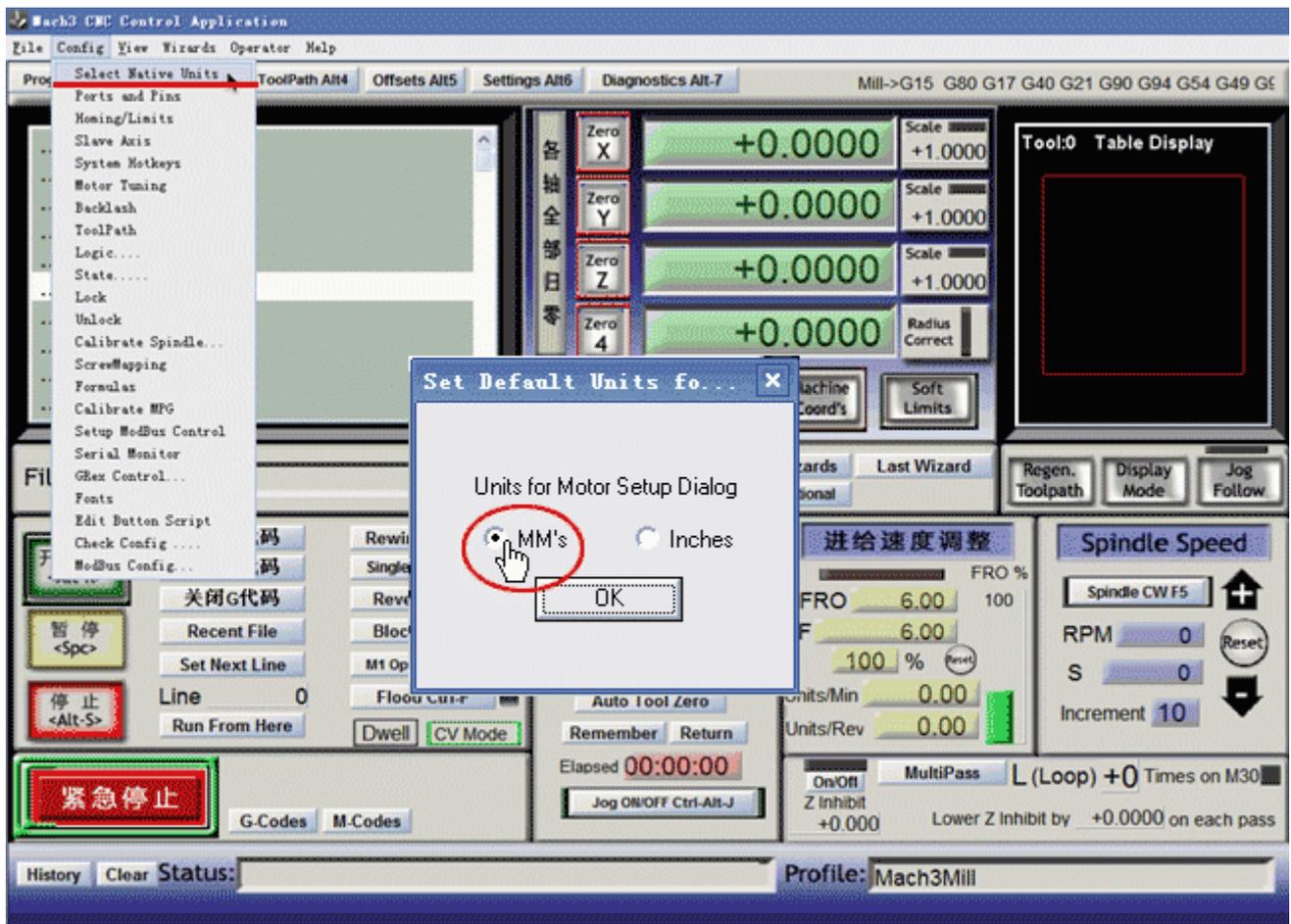


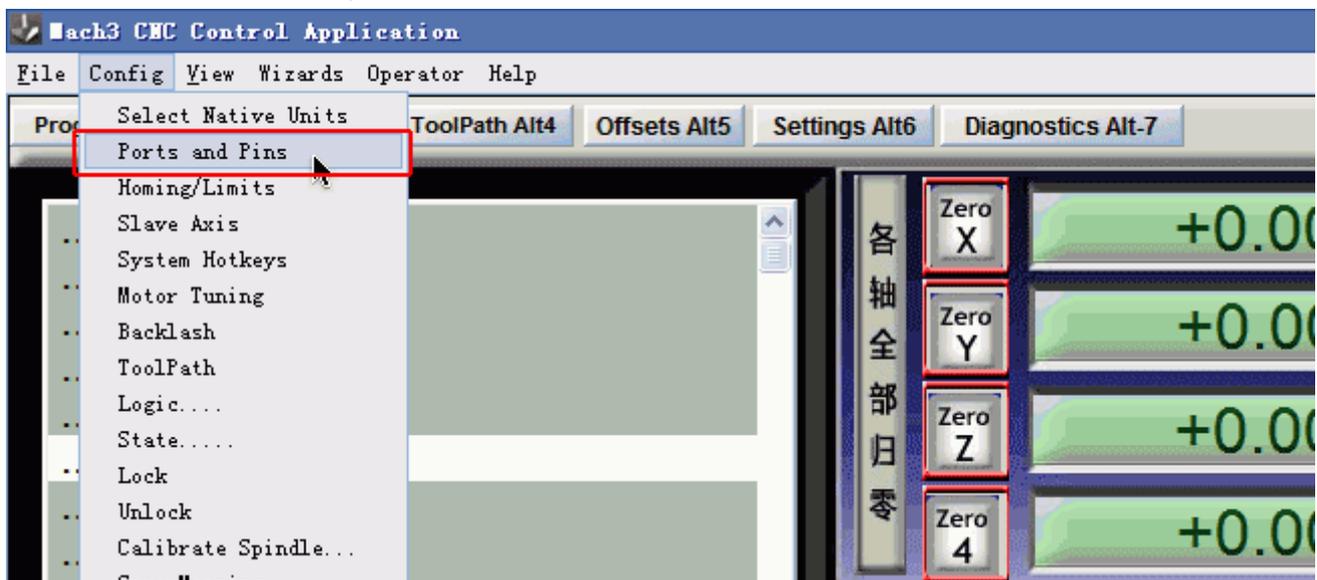
How to set the MACH3 software

1. After restarting the PC, choose the **MACH 3 