



RZNC-05 Series

Function Operation

How to running with U flash

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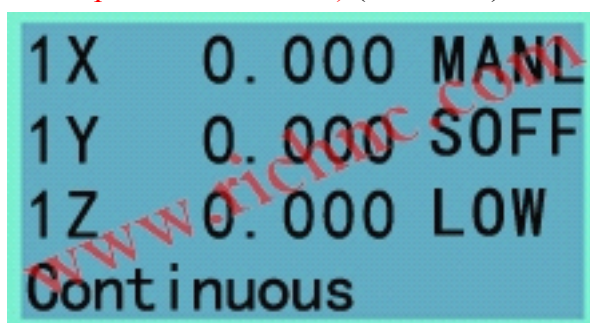
How to running a job

1. Connect the RZNC Controller with computer or machine, power on, the controller will show your "Goto Home"(as View 1)



View 1

2. Press the "Delete" key, the RZNC Controller will showing "manual state screen". (this state is Low-speed manual mode) (as View 2)



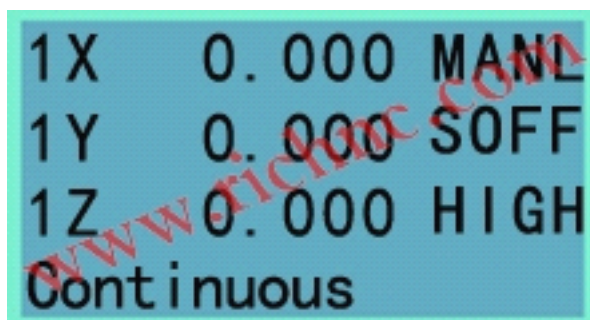
View 2

Remark:

If we had the correct parameters, we must press the "OK" key when the controller show your "Goto Home" with machine (Connect with machine).

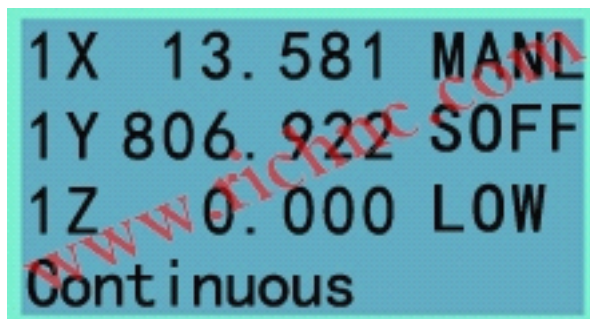
If we connect with the computer, we must press the "DELETE" key when the controller show you "Goto Home".

3. Press the "High/Low" key, the system will be in another manual operation mode (this state is High-speed manual continuous mode) (as View 3)



View 3

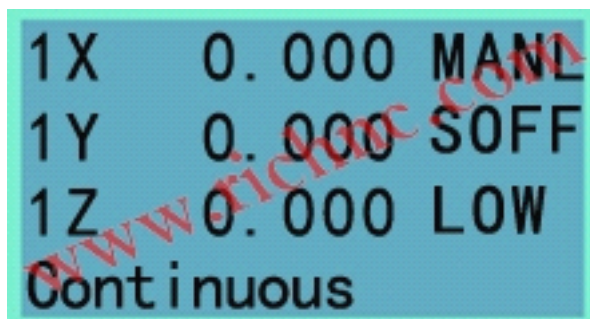
4. Press the "X+/X-" and "Y+/Y-" move the spindle close to the corner of the material (as View 4)



```
1X 13.581 MANL
1Y 806.922 SOFF
1Z 0.000 LOW
Continuous
```

View 4

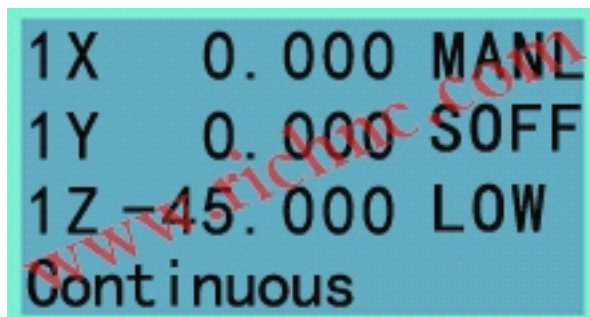
5. Press the "4" key, make the "X and Y axes working origin", building the "working start X Y point" (as View 5)



```
1X 0.000 MANL
1Y 0.000 SOFF
1Z 0.000 LOW
Continuous
```

