

MYSWEETY
CNC ROUTER 3018-PRO

USER MANUAL







Contents

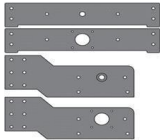






Part 1: Package List----- **2**








Part 2: Assembly Instruction----- **6**










Part 3: Debugging----- **22**

Part 1: Package List

Name	Size	Picture	Qty
Aluminum profile	2040*290mm		2
	2020*360mm		2
	mesa		1
Linear axis	10*360mm		2
	10*290mm		2
Lead screw	T8(365mm)		1
	T8(295mm)		1
ER11 and Holder			1

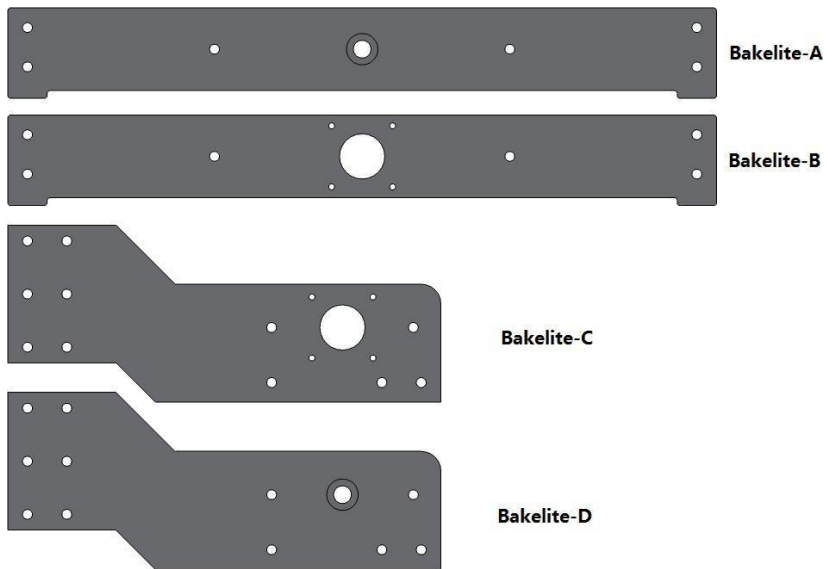
Name	Size	Picture	Qty
Phenolic resin plate			4
Stepper motor			2
Spindle			1
X-Z axis assembly			1
Slider			4
Nut seat			1
Milling cutter			10

Name	Size	Picture	Qty
Copper chuck			2
4P motor line			3
Spindle motor line			1
24V power supply			1
Control board			1
USB cable			1
Plate clamp			4


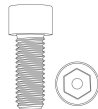

Name	Size	Picture	Qty
Cable tie			5
CD			1
Set screw	M3		8
	M4		8
Allen wrench	1.5mm, 2.0mm, 2.5mm, 3.0mm, 4.0mm		5
Bolt	M5*16		32
	M5*10		14
	M3*14		8
	M4		1
Copper nut			2
Nut	20M5		16
	30M5		10
Spring			2
Coupling			2

Part 2: Assembly Instruction

Bakelite:

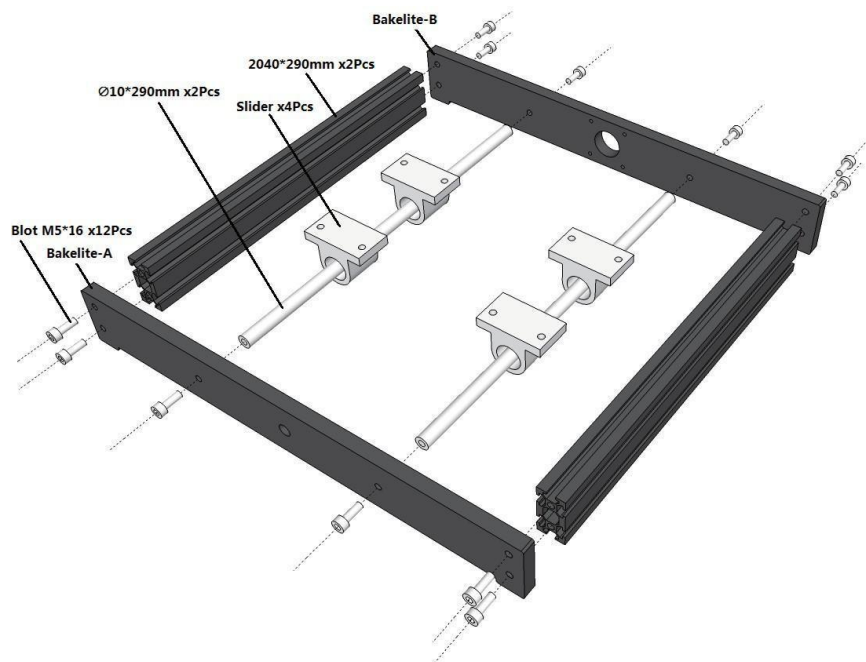


Tool:

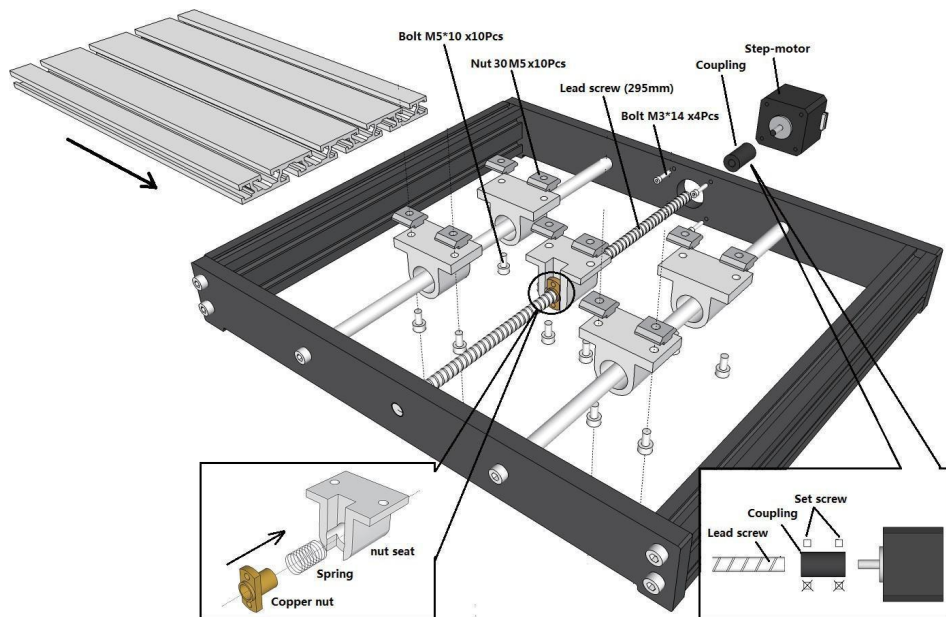
	Bolt	Set screw
		
1.5mm		M3
2.0mm		M4
2.5mm	M3	
3.0mm	M4	
4.0mm	M5	

Step 1

Base Assemble

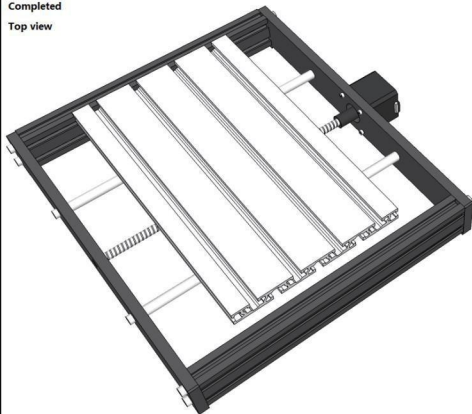


Step 2 Table Assemble

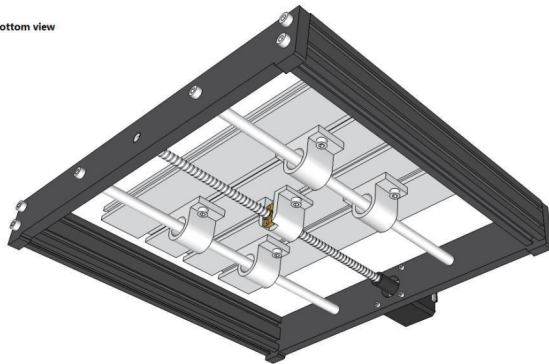


Completed

Completed
Top view

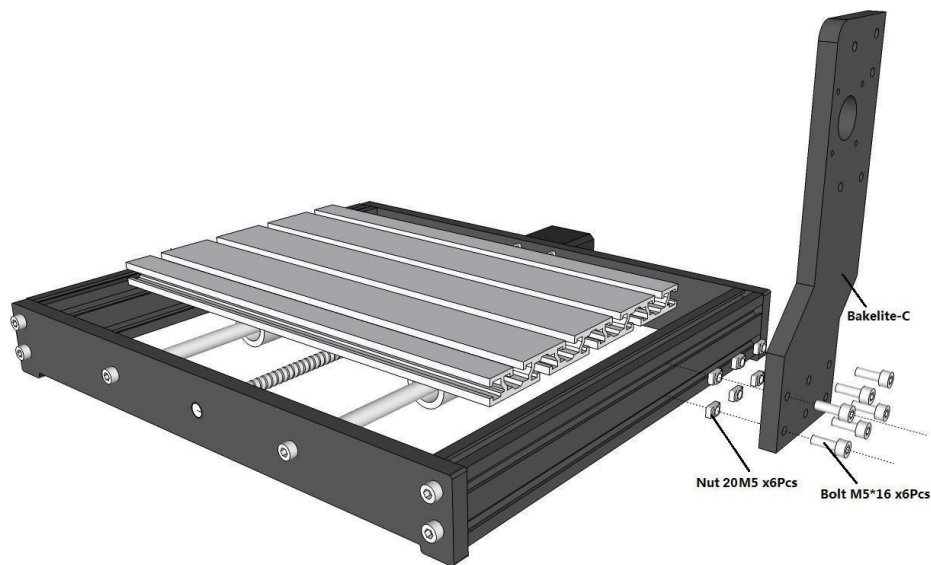


Bottom view

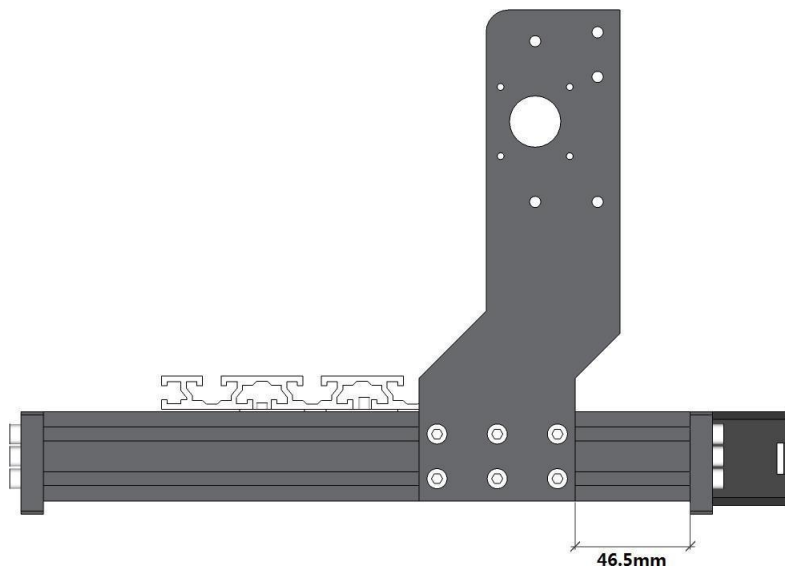


