



XC3000S Series

Laser Cutting System User Manual



Thank you for choosing this product from !

The manual provides a detailed introduction to the installation and use of the XC3000S Series professional laser cutting system, including a quick start, introductions to the function, notes and more. The software must be used with a dongle. If you do not have a dongle, you can use a simulator.

Please read the manual in detail before using the software and the associated equipment, as this will help you to use it better.

Due to the constant updating of functions, the product you receive may differ in some respects from instructions in the manual.

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If there is any error in the document, please inform us as soon as possible.

The data contained in this manual is only used to describe the product and shall not be regarded as a statement of security interest.

For the benefit of our customers, we will constantly try to ensure that the products we develop comply with the latest technology.

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Website: www.raytools.ch

Dismantling, repair or modification will void the warranty, including the normal replacement of worn parts and components required for maintenance or commissioning operations.

- Unauthorized modification of products or use of non-original spare parts will directly lead to the invalidation of warranty and liability exemption.
- It is recommended to only use the spare parts provided by us or submit them to our designated professional team for installation.

Safe use

- Ensure that the product is used in a dry environment.
- Ensure that the product is used in the environment required by EMC standards.
- The product is only allowed to run within the parameters specified in the technical data.

Basic safety instructions

- Be familiar with the basic provisions for safety and accident prevention, having received equipment operation guidance.
- Read and understand basic safety instructions and operations.
- Must have studied the relevant regulations and safety instructions and understand the possible hazards.
- Comply with relevant regulations and implement

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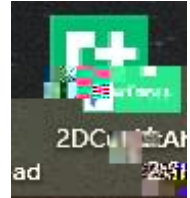
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Once the software has been installed, the icon will appear on the desktop, as shown on the right.

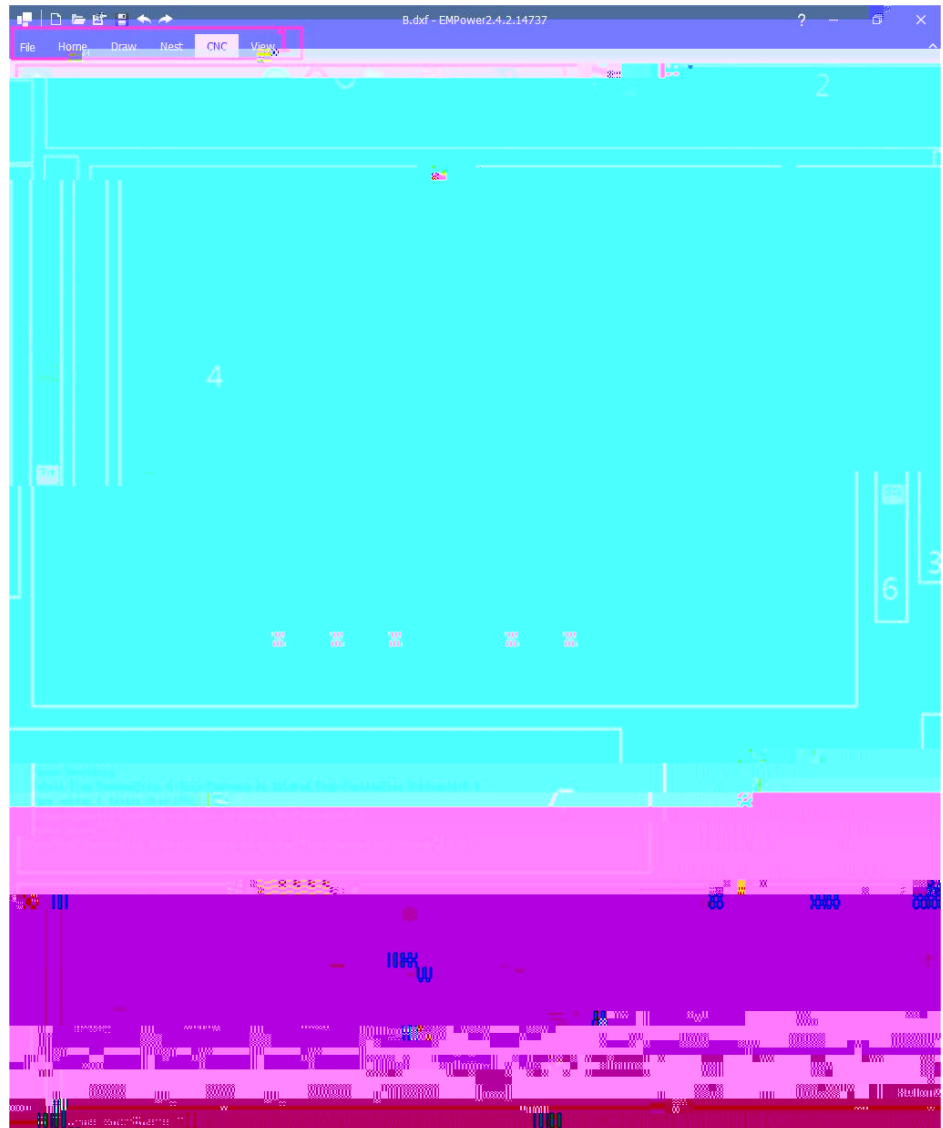
Double-click left mouse button on it to run

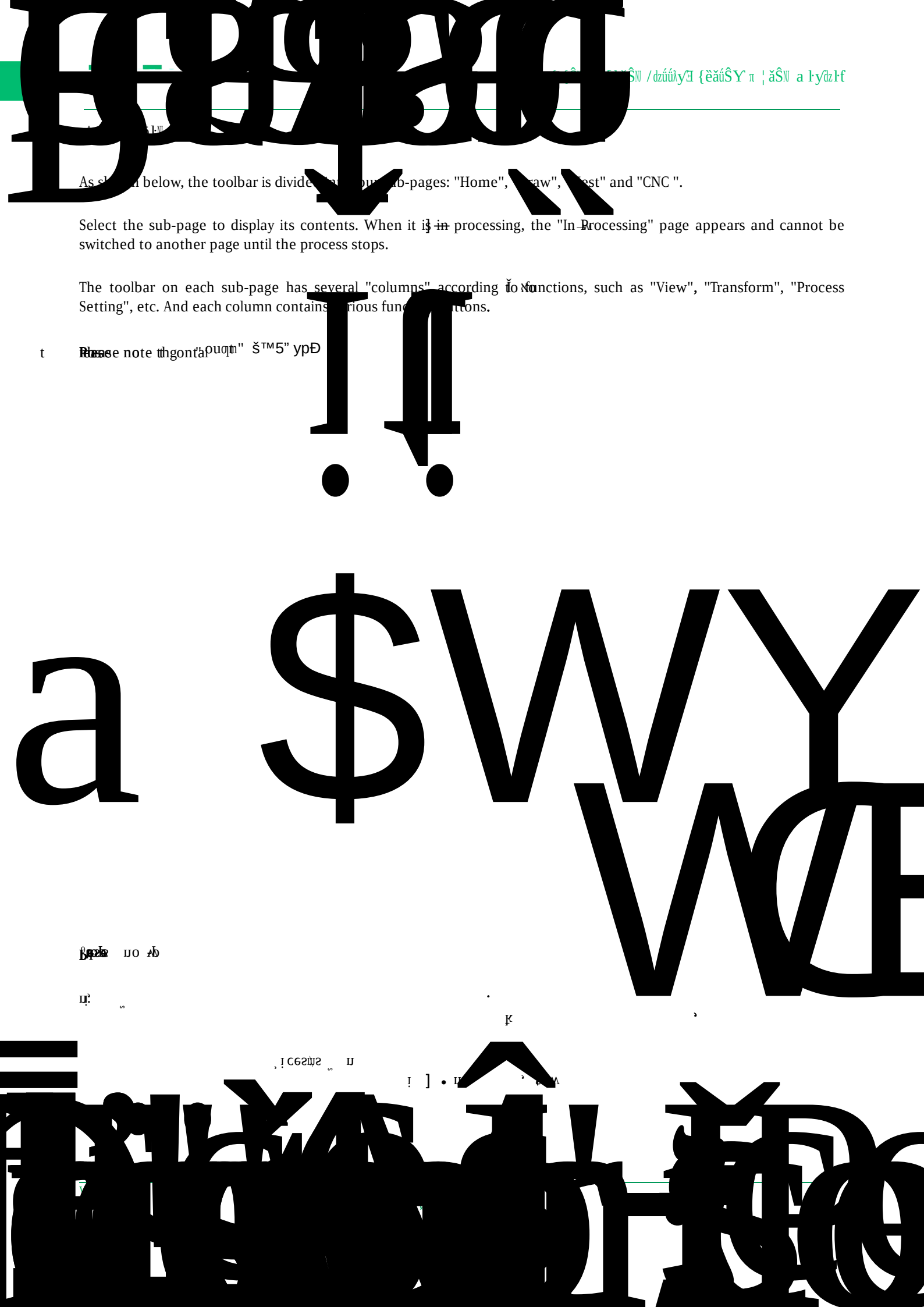


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The mainform is one of the most common used user interfaces. There are many operating areas, as shown below:

- 1: Menu
- 2: Toolbar
- 3: Quick Drawing Toolbar
- 4: Drawing Area
- 5: Control Panel
- 6: Process Toolbar
- 7: Log
- 8: Status Bar





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As shown below, the toolbar is divided into four sub-pages: "Home", "Draw", "Test" and "CNC".

Select the sub-page to display its contents. When it is in processing, the "In-Processing" page appears and cannot be switched to another page until the process stops.

The toolbar on each sub-page has several "columns" according to functions, such as "View", "Transform", "Process Setting", etc. And each column contains various functions.

Please note that the toolbar is not visible when the machine is in processing.

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In the top left corner, there is a 'File' menu, which contains some file-related options. Click on the

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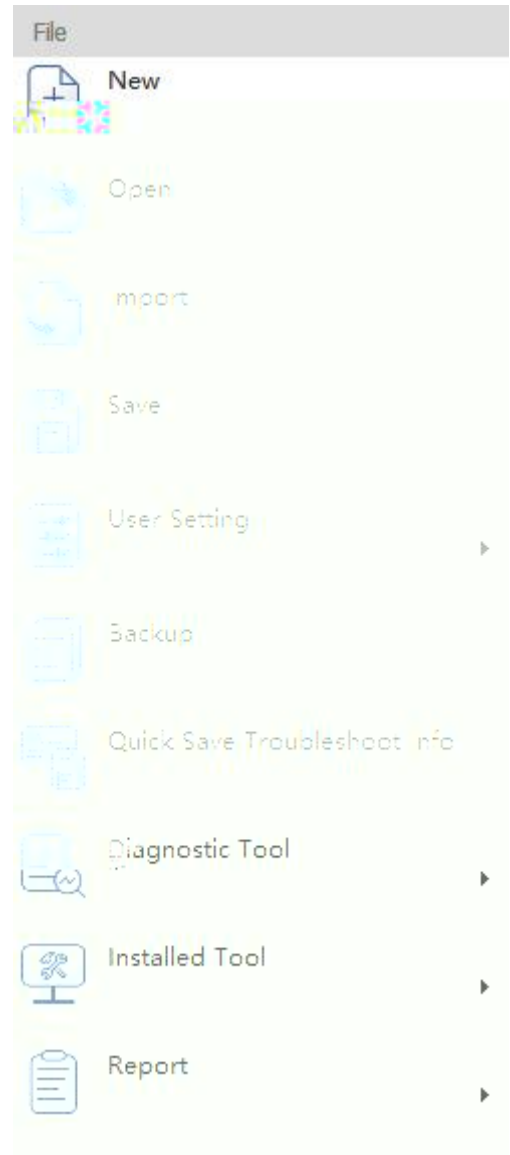
Create a new drawing and not save the current one.

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Import graphics to be processed. Supported file formats include dxf, emw, nc, nsp, etc.

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Import another file to the drawing board