View 5

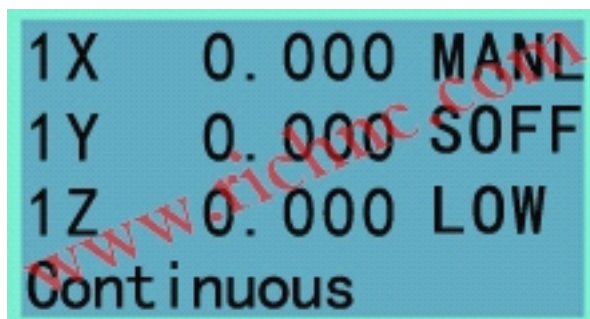
6. Press the "Z+/Z-" move the tool close to the surface of the material (as View 6)



```
1X 0.000 MANL
1Y 0.000 SOFF
1Z -45.000 LOW
Continuous
```

View 6

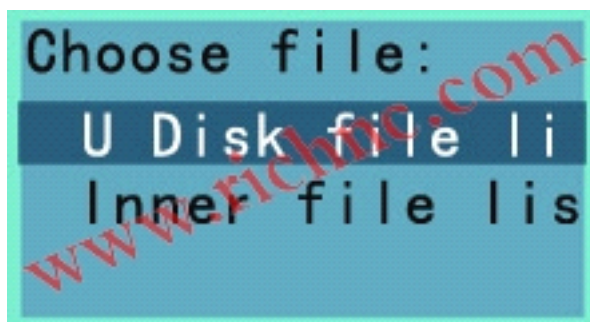
7. Press the "8" key, make the "Z axis working origin" building the "working start Z point" (as View 7)



```
1X 0.000 MANL
1Y 0.000 SOFF
1Z 0.000 LOW
Continuous
```

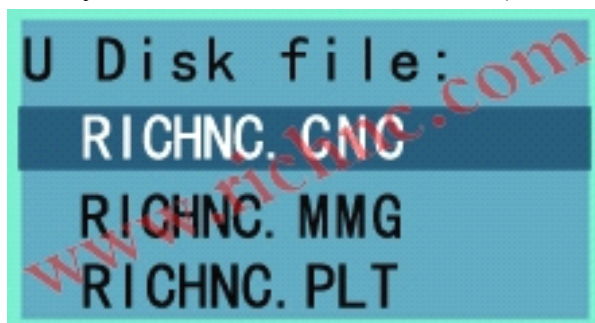
View 7

8. After found the working origin, put the U flash into the controller. Press the "RUN" key, the controller will show your (as View 8)



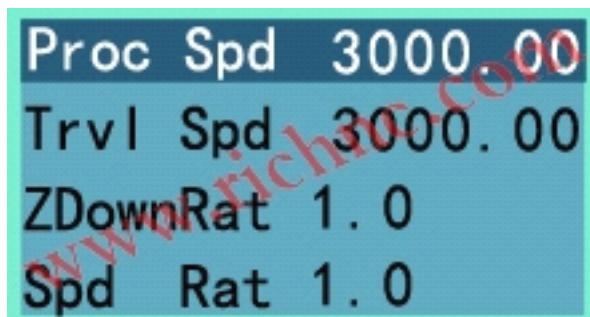
View 8

9. Press the "OK" key, we will view the U flash files (as View 9)



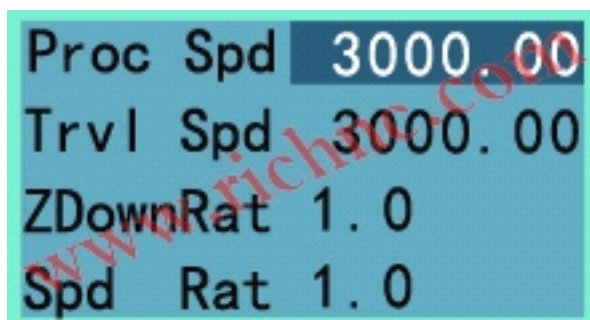
View 9

10. Press the "X+/X-" key to select the job file, we choice the "RZNC.CNC" file and press the "OK" key, The controller will show your this job parameters: **Processing speed, Travel speed, Z down Rate, Speed Rate, Spindle Grade, Pulse Equivalent, Z up distance** (as View 10)



