ChinaCNCzone

Steel structure HY3040 5Axis USB Mach3 router machine Manual
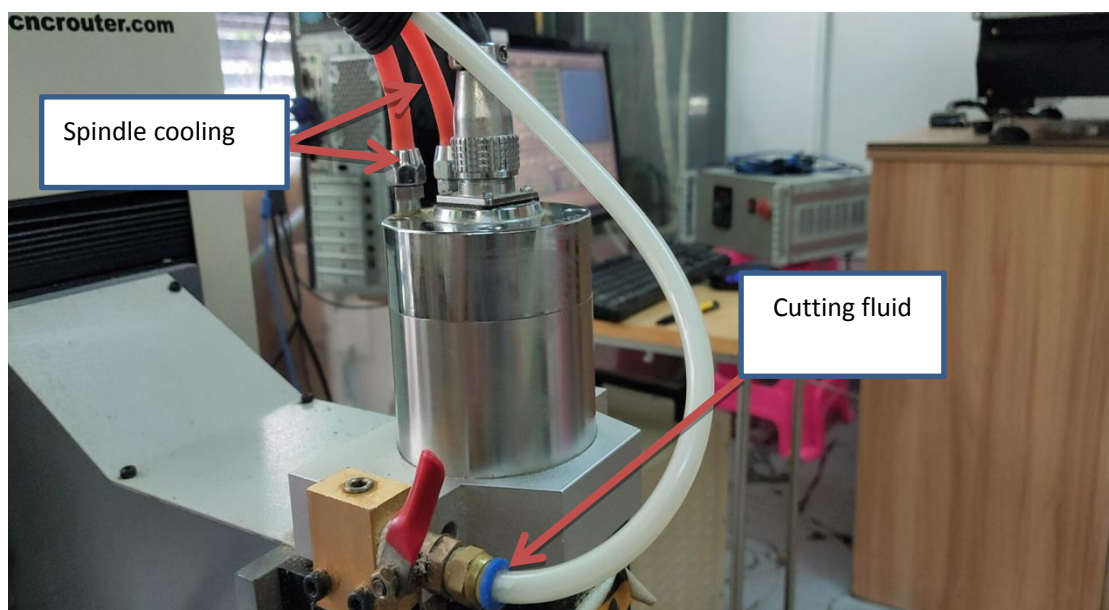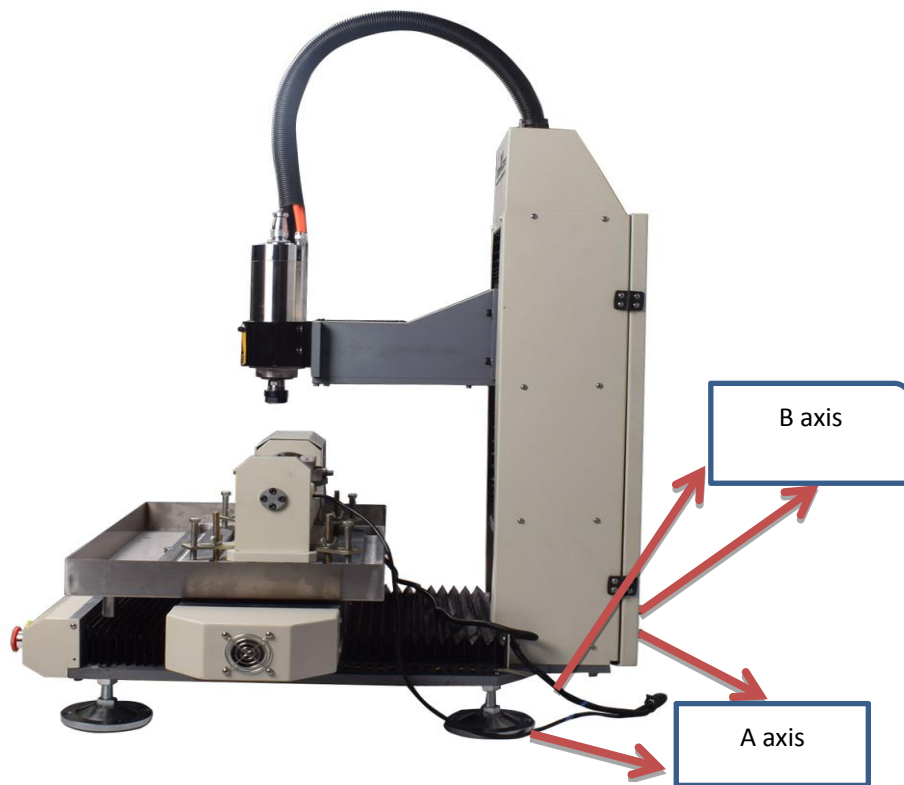
Gross weight: 230KG

26cm

20cm

95cm

20cm

45cm

40cm

60cm

79cm

86cm

Content

Note：**The dial gauges, special 5axis fixture, dial Gauge and handwheel that appear in the manual are all optional. If necessary, please contact sales to purchase.**
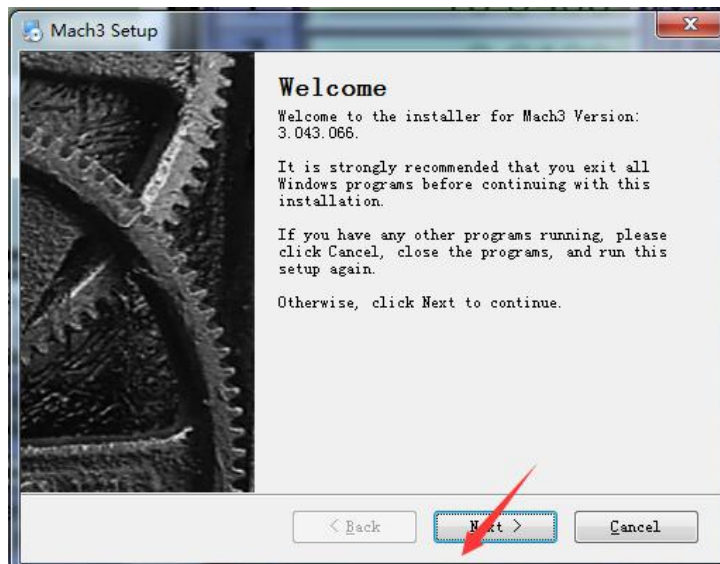
1.connect as picture shown

