



6040 mini Numerical Control Carving Machine manual -MACH3 USB version

Shenzhen Scotle Technology Group Limited

ChinaCNCzone

Address: 038-068 2F Handmade Culture Street, Phase III, Shuike Road,
Bantian, Longgang, Shenzhen, China

Website: www.chinaCNCzone.com

www.scotle.en.alibaba.com

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Part 1 Assembling

Tools and spare parts needed during assembly:

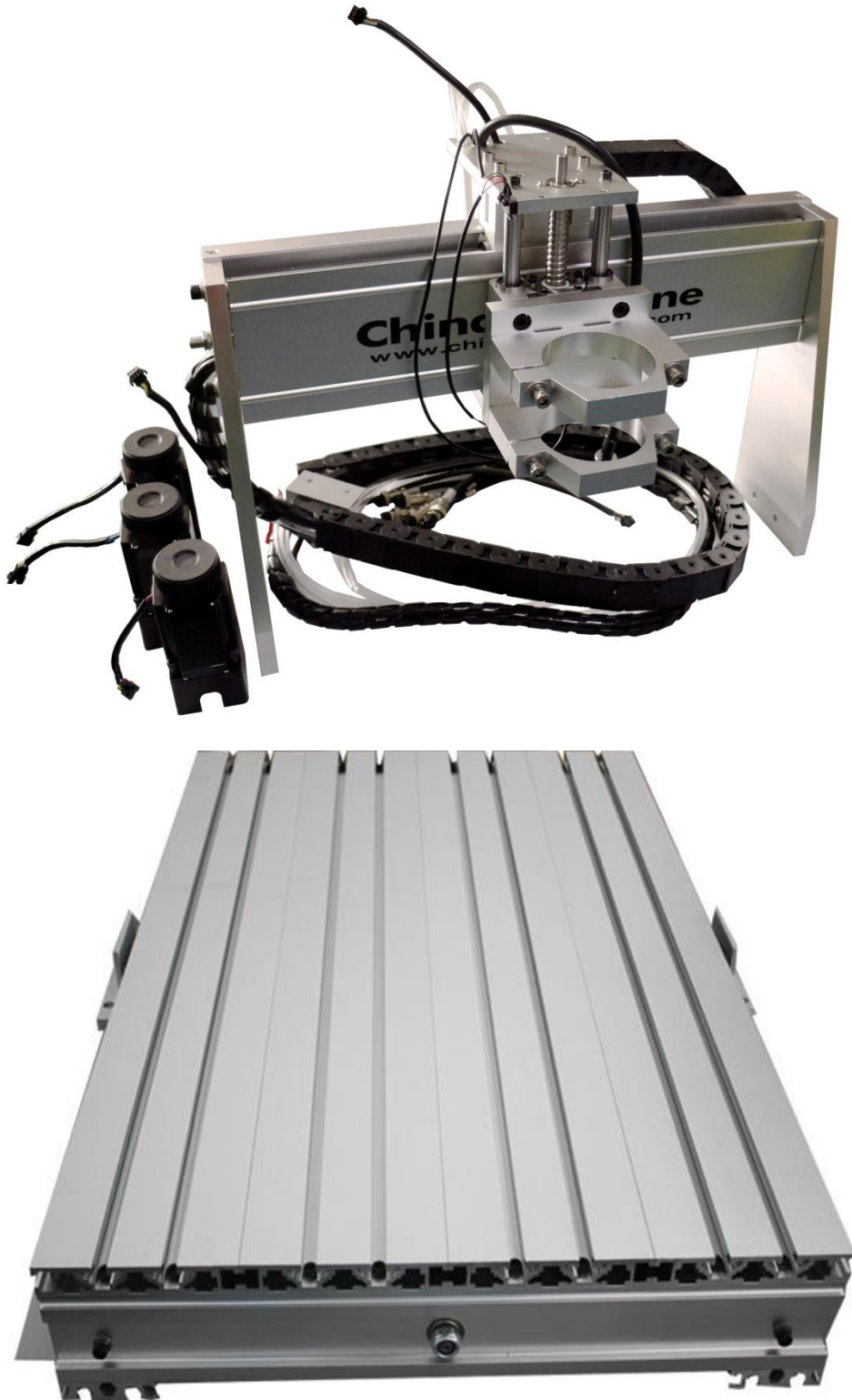


- 1. Waterpump *1
- 2. Spanner*2
- 3. USB cable *1
- 4. Millingbit *2, engraving bit *3
- 5. Clamp tool *6
- 6. Power cable *1
- 7. Stepper motors *3
- 8 Spindle *1

1. Open two cartons you received. The square box included the control box, accessories, the 4th axis and the upper gantry of the machine. The other box is bottom base of the machine.



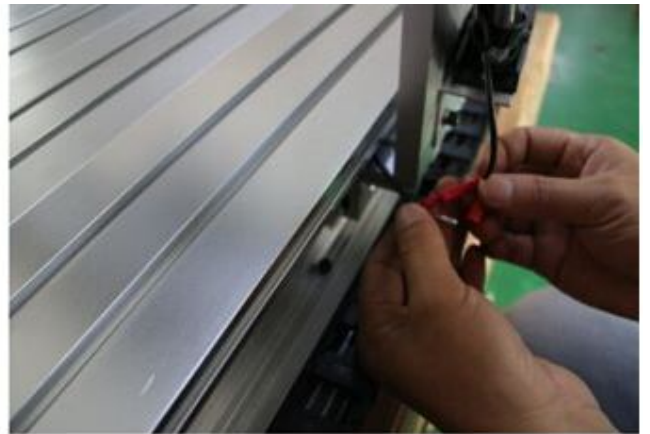
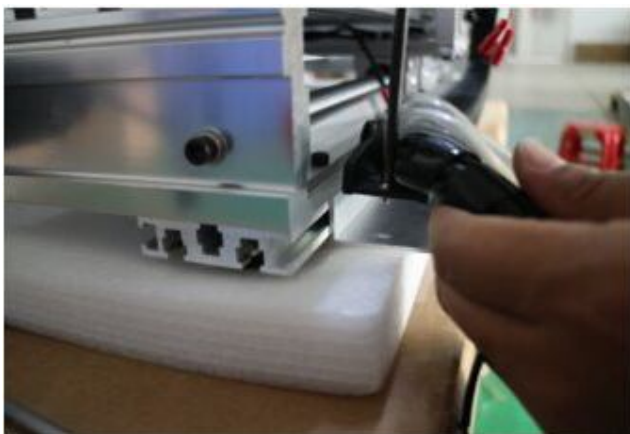
2. Then take out upper gantry of machine , Meanwhile take out bottom base of the machine.



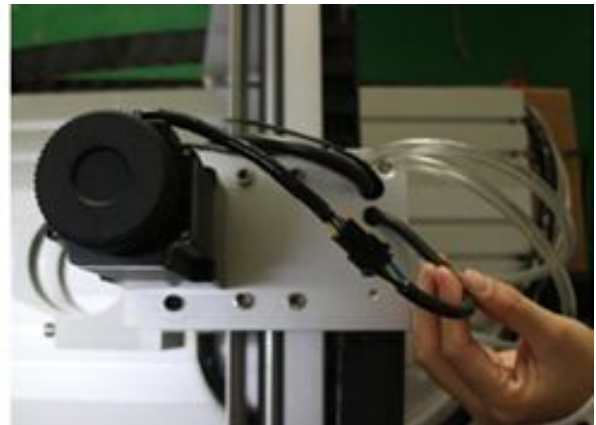
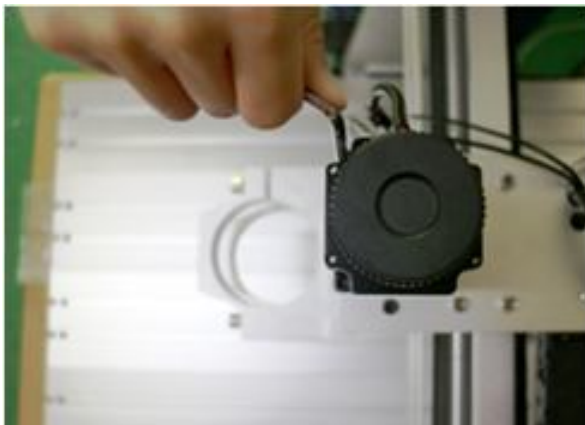
3. Put upper gantry on bottom base, tight screws one by one as below.



Following fixed the belt in one side of machine. At last the two red lines are for limited switches. connect the red lines with the purple lines under the working table.



4. Install step motors. 3 step motors are same for X Y Z Axis. Firstly Put step motor to corresponding Axis. Tight four screws and make sure tighten.



Connected that corresponding cable.

Second, You can try to found the screw position before installation.



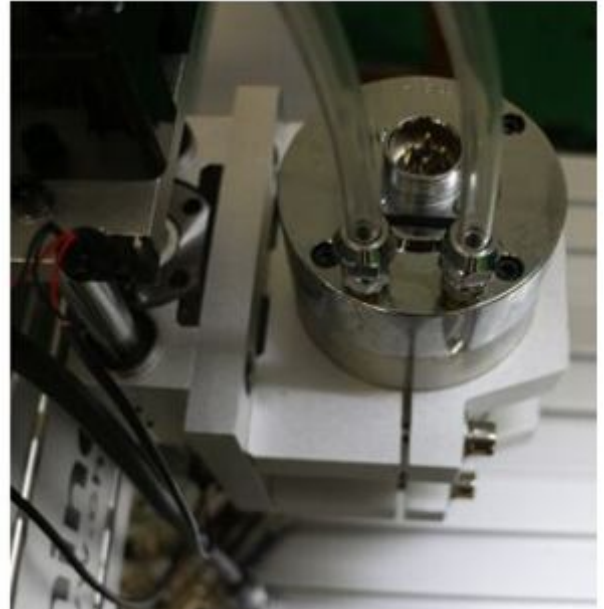
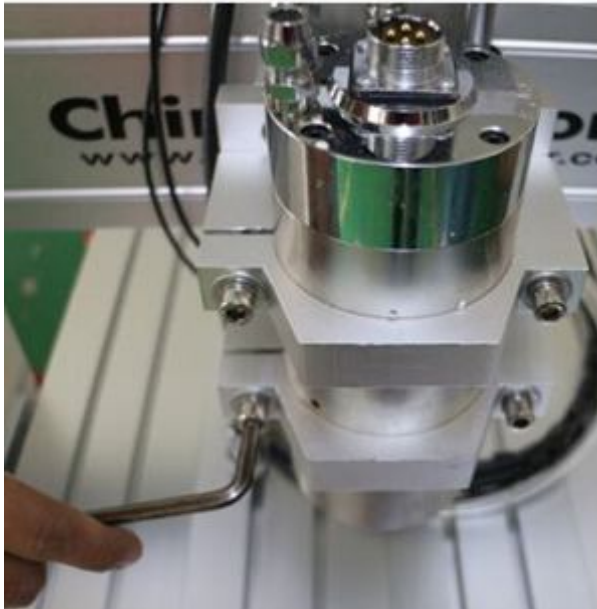
Third, tight the screw of coupling, make sure ball screw and couple good contact.