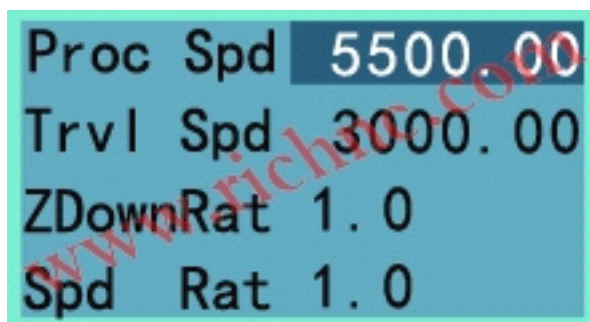
View 10

11. Press the "DELETE" key move the cursor to numbers (as view 11)



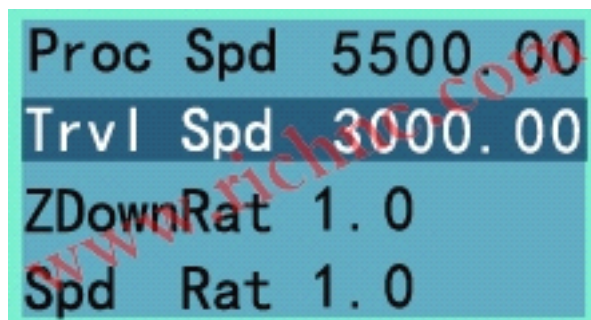
View 11

12. Press the number key to change the processing speed, we change the processing speed to 7000mm/Min (as view 12)



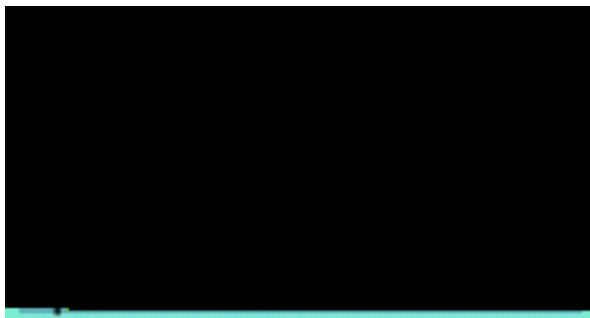
View 12

13. Press the "OK" key to saving the processing speed to "7000mm/Min" and go to next parameter(as view 13)



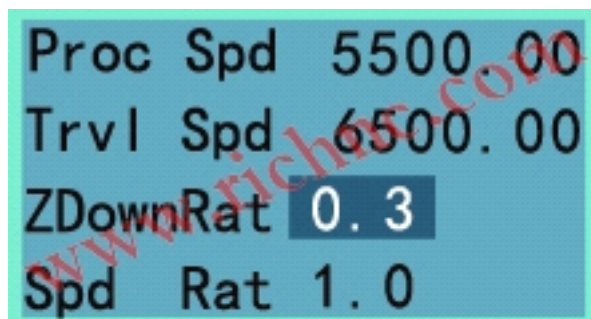
View 13

14. As above method, we can change the Travel speed to 6500.00(as view 14)



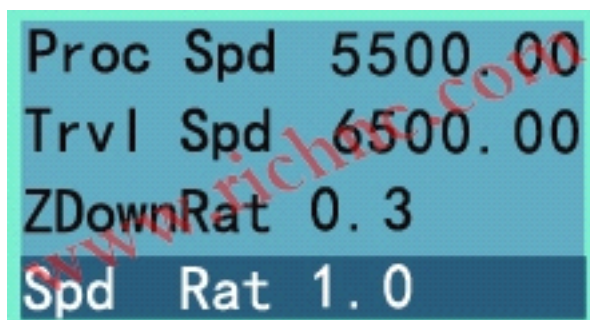
View 14

15. Normal we need to slowly the Z Down speed ,so we must change the Z Down Rate(as view 15)



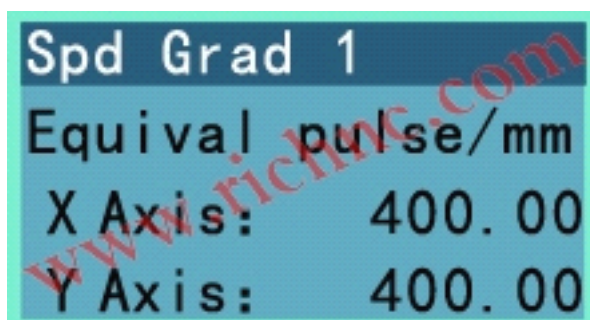
View 15

16. Press the "OK" key for save the Z Down Rate and next(as view 16)