B axis

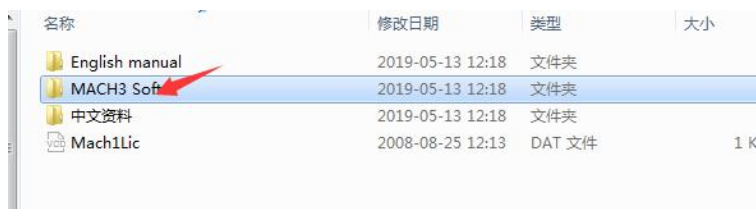A axis

Spindle cooling

Cutting fluid

2.Mach3 Installation

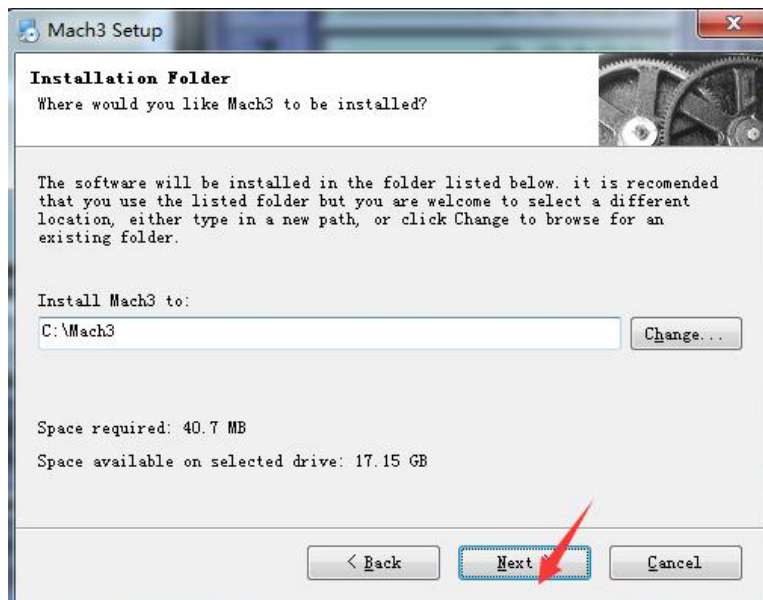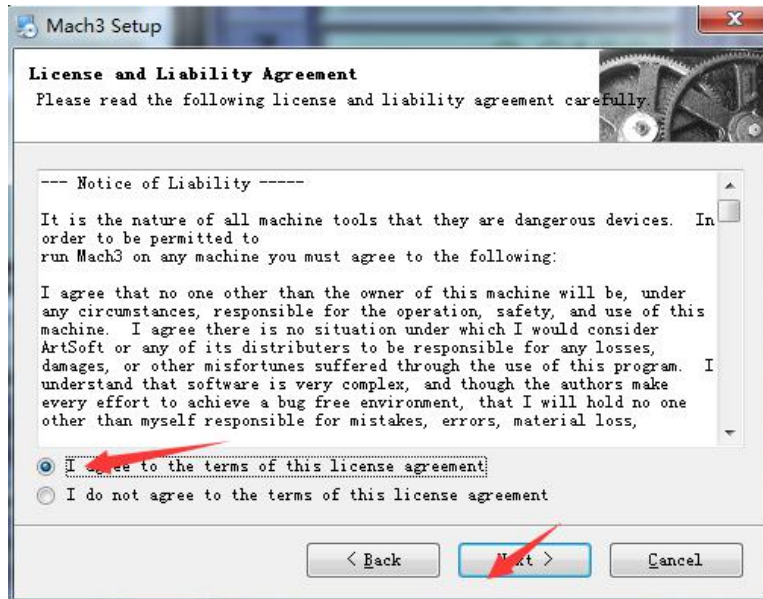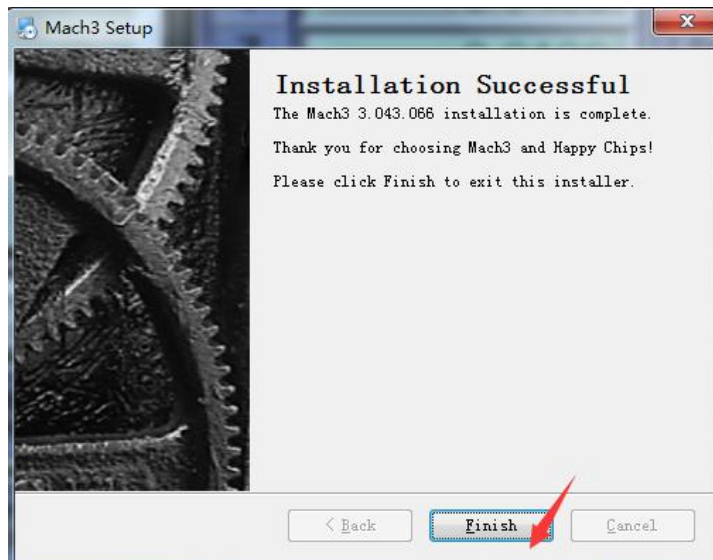MACH3 was machine control software , The machine also need G code design software , We would try to provide fusion 360 G code design software in future. But we are able to provide post processor for G code design .

（Notice：Before installing, please turn off anti-virus software.）

1.Open the Compressed file, and find the file Mach3 soft . Open it And click the Mach3Eng and install the software.

Mach3 Setup

License and Liability Agreement
Please read the following license and liability agreement carefully.