At last ,The step motors installation finished.



5. Install spindle. First put spindle in spindle clamping, and then tight screws one by one as the first picture show. Second, put the water pipes to the top of the spindle and tight the screws. Then the spindle is assembled.



6. Controller box connection. Connect all lines from machine frame to controller box one by one, According to corresponding marks ,The installation of the machine is finished.





USB Port

4. Last step ,Water pump connection. Connect pipes between water pump and spindle.

Attention: The water pump can not put into the water, it's very dangerous. Just keep water pump outside of tank. If the water pump is wet, cut off the electricity and dry it.



And also connect power cable to controller box according to marks.

Part 2 Mach3 installation and setting

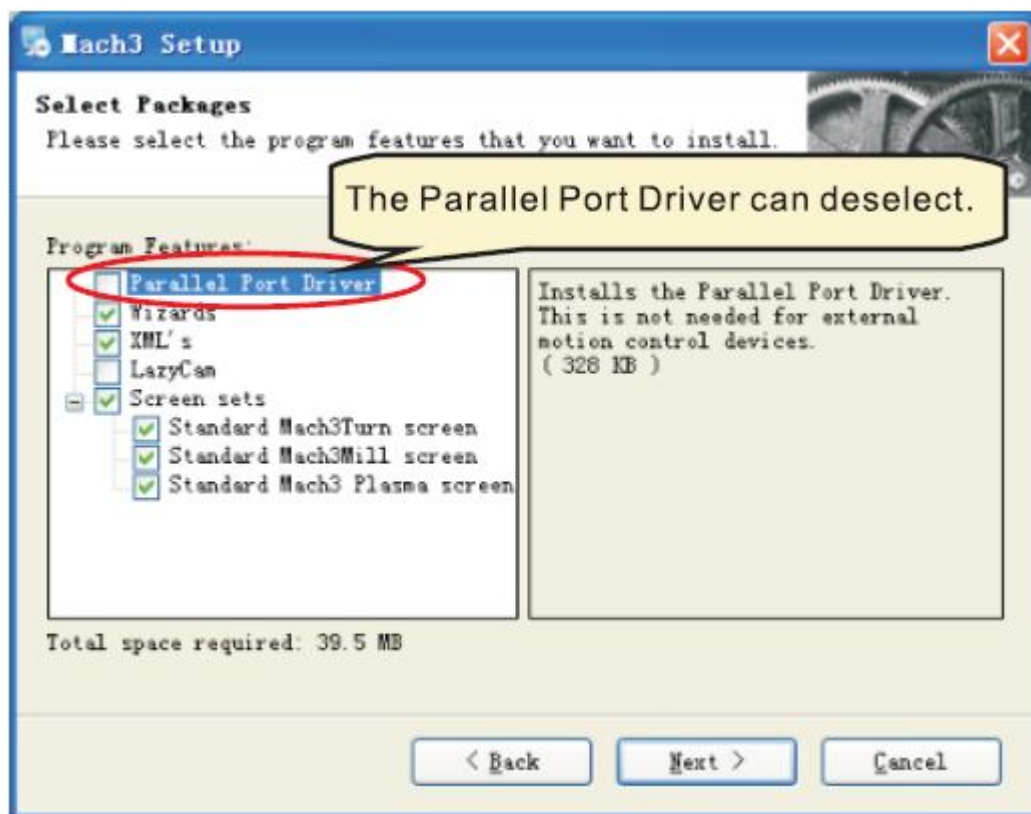
1 Download MACH3

Download latest MACH3 version from MACH3 official website or you can directly install MACH3 from

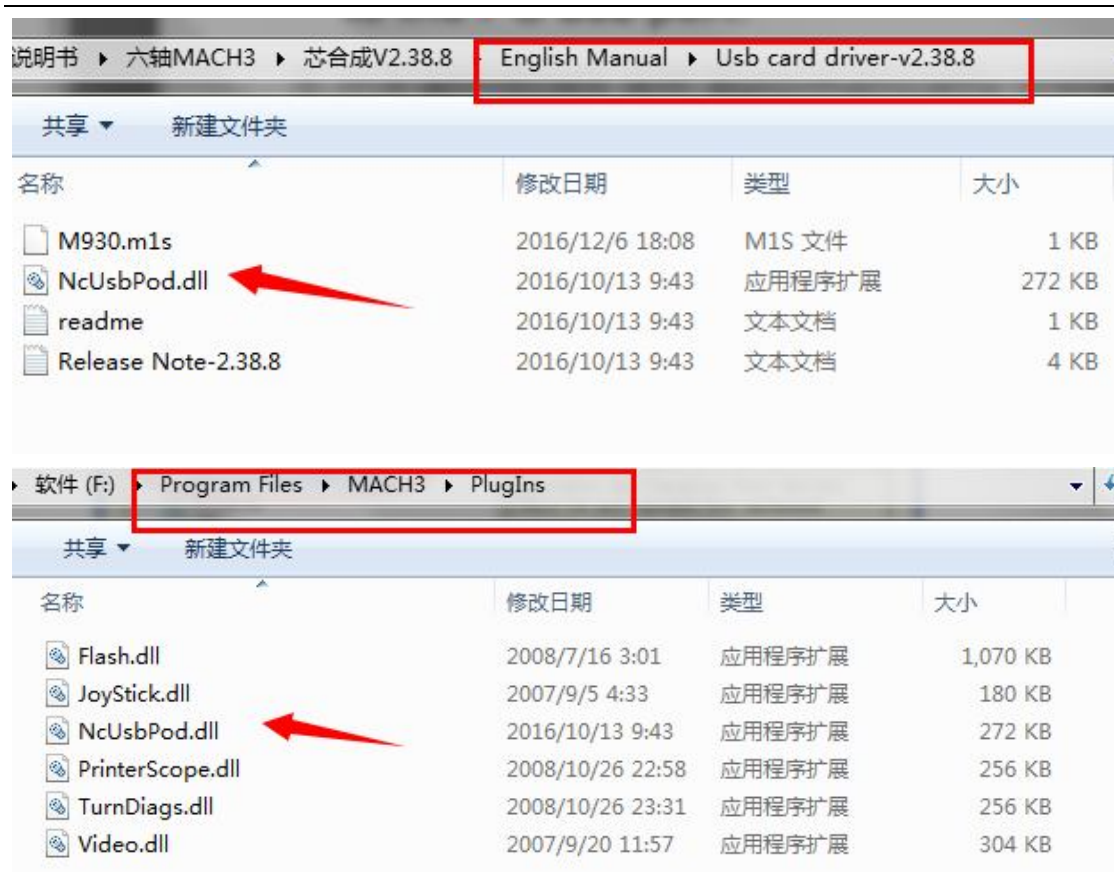
CD.<http://www.machsupport.com/software/mach3/>

