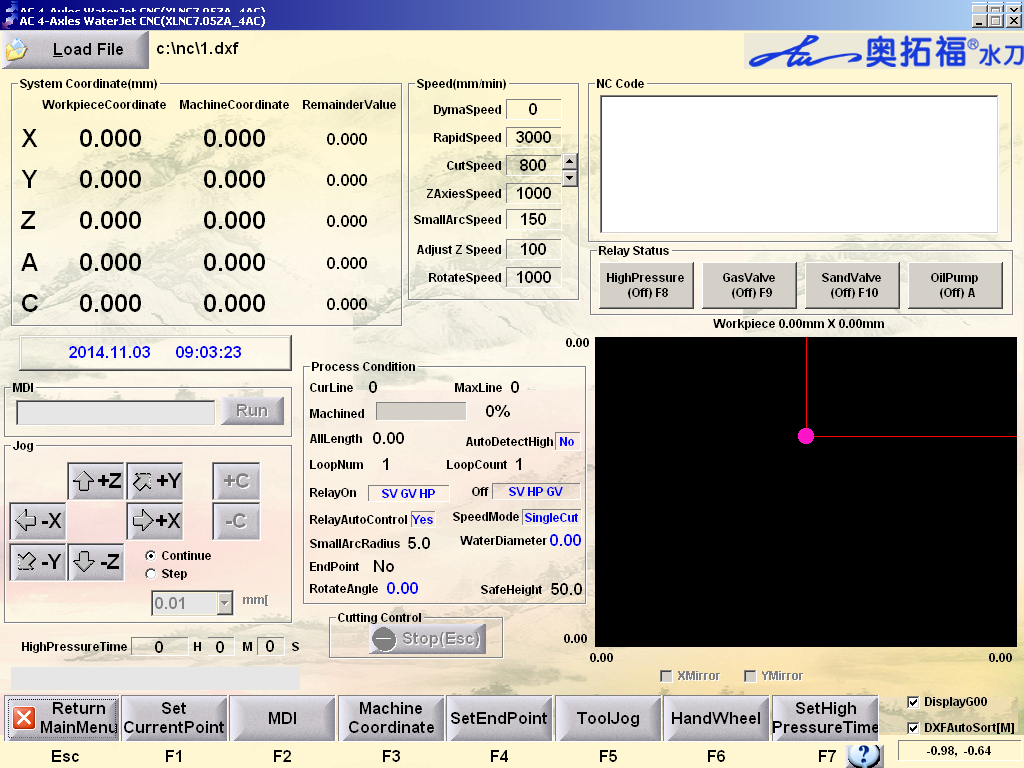
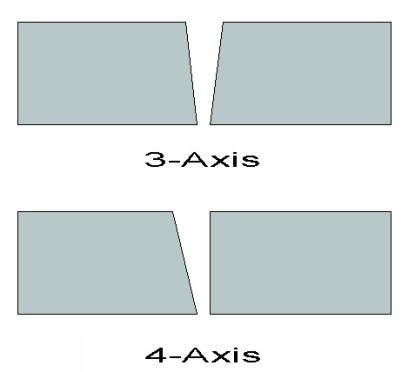
**How to adjust 4-axis cutting head**

1. **Description:**

4-axis is used to compensate the cutting angle showing in below picture:

**1 to 3 degree**





A-axis is angle axis. (0-45degrees)

B-axis is rotation axis. (0-360degrees)

