

How to adjust the moving precision of CNC-F2100

➔ Problem : The precision of CNC X/Y axis is not correct;

- Solution overview:
1. Adjust system pulse parameters--X axis;
 2. Adjust system pulse parameters--Y axis;

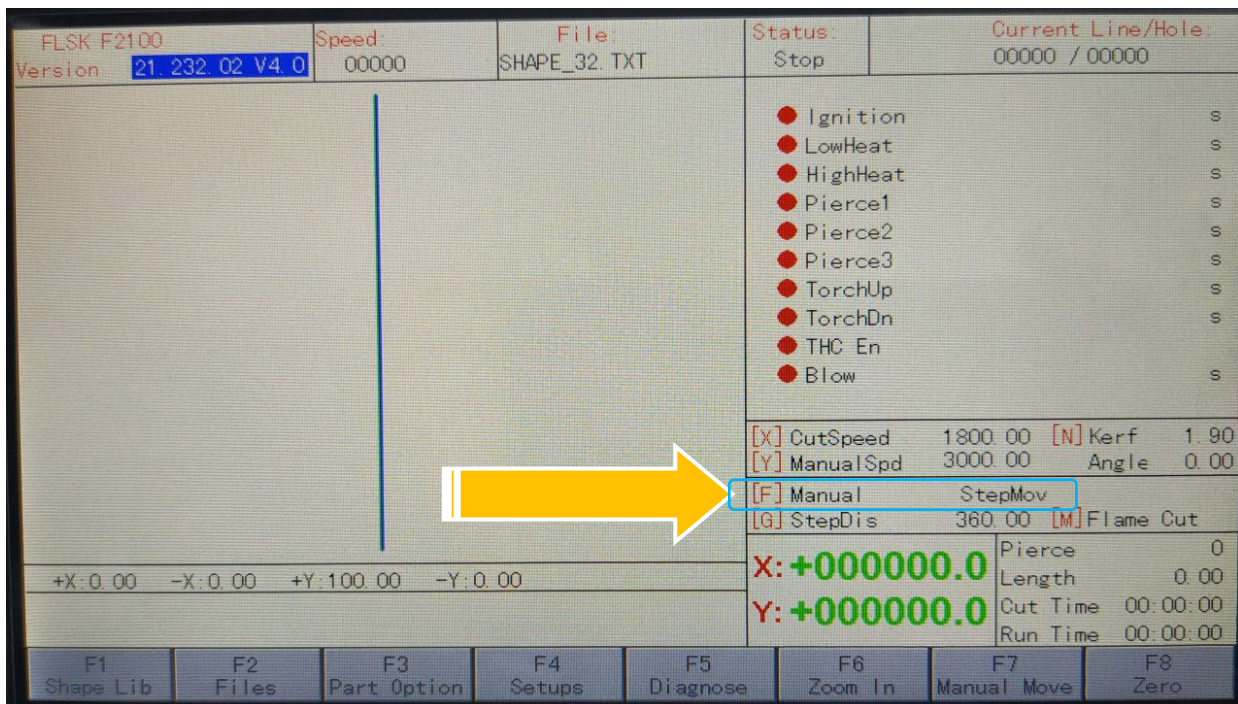
Problem analysis:

✳ Adjust system pulse parameters--X axis;

Solution: **Step 1-** Move the X axis to one end of the frame and mark it at the initial position;

This is to measure the actual distance the X axis moves.

Step 2- Interface main ,Press **【F】** button , Choose **【StepMov】** As show in pic1.



