



Acorn Pro License Software Upgrade Instructions

How to Configure Acorn Settings

These instructions are for configuring Acorn after running the centroid_cnc12_v5.06_installer, or after the software has been installed.

Import Your Pro License

After installing the Acorn 5.06 software do the following:

1. Click on **Utility**, or press F7 (see Figure).

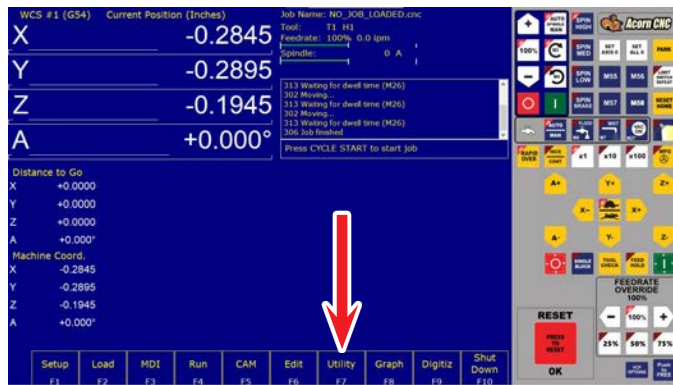


FIGURE 1

2. Import your Pro license file.
3. Click on **Import License**, or press F8 (see Figure).

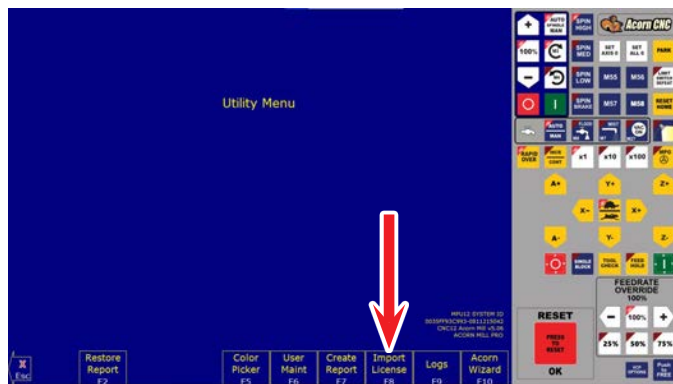


FIGURE 2

4. Select your Pro license file, then click **Open** (see Figure 3).

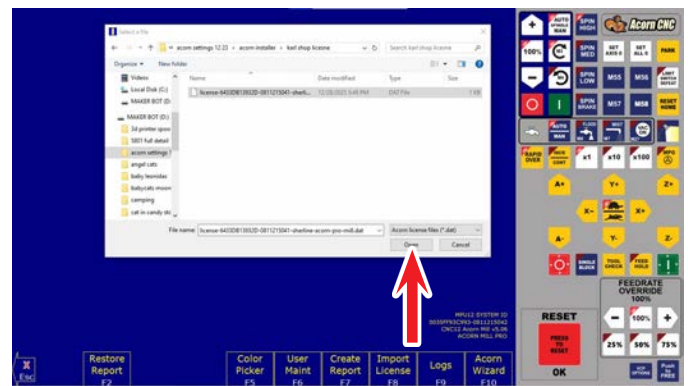


FIGURE 3

5. Your Pro license software is now installed.

Import Machine Setting File

You can import a pre-configured setting file for your machine by using the following example: The *5800ballscrawlaser.xml* file is the setting file for the Sherline 5800 mill.

1. Click on **Utility**, or press F7.
2. Then click on Acorn Wizard.
3. On the **Axis Drive Type** page, click on the **Custom** tab, then click on Import (see Figure 4).

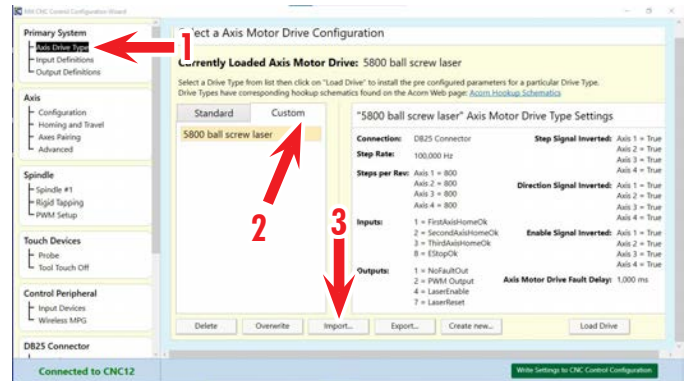


FIGURE 4—1-Select the Axis Drive Type; 2-Click on the Custom tab; 3-Click on the Import button.