--- Notice of Liability -----

It is the nature of all machine tools that they are dangerous devices. In order to be permitted to
run Mach3 on any machine you must agree to the following:

I agree that no one other than the owner of this machine will be, under any circumstances, responsible for the operation, safety, and use of this machine. I agree there is no situation under which I would consider ArtSoft or any of its distributers to be responsible for any losses, damages, or other misfortunes suffered through the use of this program. I understand that software is very complex, and though the authors make every effort to achieve a bug free environment, that I will hold no one other than myself responsible for mistakes, errors, material loss,

○ I agree to the terms of this license agreement
○ I do not agree to the terms of this license agreement

< Back   Next >   Cancel

Mach3 Setup

Installation Folder
Where would you like Mach3 to be installed?

The software will be installed in the folder listed below. it is recomended that you use the listed folder but you are welcome to select a different location, either type in a new path, or click Change to browse for an existing folder.

Install Mach3 to:

C:\Mach3   Change...

Space required: 40.7 MB

Space available on selected drive: 17.15 GB

< Back   Next >   Cancel

2.Return to this interface，and find the file named "中文资料"，open it，open file "XHC-MKX-V"，right click "一键安装驱动"，Run as administrator.

名称	修改日期	类型	大小
English manual	2019/5/10 17:52	文件夹	
MACH3 Soft	2019/5/10 17:52	文件夹	
中文资料	2019/5/10 17:52	文件夹	
Mach1Lic.dat	2008/8/25 12:13	DAT 文件	1 KB

名称	修改日期	类型	大小
How to do Slave home	2018/6/11 13:41	DOCX 文档	120 KB
m200.m1s	2017/7/4 13:24	M1S 文件	1 KB
m201.m1s	2017/7/4 13:25	M1S 文件	1 KB
m202.m1s	2017/7/20 10:18	M1S 文件	1 KB
m203.m1s	2017/7/20 10:18	M1S 文件	1 KB
M930.m1s	2014/2/27 16:53	M1S 文件	1 KB
m933.m1s	2017/3/6 13:07	M1S 文件	1 KB
m999.m1s	2013/5/9 14:02	M1S 文件	1 KB
Mach3Mill	2017/7/20 10:15	XML 文档	150 KB
NcUsbPod.dll	2018/9/21 15:59	应用程序扩展	752 KB
Release Note-2.59.1	2018/9/21 11:27	文本文档	6 KB
slave home readme	2018/9/21 9:39	文本文档	1 KB
安装说明	2018/10/8 15:16	文本文档	1 KB
一键安装驱动(mach3必须在c盘)	2018/10/8 15:15	Windows 批处理...	1 KB

3.return to this interface，open file"中文资料"

English manual	2019-05-13 12:18	文件夹	
MACH3 Soft	2019-05-13 12:18	文件夹	
中文资料	2019-05-13 12:18	文件夹	
Mach1Lic	2008-08-25 12:13	DAT 文件	1 KB

Open"Mach3 界面"file，and open"六轴界面" file，copy"4zjm"file.

MACH3-界面	2019-05-13 12:18	文件夹	
macro宏代码	2019-05-13 12:18	文件夹	
MKX-V-5代卡接线图	2019-05-13 12:18	文件夹	
MKX-V-5代卡配置文件	2019-05-13 12:18	文件夹	
MKX-V-5代卡说明书（手轮说明书）	2019-05-13 12:18	文件夹	
XHC-MKX-V 驱动一键自动安装	2019-05-13 12:18	文件夹	
Mach3Mill	2019-04-28 14:34	XML 文档	151 KB
安装与使用说明	2018-12-12 16:07	文本文档	1 KB

六轴界面	2019-05-13 12:18	文件夹	
四轴界面	2019-05-13 12:18	文件夹	
六轴界面	2018-04-25 17:05	zip Archive	1,469 KB
四轴界面	2018-09-12 15:59	zip Archive	1,469 KB

4zjm	2019-05-13 12:18	文件夹	
XHC-6zjm.set	2016-10-27 14:23	SET 文件	71 KB
使用说明	2016-10-27 16:24	文本文档	1 KB

4.on the computer desk，right click "MACH3 Mill"，Click "attribute"，click File location

Find out file "Bitmaps"，Paste file"4zjm"in to it
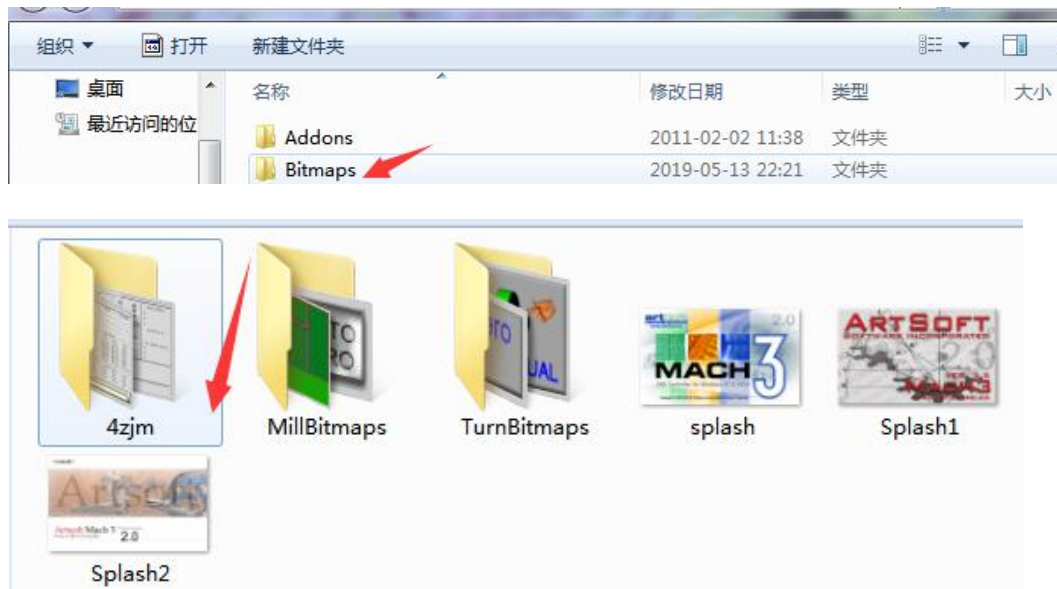
5.return to this interface（中文资料/Mach3 界面/六轴界面），copy
"XHC-6Zjm.set",

