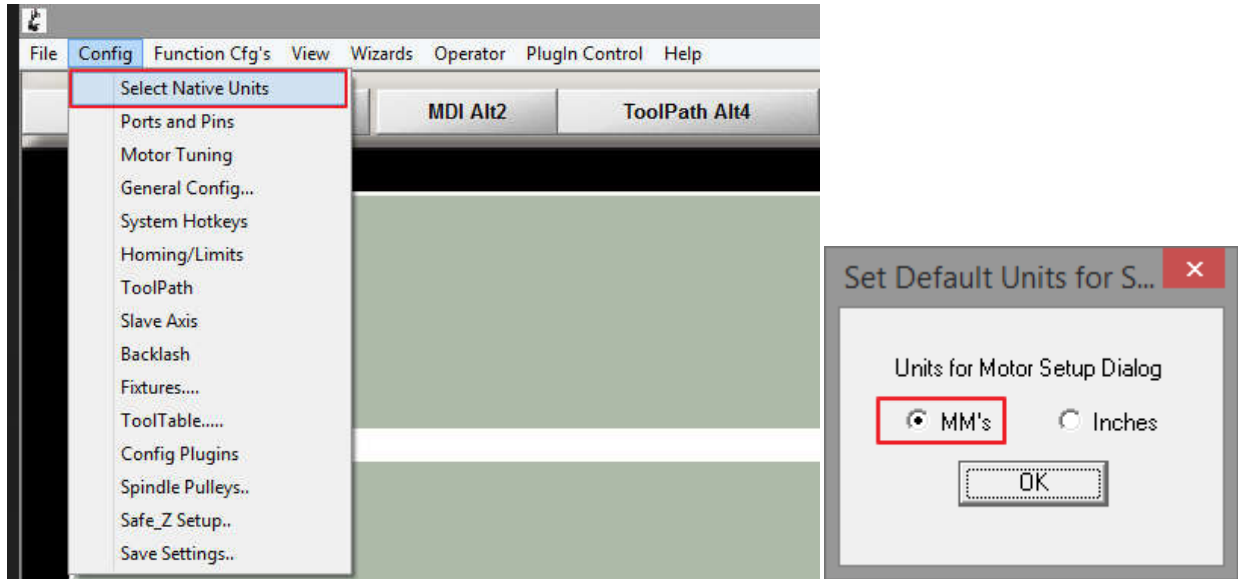
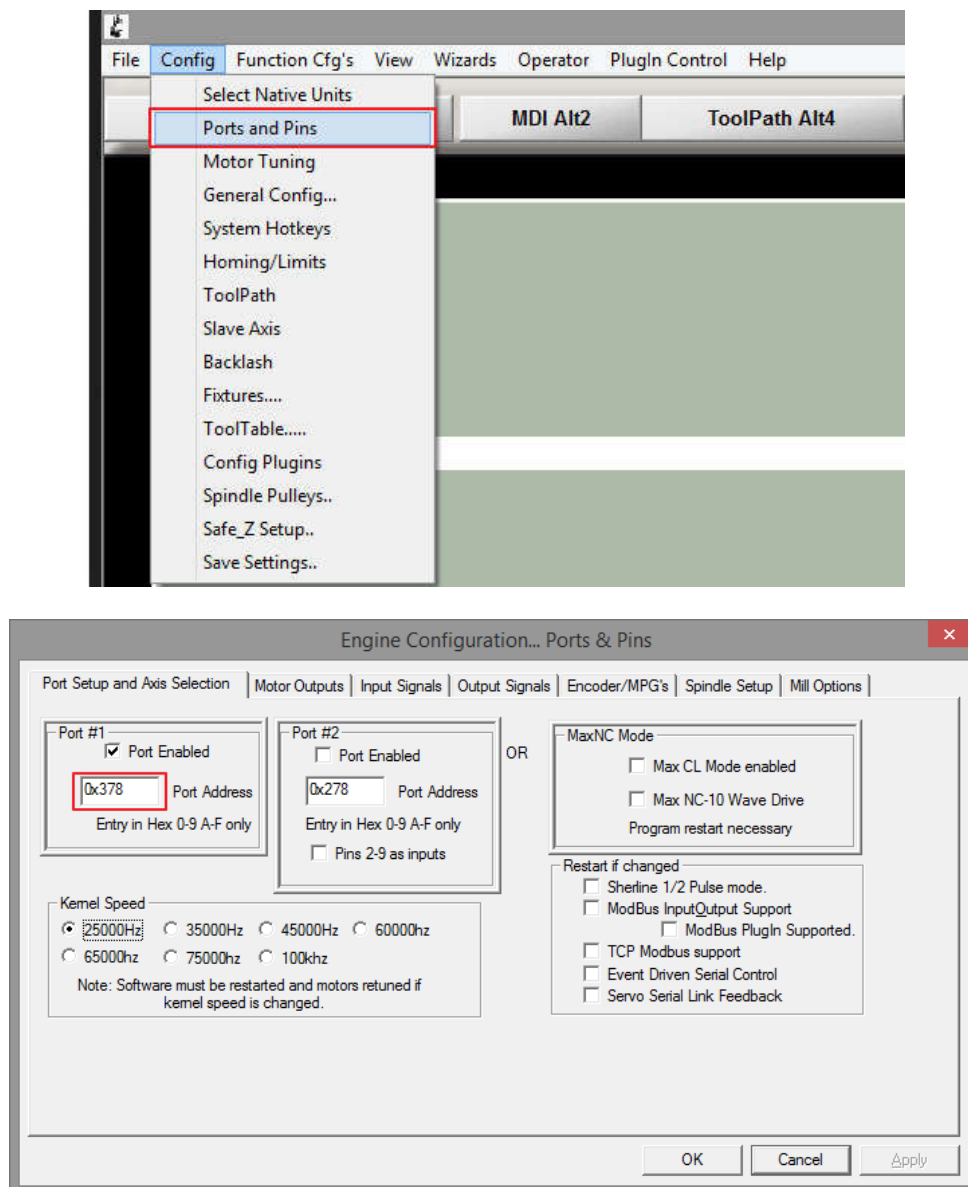