4. Go to *acorn settings12 23>setting file*, then click **OK** (see Figure 5).

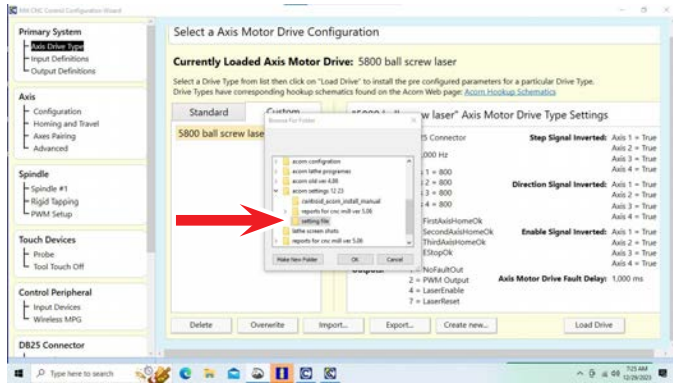


FIGURE 5

5. In this example, you should see *5800 ball screw laser* under the **Custom** tab. Then click on the **Load Drive** button (see Figure 6).

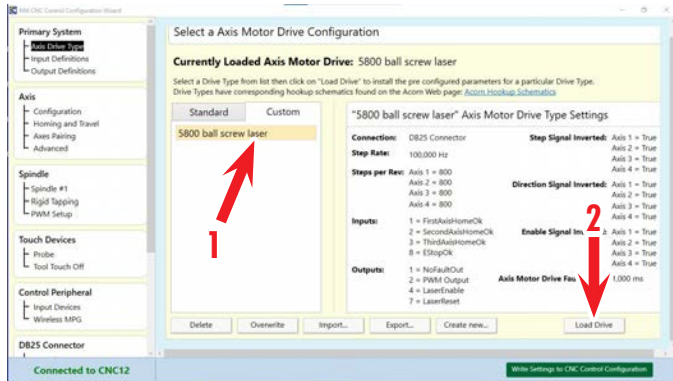


FIGURE 6—1-5800 ball screw laser file; 2-Load Drive button.

6. Then turn the Acorn software off. Then power off the control box. Wait 2-3 seconds and power on the control box. Now restart the Acorn software.

Setting Machine Parameters Page

1. Click on **Setup**, or press F1 (see Figure 7).



FIGURE 7

2. Enter the password *137* and press the Enter key (see Figure 8).



FIGURE 8

3. Click on **Parms**, or press F3 (see Figure 9).



FIGURE 9

4. On this page, you can change any parameter by clicking on it. In the following example, we change **parm 003** from 0.0000 to 6.0000 (this turns off the “Z” reference tool in the tool file). Save your change by clicking on **Save**, or press F10.

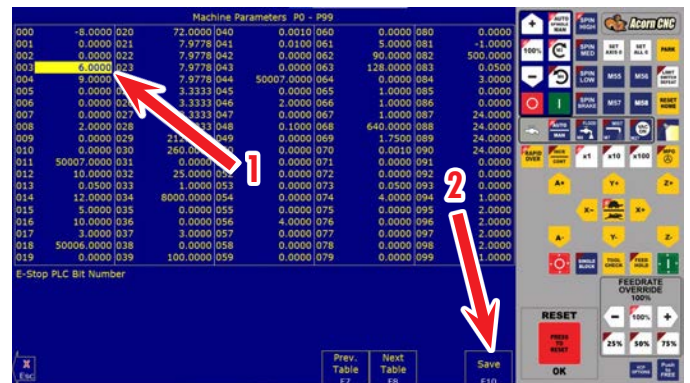


FIGURE 10—1-Parameter 003 changed from 0.0000 to 6.0000; 2-Save button.

