



Accessing the Acorn Parameter Settings Page

How to Go to the Acorn Parameter Page

1. Click on “Set up F1,” then click on “Config F3.” Enter the password (137) and hit Enter (see Figure 1).

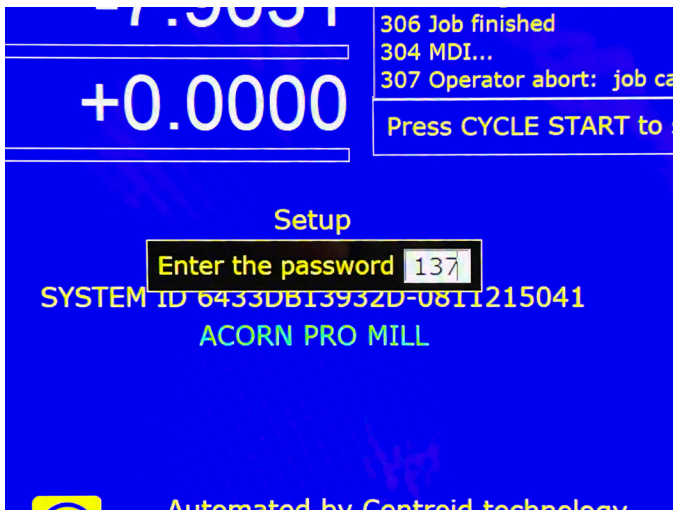


FIGURE 1

2. Click on “Params F3.” Now the “Machine Parameters P0 – P99” will show on the screen (see Figure 2).

Machine Parameters P0 - P99								
000	-8.0000	020	72.0000	040	0.0010	060	0.0000	080
001	0.0000	021	7.9778	041	0.0100	061	5.0000	081
002	0.0000	022	7.9778	042	0.0000	062	90.0000	082
003	0.0000	023	7.9778	043	3.0000	063	128.0000	083
004	9.0000	024	7.9778	044	50007.0000	064	0.0000	084
005	0.0000	025	3.3333	045	64.0000	065	1.0000	085
006	0.0000	026	3.3333	046	2.0000	066	1.0000	086
007	0.0000	027	3.3333	047	0.0000	067	1.0000	087
008	2.0000	028	3.3333	048	0.1000	068	640.0000	088
009	0.0000	029	212.0000	049	0.0000	069	1.7500	089
010	0.0000	030	260.0000	050	0.0000	070	0.0010	090
011	50007.0000	031	0.0000	051	0.0000	071	0.9994	091
012	10.0000	032	25.0000	052	0.0000	072	0.0000	092
013	0.0500	033	1.0000	053	0.0000	073	0.0150	093
014	12.0000	034	4000.0000	054	0.0000	074	4.0000	094
015	5.0000	035	5.0000	055	0.0000	075	0.0000	095
016	10.0000	036	0.0000	056	4.0000	076	0.0000	096
017	0.0000	037	3.0000	057	0.0000	077	0.0000	097
018	50006.0000	038	0.0000	058	0.0000	078	1.0000	098
019	2.0000	039	200.0000	059	0.0000	079	0.0000	099

Modal Tool and Height Offset Control

FIGURE 2

3. In this example, we are going to change parameter 003. In the original default settings, parameter 003 is set to (0.0000) as shown in Figure 2. Parameter 003 is (Modal Tool and Height Offset Control). When this parameter is set to 0.0000, your machine is set up without limit switches to home your machine and set machine zeros. You will use a “Reference Tool” to set your Z Reference and part Zero Position. The “Offset Lib.” page will look like the picture below (see Figure 3).

