



How to Use the Sherline/MASSO Controller to Control Different Machines Instructions

About the Sherline/MASSO Software for Controlling Different Sherline Machines

1. You will need to have separate flash drives for each machine. On these flash drives will be the software for that specific machine, all of the setting information, and all of your programs.
2. You should save your HTG software files and your Data1 file on a separate computer. Once the controller uploads the HTG software file, it changes it to an HT1 file. From this point onward, the controller is set up to run that machine only and it will not read the HT1 file again.

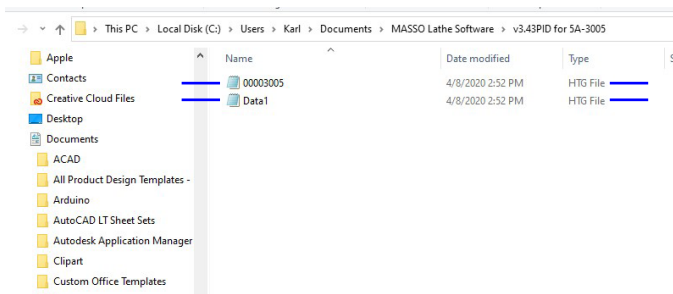


FIGURE 1—The blue markers show the HTG files.

3. In order to use your controller for a different machine (example, switching the controller from your mill to your chucker lathe), you need to upload the software for that machine to the controller (along with all of the settings). To do this, you must follow the instructions below.

Sherline/MASSO Software Upload Instructions when Switching Your Controller to Different Machines

1. Delete the file with the suffix “.HT1” from the flash drive “Main Directory”; from this point on, we will describe this file as “00002096.HT1” wherein the number 00002096 is an arbitrary file number.

NOTE: Whenever MASSO reads the 00002096 file for an upgrade, it changes the file to 00002096.HT1 so it can't be read again. If your flash drive has not been used to do the upgrade, then the file will still be 00002096. You must remove any file that has .HT1 in it, in order to load the new machine software.

Name	Date modified	Type	Size
masso 4 axis mill 3.31	6/27/2018 10:02 AM	File folder	
masso mill 4 axis upgrade	3/30/2018 8:12 AM	File folder	
MASSO Mill 4-Axis Update v3.34	7/16/2018 9:01 AM	File folder	
programs	6/27/2018 10:01 AM	File folder	
upgrade 3 28 18	3/28/2018 11:26 AM	File folder	
upgrade 3 39 18	3/30/2018 10:57 AM	File folder	
00002096.HT1	7/16/2018 11:43 AM	HT1 File	481 KB
Data1	7/16/2018 11:43 AM	HTG File	52 KB
masso documentation	3/23/2018 12:30 PM	Adobe Acrobat D...	24,411 KB
MASSO_Settings		HTG File	1 KB

FIGURE 1—The blue markers indicate the files to delete.

2. Open the most recent machine upgrade software folder for the new machine; in this case, it is “3.34” (see Figure 2).

Name	Date modified	Type	Size
masso 4 axis mill 3.31	6/27/2018 10:02 AM	File folder	
masso mill 4 axis upgrade	3/30/2018 8:12 AM	File folder	
MASSO Mill 4-Axis Update v3.34	7/16/2018 9:01 AM	File folder	
programs	6/27/2018 10:01 AM	File folder	
upgrade 3 28 18	3/28/2018 11:26 AM	File folder	
upgrade 3 39 18	3/30/2018 10:57 AM	File folder	
00002096.HT1	7/16/2018 11:43 AM	HT1 File	481 KB
Data1	7/16/2018 11:43 AM	HTG File	52 KB
masso documentation	3/23/2018 12:30 PM	Adobe Acrobat D...	24,411 KB
MASSO_Settings		HTG File	1 KB

FIGURE 2

NOTE: These files are also in a folder on the flash drive which is named with the serial number for your Controller. In this instance below, the folder is 5A-3019 (see Figure 3).

Name	Date modified	Type	Size
5A-3019	9/27/2019 10:26 AM	File folder	
massos sample program	9/27/2019 10:55 AM	File folder	
MASSO_Settings		HTG File	1 KB
MASSO_Tools		HTG File	2 KB

FIGURE 3

Open the folder corresponding to your serial number. In this folder you will find the software and a data file (see Figure 4).

Name	Date modified	Type	Size
00003019	7/24/2019 7:33 AM	HTG File	481 KB
Data1	7/24/2019 7:33 AM	HTG File	52 KB

FIGURE 4

3. Load both the 00002096 and Data1 files onto the flash drive Main Directory. Do not load them into a folder on the flash drive or the control will not read them (see Figure 5).

