



SINO GOOKII TECH CO.,LTD.

How to calibrate the tool

正确的关机流程：先关掉电脑。再关闭设备电源开关。以免数据丢失。

Please note that you should follow the correct shutdown process to avoid data loss: first switch off the computer, then turn off the device power switch.

对刀过程

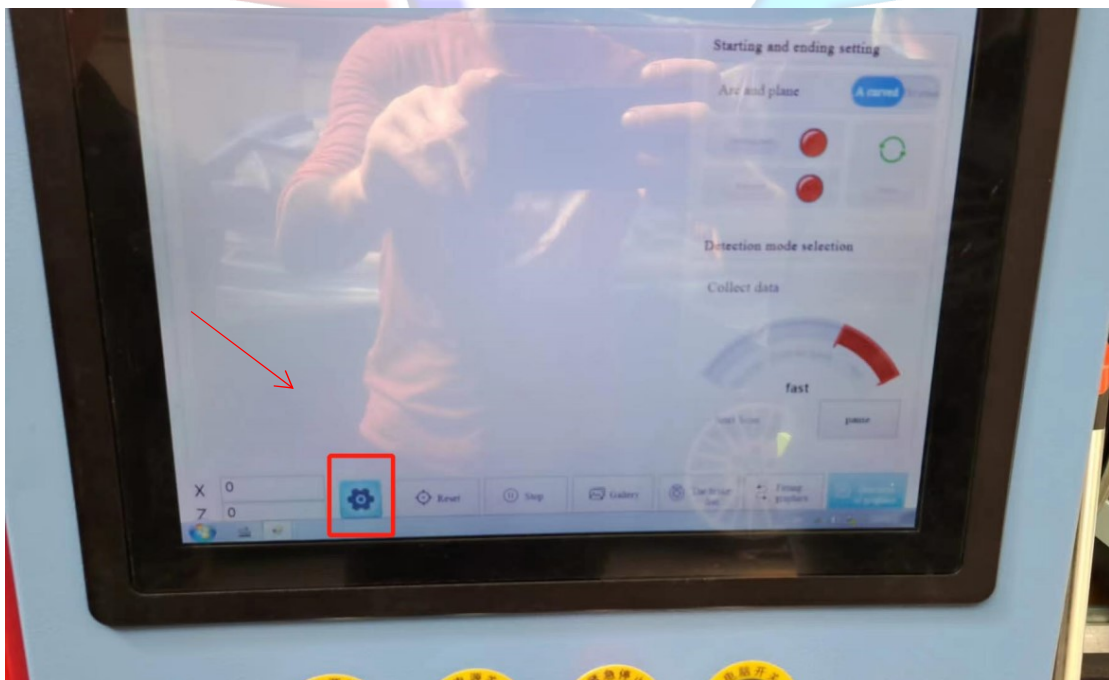
The Calibration Process

1. 贴胶带，在轮毂上面标注一个点：

Put tape on the rim, and then mark a point on the tape (any flat zone).

