DrufelCNC

DrufelCNC DDSM6V5.0 (DDREAM) Installation Manual



DrufelCNC, 2021

DrufelCNC - software for controlling CNC machines. Read more: https://drufelcnc.com

Contents

Annotation	4
NOTICE OF LIABILITY	5
1. Features	6
2. Appearance	7
3. Product connection define and method	8
4. Basic connection diagram	12
5. Connection diagram stepper motors and spindle	13
6. Connection diagram input ports	14
7. Connection diagram MPG	15
8. Installing DrufelCNC	16
9. DrufelCNC interface	22
10. Run the program	
11. Customization	27
11.1. Common	27
11.2. Controller Configuration	
11.3. Axis Setup	
11.3.1. Calibrate axis	
11.4. Configure Input Ports	
11.4.1. Input port diagnostics	
11.4.2. Hot keys	
11.5. Configuring output ports	
11.6. Spindle adjustment	
11.7. Machine size	
11.7.1. Size axis	
11.7.2. Soft limit	
11.7.3. Home function	
12. Run the control program (G-code)	
13. Search tool zero	
14. Manual control	
15. Spindle control and cooling	
16. Assignment of coordinates	
16.1. Measurement system	
16.2. Machine coordinates	
16.3. Work coordinates	
17. Display 3D model	50

DrufelCNC - software for controlling CNC machines. Read more: https://drufelcnc.com

18.	Opening HPGL files	51
19.	Basic parameters of the HPGL file converter	
19.1.	Spindle settings of HPGL file converter	
19.2.	Use step by step	
20.	Generating a G-code from an image	
21.	Stepper motors	

Annotation

This document is the user guide for the DrufelCNC software. The information contained in this document may be modified by employees of the company with the subsequent notification. Your changes are reflected in the document version. The company does not guarantee the absence of errors or typographical errors in this document, but will work to eliminate them, and will also be grateful to everyone who finds them and points to them.

Comments and suggestions to this document are accepted by email: social@drufelcnc.com. Document version - V.1.17.

NOTICE OF LIABILITY

Using any CNC machine is a dangerous operation. All precautions must be taken, as the machines may turn on at any time, the software MAY malfunction at any time, any user of the Software must understand and take this into account, and must immediately uninstall the Software and not proceed with the installation if they are not fully understand all the consequences of the use, as well as the fact that in case of misuse, the wrong code, unexpected movement or any damage caused by the aforementioned consequences mi, there is no legal protection.

1. Features

- Support for CNC controlled 6-Axis, can connect five stepper motor drivers or servo drives.
- USB communication interface, and power supply for the board.
- 10 IO input, opto-isolated, It Can be configured to limit the emergency stop and other functions, all of them are 2edg port.
- 14 IO input with no opto-isolated but with iso-IC. This port is set to IDC 2.54mm port.
- 14 IO output with no opto-isolated but with iso-IC. This port is set to IDC 2.54mm port.
- 2IO output with opto-isolated for spindle.
- Spindle control port has PWM Mod (0%-100% duty cycle with 12Vpp) and voltage Mod (0-10V).
- Spindle speed feedback port-INDEX.
- There is a power auto stability system. When USB port overvoltage or under voltage or within other EMI, this system can make power of system stable.
- There are High speed interface chips, which make stepper driver signal more stable.
- There is a USB protection chip, which can protect system within high voltage EMI.
- Support for the operating system Windows XP, Windows 7 (32 / 64bit), Windows 8, Windows 10.
- Applicable to all versions of DrufelCNC software.

2. Appearance

The board Size is 120*72*20mm.



DrufelCNC - software for controlling CNC machines. Read more: https://drufelcnc.com

3. Product connection define and method

The controller connection includes a power supply interface, a USB connection interface, an MPG interface, a Stepper / Servo control output interface, a spindle control output interface, Estop and a limited switch input and tool settings interface and so on.



1 - Stepper motor control interface.

6-axis stepper motor control signal output, axes are defined as XYZABC from left to right. Each axis is defined as COM+\CP-\DIR-. They are positive common, negative pulse, negative direction. This card is common positive

connection, so CK+ and DIR+ of Stepper driver should be connected to COM+. This board does not support the common negative connection. This card doesn't have EN signal, Most drives on sale should not connected to the EN signal.



2- Spindle Control Output Port.



3 - Common IO output interface.