2 Install MACH3

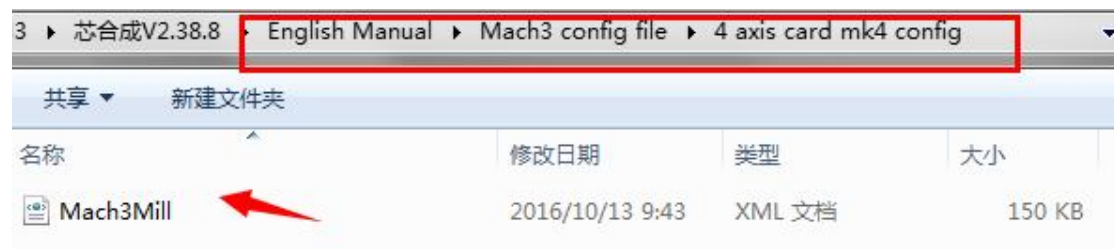
Do not choose parallel port driver



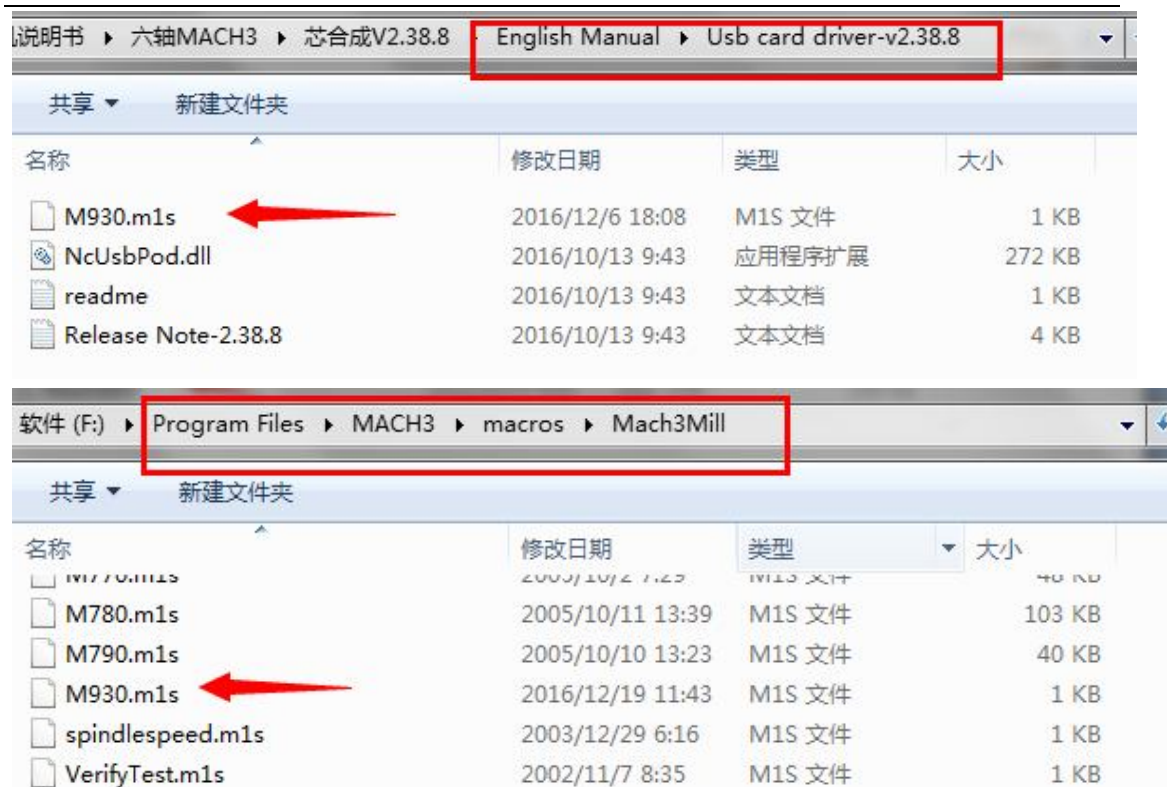
After installation finished ,Connect USB cable between controller box and computer. Copy NcUsbPod.dll from USB card driver file to MAC3/PlugIns file .This file to enable USB motion card.



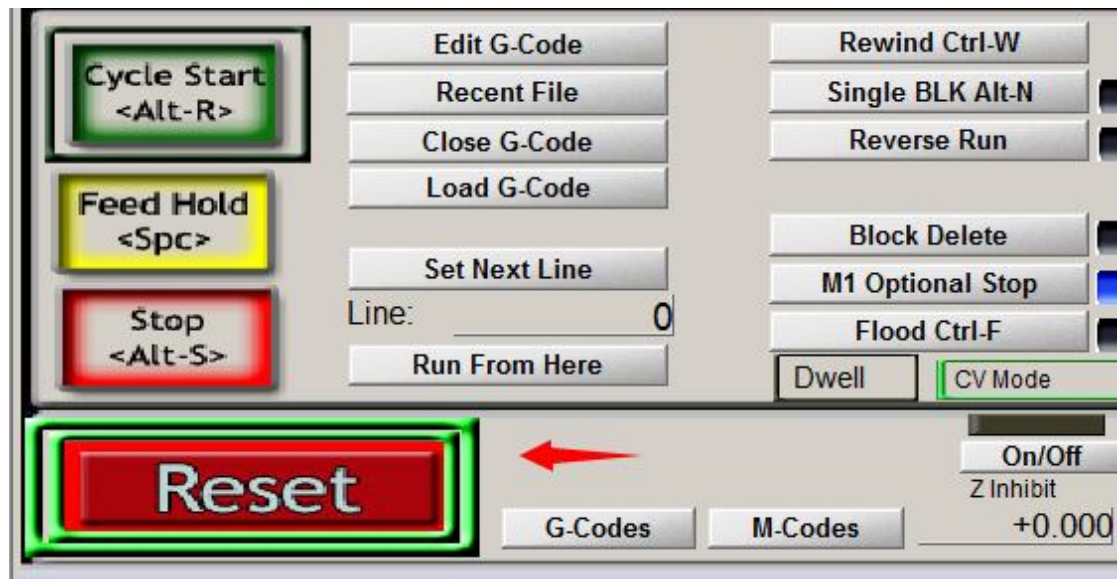
Then ,copy mach3mill.xml from file to mach3, The file is used to basic software setting .



Copy M930.m1s file from Usb card driver to Mach3/macros/Mach3mill file, This file used to auto zero tool setting.

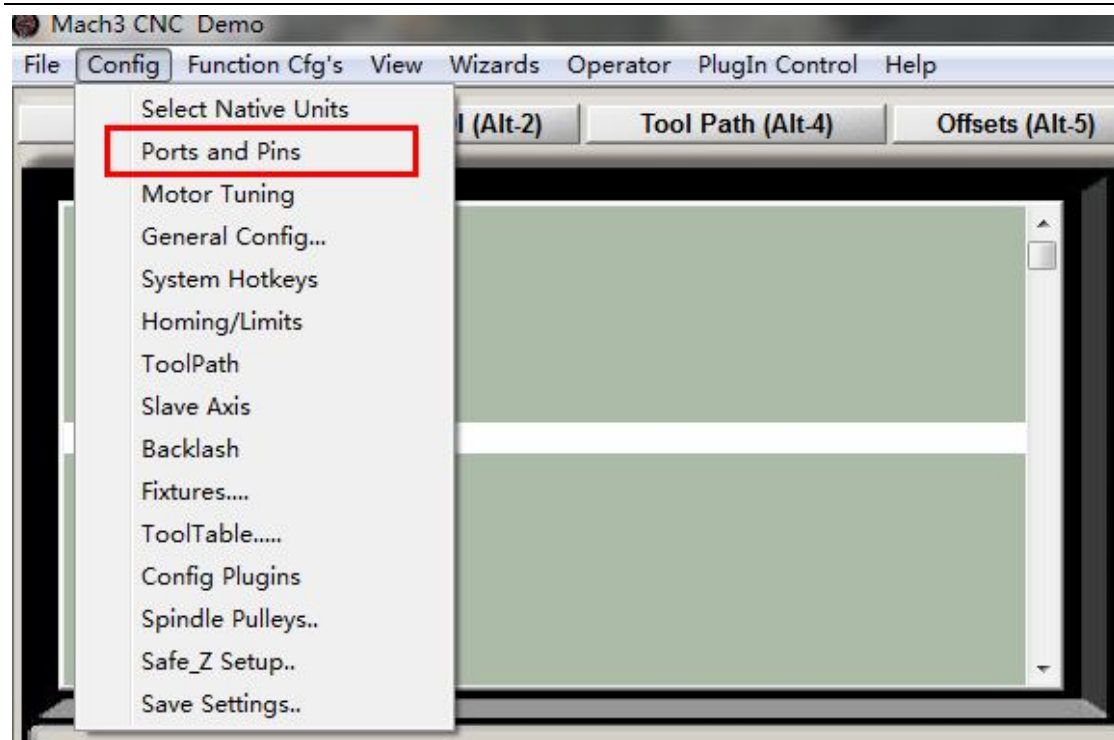


At last, click reset button to keep it green , let machine can normal work.

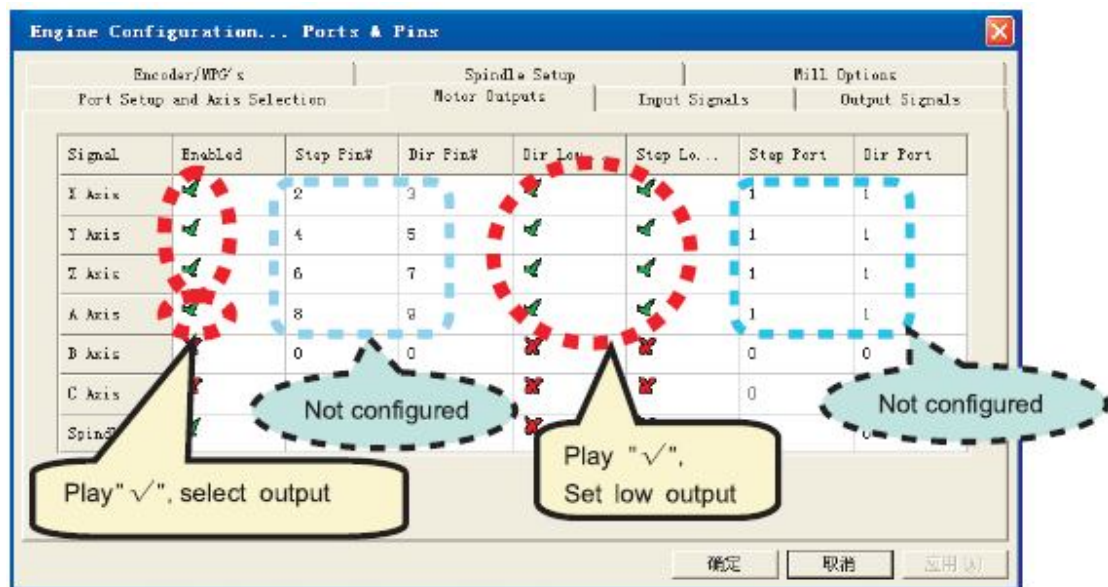


3 Mach3 software setting

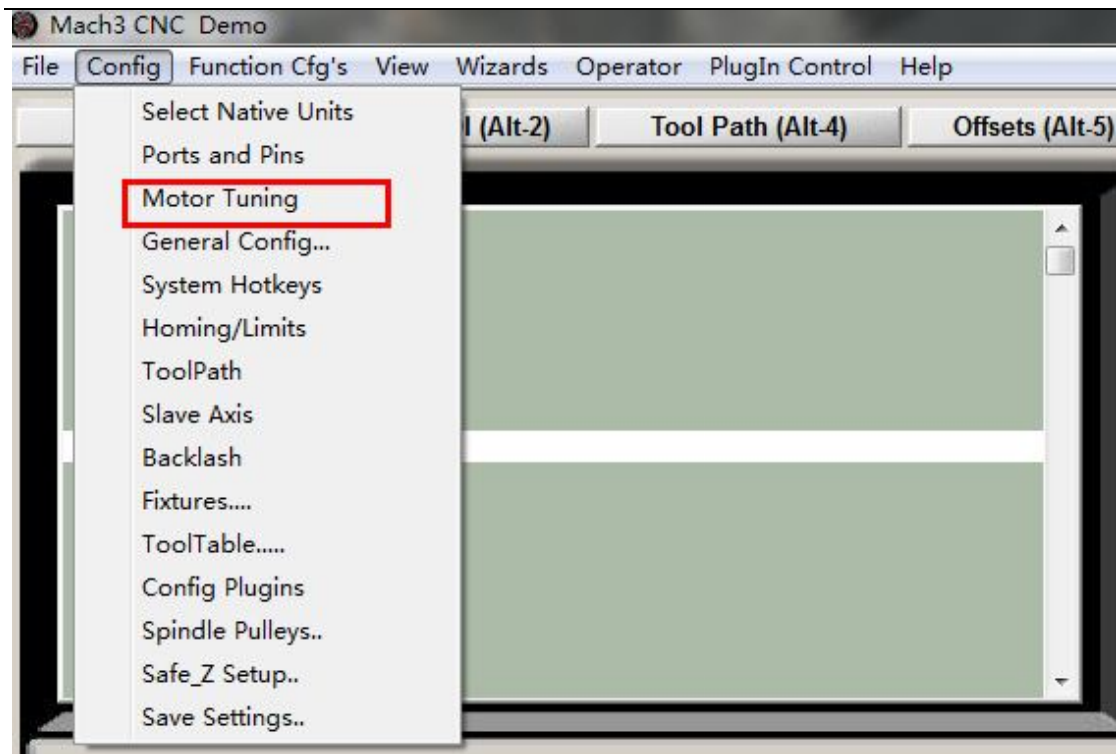
X Y Z A Axis output configuration as below, select config and Ports and pins .