View 16

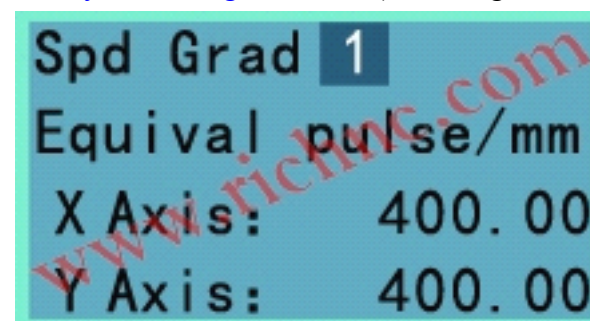
17. Normal we need not to change the Speed Rate, so we press the "OK" key to next (as view 17)



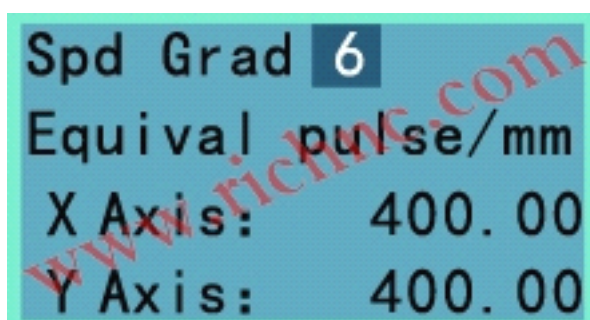
View 17

18. We can select the spindle speed if we had setup the spindle speed function on "Machine setup"

For example: we had setup the multi speed states, so select the 20000rpm, the 6 state. Press the "Delete" key to moving the cursor (as view ground 18)

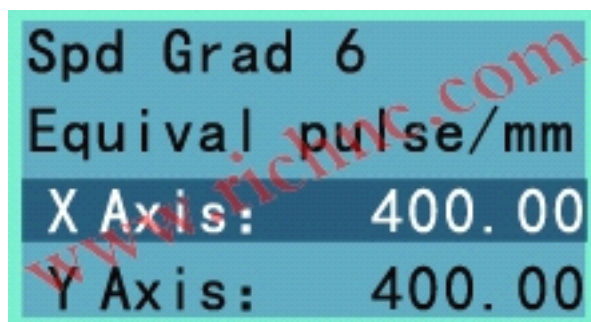


View 18-1



View 18-2

19. Press the "OK" key to next (as view 19)

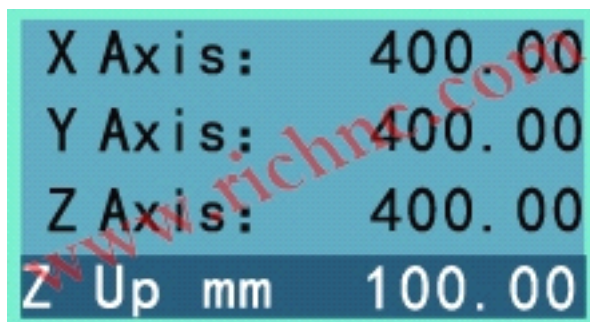


View 19

Remark:

We just only able change the pulse Equivalent on the "Machine setup", can not now

20.Moving the cursor to found the "Z Up mm", normal this parameter had be setup in processing file,so we need not to change it now(as view 20)



