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<td>72</td>
</tr>
</tbody>
</table>
1.1 About these instructions

These instructions provide all the information and safety precautions needed for the safe operation of the product.

1.2 Information on the product

<table>
<thead>
<tr>
<th>Product designation</th>
<th>Part number</th>
</tr>
</thead>
<tbody>
<tr>
<td>DRO 101</td>
<td>1197252-xx</td>
</tr>
<tr>
<td>1 axis</td>
<td></td>
</tr>
<tr>
<td>DRO 102</td>
<td>1197252-xx</td>
</tr>
<tr>
<td>2 axes</td>
<td></td>
</tr>
<tr>
<td>DRO 103</td>
<td>1197252-xx</td>
</tr>
<tr>
<td>3 axes</td>
<td></td>
</tr>
</tbody>
</table>

The ID label is provided on the back of the product.

Example:

1. Product designation
2. Part number
3. Index

Validity of the documentation

Before using the documentation and the product, you need to verify that the documentation matches the product.

- Compare the part number and the index indicated in the documentation with the corresponding data given on the ID label of the product
- If the part numbers and indexes match, the documentation is valid

If the part numbers and indexes do not match so that the documentation is not valid, you will find the current documentation for the product at www.acu-rite.com.
1.3 Notes on reading the documentation

The table below lists the components of the documentation in the order of priority for reading.

**WARNING**

**Fatal accidents, personal injury or property damage caused by non-compliance with the documentation!**

Failure to comply with the documentation may result in fatal accidents, personal injury or property damage.
- Read the documentation carefully from beginning to end
- Keep the documentation for future reference

<table>
<thead>
<tr>
<th>Documentation</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Addendum</td>
<td>An addendum supplements or supersedes the corresponding contents of the Operating Instructions and, if applicable, of the Installation Instructions. If this document is included in the shipment, read it first before you proceed. All other contents of the documentation retain their validity.</td>
</tr>
<tr>
<td>Installation Instructions</td>
<td>The Installation Instructions contain all the information and safety precautions needed for the proper mounting and installation of the product. They are an excerpt from the Operating Instructions and are included in every shipment. This document has the second highest priority for reading.</td>
</tr>
<tr>
<td>Operating Instructions</td>
<td>The Operating Instructions contain all the information and safety precautions needed for the proper operation of the product according to its intended use. This document has the third highest priority for reading. This documentation can be downloaded from the download area at <a href="http://www.acu-rite.com">www.acu-rite.com</a>. The Operating Instructions must be printed prior to commissioning the product.</td>
</tr>
<tr>
<td>Documentation of connected measuring devices and other peripherals</td>
<td>These documents are not included in delivery. They are shipped with the respective measuring devices and peripherals.</td>
</tr>
</tbody>
</table>

**Would you like any changes, or have you found any errors?**

We are continuously striving to improve our documentation for you. Please help us by sending your requests to the following e-mail address:

[usordoc@acu-rite.de](mailto:usordoc@acu-rite.de)
1.4 Storage and distribution of the documentation

The instructions must be kept in the immediate vicinity of the workplace and must be available to all personnel at all times. The operating company must inform the personnel where these instructions are kept. If the instructions have become illegible, the operating company must obtain a replacement from the manufacturer.

If the product is given or resold to any other party, the following documents must be passed on to the new owner:

- Addendum, if supplied
- Installation Instructions
- Operating Instructions

1.5 Target group for the instructions

These instructions must be read and observed by every person who performs any of the following tasks:

- Mounting
- Installation
- Commissioning
- Setup, programming and operation
- Service, cleaning and maintenance
- Troubleshooting
- Removal and disposal
1.6 Notes in this documentation

Safety precautions
Comply with all safety precautions indicated in these instructions and in your machine tool builder’s documentation!
Precautionary statements warn of hazards in handling the product and provide information on their prevention. Precautionary statements are classified by hazard severity and divided into the following groups:

**DANGER**

Danger indicates hazards for persons. If you do not follow the avoidance instructions, the hazard will **result in death or severe injury**.

**WARNING**

Warning indicates hazards for persons. If you do not follow the avoidance instructions, the hazard **could result in death or serious injury**.

**CAUTION**

Caution indicates hazards for persons. If you do not follow the avoidance instructions, the hazard **could result in minor or moderate injury**.

**NOTICE**

Notice indicates danger to material or data. If you do not follow the avoidance instructions, the hazard **could result in things other than personal injury, like property damage**.
### Informational notes

Observe the informational notes provided in these instructions to ensure reliable and efficient operation of the product. In these instructions, you will find the following informational notes:

<table>
<thead>
<tr>
<th>Symbol</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>📘</td>
<td>The information symbol indicates a <strong>tip</strong>. A tip provides important additional or supplementary information.</td>
</tr>
</tbody>
</table>
| 🔧     | The gear symbol indicates that the function described **depends on the machine**, e.g.:
  - Your machine must feature a certain software or hardware option
  - The behavior of the function depends on the configurable machine settings |
| 📚     | The book symbol represents a **cross reference** to external documentation, e.g. the documentation of your machine tool builder or other supplier. |
1.7 Symbols and fonts used for marking text

In these instructions the following symbols and fonts are used for marking text:

<table>
<thead>
<tr>
<th>Format</th>
<th>Meaning</th>
</tr>
</thead>
<tbody>
<tr>
<td>▶ ...</td>
<td>Identifies an action and the result of this action</td>
</tr>
<tr>
<td>&gt; ...</td>
<td>Example:</td>
</tr>
<tr>
<td>▶ Press the enter key</td>
<td></td>
</tr>
<tr>
<td>▶ The parameters are saved and the <strong>Job Setup</strong> menu is displayed</td>
<td></td>
</tr>
<tr>
<td>■ ...</td>
<td>Identifies an item of a list</td>
</tr>
<tr>
<td>■ ...</td>
<td>Example:</td>
</tr>
<tr>
<td>■ Installation Setup</td>
<td></td>
</tr>
<tr>
<td>■ Job Setup</td>
<td></td>
</tr>
<tr>
<td><strong>Bold</strong></td>
<td>Identifies menus, screens, displays, keys, and soft keys</td>
</tr>
<tr>
<td></td>
<td>Example:</td>
</tr>
<tr>
<td>▶ Press the <strong>Menu</strong> key</td>
<td></td>
</tr>
<tr>
<td>▶ The <strong>Configuration Menu</strong> is displayed</td>
<td></td>
</tr>
</tbody>
</table>
2.1 Overview
This chapter provides important safety information needed for the proper mounting, installation and operation of the product.

2.2 General safety precautions
General accepted safety precautions, in particular the applicable precautions relating to the handling of live electrical equipment, must be followed when operating the system. Failure to observe these safety precautions may result in personal injury or damage to the product.

It is understood that safety rules within individual companies vary. If a conflict exists between the material contained in these instructions and the rules of a company using this system, the more stringent rules take precedence.

2.3 Intended use
The products of the DRO 100 series are advanced digital readouts for use on manually operated machine tools. In combination with linear and angle encoders, digital readouts of the DRO 100 series display the position of the tool in more than one axis and provide further functions for operating the machine tool.

The products of the DRO 100 series:
- must only be used in commercial applications and in an industrial environment
- must be mounted on a suitable stand or holder to ensure the correct and intended operation of the product
- are intended for indoor use in an environment in which the contamination caused by humidity, dirt, oil and lubricants complies with the requirements of the specifications

The products of the DRO 100 series support the use of a wide variety of peripheral devices from different manufacturers. HEIDENHAIN cannot make any statements on the intended use of these devices. The information on their intended use, which is provided in the associated documentations, must be observed.
2.4 Improper use
When the product is used it must be ensured that no hazard to persons can result. If any such hazard exists, appropriate measures must be taken by the operating company.
In particular, the product must not be used in the following applications:
- Use and storage outside the specifications
- Outdoor use
- Use in potentially explosive atmospheres
- Use of the product as part of a safety function

2.5 Personnel qualification
The personnel for mounting, installation, operation, service, maintenance and removal must be appropriately qualified for this work and must have obtained sufficient information from the documentation supplied with the product and with the connected peripherals.
The personnel required for the individual activities to be performed on the product are indicated in the respective sections of these instructions.
The personnel groups that are responsible for mounting, installation, operation, maintenance and removal have different qualifications and tasks, which are specified as follows.