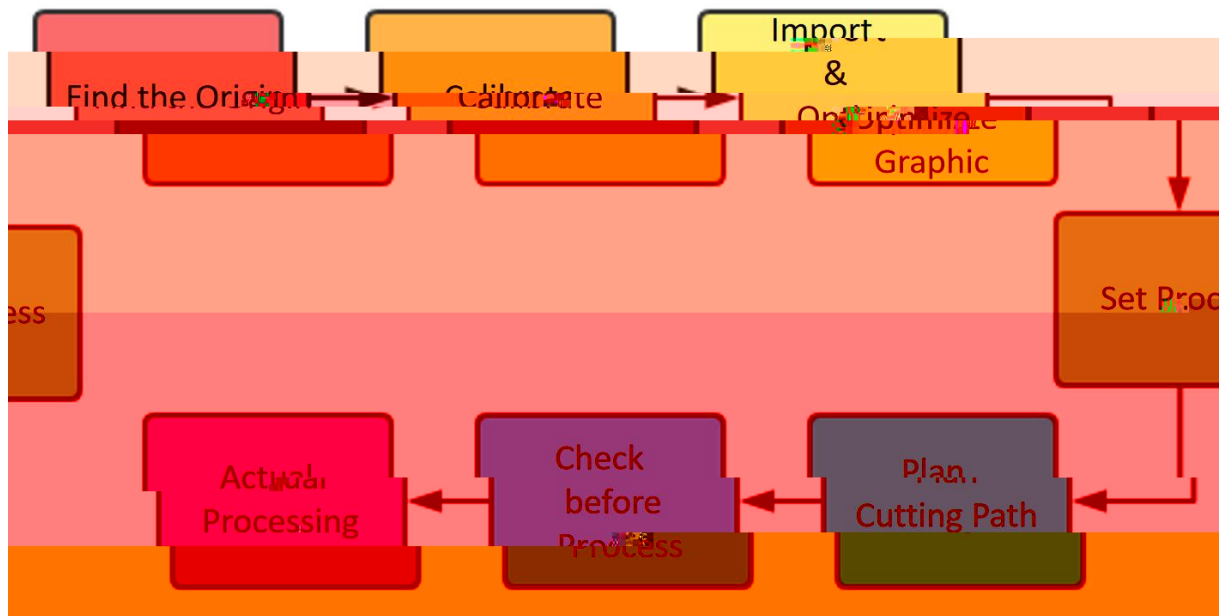


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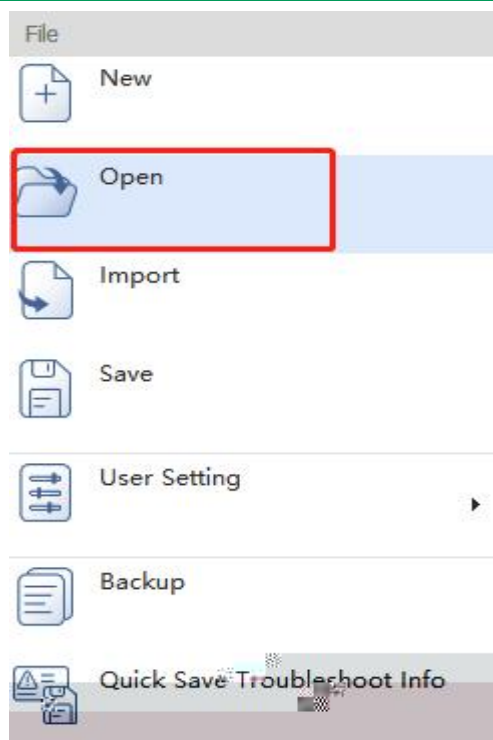
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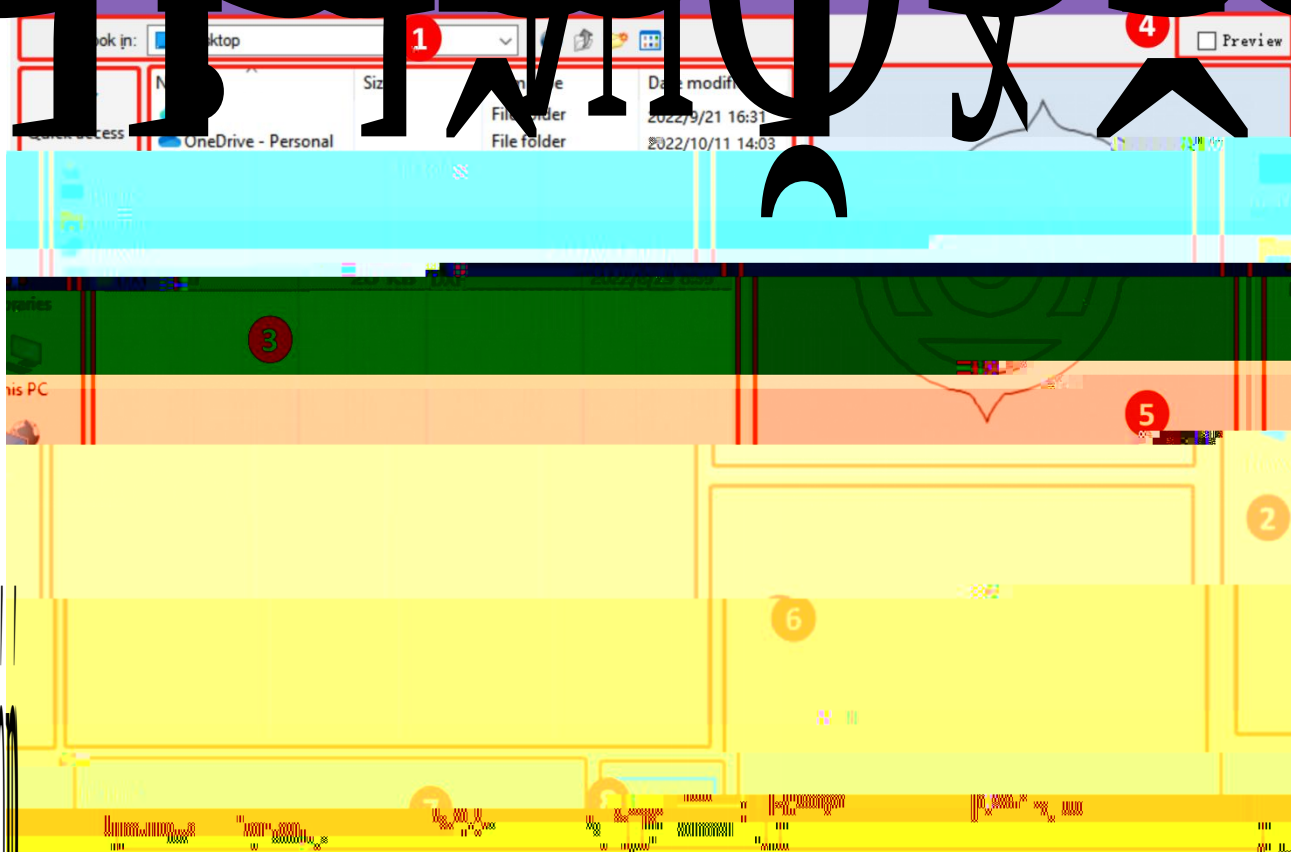
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After opening the software, click on Return Q



An interface of graphic import will pop up. Select the graphic in the disc and click on Open button. Currently supported file formats include DXF, EMW, NC, and NSP, as shown below



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Show the current file path.

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Select the disc of needed file.

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Files and folders are shown as complying with the filter criteria by current disc path.

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Select to preview the graphic or not.

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Click on Preview ůž

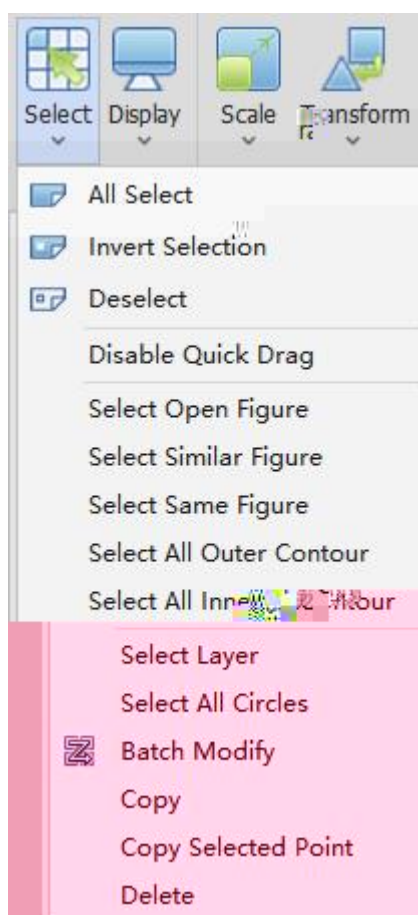
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There are various ways to select graphics. Basic operation is to click on the graphic contour. Another way is box selection. Left click and hold the mouse. Then, drag it to create a translucent box to select the graphic.

There are two types of box selection. When drag the mouse from left to right, only the graphic completely covered in the selection box will be selected. When drag the mouse from right to left, once part of the graphic is in the box, the graphic will be selected. You may use both types flexibly up to your need.

Click on Select in Home sub-page, and the drop-down bar will pop up. There are more advanced options, as shown below:



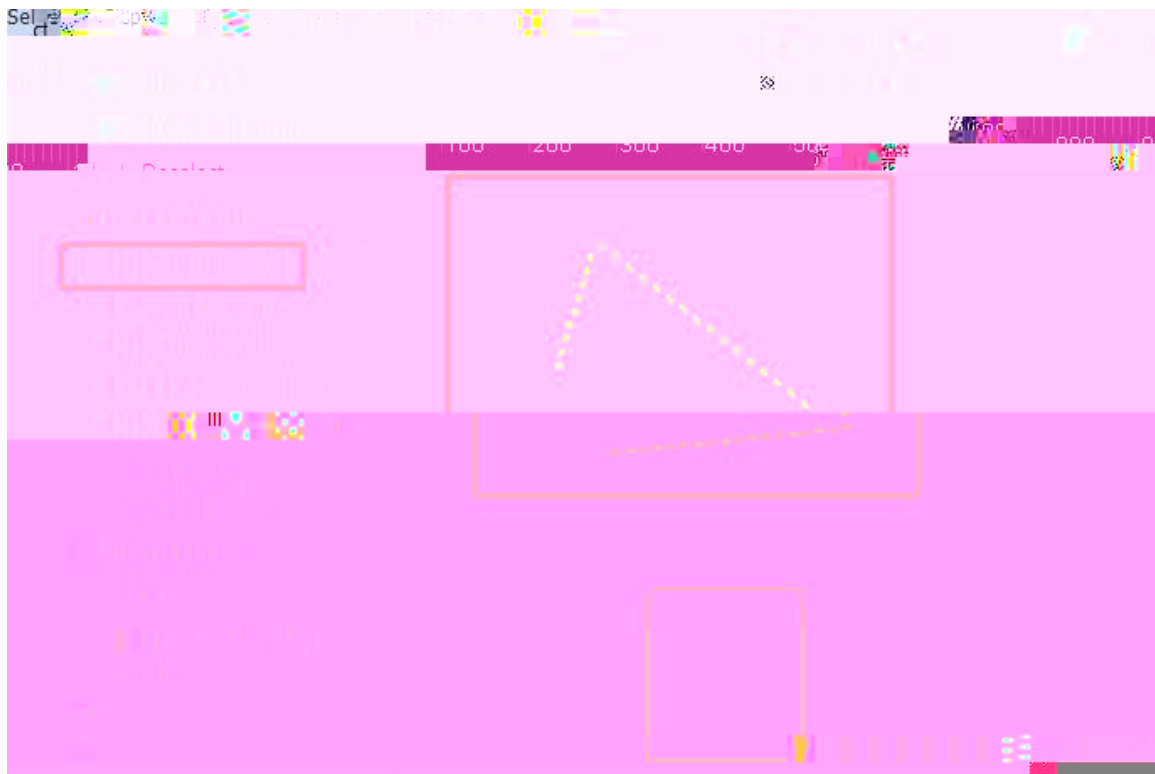
óMú ! ff {ŜtŜŌŭ: select all the graphics in current drawing.

óHú LyÓŠNú {ŠfŠŰú2y: change current selected graphics into unselected.

⌘⇧5: deselect the selected graphics.

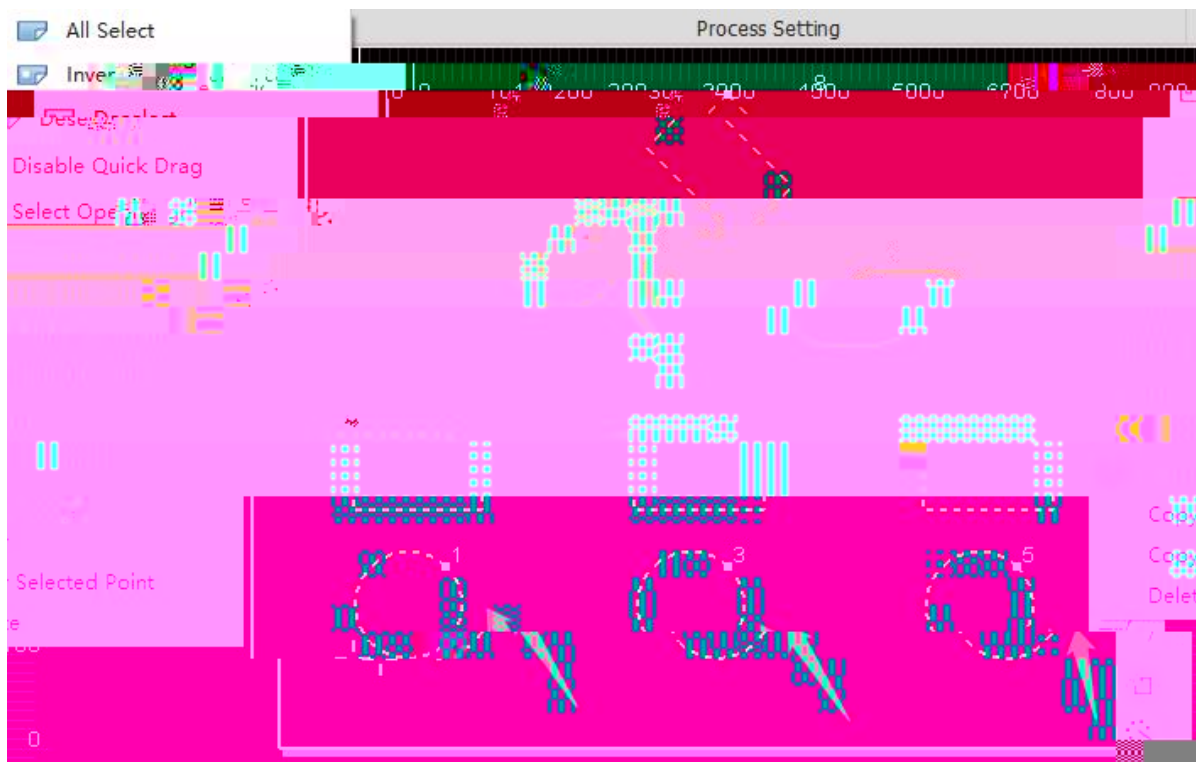
ᄒᆞᆫ ᄇᆞᆯᆡᆷ ᄂᆞᆫᆸᆺ ᄇᆞᆯᆡᆷ: make the graphics in current drawing area can not be dragged.

