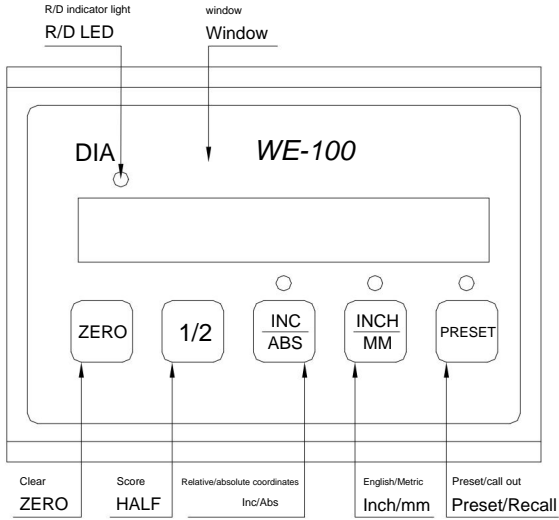


contents

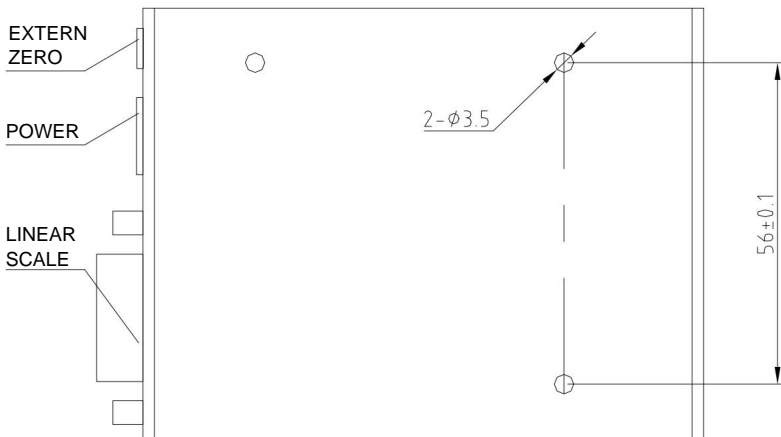
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A panel, back panel diagram and button description

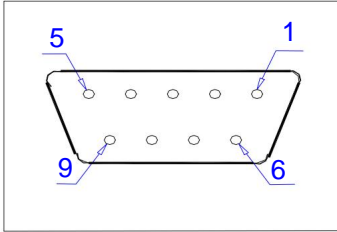
1.1 Panel diagram



1.2 Backplane diagram



1.3 Electronic ruler (or magnetic ruler) pin signal



Foot number	No.
1	+5V
2	0V
3	A
4	B
5-8	NC
9	FG

1.4 Button description

key symbol	Function	Description:
	Reset	Clear the displayed value to zero and use it as the cancel key when setting and presetting the number internally.
	Score	Divide the displayed value by 2 and use it as a sign when presetting the number
	Relative/absolute coordinate mode	INC/ABS coordinate mode switching shifts to the left when presetting the number
	Imperial/Metric units	The display value switches between metric/imperial system and increases the number by 1 when presetting the number.
	preset /call out	The preset/recall operation is a confirmation key when setting the internal settings and preset numbers.

2. Basic operating instructions

2.1 Power on

Function introduction: Turn on the POWER, and the digital display enters the self-test state.

After completion, the various states of the last shutdown will be retained (including position, coordinate mode, display unit, indicator light, parameter setting value, etc.)

2.2 Clear

Function introduction: When the digital display is in normal display state, the displayed value is cleared to zero.

Operation steps:

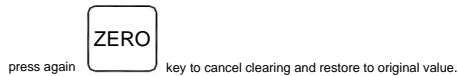


Note : (1) INC and ABS can be cleared in both states.

(2) When cleared in ABS mode, the value in INC mode is also cleared at the same time; while cleared in INC mode

At zero, the ABS mode value does not change.

(3) After clearing, if the electronic ruler (or magnetic ruler) has not moved and other keys have not been pressed, you can



2.3 Absolute/relative coordinate switching

Function introduction: The coordinates are between "ABS" (absolute coordinates) and "INC" (relative coordinates) switch between.

Operation steps:



Note:When the light is on, it means that the coordinate mode is "INC" (relative coordinates).

2.4 Conversion of metric/imperial units

Function introduction: The unit of display size is switched between "MM" (metric system) and "INCH" (imperial system).

Operation steps:



according to  key to complete the switch.


Note: When the light is on, it means that the unit of the displayed size is "INCH" (imperial system).


2.5 points


Function introduction: Divide the displayed value by 2.

Using this function, the zero point can be set at the center of the workpiece.

Operation steps:

- 1) Aim the edge finder at one side of the workpiece and press  key;

- 2) Move the edge finder to the other side of the workpiece and press  key; (To prevent misuse

- press again  button to restore to the state before splitting)

- 3) Move the edge finder and find the point with a displayed value of 0.000, which is the center of the workpiece.


Note: This function can only be used in **INC** mode.

2.6 Preset values


Function introduction: When the digital display is in normal display state, preset the display value of the current position. Example: Preset-125.455



Operation steps:




- 1) Press and hold  For about 3 seconds, the window displays the current value of the electronic ruler (or magnetic ruler), and

The last digit flashes to indicate that it has entered the preset mode.