General IO output. Have a current drive capability within 20MA.The card turn 90° clockwise, it's defined as GND, OUT2, OUT4, OUT6, GND, OUT8, OUT10, GND, OUT12 and OUT14 from left to right in top row; it's defined as +5V, OUT1, OUT3, OUT5, +5V, OUT7, OUT9, +5V, OUT11 and OUT13 form left to right in bottom row.



4 - USB Port.

5 - Input Ports. Estop input connection



DrufelCNC - software for controlling CNC machines. Read more: https://drufelcnc.com

Probe input connection



End switch input connection



DrufelCNC - software for controlling CNC machines. Read more: https://drufelcnc.com

4. Basic connection diagram





5. Connection diagram stepper motors and spindle

6. Connection diagram input ports



7. Connection diagram MPG



8. Installing DrufelCNC

To install the program you need to download the installation files on the official website www.drufelcnc.com. You can use one of the following files:

- DrufelCNC_installer_x64.exe, DrufelCNC_installer_x32.exe this installation file will automatically install DrufelCNC on your computer documentation and examples of g-codes;
- DrufelCNC.zip archive with DrufelCNC x32 and x64 with examples and documentation.

Run the desired file and follow the installation instructions.

Description of the installation process

1. *Start the installation process.* In this installation window you need to select the program installation mode.



2. *License Agreement.* The License Agreement installation window contains the text of the license agreement for the use of the DrufelCNC software product. Please read the agreement and select "I accept the terms of the license agreement". To continue the installation, click "Next." During the entire installation process, to return to the previous installation step, click the Back button. To exit the installer, click Cancel.

Setup - DrufelCNC version 1.17 -		×
License Agreement Please read the following important information before continuing.		Ø
Please read the following License Agreement. You must accept the terms of this agreement befo continuing with the installation.	re	
LICENSE AGREEMENT DrufelCNC software		^
NOTICE OF LIABILITY		
Using any CNC machine is a dangerous operation. All precautions must be taken, as the machine turn on at any time, the software MAY malfunction at any time, any user of the Software must understand and take this into account, and must immediately uninstall the Software and not pro with the installation if they are not fully understand all the consequences of the use, as well as fact that in case of misuse, the wrong code, unexpected movement or any damage caused by t aforementioned consequences mi, there is no legal protection.	s may ceed the he	
TO GET THE PERMISSION TO STARTING ON ANY MACHINE, YOU MUST AGREE WITH THE FOLLOWING:		
I agree that no one except the owner of this car will under any circumstances be responsible for operation_safety and use of this machine. Lagree that there is no situation in which I would con	the the	~
 I accept the agreement 		
○ I do not accept the agreement		
Next >	(Cancel

3. Select the directory in which the installation will be made. At this stage of the installation, you must specify the directory in which DrufelCNC will be installed. The default installation directory is "C:\Program Filies\DrufelCNC".

If you wish, you can specify any other path. Depending on the version of Windows, the default path may be different. To continue the installation, click "Next."

Setup - DrufelCNC version 1.17	_		×
Select Destination Location Where should DrufelCNC be installed?			Ø
Setup will install DrufelCNC into the following folder.			
To continue, click Next. If you would like to select a different folder, click Browse.			
C:\Program Files\DrufelCNC	Br	rowse	
At least 15.0 MB of free disk space is required.			
< Back Nex	(t >	Car	ncel

4. *Selection of additional installation parameters.* At this stage of installation, it is necessary to determine the need to create program shortcuts on the desktop. By default, a program shortcut will be created. To continue the installation, click "Next."

Setup - DrufelCNC version 1.17		_		×
Select Additional Tasks Which additional tasks should be performed?				Ø
Select the additional tasks you would like Setup to perform while installin	ng DrufelC	NC, then dick	Next.	
Additional shortcuts:				
Create a desktop shortcut				
<1	Back	Next >	Ca	incel

5. *Preparing for installation.* A window with information about the selected installation type, selected components and installation directory will be displayed. Check the information and click "Install."

D Se	tup - DrufelCNC version 1.17	_		×
Re	ady to Install Setup is now ready to begin installing DrufelCNC on your computer.			Ø
	Click Install to continue with the installation, or click Back if you want to review or change	any sett	ings.	
	Destination location: C:\Program Files\DrufelCNC		1	×
	Additional tasks: Additional shortcuts: Create a desktop shortcut			
	<		>	
	< Back Inst	all	Car	ncel

Setup - DrufelCNC version 1.17	_		×
Installing Please wait while Setup installs DrufelCNC on your computer.			Ø
Creating shortcuts C: \ProgramData \Microsoft \Windows \Start Menu \Programs \DrufelCNCx64.lnk			
		Са	ncel

6. *The final stage of installation.* At the last stage, the installation program will report the result and will offer to start the programs depending on the type of installation selected earlier. By default, you can run the program. To complete the installation, click Finish.