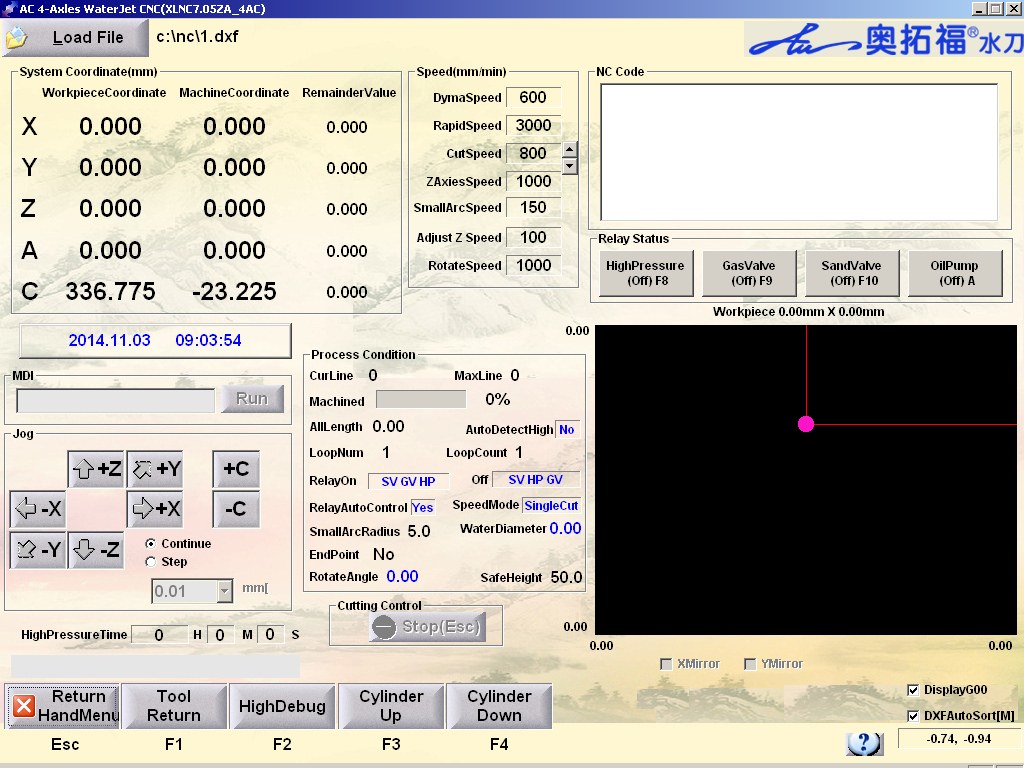
1. **Adjust 4-axis cutting head:**

**Step 1: Align the cutting head. Make sure it is straight up and down.**

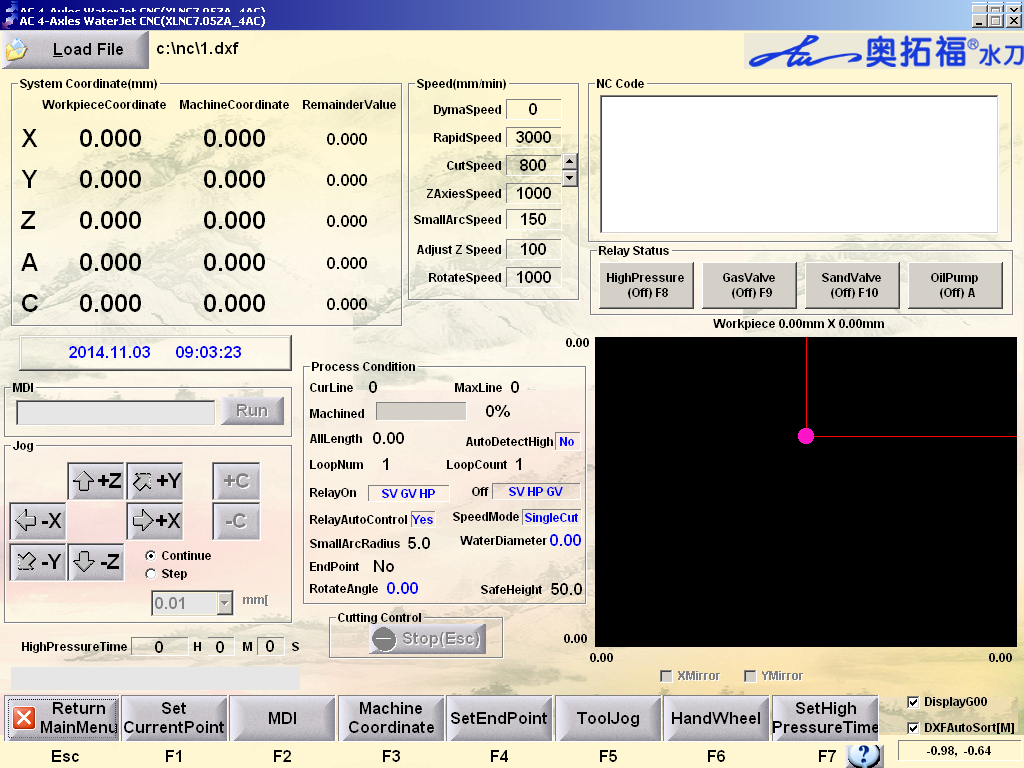