όπου {SfS0ú hLŒyCÆdzNŒ: select all the open graphics in the drawing area, as shown below:



S6: select all similar graphics in the current drawing, as follows:

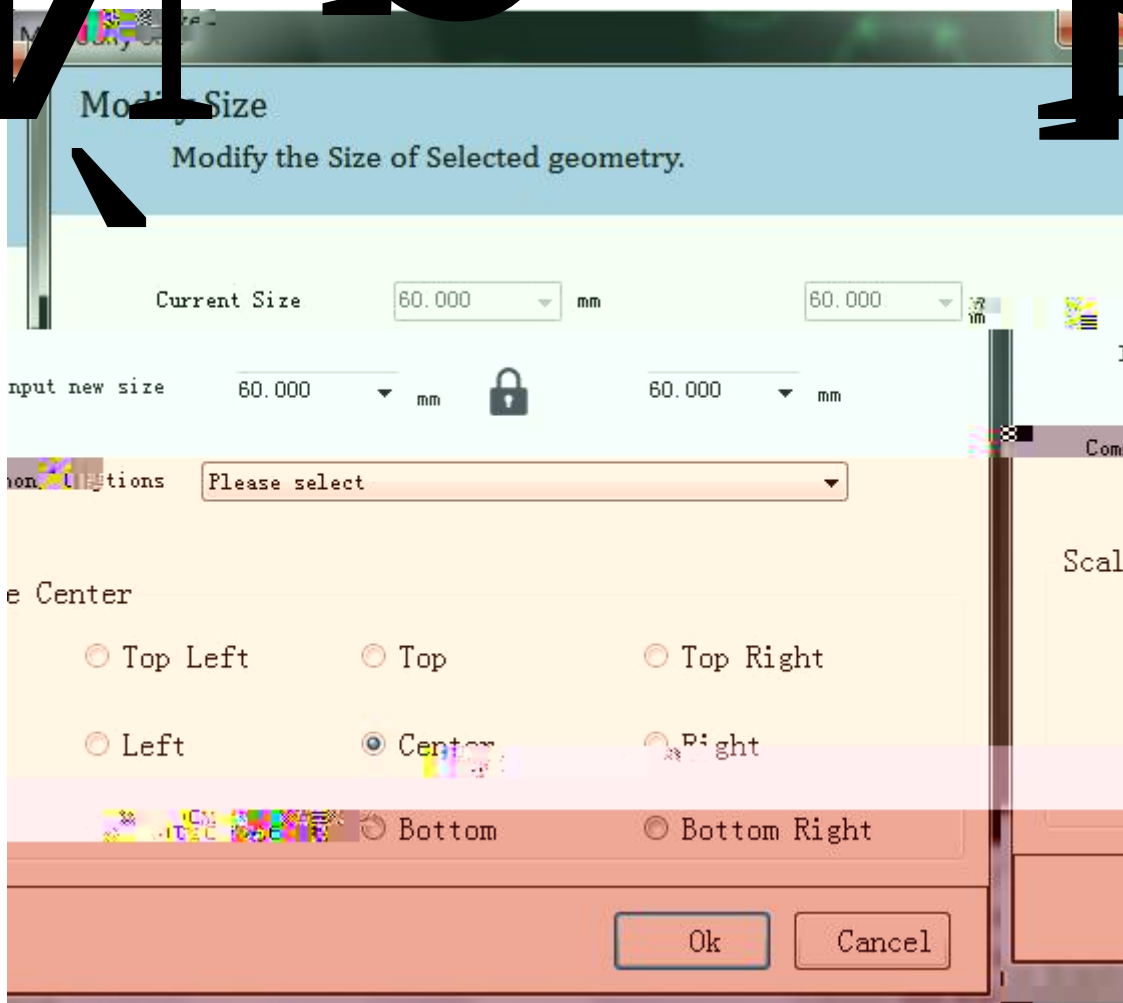
- Select a target graphic (squares and circles are shown in below figure as an example),
- Click on Select Similar Figure,
- All squares and circles of the same size in the drawing are selected.



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Click on Display button in t



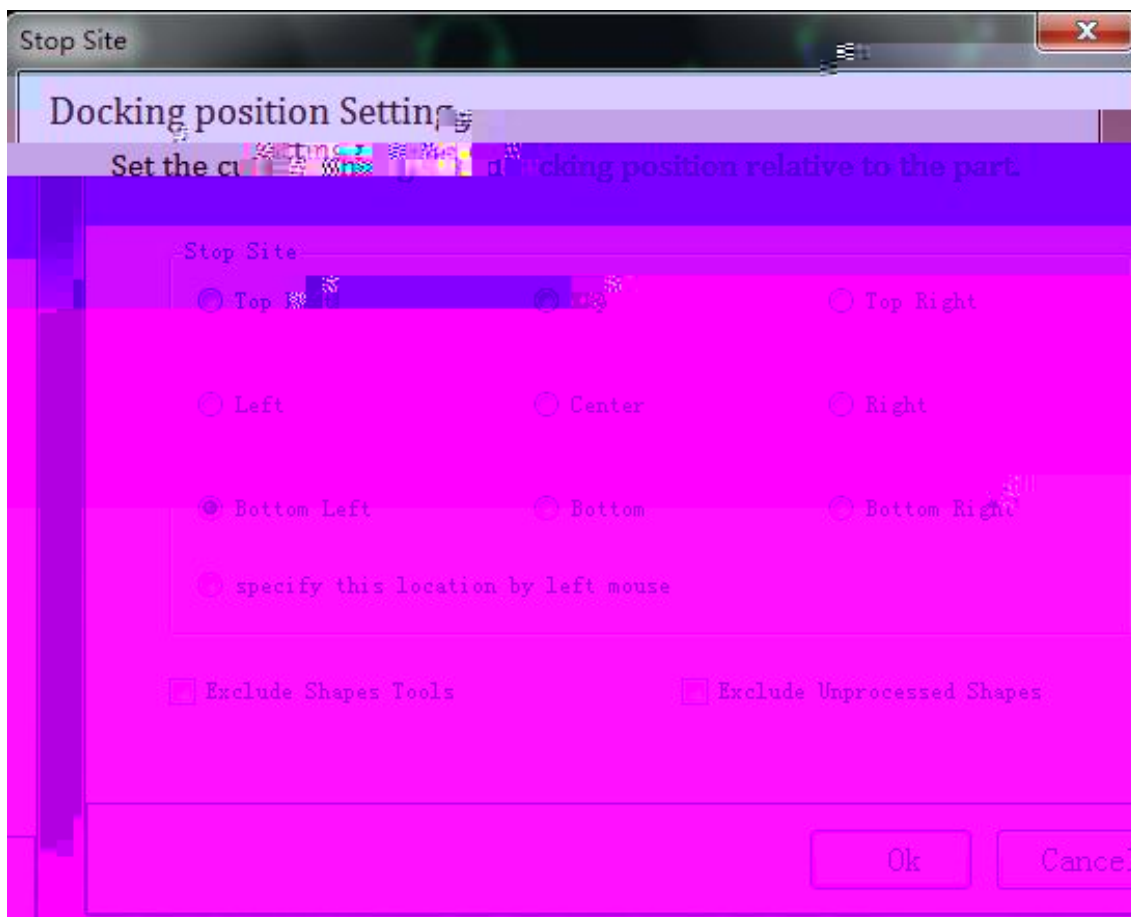


When the status of the lock in the interface is , the length and width of the graphic scale according to its original size. To set length and width individually, click on the button as  to unlock it according to the needed

Common Options: select the option according to needed

Set the cutting head to a relative position to the graphic as the zero reference (docking position).
The bottom left is recommended.

Click on Zero Ref button in THE Home sub-page and set the parameters. After setting, click on OK to complete, as shown below:

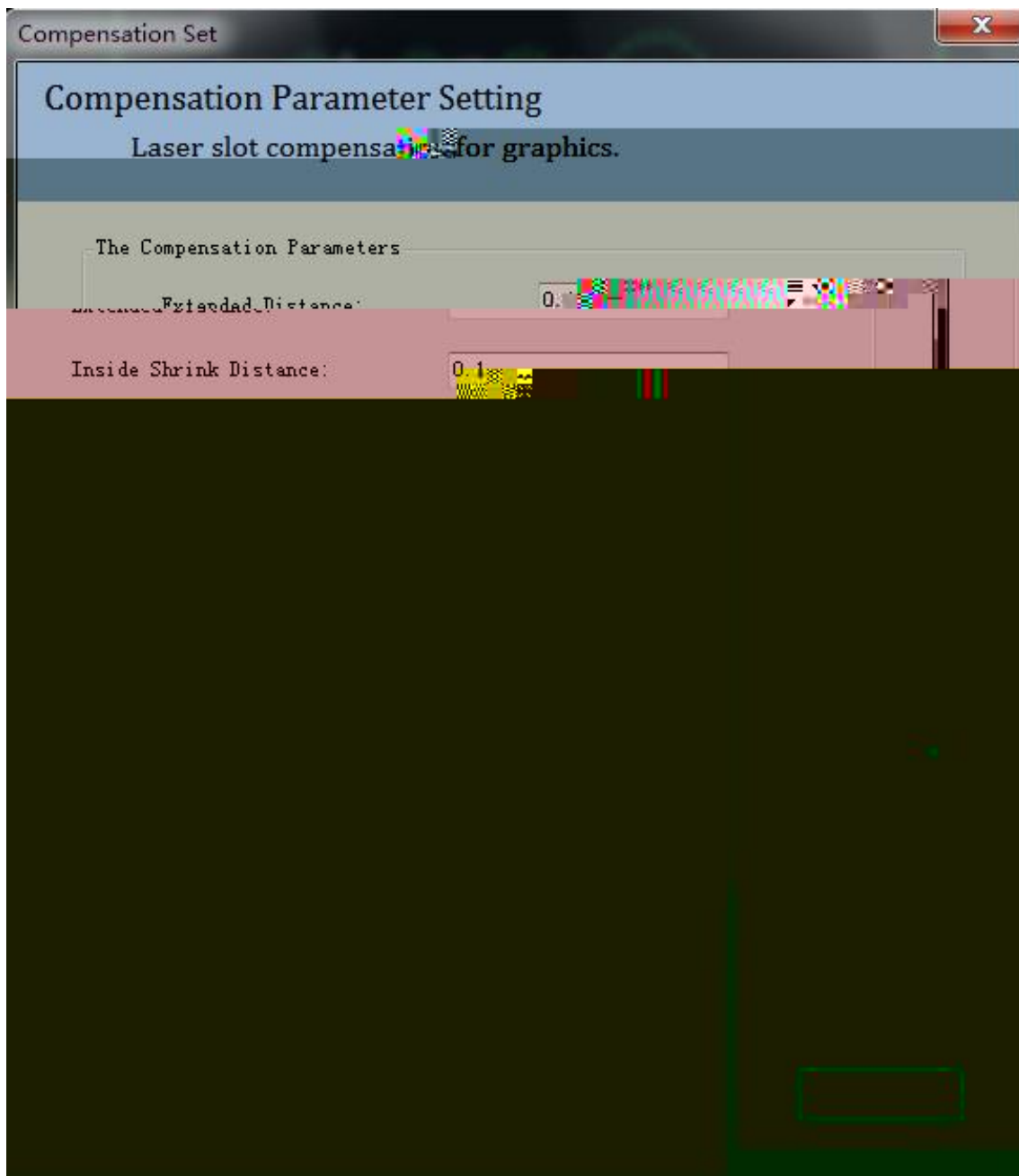


Note: “Select the zero reference by following the graphic” can be selected in the “Advanced Selection” in the Configuration Tool.

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By scaling the graphic, compensate the impact of the cutting slots to the parts. Sharp and round corner can be chosen in sharp point processing. Way of compensation includes Expand and contract, All expand, and All contract.

Select the graphic to be compensated and click on Compensate in Home sub-page. Set the parameters and click on OK to compensate the selected graphic, as shown below:



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Extended Distance: the value that increases in equal intervals outwards.

Inside Shrink Distance: the value that decreases in equal intervals inwards.

Sharp Point Processing: to use sharp or filleted corner.

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Read the configuration in the compensation library by selecting materials and thickness to quickly apply.

Modify default parameters in the compensation library by selecting materials and thickness.

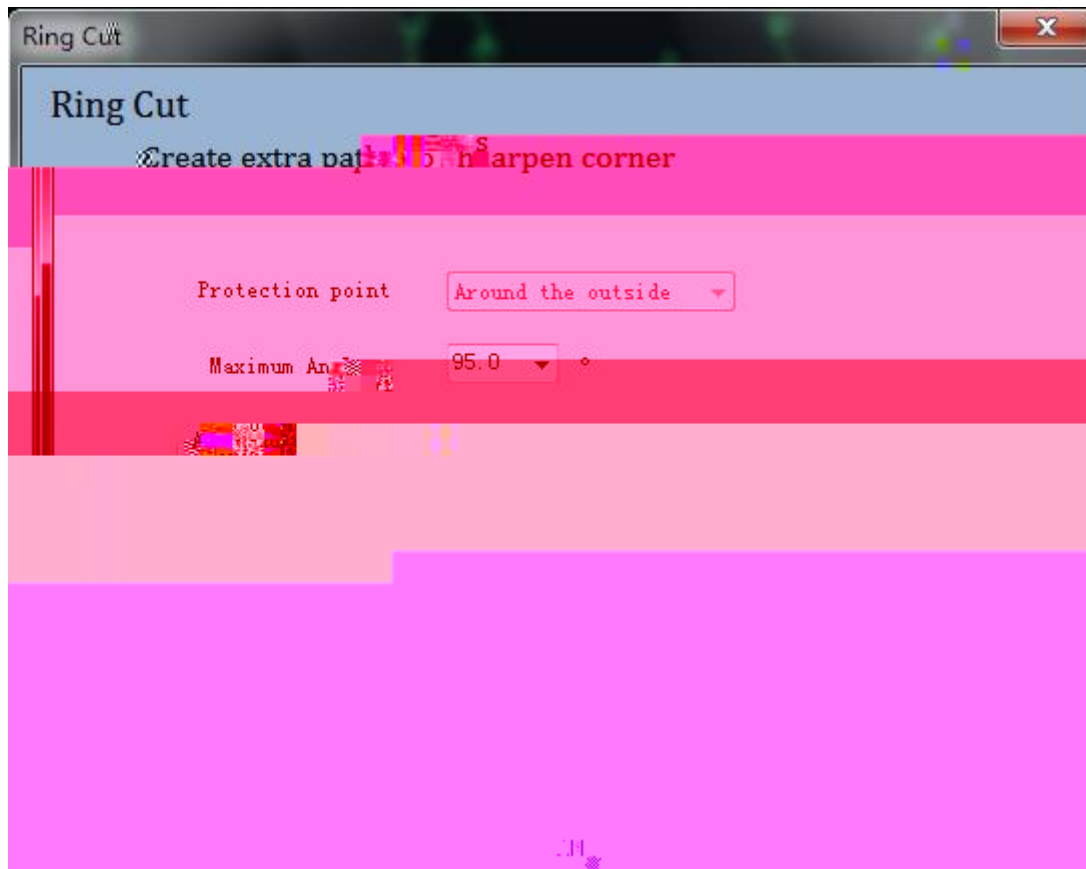
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Way of compensation includes Out Expand and In Shrink, All Out Expand, and All In Shrink.

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Add Ring Cut or cooling point to the graphic.

Select the graphic to be ring cut and click on Ring Cut in Home sub-page. Set the parameter for ring cut and click on OK to complete, as shown below:



Protection Point: select the type of ring cut., with the option of around the outside.

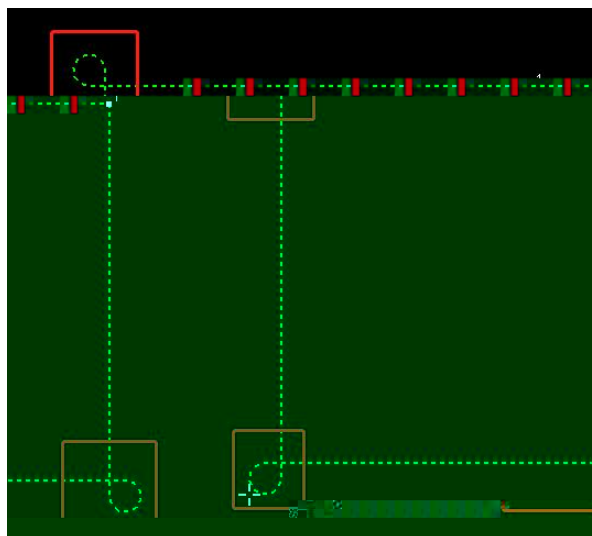
Maximum Angle: corner bigger than this angle will not use the outside cutting.