Tool Setter Page

This is where you set the **Tool Touch Off Configuration**.

NOTE: Enter the X, Y location for the **Tool Touch Off** plate (where you put it on the table). Then change the **Fixed TT** for **Tool Offset Library** to **Yes**. Now, when you use the **Tool Touch Off**, the machine will move to the X, Y location you set before moving the tool down to the plate (see Figure 11).

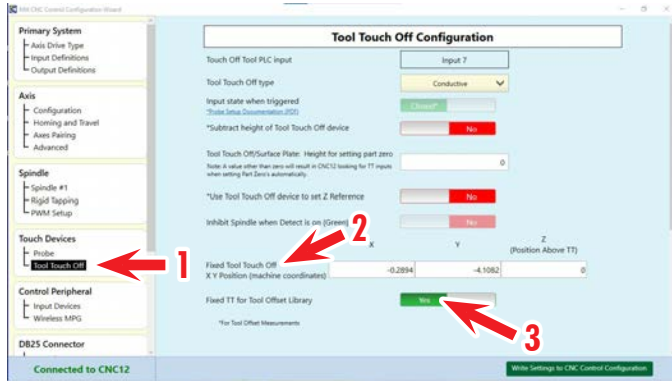


FIGURE 11—1-Tool Touch Off; 2-Enter the XY position for the machine coordinates; 3-Click Yes button.

Acorn Setting Screen Shots

Following are screen shots for setting up the Acorn Mill CNC Control Configuration Wizard. These screen shots are for our 5800 ball screw mill. The screens will vary depending on your machine, leadscrew type, stepper motors, etc. Follow the indexes on the left side of the screens for reference.

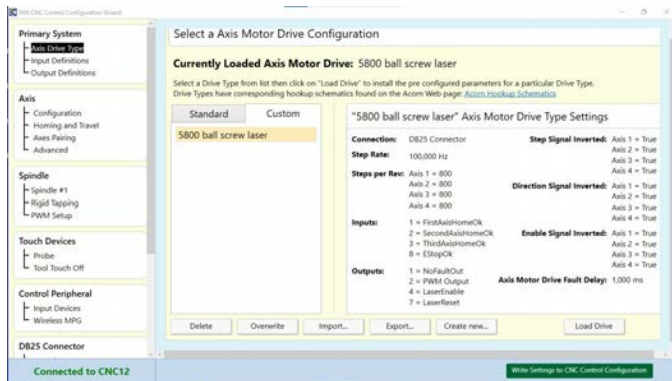


FIGURE 12—Primary System, Axis Drive Type screen.

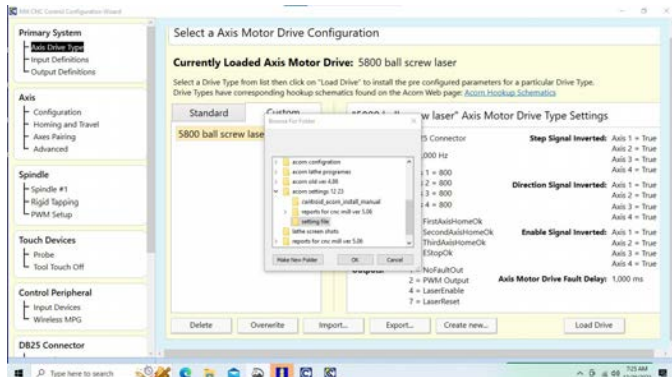


FIGURE 13—Primary System, Axis Drive Type, Import XML Setting file screen.

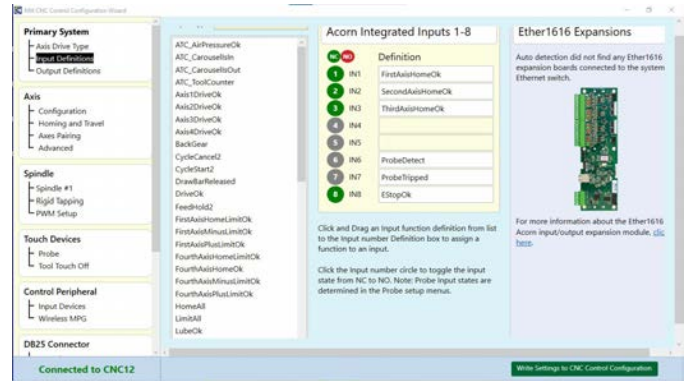


FIGURE 14—Primary System, Input Definitions screen.