名称	修改日期	类型	大小
4zjm	2019/5/10 17:52	文件夹	
XHC-6zjm.set	2016/10/27 14:23	SET 文件	71 KB
使用说明	2016/10/27 16:24	文本文档	1 KB

Paste it into WINXP(C：) mach3 as follow：

tools	2004-02-22 23:18	DAT 文件	10 KB
TurnJogIncs	2003-09-11 8:59	文本文档	1 KB
VideoOCX.ocx	2003-12-31 7:37	ActiveX 控件	448 KB
VideoOCXTools.ocx	2003-04-11 3:10	ActiveX 控件	68 KB
XHC-6zjm.set	2016-10-27 14:23	SET 文件	71 KB

6.find out "Mach3Mill ",copy it and paste into WINXP(C：) "mach3" file,it will
show as follow

MACH3-界面	2019-05-13 12:18	文件夹	
macro宏代码	2019-05-13 12:18	文件夹	
MKX-V-5代卡接线图	2019-05-13 12:18	文件夹	
MKX-V-5代卡配置文件	2019-05-13 12:18	文件夹	
MKX-V-5代卡说明书（手轮说明书）	2019-05-13 12:18	文件夹	
XHC-MKX-V 驱动一键自动安装	2019-05-13 12:18	文件夹	
Mach3Mill	2019-04-28 14:34	XML 文档	151 KB
安装与使用说明	2018-12-12 16:07	文本文档	1 KB

Mach1Lic	2008-08-25 12:13	DAT 文件	1 KB
Mach3	2004-10-13 1:47	BMP 文件	122 KB
Mach3	2012-10-13 3:08	应用程序	4,353 KB
Mach3	2011-04-20 20:59	安装信息	3 KB
Mach3.noapic	2010-05-02 22:30	NOAPIC 文件	107 KB
Mach3.sys	2011-04-12 1:14	系统文件	107 KB
Mach3Mill	2019-05-17 10:17	XML 文档	150 KB
Mach3MillGcode	2011-01-19 6:19	HTM 文件	89 KB

7.return to copy"Mach1lic"，and paste into WINXP(C：) "mach3" file

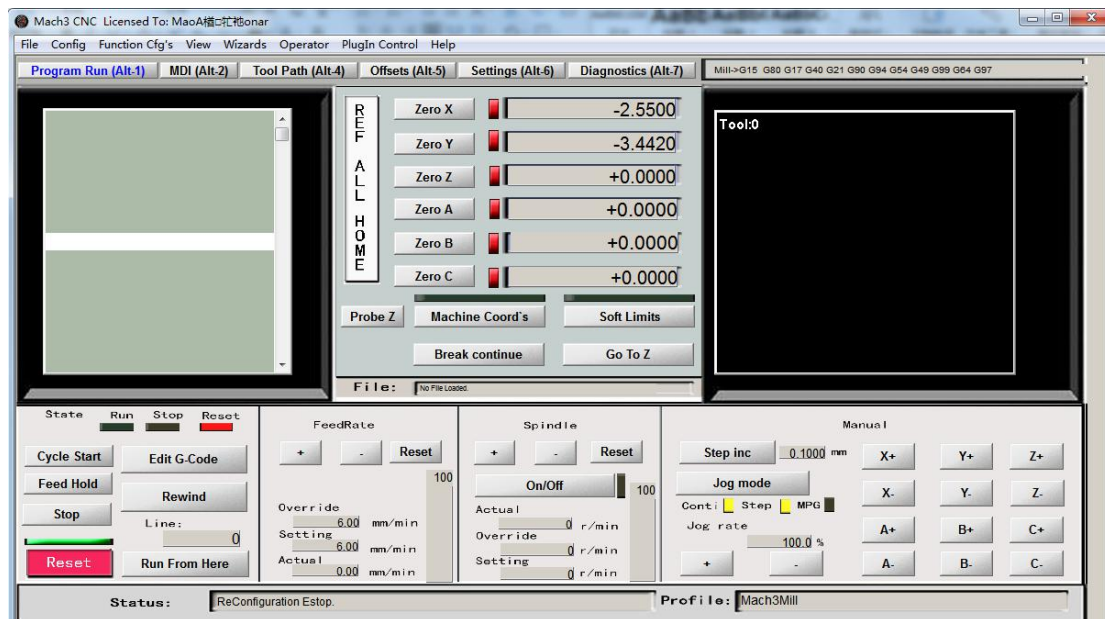|			
English manual	2019-05-13 12:18	文件夹	
MACH3 Soft	2019-05-13 12:18	文件夹	
中文资料	2019-05-13 12:18	文件夹	
Mach1Lic	2008-08-25 12:13	DAT 文件	1 KB