9. DrufelCNC interface



The DrufelCNC interface can be divided into three blocks:

- 1. G-code window
- 2. Base functions
- 3. 3D window

G-code-window:

	Edit file Settings	
	DrufelCNC	
Open file		About DrufelCNC
	1: G00F300	
	2: G01F300	
	3: M04S24000	
	4: G00Z3	
	5: G00X0Y122.975	
	6: Z-0.03	
	7: X-0.025Y29.025	
	8: X1.45Y32.125	
	9: X5.625Y39.7	
G-code	10: X10.85Y48.325	
Window	11: X16.9Y56.8	
	12: X20.175Y60.725	
	13: X20.175Y103.225	
	14: X33.875Y103.275	
	15: X39.125Y102.15	
	16: X42Y101.225	
	17: X44.5Y100.225	
	18: X46.425Y99.2	
	19: X49.3Y97.325	
	20: X51.4Y95.85	
	21: X52.9Y94.3	
	22: X54.575Y92.275	
	23: X56.6Y89.9	
	📿 of the task: 2 hour. 21 min. 51 sec. 997 ms.	Remaining part
	🔀 to completion:	processing time
	CONCY -	
Start button	Start Start	
		Emergency
		stop button
Pause button	Pause Stop Received Stop	
	08:59:14.118 All machine coordinates are set to zero	Log of events
	08:58:59.343 Connection successful.	and actions
	< >	
	-	

Functions	Description
Open file	Open file button
Edit file	Edit g-code file button
Settings	Function setting button
About DrufelCNC	DrufelCNC information
	button
G-code window	Display of G-code
Start	Start button
Pause	Pause button
Remaining time part	Remaining part
	processing time
Emergency stop	Emergency stop
	button
Log of events and	Log of events and
actions	actions

Base functions:



Functions	Description
Work coordinates	Activating work
Machine coordinates	Activating machine
Inch	Activating inch mode
Millimeters	Activating millimeter mode
All zero	Reset all coordinates
Go to home	Tool movement to zero coordinates
Go to X0 Y0	Go to X0 and Y0 coordinates
All home	All axes GOTO HOME
X Y home	X Y axis goto home
Z safe	Move the Z-axis to a
Set the probe height	Set the probe height
Find probe	Find probe
Stop Probe	Stop Probe
Button to increase	Button to increase
the rotation of the	the rotation of the
spindle	spindle
Button to reduce	Button to reduce
the rotation of the	the rotation of the
spindle.	spindle.
Spindle power	Spindle power button
Spindle off	Spindle off button
Turn on cooling	Turn on cooling button
Turn off cooling	Turn off cooling button
Panel manual speed	Panel manual speed
Manual control axes	Manual control axes
Manual control z axes	Manual control z axes
Increase speed	Increase speed
Decrease in spindle	Button to reduce
rotation	the rotation of the spindle
Increase spindle	Button to increase
rotation	the rotation of the spindle
Stop Probe	Stop Probe button
Find probe	Find probe button
Set the probe height	Probe height button

3D window:



Functions	Description
Scale 3D model	Scale 3D model button
Reducing	Reducing
the 3D model	the 3D model button
Zoom 1:1	Zoom 1:1 button
Zoom x10	Zoom x10 button
3D window	Display of 3D-model
Turn off grid	Turn off grid button
Turn on grid	Turn on grid button
View in 3D	View in 3D button
ZY plane in 3D	View the ZY plane in 3D
XZ plane in 3D	View the XZ plane in 3D
XY plane in 3D	View the XY plane in 3D

10. Run the program

To run the program, use the version depending on the bitness of your operating system:

- DrufelCNCx32.exe version for 32-bit operating systems
- DrufelCNCx64.exe version for 64-bit operating systems

The main window of the program.



In the lower left corner displays the status of the connection to the USB controller, and other informational messages.

11. Customization

To configure DrufelCNC you must click on the button with the image of the key

Next, go to the section of settings that interests you.

11.1.Common

In the common tab, you can set values for accelerated tooth movement (idle movement, G00), working feed (G01, G02, G03) and use anti-aliasing.







Use anti-aliasing When moving on bends, the speed will decrease, for smoothing. When moving along curved vectors, the speed of movement will decrease.