Operator
The operator uses and operates the product within the framework specified for the intended use. He is informed by the operating company about the special tasks and the potential hazards resulting from incorrect behavior.

Qualified personnel
The qualified personnel are trained by the operating company to perform advanced operation and parameterization. The qualified personnel have the required technical training, knowledge and experience and know the applicable regulations, and are thus capable of performing the assigned work regarding the application concerned and of proactively identifying and avoiding potential risks.

Electrical specialist
The electrical specialist has the required technical training, knowledge and experience and knows the applicable standards and regulations, and is thus capable of performing work on electrical systems and of proactively identifying and avoiding potential risks. Electrical specialists have been specially trained for the environment they work in.
Electrical specialists must comply with the provisions of the applicable legal regulations on accident prevention.
2.6 Obligations of the operating company

The operating company owns or leases the product and the peripherals. It is responsible that the intended use is complied with at all times.

The operating company must:
- Assign the different tasks to be performed on the product to appropriate, qualified, and authorized personnel
- Verifiably train personnel in the tasks they are allowed to perform and how to perform them
- Provide all materials and means necessary in order for personnel to complete the assigned tasks
- Ensure that the product is operated only when in perfect technical condition
- Ensure that the product is protected from unauthorized use

2.7 General safety precautions

The safety of any system incorporating the use of this product is the responsibility of the assembler or installer of the system.

The product supports the use of a wide variety of peripheral devices from different manufacturers. HEIDENHAIN cannot make any statements on the specific safety precautions to be taken for these devices. The safety precautions provided in the respective documentations must be observed. If no such information has been supplied, it must be obtained from the manufacturers concerned.

The specific safety precautions required for the individual activities to be performed on the product are indicated in the respective sections of these instructions.
### 2.7.1 Symbols in the instructions

The following safety symbols are used in this manual:

<table>
<thead>
<tr>
<th>Symbol</th>
<th>Meaning</th>
</tr>
</thead>
<tbody>
<tr>
<td><img src="image" alt="Warning Symbol" /></td>
<td>Identifies information that warns of personal injury</td>
</tr>
<tr>
<td><img src="image" alt="ESD Symbol" /></td>
<td>Identifies electrostatic sensitive devices (ESD)</td>
</tr>
<tr>
<td><img src="image" alt="ESD Wristband" /></td>
<td>ESD wristband for personal grounding</td>
</tr>
</tbody>
</table>

### 2.7.2 Symbols on the product

The following symbols are used to identify the product:

<table>
<thead>
<tr>
<th>Symbol</th>
<th>Meaning</th>
</tr>
</thead>
<tbody>
<tr>
<td><img src="image" alt="Warning Symbol" /></td>
<td>Observe the safety precautions regarding electricity and power connection before you connect the product</td>
</tr>
<tr>
<td><img src="image" alt="Earth Symbol" /></td>
<td>Earth (ground) terminal as per IEC 60417 - 5017. Observe the information on installation.</td>
</tr>
</tbody>
</table>
2.7.3 Electrical safety instructions

**WARNING**
Hazard of contact with live parts when opening the product.
This may result in electric shock, burns or death.
- Never open the housing
- Only the manufacturer is permitted to access the inside of the product

**WARNING**
Hazard of dangerous amount of electricity passing through the human body upon direct or indirect contact with live electrical parts.
This may result in electric shock, burns or death.
- Work on the electrical system and live electrical components is to be performed only by trained specialists
- For power connection and all interface connections, use only cables and connectors that comply with applicable standards
- Have the manufacturer exchange defective electrical components immediately
- Regularly inspect all connected cables and all connections on the product. Defects, such as loose connections or scorched cables, must be removed immediately

**NOTICE**
Damage to internal parts of the product!
Opening the product will result in forfeiture of warranty and guarantee.
- Never open the housing
- Only the product manufacturer is permitted to access the inside of the product
3

Transport and storage
3.1 Overview

This chapter contains all of the information necessary for the transportation and storage of the product and provides an overview of the items supplied and the available accessories for the product.

3.2 Unpacking

- Open the top lid of the box
- Remove the packaging materials
- Unpack the contents
- Check the delivery for completeness
- Check the delivery for damage

3.3 Items supplied and accessories

**Items supplied**

The following items are included in the shipment:
- Product
- Power cord (in 1197252-0x)
- Installation instructions
- Addendum (optional)

_Further information_:

"Notes on reading the documentation", Page 11

**Accessories**

The following items are optionally available and can be ordered from HEIDENHAIN as additional accessories:

<table>
<thead>
<tr>
<th>Accessories</th>
<th>Part number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Single-Pos stand</td>
<td>1197273-01</td>
</tr>
<tr>
<td>For rigid mounting, inclination angle 20°</td>
<td></td>
</tr>
<tr>
<td>Multi-Pos holder</td>
<td>1197273-02</td>
</tr>
<tr>
<td>For fastening on an arm, continuously tiltable and swivelable</td>
<td></td>
</tr>
<tr>
<td>Cover</td>
<td>1197275-01</td>
</tr>
<tr>
<td>For protection from dirt and debris</td>
<td></td>
</tr>
</tbody>
</table>

3.4 In case of damage in transit

- Have the shipping agent confirm the damage
- Keep the packaging materials for inspection
- Notify the sender of the damage
- Contact the distributor or machine manufacturer for replacement parts

**In case of damage in transit:**

- Keep the packaging materials for inspection
- Contact HEIDENHAIN or the machine manufacturer

This applies also if damage occurred to requested replacement parts during transit.
3.5 Repackaging and storage

Repackage and store the product carefully in accordance with the conditions stated below.

Repackaging

Repackaging should correspond to the original packaging as closely as possible.

- Attach all mounting parts and dust protection caps to the product or repackage them in the same way they were originally shipped from the factory.
- Repackage the product such that it is protected from impact and vibration during transit.
- Repackage the product such that it is protected from the ingress of dust or humidity.
- Place all accessories that were included in the shipment in the original packaging.

Further information: “Items supplied and accessories”, Page 24

- Include the Addendum (if it was included in the items supplied), the Installation Instructions and the Operating Instructions.

Further information: “Storage and distribution of the documentation”, Page 12

If you return the product for repair to a service agency:

- Ship the product without accessories, without measuring devices and without peripherals.

Storage of the product

- Package the product as described above.
- Observe the specified ambient conditions.
- Inspect the product for damage after any transport or longer storage times.
4 Mounting
4.1 Overview

This chapter contains all of the information necessary for mounting the product.

The following steps are only to be performed by qualified personnel.

Further information: “Personnel qualification”, Page 19

4.2 Assembly

General mounting information

The receptacle for the mounting variants is provided on the rear panel. The connection is compatible with VESA standard 100 mm x 100 mm.

The material for attaching the mounting variants on the device is included in the delivery.

You will also need the following:
- Torx T20 screwdriver
- Material for mounting on supporting surface

The product must be mounted on a stand or holder to ensure the correct and intended operation of the product.

Routing the cables

In the figures showing the stand and holder, you will find suggestions for routing the cables after mounting.