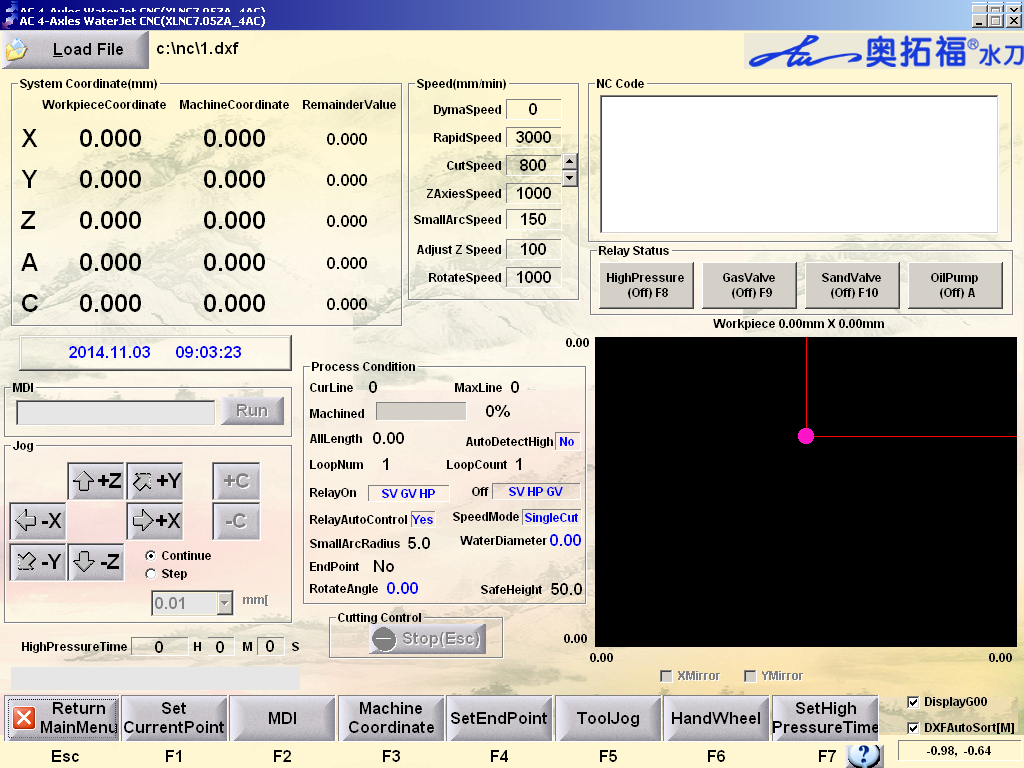


**Step 2: Return C-axis to “Original Point”:**

Click “F3 JOG” “F5 Tool Jog” “F1 Tool Return”. (Now C-axis will automatically rotate back to 90 degrees.)