11.2.Controller Configuration

In the window that opens, go to the «Device Controller» tab.

nettings 🖉								_		×
tommon	Device controller	Axes setti	ngs 🕣	Input Po	orts 💽 Output	Ports	Spi	ndle 🛃	🛓 Machin	e size
Devices:					Automatic s	election of	supported	device	💯 Refre	sh
Name Name NVxMxV2	Manufacturer NOVUSUN	VID 49745	PID 0	Version 256	Serial number 0001A0000000	Outp 65	Input 65			^
		33006	33	256		0	9			
<	-4									>
Period sending comma	nas			Stand	Device mode					
5 ms The duration of the co 5 us	∽ ntrol pulse ∽		The	period of scar	nning coordinates					
Apply							Save	X	Cancel	

In the hardware section, you must select a controller by setting a point in the radio button block opposite the USB controller. Save the settings.

11.3. Axis Setup

To configure a stepper motor or servo drive, go to the Axis Settings tab.

P Settings	_		×
Common Device controller 💭 Axes settings 🔶 Input Ports 💽 Output Ports 🗊 Spindle	<u> </u>	Machine	size
Setting the axis X Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step Backlash mm Invert direction Invert step Backlash mm Invert direction Invert step Invert Invert step Invert Invert step Invert Invert step Invert Invert Invert step Invert In	Slav	ve axis - V	^
Setting the axis Y Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step Backlash mm Invert direction Invert step Backlash mm Invert direction Invert step Invert Invert Invert step Invert Invert Invert step Invert Invert Invert Invert Invert Invert Invert step Invert I	Slav	ve axis - V	
Setting the axis Z Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step Backlash mm Invert direction Invert step Backlash mm Invert direction Invert step Invert Invert Invert step Invert Invert Invert step Invert Invert Invert step Invert Invert Invert Invert Invert step Invert Inv	Slav	ve axis - V	
Setting the axis A Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step Backlash mm Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step Backlash mm Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Invert direction Invert step 0 Impulses at 1 mm Speed mm/min Invert step 0 Impulses at 1 mm	Slav	ve axis - V	
Setting the axis B Impulses at 1 mm Speed mm/min Acceleration mm/min Invert direction Invert step Backlash mm Impulses at 1 mm 320 Impulses Im	Slav	ve axis - V	•
Apply Save	< c	ancel	

Set the required number of pulses for each axis. Save the settings. If necessary, specify the submission of the axes. Use the inversion setting to change the direction of rotation of the motor.

Fnabled	Enables the axis to be displayed in the coordinate list.
Impulses at 1 mm	The number of pulses per millimeter. You can use the calibration function to calculate.
Speed mm/min	Maximum speed of the axis movement.
Acceleration mm/min	Smooth acceleration of the axis movement.
Invert direction	Invert the direction of movement of the axis.
Invert step	Invert the step signal when transmitting the axis movement commands.
Backlash mm	Backlash of the ball screw.



A slave axis can be defined for an axis. Then, the slave axis will move along with the current.

11.3.1. Calibrate axis

By clicking on the calibration button for a specific axis, the axis calibration window will open. This window is for calculating the number of pulses per mm.



Attention! This speed must be slow! This is necessary so that you can quickly respond to an emergency and not damage the machine.

After that click on the «Start move» **start move** button. After pressing the button, movement will begin for the specified segment.

Calibrate X-axis		×
Calibr	ate	X-axis
Move to, mm 50 50 50 50 50 50 50 50 50 50		The tool has moved to, mm
	_	Apply Cancel

After the tool has finished moving, use the ruler to measure the actual distance the tool moved.

Enter this value in the «The tool has moved» to field.

Calibrate X-axis		×
Calibr	ate	X-axis
Move to, mm 50 50 • Stoped, mm/min Stoped • Stoped • Stoped • Stoped • Stoped		The tool has moved to, mm
		Apply Cancel

Click the «Calculate» Calculate button. After pressing, the number of pulses per 1 mm will be calculated that you need to set for the axis to be calibrated.

💋 Calibrate X-axis		×
Calibra	ate	X-axis
Move to, mm 50 V	•	The tool has moved to, mm
Move speed, mm/min 300 Stoped Stop move	v	Calculate Set 1600 pulses per millimeter.
		Apply Cancel

Click the «Apply» Apply button to apply the calculation results.

11.4. Configure Input Ports

To configure input ports, go to the Input Ports tab.