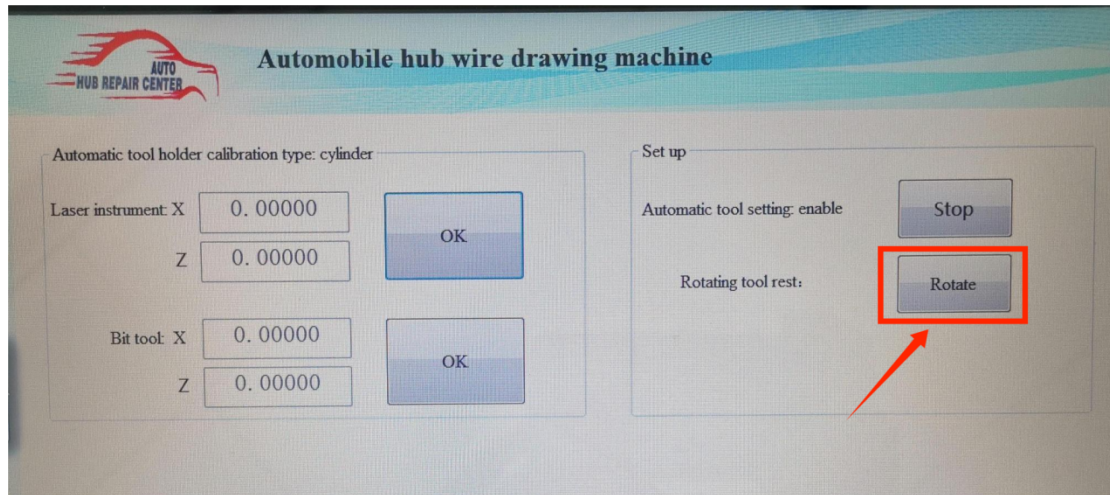
2. 点击屏幕上设置按钮：

Click the “**setting**” button  on the screen:



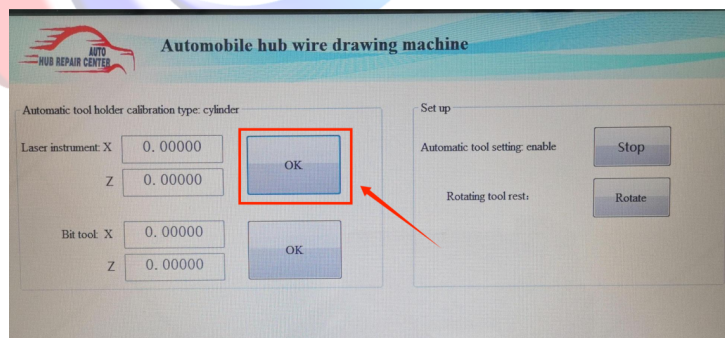
3. 点击旋转按钮两次:

Click the **"Rotate"** button two times;



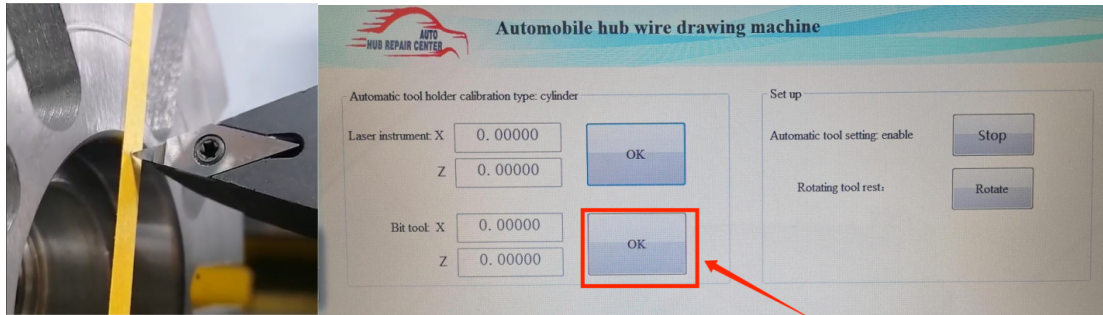
4. 调整激光点与我们标注点重合，激光器读数前两位为零，点击激光光头后面的“确定”按钮。

Adjust the laser point to coincide with the previous marked point, the first two digits of the laser reading are zero, then click the **"OK"** button behind the **"Laser instrument"**.



5. 移动刀尖与我们的标注点完全贴合，点击刀具后面的 确定。

Adjust the tool by the holding pulse wheel, the tip of the tool needs to be completely in contact with the marked point. Then click the **"OK"** button behind the **"Bit tool"**.