MILL icon** on the desktop to start the Mach 3.

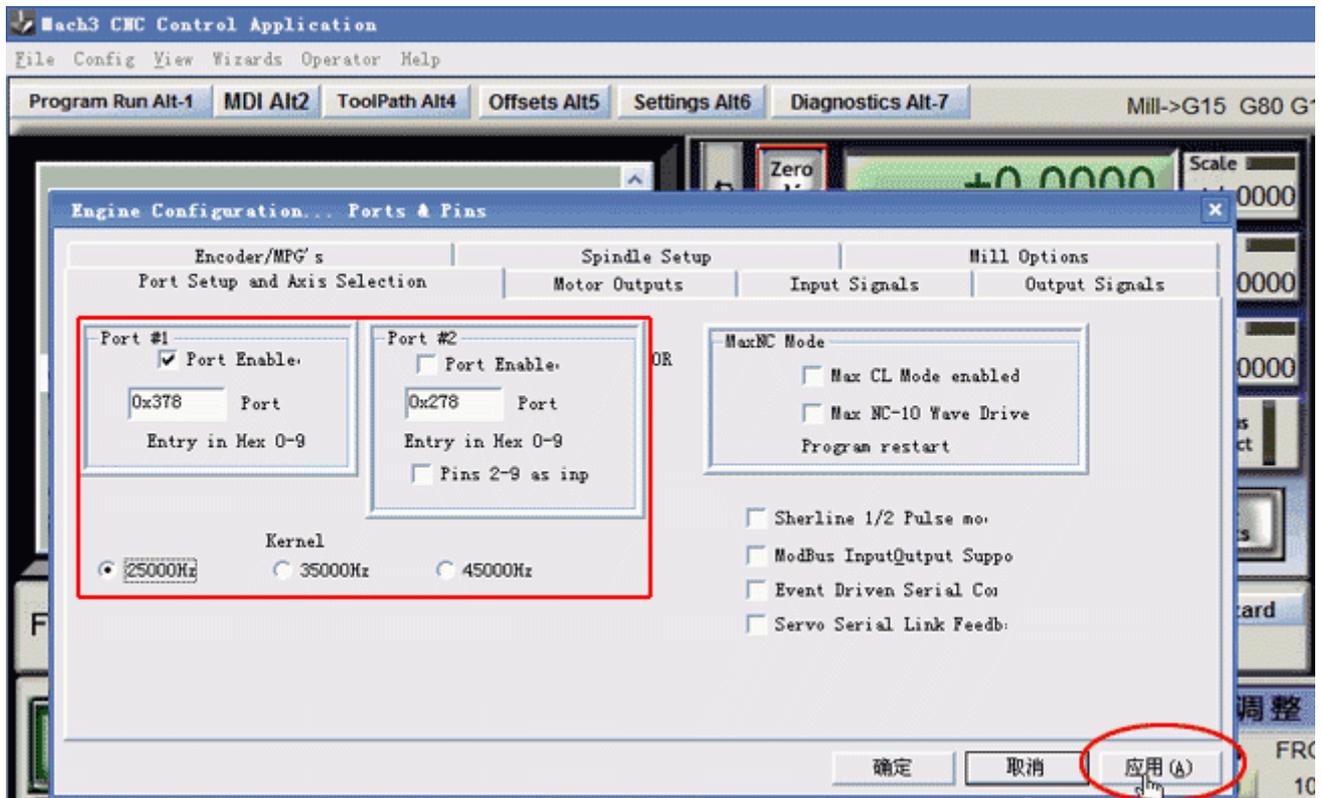
2. Open the “Config -- select Native Units” menu, then choose the “MM’s”