OutsideCut Type: select the arc or triangle as the contour of outside cutting.

OutsideCut Length: set the perimeter of the contour of outside cutting.

ShortestSide Length: set the shortest edge length.

The graphic added with ring cut is shown on the left.



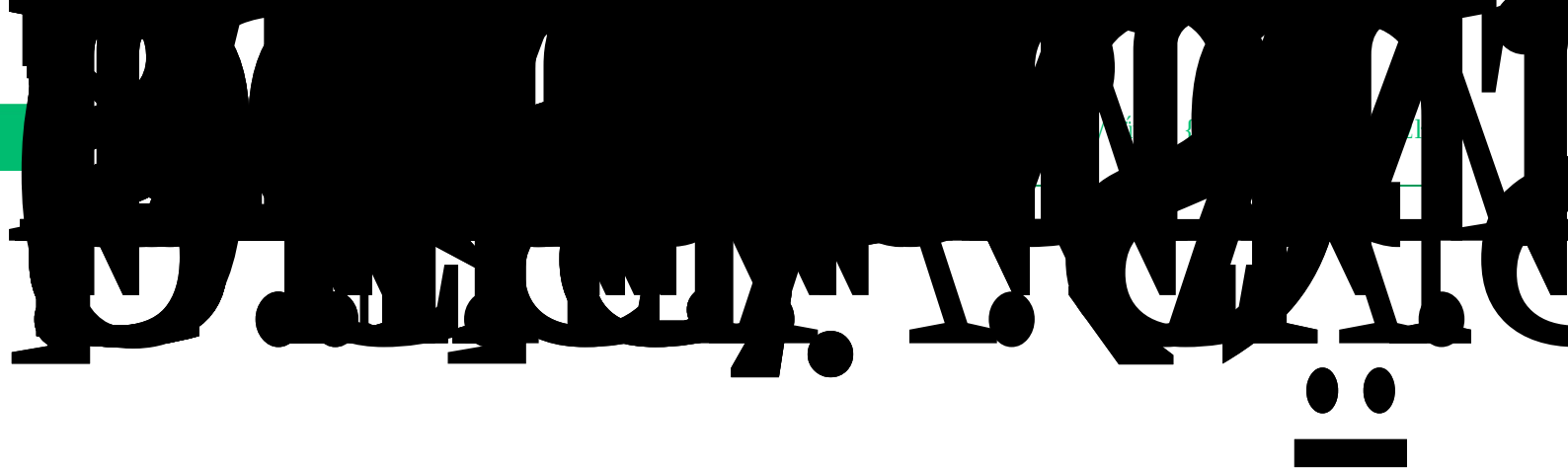
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The workpiece with micro connections can avoid falling off. Micro Joint includes manual and auto ones.

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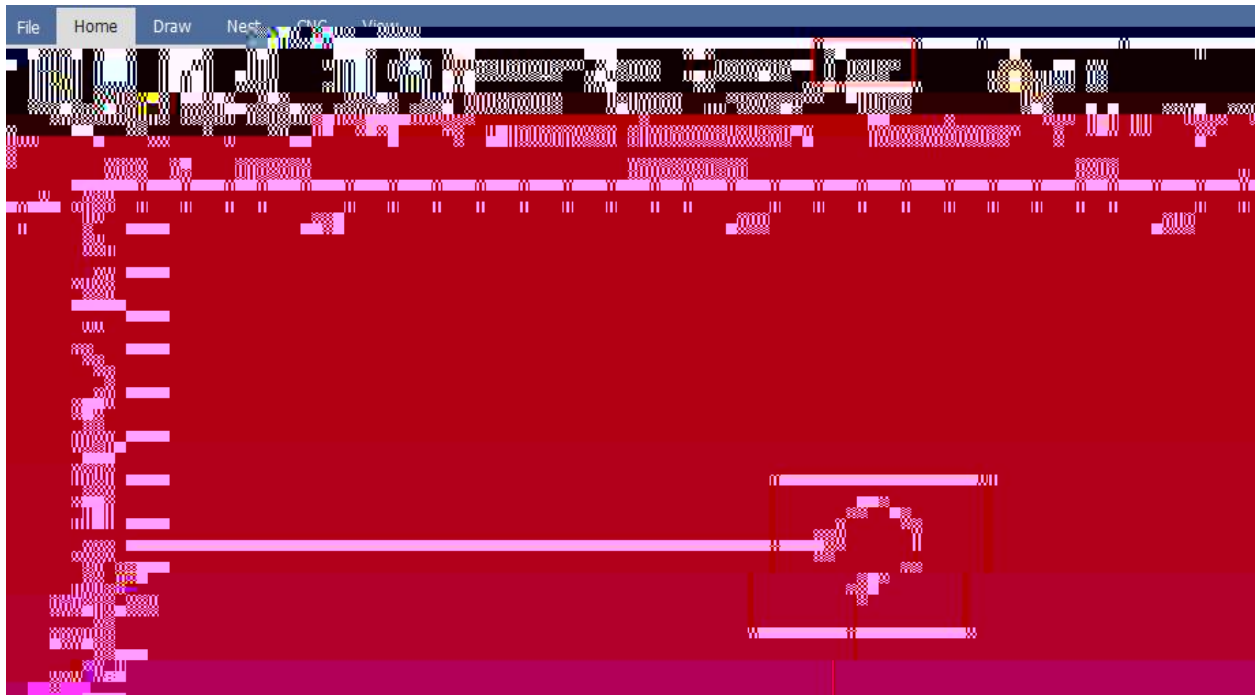
Select the graphic

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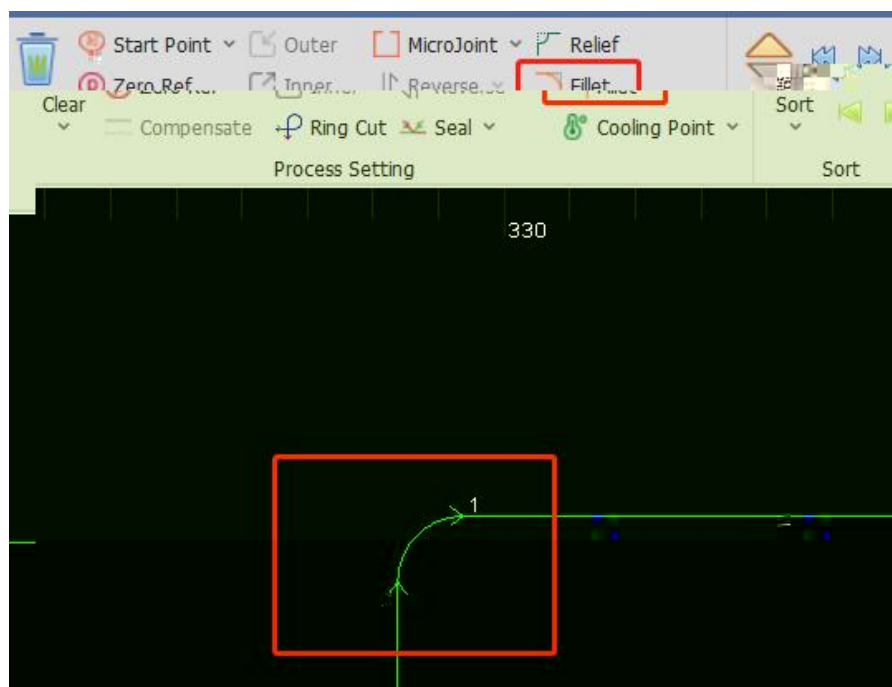
Click on  button to generate release corners for the following bending process.



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Switch the sharp corners into the filleted corner.

Select the graphic needs fillet and click on Fillet button in the Home sub-page. Set the fillet radius and click on OK. Then, click on the corner of the graphic to complete. The setting of fillet is shown as below:

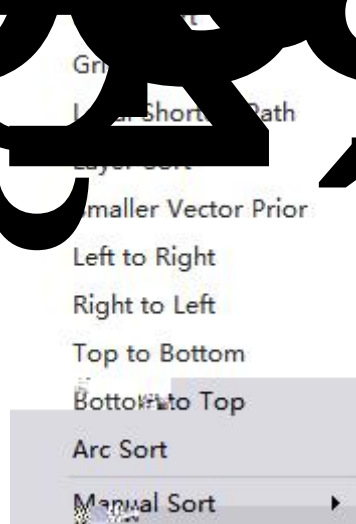


The cooling point is used to avoid the workp

are manual and auto cooling.

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Click on Cooling Point in the Home sub-page

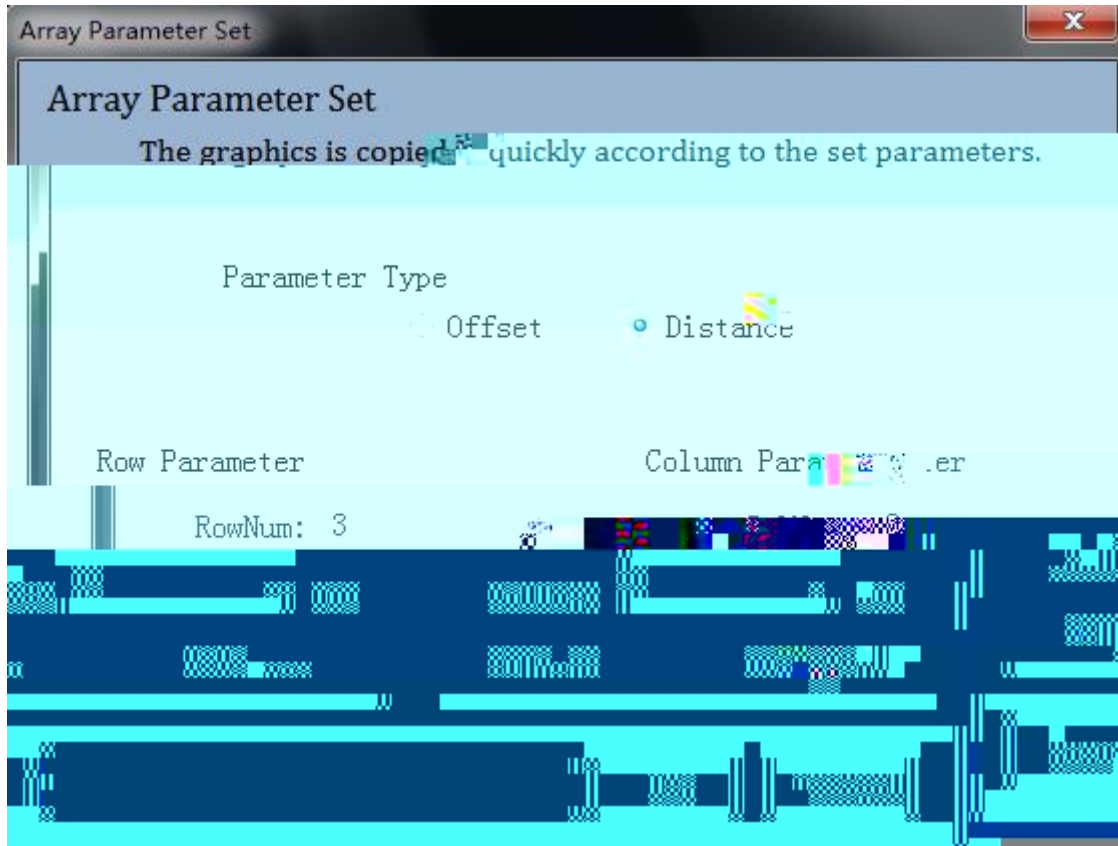


In the Sort column, four “manual sorting buttons” are provided for each column:  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort,  Manual Sort, Manual Sort,

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Quickly copy the graphics. There are two kinds of an array: rectangular and circular.

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Select the graphic to be copied in an array and click on Array button in the Home sub-page.

Set parameters of the array and click on OK to complete. The parameter setting is shown as below:

t FŵF-YŠŴŠŵ ŵěLJŠ: select to array according to offset or distance.

w2Ŵ κ /2ŵdzYy'bdzY: the number of row and column in the array

ów2Ŵ κ /2ŵdzYyŵ 5ŵăŵFyŴŴ κ hŴăŠŵ: the distance and offset value

| LJ κ 52Ŵy'κ [ŠŴŵ κ wŴEKŵ: directions of the array

óMú /ŵŴŴdzFŵ



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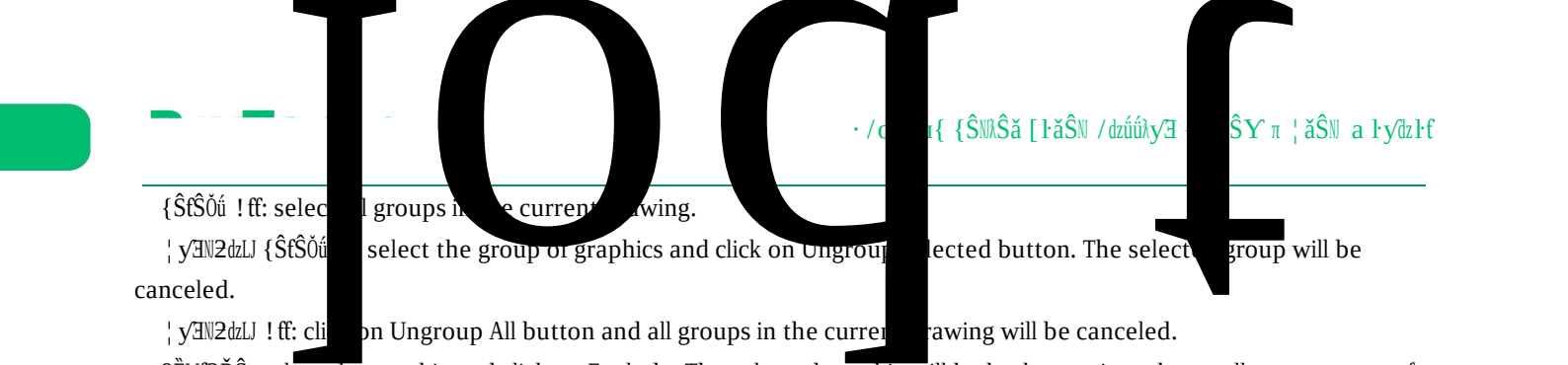
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{ŠtŠŮú !ff: select all groups in the current drawing.
,yŒW2dzLJ {ŠtŠŮú select the group of graphics and click on Ungroup Selected button. The selected group will be canceled.
,yŒW2dzLJ !ff: click on Ungroup All button and all groups in the current drawing will be canceled.
9ÈLJf2ŘŠ: select the graphic and click on Explode. The selected graphic will be broken up into the smallest segments of a line (arcs or lines).