Mach3 Config Guide

1. Config --> Select Native Units



2. Config --> Ports and Pins



Engine Configuration... Ports & Pins

Port Setup and Axis Selection | Motor Outputs | Input Signals | Output Signals | Encoder/MPG's | Spindle Setup | Mill Options

Signal	Enabled	Step Pin#	Dir Pin#	Dir LowActi...	Step Low A...	Step Port	Dir Port
X Axis		2	3			1	1
Y Axis		4	5			1	1
Z Axis		6	7			1	1
A Axis		8	9			1	1
B Axis		0	0			0	0
C Axis		0	0			0	0
Spindle		0	0			0	0

OK Cancel Apply

Engine Configuration... Ports & Pins

Port Setup and Axis Selection | Motor Outputs | Input Signals | Output Signals | Encoder/MPG's | Spindle Setup | Mill Options

Signal	Enabled	Port #	Pin Number	Active Low	Emulated	HotKey
Input #3		1	0			0
Input #4		1	0			0
Probe		1	13			0
Index		1	0			0
Limit Ovrd		1	0			0
EStop		0	10			0
THC On		1	0			0
THC Up		1	0			0
THC Down		1	0			0

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

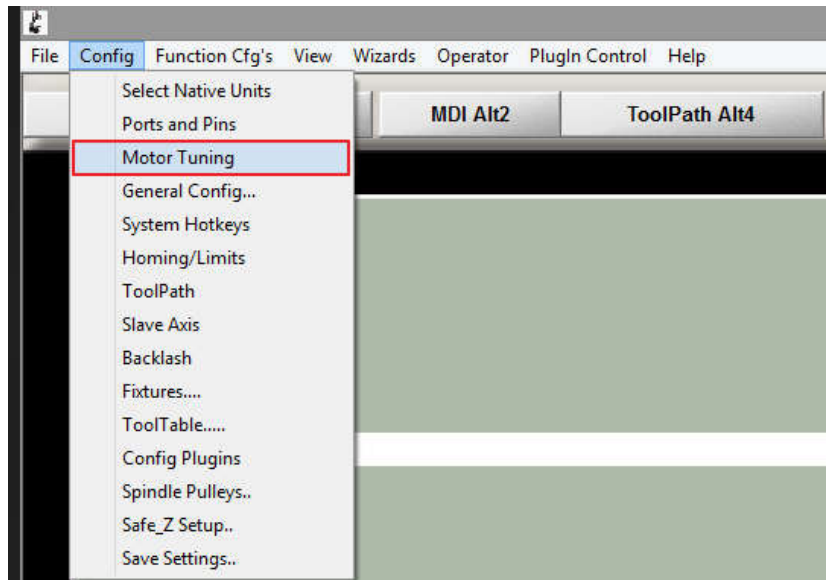
Automated Setup of Inputs

OK Cancel Apply

Note :: If you not finish wiring e-stop button then port# need to set to 0

If you already wiring e-stop button then port# need to set to 1

3.Config --> Motor Tuning



X-Axis ::

