



Electronica EL400 Line Hole Function

Congratulations on the purchase of your Electronica EL400 series mill kit. This article addresses how to perform the Line Hole function.

The Line Hole function allows the user to program an equally spaced infinite series of holes along any of the three axis – X, Y or Z. This function is a simpler version of the more advanced Angle Hole function.

In order to indicate the correct direction, the EL400 display assumes you have set your scales up as follows: As you cut from left to right on your workpiece (the mill table slides left) the X axis scale should count positive. As you cut from front to back on your workpiece (the mill table slides forward) the Y axis scale should also count positive. While the function will ultimately work with a non-std setup, the following explanations might appear contradictory if the assumed scale directions are not adhered to.

DRO PROS also recommends changing the Zero Beep settings. See the "EL400 Zero Beep" library article, which allows you to reduce the sensitivity of the display beeping as you approach each point.

Line Hole:

1. To access the Line Hole function, push the function or "fn" button. It's the very right most button on the very bottom row. Note that "fn" should light on the bottom of the display window in red.
2. Push the #6 key until the x axis display window reads "LinEAR".
3. Push the "ent" key. The x axis display window reads "SELECT".
4. Push whichever axis button you plan on aligning your holes (ie "X", "Y", or "Z") **twice**.
5. On the keypad, enter the distance between holes, followed by the "ent" key **twice**.

The axis display windows will have an extra leading decimal on the far left of the display window, which is a visual reminder you are in a function mode. The "distance to go" to hole position 1 is displayed on the associated window (X, Y, or Z as selected in step 4 above).

- To proceed to hole position 1, move your mill such that the associated axis window "zeroes out".
- To sequentially advance to the next hole position, push the #6 key.
- To check which hole the display is currently indicating, push the #8 key. To return to the normal screen, push the #8 key a second time.

6. To exit the Line Hole function, push the "C" button.

Congratulations, you've now accomplished Line Hole Arc!

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