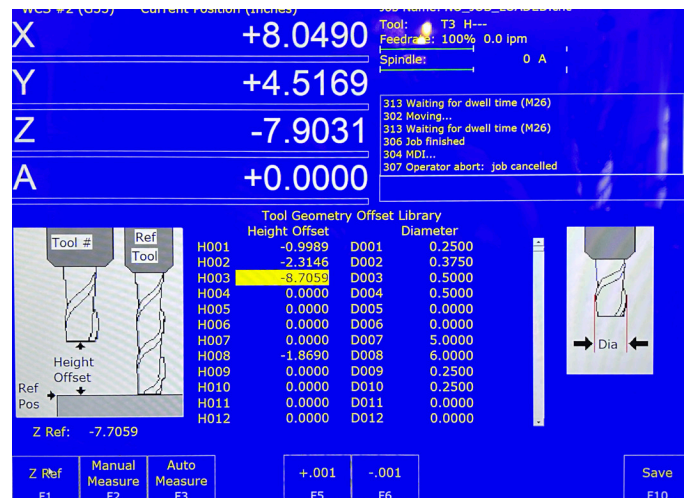


FIGURE 3

4. We are going to change parameter 003 for a machine that has limit switches and we will be using a tool setter to acquire our tool heights. To do this, we will change parameter 003 to (6.0000). Go to the parameter page, use the cursor arrows to move to parameter 003 and the value will be highlighted in yellow. Now enter “6.0” and hit Enter. The value will change to “6.0000” (see Figure 4).

000	-8.0000	020
001	0.0000	021
002	0.0000	022
003	6.0000	023
004	9.0000	024
005	0.0000	025
006	0.0000	026
007	0.0000	027
008	2.0000	028
009	0.0000	029

FIGURE 4

- Click on “SAVE F10” to save the parameter settings. Then click on ESC to go back to the previous pages (see Figure 5).

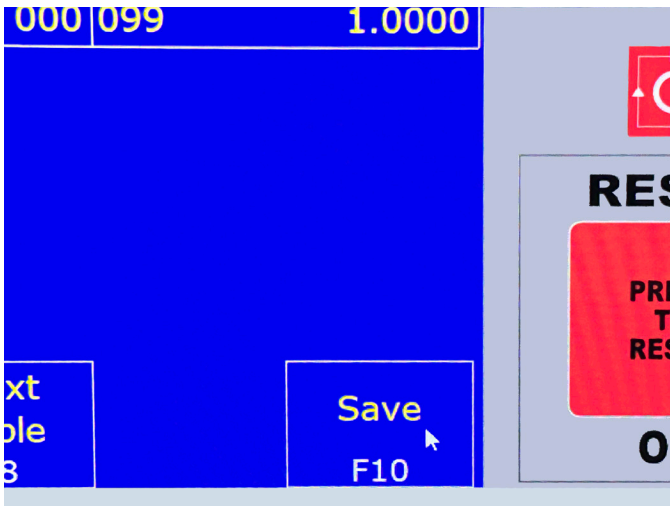


FIGURE 5

- Now go back to the “Offset Lib.” page and it will look like the picture below (see Figure 6).

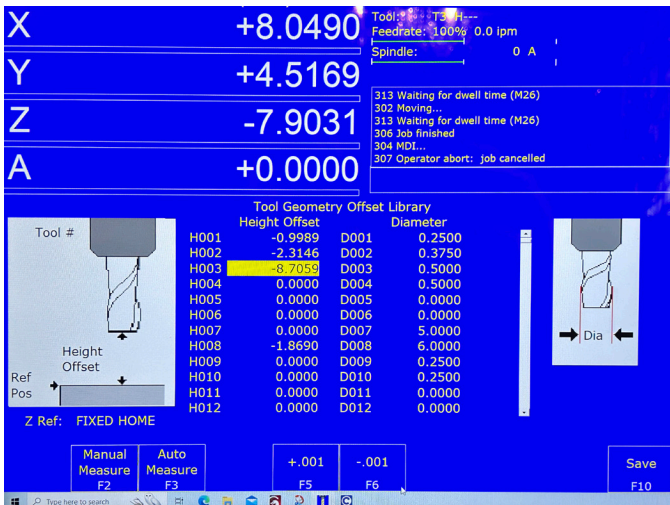


FIGURE 6

- Now you are ready to set all of your tools using the Tool Touch Pad with your Z Ref as your machine home position in the Z axis.

Thank you,
Sherline Products Inc.