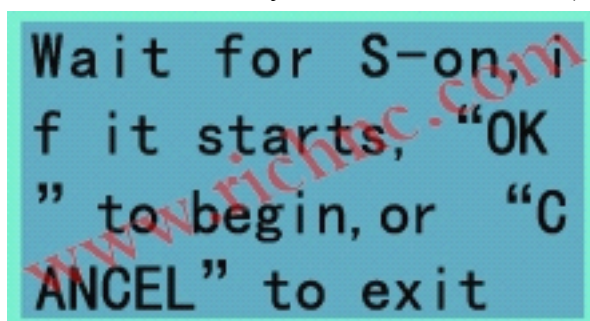
View 20

21.Press the "OK" key ,the RZNC controller will checking the file(as view 21)



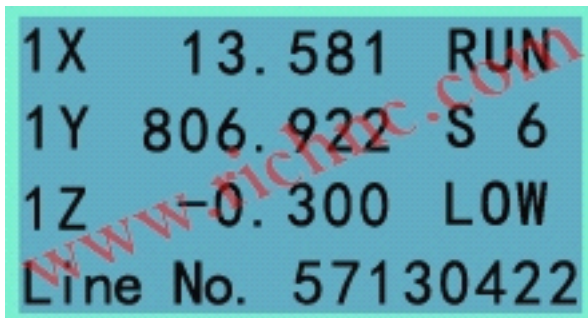
View 21

22.The RZNC controller will show you some informations(as view 22)



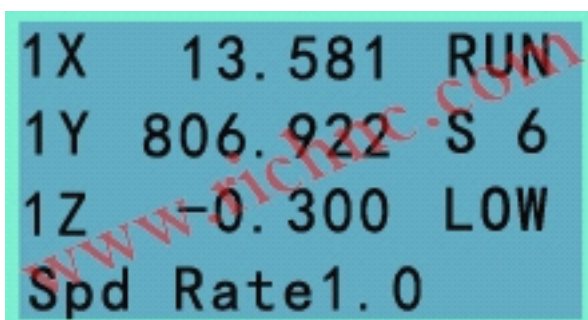
View 22

23. We will wait the spindle got the enough speed and auto working. we can press the "OK" key, the RZNC controller will direct start working. (as view ground 23)



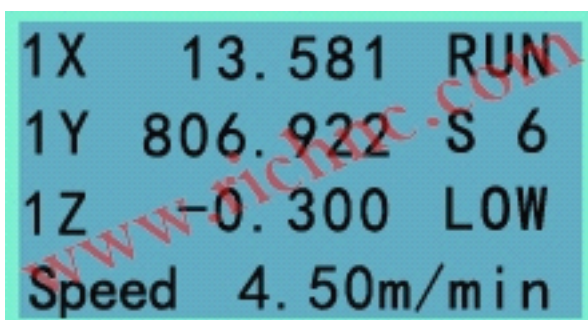
1X 13.581 RUN
1Y 806.922 S 6
1Z -0.300 LOW
Line No. 57130422

View 23-1



1X 13.581 RUN
1Y 806.922 S 6
1Z -0.300 LOW
Spd Rate 1.0

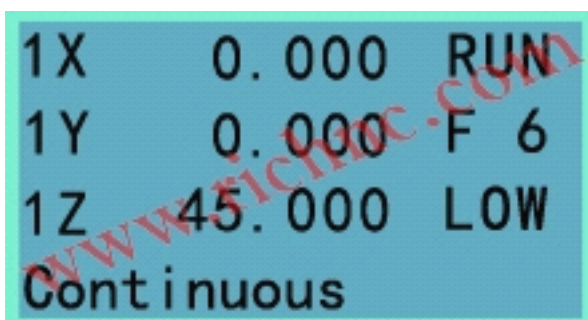
View 23-2



1X 13.581 RUN
1Y 806.922 S 6
1Z -0.300 LOW
Speed 4.50m/min

View 23-3

24. The RZNC controller working now, we just wait he stop after finished this job (as view 24)



1X 0.000 RUN
1Y 0.000 F 6
1Z 45.000 LOW
Continuous

View 24

Please use caution parameter setting function if it is safe. If have any question please contact the richnc@hotmail.com first.