Then ,make all setting as below:

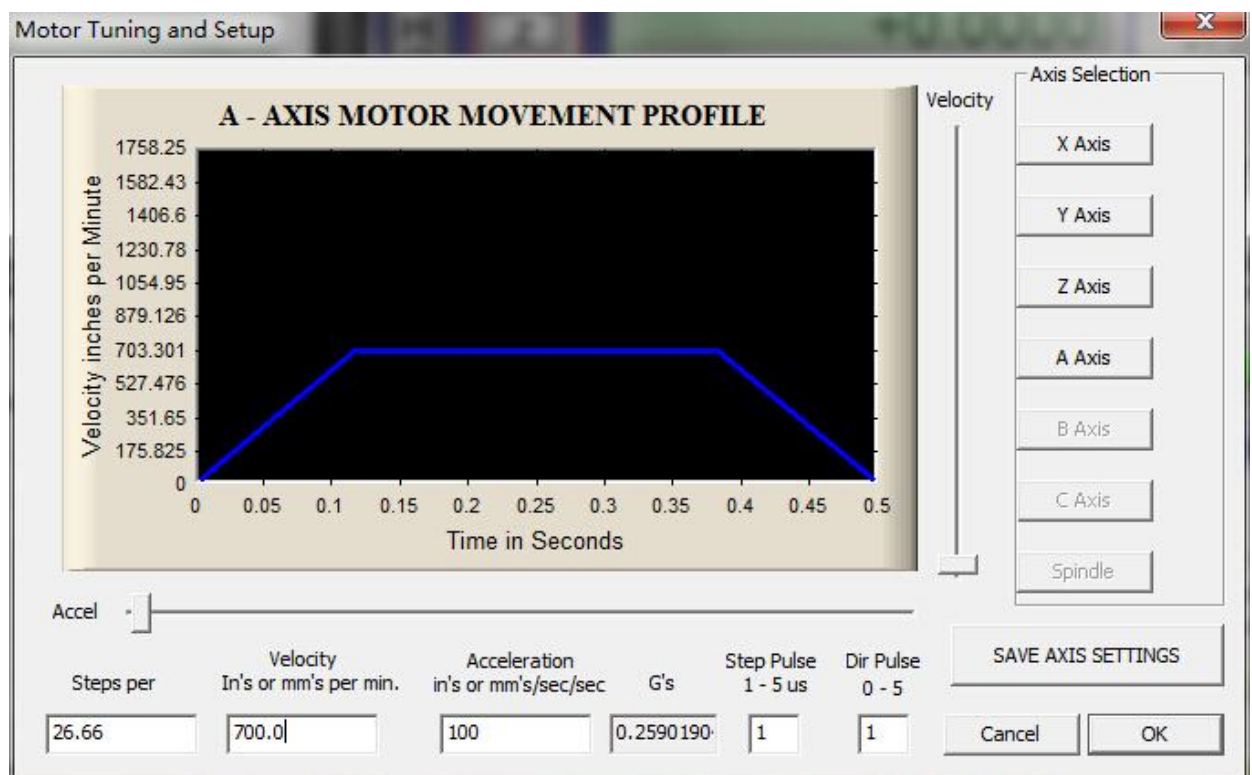
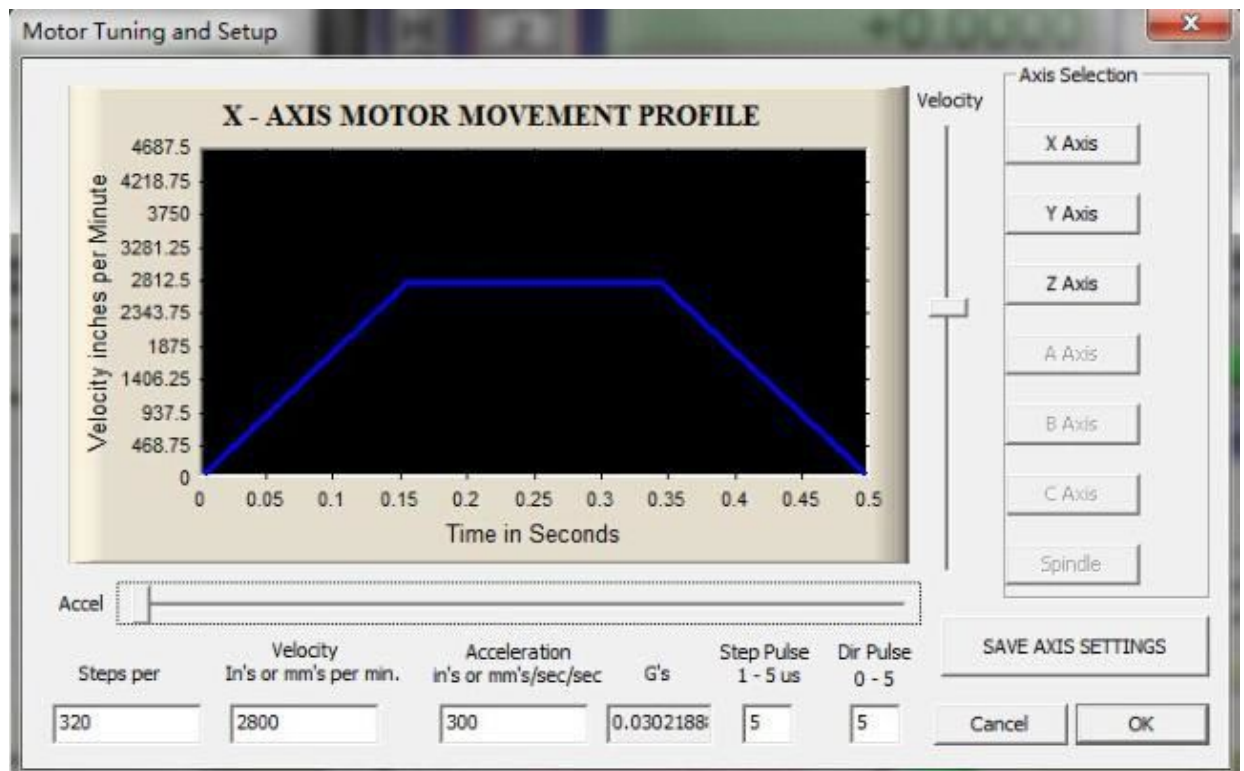


Motor parameter settings, X Y Z Axis setting is completely same ,The Axis setting is different.



If can not set A Axis ,Need to Enable A Axis firstly in Motor outputs

Encoder/MPG's			Spindle Set	
Port Setup and Axis Selection			Motor Outputs	
Signal	Enabled	Step Pin#	Dir Pin#	Dir Lc
X Axis		2	6	
Y Axis		3	7	
Z Axis		4	8	
A Axis		5	9	



Homing/Limits home direction setting as below

Motor Home/SoftLimits

Entries are in setup units.

Axis	Revers...	Soft Max	Soft Min	Slow Z...	Home ...	Home Neg
X		100.00	-100.00	1.00	0.0000	
Y		100.00	-100.00	1.00	0.0000	
Z		100.00	-100.00	1.00	0.0000	
A		100.00	-100.00	1.00	0.0000	
B		100.00	-100.00	1.00	0.0000	

G28 home location coordinates

X	0	A	0
Y	0	B	0
Z	0	C	0

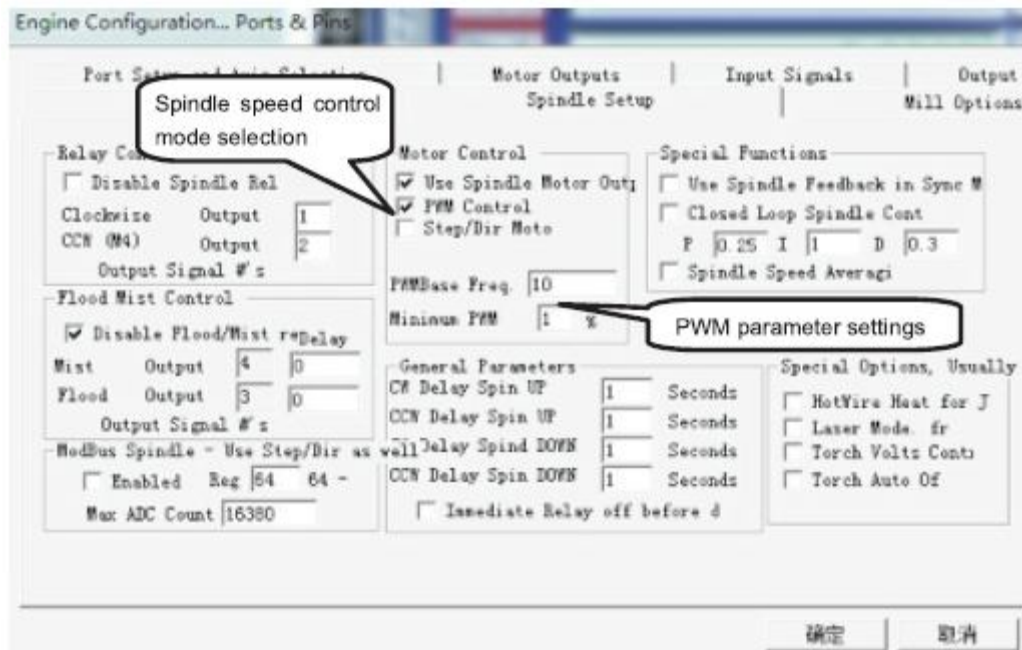
If home moving way reverse ,change Active low from to X ,or
change from X to .