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Set the selected graphics as the path and layer. The parameter setting

Circle: select to cut a circular path.

Linear: select to cut a rectangular and polygon-shaped path.

Radar: linear cutting path without smooth joints. Other cutting modes include Round and Leadline.

Sort: select different sort modes to use different fly cutting paths.

Start: select the start position of the graphic to be processed.

Line/Array: if the horizontal and vertical length of the graphic is smaller than the tolerance, the graphic will be in a line or an array; if larger, the graphic will be in multiple lines or arrays.

Smooth: if the distance between two graphics is less than the max smooth joint length, an arc tangent will be auto-added to the cutting path to speed up processing and improve efficiency.

Radius: radius of the arc mentioned in Max Smooth Joint.

Lift: select to lift the Z-axis in the travel between two groups in fly cutting.

Laser: laser on in advance for better cutting off the workpiece.

Delay: as over-cutting distance, laser off delay is for better cutting off the workpiece.

Combine

Combine workpieces with common edges to use one edge for cost efficiency and improve processing efficiency.

Select graphics to be co-edged and click on Co-edge button in the Home sub-menu

Graphic

Co-edge

OK

Cancel



After setting the maximum distance, click the **OK** button.

Select the graphic to be bridged and click the **Bridge** button. Double-click the drawing area to see the bridge.

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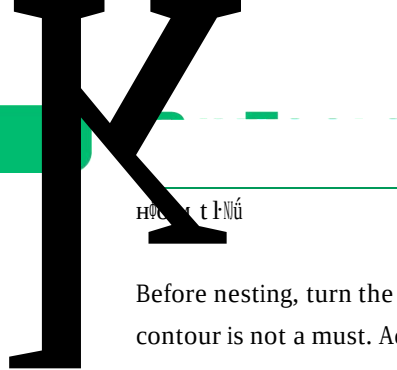
When drawing a graphic in the drawing area, there will be a prompt of next step in the log area.

User can complete the drawing with the prompt.

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Click on Line button in the Draw sub-page and click on the star

(2) Input the number of vertices (fixed-point) and no other information. Set the center, inner vertex, and outer vertex in the drawing area. Draw the star-shaped graphic by the three points. Its angle can be rotated randomly, as shown below:



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Before nesting, turn the graphics into parts for cutting. A part consists of its inner and outer contours, and the outer contour is not a must. Add parts by selecting the graphics and right-clicking to add

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Set the nesting parameters.

óMÚ .21:NIŘ {Ŝú: set the size and count of plates

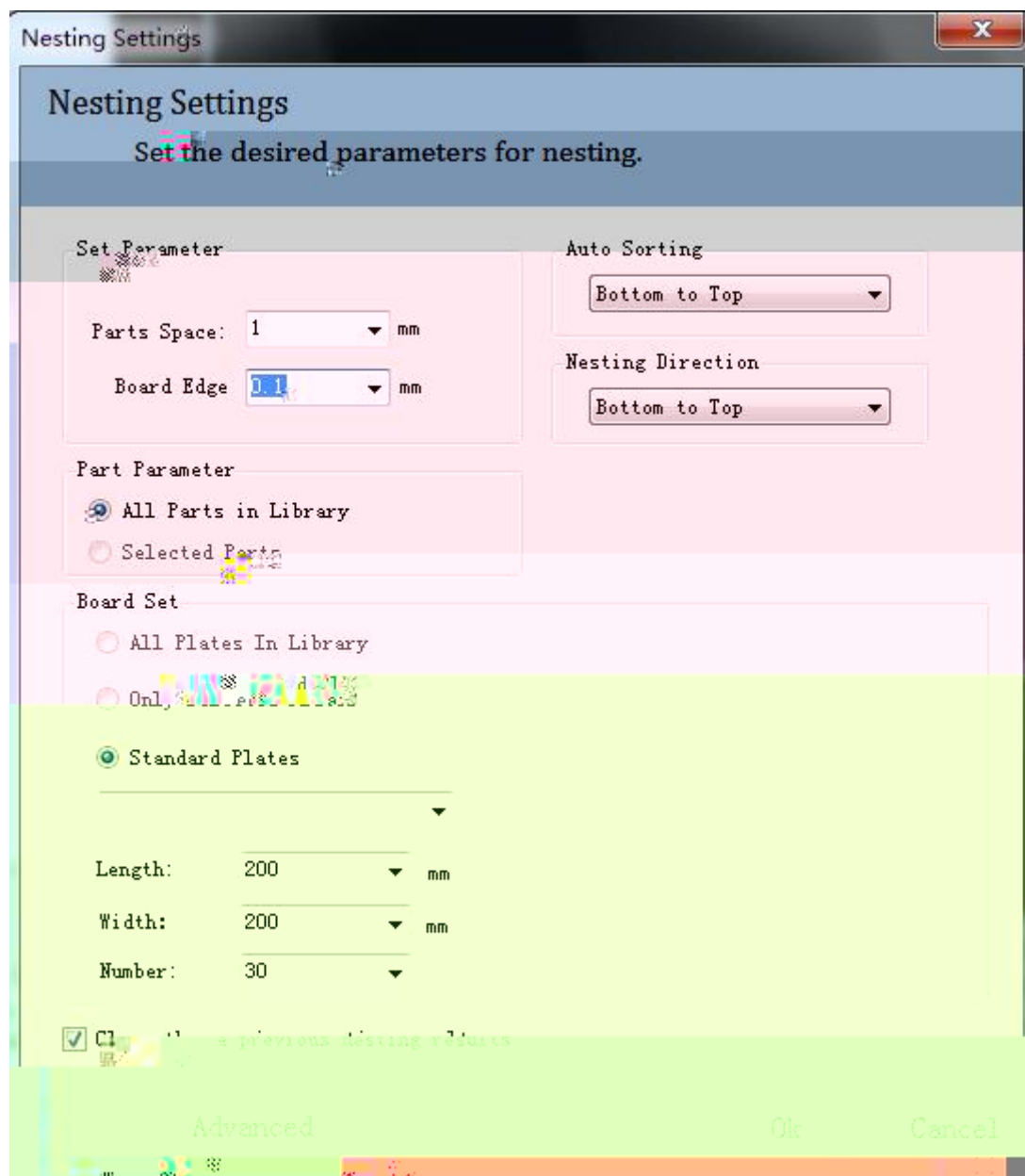
ÓHÚ {ŠŮ t 1N1YŠŮŠN: set the space between parts and interval between the part and the sheet margin (board edge).

óóú !dzú2 {2WúlyE: set the sorting way and the nesting direction of the parts.

όπου t l·Nú t l·Nl·YŜúŜN: select the parts to nest.

όπου /fſi:n ũkſ LJNſŌλ2dză yſăũlyſ Nſădzfũă: whether to continue the nesting on the former results.

óú !ŔŒ!yŔŖ: click to set the advanced parameters.



$$\mathbb{H} \circ \mathbb{O} \circ \mathbb{P} \quad ! \, \check{\mathbb{R}} \acute{\mathbb{O}} \mathbb{I} \cdot \mathbb{Y} \check{\mathbb{O}} \hat{\mathbb{S}} \check{\mathbb{R}} \quad \mathbb{t} \mathbb{I} \cdot \mathbb{N} \mathbb{I} \cdot \mathbb{Y} \hat{\mathbb{S}} \acute{\mathbb{U}} \hat{\mathbb{S}} \mathbb{N}$$

$\mathbf{l} \cdot \Phi \{ \dot{\mathbf{u}} \cdot \mathbf{N} \dot{\mathbf{u}} \} \mathbf{E}$: set the start point of nesting.

00 b5: set the priority of nesting direction.

α : refers to the angle of each placement when placing the part (the smaller the angle, the better the result and the slower the nesting speed).

β : refers to the precision of nesting. The smaller the the value, the better the effect and the slower the speed.

S6: decide whether to place the part in the hole of the waste area of another part. Select to improve the utilization of the plate with slower nesting speed.

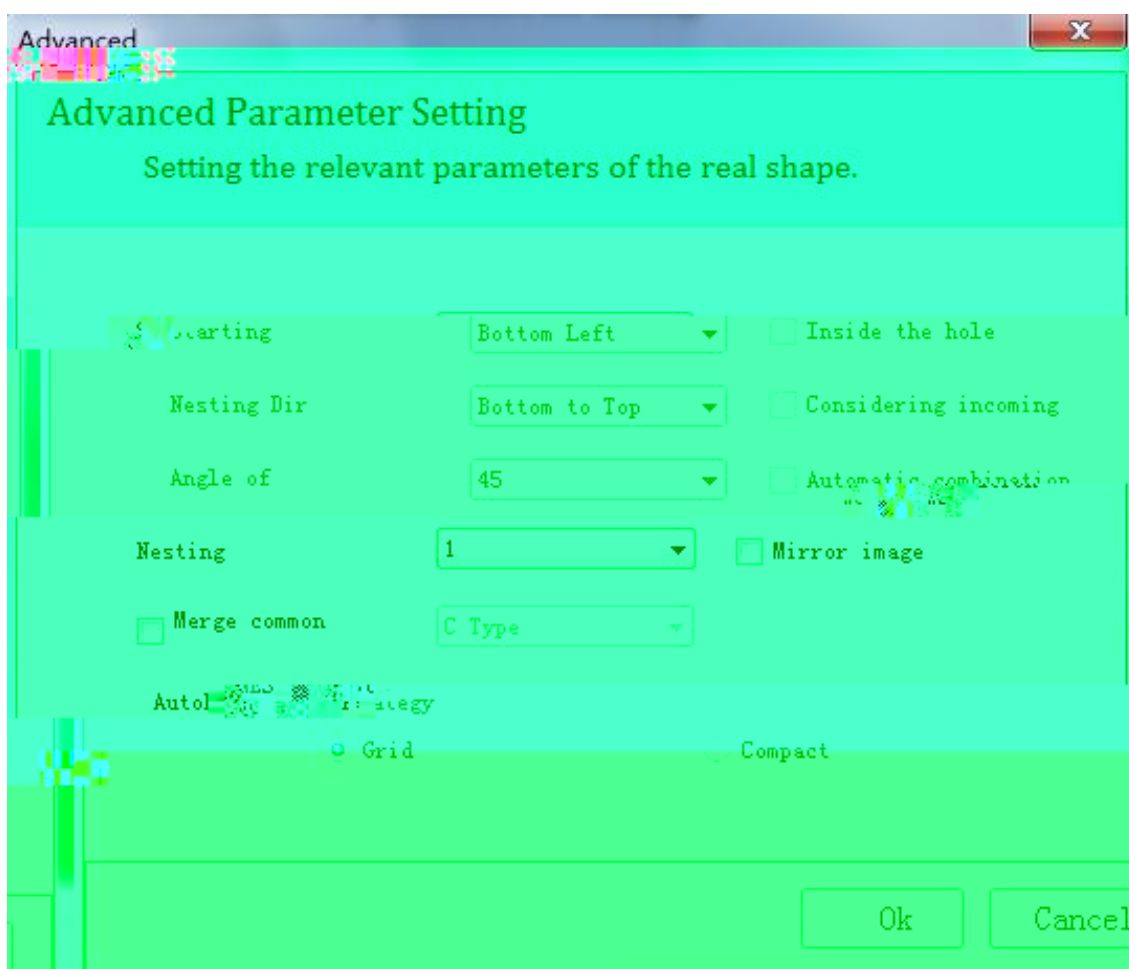
TP / 2vāĩRŠŋvE ʎvŎ2YʎvE: decide whether the edges of the part have deadlines.

⌘ ! dzú2Yl:úŒŒ Œ2YŒŒyl:úŒ2y: combine the placed nesting parts and copy the resulting nesting to speed up nesting.

KEYWORDS: allow the mirroring of the graphic to improve the utilization of the plate.

turn on the function and complete the nesting on co-edged parts.

!dzú2b9{¢ǎúN-úÊÈ: select grid to sort the parts in rows and select compact to sort into any space.

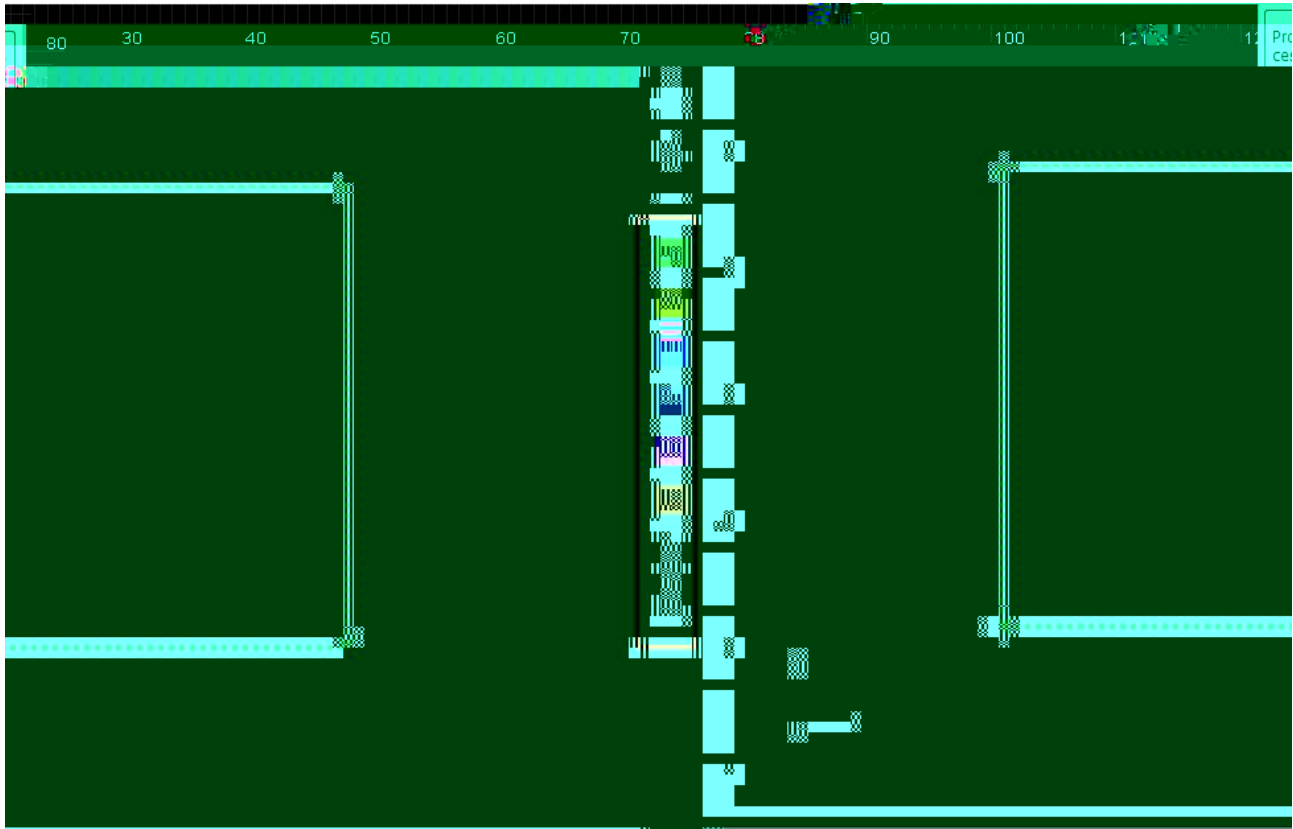


Right-click on any material in the process structure to add a new material or thickness type. Users can add a new type of material or the thickness of material in the interface popped up.

