



Redsail Technology Co., Ltd

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Instruction for rotary installation

First step:

1. If your machine don't have motorized up and down table, please use "Lifter Handle" to rotate the bar and make sure the working table is in the right position.



Lifter Handle



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2.If your machine have motorized up and down table,plea "▲"and"▼" to adjust the working table to the right position.

1)when you press "Z/U" ,the control panel is like below:

2) Then press"▲"and"▼"to adjust the height of working table please see the picture following:

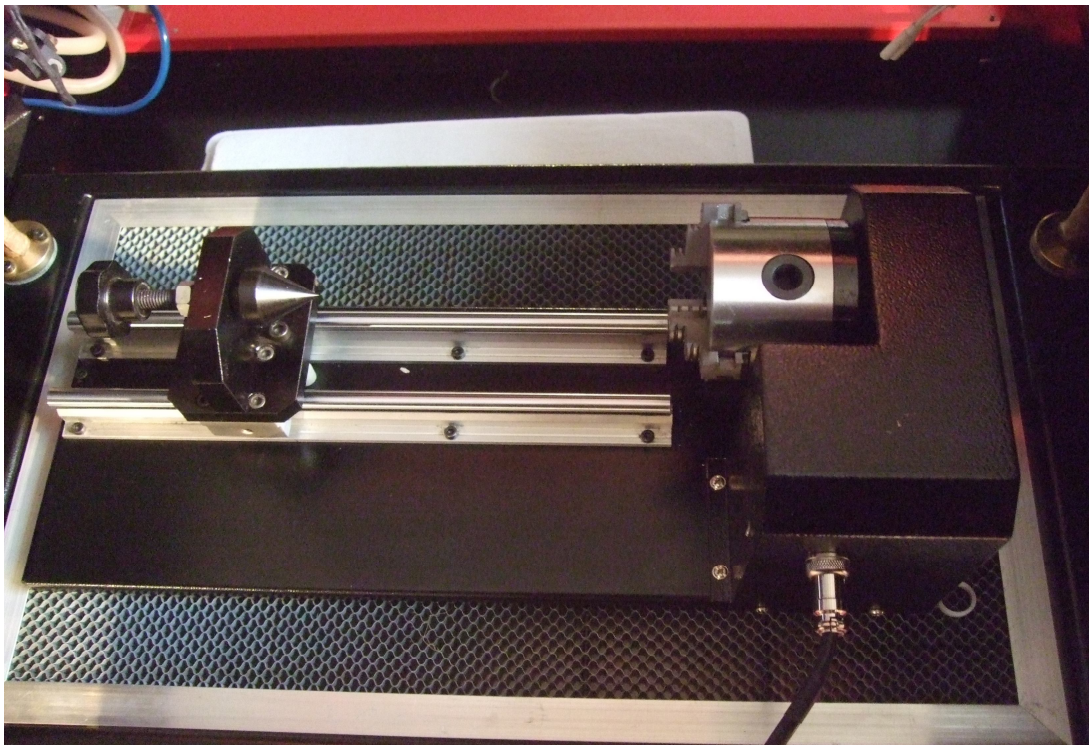
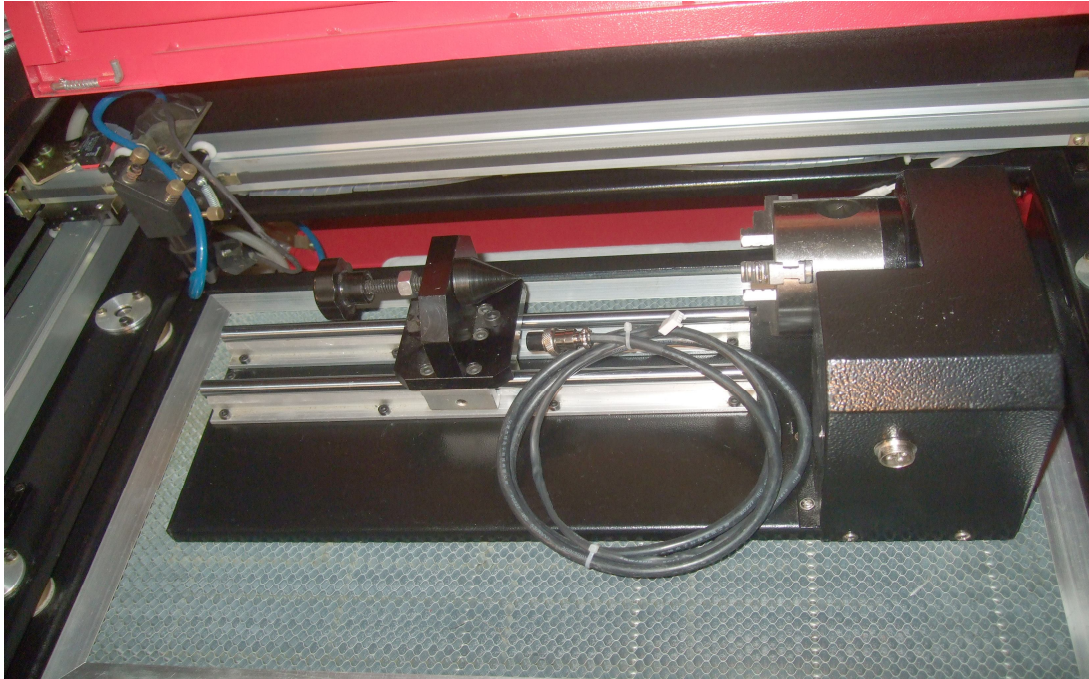




