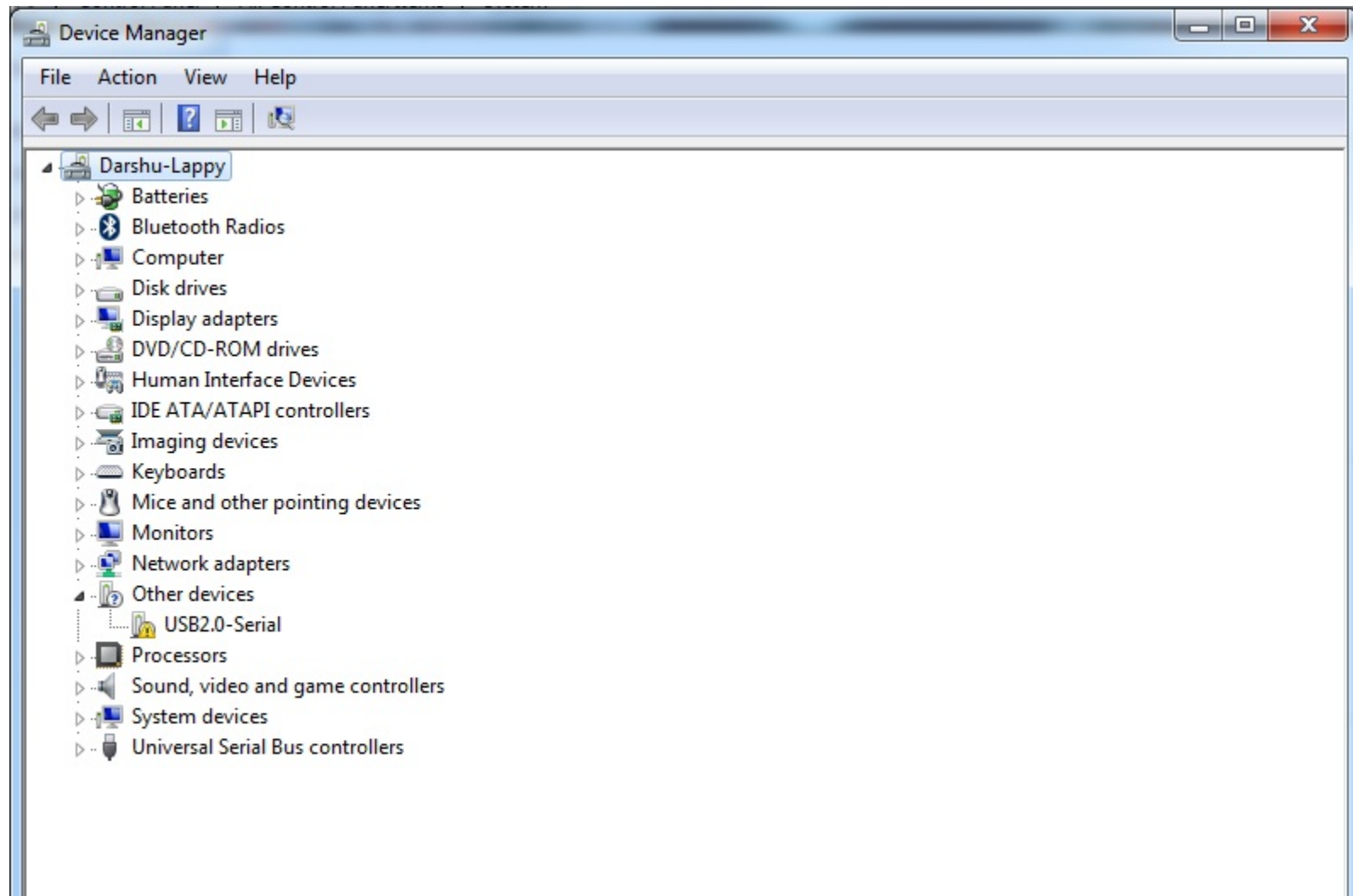


A note on safety

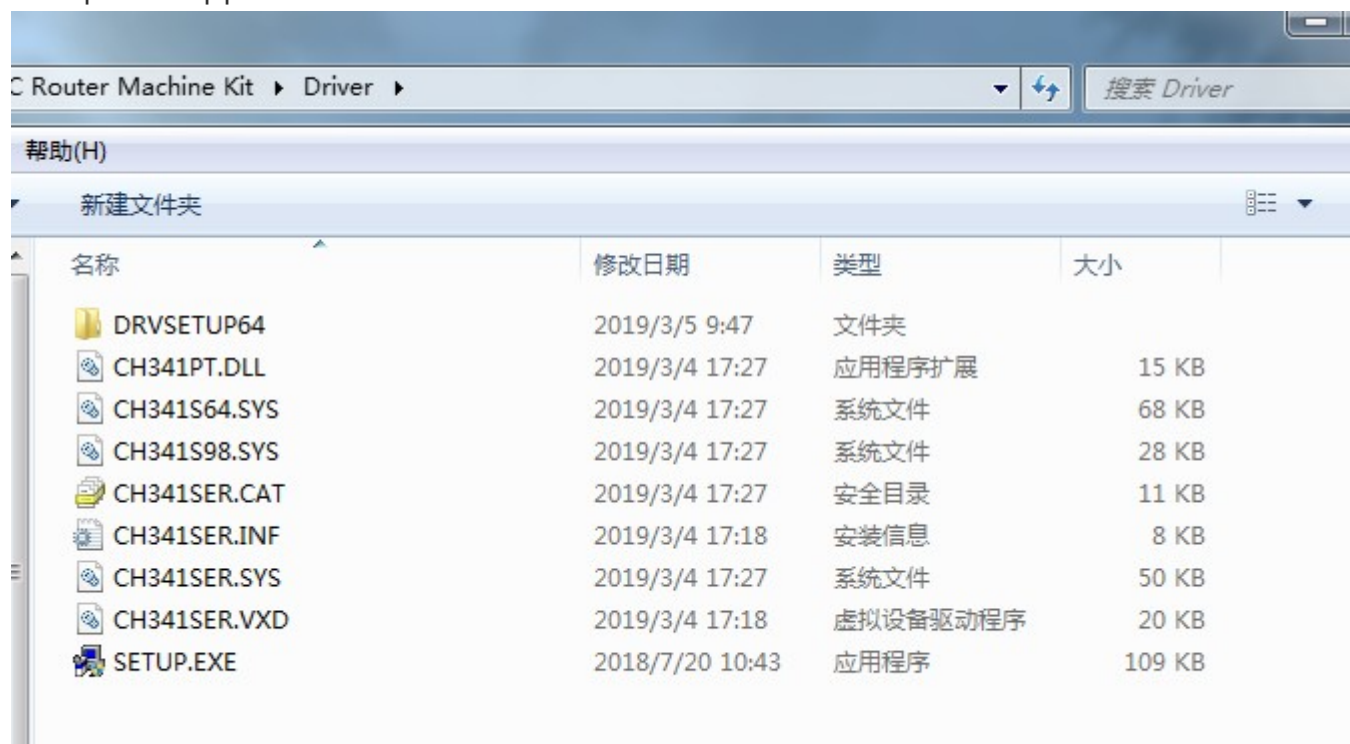
Never operate the machine without adequate safety gear for the current task. Never reach into the machine's operating envelope while it is running. Always have a means of safely disabling the machine's motion and spindle. Never leave the machine operating un-attended.