Settings					- 🗆
Common 🛃 I	Device controller	Axe	s settings 🕣	Input Ports	Output Ports 🛒 Spindle 🙏 Machine
Name	Port number	Invert	Value now	Hot Key	Hotkey settings
Main Input Ports	Port number	Invert	Value now	Hot Key	↑ Ctrl + Δ ^{Use default keys}
Emergency stop	1 [No	Low	None None	Use global hotkey
	0	No	Low	None None	
···· Pause	0	No	Low	None	
···· Start	0	No	Low	None None	
Probe	2	No	Low		
(axis	Port number	Invert	Value now	Hot Key	Input port diagnostics
🖂 Limit X+	3	No	Low		In0 In1 In2 In3
🖂 Limit X-	3	No	Low		In4 📕 In5 📕 In6 📕 In7 📕
	3	No	Low		In8 In9 In10 In11
' axis	Port number	Invert	Value now	Hot Key	In12 In13 In14 In15
Limit Y+	4	No	Low		In16 In17 In18 In19
🖳 🗹 Limit Y-	4 [No	Low		
	4	No	Low		
Z axis	Port number	Invert	Value now	Hot Key	
🖳 🗹 Limit Z+	5	No	Low		
🖂 Limit Z-	5	No	Low		Low Active

Set the input port numbers according to the configuration of the machine and the CNC controller. Save the settings.

11.4.1. Input port diagnostics

DrufelCNC - software for controlling CNC machines. Read more: https://drufelcnc.com

This panel displays the current state of the controller input ports.



A red LED indicates I there is no signal on the input port. A green LED indicates I signal is present on the input port.

11.4.2. Hot keys

In order to set your hot keys, you need to click on the Hot Key column of a specific input port.

🖉 Settings					– 🗆 ×
Common 🛃 D	evice controlle	er 🔝 Axe	es settings 🕘	Input Ports	Output Ports 5pindle And Machine size
Name	Port number	Invert	Value now	Hot Key	Hotkey settings
Main Input Ports	Port number	Invert	Value now	Hot Key	↑ Ctrl + Δ Use default keys
Emergency stop	1	No	Low	Press the key	Use global hotkeys
Smooth stop	0	Νο	Low	None	
Pause	0	Νο	Low	None None	
Start	0	No No	Low	None None	

Next in this field you must specify your keyboard shortcut that you want to use.

Settings					- 0	>
Common 🛃 D	evice controller	Axe	s settings 🛨	Input Ports	Output Ports 🕂 Spindle 🙏 Machi	ne siz
Name	Port number	Invert	Value now	Hot Key	Hotkey settings	
Main Input Ports	Port number	Invert	Value now	Hot Key	↑ Ctrl + Δ ^{Use default ke}	eys
Emergency stop	1 [No	Low	Alt + E	Use global hot	tkeys
Smooth stop	0 [No	Low [None		-
Pause	0 [No	Low [None		ini i
Start	0 [No	Low [None		
Probe	2 [No	Low			
X axis	Port number	Invert	Value now	Hot Key	Input port diagnostics	
🗹 Limit X+	3 [No	Low		In0 In1 In2 In3	
🗹 Limit X-	3 [No	Low		In4 📕 In5 📕 In6 📕 In7	
Home X	3 [No	Low		In8 In9 In10 In11	
Y axis	Port number	Invert	Value now	Hot Key	In12 In13 In14 In15	
🖂 Limit Y+	4 [No	Low		In16 In17 In18 In19	
🖳 🗹 Limit Y-	4 [No	Low			
- Home Y	4 [No	Low			
Z axis	Port number	Invert	Value now	Hot Key		
🗹 Limit Z+	5 [No	Low		In28 In29 In30 In31	
Limit Z-	5	No	Low		V Low Active	

«Use global hotkeys» - this function in which if the DrufelCNC window is not active, then hotkeys will still go to DrufelCNC.

«Use default hotkeys» - this function for hotkeys will work according to the following list:

Default Hotkey Info		×
	Default hotkeys	
Esc F1 F2 F3 F4 F5 F	F8 F7 F8 F9 F10 F11 F12	Print Scroll Scroll Fause SysRq Lock Break Lock Lock
$ \begin{array}{c c} & & & & \\ \hline \\ \hline$		Insert Home Page Dub Page Detete Page To Page
	M C C Ctri	↑ ↓ <p< td=""></p<>
Emergency stop	RStart	[▶] Spindle On/Off
Smoth stop		Spindle Speed +10%
→ Jog X++	Jog Z++	Spindle Speed +10%
← Jog X	Page Jog Z	Spindle Speed -10%
Jog Y++	End Jog A++	Jog Speed +100
↓ Jog Y	Insert Jog A	Jog Speed -100

Attention! Custom shortcuts take precedence over the default keys.