8:Open "machmill "software on computer desk， click "view",it will show loadscreens
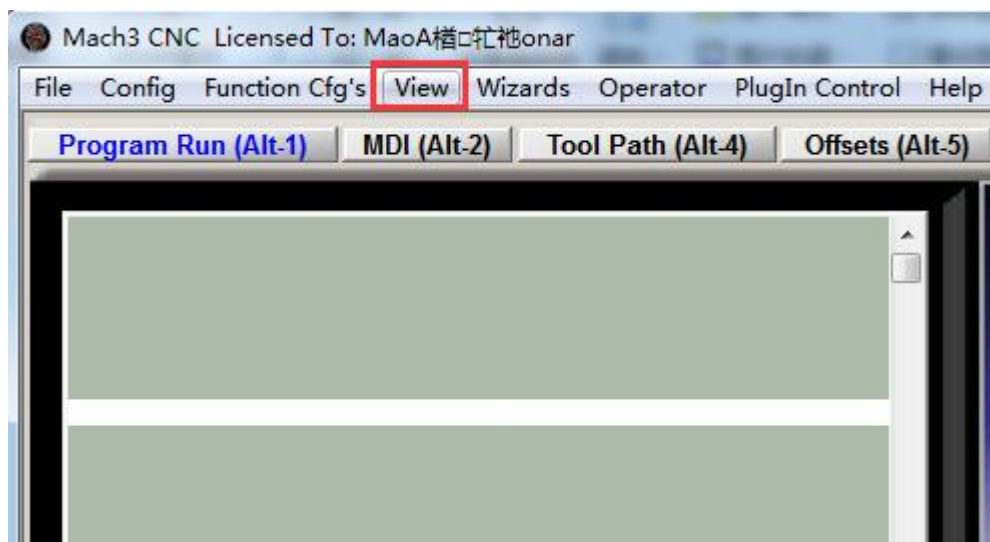
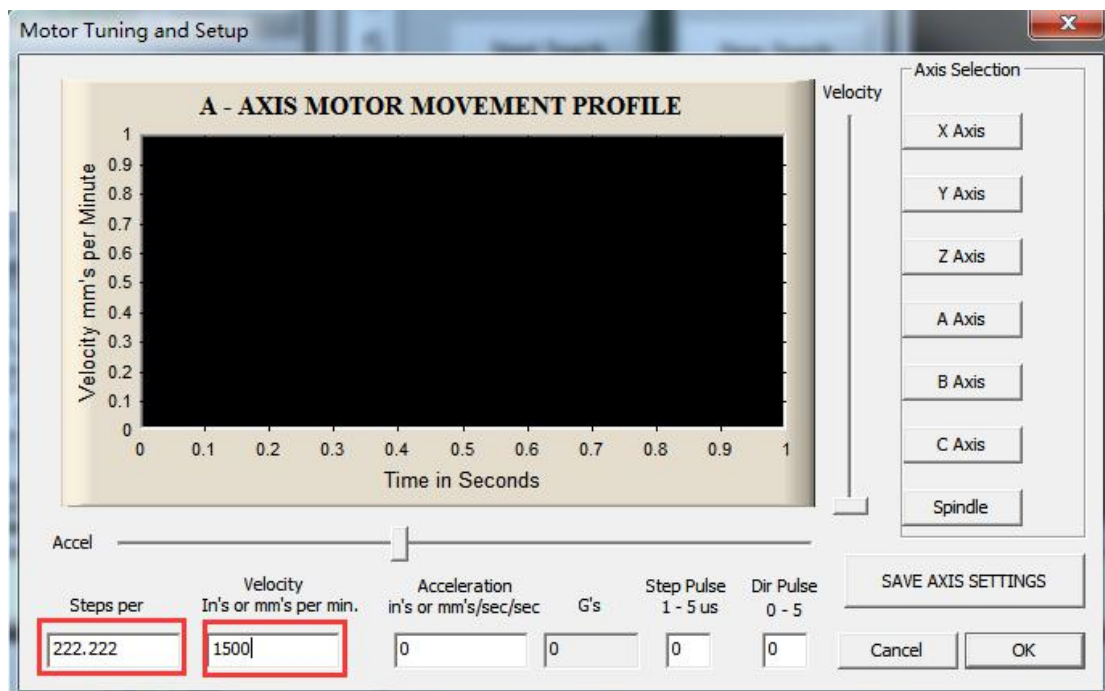Choose loadscreens，find out "XHC-6z0jm.set"，and then open it.
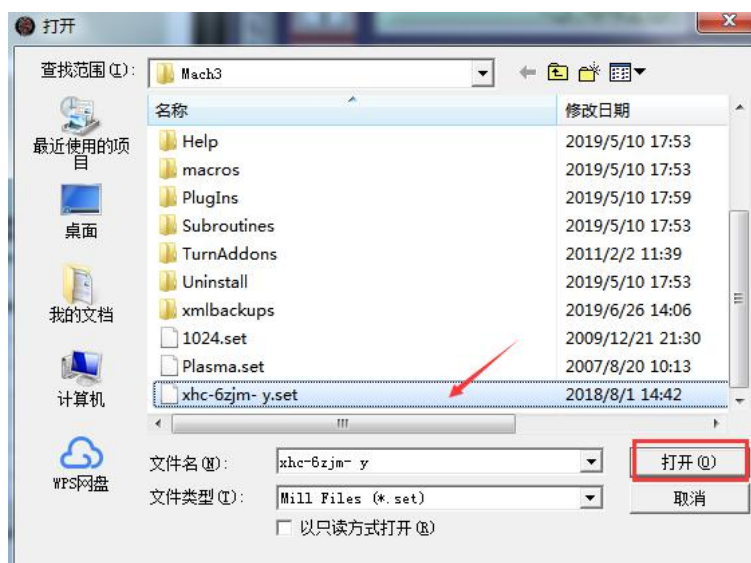
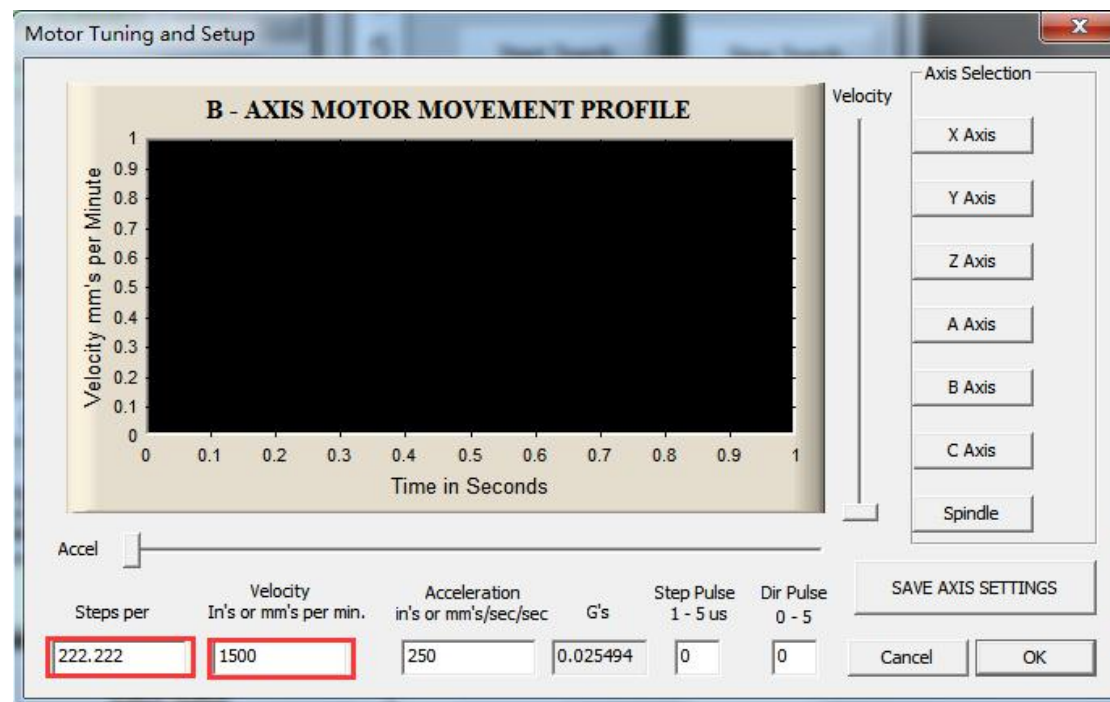It will show the page as follow，and then you can set the parameters