1. Install CH340 Drivers

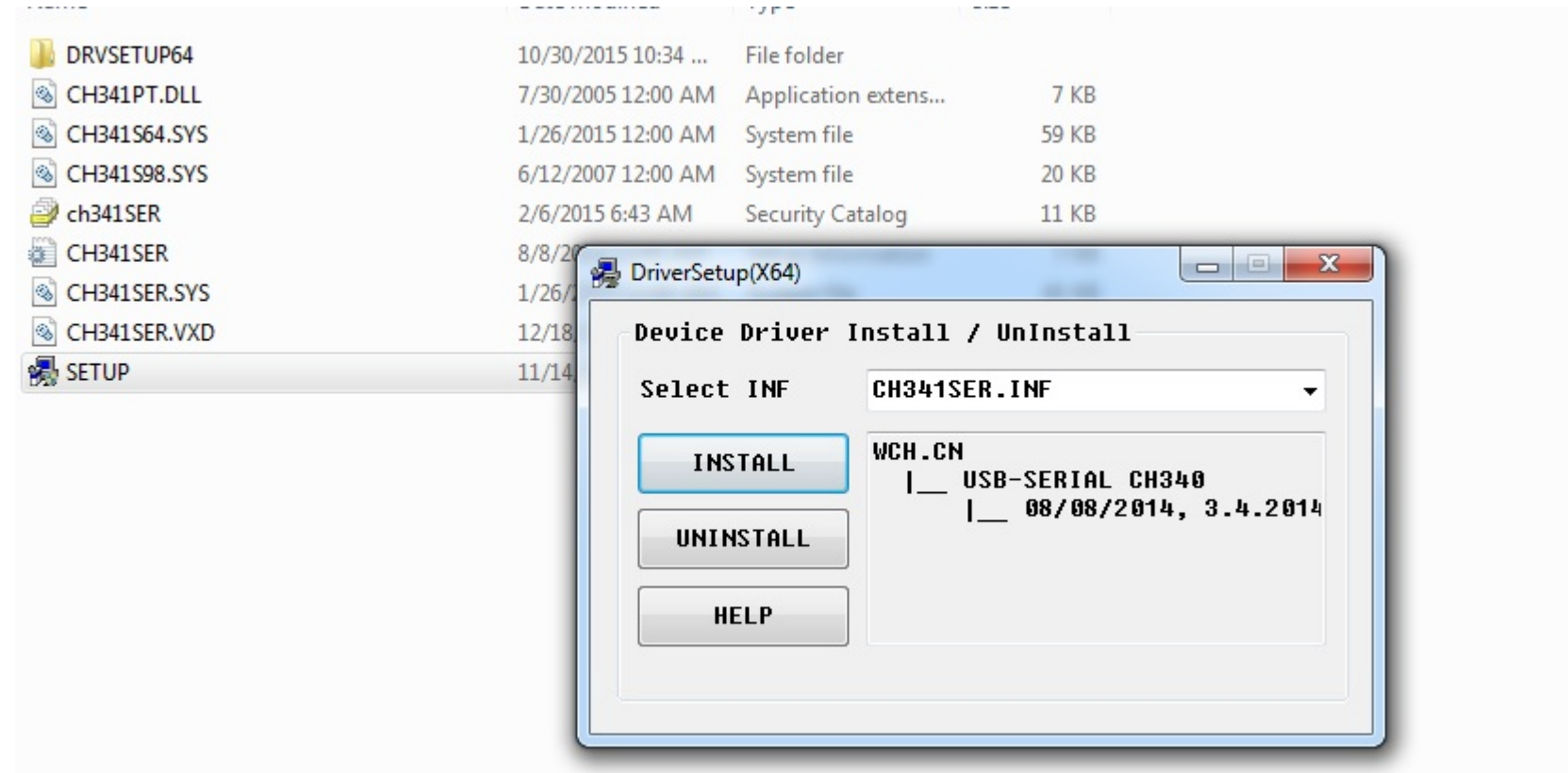
Initially connect your Machine Control Board to your PC. In the device manager it will show "USB2.0-Serial" (as shown in below figure) which means your ch340 driver has not been installed.



