

## HD Series and HD Mini Settings

Website: [support.technocnc.com](http://support.technocnc.com) | Call: 631-648-7481

### High/Low Speeds and Step Distances (from main screen, press 'OK')

MSpd:	800 / 100	
Step XY:	0.005	
Step Z:	0.005	
File:	(active file name)	Note: These numbers can vary.

All following settings can be found by pressing the 'Menu' key and are worded/abbreviated as you would see them on screen.

*Note: All settings with '\*' on screen requires reboot to take effect.*

1. LOCAL FILES
2. USB FILES
3. OPERATIONS
  1. Back to REF Point
    1. All Home
    2. Z Home
    3. X Home
    4. Y Home
  2. Rect Machining
    1. Params Setting
      - Engr Depth
      - Each Depth
      - Tool Dia
      - Nose Gap
      - Height
      - Width
      - X Init
      - Y Init
      - Mode Horiz Mill
      - EXECUTE
    2. Load the Last
  3. Select Line No
    - Total: \_\_\_\_\_
    - StartLine: \_\_\_\_\_
    - EndLine: \_\_\_\_\_
    - EXECUTE NOW
  4. Machining Info
    - Time
    - X: \_\_\_\_\_
    - Y: \_\_\_\_\_
    - Z: \_\_\_\_\_
  5. Park MCS Site

1. Park Mode
  - Not Move
  - To Park Site
  - To WCS Origin
2. Park Site
  1. Input Site
    - Input Park Site
    - X: \_\_\_\_\_
    - Y: \_\_\_\_\_
    - Z: \_\_\_\_\_
  2. Select Site
    - Select Current Position As
    - Park Pos by [OK] Key
    - Return ny [ESC] Key
6. Select WCS
  - G54 WCS
  - G55 WCS
  - G56 WCS
  - Select by [OK]
4. Oper Param
  1. G00 Speed
    - 800.00 in/min **(HD Series)** — 400.00 in/min **(HD Mini)**
  2. GXX Speed
    - 400.00 in/min **(HD Series)** — 250.00 in/min **(HD Mini)**
  3. Back REF First
    - YES
  4. Lifts on Pause\*
    - 0.25 inch
  5. Offset →
    1. Public Offest
      1. X
      2. Y
      3. Z
    2. Work Offset
      1. G54 Offset →
        1. X
        2. Y
        3. Z
  6. Cycle Process →
    1. Cycle Process
      - NO
    2. Cycle Times
      - 1
    3. Cycle Interval

*(settings repeat through G59)*

- 0 ms
- 4. S-Off in Intev  
NO
- 7. G73-G83 Retract  
0.0 inch
- 8. Ignore F Code  
NO
- 9. Ignore S Code  
NO
- 10. Spindle Stop →
  - 1. S off at Pause\*  
YES
  - 2. S off at Stop\*  
YES
  - 3. S off at End  
Yes
- 11. Ratio on Manu\*  
NO
- 12. DXF Params →
  - 1. Lifting Height\*
  - 2. Process Depth\*
  - 3. 1<sup>st</sup> Point as 0\*  
NO
  - 4. Shape Process\*  
NO
  - 5. Bottom Process\*  
NO
  - 6. Metric Size\*  
NO
- 13. ENG Params →
  - 1. Lifting Height\*  
0.039
  - 2. Tool Change Tip\*  
YES
  - 3. Cycle Times\*  
1
  - 4. Deep Hole Mode\*  
0
  - 5. Retract Amount\*  
0.25
  - 6. Select Tool No\*  
YES
- 14. Tool Change →
  - 1. ATC Capacity\*

10  
2. Current Tool No

1  
3. Tool Offset

1. Tool 1  
X: \_\_\_\_\_  
Y: \_\_\_\_\_  
Z: \_\_\_\_\_

*(settings repeat through tool 10)*

15. ENG Unit  
YES

5. MFR Param

**PASSWORD: 33587550**

1. Velocity →

1. Decel Dist  
0.394 inch
2. Approach Speed  
25.00 in/min
3. Single Axis Acc  
25.00 in/sec<sup>2</sup>
4. Max Turn Acc  
100.00 in/sec<sup>2</sup>
5. Jerk  
300.00 in/sec<sup>3</sup>
6. Max Speed of Z  
125.00 in/min
7. Short Seg Spd Lmt  
YES
8. SPDLMT Length  
0.1 inch
9. Enbl Plunge Rate  
NO
10. Z Plunge Cut Spd  
50.00 in/min
11. REF Circle Radius  
0.1 inch
12. REF Circle Speed  
100.00 in/min

2. Axis Output Dir →\*

X: Negative  
Y: Negative  
Z: Negative

3. Pulse Equiv →\*

X: 0.0078125 (HD Series)	0.005000 (HD Mini)
Y: 0.0078125 (HD Series)	0.005000 (HD Mini)
Z: 0.0025000 (HD Series)	0.002500 (HD Mini)

4. Machine Stroke →
  1. Strk Upper Lmt →  
X:  
Y: *varies depending on machine size*  
Z:
  2. Strk Lower Lmt →  
X:  
Y: *varies depending on machine size*  
Z:
5. Ref Point Set →
  1. RefP Speed →  
X: 70 in/min  
Y: 70 in/min  
Z: 60 in/min
  2. RefPDir  
X: Negative  
Y: Negative  
Z: Positive
  3. Retract Dist
    1. X Retract Dist  
0.079 inch
    2. Y Retract Dist  
0.079 inch
    3. Z Retract Dist  
0.079 inch
6. Spindle Set →
  1. Spindle Gears\*  
7
  2. On/Off Delay  
5000 ms
  3. Initial Gear\*  
6
  4. Max Spdl Speed\*  
18000
7. Y Rotary Axis →
  1. Y as Rotary Axis\*  
NO
  2. Rotary Y Pulse  
0.006 deg/pulse
  3. MM as Unit  
NO
  4. Rev Work Radius  
0.394
  5. Rotary Takeoff

- 0.291 rad/s
- 6. Rotary Y Acc  
6.98 rad/s<sup>2</sup>
- 7. Max Rotary Vel  
30 r/min
- 8. Backlash Set
  - 1. Compensation on  
NO
  - 2. Axis Backlash →\*  
X: 0.0  
Y: 0.0  
Z: 0.0
- 9. Calib Thickness  
1.587 inch *(will vary slightly)*
- 10. Enable S Algo  
YES
- 11. Arc Increment  
YES
- 12. Forward Look Seg  
50
- 13. Sign of BK REF  
YES
- 14. Safety Height\*  
0.25 inch
- 15. Lube →
  - 1. Enable Auto Lube  
NO
  - 2. Time Interval  
5000s
  - 3. Duration  
5s
- 16. G00 Feed 100%\*  
YES
- 17. Smoothing Time  
0.0s
- 6. Param Upkeep
  - 1. Backup Params
  - 2. Restore Params
  - 3. Factory Params
  - 4. Export Params
  - 5. Import Params
- 7. System Upkeep
  - 1. Language
    - 1. Chinese

2. English
2. Export Log
3. System Update
4. Register
5. Help
  - Spec: Help Message Show Delay
  - Value: 60
  - Unit: S
6. Reboot
7. Exit
8. Diagnosis
  1. System Info
    1. Software Version
    2. Card No
    3. Remaining Time
    4. Register Tmes
  2. Port List
  3. Keypress Diag
  4. Import Diag
  5. Outport Diag