Output signals setting as below

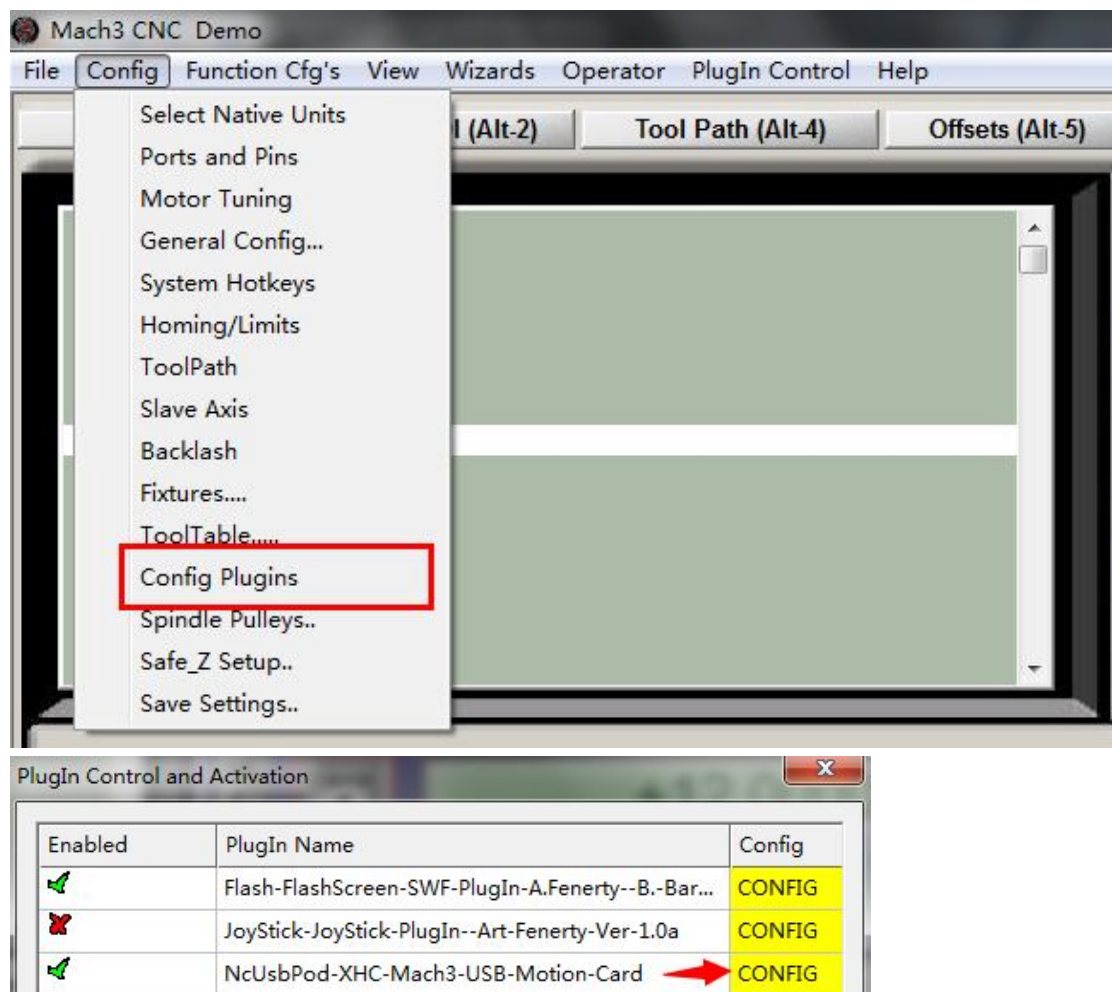
Engine Configuration... Ports & Pins

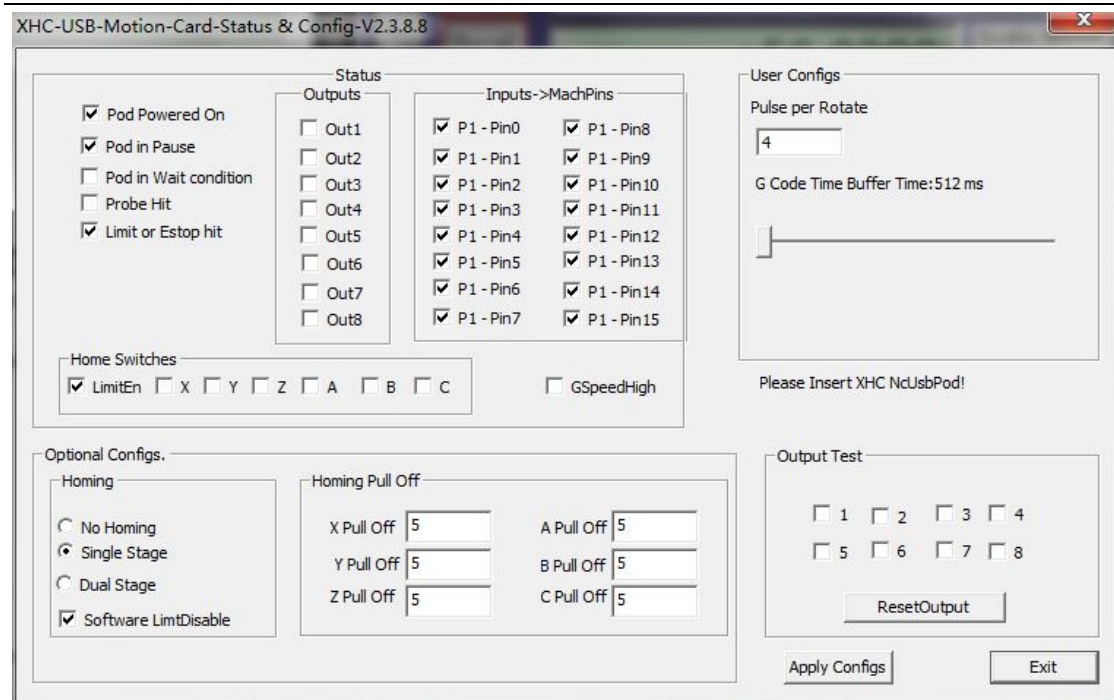
Encoder/MPG's		Spindle Setup		Mill Options
Port Setup and Axis Selection		Motor Outputs	Input Signals	Output S
Signal	Enabled	Port #	Pin Number	Active Low
Enable6		1	0	
Output #1		1	0	
Output #2		1	1	
Output #3		1	2	
Output #4		1	3	
Output #5		1	0	
Output #6		1	0	
Chase Pump		1	0	

Spindle speed control as below:



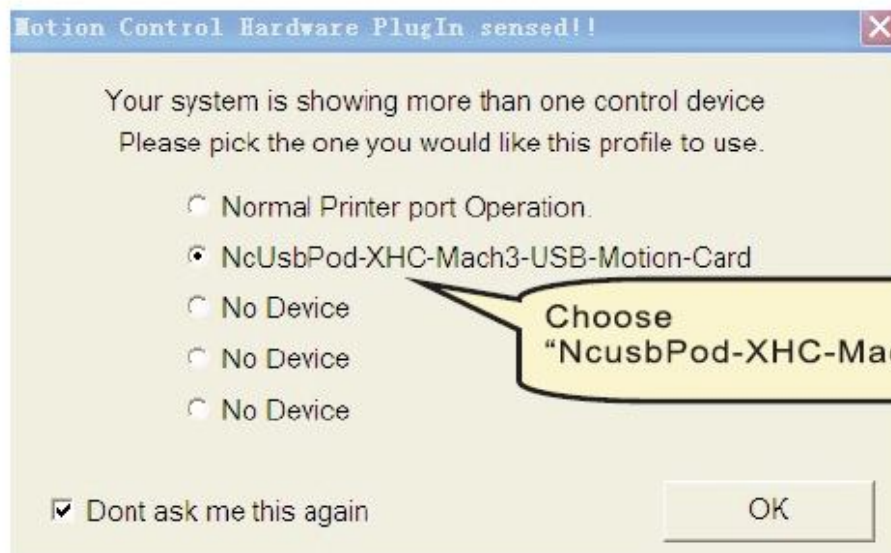
USB Motion control card configuration





At last , Open

software ,Choose"NcUsbPod-XHC-Mach3-USB-Motion-Card",andChoose "Don't ask me this again"