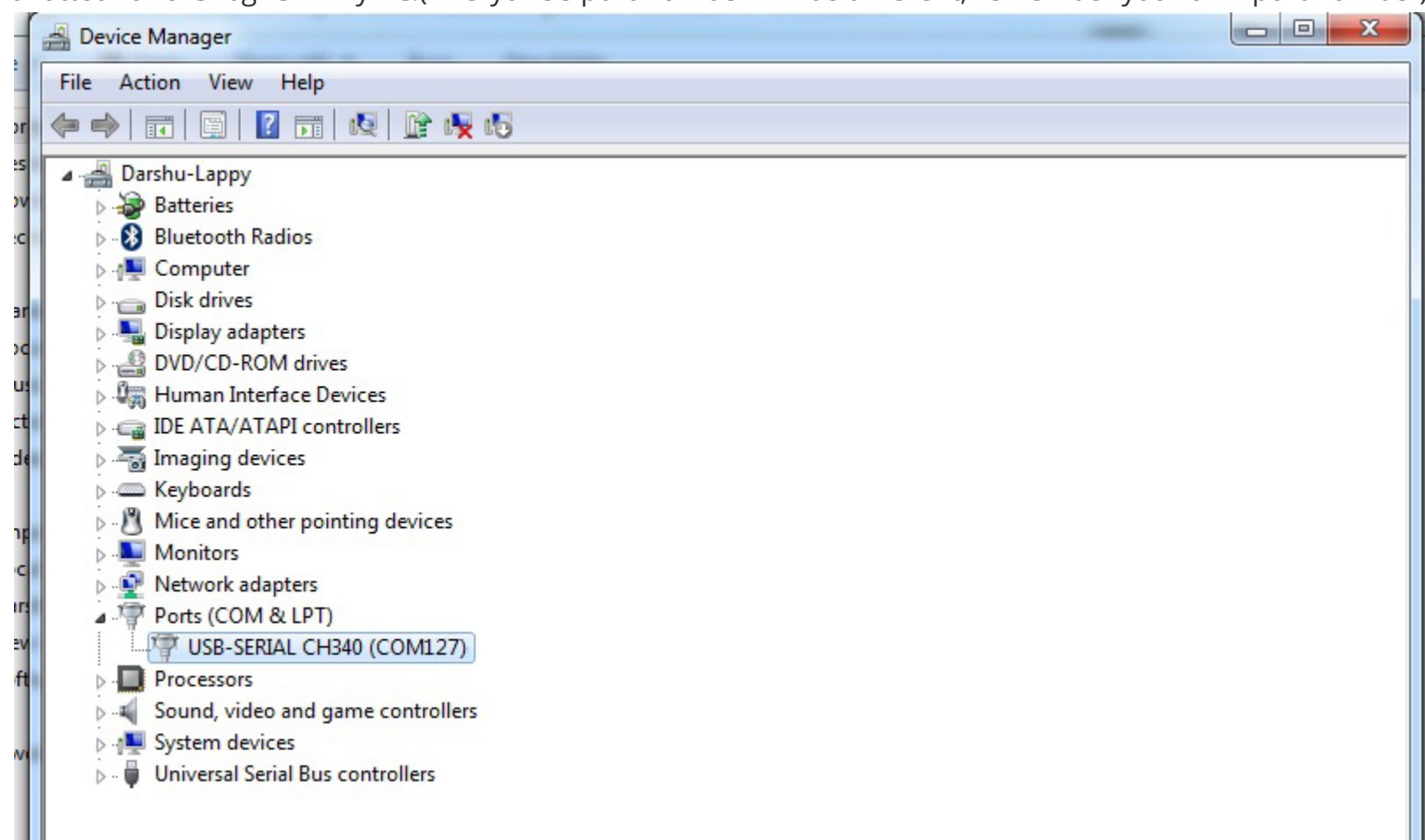
Now extract the CH340g drivers in a folder and in that you will find folder named "CH341SER" in which there will be a "setup.EXE" application file as shown below.



Open the setup file and a “Driver Setup” option will open. Just click on the install file.



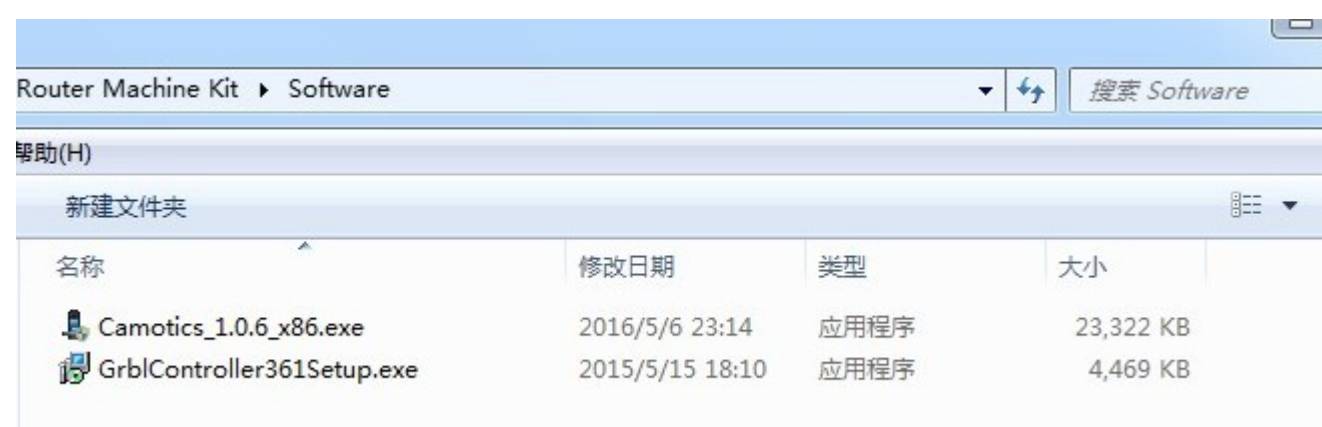
This installation takes some time. In my PC it took 1 minute so just have patience. Once installed it will show driver successfully installed. Now go again back to device manager and there you will see that the driver has been successfully been installed and a com port has been allotted. In below image you can see that “COM127” has been allotted for ch340g IC in my PC.(Everyone's port number will be different, remember your own port number)



Drivers for the ch340 IC has now been installed successfully.

2. Install Control Software “Grbl Controller”

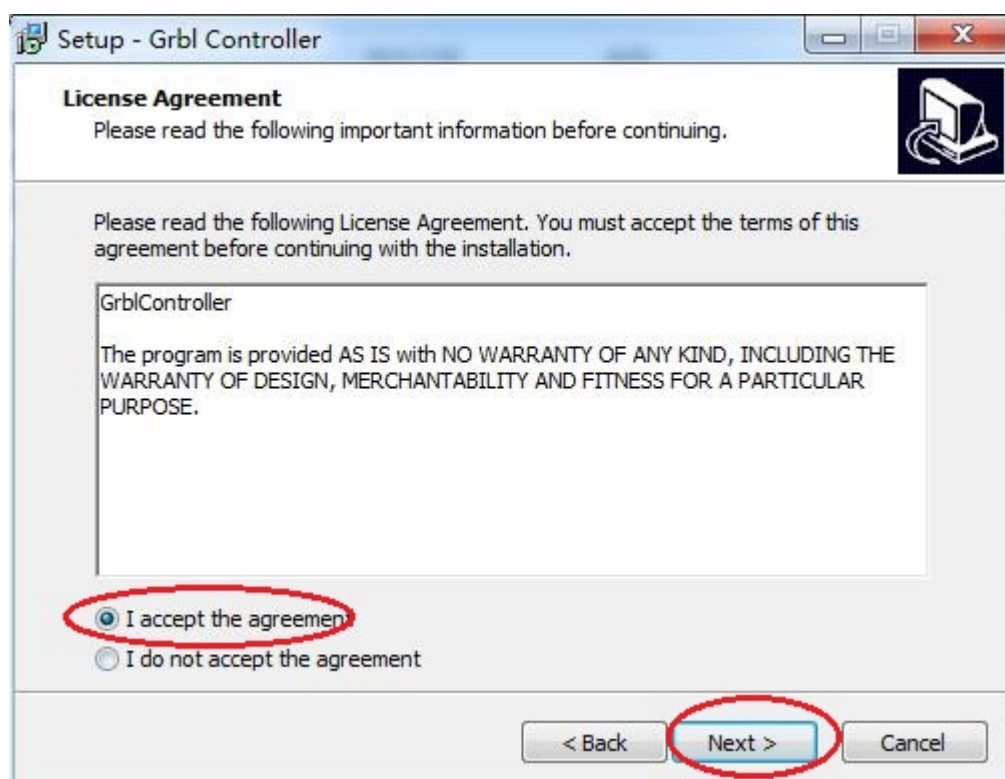
Grbl Controller in software folder and in that you will find “GrblController361Setup.exe”



