

General Logic Configuration

G20,G21 Control

☐ Lock DRO's to setup units

Tool Change

- ☒ Ignore Tool Change
☐ Stop Spindle. Wait for Cycle Start.
☐ AutoTool Changer

Angular Properties

Unchecked for Linear

- ☐ A-Axis is Angular
☒ B-Axis is Angular
☒ C-Axis is Angular

Pgm End or M30 or Rewind

- ☐ Turn off all outputs
☐ E-Stop the system
☒ Perform G92.1
☐ Remove Tool Offset
☒ Radius Comp Off
☒ Turn Off Spindle

M01 Control

- ☒
- Stop on M1 Command

Serial Output

ComPort # BaudRate

- ☒
- 8-Bit 1 Stop
- ☐
- 7 Bit 2-Stop

Program Safety

- ☐
- Program Safety Lockout

This disables program translation while the External Activation #1 input is activated.

Editor

GCode Editor

Browse

Startup Modals

- ☐
- Use Init String on ALL "Resets"

Initialization String

Motion Mode

- ☒
- Constant Velocity
- ☐
- Exact Stop

Distance Mode

- ☒
- Absolute
- ☐
- Inc

IJ Mode

- ☐
- Absolute
- ☒
- Inc

Active Plane of Movement

- ☒
- X-Y
- ☐
- Y-Z
- ☐
- X-Z

Jog Increments in Cycle Mode

Position 1	<input type="text" value="1"/>
	<input type="text" value="0.1"/>
	<input type="text" value="0.01"/>
	<input type="text" value="0.001"/>
Use 999 to indicate a	<input type="text" value="0.0001"/>
Continuous Jog selection.	<input type="text" value="1"/>
	<input type="text" value="0.1"/>
	<input type="text" value="0.01"/>
	<input type="text" value="0.001"/>
Position 10	<input type="text" value="0.0001"/>

Shuttle Wheel Setting

Shuttle Accel.

Seconds

General Configuration

- ☐ Z is 2.5D on Output #6
☒ Home Sw. Safety

LookAhead

 Lines

- ☐ UDP Pendant Control
☐ Run Macro Pump
☐ ChargePump On in EStop
☒ Persistent Jog Mode.
☒ FeedOverride Persist
☐ No System Menu in Mach3
☒ Use Key Clicks
☐ Home Slave with Master Axis
☐ Include TLO in Z from G31

Rotational

- ☐ Rot 360 rollover
☐ Ang Short Rot on G0
☒ Rotational Soft Limits

Screen Control

- ☐ Hi-Res Screens
☒ Boxed DRO's and Graphics
☐ Auto Screen Enlarge
☒ Flash Errors and comments.

Inputs Signal Debouncing/Noise rejection

Debounce Interval: x 40usIndex Debounce

- ☐ Disable Gouge/Concavity Checks
☐ G04 Dwell in ms
☒ Use WatchDogs
☐ Debug This Run
☒ Enhanced Pulsing
☐ Allow Wave Files
☐ Allow Speech
☐ Set Charge Pump to 5Khz for Laser standby level
☐ No FRO on Queue

 Turn Manual Spindle Incr. Spindle OV increment

CV Control

- ☐ Plasma Mode
☒ CV Dist Tolerance Units..
☒ G100 Adaptive NurbsCV
☐ Stop CV on angles > Degrees

Axis DRO Properties

- ☐ Tool Selections Persistent.
☒ Optional Offset Save
☒ Persistent Offsets
☐ Persistent DROs
☒ Copy G54 from G59.253 on startup

OK

History

Clear

Mach3

MaquiMach3Mill