- 2) Press the  The flashing number of the button increases by 1. When the number is 9, it becomes 0 (when the flashing number is the last digit, the value increment is related to the current resolution).

- 3) Press the  The key flashes and moves one position to the left. If it moves to the highest position, press it again.  button once to go to the rightmost position.

- 4) Press the  button. If it was originally a positive number, the current value will become a negative number. Otherwise, if it was originally a negative number, it will become a positive number.

- 5) Use the above method to input the value of each digit.

- 6) Press the  key, the default value will be restored and exit; or if the default value is not stored, then

according to  key to exit.



Note: 1) The preset value operation can only be performed in the INC state.


2) The decimal point position always remains unchanged and is related to the resolution of the current axis.

2.7 Outbound call operation

Function introduction: call out the preset value.

Operation steps:

- 1) Press  key to call out the preset value. At this time  The light above the key lights;

- 2) To prevent misoperation, you can press it again  key to cancel the call.

Note: Outbound calls can only be made in the INC state.

Three internal operating parameter function settings

Parameter content:

unit	Resolution settings
rA	D/R mode setting
dir	Electronic ruler (or magnetic ruler) counting direction setting
ikB	Last two digits display settings
L	Linear compensation setting
AUTOSET	Automatically set
QUIT	Exit settings



Note: Press

You can switch between setting parameter items by pressing



Change parameter values.

3.1 Enter the internal operation parameter function setting



After turning on the power, when the digital display box performs

key. After the self-test is completed, the window will display

self-test, pressing "UNIT 1" indicates that it has entered the internal function settings.

3.2 Resolution setting


Set the electronic ruler (or magnetic ruler) resolution.

Operation steps:

1) Enter the internal function settings;



2) Press key until the window displays "unit 1";

- 3) Press  the button to switch between resolutions. The options are 0.5 μ m, 1 μ m, 5 μ m, 10 μ m, 50 μ m, 100 μ m, 500 μ m, 1000 μ m, etc. The factory setting value is 1 μ m.

3.3 D/R mode setting

Set the position of the electronic ruler (or magnetic ruler) to be displayed in R mode (radius mode) or D mode (diameter mode). The D mode display value is twice the R mode display value.

Operation steps:

- 1) Enter the internal function settings;

- 2) Press  Until the window displays "rA 0";



- 3) Press the button to select R mode or D mode. 0 means R mode, 1 means D mode. The factory setting value is 0, which is R mode.

3.4 Counting direction setting


Set the counting direction of the electronic ruler (or magnetic ruler).

Operation steps:

- 1) Enter the internal function settings;

- 2) Press  Until the window displays "dir 0";



- 3) Press the  key to select the counting direction of the electronic ruler (or magnetic ruler). 0 and 1 directions opposite direction, the specific direction will be determined during installation. The factory setting value is 0.

3.5 The last two digits display settings

Set whether the last two digits of the data in the window are displayed.

Operation steps:

- 1) Enter the internal function settings;



- 2) Press ZERO Until the window displays "bL 0";



- 3) Press the button to select the display mode. 0 indicates that the last two digits are displayed, 1 indicates that the last digit is not displayed, and 2 indicates that the last two digits are not displayed. The factory setting value is 0.

3.6 Linear compensation setting

Set the linear compensation value of the electronic ruler (or magnetic ruler).

Operation steps:

- 1) Enter the internal function settings;



- 2) Press until the window displays a five-digit value. If it is all zero, it means there is no compensation. Otherwise, the compensation value is set to this value; that is, "LL". The last L represents the current linear compensation value, and the last digit flashes and waits for the input value. |




- 3) Press INCH
MM The key flashes and the number increases by 1. When the number value is 9, it becomes 0.



- 4) Press one INC
ABS Move the key one position to the left. When it moves to the highest position, move it further left to the rightmost position. digit on the side.



- 5) If the button was originally a positive number, the current value will become a negative number. On the contrary, if the button was originally a negative number, the current value will become a positive number.

- 6) Press  Save the entered value and exit setting the compensation value.

Note: 1) The maximum input compensation value shall not exceed 99999, and the minimum value shall not be less than -99999.

- 2) The compensation value is calculated according to the following formula:



$$\text{Compensation value} = \frac{\text{Display value} - \text{Standard value}}{\text{Standard value}} \times 1000000$$

3.7 Automatic settings

Set the system to factory settings.

Operation steps:

- 1) Enter the internal function settings;




- 2) Press  until the window displays "AUTOSET". At this time, press  the key to confirm the automatic setting, and the window displays "Init_EE". After completion, it will automatically switch to the next setting item.

Note: After the system is automatically set, all setting items are set to 0.

3.8 Exit internal function settings

Save and exit internal function settings.

Operation steps:

- 1) Press  key until the window displays "QUIT".
- 2) Press to  store the setting value and leave the internal function setting. (Press  back to internal Key weight function settings)

Appendix A: Specifications

size: 104*77*35(mm)

weight: 252.5g

Power DC 7.5~9V

supply: <5W

Power consumption: Electronic interface: TTL