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Second step: put rotary on the working plate, please check the picture below:





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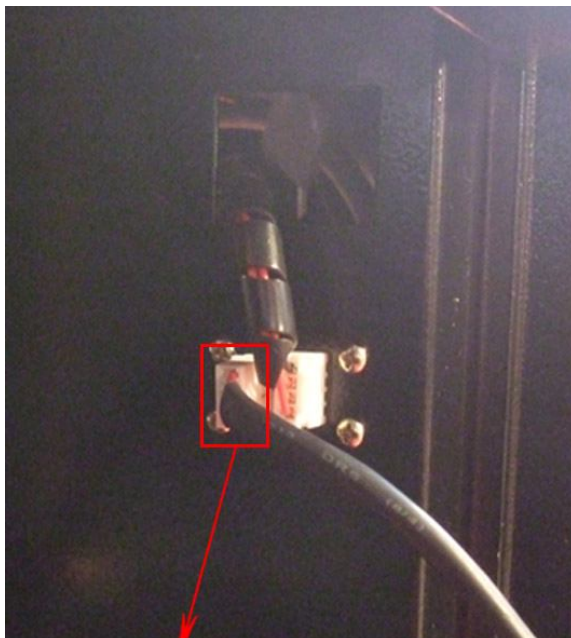
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Third step: Connect rotary with machine as the picture shows by the cable :

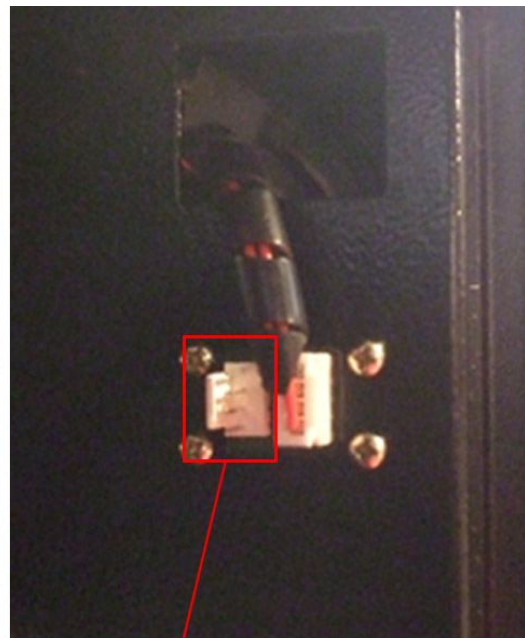
1) please plug in the rotary use wire first, as pictures show:



2) then plug the wire in the port to connect the machine:



Please plug into the port(Plug 1)