2、A/B axis setting

1.A axis

2.B axis

Then all the setting is finished.

3、 Machine calibration
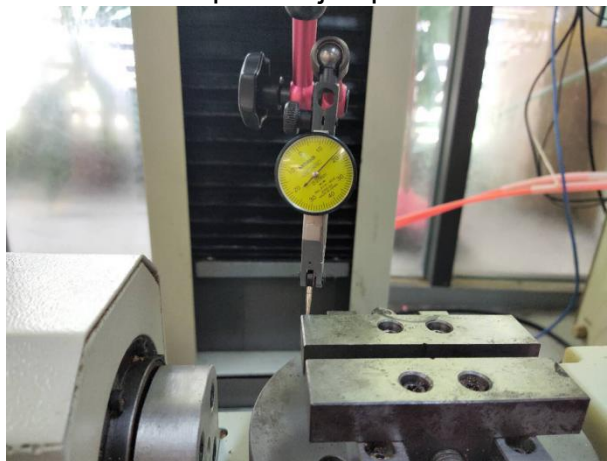
Calibration needs to use the calibration table

1. Use the calibration meter to move in the X-axis direction to ensure that the meter pointer jumps within 1~2 wires. as the picture shows;

Note: If it is not parallel, I hope you can use a soft thing to rap the 5-axis table to adjust the position, for example, with a wooden hammer, do not use hard things to hit the table or it will damage the 5-axis table.

2 Similarly, use the calibration meter to move in the X-axis direction to ensure that the meter pointer jumps within 1~2 filaments. as the picture shows;
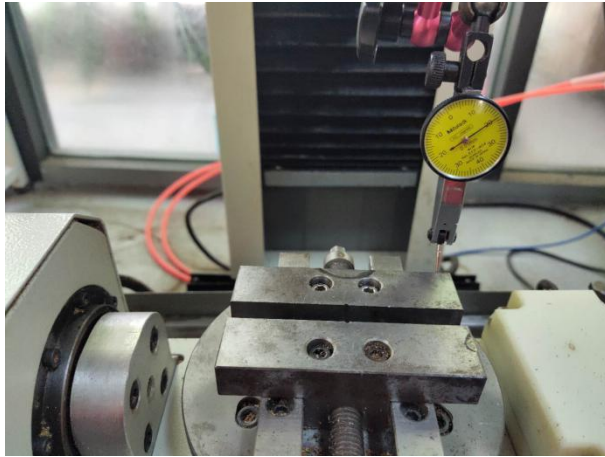
If it is not parallel, you can rotate the angle of the A-axis table to adjust and keep it parallel.

3. Use the calibration meter to move in the Y-axis direction to ensure that the meter pointer jumps within 1~2 wires. as the picture shows;
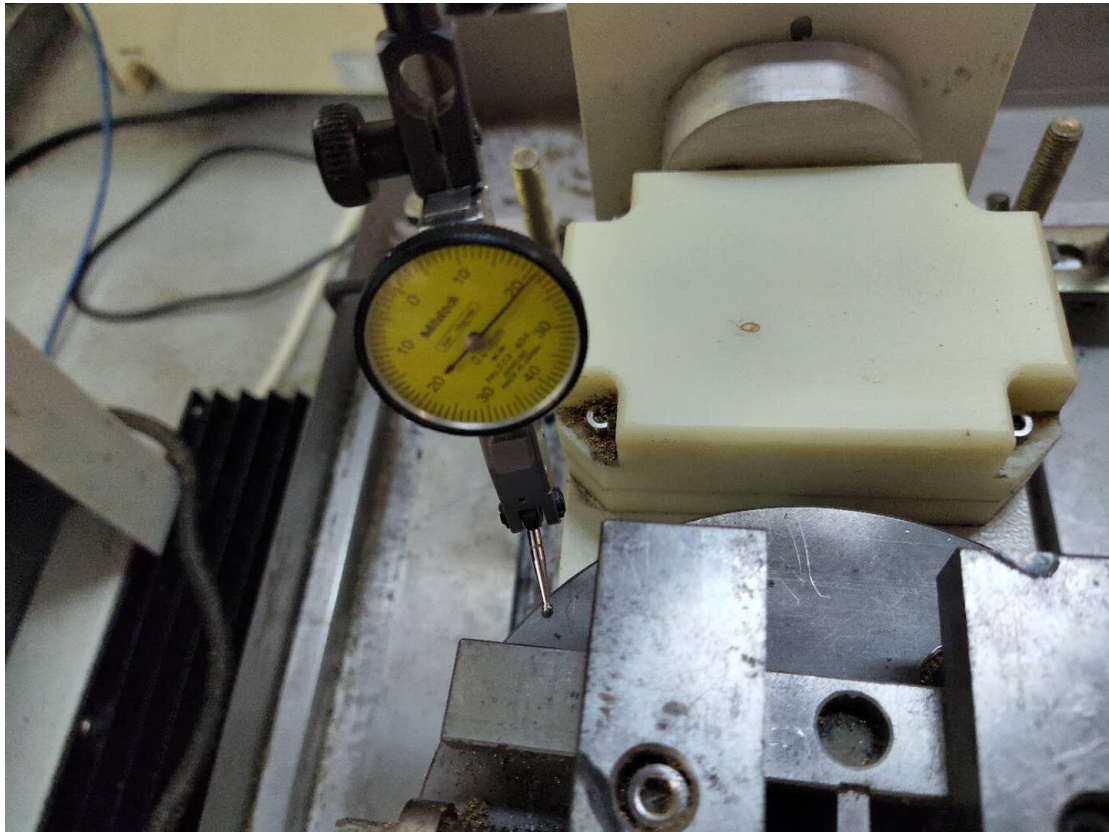
4. If it is not parallel, you can rotate the angle of the B-axis table to adjust and keep it parallel