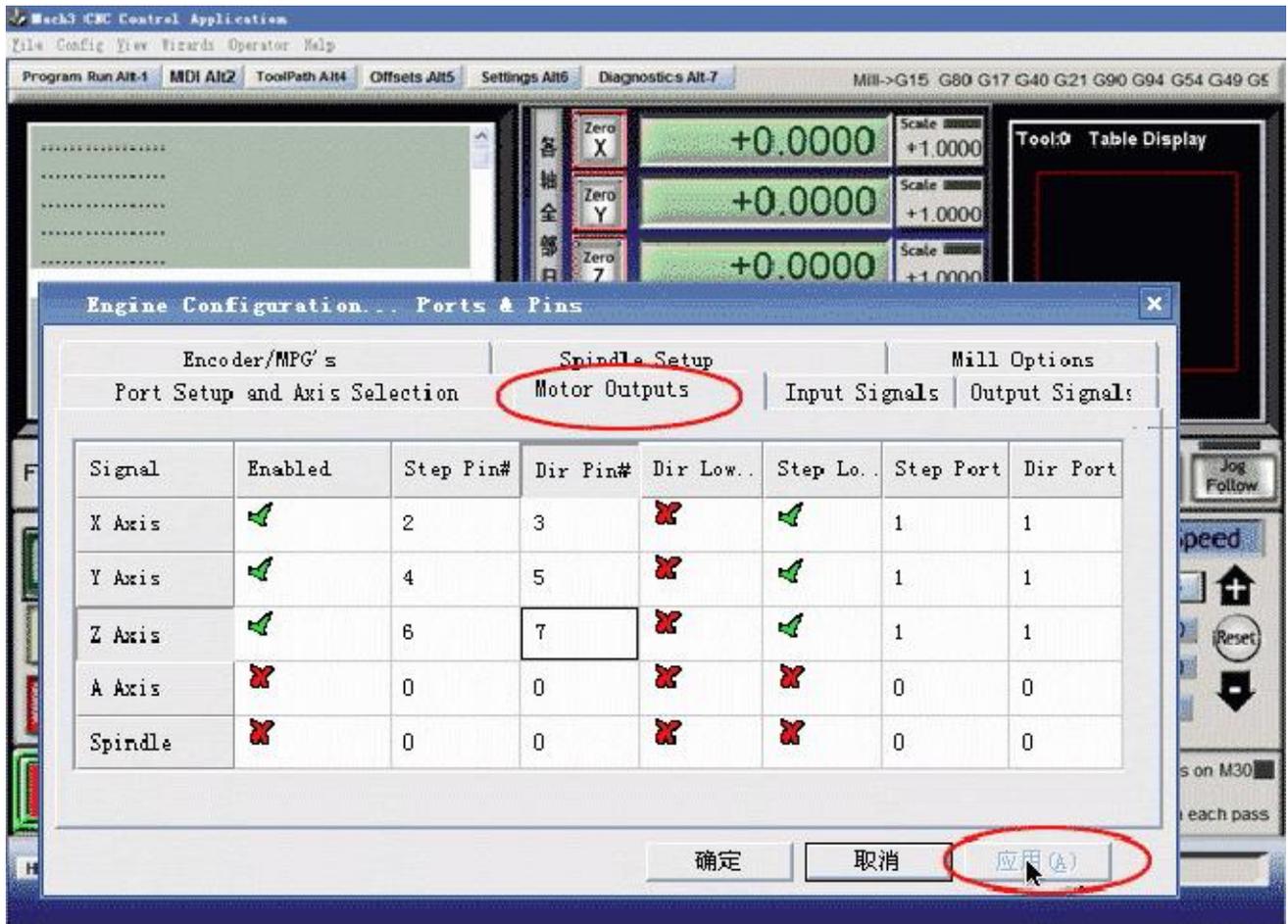
3. See as below, open "Config--Ports and Pins" to enter the setup.



