MonPort rotary axis



Contents

Product preview	1
Instructions for use of type C rotary axis	2
Software operation ·····	4

Product preview



Instructions for use of type C rotary axis



Loosen the screws to tighten the timing belt



Loosen the screw to adjust the distance between the rollers



Software operation

Rotary Axis connection control board:

Remove all Y-axis motor connecting wires on the control board, and insert the rotary axis motor wire plug into the Y-axis socket of the control board

1.Open LaserEngraver



2.Open the advanced settings, and set the reference step number of the Y axis of the motion parameter to 40, click OK and save.

LaserEngraver 3.	0 机器状态::	空闲	工作坐标	: X:0.00 Y:0.00						۵	- 8 🗆 ×
断开设备 1152	4 <u>~</u> 打开o代码	打开图像	打开口口	编辑文字	图晖	高级设			\wedge	设为起	点 激光
	 jää)参数	_		起点位置	-	٦	< <u>'</u>	\sim	ie	点 弱光
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Rotary axis connection control board:

Remove all Y-axis motor connecting wires on the control board, and insert the rotary axis motor wire plug into the Y-axis socket of the control board

1.Open LaserGRBL

📥 LaserGRBL v4.2.1		- 🗆 ×
Grbl 文件 颜色 语言 Tools ?		
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@ Grbl 1.1f ['\$' for help] ^]	
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	Right cilck izer to add enzions burtons	()
行: 0 提/平 估计时间: now	S [1.00x] G	1 [1.00x]G0 [1.00x] 状态: 空闲 _



2.Open the Grbl-Grbl configuration, set the parameter \$101=40, click Write, close

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430 Maximum spindle speed 100 RPM Ma 471 Minimum spindle speed 0 RPM Ma 4731 Minimum spindle speed 1 boolean Z 4701 Xaits travel resolution 0.00 step/ram Z 4710 X-axits travel resolution 40.000 step/ram Z 4710 Z-axits travel resolution 250.000 step/ram Z 4711 Y-axits maximum rate 5000.000 sm/min. Z 4711 Y-axits maximum rate 500.000 sm/min. Z 4712 Z-axits maximum rate 500.000 sm/min. Z 4712 Z-axits acceleration 500.000 sm/sec? X 4712 Z-axits acceleration 500.000 sm/sec? X	etract distance after triggering switch	millimeters	1.000	Homing switch pull-off distance	\$27	' for help	1.1f ['\$	🔍 Grbl
131 Minimum spindle speed 0 RPM M5 132 Laser-mode enable 1 boolean 27 100 X-wit screwl resolution 80.000 step/rmn 27 101 Y-axis travel resolution 40.000 step/rmn 27 101 X-axis travel resolution 250.000 step/rmn 27 101 X-axis maximum rate 5000.000 mm/min 27 111 Y-axis maximum rate 500.000 mm/min 27 112 X-axis accleration 500.000 mm/sec ² 27 112 X-axis accleration 500.000 mm/sec ² 27	aximum spindle speed. Sets PWM to 100% d	RPM	1000	Maximum spindle speed	\$30			
23 Levermode enable 1 bollean Er 3100 X-asits travel resolution 80.000 step/rmm X 1010 Y-asits travel resolution 40.000 step/rmm X 1012 2-waits stravel resolution 250.000 step/rmm Z 1111 Y-asits stravel resolution 250.000 step/rmm X 1111 Y-asits strainum stee 5000.000 smm/ain X 1111 Y-asits schimm stee 5000.000 smm/ain Z 1112 2-waits schimm stee 500.000 smm/ain Z 1112 1-waits schimm stee 500.000 smm/ain Z 1112 1-waits schimat stee 500.000 smm/sec ² Z 1112 1-waits schiezionin 500.000 smm/sec ² Z	inimum spindle speed. Sets PWM to 0.4% c	RPM	0	Minimum spindle speed	\$31			
100 X-axis travel resolution \$0.00 step/am X \$101 X-axis travel resolution 40.000 step/am X \$102 Z-axis travel resolution 25.000 step/am X \$110 X-axis travel resolution 25.000 step/am X \$111 X-axis travel resolution 5000.000 step/am X \$2112 2-axis travel resolution 5000.000 stm/amin X \$2112 2-axis travel resolution 5000.000 stm/amin Z \$2123 2-axis travel resolution 500.000 stm/sec Z \$1213 X-axis acceleration 500.000 stm/sec Z \$1214 Y-axis acceleration 500.000 stm/sec Z	nables laser mode. Consecutive G1/2/3 co	boolean	1	Laser-mode enable	\$32			
S101 Y-axis travel resolution 40.000 slsp/mm Y- 210 2-mis travel resolution 250.000 step/mm 2 101 X-axis starting rate 500.000 step/mm 2 111 Y-axis starting rate 500.000 sm/min X 112 Y-axis starting rate 500.000 sm/min Z 112 X-axis acceleration 500.000 sm/sec ² X 1210 X-axis acceleration 500.000 sm/sec ² X	-axis travel resolution in steps per mil	step/mm	80.000	X-axis travel resolution	\$100			
102 310 X-axis travel resolution 250.000 step/rmm Z 310 X-axis maximum rate 5000.000 mm/min X 5111 Y-axis maximum rate 5000.000 mm/min X 2112 2-axis maximum rate 5000.000 mm/min Z 3120 X-axis maximum rate 5000.000 mm/sec ² X 5121 X-axis maximum rate 5000.000 mm/sec ² X	-axis travel resolution in steps per mil	step/mm	40.000	Y-axis travel resolution	\$101			
\$110 X-axis maximum rate \$000.000 mm/min X- \$111 Y-axis maximum rate \$000.000 mm/min Y \$112 2-mis maximum rate \$000.000 mm/min Z \$120 X-axis maximum rate \$000.000 mm/min Z \$121 X-axis acceleration \$000.000 mm/sec^2 X \$121 Y-axis acceleration \$00.000 mm/sec^2 X	-axis travel resolution in steps per mil	step/mm	250.000	2-axis travel resolution	\$102			
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2112 2-mails maximum sate 500.000 mm/min 2- 310 X-mails acceleration 500.000 mm/sec*2 X- 9111 Y-mails acceleration 500.000 mm/sec*2 X-	-axis maximum rate. Used as GO rapid rate.	mm/min	5000.000	Y-axis maximum rate	\$111			
\$120 X-axis acceleration \$00.000 mm/sec^2 X- \$121 Y-axis acceleration \$00.000 mm/sec^2 Y-	-axis maximum rate. Used as GO rapid rate.	mm/min	\$00.000	Z-axis maximum rate	\$112			
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	-axis acceleration. Used for motion plan	mm/sec^2	600.000	Y-axis acceleration	\$121			
\$122 Z-axis acceleration 10.000 mm/sec^2 Z-	-axis acceleration. Used for motion plan	mm/sec^2	10.000	Z-axis acceleration	\$122			
The second state of the second s	aximum X-axis travel distance from homin	millimeters	500 000	X-axis maximum travel	\$130	A (
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