Step 3

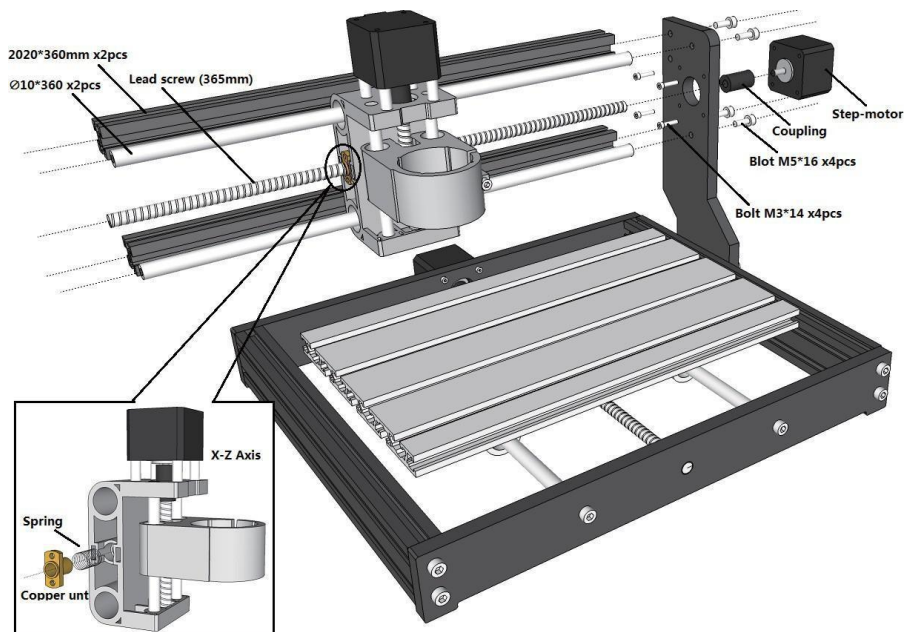
Base & Bakelite-C



Completed & Ubiety

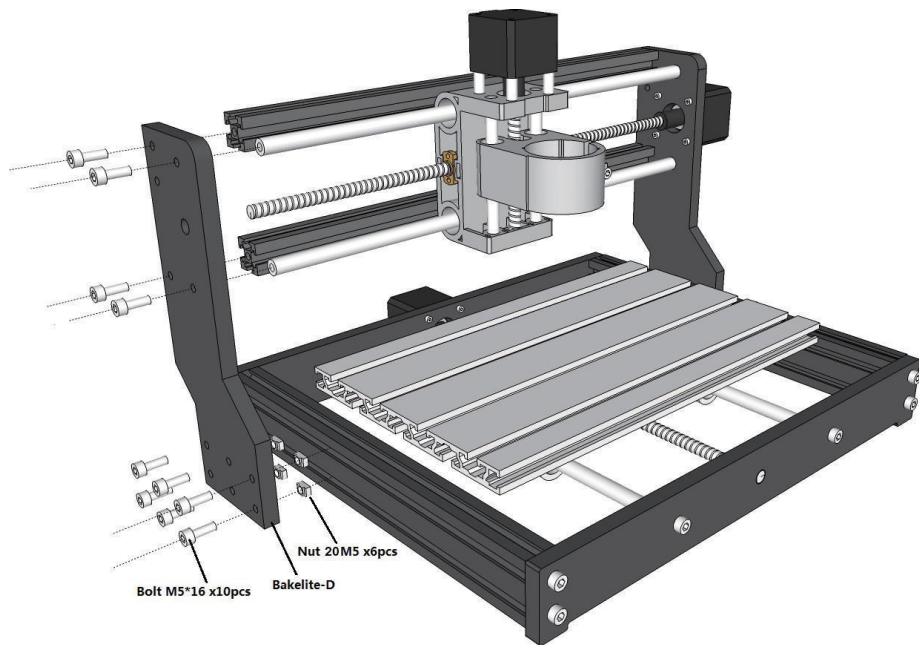


Step 4 X-Z Axis

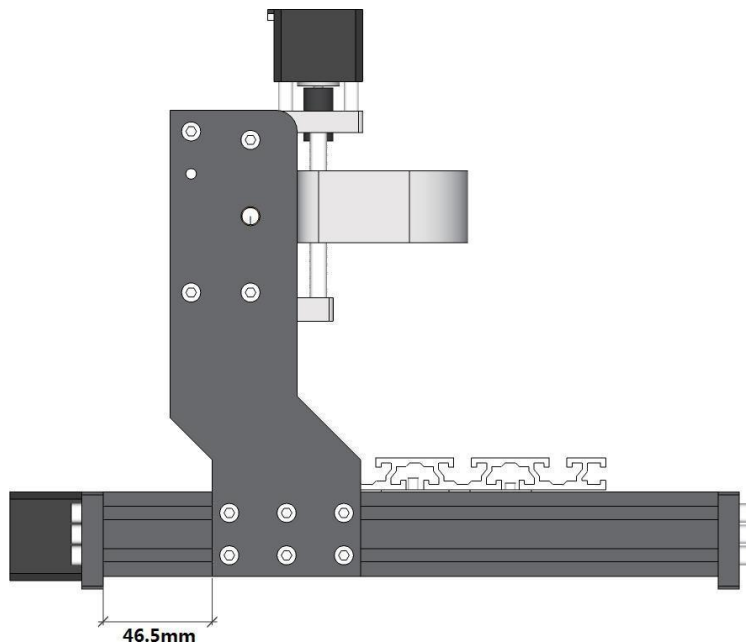


Step 5

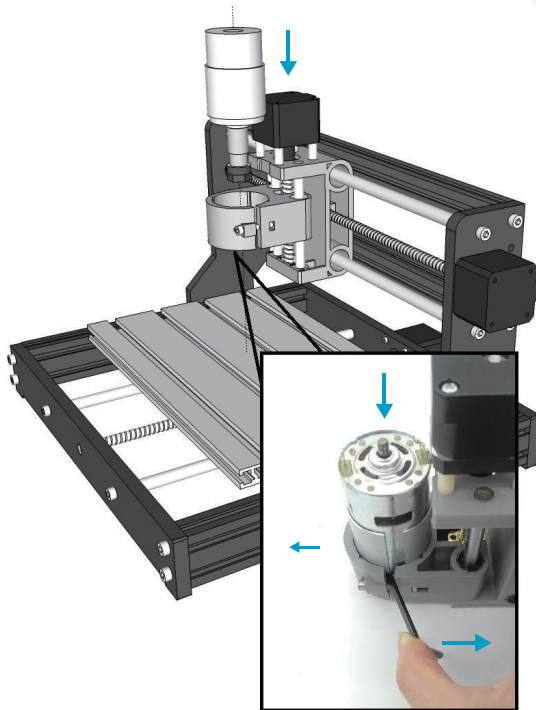
Bakelite-D

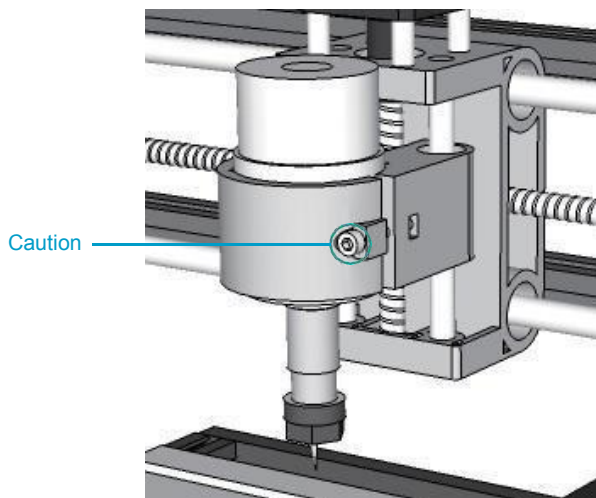


Completed & Ubiety



Step 6 Spindle

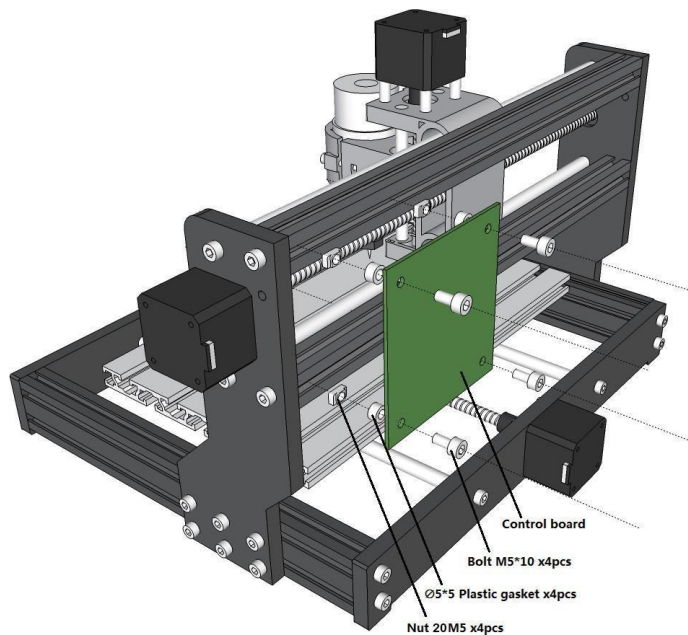