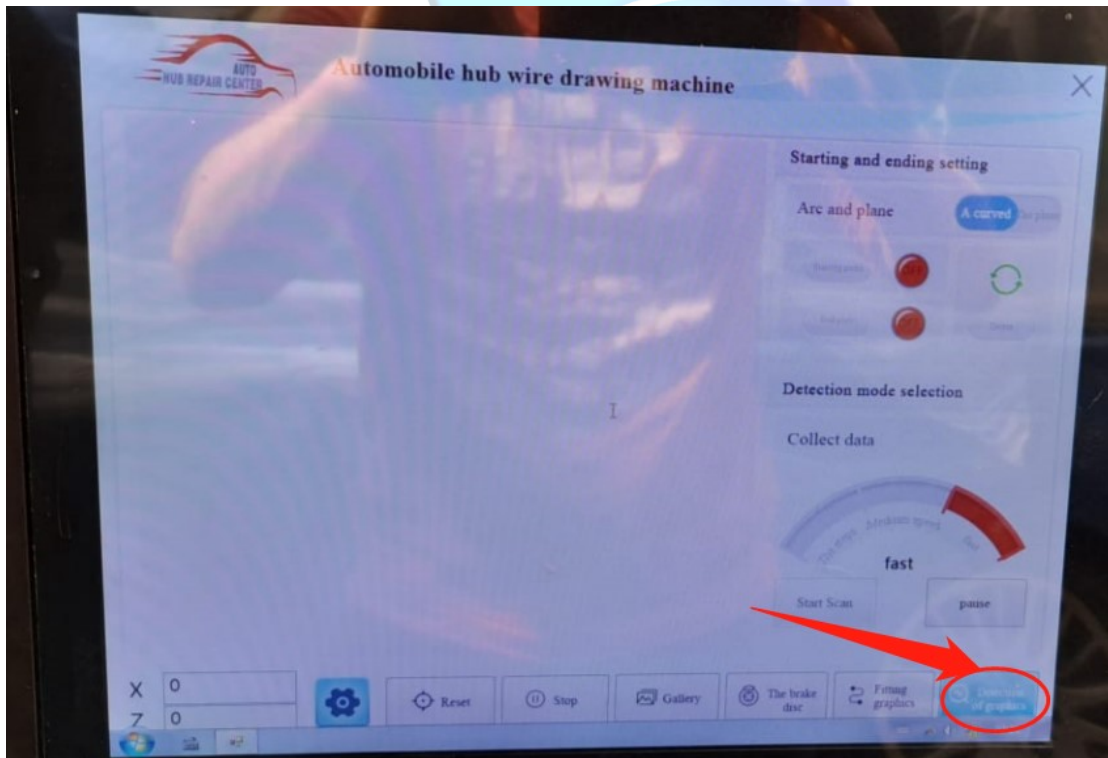


6. 校准完成，点击确定。

The calibration is completed, then click the **"OK" button**.