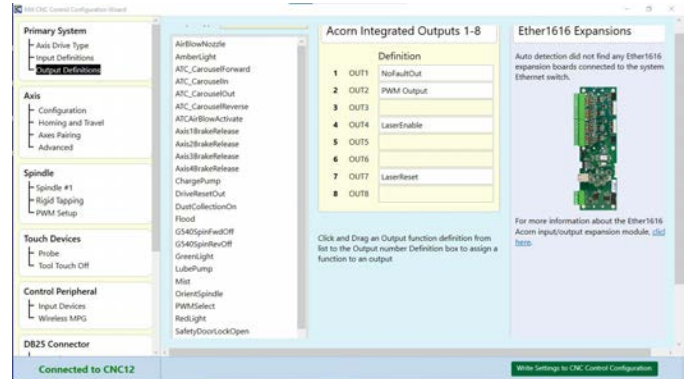


FIGURE 15—Primary System, Output Definitions screen.

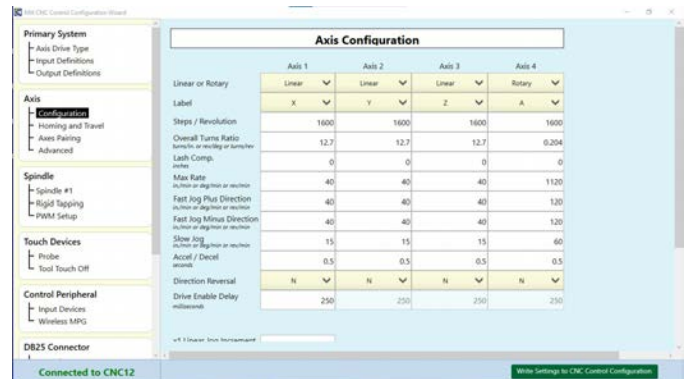


FIGURE 16—Axis, Configuration screen.

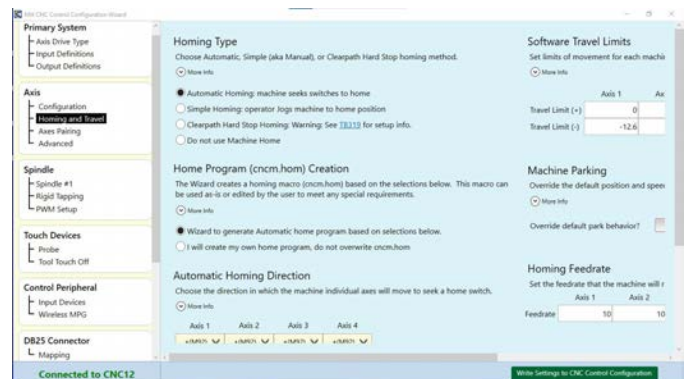


FIGURE 17—Axis, Homing and Travel screen (1).

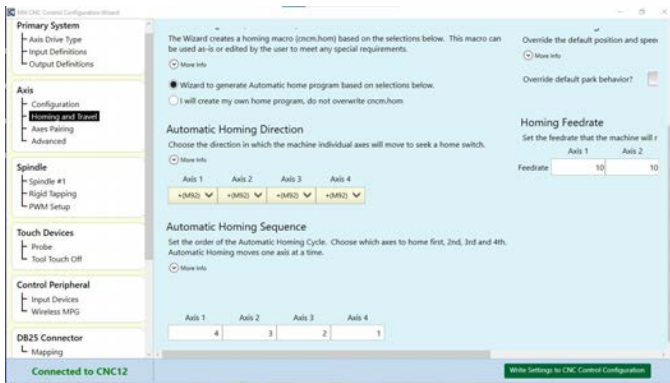


FIGURE 18—Axis, Homing and Travel screen (2).



FIGURE 22—Spindle, PWM Setup screen.