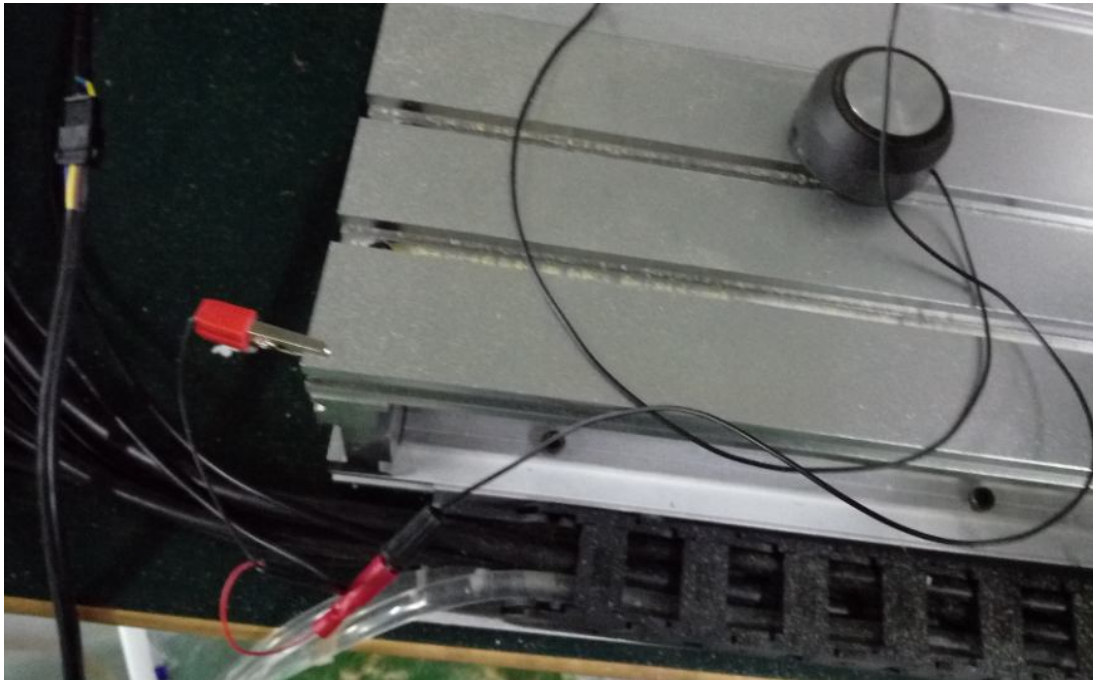
All above , The MACH3 installation and setting is finished.

Part 3 Start position setting

The start position setting is a important preparation before start work .

1 Confirm probe connection is correct





2 To confirm actual height of probe

Generally ,It is 26mm. The offset is actual height +0.5mm. For example ,The actual height is 26mm ,The offset is $26+0.5=26.5$ mm.



3 Test Probe

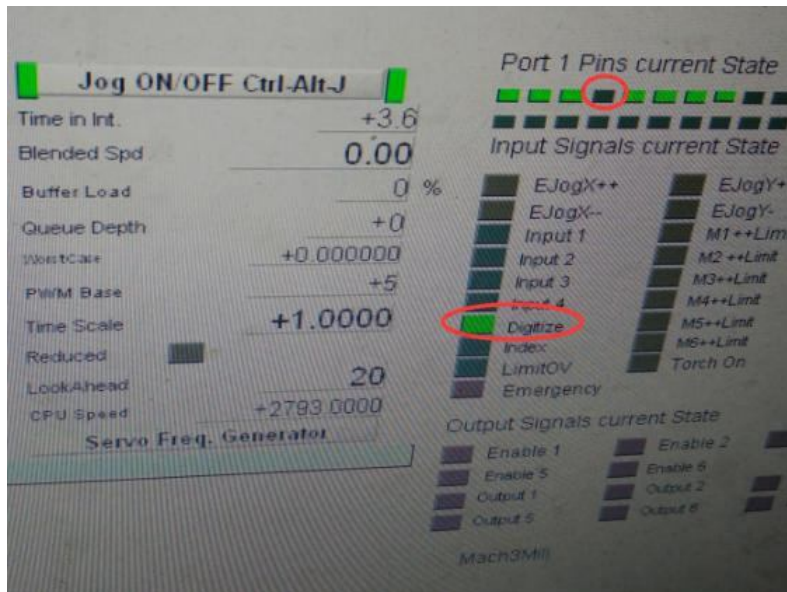
Click Diagnostics, Entry intoDiagnostics interface ,test the probe whether

is correct connection



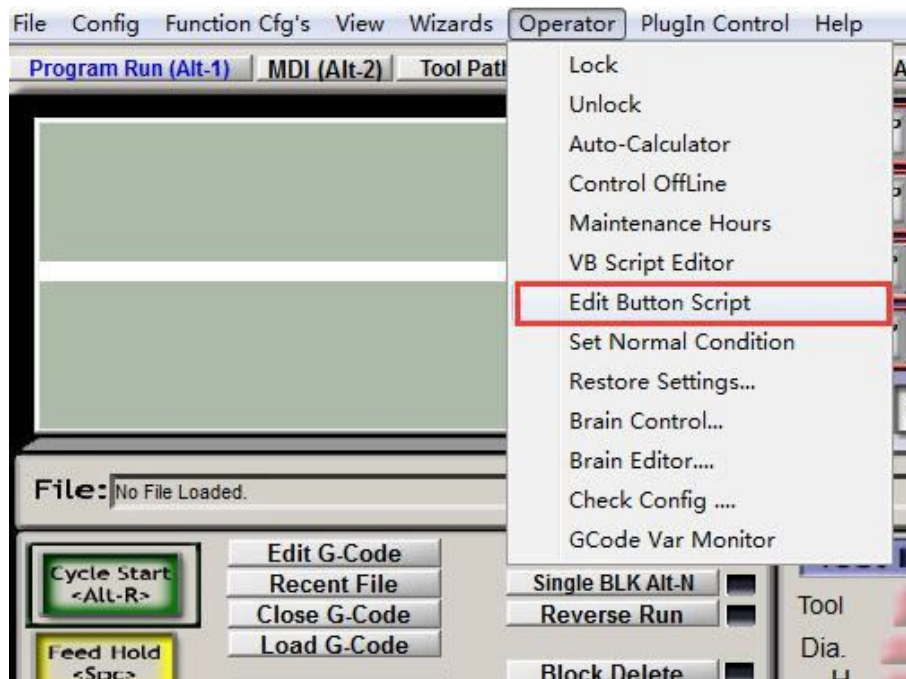
Then using probe to touch engraving bits ,The below one will get black ,and the other one will get light ,The test is finished ,it shows the probe hardware connection is correct.



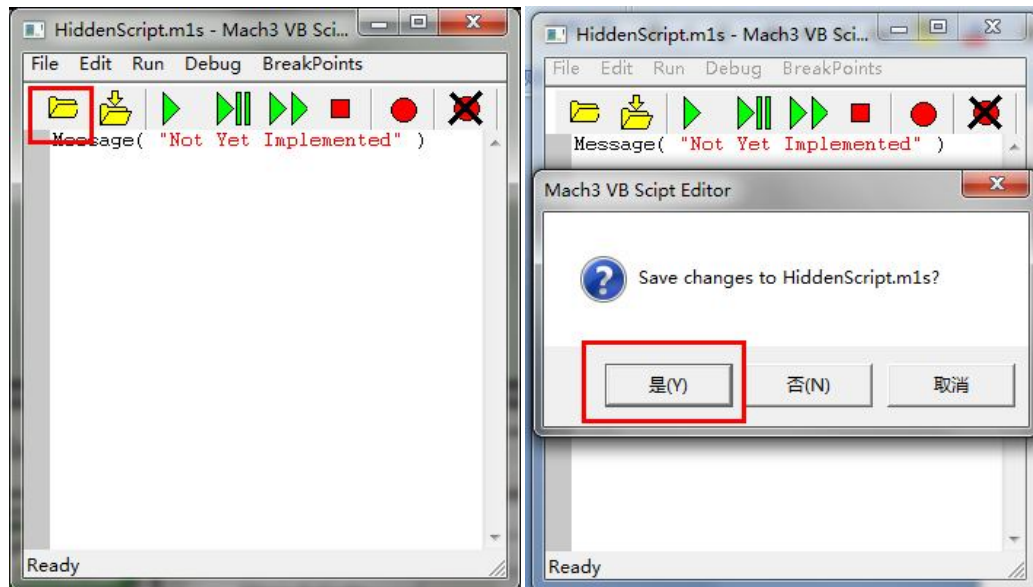


4 Button Script setting

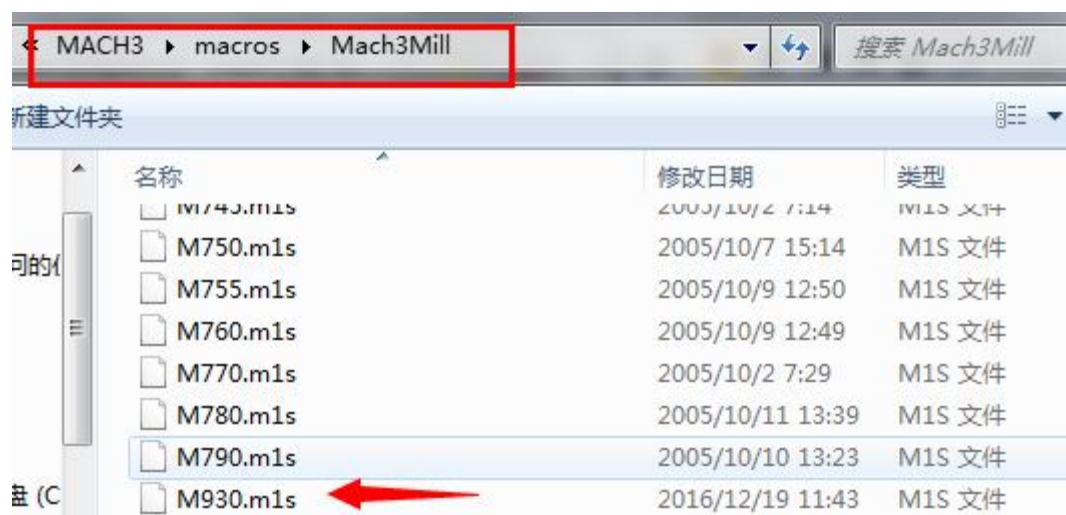
Then Click “Program Run (Alt-1)”, then click “Operator” and choose “Edit Button Script”, Then The Auto zero tool button will flash (Meanwhile other button also flash , ignore it)