Steps per = 160 , Velocity = 3200 , Acceleration = 100 , Step Pulse = 5 , Dir Pulse = 5

Y-Axis ::

Steps per = 160 , Velocity = 3200 , Acceleration = 100 , Step Pulse = 5 , Dir Pulse = 5

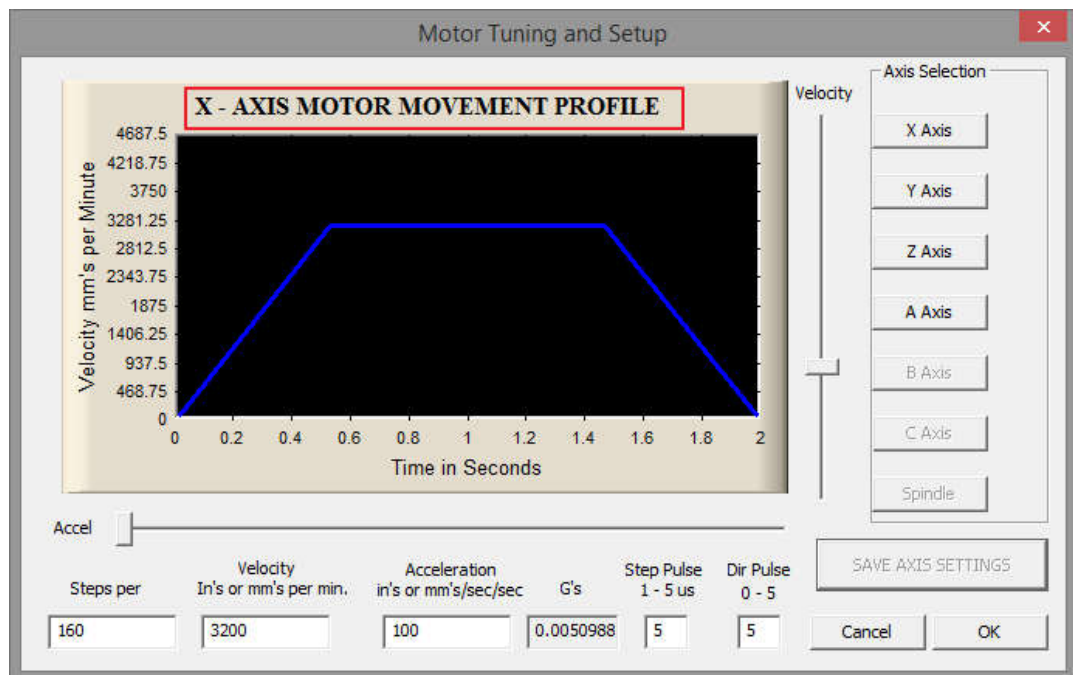
Z-Axis ::