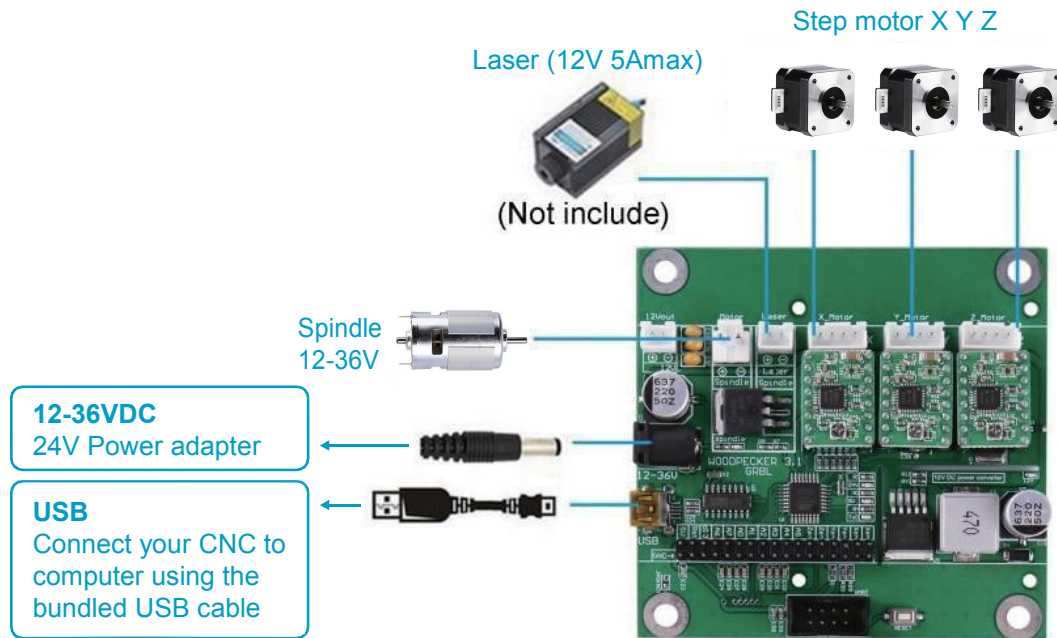
- Tighten the M4 bolt without using excessive force to prevent plastic damage.

Step 7

Control board



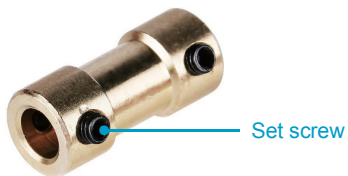
Step 8 Wiring diagrams



Step 9 Milling cutter installation

Copper chuck:

1. Screw the M3 set screws into the copper chuck.
2. Install the copper chuck into the motor and tighten the screws.