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$$o\phi o \ [1\text{-}\hat{e}\hat{S}_N]$$

There are 7 process layers and every one of them can be set separately.

Select the graphic in the drawing area and click on the corresponding layer button on the right. And the graphic will be processed using the selected layer process, as shown below:



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tN2ÔŠăă/yƏ a 2ŘŠ	
5ŜTfY	After selecting the function, the process is first carried out along the cutting path using the film parameters to defilm, and then carried out the normal process according to the layer parameters. Select the function and you can set the defilm parameter in the FilmCut interface.
tNŠLJŠNÖŠ	Selecting the function, prepierce at the start of the graphic or the start point of the leadline, before actual cutting. There is also a function of auto-group prepiercing which can be selected in the global parameter.
tN2ÔŠăă/yƏ Y2ŘŠ	Select standard or fixed height cutting. Fixed height cutting refers to cutting at a fixed height.

oΦp / dzüüλyE t l·Nl·YŜüŜNl

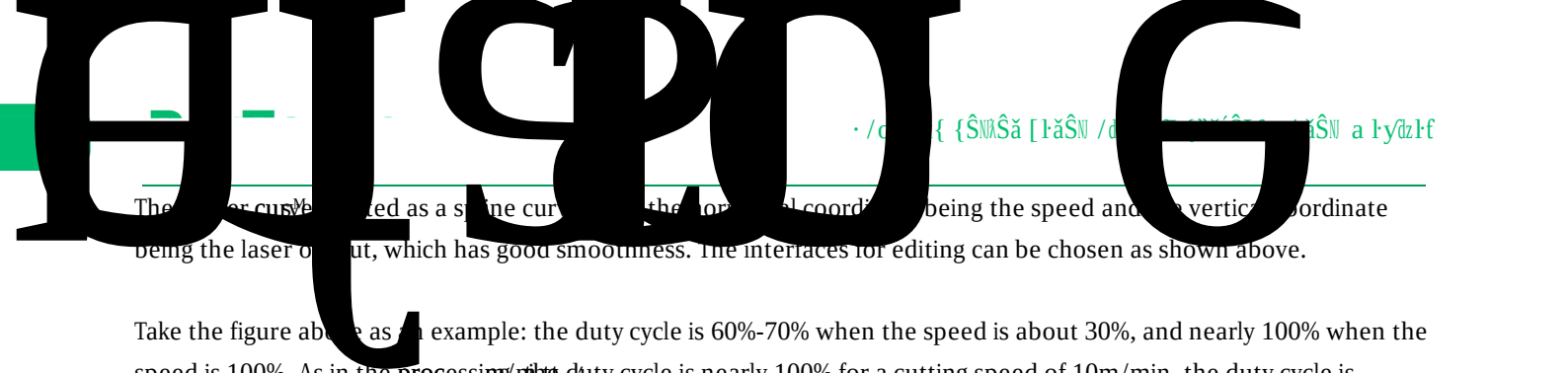
/dzúúlyE t l·Nl·YŜúŜNl

b2ÎÎtŠ KŠŒKŰ	Set the cutting height from the nozzle to the plate.
{LÎŠŠŔ	Set the command speed of cutting.
t2 ø ŠŦ	Set the peak power of the laser in cutting.
/dzŰ ŦŦŠlj	Set the frequency of the laser in cutting. It refers to the time of beam out in 1 second. The higher the value, the more continuous the laser beam is. 5000Hz is a successive beam.
5dzŰë ŐëŦtŠ	Set the duty cycle of the laser in cutting. It refers to the ratio of beam-out duration in one beam-out cycle and the total time. The higher the ratio value, the higher the average power is when beam out. When it is 100%, it means the average power equals the peak power.

D K s



926



The laser curve is used as a spline curve, the horizontal coordinate being the speed and the vertical coordinate being the laser output, which has good smoothness. The interfaces for editing can be chosen as shown above.

Take the figure above as an example: the duty cycle is 60%-70% when the speed is about 30%, and nearly 100% when the speed is 100%. As in the processing, the duty cycle is nearly 100% for a cutting speed of 10m/min, the duty cycle is 60%-70% for a cutting speed of about 3m/min.

The default parameter



select to start using the trace as mic point and not the thick plate. Select the joint in processing

Set the percentage of the retention left in cutting

select to use the leadline.

Speed: set the cutting speed of graphic with leadlines.

Duty: set the beam-out duty cycle when laser cutting with leadlines.

Frequency: set the beam-out frequency when laser cutting with leadlines.

select to descent slowly when cutting with leadlines.

Lead height: set the nozzle height when cutting with leadlines.

Stable dist: slowly descent the leadline height to the stable height of the plate in cutting. Set the stable distance of the leadline from the plate.

Focus Adjmt: select to use the focus adjustment of leadlines.

Focus point: set the focus position when cutting with leadlines.

Initial leadline: set the initial length of leadline of focus-adjust cutting.

Lead circle: select to use the lead circle.

Speed: set the processing speed of the lead circle.

Radius: set the radius of the lead circle.

Select to use the process to remove slags.



cutting

cutting

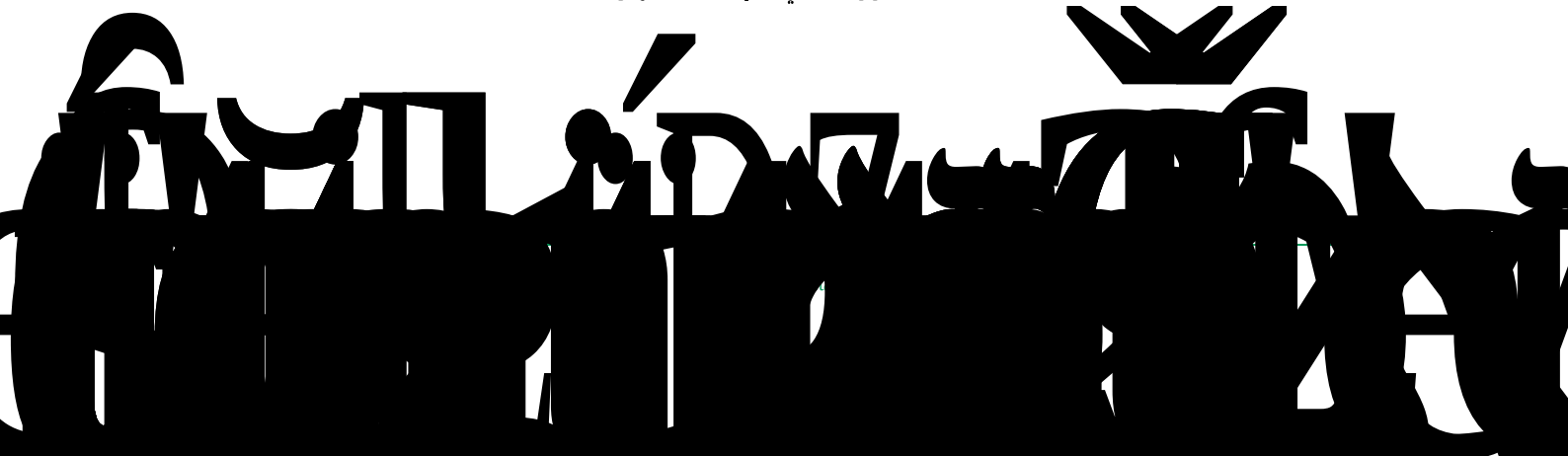
cutting

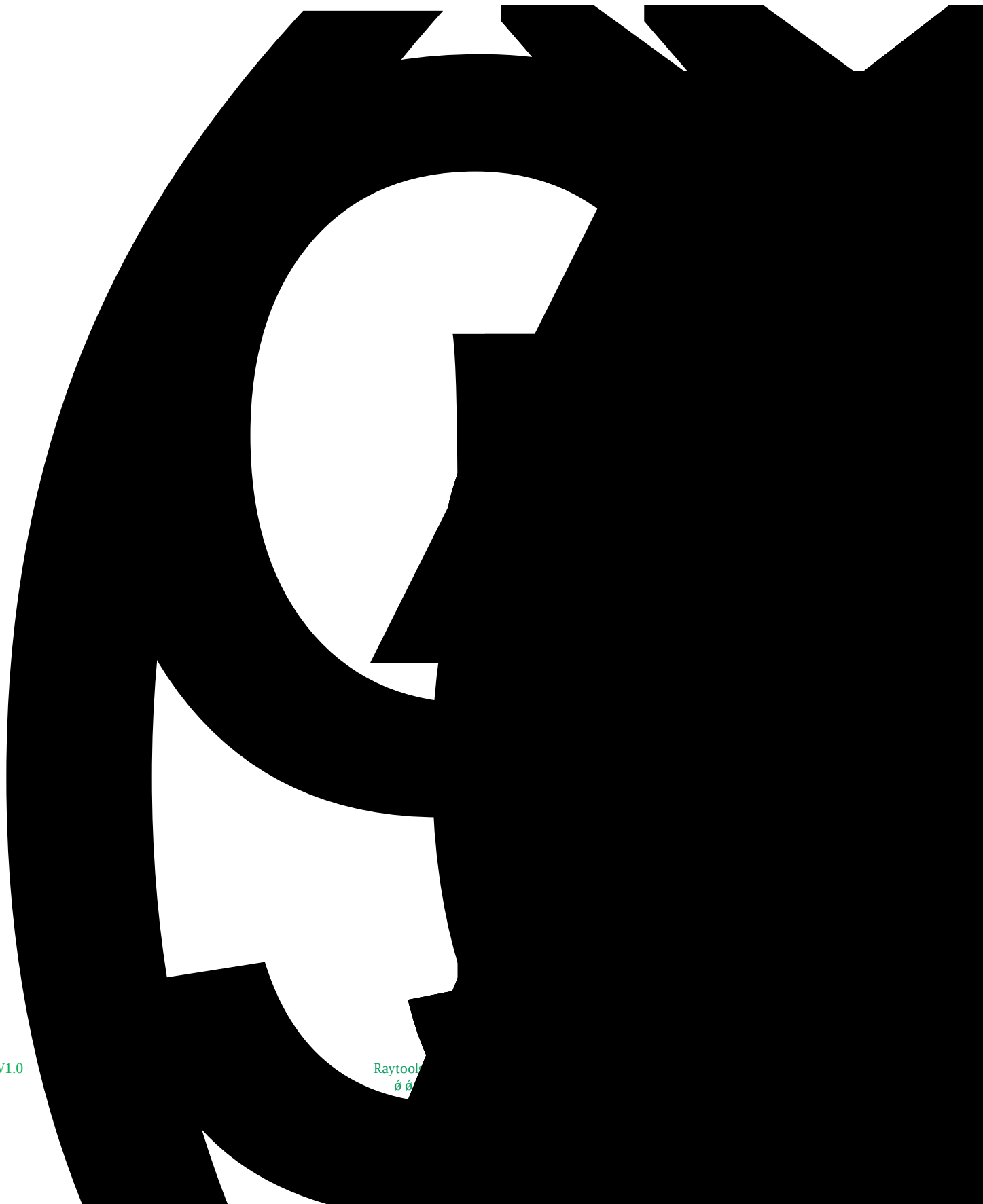
cutting

cutting

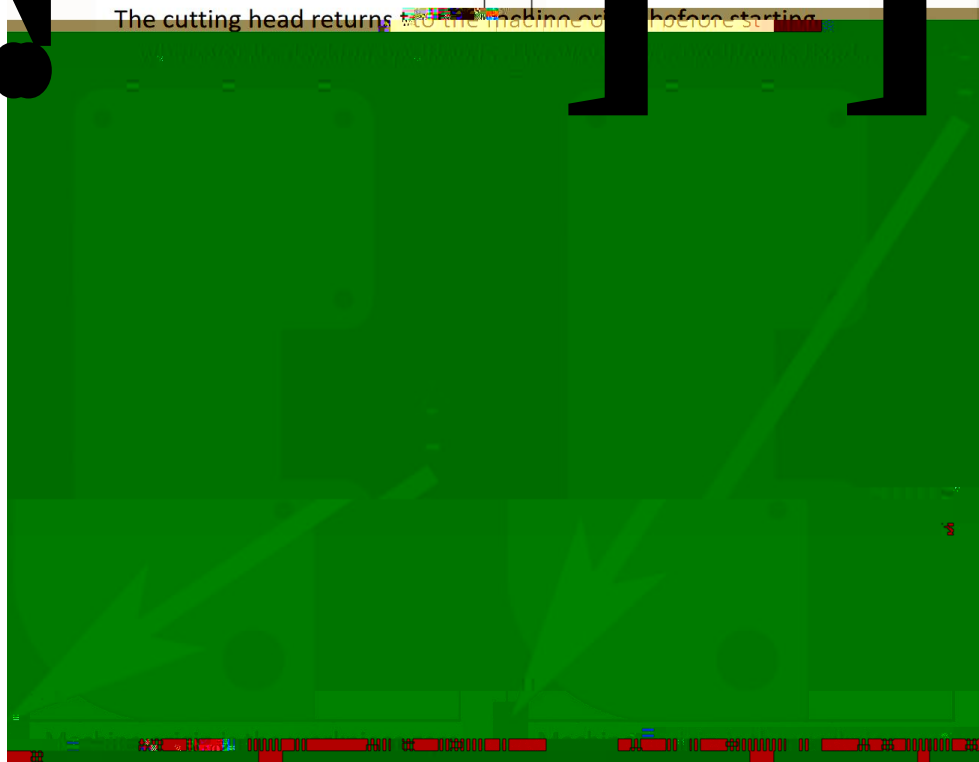
cutting

cutting with 6









When selecting workpiece coordinate 1 to 9, the workpiece zero point is set manually by the user by clicking on Mark, and once set saved for a long time until the next setting. The workpiece coordinate system is suitable for batch production for the workpiece position is generally determined by a fixed fixture. Keep the processing in the same position each time by using workpiece coordinate 1 to 9 .