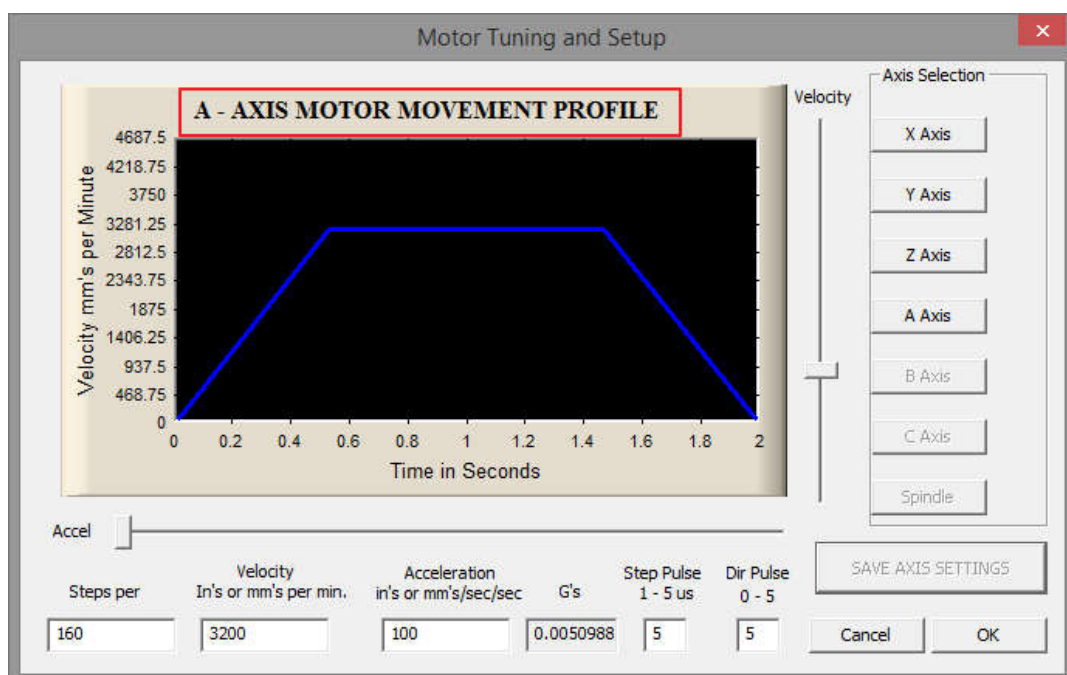
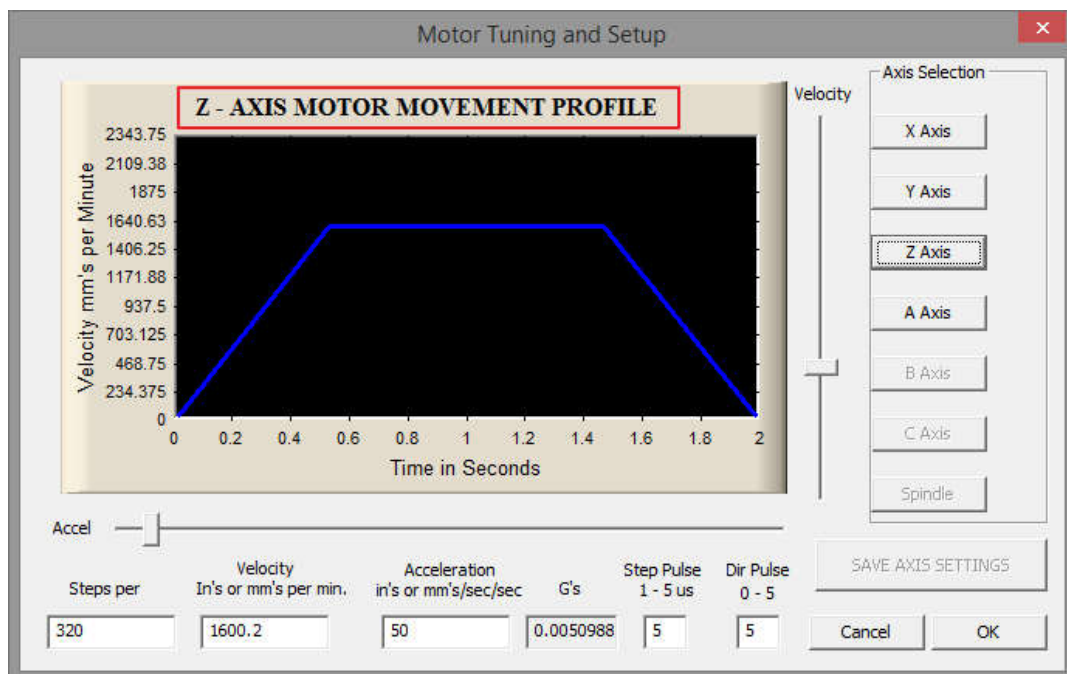
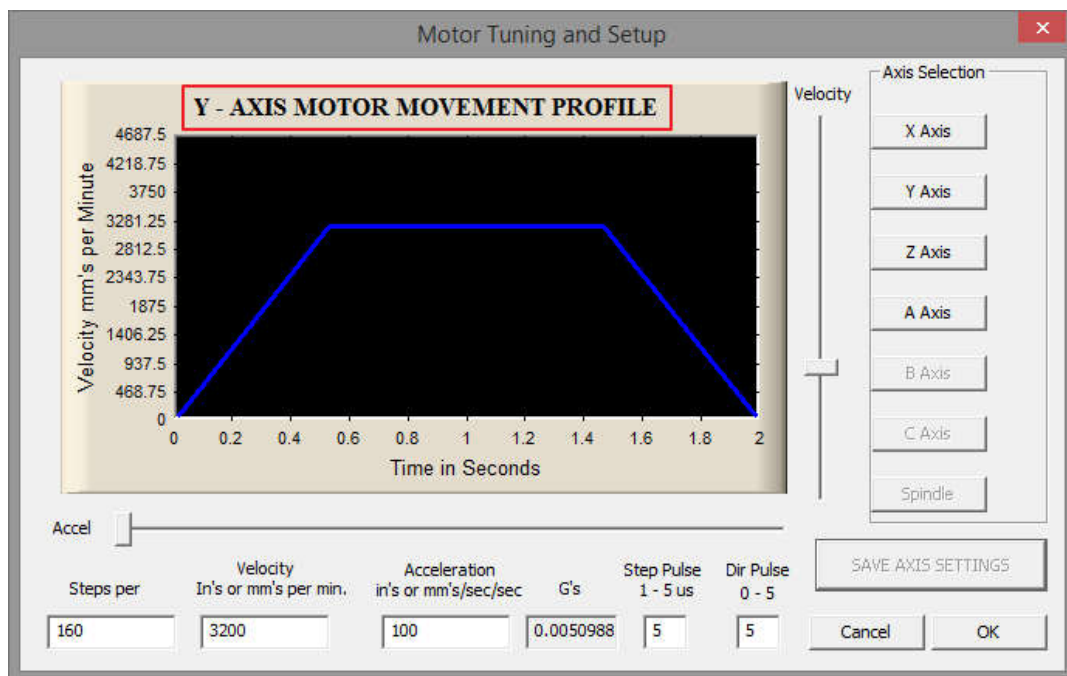
Steps per = 320 , Velocity = 1600 , Acceleration = 50 , Step Pulse = 5 , Dir Pulse = 5