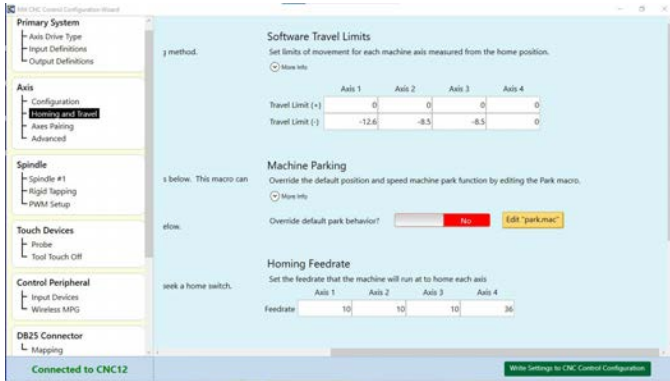


FIGURE 19—Axis, Homing and Travel screen (3).

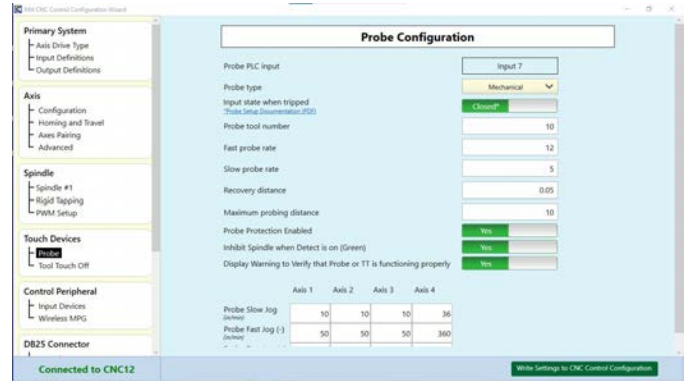


FIGURE 23—Touch Devices, Probe screen (1).

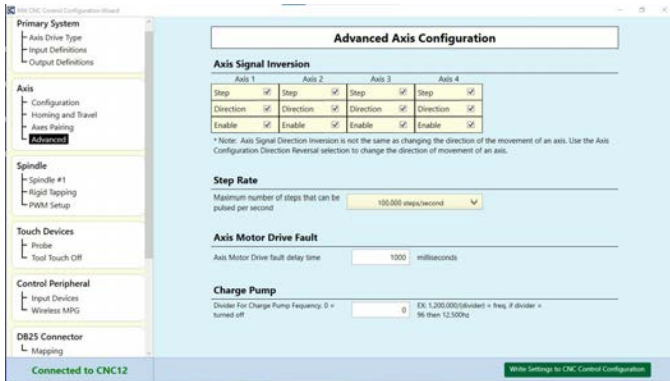


FIGURE 20—Axis, Advanced screen.

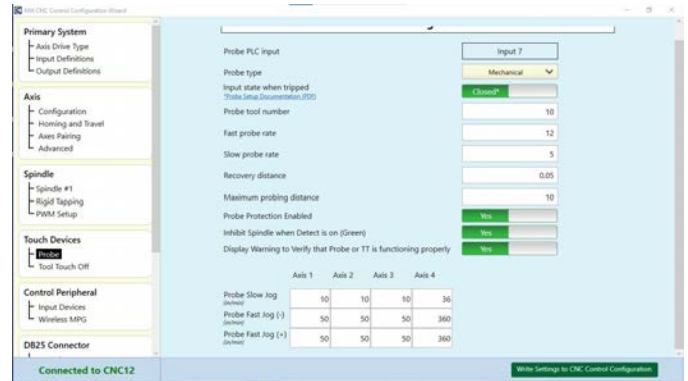


FIGURE 24—Touch Devices, Probe screen (2).

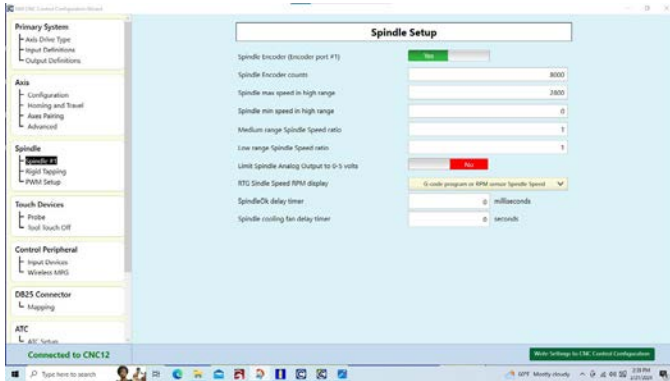


FIGURE 21—Spindle, Spindle #1 screen.