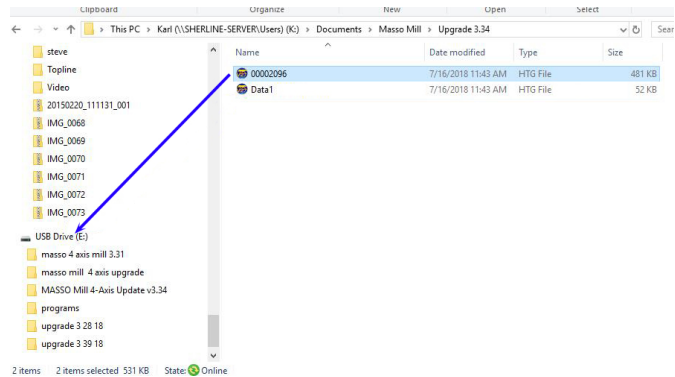


FIGURE 5—The blue arrow indicates the files to move onto the flash drive.

4. Put the flash drive in the MASSO controller.
5. Turn on the power.
6. Wait for the load bar to reach 100%.

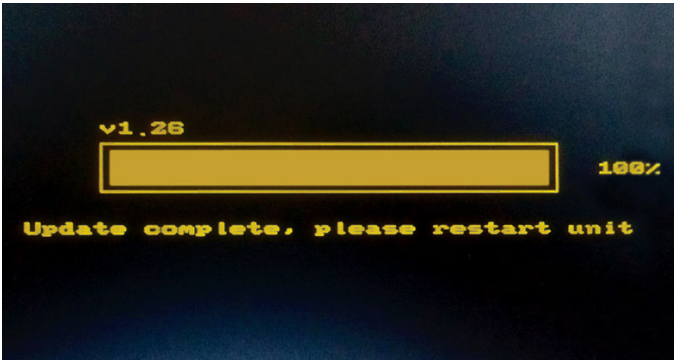


FIGURE 6

7. Turn the power off/on.
8. Type in the password (SP).
9. Press the E-stop on/off.
10. F1-Set up:
 - A. Password (- - - -)

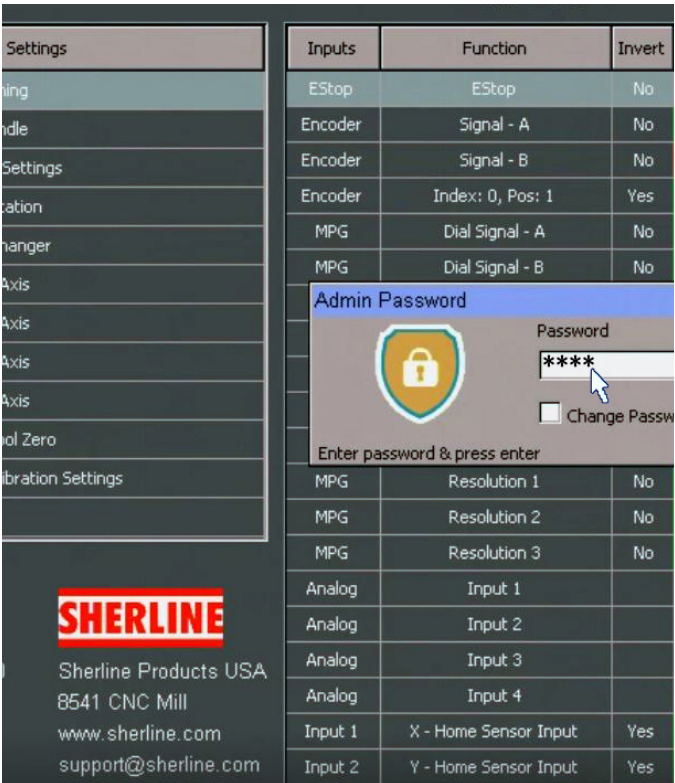


FIGURE 7—Password dialog box.

- B. Save and load calibration settings.



FIGURE 8—Click “Save & Load Calibration Settings.”

- C. Load from file. This loads all of the machine settings into the MASSO board (see Figure 9).