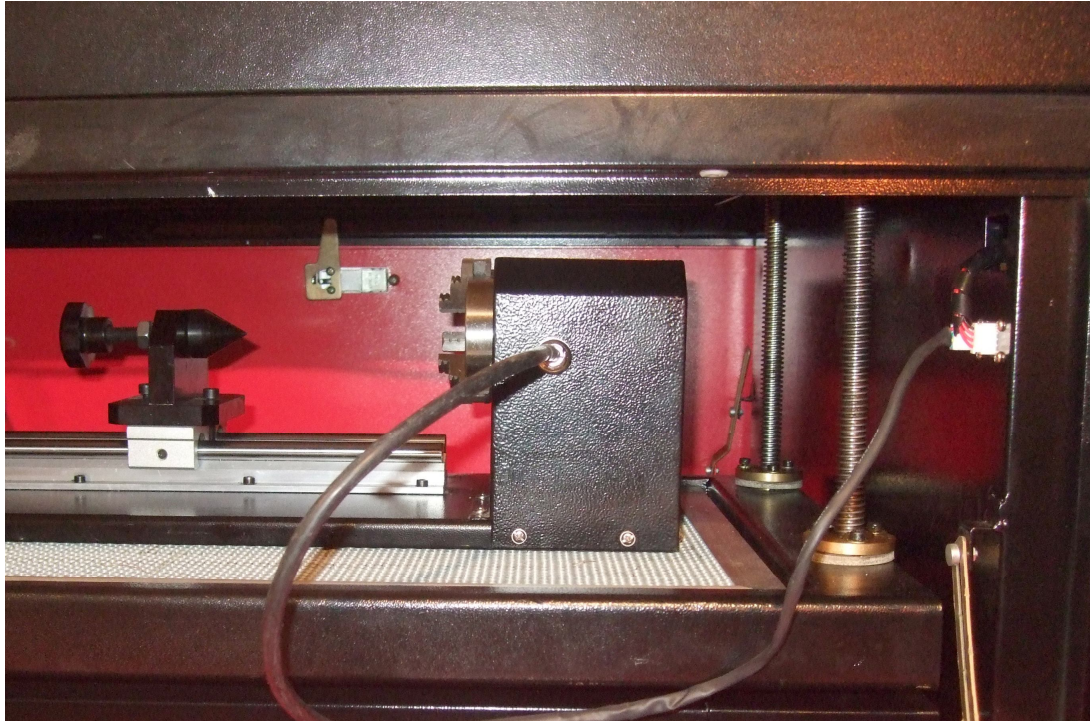
Plug 1



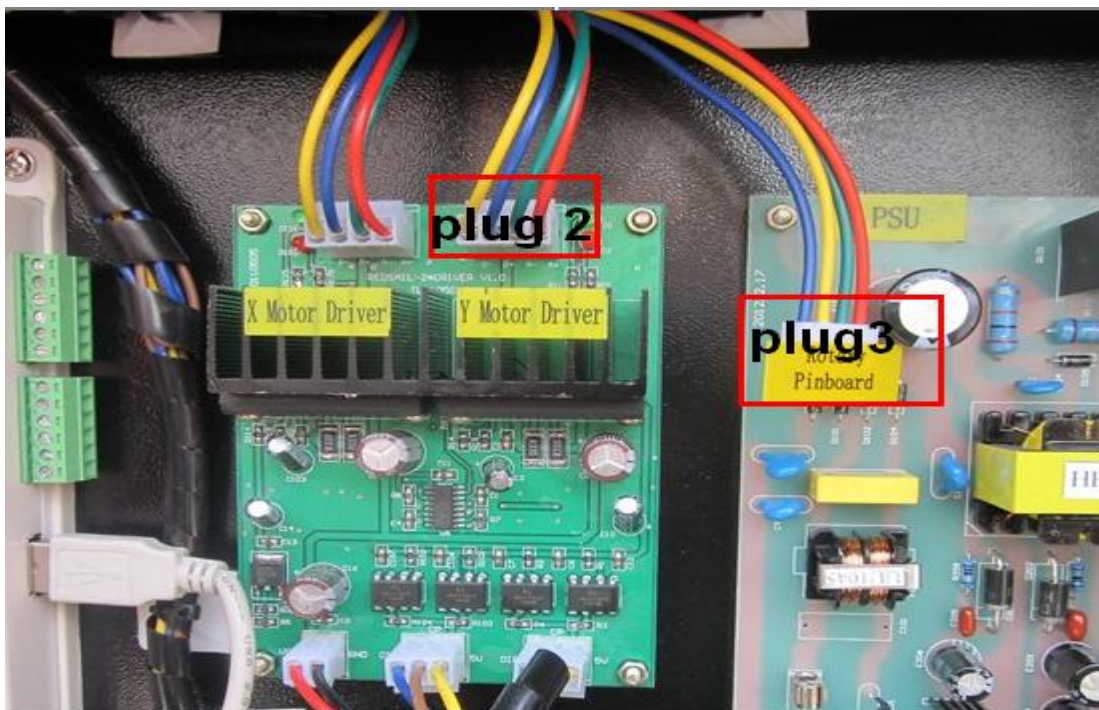
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3)The finish picture is below:



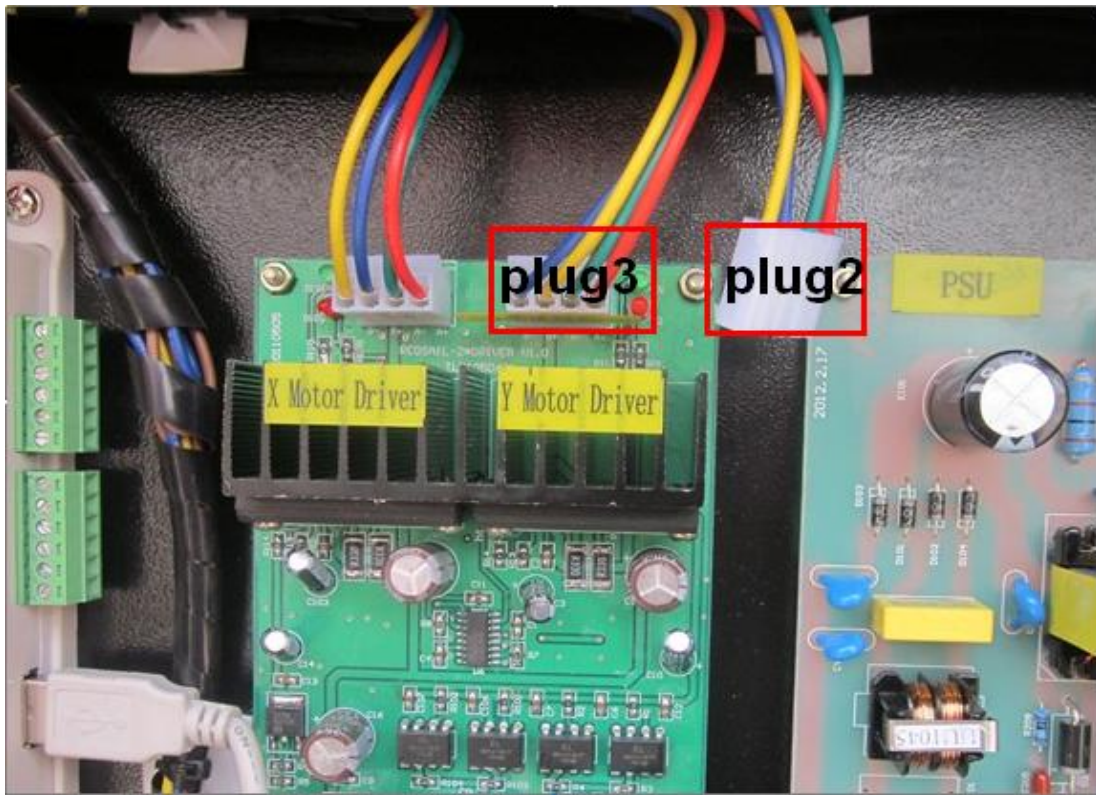
Fourth step: Please change plug2 to plugs 3 as the pictures show below(Note: when using rotary attachment,we will use the motor for itself,so we should connect the cable of rotary attachment to Y axis driver) :