Open the "GrblController361Setup.exe" file to install. Just click "next".



Choose "I accept the agreement", and click "next".



Click next until the installation is complete.

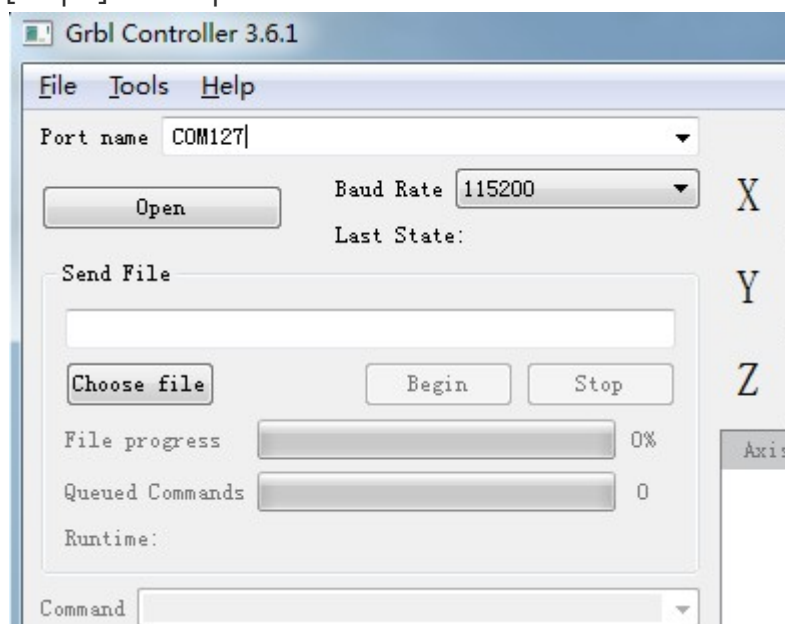
3. Connect to your machine

[step1] open the installed software "Grbl Controller"

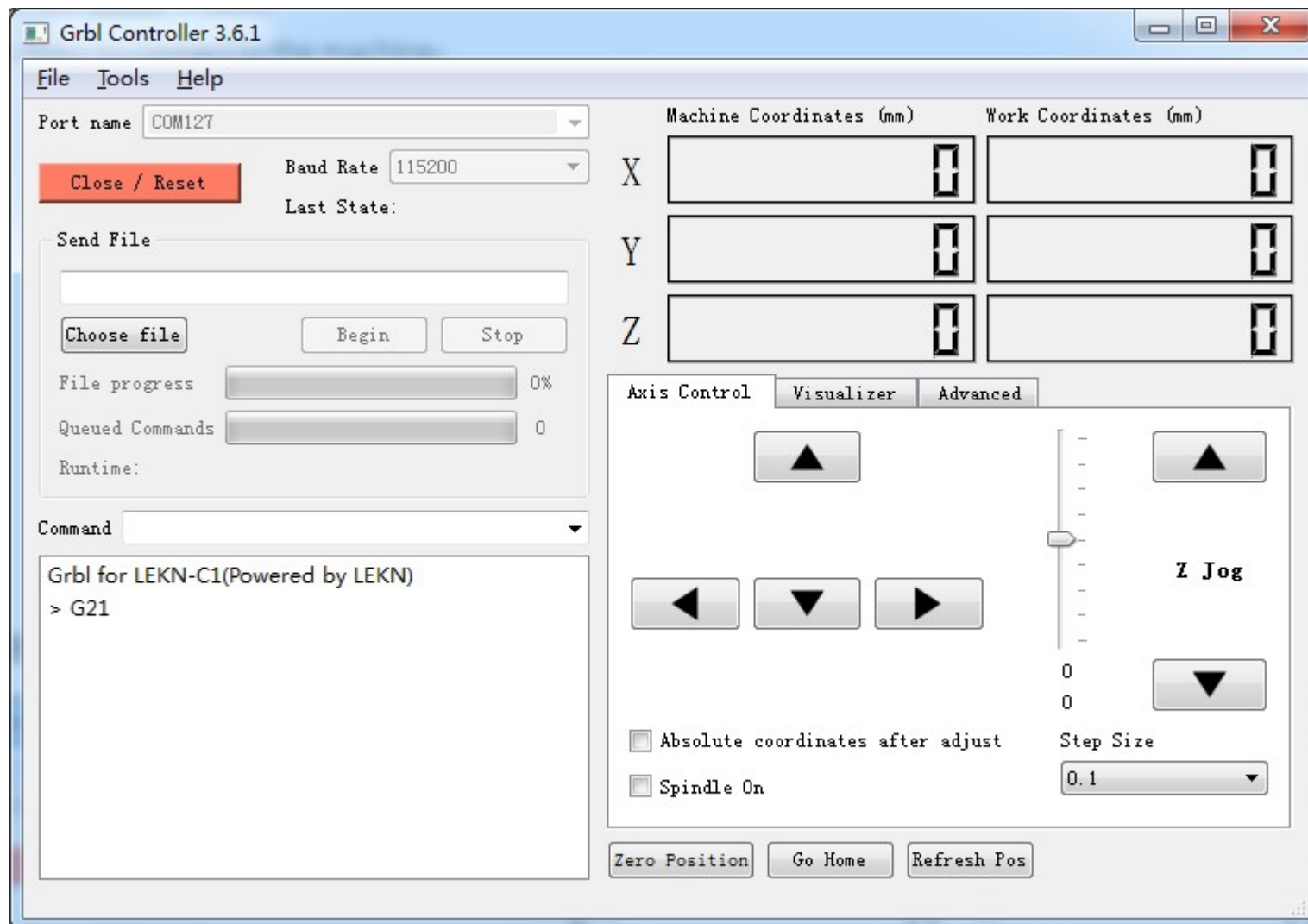
[step2] Select the port number of your machine.(my machine is COM127)