11.5.Configuring output ports

To configure output ports, click the Output Ports tab.

Settings						_	
Common 🛃 De	evice controlle	er 🛴 Axe	es settings 🔶	Input Ports	rts Spindle	-	Machine
Name	Port number	Invert	Value now				
Spindle Output Ports	Port number	Invert	Value now				
🖂 Turn the spindle	1	No No	Low				
	2	No No	Low				
Spindle anticlock	3	No No	Low				
Cooling Output Ports	Port number	Invert	Value now				
Cooling	4	No No	Low				
Additional cooling	5	No No	Low				
Enable axles Output Ports	Port number	Invert	Value now				
Enable X axle	0	No No	Low				
Enable Y axle	0	No No	Low				
Enable Z axle	0	No No	Low				
Enable A axle	0	No No	Low				
Enable B axle	0	No No	Low				
	0	□ No	Low				

Set the output port numbers according to the configuration of the machine and the CNC controller. Save the settings.

11.6.Spindle adjustment

To configure the spindle parameters, you need to go to the "Spindle" tab.

Settings	—		\times
Common Device controller 🔛 Axes settings 🔶 Input Ports 🕞 Output Ports		Machine s	size
Spindle specifications Direction of rotation of the spindle			
Spindle speed (rpm) 6000 Counterdockwise			
Acceleration (rpm/10ms) 50 Clockwise			
Spindle coefficient			
Output signal (0.0 - 1.0) 1 Speed signal multiplier			
Apply Save	X	Cancel	

Set the speed and acceleration parameters according to the spindle

specification. Set the default spindle rotation direction.

Set the spindle coefficient. Save the settings.

6000

Spindle speed

Spindle speed (rpm) -- the nominal number of revolutions per minute

for your spindle.

Acceleration



- when the spindle is turned on, the spindle

rotation speed will be smoothly set in accordance with the specified acceleration.

Spindle coefficient



speed signal multiplier - if you need to calibrate the output value

of the port 0-10V then change this multiplication factor.

With this Counterclockwise/Clockwise setting,



you can set the direction of rotation of the spindle when you press the «Turn

the spindle» window.

11.7.Machine size

With these settings you can customize the machine dimensions, soft limits, home function.

P Settings		- 🗆 X
Common Device controller	Axes settings 🔶 Input Port	s 🕒 Output Ports 🕅 Spindle 🚜 Machine size
Size axis X Axis minimum, mm Axis maximun, mm Axis maximun, mm 300	Soft Limit for X axis Use for Safe, slow, mm Min Max 10	Home X-axis function Home direction Home order Speed, mm/min To max To max To max Home order Speed, mm/min
Size axis Y Axis minimum, mm Axis maximun, mm Axis maximun, mm 400	Soft Limit for Y axis Use for Safe, slow, mm	Home Y-axis function Home direction Home order Speed, mm/min To min To max 7 2 2 300 +
Size axis Z Axis minimum, mm Axis maximun, mm Axis maximun, mm 200	Soft Limit for Z axis Use for Safe, slow, mm Min Max 10	Home Z-axis function Home direction Home order Speed, mm/min To max To max 3 2 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3
Size axis A Axis minimum, mm Axis maximun, mm Axis maximun, mm I 100	Soft Limit for A axis Use for Safe, slow, mm Min Max (10) •	Home A-axis function Home direction Home order Speed, mm/min To min To max To max 4 (2010) 300
Size axis C Axis minimum, mm Axis maximun, mm Interpretation Axis maximun, mm	Soft Limit for C axis Use for Safe, slow, mm Min Max 10	Home C-axis function Home direction Home order Speed, mm/min To min To max 6 300 +
Apply		Save Cancel

11.7.1. Size axis

Set the min / max limits for your machine.

Attention! The limits are specified in machine coordinates. The difference between the min and max should be the actual axis length of your machine.



According to these settings in the 3D model window, the dimensions of the axis will be displayed as a quadrilateral in each plane.



11.7.2. Soft limit

DrufelCNC - software for controlling CNC machines. Read more: https://drufelcnc.com

If you want the tool to stop when it reaches the minimum and maximum of your axis, use the appropriate constraints. These settings are designed to not damage your machine.

