the queen in entrance, Handle person press The coordinate 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 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.