[step3]Baud Rate select 115200

[step4] Click open to connect to the machine

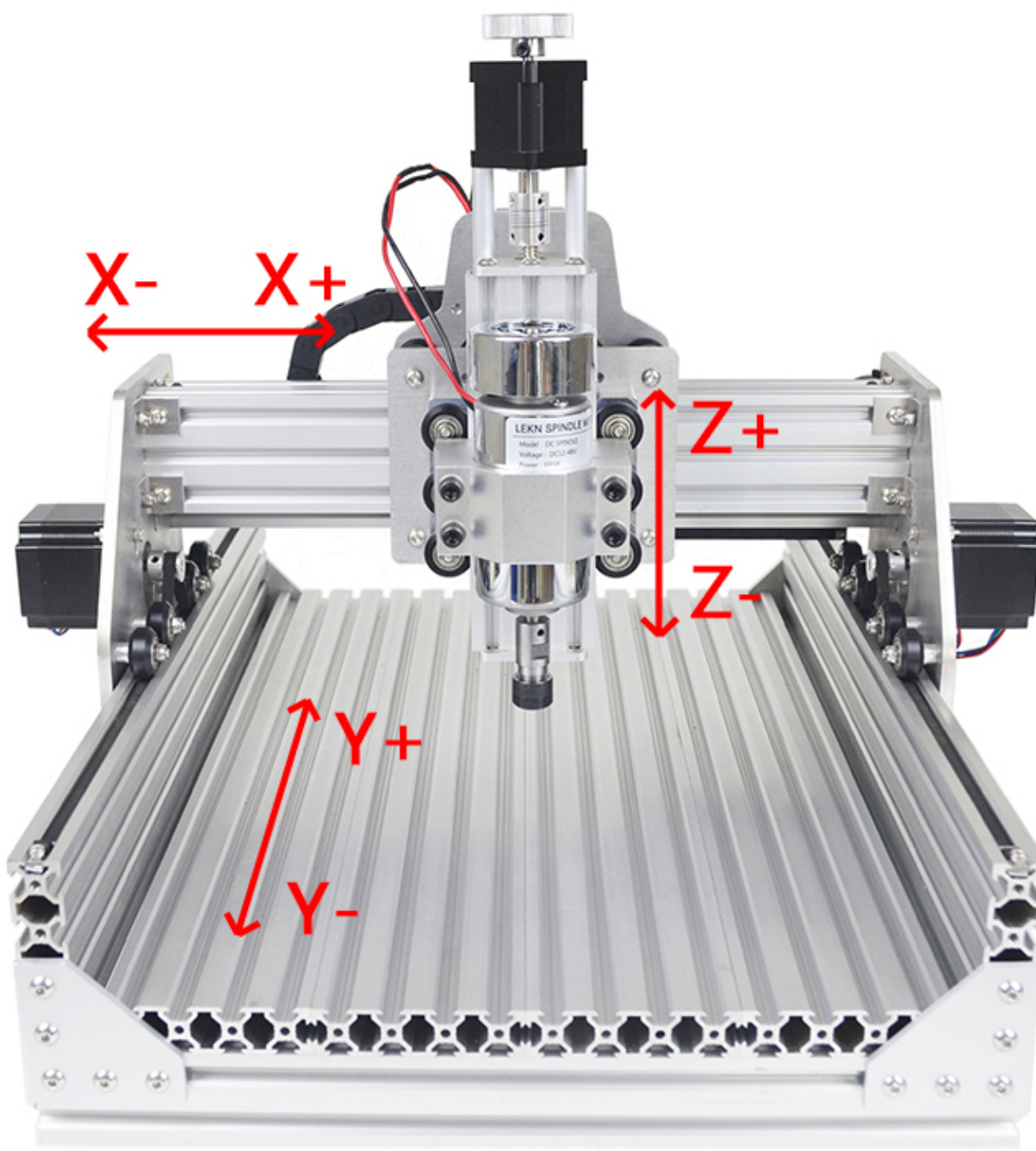


When the machine is connected, there will be this print message.



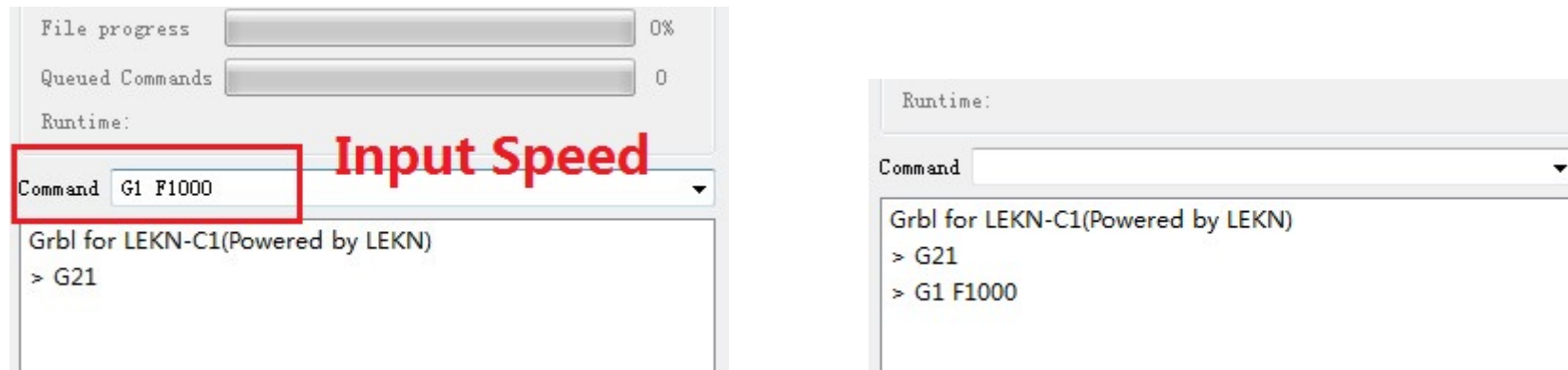
4. Test your machine

axis coordinates:

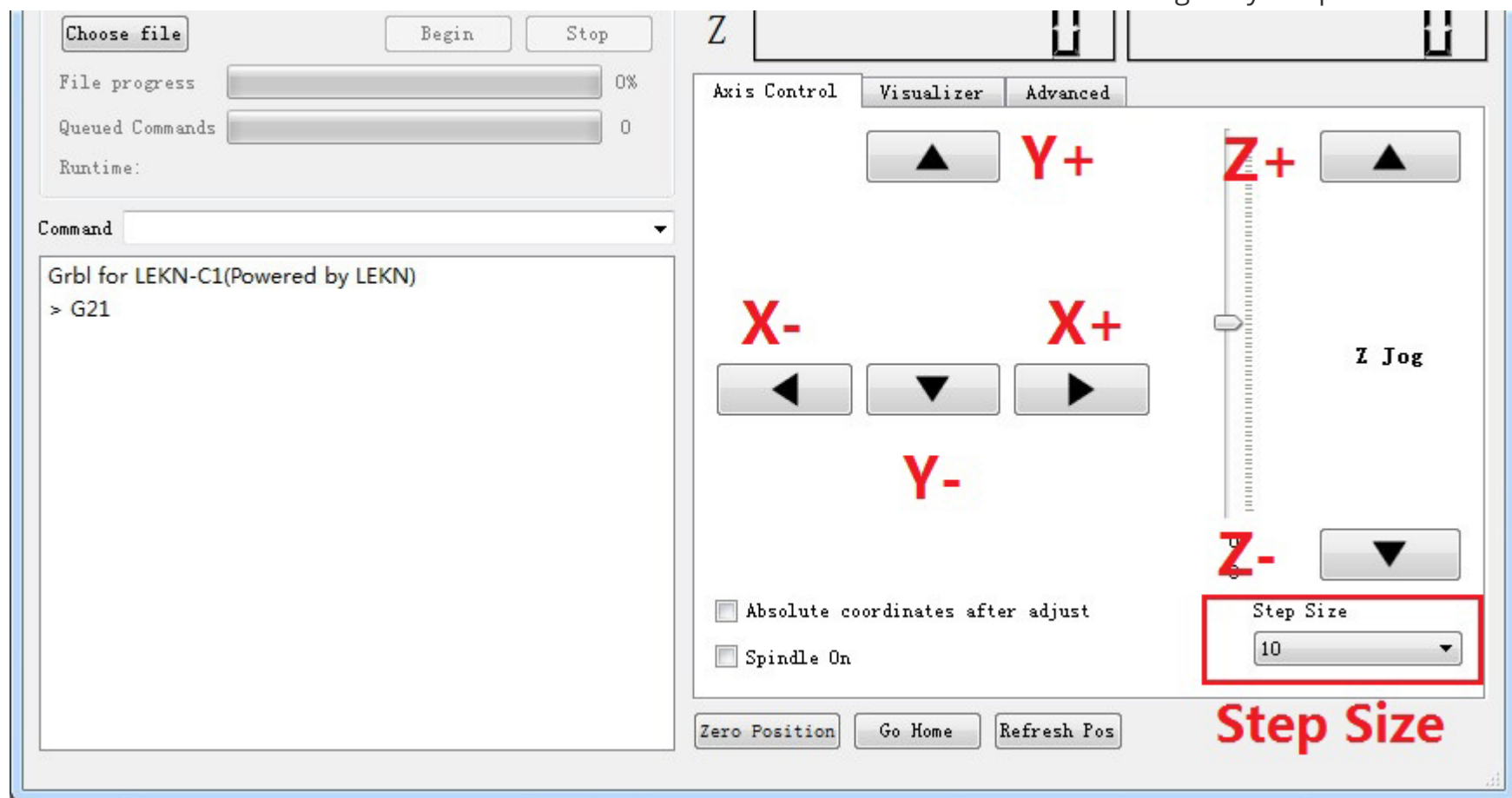


[step1] Test the motion of each axis

First, enter the speed in the software command box.(Just test here, set 1000mm/min)

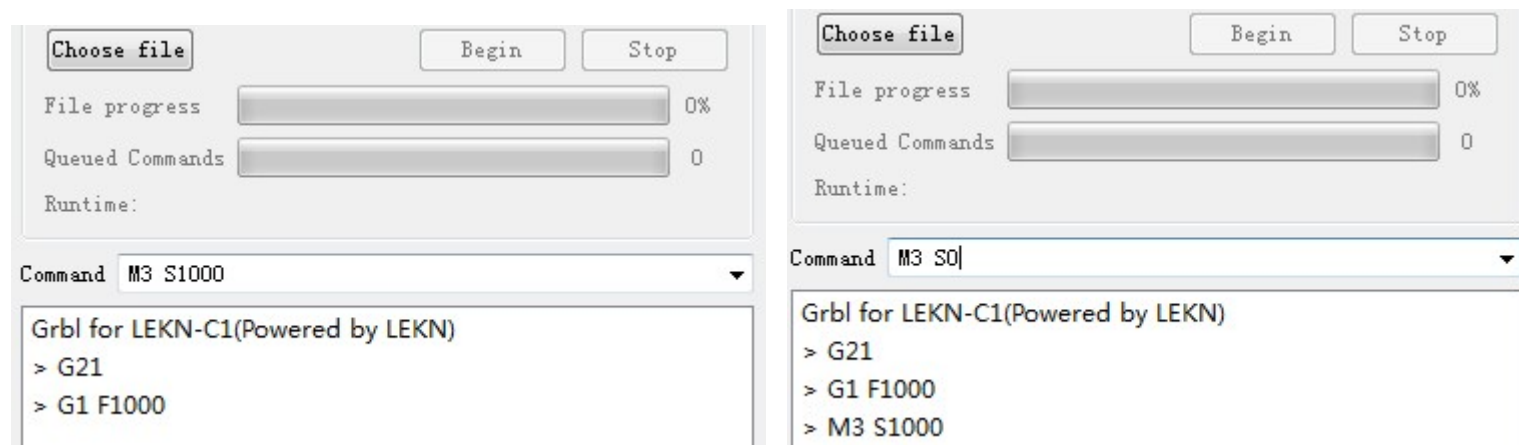


Click the button to control the motion of each axis. The distance of movement can be changed by "Step Size"



[step2] Test spindle motor

Input " M3 S1000 " command to open the spindle motor; Input " M3 S0 " command to close it.