7. 点击探测图形，重新开始操作。

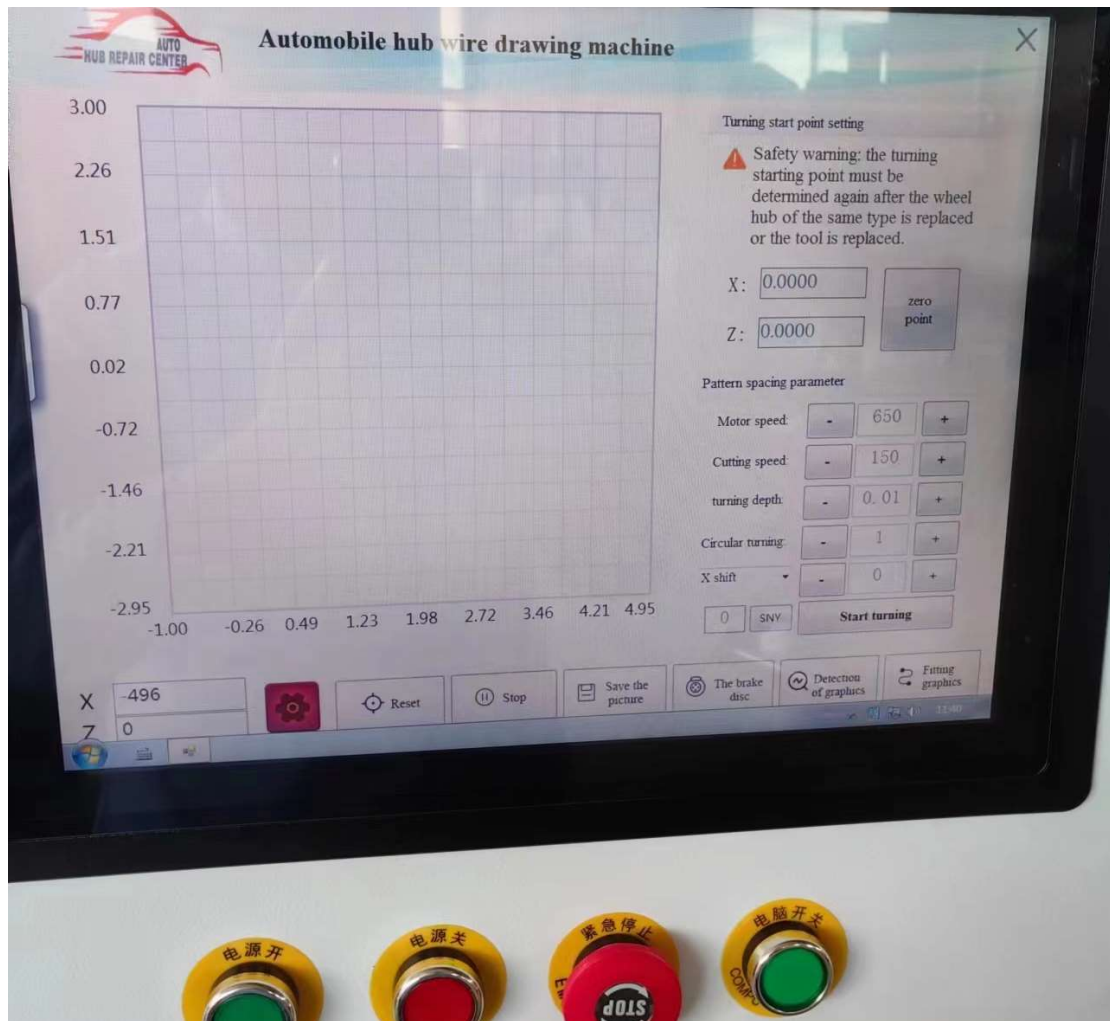
Click the **"Detection of graphics"** button. Start the operation again.





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How to set the CNC texture thickness



主轴转速 (Motor speed): 不用调整 (No need to adjust)

走刀速度 (Cutting speed): 第一次加工不需要调整 (No need to adjust for the first machining work)

调整规则: 数值越小, 纹路越细, 推荐在 100~150 内调整。(Adjustment rules: the smaller the value is, the finer the texture is. It is recommended to adjust from 100 to 150)



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削減厚度(turning depth): 第一次加工不需要调整 (No need to adjust for the first machining work)

调整规则: 第二次加工根据第一次切削的深度调整, 可按 0.01-0.1-0.15 的数值顺序调整 (**Adjustment rules:** When do the second processing, adjust according to the depth of the first cutting, which can be adjusted in the numerical order of 0.01-0.1-0.15)

循环次数 (Circular turning): 新手建议不调整 (Beginners are not advised to adjust)

偏移量 (X shift): 第一次需要根据轮毂形状调整 (It needs to be adjusted according to the shape of the hub for the first time)

调整规则 (adjustment rules):

1、如果轮毂的横切面为平面, 不用调整。(If the cross-section of the hub is flat, no need to adjust)

2、如果轮毂的横切面呈中心到边缘为爬升的形状, 调整为 **-0.5**。

(Adjust to -0.5 if the cross-section of the hub has a center-to-edge climbing shape)



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About the machinery lubricating oil

当机器发出蜂鸣声，并且如图所示区域的数字开始闪烁，才需要加注机械油。

(When the machine beeps and the numbers in the area shown in the picture start to flash, it is necessary to add the machinery lubricating oil.)

建议机械油标号为：**32#机械油**。

The machinery lubricating oil recommended is: **32# machinery lubricating oil**)

15#机械油也可，但是需要每三个月定期更换。

15# machinery lubricating oil is also OK, but it needs to be replaced every three months.