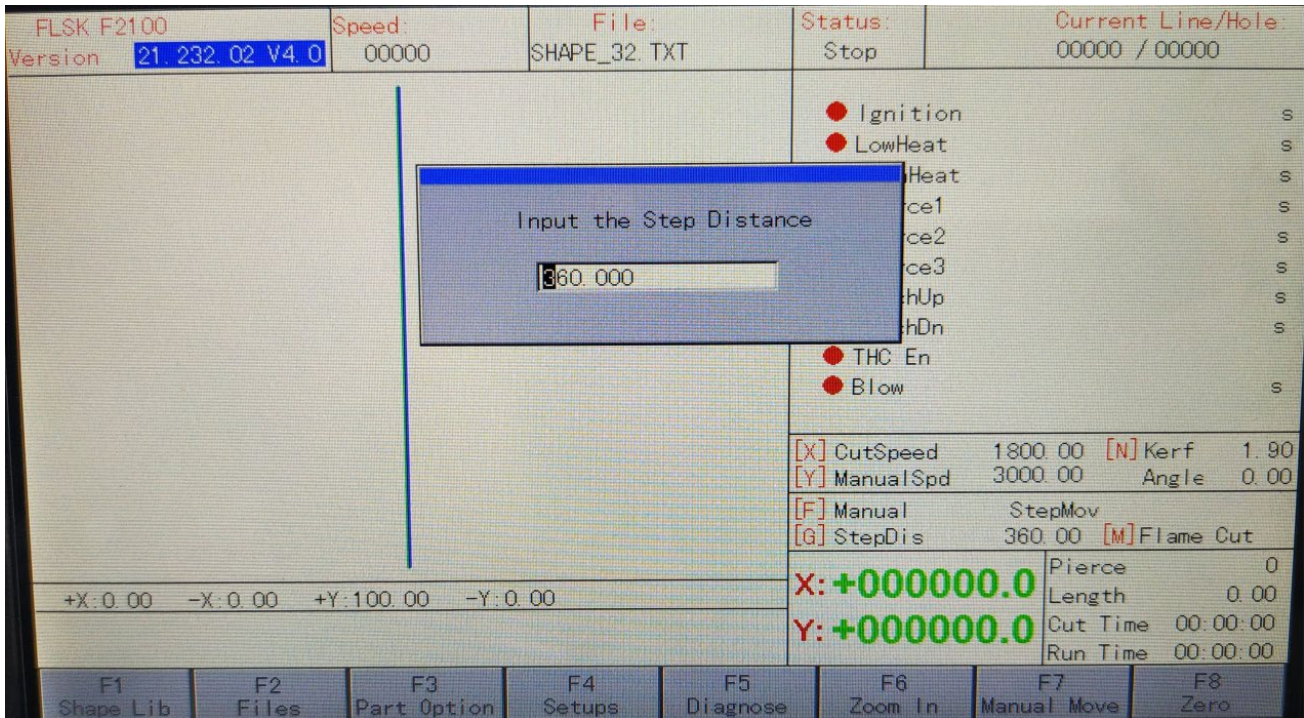
Pic-1

Step 3- Interface main ,As show in pic1→Press **【G】** button, then Input 1000 value,

Press  enter As show in pic2.

Note: The input value of 1000 is the theoretical movement distance of the X axis.

Service Support Spirit



Pic-2

Step 4- Interface main ,As show in pic1→Press **【F8 Zero】** button [Clear the coordinates for easy observation], →Press X-axis direction key[Both direction keys can be], as shown in pic.→The X axis moves a some distance. Please measure the distance from this position to the initial position.



Step 5-Calculate the X-axis pulse with the formula;

【The theoretical distance】

【The actual distance】

$$X \text{ System pulse value} = \text{new pulse value}$$

→ For example: the System Pulse value is 127, The input theoretical value is 1000; The actual distance is 1500

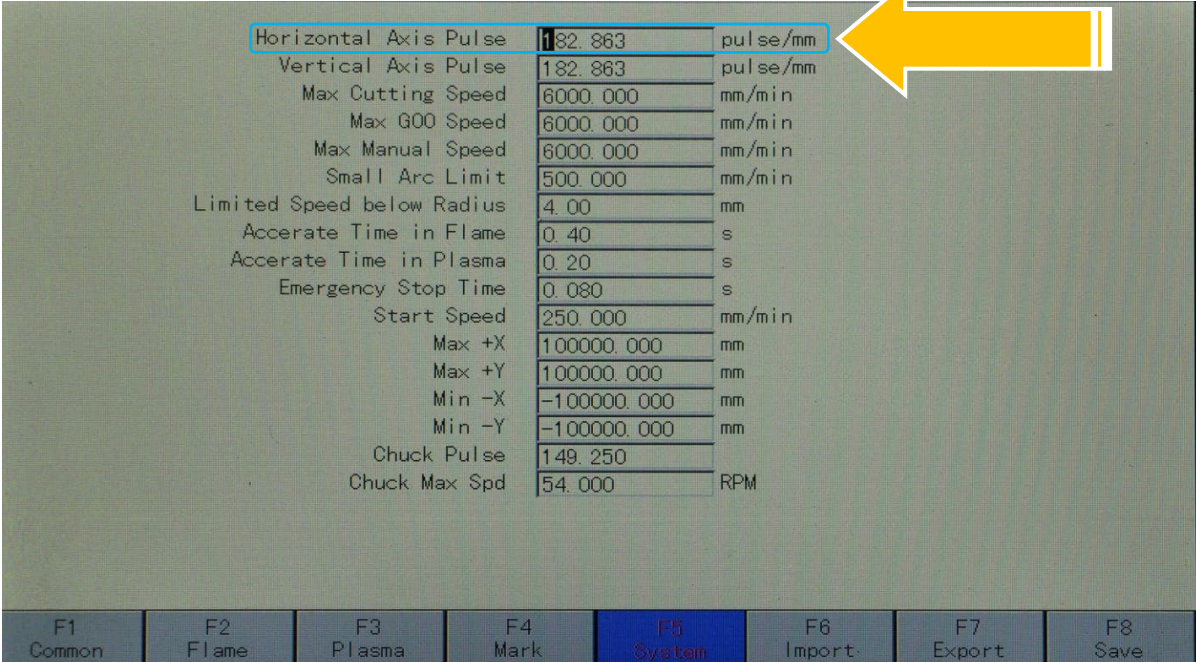
→ So:

【The theoretical distance:1000】

【The actual distance:1500】

X System pulse value: 125 = New pulse:83.333

Step 6-Output new pulses to the system;



Horizontal Axis Pulse	182.863	pulse/mm
Vertical Axis Pulse	182.863	pulse/mm
Max Cutting Speed	6000.000	mm/min
Max G00 Speed	6000.000	mm/min
Max Manual Speed	6000.000	mm/min
Small Arc Limit	500.000	mm/min
Limited Speed below Radius	4.00	mm
Accerate Time in Flame	0.40	s
Accerate Time in Plasma	0.20	s
Emergency Stop Time	0.080	s
Start Speed	250.000	mm/min
Max +X	100000.000	mm
Max +Y	100000.000	mm
Min -X	-100000.000	mm
Min -Y	-100000.000	mm
Chuck Pulse	149.250	
Chuck Max Spd	54.000	RPM

F1 Common F2 Flame F3 Plasma F4 Mark F5 System F6 Import F7 Export F8 Save

Pic-3

Step 7- Please follow the steps, please try again;

Note: If you find the moving precision is still not correct, please repeat the above steps.