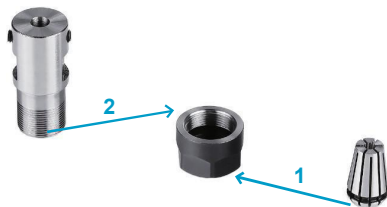


3. Install the milling cutter into the copper chuck and tighten the set screws.



ER11: Pre-installation

1. Install the ER11 into the ER11 extension rodholder.



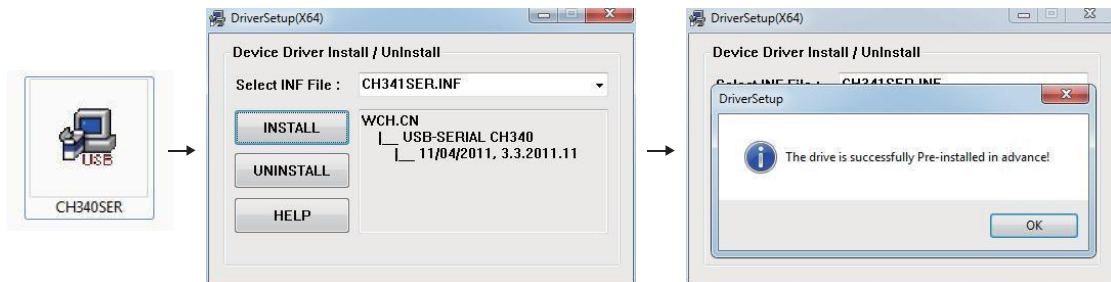
2. Install the ER11 extension rod holder into the motor. Generally, it's a little difficult to install.