If mounting to a stand:
- Bring the cables together
- Route the cables together through the opening in the stand from behind
- Route the cables laterally to the connections
4.3 Mounting on Single-Pos stand

The Single-Pos stand allows you to place the product on a surface at an inclination angle of 20° and secure the product to a surface.

Mount the stand to the upper VESA 100 tapped holes on the rear panel of the product

- Use a Torx T20 screwdriver to tighten the countersunk head screws M4 x 8 ISO 14581 included in delivery
- Comply with the permissible tightening torque of 2.6 Nm

Secure the product against movement during operation

- Attach the supplied self-adhesive rubber pads to the bottom of the product
- If you do not screw the product to a surface, attach self-adhesive rubber pads to the bottom of the stand

Attach the rubber pads to the stand only if you do not screw the product to a surface.

Dimensions of the Single-Pos stand

ISO 14510-M4x8
Md = 2.6 Nm

21° ±2°
161.2 ±1
123 ±1

Dimensions of the Single-Pos stand

22.2
4.2
70
4.4 Mounting on Multi-Pos holder

Mount the holder to the bottom VESA 100 tapped holes on the rear panel of the product

- Use a Torx T20 screwdriver to tighten the countersunk head screws M4 x 10 ISO 14581 (black) included in delivery
- Comply with the permissible tightening torque of 2.5 Nm

You can tilt and swivel the holder to an angle that allows you to comfortably view the readout.

Dimensions of the Multi-Pos holder
4.5 Mounting a cover

The cover protects the product from dirt and debris.

Place the cover on the product
- Place the cover over the product
- Align the cover and product on the right hand side, when viewing the front of the product

Mount the cover to the product
- Remove the adhesive strip protectors from the adhesive tabs
- Fold the adhesive tabs toward the product
- Press the adhesive tabs against the product securing the tab to the product
5.1 Overview
This chapter contains all the information necessary for installing the product.

- The following steps must be performed only by qualified personnel.

Further information: “Personnel qualification”, Page 19

5.2 General information

**NOTICE**

Engaging and disengaging connecting elements!
Risk of damage to internal components.
- Do not engage or disengage any connecting elements while the unit is under power

**NOTICE**

Electrostatic discharge (ESD)!
This product contains electrostatic sensitive components that can be destroyed by electrostatic discharge (ESD).
- It is essential to observe the safety precautions for handling ESD-sensitive components
- Never touch connector pins without ensuring proper grounding
- Wear a grounded ESD wristband when handling product connections

**NOTICE**

Incorrect pin assignment!
This may cause product malfunctions or damage to the product.
- Only assign pins or wires that are used
5.3 **Product overview**

The connections on the rear panel of the device are protected by dust protection caps from contamination and damage.

**NOTICE**

Contamination or damage may result if the dust protection caps are missing!

This may impair the proper functioning of the contacts or destroy them.

- Remove dust protection caps only when connecting measuring devices or peripherals
- If you remove a measuring device or peripheral, reattach the dust protection cap to the connection

The type and number of connections may vary depending on the product version.

**Rear panel without dust protection caps**

![Rear panel without dust protection caps](image)

**Rear panel**

1. Power switch and power connection
2. Earth (ground) terminal as per IEC 60471 - 5017
3. X31: USB 2.0 Hi-Speed connection (Type C) for USB mass storage device and PC connection (beneath protective cover)
4. X1 to X3: Device variant with 9-pin D-sub connections for encoders with TTL interface
5.4 Connecting the encoders

- Remove and save the dust protection caps
- Route the cables depending on the mounting variant

**Further information:** "Assembly", Page 28

- Connect the encoder cables tightly to the respective connections

**Further information:** "Product overview", Page 35

- If the cable connectors include mounting screws, do not overtighten them

**Pin layout of X1 to X3**

<table>
<thead>
<tr>
<th>TTL</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
</tr>
<tr>
<td>/</td>
</tr>
</tbody>
</table>

5.5 Connecting a USB device

- Open the dust protection cap
- Connect the USB device or cable to the respective connection

**Further information:** "Product overview", Page 35

**Pin layout of X31**

```
A1  A2  A3  A4  A5  A6  A7  A8  A9  A10  A11  A12
GND TX1+ TX1- VBUS CC1 D+ D- SBU1 VBUS RX2- RX2+ GND
B1  B2  B3  B4  B5  B6  B7  B8  B9  B10  B11  B12
GND TX2+ TX2- VBUS CC2 D+ D- SBU2 VBUS RX1- RX1+ GND
```
5.6 Connecting the line voltage

**WARNING**

**Risk of electric shock!**

Improper grounding of electrical devices may result in serious personal injury or death by electric shock.

- Always use 3-wire power cables
- Make sure the ground wire is correctly connected to the ground of the building’s electrical installations

**WARNING**

**Fire hazard from the use of power cables that do not meet the national requirements of the respective country in which the product is mounted.**

Improper grounding of electrical devices may result in serious personal injury or death by electric shock.

- Use only a power cable that meets at least the national requirements of the respective country in which the product is mounted

- Use a power cable that meets the requirements to connect the power connection to a 3-wire grounded power outlet

**Further information:** “Product overview”, Page 35

**Pin layout of the power connection**

<table>
<thead>
<tr>
<th>1</th>
<th>2</th>
<th>3</th>
</tr>
</thead>
<tbody>
<tr>
<td>L/N</td>
<td>N/L</td>
<td></td>
</tr>
</tbody>
</table>
6

Fundamentals of positioning
6.1 Overview
This chapter describes basic positioning information.

6.2 Datums
The workpiece drawing identifies a certain point on the workpiece (example: “a corner”) as the absolute datum, and perhaps one, or more other points as relative datums.
The datum setting procedure establishes these points as the origin of the absolute, or relative coordinate systems. The workpiece, which is aligned with the machine axes, is moved to a certain position relative to the tool. The display is set to zero.

6.3 Actual position, nominal position, and Distance-To-Go

The position of the tool at any given moment is called the Actual Position \(I\), while the position that the tool is to move to is called the Nominal Position \(S\). The distance from the nominal position to the actual position is called the Distance-To-Go \(R\).
6.4 Absolute workpiece positions

Each position on the workpiece is uniquely identified by its absolute coordinates.

Example: Absolute coordinates of position 1:
X = 20 mm
Y = 10 mm
Z = 15 mm

If you are drilling, or milling a workpiece according to a workpiece drawing with absolute coordinates, the tool is moving to the value of the coordinates.
6.5 Incremental workpiece positions

A position can also be referenced to the preceding nominal position. In this case the relative datum is always the last nominal position. Such coordinates are referred to as Incremental Coordinates (increment = increase). They are also called incremental, or chain dimensions, since the positions are defined as a chain of dimensions. Incremental coordinates are designated with the prefix \( I \).

**Example:** Incremental coordinates of position 3 referenced to position 2.
Absolute coordinates of position 2:
- \( X = 10 \) mm
- \( Y = 5 \) mm
- \( Z = 20 \) mm

Incremental coordinates of position 3:
- \( I_X = 10 \) mm
- \( I_Y = 10 \) mm
- \( I_Z = 15 \) mm

If you are drilling, or milling a workpiece according to a drawing with incremental coordinates, you are moving the tool by the value of the coordinates.
6.6 Zero angle reference axis

The Zero Angle Reference Axis is the 0.0° position. It is defined as one of the two axes in the plane of rotation. The following table defines the Zero Angle where the position of the angle is zero for the three possible planes of rotation.

For angular positions, the following reference axes are defined:

<table>
<thead>
<tr>
<th>Plane</th>
<th>Zero Angle Reference Axis</th>
</tr>
</thead>
<tbody>
<tr>
<td>XY</td>
<td>+X</td>
</tr>
<tr>
<td>YZ</td>
<td>+Y</td>
</tr>
<tr>
<td>ZX</td>
<td>+Z</td>
</tr>
</tbody>
</table>

Positive direction of rotation is counterclockwise if the working plane is viewed in the negative tool axis direction.