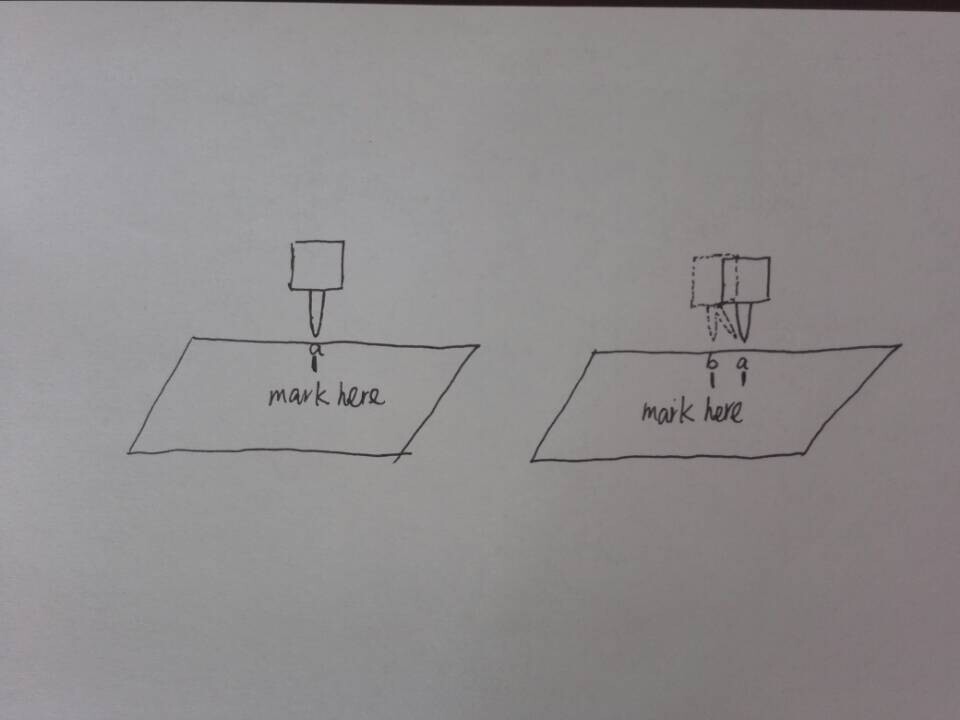


Click “MDI”. Input “C0”(C-axis Zero), and click run.