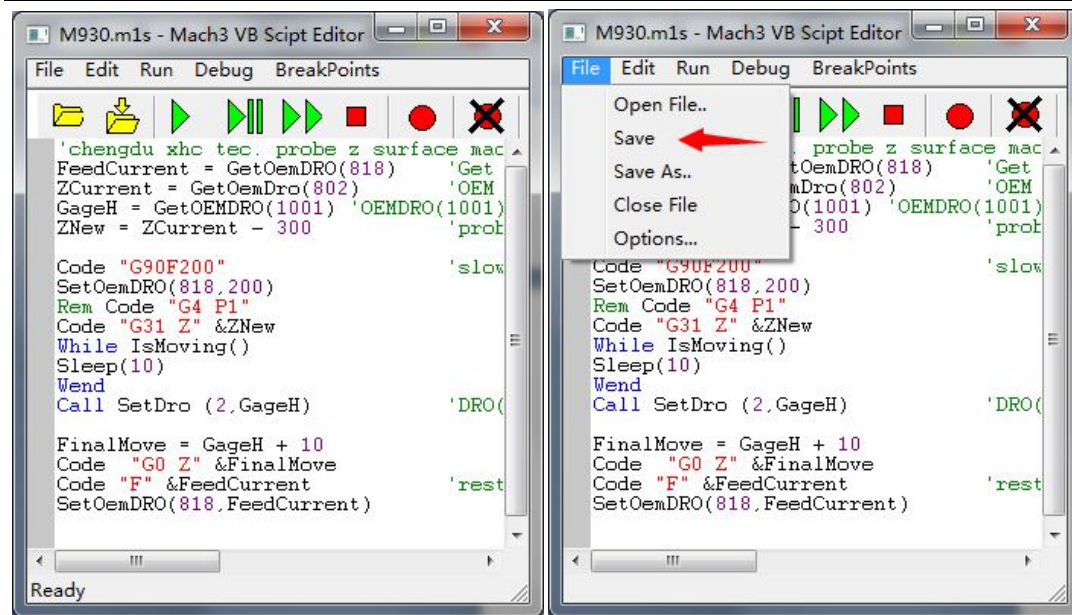


Click Auto zero tool button ,and enter into MACH3 VB script interface, and click open file ,and choose save.

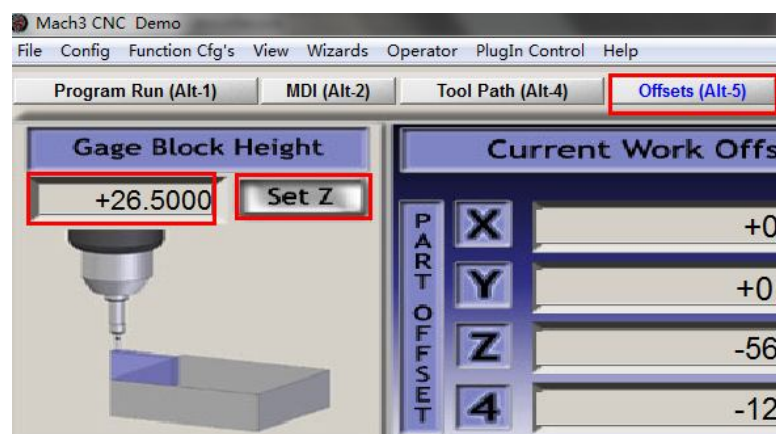


Then find M930.m1s file from MACH3/macros/Mach3mill,open it .





At last Click “Offsets(Alt-5)”,and change Gage Block Height to “26.5” which previous measured offset.

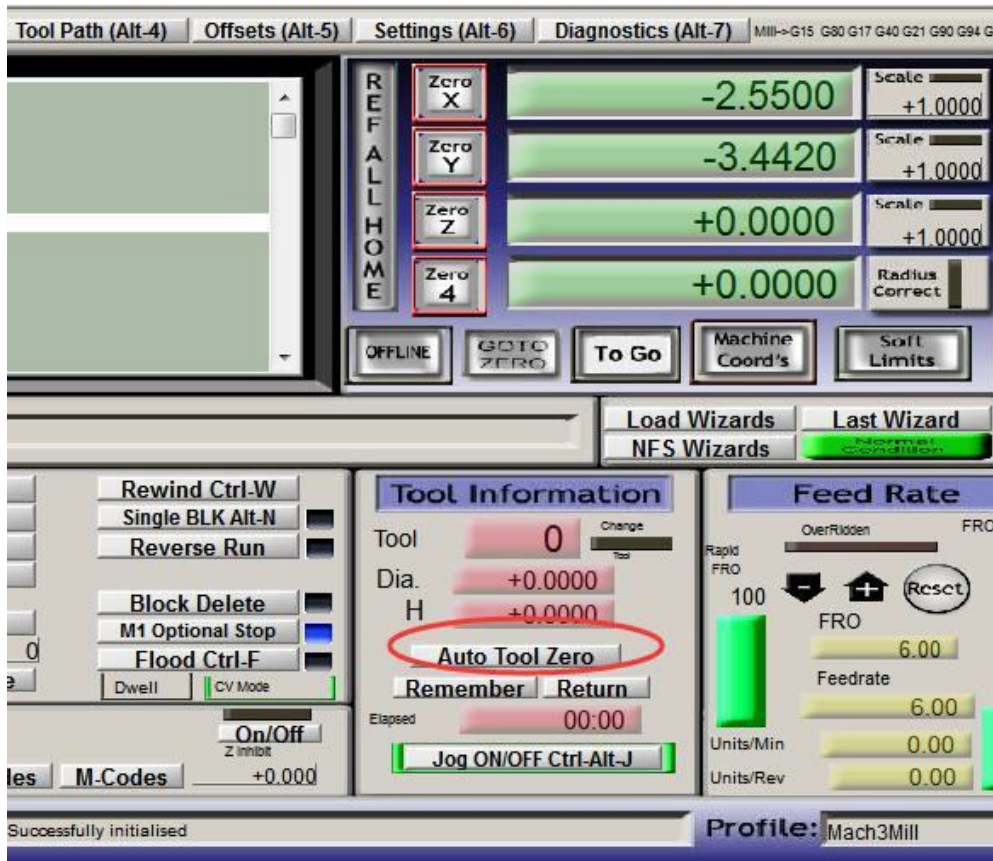


5 Select start position

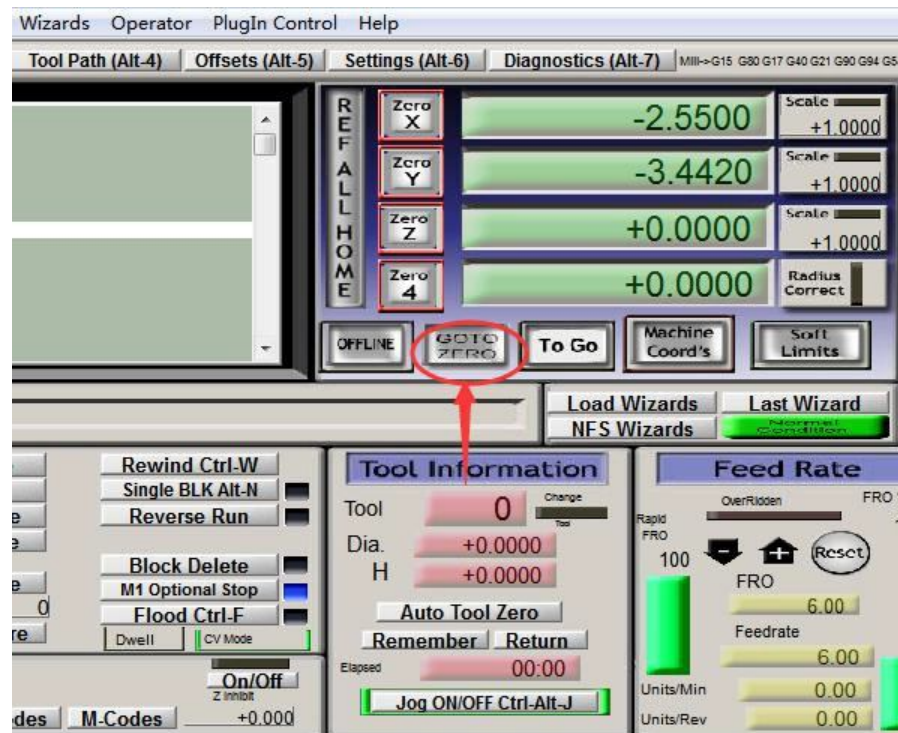
the spindle to the position where you want , Then cleaning X and Y Axis using Zero X , Zero Y .



Put probe under spindle again, click auto zero tool again , The Z Axis will automatic touch probe and return back , Meanwhile Z Axis will Automatic Zero Z .



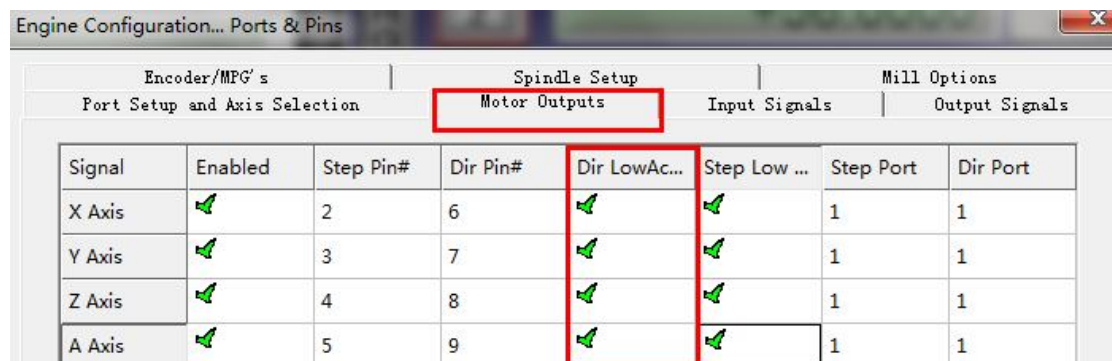
At last , Take probe away from work piece ,Click Goto Zero button ,The machine will automatic go to zero point. The start point setting is finished.