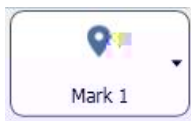
Click on the status



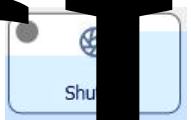
click on Mark to mark the current point as the cutting head position.



click on Go Marker and the cutting head will move to the marked point.



11 positions can be marked. Select the needed marked point in the drop-down bar.



once the pin of the laser shutter connects to the system, click on Shutter to control the shutter switch.



once the pin of the red laser light connects to the system, click on Aiming to control the red light.



click on Laser to make the beam out to confirm the status of the laser beam. Set the laser parameters

by clicking on the drop-down bar on its right.



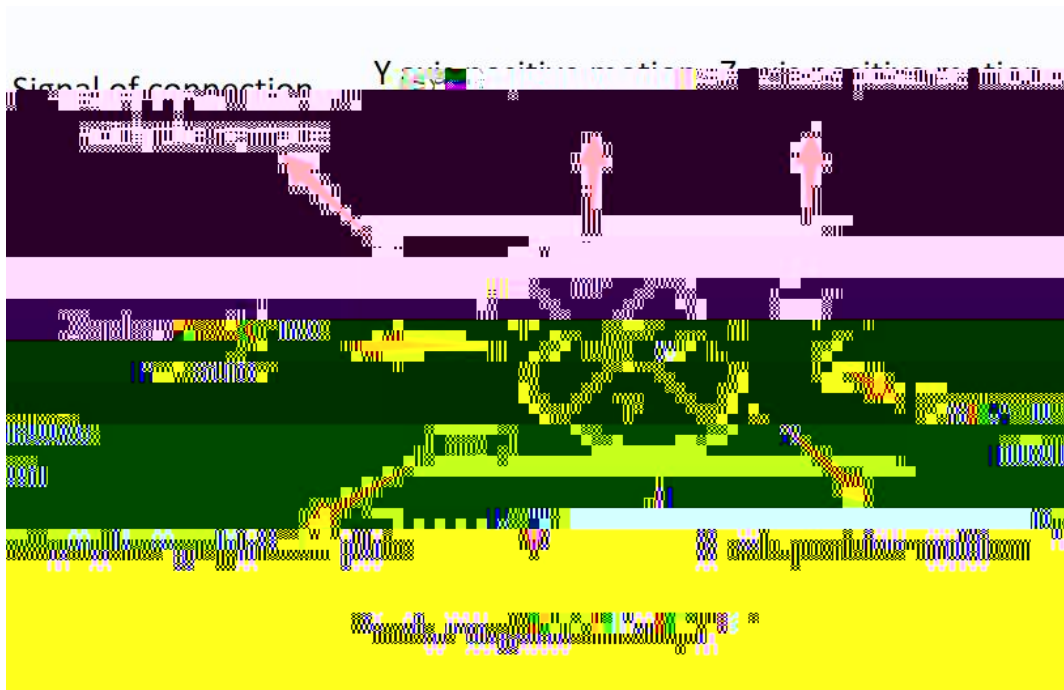
click on Follow to bring the cutting head to a diřrs



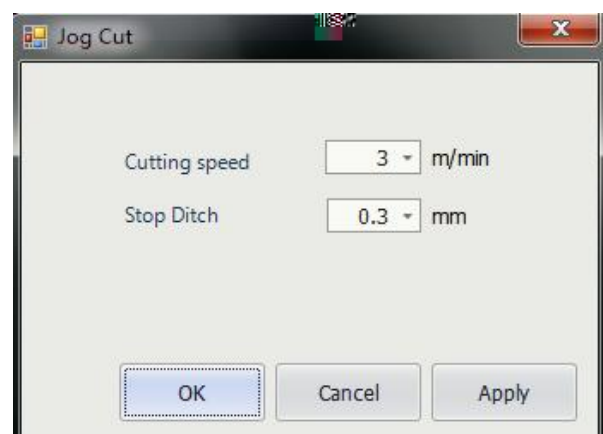
click on Blow to manually open or close the protective gas.



Click on Nitrogen. Air, nitrogen, and oxygen are all selectable for blowing.



Clăú: after selecting and setting the speed, the axis m





dry run is different from the actual processing, with no laser, no gas, and no following-up, with other steps the same as the actual ones. If user clicks on pause while dry running and wants to continue to dry run, click on Dry run to resume the simulation. In paused status, clicking on Start leads to the actual processing from the position.



set the processing in loops at the position and click on Loop to see the following interface:



only enter the breakpoint mode in paused state. In breakpoint mode, most functions in the control panel will be locked. User can move the cutting head by button for manual operating or wireless remote, or using the fixed-height.



click on Pt CONT button, and the cutting head will move back to the located position and resume processing.



click on the button in paused state, and the cutting head will move backward along the cutting path.

Click on Pause to stop the motion.



click on the button in paused state, and the cutting head will move forward.



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click on the button to return to the machine origin. Note that right after opening the software, the first step is to return to zero and then the functions in control panel will be activated.



after selecting, at the end of the processing, the cutting head will auto-move back to the selected marked point.



9100'

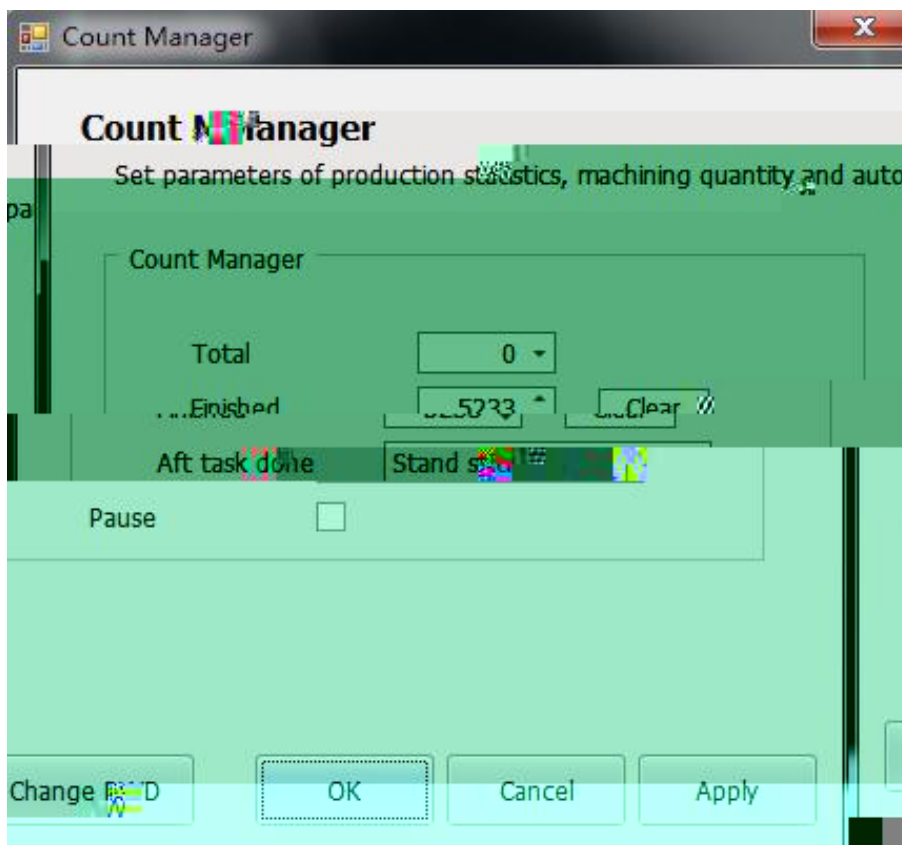
060010'

Count/Plan num15233/0 Manage

Count: count for each time of actual processing.

Plan: the actual count planned to be processed.

Click on Mange button in the processing control and there pops up an interface as shown below:



02úlf: set the expected count of the workpiece to be processed.

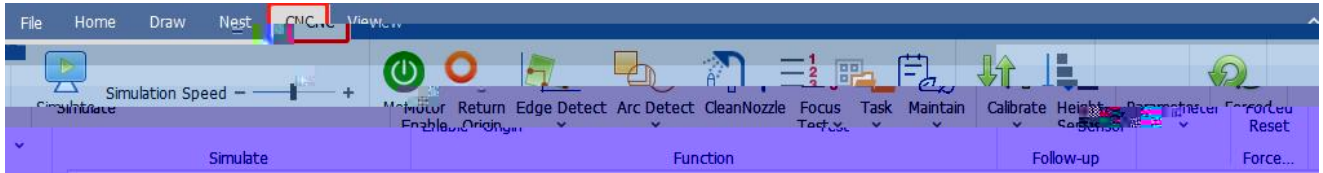
0lyŵăKŠŖ: display the completed count.

/fŠIŵ: clear current completed count.

!Tú ŵlăŵ Ŗ2yŠ: there are corresponding prompts after the processing plan has been completed.

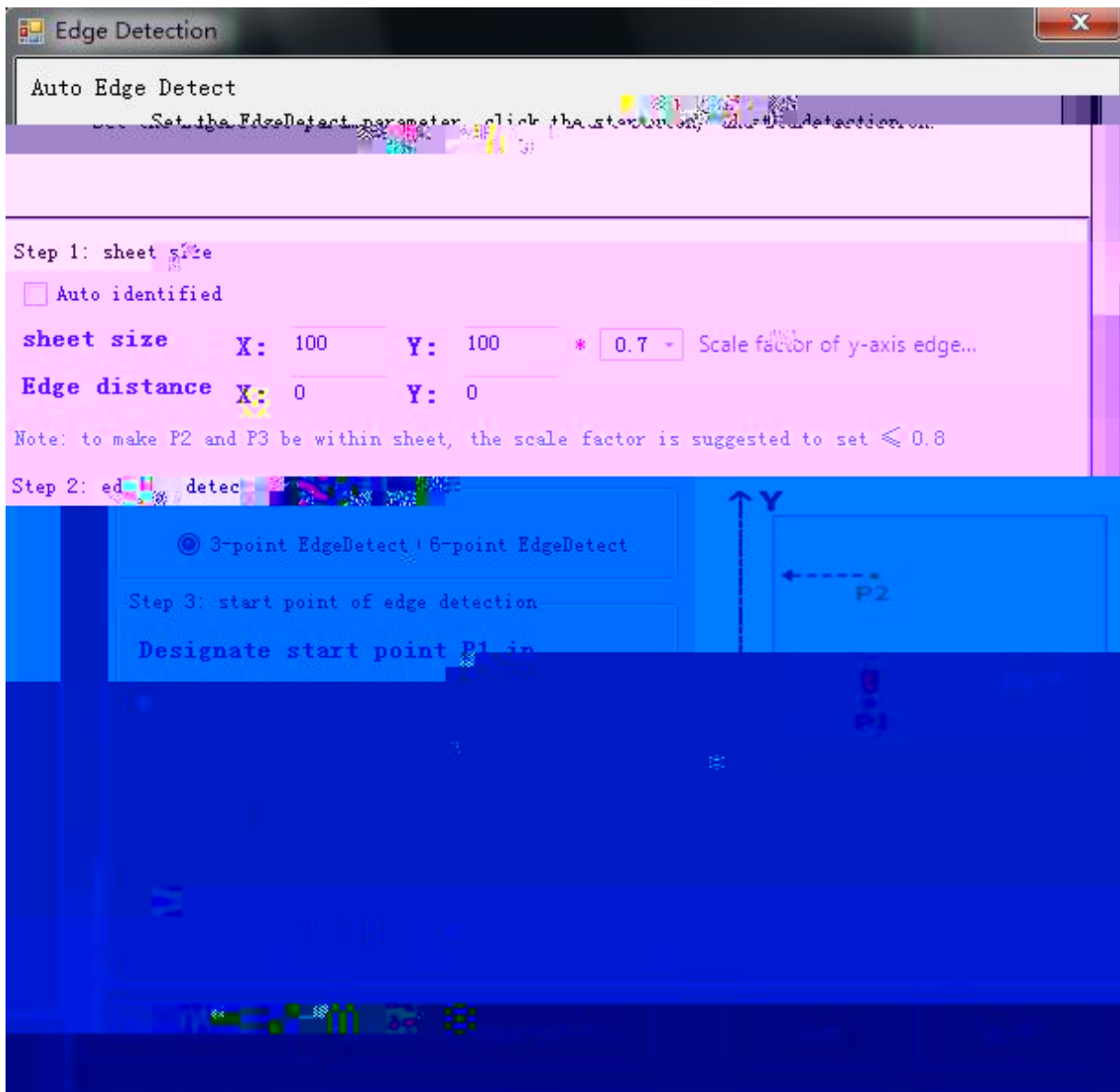
tI dzăŠ: select to pause the count of processing.

Click on the button
shown below:



Before processing, confirm the cutting parameters.

Before processing, confirm the cutting parameters.



After completing the parameter setting, click on Save and start edge detection button, and the machine will start working. The result will be shown below the drawing area.

The following are the parameters for auto-detection:

(Sheet size) !đúž ŀŔŖŷŭŕŦŖŨŦŖŮ: select to auto calculate the sheet size after edge detection.

{KŜŜŨ űŦŦŦ: X is the length of the sheet in X-axis direction of the machine. Y is the length of the sheet in Y-axis direction of the machine. Please note that inputting the wrong sheet size will risk sticking the cutting head. Please input the actual sheet size!

9RÆŠ ŘřăřlyŸŠ: set the positional deviation of Point P for edge detection. A positive value shifts the zero point of the sheet inwards, a negative value outwards.