4. To check whether all the data is same as the follows in the big red circle and then choose OK to continue.



5. Click "Motor Outputs" to setup the Pin of the stepper motor as follow



This part is very important, please check your setup is as same as the data above. Even a small error will cause the machine working incorrectly. Do not forget to save the setup.

Remark:

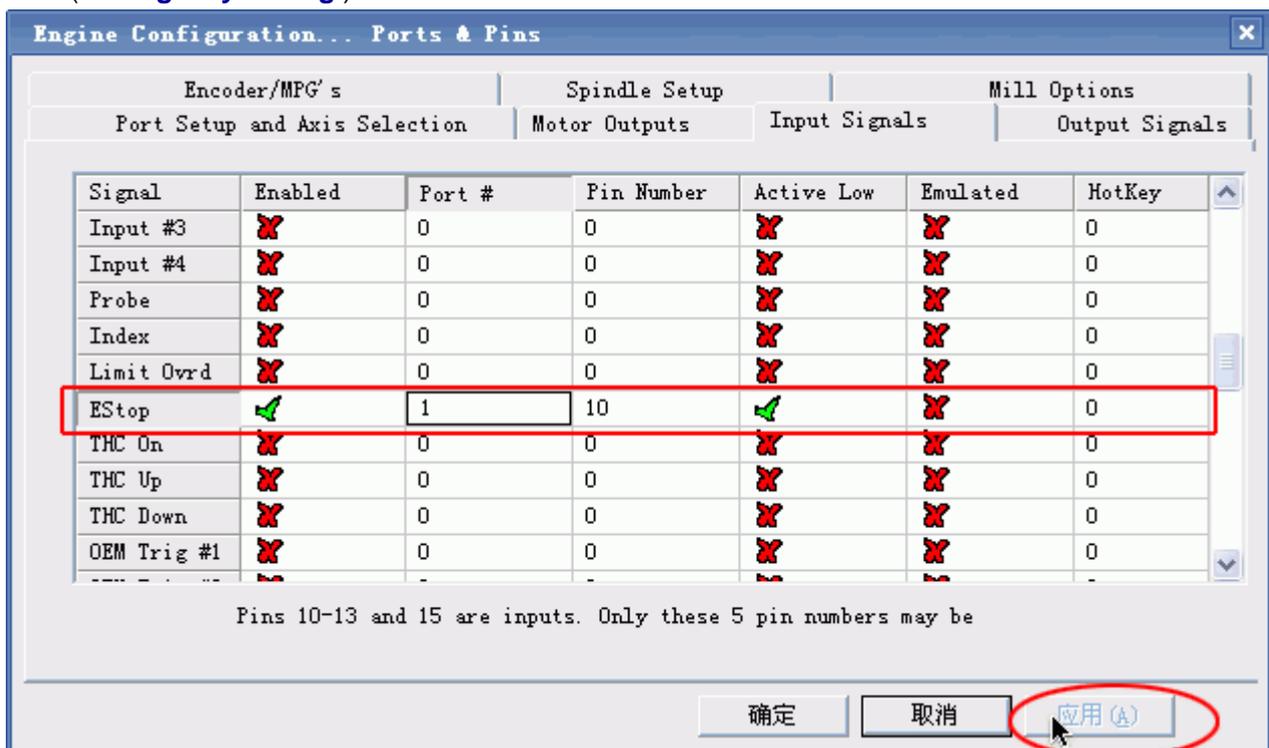
(1). If you want to use the 4th axis(A axis), you can setup the A axis data as follows:

A Axis	✔	8	9	✘	✘	1	1
--------	---	---	---	---	---	---	---

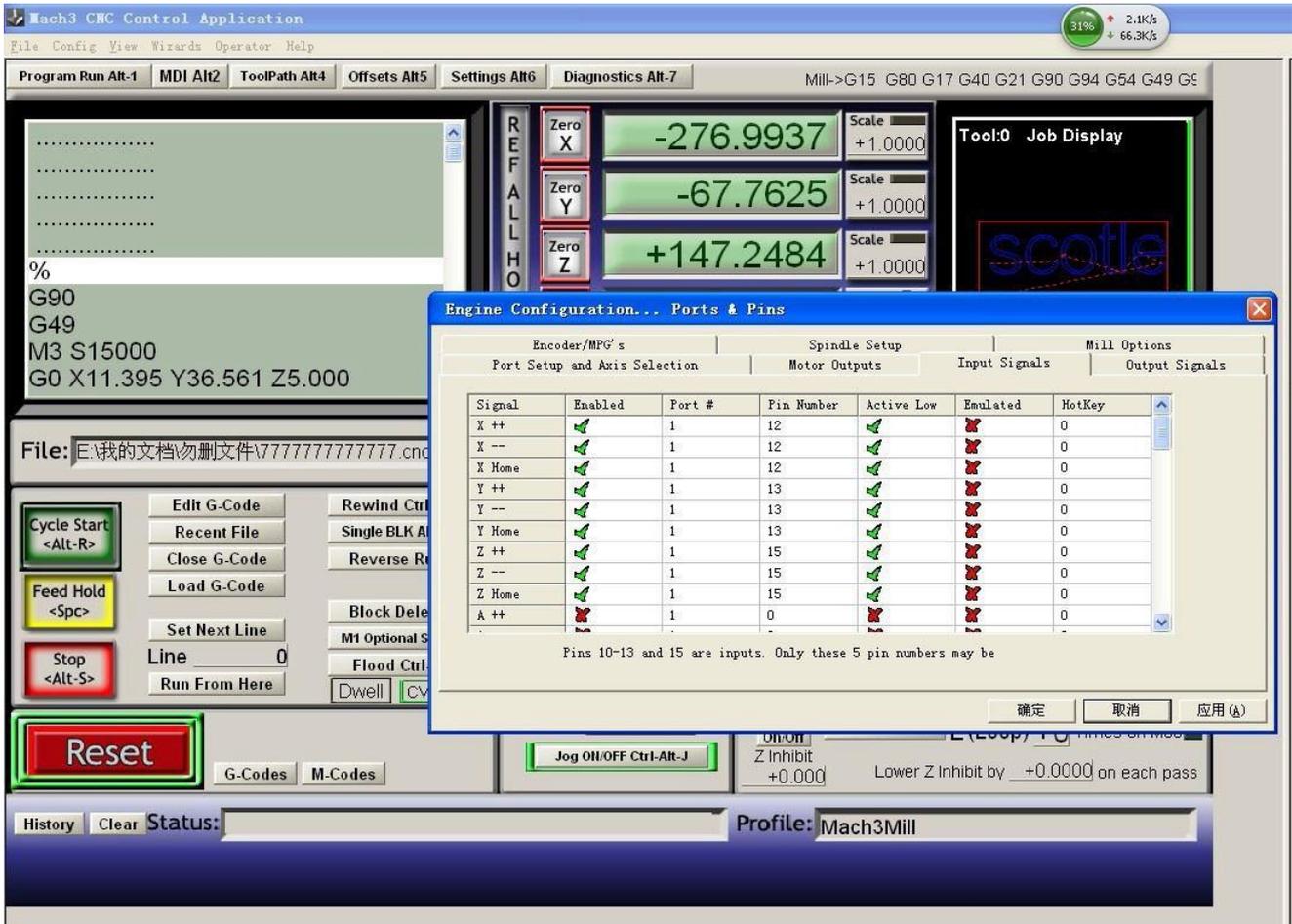
(2). "Dir Low Active" This choice is to set up the Direction of the motor, if you find the running direction of the axis is inverse, you can choose the "Dir Low Active" to change the direction and then save the setup. As below picture:



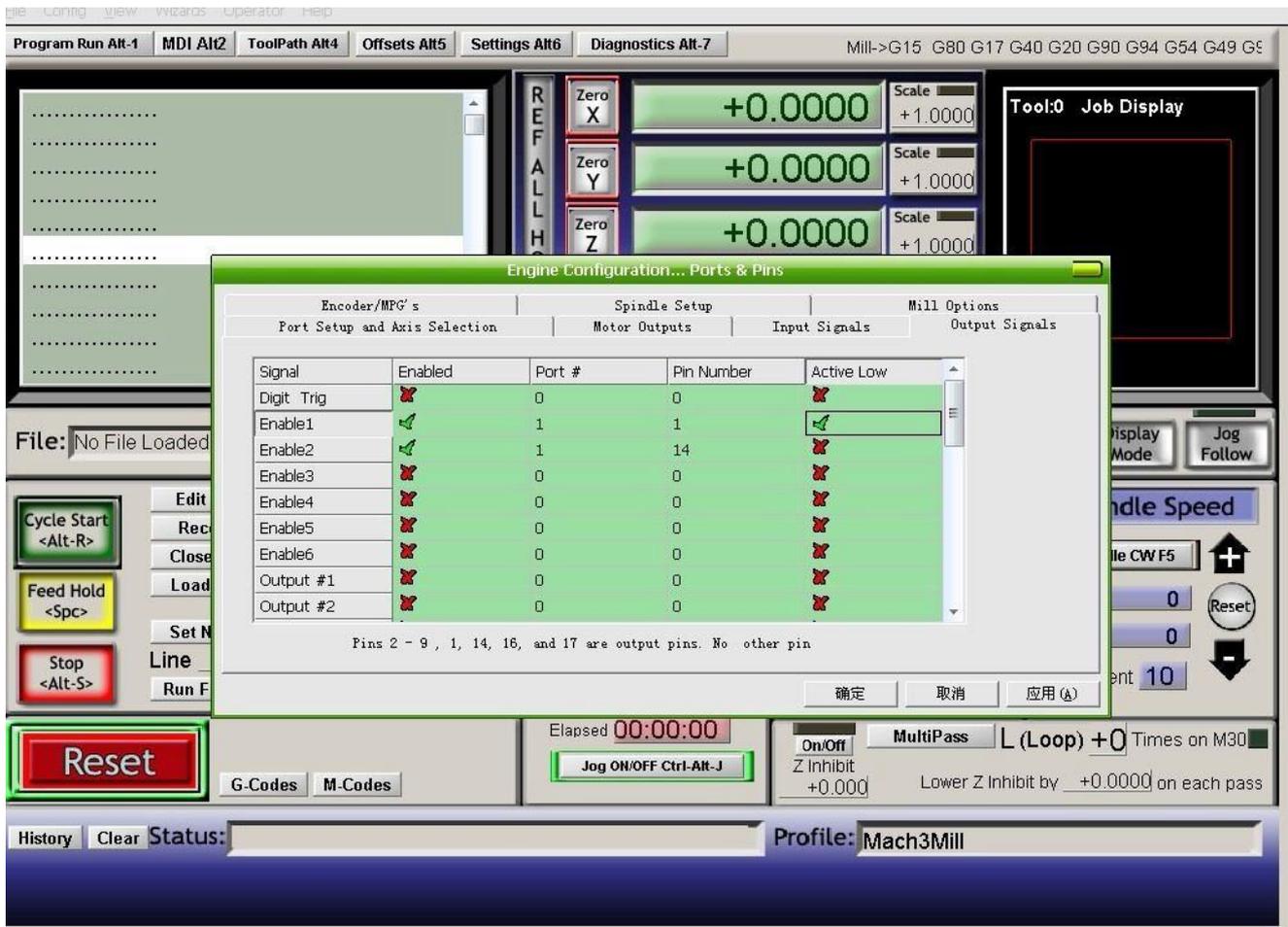
6. The clients who bought the Control box from us, need to setup the E-stop signal, still in “Ports and Pins” menu to click “Input Signals” to find the “Estop”, then setup as follow, final apply and then save. (**Emergency setting**)



