KME CNC
5 AXIS SYSTEMS

<u>How to Set Up Your KME Control Box</u>

1) First, turn on the control box, and wait for approximately 30 seconds for the startup sequence before pushing any buttons.

2) Once the drive finds home position, proceed by pushing the (F1) key to get you into Jog mode screen. From the Jog Mode Screen, select desired drive: *C1*, *C2* or *A* by using the up or down arrow.

3) Once desired drive is selected, you can now jog using the forward and back jog key. You will be in default speed at 5%. If you would like to go faster, then push the (F1) key again and you will be at 50% speed. If you push one more time, then you will be at 100% speed. If you wish to obtain a specific degree angle, you have the option by entering the desired value on the numerical keypad located on the right (for example 23.523°) that angle is now displayed at the top screen. Once you push "ENTER", your pallet would then move to the desired angle.

4) You can set your work offset (or find your work zero / home) by selecting a probe or gauge of your choice and touching off your part. You can use incremental jogging by pushing the (F2) key for .1° or the (F3) for .01°, or (F4) Key for .001°.

5) Once you find your work zero, you should save this as your work offset. To accomplish this, push the "MENU" key to go back to the main menu screen. Then, hold down the (F4) key/work offset for approximately 6 seconds, the control box will enable you to enter the work offset menu from the previous screen. If done correctly, the screen will flash once. Once you are on the work offset menu screen, you will be able to save all work offsets or just a drive of your choice by selecting the appropriate keys: (F1) key for *C1*, (F2) key for *C2*, and (F3) key for *A*. After selecting a desired drive, push the "ZERO" key to set the work offset for the drive. After establishing work offsets on all desired drives, press the "MENU" key to return to the main menu.

6) Now, the control box is ready for use. To start cutting parts, simply push the "START" button on the left side of the control box to bring the KME system in DPRNT mode. The screen will read "DPRNT" on the top left corner (as shown below), confirming that your KME system is now ready to receive DPRNT commands from your VMC. If you would like to exit DPRNT mode, push e-stop and it will allow you to exit DPRNT mode.