3-point and 6-point. It is suggested to use the 6-point edge detection on the thin sheet. Detect the edge by a single point 6 times to avoid interference from the tooth tip to the edge detection on a thin sheet.

5ŠŋŠŌă TN2Y ūKŠ ŌdzŋŋŠyŭ LJ2ăŋŋ2y 2T ūKŠ ŌdzúŋlyE KŠIŘ: select, and the edge detection will start from the current position of the cutting head. After selecting, please move the cutting head into the range of the sheet to make sure there is a sheet **under** cutting head.

5ŠŋŠŌă ŠŘĚŠ TN2Y ūKŠ ŋŭIŋŋ LJ2ŋŋŭ: select, and the edge detection will start from a fixed position. Move the cutting head into the range of the sheet and click on Save start point button. The current position of the cutting head will be recorded as a fixed position **for** detecting edge.

/IŋŋdzIŋŋŋ ŋ2ŋŋŋ2y IyĚtŠ: the rotation angle obtained by edge detection.

5ŠŋIŋĚŠŘ LJŋŋŋŋŋŋă 2T ŠŘĚŠ ŘŠŋŠŌŋ2y: Set the basic parameters for capacitive edge detection.

IŠŋĚKŭ: the height from the cutting head to the plate **in** the process of edge detection.

{ŋŋLJ KŠŋĚKŭ: the sensitive degree in edge detection. The higher the value, the **less** sensitive

Менеджер

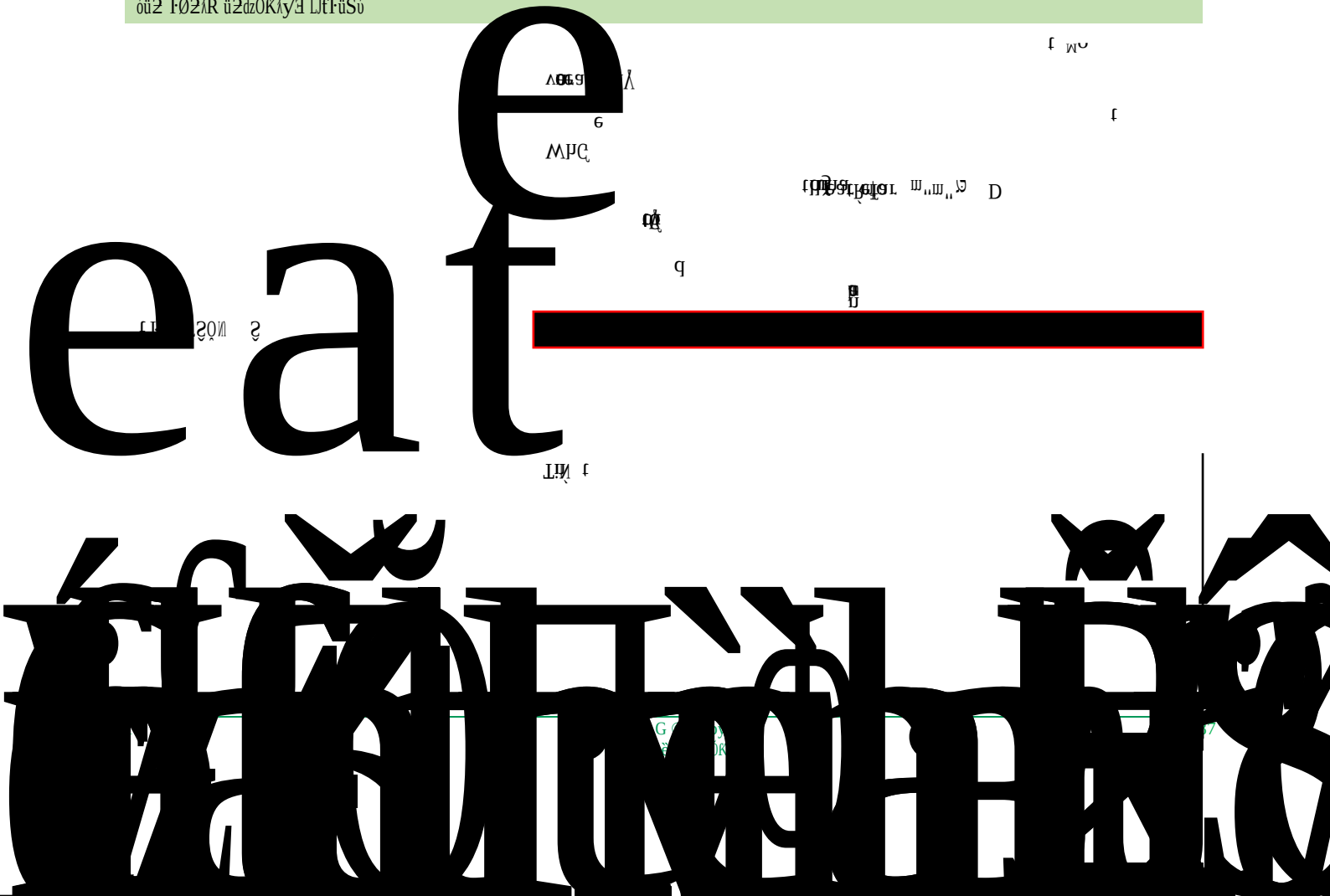
· /оллл{ {ŠŸŠă [1Šă

%.%



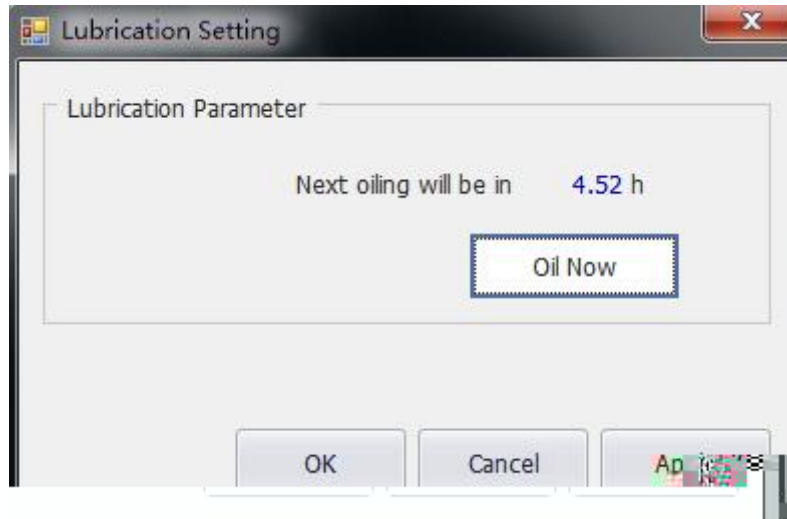
		previous cycle (1ms ago) is greater than this value, the cutting head is considered to have touched plate, and at this time the cutting head moves upwards and starts the calibration to record the capacitance value in relation to the height.
LyLJfIÔŠ ōłŘáK	0.2	It refers to the range of height used to decide if the cutting head follow-up is in place.
{ŠŋŲ2 CŠŠŘōIŲĴ ŘŠfIë	5	The delay can be auto-measured or adjusted by auto-tuning.
I ŠŋEKú äŠyă2ŋ ŘŠfIë	10	The delay can be auto-measured or adjusted by auto-tuning.

ċ2dzŲKπtfl-úŠ t IŋI-YŠúŠŋ		
t IŋI-YŠŠŋ	5ŠfIċŋ	wŠYIŋĴ
t ŋŠŋŲlyE ŘŠfIë	200	In piercing, the system will alarm and stop cutting if the duration of the touch-plate signal is greater than the value.
/ dzúlyE ŘŠfIë	100	In cutting, the system will alarm and stop cutting if the duration of the touch-plate signal is greater than the value.
5ŋë ŋdzYŘŠfIë	50	When the cutting head is in a dry run, the system will alarm and stop cutting if the duration of the touch-plate signal is greater than the value.
t ŋŠŋ2dzŲKπLJfI-úŠ KŠŋEKú	0.1	If the current height is smaller then the value, it means the touch-plate signal is triggered. The function is used to protect the value, so it is fine to use the default value.
9ŘĖŠ f2f2 ō óú2 IŲ2ŋŘ ū2dzŲKlyE LJfI-úŠ	Disable	Enabled, once the cutting head is



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Click on Lubrication button in the CNC sub-page, and the setting interface will pop up. Users can check the time to do the next lubrication, or click on Oil Now to lubricate the machine at once, as shown below:



201

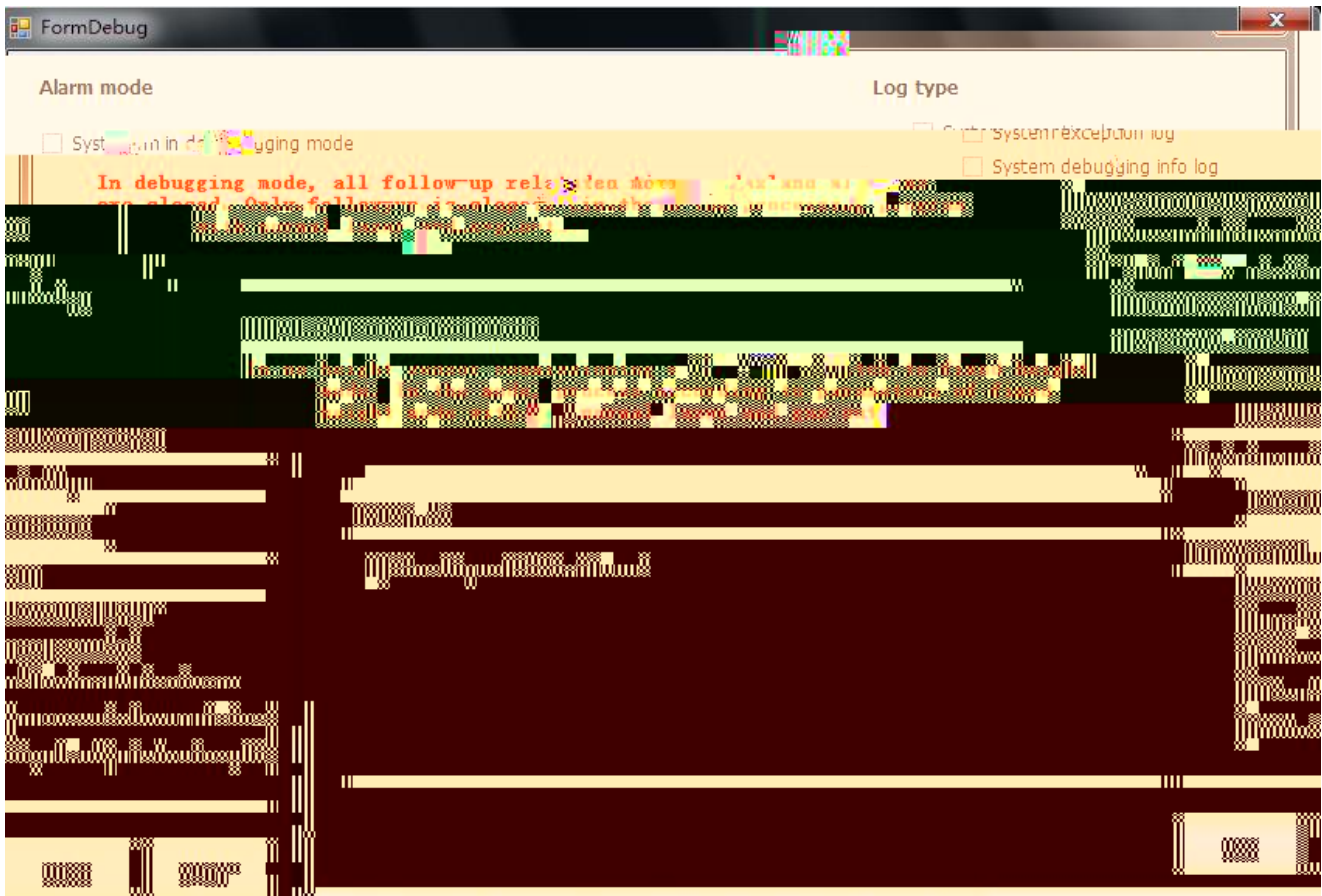
· /олл{ {ŠŵŠă [FăŠŵ /dzúŵyЭ {ěăŵŠY π |ăŠŵ a FyŵzFf

p 5dzăŵ ŠY2ŴF

Click on Dust Removal button in the CNC sub-page, and the **setting** interface will pop up. Users can set the function open or closed, and timed output. There are also selections for all on or all off

pΦmπ {ŠúŵyЭ

Click on Setting button in the CNC sub-page and its interface will pop up, as shown below:



!fŵNY Y2ŘŠ: select or deselect according to the users' needs while debugging. The default is to deselect.

[2Э ũëŁŠ: types of the log can be selected according to the users' needs and viewed in the log area.

Cfë /dzú Ő2YYŵăăŵ2yŵyЭ: click on Parameter Setting to turn on the EDS2000 hardware for fly cutting. It's also able to set the fine and coarse tuning of the pulse.

/2yŵŵ2f ŁŵŵyŠf:

{ ōŵŐK ũ2 ŐŠŵŵŐŦf ŘăŵŦŦë: select to place the control panel at the bottom of the mainform. It is suitable for vertical display. The setting takes effect after re-open the software.

9yŦŵŦŠ ŁŵŵŐŠăăŵyЭ f2ŐŦ: select to lock the control panel and make it ineffective.

! dzú2 ŠyŦŵŦŠ ōKŠyăăŦŵăă2ŦŦŦŦŦ: select to make the software auto-enable once opened. The software will not auto-enable if deselect the function.

a FyŵŦŦŦë Y2ŐŠ ŦŦŦăă Ř2 ōyō ŦŦŦăă ũ2 ŦŐ2ŦŦ ũ2dzŐK ŁŦŦŦŦŦ: turn on the touch-plate detection when Z axis moving.

! dzú2 ŦŦŦŦyЭ ōKŠyăăŦŦăă ũ2dzŐKŠă ŁŦŦŦŦŦ: turn on the function of Z-axis lifting when touching plate.



cŋo {ěăŋŠY

The system alarm is mainly used to display the current alarm or prompt, as shown below:

Draw	System	Alarm		
	Time	Alarm No.	Status	Message
!	13:12:05.412	20021	Active	Machine tool axis not all return to zero
!	13:12:13.765	20021	Active	The system has detected that the height regulator is not calibrated. Please calibrate.

b2ŋŠ: when a red alarm displays in the status bar, it is needed to clear the alarm before processing. If it is a grey or white prompt, it does not matter to the processing.