A-Axis ::

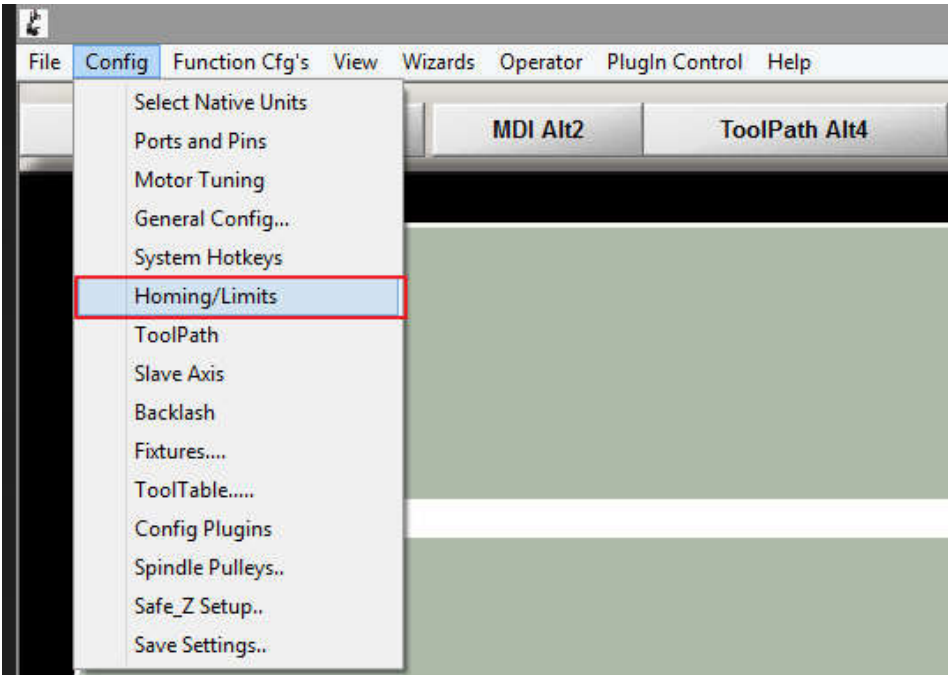
Steps per = 160 , Velocity = 3200 , Acceleration = 100 , Step Pulse = 5 , Dir Pulse = 5

** After finish set values then click "SAVE AXIS SETTINGS"





4.Config --> Homing/Limits



Motor Home/SoftLimits

Entries are in setup units.

