

%
O0100
G17G40G49G80
G91G28Z0
M06T14
(3T0.2R-T14)
G90G54G00X0Y0
G43H14Z20.S4000M03
G00X-54.611Y-97.002Z20.M07
Z2.
Z1.
G01Z-0.8F600
G03X-54.711Y-97.175I0.1J-0.173
X-54.684Y-97.275I0.2
X-54.208Y-97.55I0.476J0.275F2000
X-53.658Y-97.J0.55
.....
.....
X-54.411Y96.652J0.2
G00Z20.
G90G54X0.0Y0.0
M09
M05
G91G28Z0
M30
%

MDX - 40 基礎操作

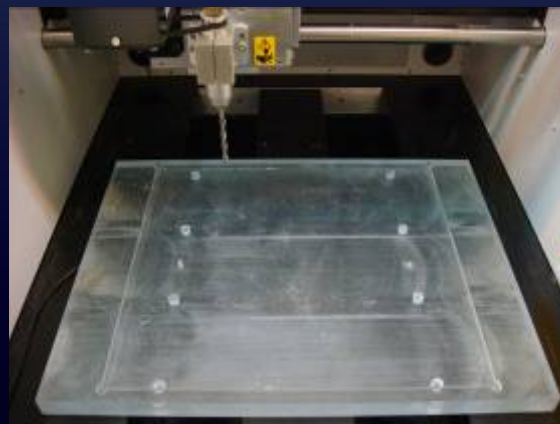
馬仁隆

MDX - 40 基礎操作

1. 開啓加工機電源



2. 按下VIEW鍵，將刀具至於加工區域



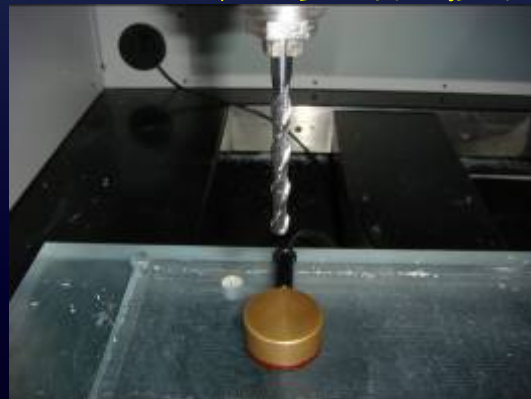
```
%  
O0100  
G17G40G49G80  
G91G28Z0  
M06T14  
( 3T0.2R-T14 )  
G90G54G00X0Y0  
G43H14Z20.S4000M03  
G00X-54.611Y-97.002Z20.M  
Z2.  
Z1.  
G01Z-0.8F600  
G03X-54.711Y-97.175I0.1J  
X-54.684Y-97.275I0.2  
X-54.208Y-97.55I0.476J0.  
X-53.658Y-97.J0.55  
.....  
.....  
X-54.411Y96.652J0.2  
G00Z20.  
G90G54X0.0Y0.0  
M09  
M05  
G91G28Z0  
M30  
%
```

MDX - 40 基礎操作

3. 開啓加工機控制視窗



4. 將刀具長度補償器置於刀具下方



MDX - 40 基礎操作

```
%  
O0100  
G17G40G49G80  
G91G28Z0  
M06T14  
( 3T0.2R-T14 )  
G90G54G00X0Y0  
G43H14Z20.S4000M03  
G00X-54.611Y-97.002Z20.M  
Z2.  
Z1.  
G01Z-0.8F600  
G03X-54.711Y-97.175I0.1J  
X-54.684Y-97.275I0.2  
X-54.208Y-97.55I0.476J0.  
X-53.658Y-97.J0.55  
.....  
.....  
X-54.411Y96.652J0.2  
G00Z20.  
G90G54X0.0Y0.0  
M09  
M05  
G91G28Z0  
M30  
%
```

5.將刀具調降至接近刀具長度補償器



6.按下Start Detection鍵自動偵測刀具
長度



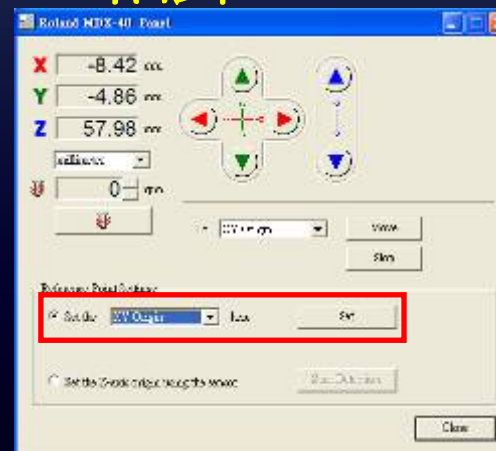
MDX - 40 基礎操作

```
%  
O0100  
G17G40G49G80  
G91G28Z0  
M06T14  
( 3T0.2R-T14 )  
G90G54G00X0Y0  
G43H14Z20.S4000M03  
G00X-54.611Y-97.002Z20.M  
Z2.  
Z1.  
G01Z-0.8F600  
G03X-54.711Y-97.175I0.1J  
X-54.684Y-97.275I0.2  
X-54.208Y-97.55I0.476J0.  
X-53.658Y-97.J0.55  
.....  
.....  
X-54.411Y96.652J0.2  
G00Z20.  
G90G54X0.0Y0.0  
M09  
M05  
G91G28Z0  
M30  
%
```

7.將刀具移至工件中心



8.XY軸歸0



MDX - 40 基礎操作

```
%  
O0100  
G17G40G49G80  
G91G28Z0  
M06T14  
( 3T0.2R-T14 )  
G90G54G00X0Y0  
G43H14Z20.S4000M03  
G00X-54.611Y-97.002Z20.M  
Z2.  
Z1.  
G01Z-0.8F600  
G03X-54.711Y-97.175I0.1J  
X-54.684Y-97.275I0.2  
X-54.208Y-97.55I0.476J0.  
X-53.658Y-97.J0.55  
.....  
.....  
X-54.411Y96.652J0.2  
G00Z20.  
G90G54X0.0Y0.0  
M09  
M05  
G91G28Z0  
M30  
%
```

7.將刀具移至工件表面



10.Z軸歸0