**Example:** Angle in the working plane X / Y

<table>
<thead>
<tr>
<th>Plane</th>
<th>Zero Angle Reference Axis</th>
</tr>
</thead>
<tbody>
<tr>
<td>+45°</td>
<td>... bisecting line between +X and +Y</td>
</tr>
<tr>
<td>+/-180°</td>
<td>... negative X axis</td>
</tr>
<tr>
<td>-270°</td>
<td>... positive Y axis</td>
</tr>
</tbody>
</table>
6.7 Reading head position

The reading head position provides feedback to the product that converts the movement of the machine axes into electrical signals. The product constantly evaluates these signals, calculates the actual positions of the machine axes, and displays the positions as a numerical value on the display.

If there is an interruption in power, the calculated position will no longer correspond to the actual position. When power is restored, you can re-establish this relationship by using the reference marks on the encoder. This product provides the Reference Mark Evaluation Feature (REF).
6.8 Encoder reference marks

Encoders normally contain one or more reference marks which the Reference Mark Evaluation feature uses to re-establish datum positions after a power interruption. There are two main options available for reference marks:

- Fixed reference marks
- Distance-coded reference marks

**Fixed reference marks**

Encoders that have one or more marks on fixed intervals have to re-establish the datums correctly. It is necessary to use the same exact reference mark, during the Reference Mark Evaluation routine, that was used when the datum was first established.

**Position Trac (Distance-coded reference marks)**

Encoders that have marks separated by a specific encryption pattern allow the product to use any two pair of marks along the length of the encoder to re-establish the prior datums. This configuration means that you only have to travel less than 20 mm anywhere along the encoder to re-establish the datums when the product is switched back on.

The established datums cannot be restored from one power cycle to the next if the reference marks were not crossed before the datums were set.
7

Basic operation
7.1  Overview

This chapter describes the product’s operating elements and user interface as well as its basic functions.

7.2  Front panel and keys

1 Display
2 Power indicator LED
3 Axis keys
4 Menu key
5 inch/mm key
6 Abs/Inc key
7 Dia/Rad key
8 C key
9 Arrow keys
10 Enter key
### Basic operation | Front panel and keys

<table>
<thead>
<tr>
<th>Key</th>
<th>Function</th>
</tr>
</thead>
<tbody>
<tr>
<td>Axis</td>
<td>Press an <strong>axis</strong> key to zero the axis</td>
</tr>
<tr>
<td>Menu</td>
<td>Press the <strong>Menu</strong> key to access the Configuration menu</td>
</tr>
<tr>
<td>inch/mm</td>
<td>Press the <strong>inch/mm</strong> key to toggle between inch and millimeter units of measure</td>
</tr>
<tr>
<td>Abs/Inc</td>
<td>Press the <strong>Abs/Inc</strong> key to toggle between Actual Value (Absolute) and Distance-To-Go (Incremental) modes</td>
</tr>
<tr>
<td>Dia/Rad</td>
<td>Press the <strong>Dia/Rad</strong> key to toggle between diameter and radius measurements</td>
</tr>
<tr>
<td>C</td>
<td>Press the <strong>C</strong> key to clear entries and error messages, or return back to the previous screen</td>
</tr>
<tr>
<td>Arrow</td>
<td>Press the <strong>arrow</strong> keys to navigate the <strong>Configuration Menu</strong></td>
</tr>
<tr>
<td>Enter</td>
<td>Press the <strong>enter</strong> key to confirm a selection, and return to the previous screen</td>
</tr>
</tbody>
</table>
# 7.3 User interface

## 7.3.1 Display layout

<table>
<thead>
<tr>
<th>Feature</th>
<th>Function</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Status bar</strong></td>
<td>Displays the current operating mode and unit of measure</td>
</tr>
<tr>
<td><strong>Display area</strong></td>
<td>Indicates the current position of each axis. Also shows forms, fields, instruction boxes, error messages and help topics</td>
</tr>
<tr>
<td><strong>Axis labels</strong></td>
<td>Indicates axis for corresponding axis key</td>
</tr>
<tr>
<td><strong>Reference mark indicator</strong></td>
<td>Indicates current reference mark status</td>
</tr>
<tr>
<td></td>
<td>🟢 Reference marks are enabled</td>
</tr>
<tr>
<td></td>
<td>🟦 Reference marks are disabled</td>
</tr>
</tbody>
</table>
### 7.3.2 Reference mark evaluation

The Reference Mark Evaluation feature automatically re-establishes the relationship between axis slide positions and display values that was last defined by setting the datum.

The reference mark indicator will flash for each axis with an encoder that has reference marks. The indicator will stop flashing after crossing over the reference marks.

#### Activating reference marks

<table>
<thead>
<tr>
<th>Axis</th>
<th>Reading</th>
</tr>
</thead>
<tbody>
<tr>
<td>X</td>
<td>0.000</td>
</tr>
<tr>
<td>Y</td>
<td>0.000</td>
</tr>
<tr>
<td>Z</td>
<td>0.000</td>
</tr>
</tbody>
</table>

1 Reference marks enabled

To activate reference marks:
- Cross over the reference marks for each axis to activate the reference
- After crossing over the reference marks, the indicator will stop flashing

#### Working without reference marks

The product can also be used without crossing over the reference marks.

<table>
<thead>
<tr>
<th>Axis</th>
<th>Reading</th>
</tr>
</thead>
<tbody>
<tr>
<td>X</td>
<td>0.000</td>
</tr>
<tr>
<td>Y</td>
<td>0.000</td>
</tr>
<tr>
<td>Z</td>
<td>0.000</td>
</tr>
</tbody>
</table>

1 Reference marks disabled

To work without reference marks:
- Press the C key to exit the reference mark evaluation routine, and continue
- After disabling reference marks the indicator will have a forward slash through it, signifying that the reference marks have been disabled

#### Re-enabling reference marks

Reference marks can be enabled any time after they have been disabled

To re-enable reference marks:
- Press and hold the Abs/Inc key for two seconds to re-enable reference marks

---

**Note:** If an encoder is setup without reference marks the reference indicator will not be displayed. A datum set from the axis will be lost once power is turned off.
7.3.3 Operating modes

The product has two operating modes:
- Distance-To-Go (Incremental)
- Actual Value (Absolute)

Distance-To-Go mode (Incremental)
The Distance-To-Go mode enables you to approach nominal positions by zeroing the axes and traversing to a position based on its distance from the zeroed position.

![Distance-To-Go mode (Inc)](image)

Actual Value mode (Absolute)
The Actual Value mode always displays the current actual position of the tool, relative to the active datum. In this mode, all moves are done by traveling until the display matches the nominal position that is required.

![Actual Value mode (Abs)](image)

Changing the operating mode
To change the operating mode:
- Press the Abs/Inc key to toggle between operating modes
7.3.4 Diameter and radius measurements

Drawings for lathe parts usually give diameter values. The product can display either the diameter or the radius. When the diameter is being displayed, the diameter symbol Ø is shown next to the position value.

Example:
- Radius display, position 1, X = 20
- Diameter display, position 1, X = Ø 40

Activating diameter and radius measurements for an axis
Further information: "Diameter Axes", Page 68

Switching between diameter and radius measurements
To toggle between diameter and radius measurements:
- Press the Dia/Rad key
7.4 Switch-on/Switch-off

7.4.1 Switch-on

Before using the product, you need to perform the commissioning steps. Depending on the purpose of use, you may have to configure additional setup parameters.