4、Starting point setting

1. After calibration, only the X Y Z axis is set at the starting point. The B axis has zero at the calibration time. When the A axis is calibrated, the A axis does not need to set the starting point.

2. First, attach the centering rod to the spindle chuck. At the same time, the speed is 400 ~ 600s
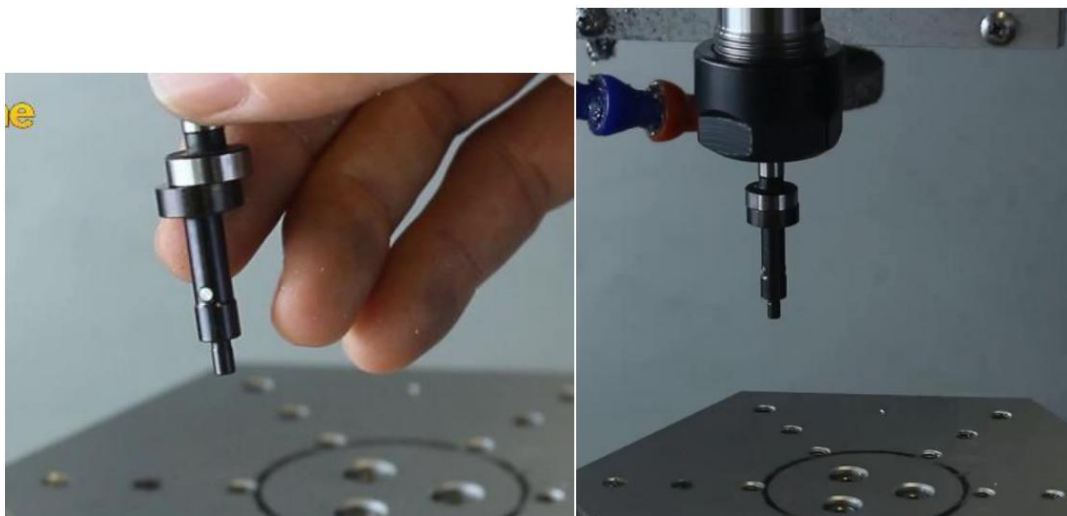
Noted：the speed cannot be too high or it will damage the centering rod.
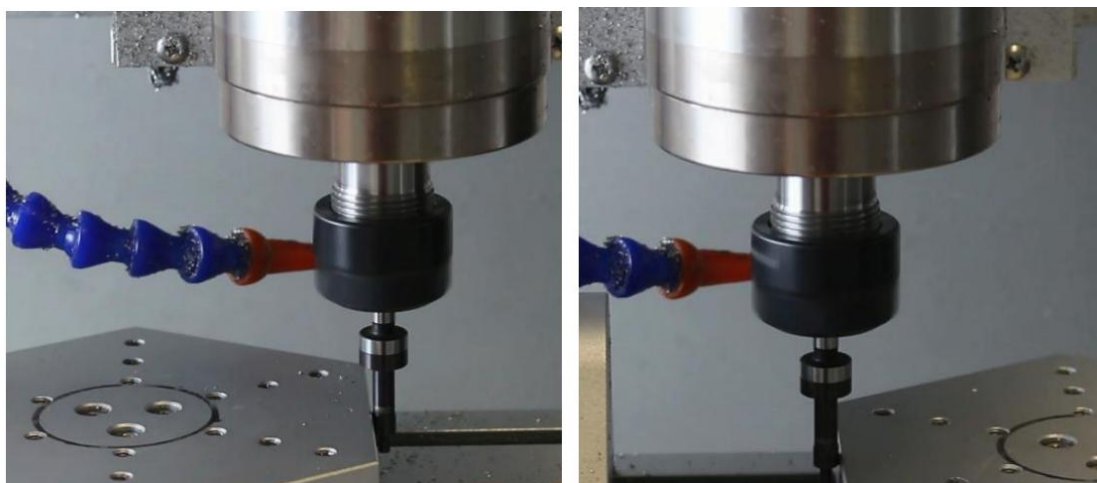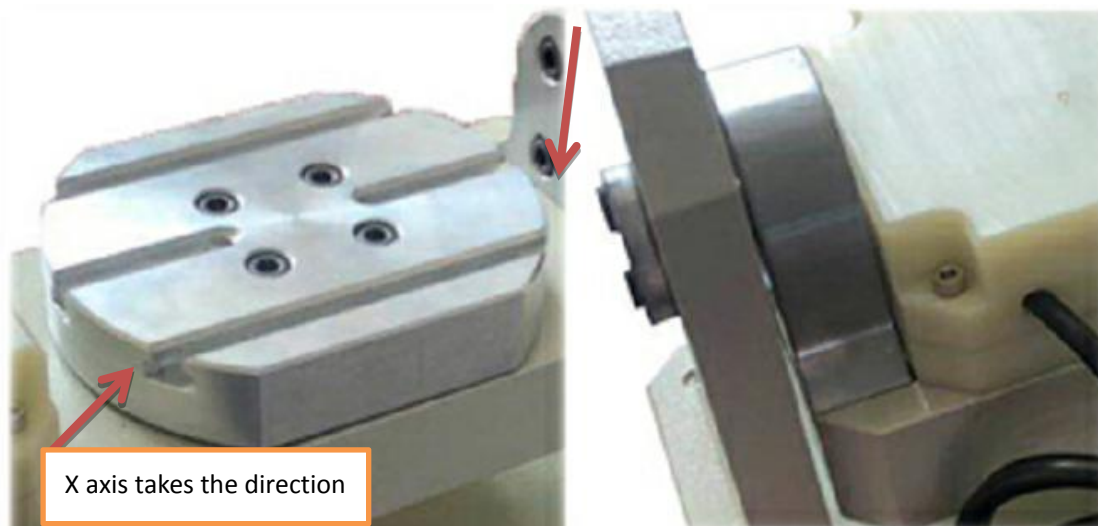
3. Y axis start point setting