Soft Limit for X axis Use for Safe, slow, mm
Min 10 📩
Soft Limit for Y axis Use for Safe, slow, mm
Min 10 🛉
Soft Limit for Z axis Use for Safe, slow, mm
Min 10 🛉
Soft Limit for A axis Use for Safe, slow, mm
Min 10 🛉
Soft Limit for C axis Use for Safe, slow, mm
Min 10 Max 10

will stop and prevent it from moving towards the minimum.

Image → When the maximum limit of your axis is reached, the tool will stop moving and prevent it from moving towards the maximum.

if the specified value remains before reaching the minimum or maximum, the tool speed is reduced to the minimum.

Safe, slow, mm

11.7.3. Home function

With these settings you can set the driving direction, priority and speed.



These settings are for buttons **Real Real Real OF State** on the main window.

• when searching for the home position, the instrument will move to the minimum.

• when searching for the home position, the instrument will move to the maximum.

Attention! If you have turned on both the "To min" and "To max" settings, then when searching for the home position, the instrument will first move to the minimum and then to the maximum.

- allows you to specify the order in which the search for the home position is performed for each axis.

home order = 1 will be executed very first.

Speed, mm/min

home order = 6 will be executed most recently.

12. Run the control program (G-code)

To run the control program in the language of G-code, you must click on the

button with the image of the folder *w*, then select the file.

If the file is recognized successfully, the three-dimensional model of the file will be displayed in the right part of the main window.



DrufelCNC - software for controlling CNC machines. Read more: https://drufelcnc.com

13. Search tool zero

To begin searching for a tool zero, set the height List of the probe

used. Next, click

. Wait until the end of the process.

First you need to configure the input port number for the probe. The Z axis is assigned according to the value found and the height of the probe.

After completing the tool zero search, the tool will return to its original position.

To cancel the tool zero search, click



For the tool zero search to work correctly, you must set the input port number in accordance with the port number on the controller where your probe is connected. Set "Invert" so that the "Value now" in the normal state of the Probe is "Low".

🔯 Common 🛃	Device controlle	r IČ	👌 Ахе	es set	tings 🕣		Input Ports	🕞 Out	put Po	rts 打	Spindle		Machine	e siz
Name	Port number	Invert		Val	ue now	Ho	: Key			Hotkey se	ttings			_
Main Input Ports	Port number	In	vert		Value now		Hot Key		^	Ctrl	+ Δ	🗹 Use de	efault key	s
Emergency stop	Í	🗹 Ye	55		Active		None			Our	· <u> </u>	🗌 Use gl	obal hotk	eys
	0	D M	,		Low		None							-
Pause	0	n M	,		Low		None							ā
- Start	0	□ Nc	,		Low		None					<u>15</u>		
🗹 Probe	2	No.)		Low								03	-
(axis	Port number	In	vert		Value now		Hot Key			-Input port	: diagnosti	cs	_	_
···· 🗌 Limit X+	3	🗹 Ye	5		Active					InO 📕	In1 📕	In2	In3	4
Limit X-	3	🗹 Ye	5		Active					In4 📕	In5 📕	In6 📕	In7	
Home X	3	🗹 Ye	5		Active					In8 📕	In9 📕	In10 📕	In11	
' axis	Port number	In	vert		Value now		Hot Key			In12 📕	In13 📕	In14 📕	In15	
···· Limit Y+	4	🗹 Ye	5		Active					In16 📕	In17 📕	In18 📕	In19	
Limit Y-	4	🗹 Ye	5		Active					In20 📕	In21 📕	In22 📕	In23	
Home Y	4	🗹 Ye	5		Active					In24 📕	In25	In26	In27	
Z axis	Port number	In	vert		Value now		Hot Key			In29	In20	In20	In21	
Limit Z+	5	🗹 Ye	5		Active						1115.2	1130	1131 –	2
Limit Z-	5	V Ye	5		Active				×	Lo	Ψ	Activ	'e 📃	

DrufelCNC - software for controlling CNC machines. Read more: https://drufelcnc.com

14. Manual control

	Manu	ual speed mn	n/min
\bigcirc	×	500	< 🖄
X1		X10	X100

sets the speed of movement of the

instrument during manual operation.

12				х	
u	N	Δ.	. 1	41	VI.
R.	0	0	1	C	
X	3	v	0	y	1
	-		~	•	

This field

- Speed reduction button.

- Speed increase button.

- **X1** 1% of the set speed or minimum speed.
- X10 10% of the set speed.
- **X100** 100% of the set speed.