Further information: “Commissioning”, Page 55

To switch-on the product:
- Turn the power switch on
  - The power switch is on the rear side of the unit
- The unit powers up. This can take a moment.
- The first-time configuration screen will appear if this is the first time turning on the product or after resetting factory default settings
- Press the Menu key to go to the Installation Guide
  or
- Press any key to continue to the display

7.4.2 Switch-off

To switch-off the product:
- Turn the power switch off
  - The power switch is on the rear side of the unit
- The unit powers down

7.5 Error messages

If an error occurs while working with the product, a message will appear on the display, and provide an explanation of what caused the error.

Further information: "What to do if...", Page 85

To clear an error message:
- Press the C key
- The error message will be cleared and normal operation can continue
8.1 Overview

Make sure that you have read and understood the “Basic Operation” chapter before performing the activities described in this section.

Further information: "Basic operation", Page 47

The following steps are only to be performed by qualified personnel.

Further information: "Personnel qualification", Page 19

During the commissioning process the product is configured for use. Parameters that are changed during the commissioning process can be reset to the factory defaults.

Further information: "Factory Defaults", Page 65

Backing up the configuration
Configuration data can be backed up after commissioning. The configuration data can be reused for equivalent products.

Further information: "Config. Parameters", Page 59
8.2 Installation Guide

An Installation Guide is provided the first time you switch-on the product. This guide will step you through common commissioning parameters. Information about specific parameters included in the Installation Guide can be found in the Settings section of these instructions.

Further information: ‘Settings’, Page 75

The Installation Guide provides configuration options for the following parameters:

- Language
- Readout Settings
  - Number of Axes
- Encoder Setup
  - Encoder Type
  - Resolution
  - Count Direction
  - Error Monitor
- Display Configuration
  - Display Resolution
  - Label
  - Display Color Scheme
  - Color Mode

Opening the Installation Guide

To access the Installation Guide from the first-time startup screen:
- Press the Menu key
- The Installation Guide opens

Navigating the Installation Guide

- Press the right arrow key to open a parameter drop-down menu
- Press the up or down arrow key to highlight a parameter option
- Press the enter key to select an option
- Press the down arrow key to advance to the next parameter or
- Press the up arrow key to go back to a previous parameter
- Repeat these steps until all parameters have been set
8.3 Installation Setup

Installation Setup parameters are used to establish encoder, display, and communication parameters.

Further information: “Settings”, Page 75

Installation Setup parameters must be configured only by qualified personnel.

Further information: “Personnel qualification”, Page 19

To access the Installation Setup menu:

- Press the Menu key
- Use the up or down arrow key to highlight Installation Setup
- Press the right arrow key
- The Installation Setup menu is displayed
8.3.1 File Management

Config. Parameters
The configuration of the product can be backed up as a file to make it available after a reset to the factory default settings or for installation on multiple products. A file with the following properties needs to be stored on the product for this purpose:
- File format: DAT
- File name: Max.config.dat

Importing Config. Parameters
To import Config. Parameters:
- Press the Menu key
- Open in the sequence
  - Installation Setup
  - File Management
  - Config. Parameters
- Select Import
- Press the enter key to confirm the selection
- Press the enter key to initiate importing the configuration parameters
- A pop-up warning informs you that the current parameter settings will be overwritten
- Press the enter key to import the configuration parameters and return to the File Management menu
  or
- Press the C key to cancel

Exporting Config. Parameters
To export configuration parameters:
- Press the Menu key
- Open in the sequence
  - Installation Setup
  - File Management
  - Config. Parameters
- Select Export
- Press the enter key to confirm the selection
- Press the enter key to initiate exporting the configuration parameters
- A pop-up warning informs you that the current parameter settings will be exported to the attached USB memory device
- Press the enter key to export the configuration parameters and return to the File Management menu
  or
- Press the C key to cancel
Power-up Screen
You can define an OEM-specific Power-up Screen, e.g. the company name or logo, which will be displayed when the product is switched on. An image file with the following properties needs to be stored on the product for this purpose:
- File format: 24-Bit Bitmap
- Image size: Max. 800 x 480 px
- File name: powerup.bmp

To load a power-up screen:
- Connect a USB mass storage device containing the power-up screen file to the USB port of the product
- Press the Menu key
- Open in the sequence
  - Installation Setup
  - File Management
  - Power-up Screen
- Select Load
- Press the enter key to confirm the selection
- Press the enter key to initiate loading the power-up screen
- A pop-up warning informs you that the power-up screen will be loaded
- Press the enter key to load the power-up screen and return to the File Management menu
  or
- Press the C key to cancel

Product Software
When a Product Software update is available it can be uploaded to the product from a USB mass storage device.

To install a product software update:
- Connect a USB mass storage device containing the Product Software update file to the USB port of the product
- Press the Menu key
- Open in the sequence
  - Installation Setup
  - File Management
  - Product Software
- Select Install
- Press the enter key to confirm the selection
- Press the enter key to initiate installing the software update
- A pop-up warning informs you that the software update will be installed
- Press the enter key to install the software update
- The product will restart
  or
- Press the C key to cancel
8.3.2 Encoder Setup

Encoder Setup parameters are used to configure each encoder input.

The adjustment procedure is the same for each axis. The following section describes the configuration of one axis. Repeat the procedure for each axis.

To set up an encoder:

1. Press the Menu key
2. Open in the sequence
   - Installation Setup
   - Encoder Setup
3. Select the encoder to set up:
   - X1
   - X2
   - X3
4. The Encoder Setup parameters are displayed for the selected axis
5. Select the desired Resolution:
   - 0.5 μm
   - 1.0 μm
   - 2.0 μm
   - 5.0 μm
   - 10.0 μm
   - The Resolution can also be established by moving the axis in either direction.
6. Press the enter key to confirm the selection
7. Select the desired Reference Mark type:
   - None: no reference signal
   - Single: single reference mark
   - Position Trac: an encoder with the Position-Trac feature
   - P-Trac (ENC 250): an ENC 250 encoder with the Position-Trac feature
   - P-Trac (LB 382C): an LB 382C encoder with the Position-Trac feature
   - EverTrack: an encoder with the EverTrack feature
   - LMF: an LMF encoder with reference marks
8. Press the enter key to confirm the selection
9. Select the desired Count Direction:
   - Negative
   - Positive
   - When the encoder’s count direction matches the operators count direction, select Positive. When they do not match, select Negative.
   - The Count Direction can also be established by moving the axis in the positive direction.
Press the enter key to confirm the selection

Select On or Off in the Error Monitor parameter to enable or disable error monitoring

On allows the DRO to monitor counting errors. The types of counting errors are contamination errors (when the signal to the encoder falls below a set limit), and frequency error (when the signal frequency exceeds the set limit).

Press the enter key to confirm the selection

Press the enter key to save the Encoder Setup parameter changes and return to the Installation Setup menu

or

Press the C key to cancel

8.3.3 Display Configuration

Display Configuration parameters are used to configure the way axes information is shown on the display.

The adjustment procedure is the same for each axis display. The following section describes the configuration of one axis display. Repeat the procedure for each axis display.

To configure an axis display:

Press the Menu key

Open in the sequence

Installation Setup
  Display Configuration

Select the axis display to set up:

Display 1
Display 2
Display 3

The Display Configuration parameters are displayed for the selected axis display

Select the desired Display Resolution

Display Resolution options vary based on the encoders connected to the product.

Press the enter key to confirm the selection

Select a Label for the axis display or Off to turn off the selected axis display:

- Off
- X
- Y
- Z
- U
- V
- W
- A
- B
- C
- S

Press the enter key to confirm the selection
Select Off or On to enable or disable a Subscript zero being displayed after the axis label.

Press the enter key to confirm the selection.

Select the desired input for the axis display in the Input 1 parameter:
- X1
- X2
- X3

Press the enter key to confirm the selection.