Installation: The aperture is smaller than the actual 0.02mm. According to the high-frequency heating (300 degrees Celsius), thermal expansion and contraction principle, to expand the hole, then insert the spindle and lock it, and then fix the shaft collet after cooling completely.



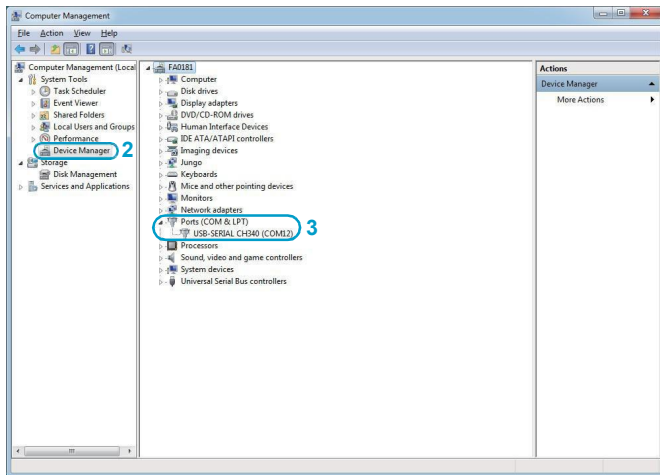
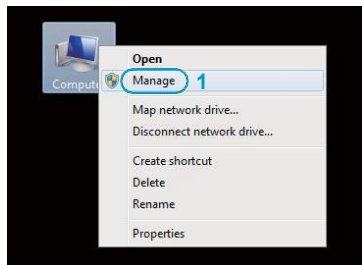
Part 3: Debugging