The current speed is highlighted in green (x_{100}).

For manual control, press the corresponding joystick button



Spindle control and cooling 15.

- Spindle power button.
- Spindle off button.

To set the spindle speed, click on the progress bar area.



Button to increase the rotation of the spindle.

- Button to reduce the rotation of the spindle.



16. Assignment of coordinates





16.1.Measurement system

The default system of units is millimeters. To set the units in inches, click **INCH MM**. To set the system of units in millimeters, click **INCH MM**. The current coordinate system is highlighted in green.

16.2. Machine coordinates



The machine coordinates are the actual coordinates of your axes.

These coordinates are used to define the limits and dimensions of the machine. If machine coordinates are activated for display, they are highlighted in green <u>MACHINE</u>.

16.3.Work coordinates

WORK M	ACHINE	INCH MM
X	88.7	783750 🔺
ø	33.0	080000
Z	12.5	545625 🚊
А	12.8	871875 🚊

Work coordinates are relative to machine coordinates.

These are the coordinates at which the g-code is executed by default.

If work coordinates are activated for display, they are highlighted in green **WORK**.

17. Display 3D model

The code you downloaded is displayed as a 3D model on the right side of the application window.



To rotate the 3D model, move the mouse pointer to the display area of the 3D model. Right-click and hold to move the mouse pointer. You can also use



18. Opening HPGL files

To open files in HPGL format, you must click on the button with the image of

the folder, then select the file.

In the window that opens, you must select the parameters for converting HPGL to G-code.



After successful conversion, you will see a three-dimensional model of the file.

19. Basic parameters of the HPGL file converter



Machining plane $4 \rightarrow 3 \odot XY$ $4 \rightarrow 3 \odot XZ$ $4 \rightarrow 3 \odot YZ$	The plane in which the HPGL file will be executed.
Scaling: 1 HPGL unit = 0.025 (1/40 mm) ~	The scale corresponds to one HPGL unit per millimeter.
Moving speed, mm/min:	Tool travel speed without milling. Moving between milling areas.
Milling speed, mm/min:	The speed at which the tool moves when milling. Model milling speed.
Tool lifting, mm:	Tool position when moving to the milling area.
Lower tool, mm: -0.03	Tool position when milling the model.

19.1. Spindle settings of HPGL file converter



☑ Turn on and off the spindle	The spindle will turn on when the HPGL file starts executing, the spindle turns off when the HPGL file finishes executing.
Turn off idle (laser mode)	The spindle will only work when milling. This setting is suitable for laser or plasma operation.
Spindle speed: 24000	The spindle speed while executing the HPGL file. When using a laser, sets the laser power.
Direction of rotation: M04 Counterclockwise	The direction of rotation of the spindle is counterclockwise when executing the HPGL file. Corresponds to command M04.
Clockwise M03	The direction of rotation of the spindle is clockwise when executing the HPGL file. Corresponds to command M03.
Cooling: M08 M07	Cooling will be turned on before executing the HPGL file. Corresponds to commands M08 and M07.

19.2. Use step by step

With the help of "Use step by step" you can set up step-by-step milling (cutting) of models. This will reduce the negative impact on the cutter.



Begin with, mm:	After this axis position, the step milling algorithm will start. For
	example after $Z = 0.5$ mm.
Step, mm:	The cutter will move this distance after each cycle through the entire HPGL file. For example, 0.5 mm.
Last step, mm:	If necessary, you can set a fixed distance for the last step.

20. Generating a G-code from an image

To open a file in the format (png, jpeg, gif, bmp), you must click on the button with the image of the folder \mathbb{P} , or select the necessary file and transfer it to the G-code field.

In the window that opens, you must select the options for converting the image into a G-code.



In the engraving color interval block, you can adjust the color interval.

Engra	aving Color Interval

In the Image Sizes block, you can adjust the image size.

Image Sizes	
H.y	Image Width (mm) 20 Image Height (mm) 24.47552447!

la - proportional image resizing.

- not proportional image resizing.

In the Laser Settings block, you can configure the laser settings.









adjustment (mm)

- accelerated position adjustment (mm)



- engraving speed setting

21. Stepper motors

If your stepper motors don't rotate



Turn on Step Invert Step Invert



If you doubt the correct connection of ENA + ENA- then temporarily do not connect it. Make sure your motors spin. The default ENA port is activated on most stepper motor drivers.



DrufelCNC - software for controlling CNC machines. Read more: https://drufelcnc.com