Select + or - in the Couple Operation parameter to couple a second input with the first:
- +
- -
- Off

Press the enter key to confirm the selection.

Select the desired input to couple with Input 1 in the Input 2 parameter:
- Not Defined
- X1
- X2
- X3

Press the enter key to confirm the selection.

Press the enter key to save the Display Configuration parameter changes and return to the Installation Setup menu

or

Press the C key to cancel.
8.3.4 Readout Settings

Readout Settings parameters are used to set axes, and position recall requirements.

To configure the readout:
- Press the Menu key
- Open in the sequence
  - Installation Setup
  - Readout Settings
- Select the Number of Axes:
  - 1
  - 2
  - 3
- Press the enter key to confirm the selection
- Select On or Off to enable or disable Position Recall

Position Recall will store the last position of each axis when power was turned off, and then redisplay that position once power is turned back on.

Any movement that occurs while power is off will be lost. Whenever power has been off it is recommended to re-establish workpiece datums using the reference mark evaluation procedure.

Further information: “Reference mark evaluation”, Page 51

- Press the enter key to confirm the selection
- Press the enter key to save the Readout Settings parameter changes and return to the Installation Setup menu
  or
- Press the C key to cancel

8.3.5 Diagnostics

The Diagnostics feature provides a way to test the keypad and display.
- Press the Menu key
- Open in the sequence
  - Installation Setup
  - Diagnostics

Keypad Test
An image of the keypad provides an indication when a key is pressed and released.
To test the keypad:
- Press each key to test
  - A dot will appear on each key when it has been pressed indicating that it is operating properly.
- Press the C key two times to exit the Keypad Test

Display Test
The Display Test cycles through the five available pixel colors; red, green, blue, black, and white. Cycling through the pixel colors allows you to more easily see if there is a color problem with the display.
To test the display:
- Press the enter key to cycle through the pixel colors
8.3.6 Display Color Scheme

Display Color Scheme parameters are used to set the color scheme of the product. Select the color scheme that makes the display easiest to view in your workspace lighting conditions.

To select a color scheme:

- Press the Menu key
- Open in the sequence
  - Installation Setup
  - Display Color Scheme
- Select the Color Mode:
  - **Day**: the color scheme is set to Day mode and cannot be selected by the user
  - **Night**: the color scheme is set to Night mode and cannot be selected by the user
  - **User Selectable**: the color mode can be selected by the user from the Job Setup menu
- Press the enter key to confirm the selection
- Press the enter key to save the Display Color Scheme parameter changes and return to the Installation Setup menu
- or
- Press the C key to cancel

8.3.7 Factory Defaults

Parameter changes made in the Job Setup and Installation Setup menus can be reset to the factory default settings. All parameters will be reset.

Further information: “Settings”, Page 75

To reset parameters to factory default settings:

- Press the Menu key
- Open in the sequence
  - Installation Setup
  - Factory Defaults
  - Reset Settings
- Select Yes
- Press the enter key to accept the selection
- Press the enter key to initiate resetting the product to the factory default settings
- A warning window will appear to confirm the reset
- Press the enter key to reset parameters to the factory default settings
- The product will restart.
- or
- Press the C key to cancel the reset
8.3.8  **Error Compensation**

The distance a cutting tool travels, measured by an encoder, can in certain cases differ from the actual tool travel. This error can occur due to ball screw pitch error, or deflection and tilting of axes. Errors can be determined with a reference measurement system, such as gauge blocks.

The product provides the ability to compensate for linear errors, and each axis can be programmed separately with the appropriate compensation.

Linear Error Compensation (LEC) can be applied, if the results of a comparison with a reference standard shows a linear deviation over the whole measuring length. In this case the error can be compensated by the calculation of a single correction factor.

The correction factor may be calculated automatically using a standard gauge block.

---

**To configure LEC:**

1. Press the **Menu** key.
2. Open in the sequence **Installation Setup**
   - **Encoder Setup**
3. Select the input to configure:
   - X1
   - X2
   - X3
4. Select **Linear** to configure LEC for the input.
5. Press the **enter** key to confirm the selection.
6. Press the **Menu** key to begin teaching the LEC factor.
7. Touch one edge of the standard with the tool.
8. Press the **enter** key.
9. Touch the opposite edge of the standard with the tool.
10. Press the **enter** key to confirm the measured value.
11. Move the encoder until the **Actual** field shows the actual size of the standard plus the diameter of the probe.
12. The **Calculated Factor** field shows the calculated correction factor based on the measured and actual values.
13. Press the **enter** key to confirm the value.
14. Press the **enter** key to save the **Error Compensation** parameter changes and return to the **Installation Setup** menu.
   
   or
   
15. Press the **C** key to cancel.

---

The adjustment procedure is the same for each axis. The following section describes the configuration of one axis. Repeat the procedure for each axis.
8.4 Job Setup

Job Setup parameters are used to accommodate specific machining requirements for each job. These parameters can be set by a system installer, supervisor, or operator.

Further information: "Settings", Page 75

<table>
<thead>
<tr>
<th>mm</th>
<th>Job Setup</th>
<th>Units</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Diameter Axes</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Graphic Prog</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Display Settings</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Language</td>
<td></td>
</tr>
</tbody>
</table>

To access the Job Setup menu:
- Press the Menu key
- Use the up or down arrow key to highlight Job Setup
- Press the right arrow key
- The Job Setup menu is displayed

8.4.1 Units

Units parameters are used to specify the preferred display units and format. You can also select the unit of measure by pressing the inch/mm key in either operating mode.

To set the units of measure:
- Press the Menu key
- Open in the sequence
  - Job Setup
  - Units
- Select the Linear units of measure:
  - inch
  - mm
- Press the enter key to confirm the selection
- Select the Angular units of measure:
  - Decimal Degrees
  - Radians
  - DMS: Degrees, Minutes, Seconds
- Press the enter key to confirm the selection
- Press the enter key to save the Units parameter changes and return to the Job Setup menu
  or
  - Press the C key to cancel
8.4.2 Diameter Axes

Diameter Axes parameters are used to set which axes can display radius or diameter values.

To setup the display of radius or diameter values:

- Press the Menu key
- Open in the sequence
  - Job Setup
  - Diameter Axes
- Select the desired axis to setup
- Select On or Off to enable or disable the display of radius or diameter values for the selected axis
- Press the enter key to confirm the selection
- Press the enter key to save the Diameter Axes parameter changes and return to the Job Setup menu
  or
- Press the C key to cancel

8.4.3 Display Settings

Display Settings parameters are used to adjust the appearance of the display.

To configure Display Settings:

- Press the Menu key
- Open in the sequence
  - Job Setup
  - Display Settings
- Use the left or right arrow key to adjust the Brightness level of the display
  The Brightness can also be adjusted using the up and down arrow keys when the product is in either operating mode.
- Select the time in minutes that the display is idle before the Display Saver (min) is activated and the display is switched off:
  - Off
  - 10
  - 30
- Press the enter key to confirm the selection
- Select the desired Color Mode:
  - Night
  - Day
- Press the enter key to confirm the selection
- Select how the axis that is in motion is displayed:
  - Off: All axes are displayed normal
  - Dynamic Zoom: The axis in motion is displayed larger than axes not in motion
  - Highlight: The axis in motion is displayed in black, axes not in motion are displayed in gray
- Press the enter key to confirm the selection
- Press the enter key to save the Display Settings parameter changes and return to the Job Setup menu
  or
- Press the C key to cancel
8.4.4 Language

The Language parameter is used to select the language for the user interface. The default Language is English.

To change the Language:

- Press the Menu key
- Open in the sequence
  - Job Setup
  - Language
- Select the desired Language
- Press the enter key to confirm the selection
- Press the enter key to save the Language parameter change and return to the Job Setup menu

or

- Press the C key to cancel
9.1 Overview

This chapter describes the procedure for simple machining operations.