Move the edge refiner to the front of the axis table and then move the zero Y axis to the other side. The Mach3 software displays the total edge finder's travel. The starting point of the Y axis is the intermediate point. Under normal circumstances, this number is 63. Finally, move the spindle to 63.000, zero Y-axis. Y-axis starting point has been completed

Y axis takes the direction

the back edge
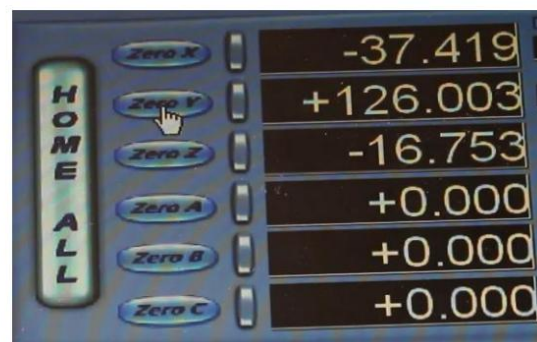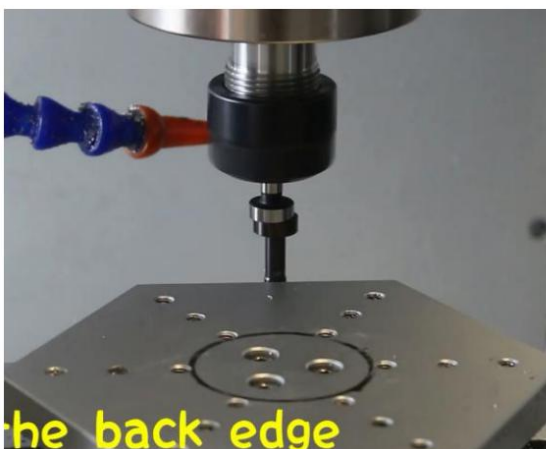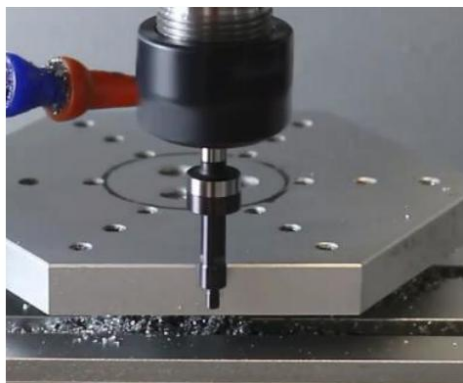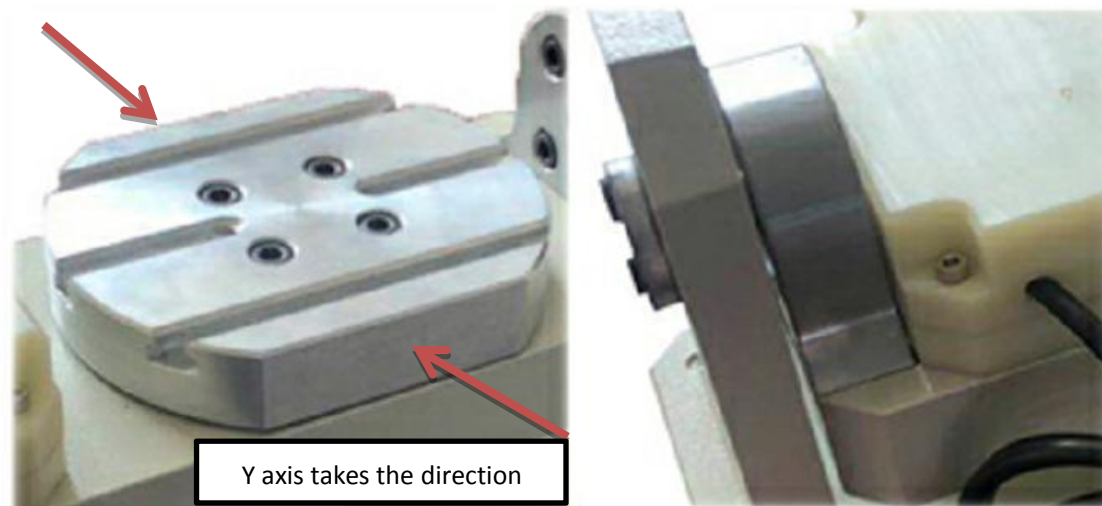
Divide the total stroke value by two, shake the Y-axis to "the value obtained by dividing by two" and click the Y-axis to clear.

4 .X axis start point setting,
It is the same as the Y-axis start point setting.

X axis takes the direction

4. Z axis start point setting

5. The tool touches the direction indicated by the arrow, then click Z to clear, the Z-axis starting point is completed.