4. Processing Test file

[step1] Install fixtures and test materials

The splint holds down the sides of the material. The material needs to be fixed tight and cannot be moved



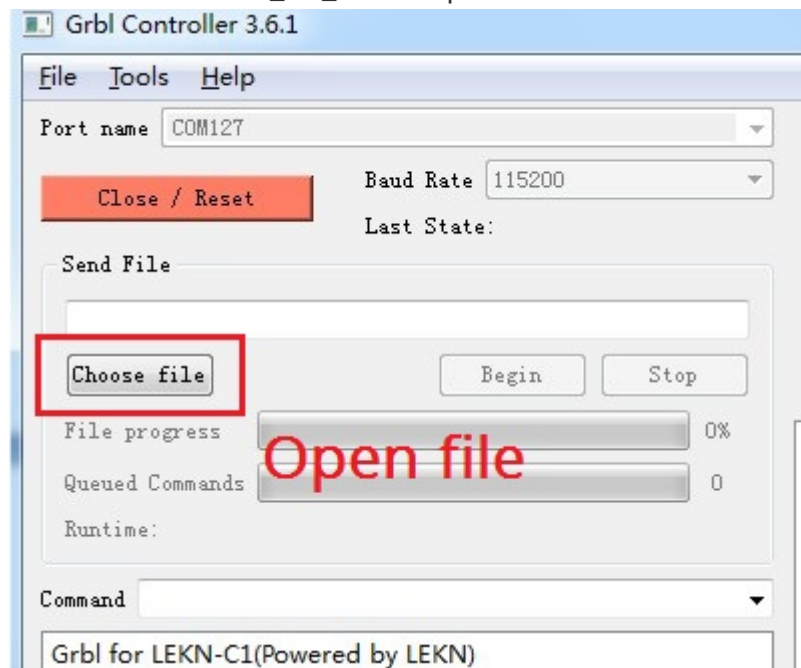
[step2]

Install the milling cutter to the spindle motor. Move the spindle position of the engraving machine so that the milling cutter tip is placed in the lower left corner of the material, just touching the material surface.

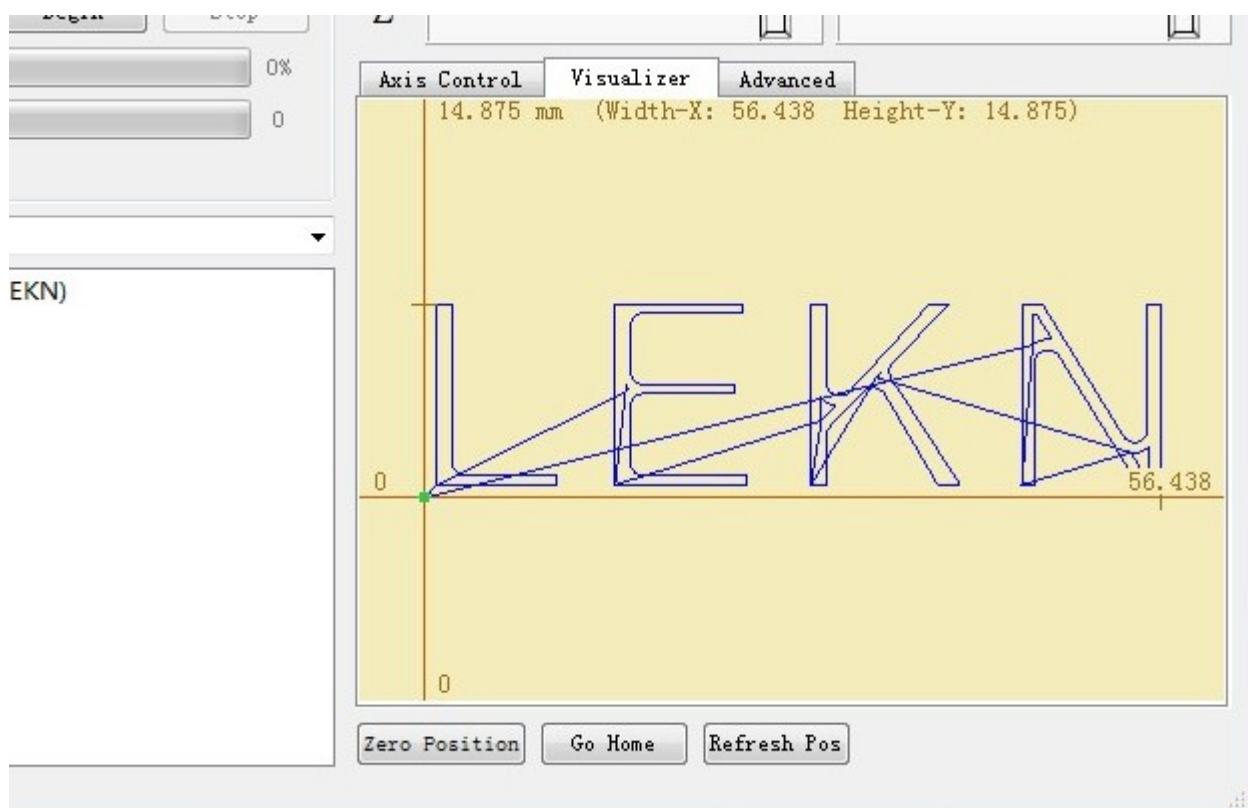
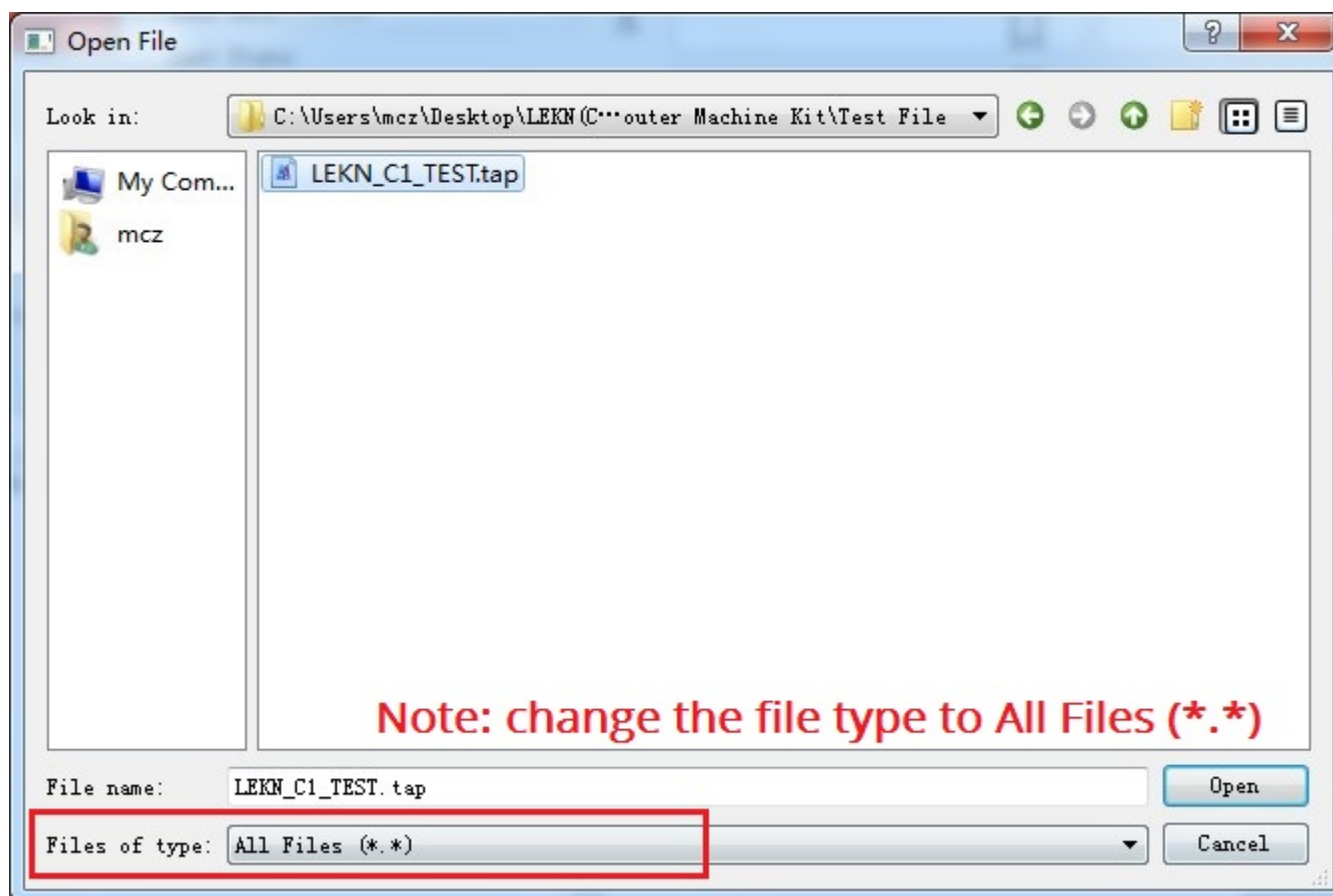