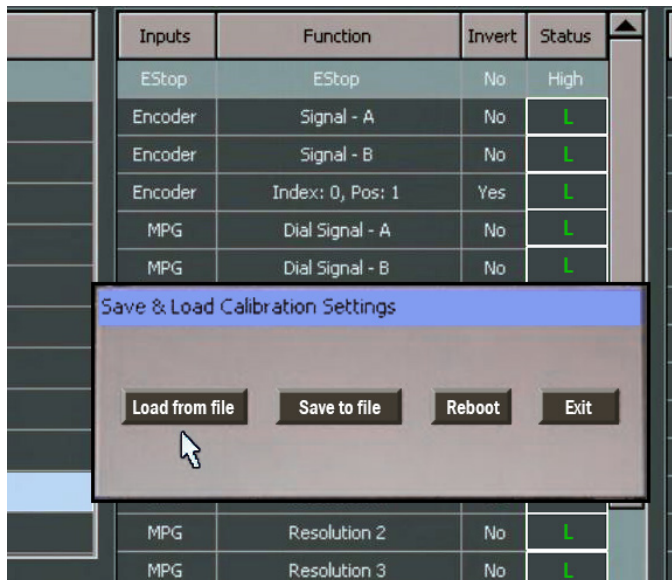


FIGURE 9

- D. Reboot

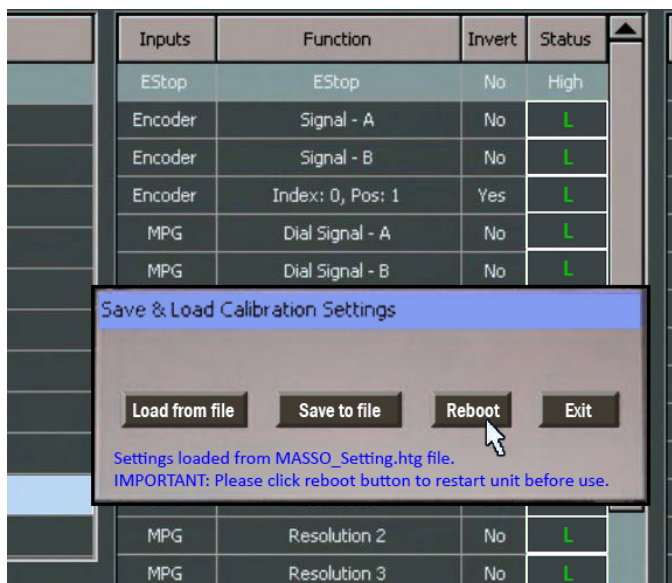


FIGURE 10

- E. PW (---), E-stop on/off.

11. Ready to run.

Saving Settings

1. Follow the above instructions 10-A, and B.
2. Then on the “Save and Load Calibration Settings,” choose “Save to File,” and then “Exit”
3. This will save all of your settings to the flash drive.

NOTES:

1. The Settings and the software upgrades are separate files. When you save a new software upgrade to the flash drive, it doesn’t affect the settings file. As long as you save your settings file, they will still be on the flash drive for future software upgrades.

2. When you first turn on the controller, the Serial No for the controller board will show in the top right corner of the screen (see Figure 8).



FIGURE 8

3. When the controller command screen comes up, the current software that is on the controller will show in the top, right corner of the screen (see Figure 9). The example below shows, “Lathe v3.40.26PID.”

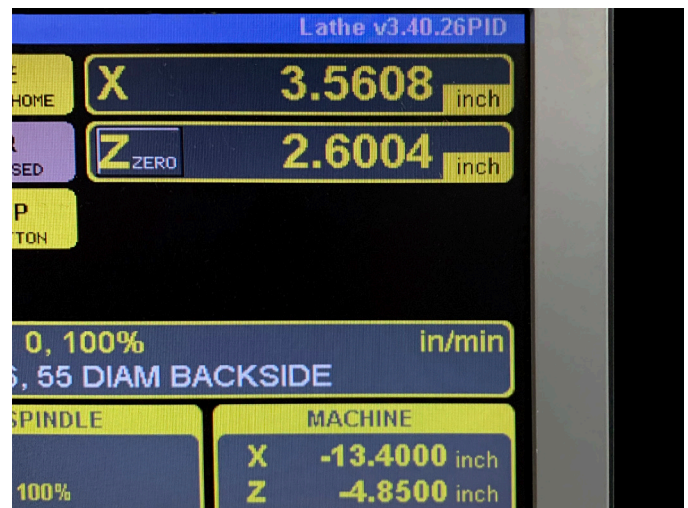


FIGURE 9—The current software version is displayed in the blue bar at the top, right corner of the monitor.

4. For your reference, the “Data1” file that is on the flash drive is the screen shot that displays the “Sherline powered by MASSO” upon startup.

Thank you,
Sherline Products Inc.