



Demo of Simple Radius function

Turn the display on, set to Imperial (Inches) mode.
Zero out all 3 axis readouts to 0.0000.
Push Simple Radius button to enter the Simple Radius function.

Step 1: Choose your arc plane.

Choose the arc plane you wish to work with by pushing the arrow buttons.
In this case, arrow to where the display shows "sR – XZ".
Push the enter button to choose this arc

Step 2: Choose the arc function.

Input the arc number function you are interested in (1-8) with the keypad, followed by the enter button.
Push the down arrow key to continue to the next parameter.

Step 3: Enter the radius of your arc.

Input the radius of your arc with the keypad, followed by the enter button.
Push the down arrow key to continue to the next parameter.

Step 4: Enter your tool diameter.

Input the diameter of your tool with the keypad, followed by the enter button.
Push the down arrow key to start Simple Radius.

At this point your display should show the following:

Top right window = AU. R- XZ
X = 0.0000
Y = 0.0000
Z = 0.0000

Now move your Z axis **slowly** towards the arc plane you've previously selected. If you accidentally move **away** from the arc plane the Z axis will read "r. OU LI" which means you're moved out of the radius limit for your chosen arc. In other words, if you get this error message, you've moved the Z axis the wrong direction. To get back to a normal reading, just move the Z axis back the other direction to get you "back into" the arc parameters.

What you're looking to do is to move your Z axis until you see an "error" in your X axis. When you do see a reading on the X axis, simply move the table to correct the X axis reading to read zero. At first, you will not have much X axis error as the arc (at least in the X axis) is not moving much. However, as you progress through your cut, the X axis error will continually increase as Z axis movement continually decreases.

Here's what **should** be happening:

Move your Z axis until your **X axis** display reads approximately 0.0002

Your Z axis probably reads -0.0012 or something similar

Continue to incrementally move your Z axis and keep correcting your X axis until your arc is finished

As soon as the Z axis reads "r. OU LI" you have completed the arc.

Congratulations!