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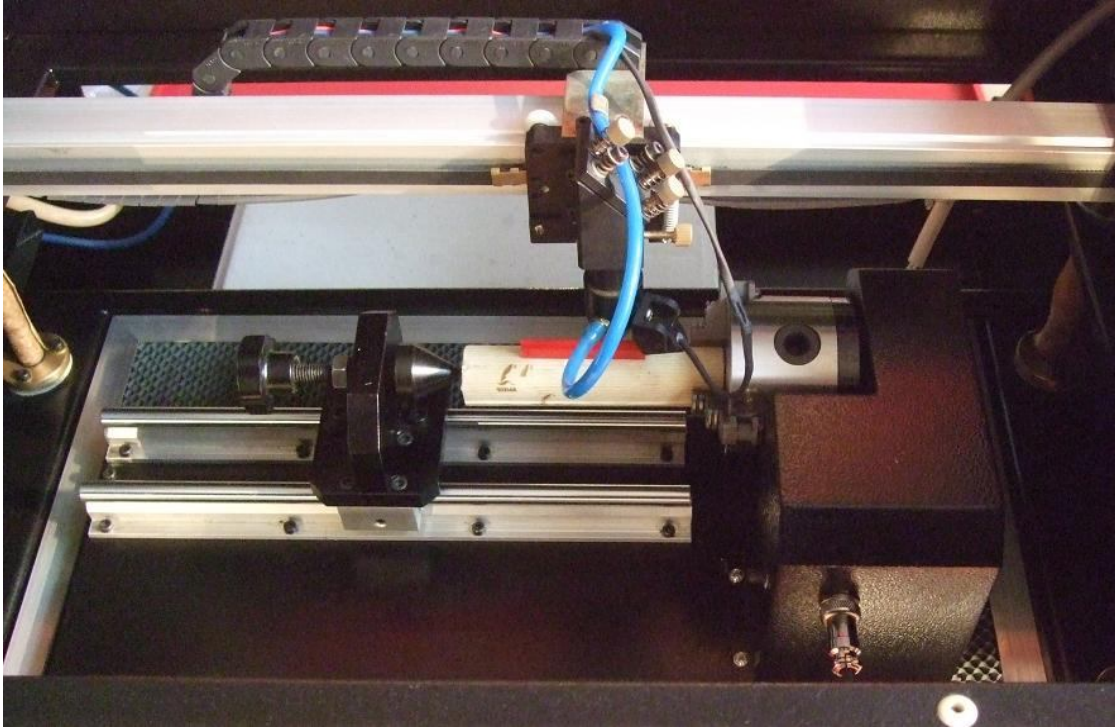
Fifth step: Adjust focal length using acrylic block.





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After all is done, please open the software and change the data as the picture shows below.



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The screenshot shows two software panels. The 'Vendor tools' panel on the left has a table of parameters:

Vendor param	
Axis	Y
Direction polarity	Negative
Limiter polarity	Negative
Keying direction	Negative
Contrl Mode	Pulse+Dir
Enable Limit trigger	Yes
Enalbe home	Yes
Step length(um)	0.35000
Max speed(mm/s)	1000.000
Jump-off speed(mm/s)	5.000
Acceleration(mm/s ²)	8000.000
Breadth(mm)	1000.000
Start speed of keying(mn)	5.000

Annotations include: 'please change to Y axis' pointing to the 'Axis' field, 'change to $2\pi R \cdot 0.4 \cdot 1000/3200$ ' pointing to the 'Step length' field, and 'the diameter of processing material' pointing to the 'Diameter(mm): 20' field in the 'Laser work' panel on the right. The 'Laser work' panel also shows 'Circle pulse: 1000' and 'Speed(mm/s): 50'. A formula $0.4 \cdot 3200$ is written in red above the 'Circle pulse' field.

... R is the radius of the processing material, the unit is millimeter.
... After you change the data, please click "read" first, then "write".

Remark: The other parameters are the same as working without the rotary attachment.

After doing all as above, it is easy to output with rotary.