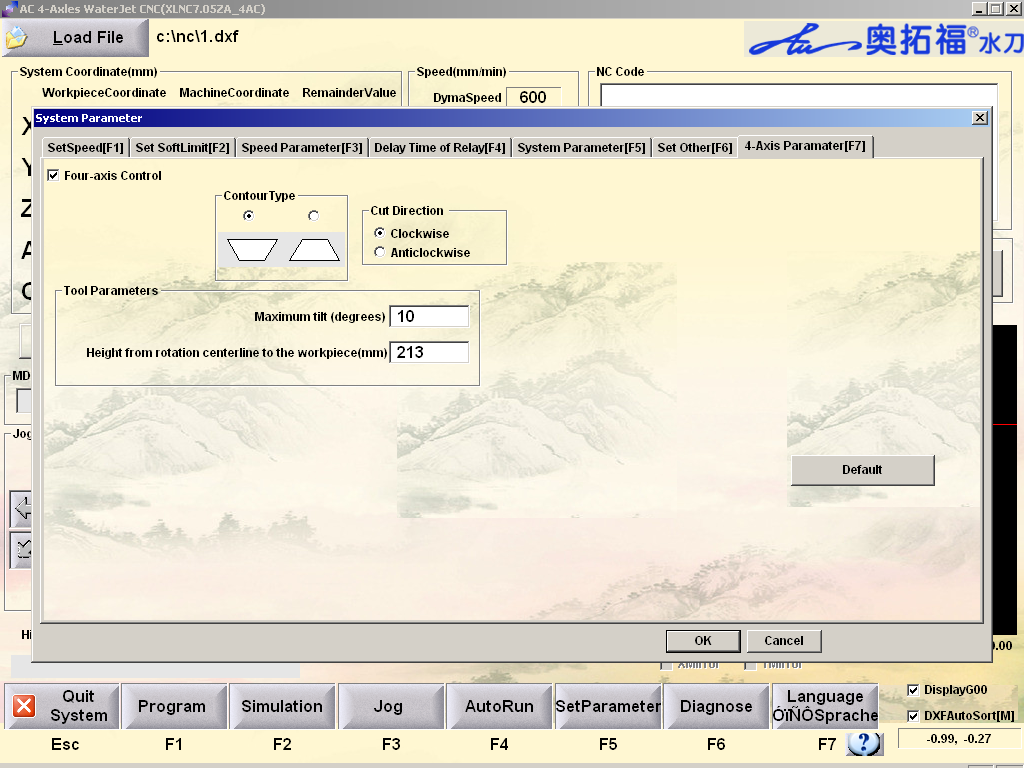
 

**Step 3: Adjust 4-axis to 20 degrees:**

1. Put a plate below the cutting head. Mark the current point of the cutting head on the plate (point “a”).



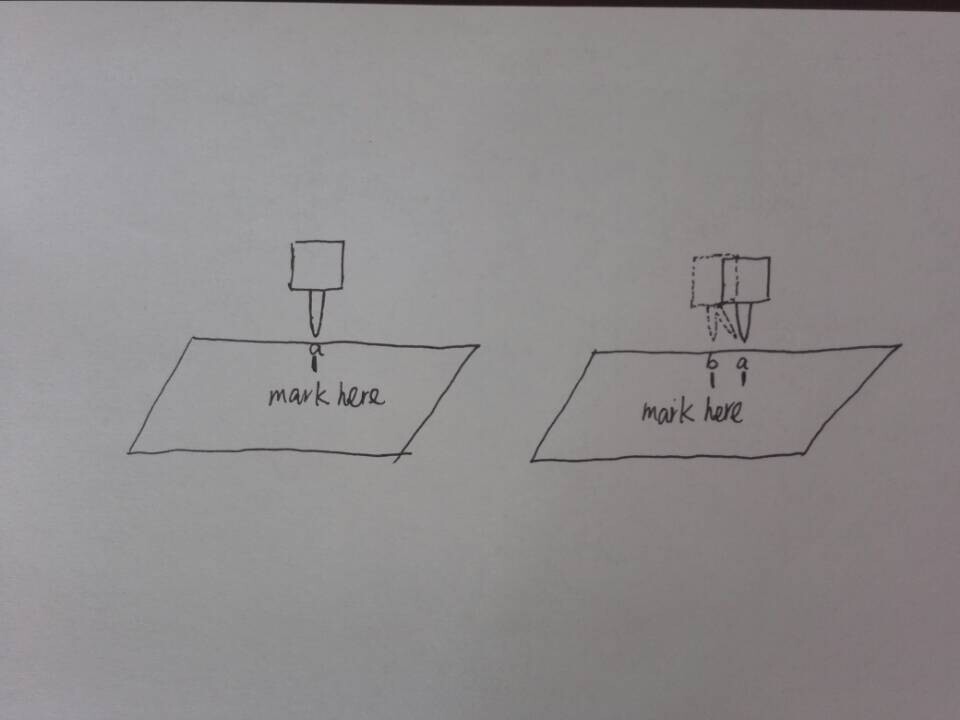
1. In the software, click “F5 Set Parameter” “ F7 4-Axis Parameter”