Part 4 FAQ

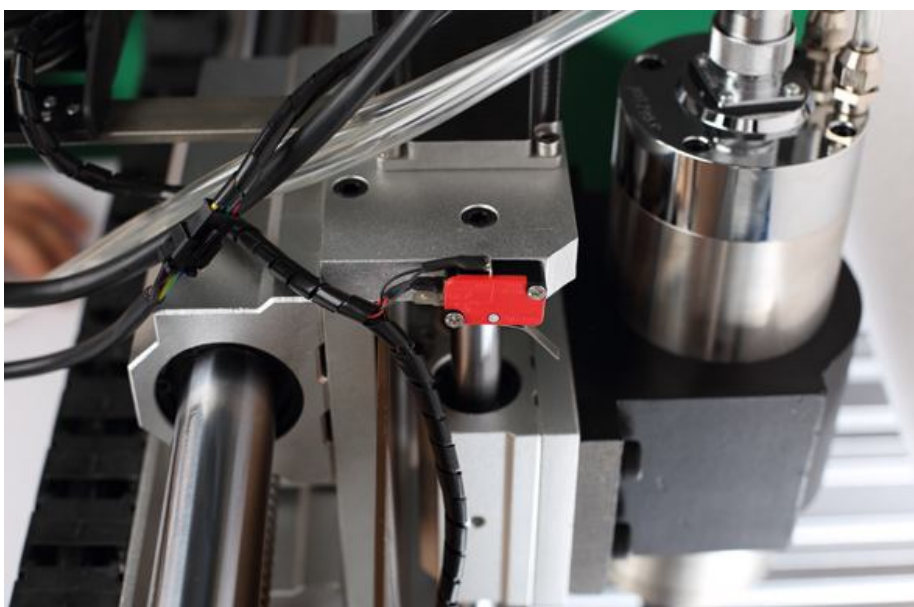
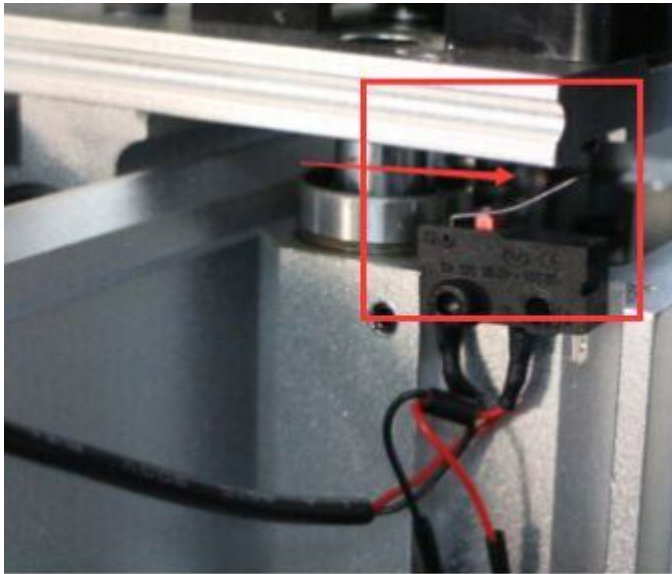
1.The Axis moving direction is wrong

Which Axis goes wrong direction , you change that Axis below Dir low active setting ,If home moving way reverse ,change Active low from ☒ to ☐ ,or change from ☐ to ☒.



2. Manual reset limit switch

All X Y Z has 2 limited switch . Once the Axis touch below limit switch ,Machine will stop work ,and reset button will get red in controller box . Then Manually Moving axis away from limit switch(switch off machine, easy to move) , press reset to make sure to get green at last restart machine to work .



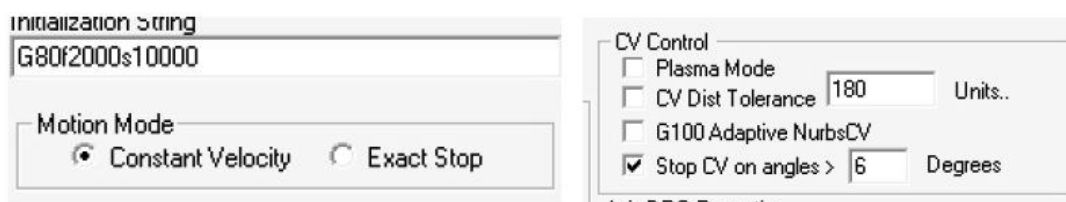
3. Package information

When unpack wooden box, some client thought machine lack accessories , That is misunderstanding .After you installed step motor ,The machine will be ready



4 Rectangle work to round

Enter into General Logic configuration , select Motion mode to constant Velocity , Select CV control stop CV on angles > 6 degrees as below:



5 USB motion card can be found by MACH3

Make sure USB cable connection is good ,make sure VFD has ground and input power of VFD has electrical filter to isolate noise.

6 How to ref all home

Firstly enable X Home ,Y Home ,Z Home , and confirm setting is correct.

Engine Configuration... Ports & Pins

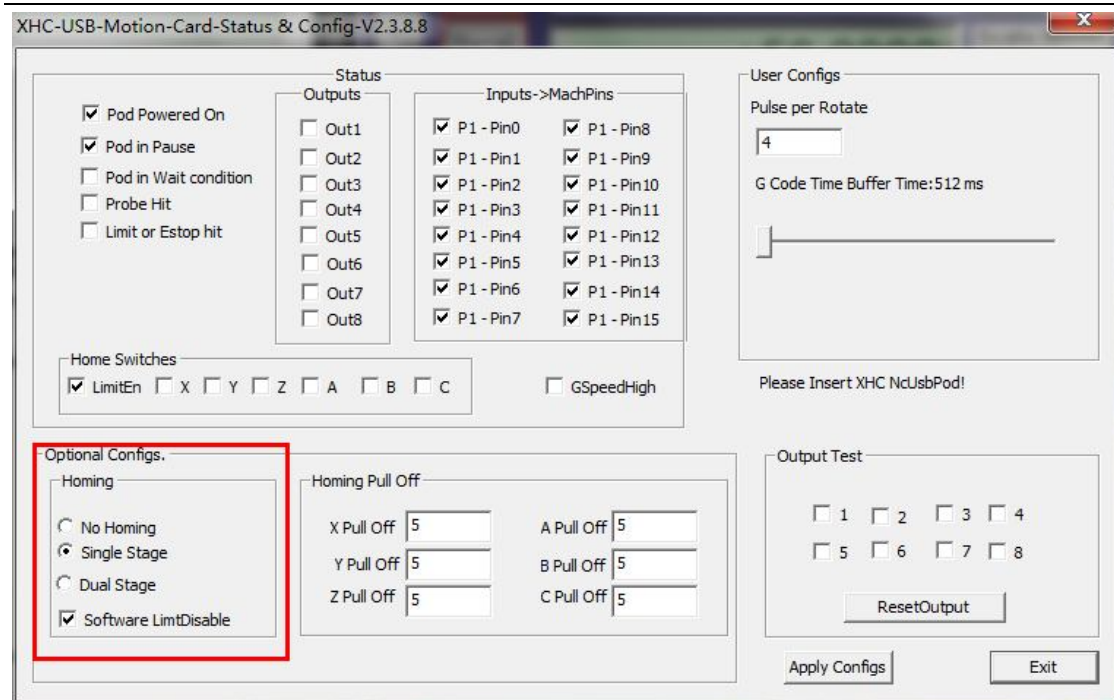
Encoder/MPG's		Spindle Setup		Mill Options		
Port Setup and Axis Selection		Motor Outputs		Input Signals	Output	
Signal	Enabled	Port #	Pin Number	Active Low	Emulated	HotKey
X ++		1	0			0
X --		1	0			0
X Home		1	0			0
Y ++		1	1			0
Y --		1	1			0
Y Home		1	1			0
Z ++		1	2			0

Engine Configuration... Ports & Pins

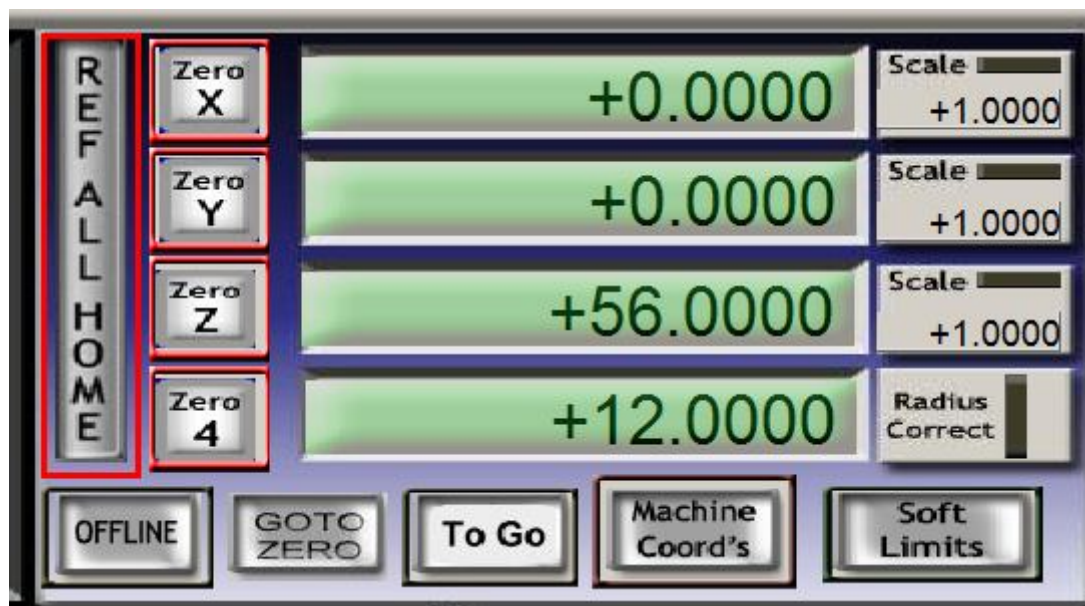
Encoder/MPG's		Spindle Setup		Mill Options		
Port Setup and Axis Selection		Motor Outputs		Input Signals	Output Signal	
Signal	Enabled	Port #	Pin Number	Active Low	Emulated	HotKey
X Home		1	0			0
Y ++		1	1			0
Y --		1	1			0
Y Home		1	1			0
Z ++		1	2			0
Z --		1	2			0
Z Home		1	2			0

Pins 10-13 and 15 are inputs. Only these 5 pin numbers may be

Secondly ,Confirm plugin setting correct ,especially ,Choose single stage



At last ,click ref all home button in MACH3.



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