



### PCD:

PCD programming and recall are only operational in incremental mode.

Press MODE and the PCD number used is displayed on the keyboard display. PCD number 0-4 are full circles. PCD 5-9 can be programmed as part circles by entering the start angle for the first hole and the angle between the first and the last hole as well as the number of holes. Programming a positive angle the hole pattern will advance CW. Programming a negative angle will advance the hole pattern CCW.



### PCD programming:

Press MODE then P on the keyboard. The light above the P key will light up. Enter the PCD number to be programmed on the keyboard (1-9). Press E to enter.

PCD 0-4: The X axis display will show r A d I U S. Enter the radius of the PCD circle and press E to enter. The X axis display will change to A n G L E. Enter the angle for the first hole calculated from Y 0.00 on the X+ axis. Press E to enter. The X axis display will change to H O L E S. Enter the number of holes and press enter. The light above the P key goes out and the program is complete.

PCD 5-9: The X axis display will show r A d I U S. Enter the radius of the PCD circle. The X axis display will change to A n G S t r t. Enter the angle of the first hole. The X axis display will change to A n G E n d. Enter the angle difference between the first and the last hole. A negative angle rotates the hole pattern CCW. A positive number rotates the hole pattern CW. The X axis display changes to H O L E S. Enter the number of holes. The light above the P key goes off and the program is complete.



### PCD recall:

Position the X and the Y axis at the centre of the PCD circle. Zero the X and Y axis.

To recall a previously programmed PCD press MODE then R. The light above the R key lights up. Enter the PCD number (1-9) on the keyboard. The X axis will display r A d I U S and the keyboard display will show the previously programmed value. Press E to advance to the next value. For PCD 0-4 the X axis will show A n G L E and the keyboard display will show the value. For PCD 5-9 the X axis will show A n G S t r t and the keyboard display will show the angle for the first hole. Press E to advance to the next value. The X axis will show A n G E n d and the keyboard display will show the difference angle between the first and the last hole. Press E to advance to the next value. The X axis display will show H O L E S and the keyboard display the number of holes programmed. Press E to display the coordinates for the first hole. Traverse the X and The Y axis until both axes display zero. Machine the part with the Z axis. Press E to advance to the next hole. Repeat these steps until the last hole has been machined. Press E and the light above the R key goes off. The X and Y axis displays show the distance to the centre point of the PCD circle.