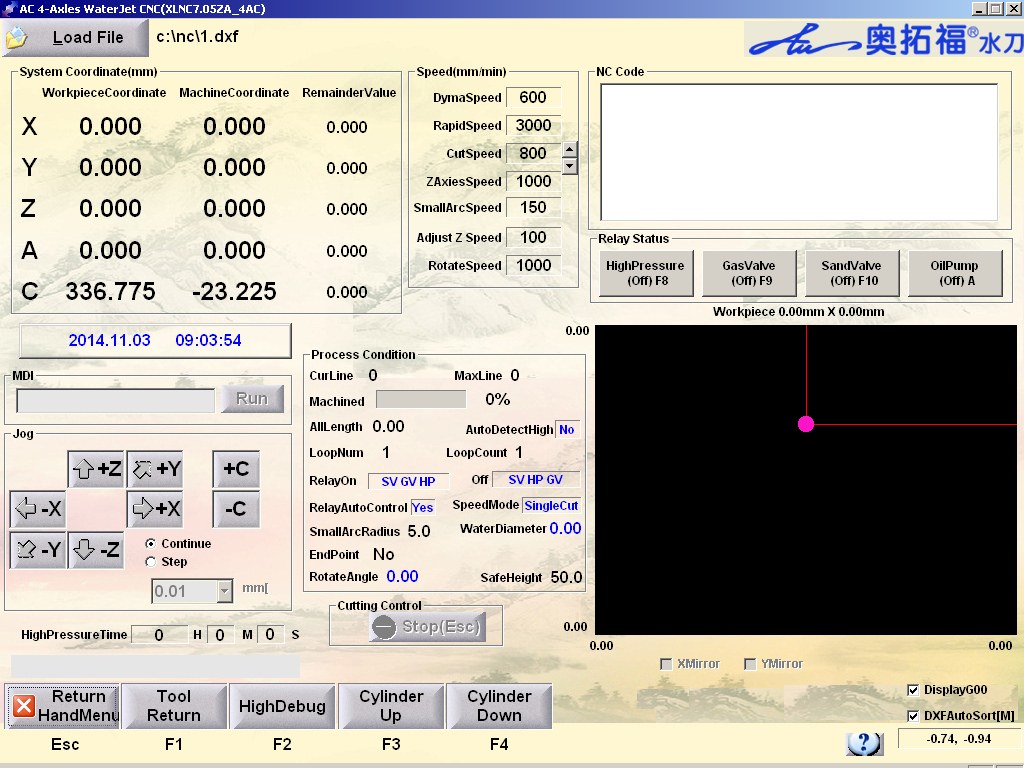
Change “Maximum tilt (degrees)” to “20”

Change “Height from rotation centerline to the workpiece” to “193”