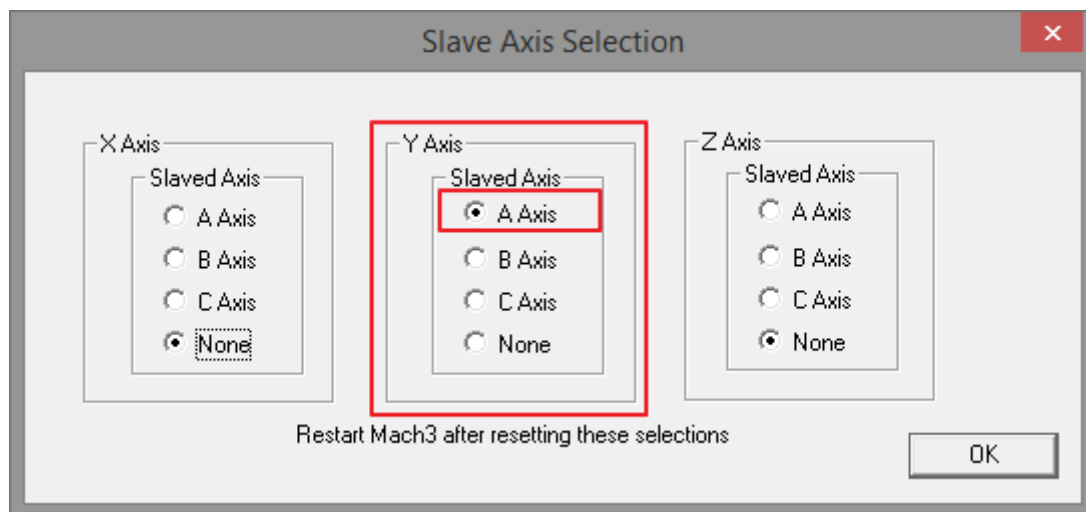
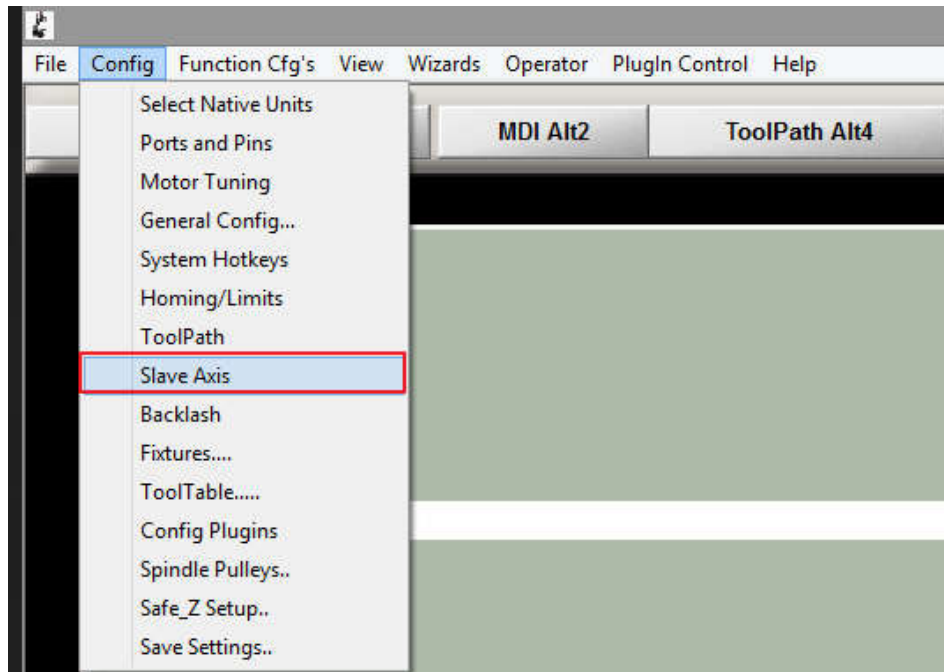
Axis	Reversed	Soft Max	Soft Min	Slow Zone	Home Off.	Home N...	Auto Zero	Speed %
X		100.00	-100.00	1.00	0.0000			20
Y		100.00	-100.00	1.00	0.0000			20
Z		100.00	-100.00	1.00	0.0000			20
A		100.00	-100.00	1.00	0.0000			20
B		100.00	-100.00	1.00	0.0000			20
C		100.00	-100.00	1.00	0.0000			20

G28 home location coordinates

X	<input type="text" value="0"/>	A	<input type="text" value="0"/>
Y	<input type="text" value="0"/>	B	<input type="text" value="0"/>
Z	<input type="text" value="0"/>	C	<input type="text" value="0"/>

OK

5.Config --> Slave Axis



Note :: After finished all setting please close Mach3 application and restart application before using.