Make sure that you have read and understood the "Basic Operation" chapter before performing the activities described in this section.

Further information: "Basic operation", Page 47

Short description
By traversing the reference marks on the encoders, you make it possible to define an absolute position. When you have completed the reference mark search, you then set the datums that will be used as the basis for all subsequent measurements.

9.2 Probing for datum setting

Probing with a tool
A tool is used to probe and set datum points.

Probing an edge
Datum points can be set by probing the edge of a workpiece with a tool, zeroing the respective axis, and repeating this process for the remaining axes.

Tool compensation
Tool compensation can be accounted for by moving the distance of the tool radius towards the workpiece and pressing the zero key, after zeroing on an edge.
Example: Probe workpiece edge and set edge as datum
An end mill is shown in this example, along with the product display.

Preparation:
- Insert the tool that will be used to set the datum
  - Datum axis: X =0
  - Tool diameter D = 0.25”
- If required, press the Abs/Inc key to select
- Touch the workpiece edge
- Press the X axis Zero key to zero the current absolute value while the tool is in contact with the workpiece edge

The location for the touched edge will not take into account the diameter of the tool in use.
- Raise the tool enough to clear the workpiece
- move the tool the distance of the tool radius towards the workpiece
- Press the X axis Zero key to zero the current absolute value
10.1 Overview
This chapter describes the settings options and the associated parameters for the product.
The basic settings options and parameters for commissioning are outlined in the respective chapter:
Further information: “Commissioning”, Page 55

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Job Setup</td>
<td>Set the individual job properties</td>
</tr>
<tr>
<td>Installation Setup</td>
<td>Set the installation setup properties</td>
</tr>
</tbody>
</table>

Activation
▶ Press the Menu key

10.2 Factory Defaults
If individual settings that were changed during commissioning need to be reset to the default setting, you can look up the default for each adjustment parameter in this chapter.
If all settings need to be reset, you can restore the product to the default settings.
Further information: “Factory Defaults”, Page 65

10.3 Job Setup

10.3.1 Units
Units settings are used to set the working units of measure for linear and angular dimensions.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Explanation</th>
</tr>
</thead>
<tbody>
<tr>
<td>Linear</td>
<td>The unit of measure used for linear measurements</td>
</tr>
<tr>
<td></td>
<td>◦ inch or mm</td>
</tr>
<tr>
<td></td>
<td>◦ Default setting: mm</td>
</tr>
<tr>
<td>Angular</td>
<td>The unit of measure used for angular measurements</td>
</tr>
<tr>
<td></td>
<td>◦ Decimal Degrees, Radians, DMS</td>
</tr>
<tr>
<td></td>
<td>◦ Default setting: DMS</td>
</tr>
</tbody>
</table>
10.3.2 Diameter Axes
Diameter Axes settings are used to set which display positions can be displayed as diameter values.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Explanation</th>
</tr>
</thead>
<tbody>
<tr>
<td>X, Y, Z</td>
<td>Off or On</td>
</tr>
<tr>
<td></td>
<td>Default setting: Off</td>
</tr>
</tbody>
</table>

10.3.3 Display Settings
Display Settings are used to adjust the appearance of the display.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Explanation</th>
</tr>
</thead>
<tbody>
<tr>
<td>Brightness</td>
<td>Set the brightness of the display</td>
</tr>
<tr>
<td></td>
<td>Setting range: 10 % ... 100 %</td>
</tr>
<tr>
<td></td>
<td>Default setting: 90 %</td>
</tr>
<tr>
<td>Display Saver (min)</td>
<td>Set how long the display can remain inactive, in minutes, before the display saver turns on</td>
</tr>
<tr>
<td></td>
<td>Settings: Off, 10, 30</td>
</tr>
<tr>
<td></td>
<td>Default setting: 30</td>
</tr>
<tr>
<td>Color Mode</td>
<td>Set the color mode for varying ambient lighting conditions</td>
</tr>
<tr>
<td></td>
<td>Settings: Night or Day</td>
</tr>
<tr>
<td></td>
<td>Default setting: Day</td>
</tr>
<tr>
<td>Axes Displays</td>
<td>Set how the axis that is in motion is displayed.</td>
</tr>
<tr>
<td></td>
<td>Off</td>
</tr>
<tr>
<td></td>
<td>Dynamic Zoom: The axis currently in motion is magnified on the display</td>
</tr>
<tr>
<td></td>
<td>Highlight: The axis currently in motion is highlighted on the display. All other axes are grayed out.</td>
</tr>
<tr>
<td></td>
<td>Default setting: Off</td>
</tr>
</tbody>
</table>

10.3.4 Language
The Language setting is used to select the language used for the user interface.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Explanation</th>
</tr>
</thead>
<tbody>
<tr>
<td>Language</td>
<td>Settings: multiple languages</td>
</tr>
<tr>
<td></td>
<td>Default setting: English</td>
</tr>
</tbody>
</table>
10.4 Installation Setup

10.4.1 Encoder Setup

Encoder settings are used to configure parameters for each encoder.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Explanation</th>
</tr>
</thead>
<tbody>
<tr>
<td>Encoder Type</td>
<td>Settings: Linear, Default setting: Linear</td>
</tr>
<tr>
<td>Resolution</td>
<td>Settings: 0.5, 1.0, 2.0, 5.0, 10.0, Default setting: 5.0</td>
</tr>
<tr>
<td>Reference Mark</td>
<td>Settings: None, Single, Position Trac, P-Trac (ENC 250), P-Trac (LB 382C), EverTrack, LMF, Default setting: Position Trac</td>
</tr>
<tr>
<td>Count Direction</td>
<td>Settings: Negative or Positive, Default setting: Positive</td>
</tr>
<tr>
<td>Error Monitor</td>
<td>Off or On, Default setting: On</td>
</tr>
</tbody>
</table>

10.4.2 Display Configuration

Display settings are used to configure the resolution, labels, and inputs shown on the display.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Explanation</th>
</tr>
</thead>
<tbody>
<tr>
<td>Display Resolution</td>
<td>Settings vary based on encoder connected to the product</td>
</tr>
<tr>
<td>Label</td>
<td>Settings: Off, X, Y, Z, U, V, W, A, B, C, S, Default Setting:</td>
</tr>
<tr>
<td></td>
<td>Display 1: X, Display 2: Y, Display 3: Z</td>
</tr>
<tr>
<td>Subscript</td>
<td>Settings: Off or On, Default Setting: Off</td>
</tr>
<tr>
<td>Input 1</td>
<td>Settings: X1, X2, X3, Default Setting:</td>
</tr>
<tr>
<td></td>
<td>Display 1: X, Display 2: X2, Display 3: X3</td>
</tr>
<tr>
<td>Couple Operation</td>
<td>Settings: +, -, Off, Default Setting: Off</td>
</tr>
<tr>
<td>Input 2</td>
<td>Settings: Not Defined, X1, X2, X3, Default Setting: Not Defined</td>
</tr>
</tbody>
</table>
10.4.3 Readout Settings

Readout Settings are used to configure the Application, Number of Axes, and Position Recall.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Explanation</th>
</tr>
</thead>
<tbody>
<tr>
<td>Number of Axes</td>
<td>Settings: 1, 2, 3</td>
</tr>
<tr>
<td></td>
<td>Default Setting: 3</td>
</tr>
<tr>
<td>Position Recall</td>
<td>Settings: Off or On</td>
</tr>
<tr>
<td></td>
<td>Default Setting: Off</td>
</tr>
</tbody>
</table>

10.4.4 Diagnostics

Diagnostics are used to test the keypad and the display.