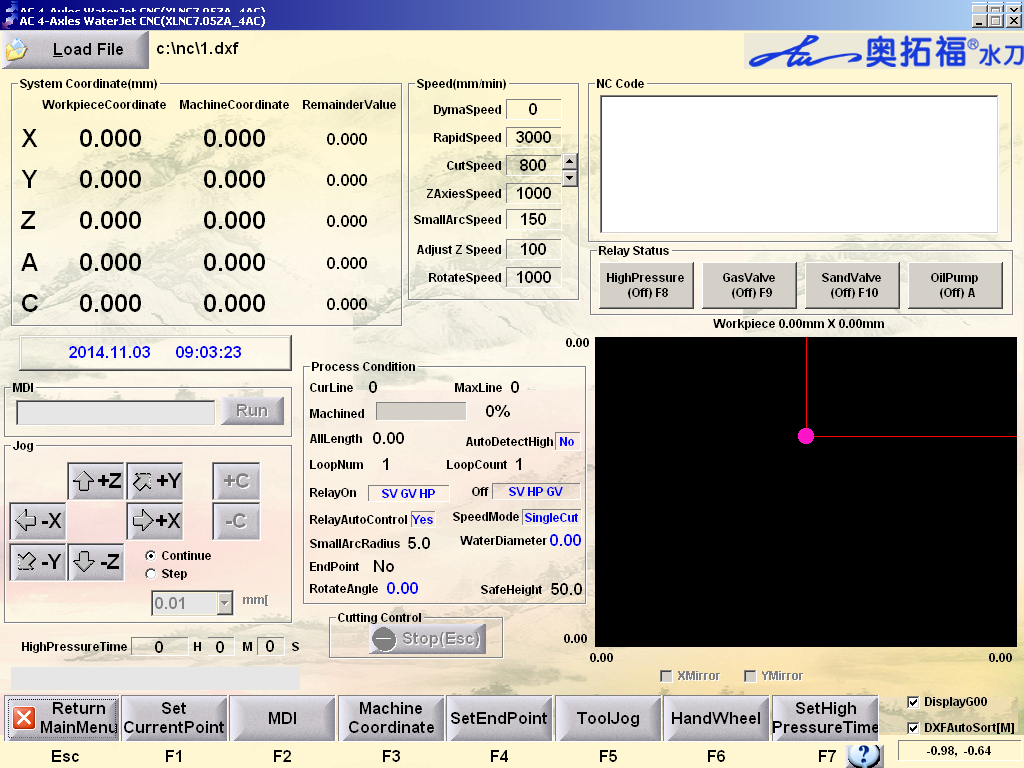
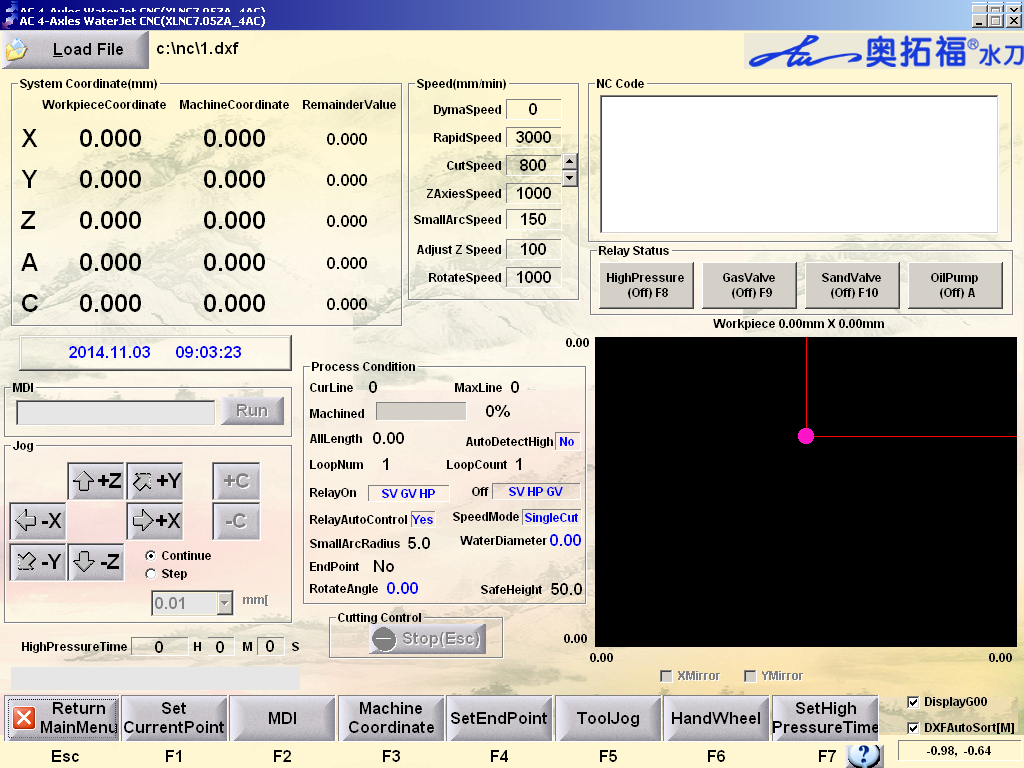
1. Go to “MDI”. Input “A20” and click run. Then the cutting head will move X-axis to a new position to compensate. Mark the new point of the cutting head on the plate (Point “b”).



1. Manually adjust the cutting head to “Point a” and tighten the cutting head.
2. Then you may found the cutting head is a little bit off from X-axis side.In the software, Click “F3 JOG” “F5 Tool Jog”. Then Click “+C” or “-C” to turn the cutting head to point at “Point a”, both on X-axis side and Y-axis side.



1. In the software, Click “F1 Set Current Point”. Change “C coordinate” to Zero.

1. If you need to adjust A-axis to 2 degrees or any other degrees you need, do again “2”, “3”, “4” steps above.
2. Now you can start to cut with 4-axis. If you want to change back to cut with 3-axis, just simply adjust the cutting head back to “Point b”, and close 4-axis Control in Parameter. You don’t need to change any other settings.