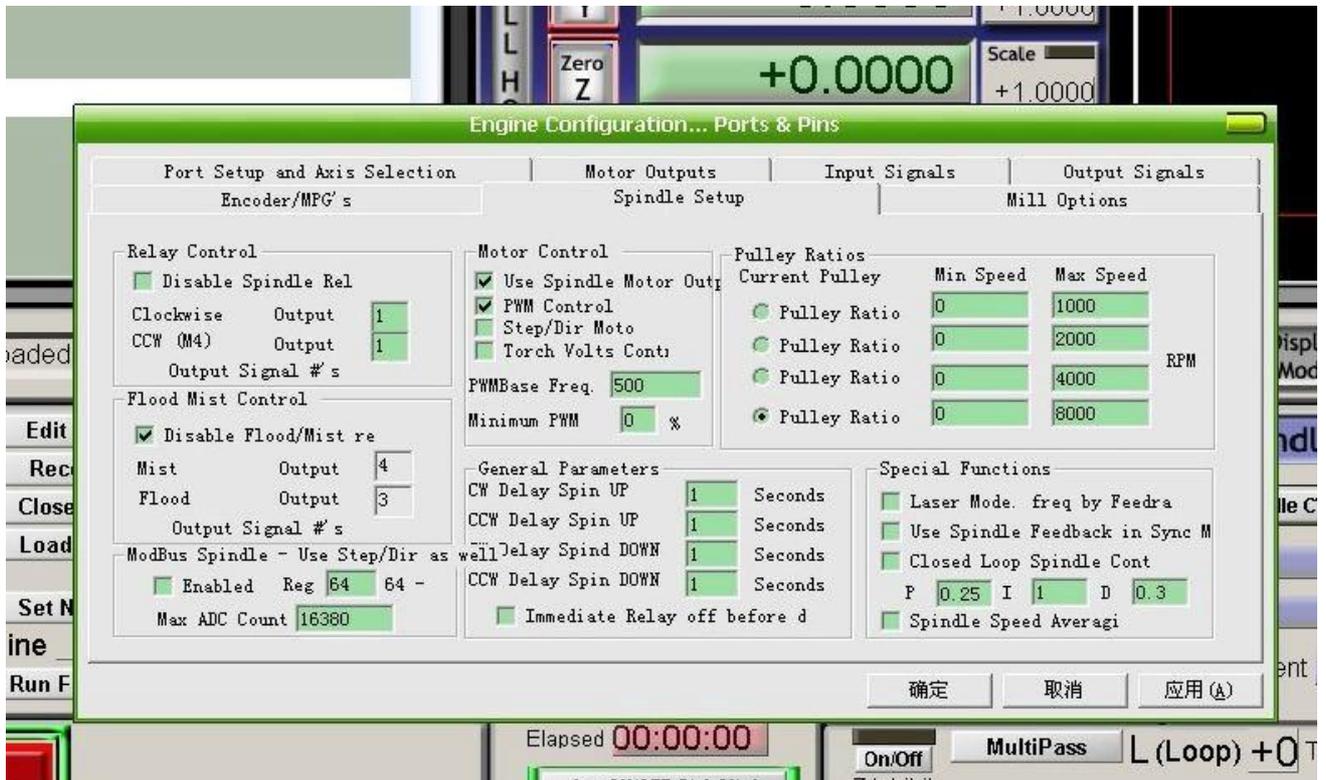
7. Limited Switch Setting in “Ports and Pins” menu to click “Input Signals” and set X, Y, Z as below:



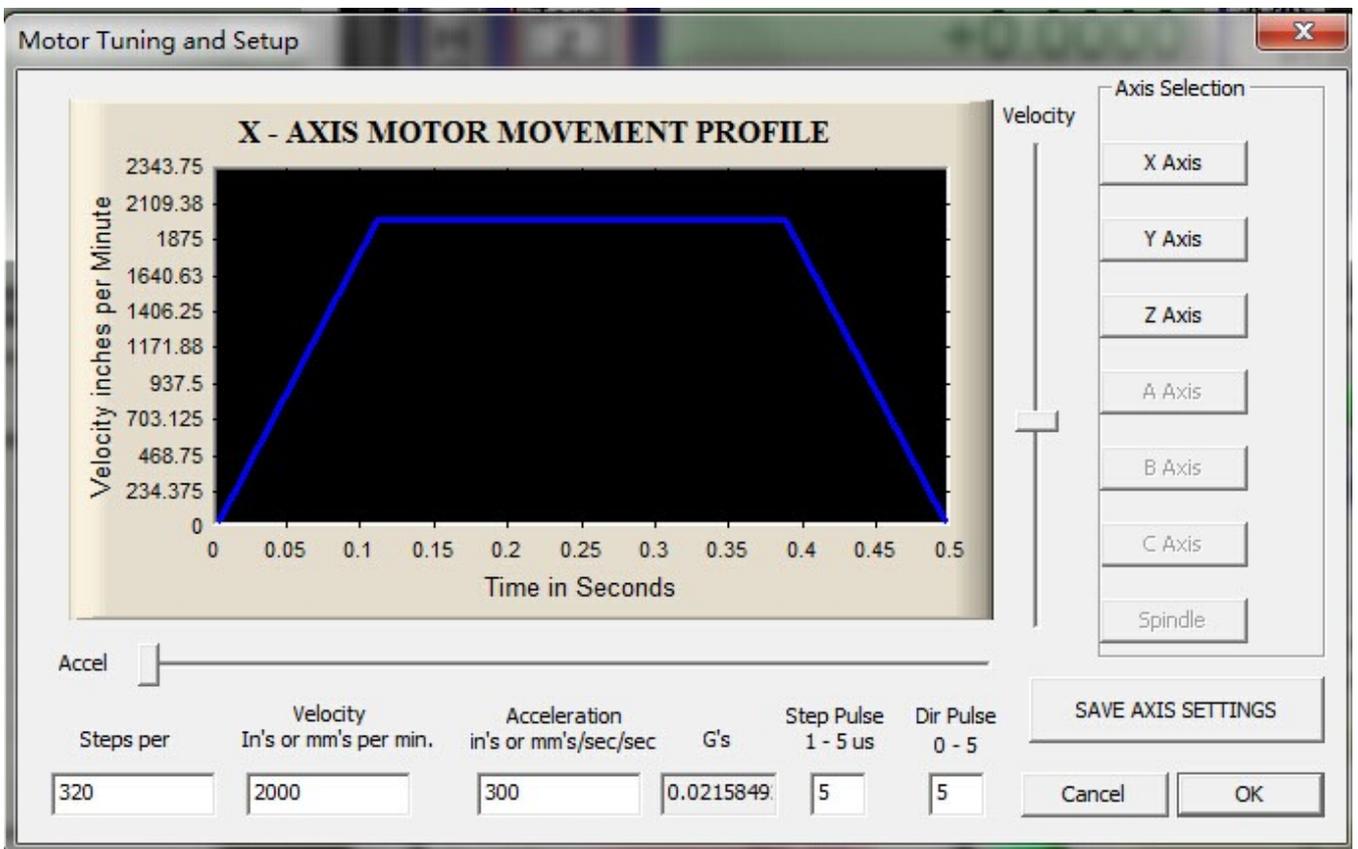
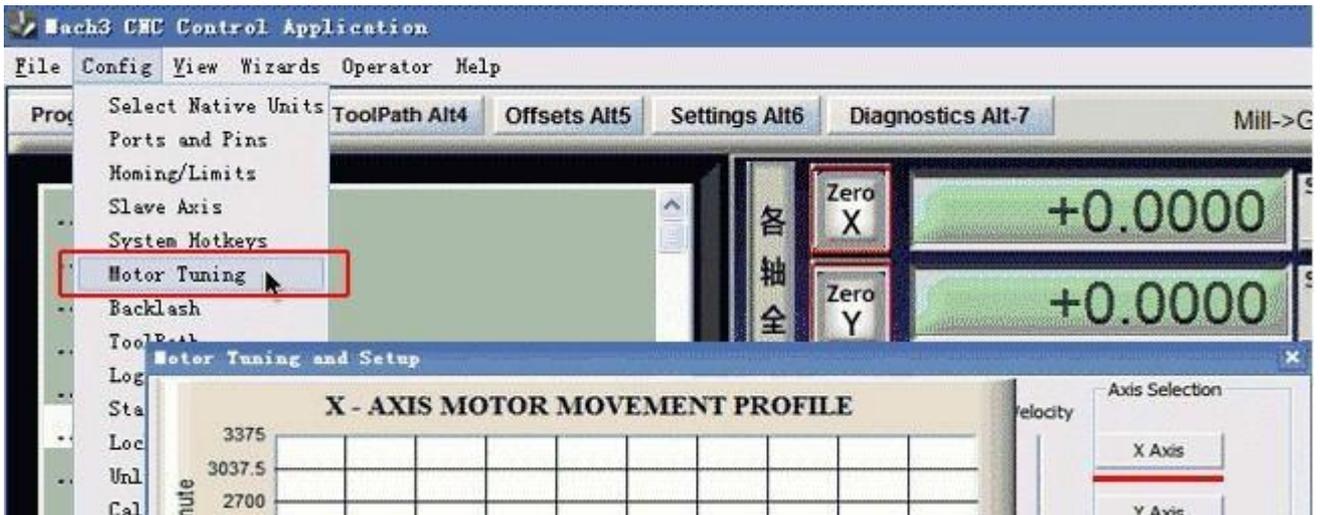
8. Output signals setting in "Ports and Pins" menu to click "Output Signals", set as below, and then save.



9. Spindle setup in “Ports and Pins” menu to click “Spindle Setup”, set as below, and then save.



10. The setup of the Stepper motor: Config-- Motor Tuning--- X Axis---setup the X axis as follows---then“SAVEAXIS SETTINS”, then s etup the Y axis and Z axis,final click “OK”. **X Axis, Y Axis, Z Axis parameters should the same.**



The setup is over, Please close the Mach software that all data setup can be available. And then open it again to check whether all the data is correct otherwise can't run your machine well.