Further information: "Diagnostics", Page 64

10.4.5 Display Color Scheme

The Display Color Scheme settings are used to select the Color Mode of the display and to set whether users can select the Color Mode.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Explanation</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color Mode</td>
<td>Settings: Day, Night, User Selectable</td>
</tr>
<tr>
<td></td>
<td>Default Setting: User Selectable</td>
</tr>
</tbody>
</table>

10.4.6 Factory Defaults

The Factory Defaults option is used to reset Job Setup and Installation Setup parameters to the default settings.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Explanation</th>
</tr>
</thead>
<tbody>
<tr>
<td>Reset Settings</td>
<td>Settings: No or Yes</td>
</tr>
<tr>
<td></td>
<td>Default Setting: No</td>
</tr>
</tbody>
</table>

10.4.7 Error Compensation

Error Compensation provides a way to configure Linear Error Compensation for each encoder.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Explanation</th>
</tr>
</thead>
<tbody>
<tr>
<td>X1, X2, X3</td>
<td>Settings: Off, Linear</td>
</tr>
<tr>
<td></td>
<td>Default setting: Off</td>
</tr>
</tbody>
</table>
Service and maintenance
11.1 Overview

This chapter describes the general maintenance work on the product:

This chapter contains a description of maintenance work for the product only.

Further Information: Manufacturer’s documentation for the respective peripheral devices

11.2 Cleaning

**NOTICE**

Cleaning with sharp-edged objects or aggressive cleaning agents

Improper cleaning will cause damage to the product.

- Never use abrasive or aggressive cleaners, and never use strong detergents or solvents
- Do not use sharp-edged objects to remove persistent contamination

- Use only a cloth dampened with water and a mild detergent for cleaning the exterior surfaces
- Use a lint-free cloth and a commercially available glass cleaner to clean the screen
11.3 Maintenance schedule

The product is largely maintenance-free.

---

**NOTICE**

Operating defective products

Operating defective products may result in serious consequential damage.

- Do not operate or repair the product if damaged
- Replace defective products immediately or contact an authorized service agency

---

The following steps are only to be performed by electrical specialists.

**Further information:** “Personnel qualification”, Page 19

### Personnel requirement

<table>
<thead>
<tr>
<th>Maintenance step</th>
<th>Interval</th>
<th>Corrective action</th>
</tr>
</thead>
<tbody>
<tr>
<td>▶ Check all labels and symbols provided on the product for readability</td>
<td>Annually</td>
<td>▶ Contact an authorized service agency</td>
</tr>
<tr>
<td>▶ Inspect electrical connections for damage and check their function</td>
<td>Annually</td>
<td>▶ Replace defective cables. Contact an authorized service agency if required.</td>
</tr>
<tr>
<td>▶ Check power cables for faulty insulation and weak points</td>
<td>Annually</td>
<td>▶ Replace power cables according to the specification</td>
</tr>
</tbody>
</table>

---

11.4 Resuming operation

When operation is resumed, e.g. when the product is reinstalled after repair or when it is remounted, the same measures and personnel requirements apply as for mounting and installing the product.

**Further information:** “Mounting”, Page 27

**Further information:** “Installation”, Page 33

When connecting the peripheral devices (e.g. encoders), the operating company must ensure safe resumption of operation and assign authorized and appropriately qualified personnel to the task.

**Further information:** “Obligations of the operating company”, Page 20

---

11.5 Resetting to the factory defaults

You can reset the settings of the product to the factory defaults, if required.

“Factory Defaults”
What to do if...
12.1 Overview

This chapter describes the causes of faults or malfunctions of the product and the appropriate corrective actions.

Make sure that you have read and understood the “Basic Operation” chapter before performing the activities described in this section.

Further information: “Basic operation”, Page 47

12.2 Malfunctions

If faults or malfunctions that are not listed in the “Troubleshooting” table below occur during operation, refer to the machine tool builder’s documentation or contact an authorized service agency.

12.3 Troubleshooting

The following troubleshooting steps must be performed only by the personnel indicated in the table.

Further information: “Personnel qualification”, Page 19

<table>
<thead>
<tr>
<th>Fault</th>
<th>Cause of fault</th>
<th>Correction of fault</th>
<th>Personnel</th>
</tr>
</thead>
<tbody>
<tr>
<td>Status LED remains dark after switch-on.</td>
<td>There is no supply voltage</td>
<td>▶ Check the power cable</td>
<td>Electrical specialist</td>
</tr>
<tr>
<td></td>
<td>The product does not function properly</td>
<td>▶ Contact an authorized service agency</td>
<td>Qualified personnel</td>
</tr>
<tr>
<td>The position display does not count the axis position even though the encoder is moving.</td>
<td>Incorrect connection of the encoder</td>
<td>▶ Correct the connection</td>
<td>Qualified personnel</td>
</tr>
<tr>
<td></td>
<td></td>
<td>▶ Contact the encoder manufacturer’s service agency</td>
<td></td>
</tr>
<tr>
<td>The position display miscounts the axis position.</td>
<td>Incorrect settings of the encoder</td>
<td>▶ Check the encoder settings</td>
<td>Qualified personnel</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Page 78</td>
<td></td>
</tr>
<tr>
<td>The connected USB mass storage device is not detected.</td>
<td>Defective connection</td>
<td>▶ Check the correct position of the USB mass storage device in the port</td>
<td>Qualified personnel</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>The type or formatting of the USB mass storage device is not supported</td>
<td>▶ Use another USB mass storage device</td>
<td>Qualified personnel</td>
</tr>
</tbody>
</table>
13.1 Overview

This chapter provides information about the removal and disposal of the product. This information includes requirements to be complied with in respect of environmental-protection laws.

13.2 Removal

Removal of the product is to be performed only by qualified personnel.

Further information: “Personnel qualification”, Page 19

Depending on the connected peripherals, the removal may need to be performed by an electrical specialist.

In addition, the same safety precautions that apply to the mounting and installation of the respective components must be taken.

Removing the product

To remove the product, follow the installation and mounting steps in the reverse order.

Further information: “Installation”, Page 33
Further information: “Mounting”, Page 27

13.3 Disposal

NOTICE

Incorrect disposal of the product!

Incorrect disposal of the product can cause environmental damage.

- Do not dispose of electrical waste and electronic components in domestic waste
- Forward the product to recycling in accordance with the applicable local disposal regulations

- If you have any questions about the disposal of the product, please contact an authorized service agency
### 14.1 Product specifications

<table>
<thead>
<tr>
<th><strong>Product</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>Housing</td>
</tr>
<tr>
<td>Housing dimensions</td>
</tr>
<tr>
<td>Fastener system, mating dimensions</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>Display</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>Visual display unit</td>
</tr>
<tr>
<td>User interface</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>Electrical data</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>Power supply</td>
</tr>
<tr>
<td>Overvoltage category</td>
</tr>
<tr>
<td>Number of encoder inputs</td>
</tr>
<tr>
<td>Encoder interfaces</td>
</tr>
<tr>
<td>Data interface</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>Ambient conditions</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>Operating temperature</td>
</tr>
<tr>
<td>Storage temperature</td>
</tr>
<tr>
<td>Relative air humidity</td>
</tr>
<tr>
<td>Altitude</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>General information</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>Pollution degree</td>
</tr>
<tr>
<td>Protection EN 60529</td>
</tr>
<tr>
<td>Mass</td>
</tr>
</tbody>
</table>
14.2 Product dimensions and mating dimensions

All dimensions in the drawings are in millimeters.
Specifications | Product dimensions and mating dimensions

Product dimensions with Single-Pos stand

ISO 14510-M4x8
Md = 2.6 Nm

123 ±1
161.2 ±1

Product dimensions with Multi-Pos holder

55.3 ±2
66.4 ±2
184.7 ±2

22.2

4.2

70