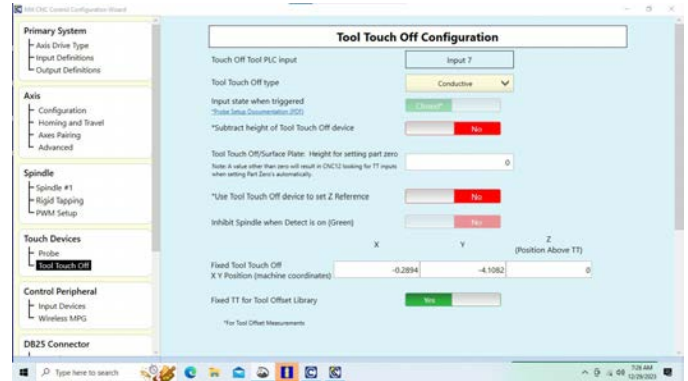


FIGURE 25—Touch Devices, Tool Touch Off screen (1).

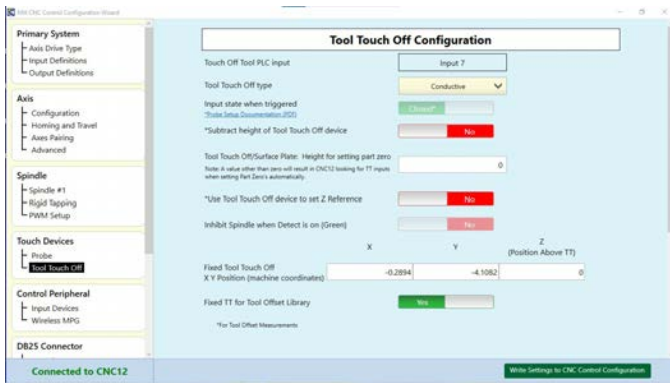


FIGURE 26—Touch Devices, Tool Touch Off screen (2).

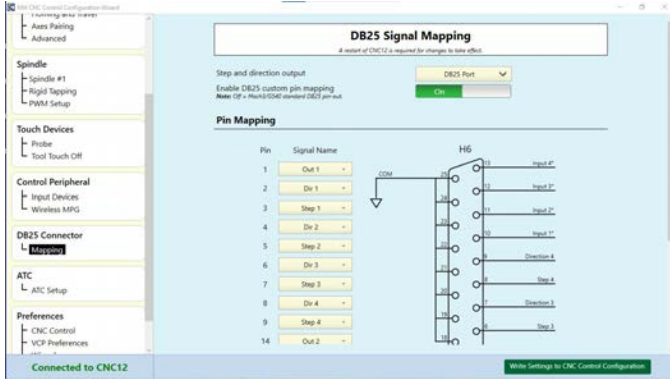


FIGURE 27—DB25 Connector, Mapping screen (1).

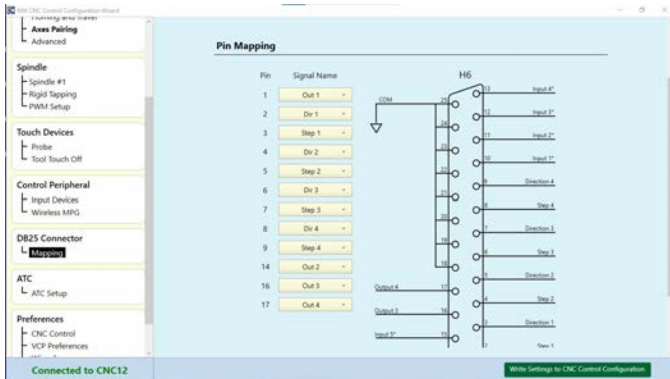


FIGURE 28—DB25 Connector, Mapping screen (2).

Thank you,
Sherline Products Inc.