1. Install the driver (software → Driver → CH340SER.exe)

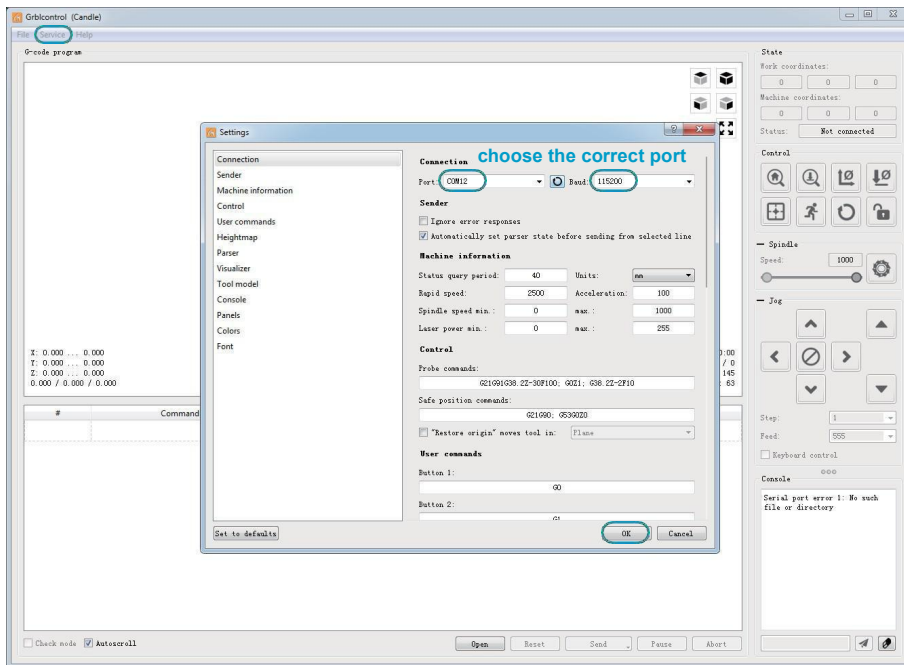


2. To Determine your Machine's COM port:

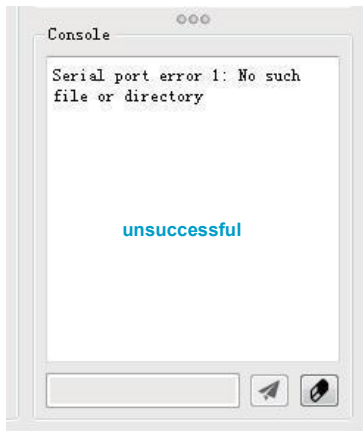
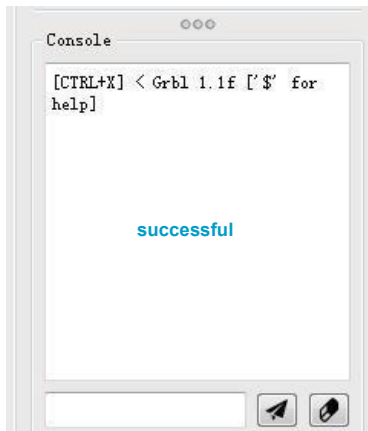
- Windows XP: Right click on "My Computer", select "Manage", select "Device Manager".
- Windows 7: Click "Start" → Right click "Computer" → Select "Manage" → Select "Device Manager" from left pane.
- In the tree, expand "Ports (COM & LPT)"
- Your machine will be the USB Serial Port (COMX), where the "X" represents the COM number, for example COM12.
- If there are multiple USB serial ports, right click each one and check the manufacturer, the machine will be "CH340".



3. Open Gbrlcontrol software(software → Gbrlcontrol → GbrlControl.exe)



- Console window print " [CTRL+X] < Grbl 1.1f ['\$' for help]" If the connection is successful.
- Console window print " Serial port error 1: No such file or directory " indicate that the connection is failed.



- Grblcontrol Use

The spindlespeed:

It does not represent the actual speed, and it represents the ratio. And this percentage is not linear.

$100 = 100/1000 \rightarrow 10\%$
 $1000 = 1000/1000 \text{ } 100\% \text{ max}$

spindle on/off

The X Y Z axis jog

The screenshot shows the Grblcontrol (Candle) application window. The main area displays G-code program text. On the right, there's a control panel with various buttons and sliders. A blue box highlights the 'Spindle' section, showing a slider set to 1000 and a gear icon. Another blue box highlights the 'Inc' section, showing directional arrow buttons. A third blue box highlights the 'Spindle' section again, showing the 'Speed' slider and the gear icon. The bottom of the window has a status bar with 'Check mode' and 'Autoscroll' checkboxes, and buttons for 'Open', 'Reset', 'Send', 'Pause', and 'Abort'.

- Tool settin

The screenshot shows the Gbrcntrl (Candle) software interface. A callout box highlights the jog controls and zeroing buttons. The jog controls include a central stop button and eight directional arrows. The zeroing buttons are labeled 'zero XY' and 'zero Z'. The software displays a 3D model of a milling machine and a G-code program.

Callout Box Content:

- spindle should be on when moving the bits
- zero XY
- zero Z
- Use the jog to move the milling cutter. Then click button zeroXY and zeroZ.

Software Interface Details:

- File Service Help**
- G-code program:**

```
[G0:00 G54 G17 G21 G90 G94 M5 M9 T0 F0 S0]
T/S: 0 / 0
```
- Coordinates:**
 - X: 0.000 ... 39.812
 - Y: 0.000 ... 10.300
 - Z: -0.200 ... 5.000
 - 39.812 / 10.300 / 5.200
- Machine Status:**
 - State: Idle
 - Work coordinates: 0.000 0.000 0.000
 - Machine coordinates: 0.000 0.000 0.000
 - Status: Idle
- Control Panel:**
 - Spindle Speed: 1000
 - Jog controls (directional arrows and stop)
 - Step: 10
 - Feed: 555
 - Keyboard control: ☐
- G-code Program Table:**

#	Command	State	Response
1	G90	In queue	
2	G1 Z5 F500	In queue	
3	G1 X0 Y0	In queue	
4	M03 S1000	In queue	
5	G1 X9.95 Y9.1	In queue	
6	G1 Z-0.2 F200	In queue	
7	G1 X9.8 Y9.1	In queue	
8	G1 X9.6 Y9.3	In queue	
- Buttons:** Open, Reset, Send, Pause, Abort

Annotations:

- Open the G-code file Start working End

IF YOU HAVE ANY ISSUES
JUST FEEL FREE TO CONTACT US
by bigbangamazon@yahoo.com.