[step3] Load test file

Engraving machine all functions are normal, and then can be processing test file. Click the "Choose file" button, select the test file "LEKN_C1_TEST.tap".

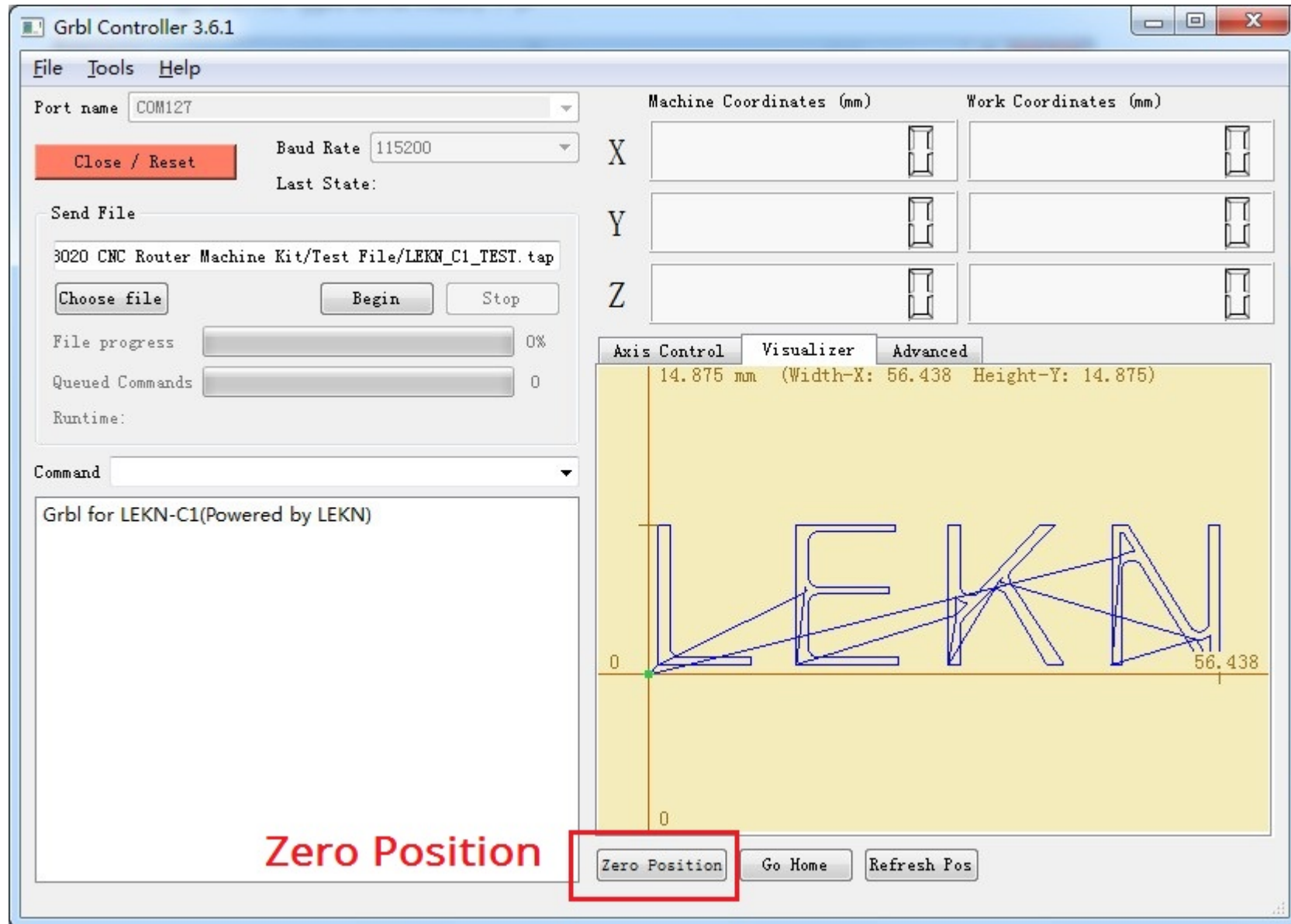


Note: change the file type to All Files (*.*)

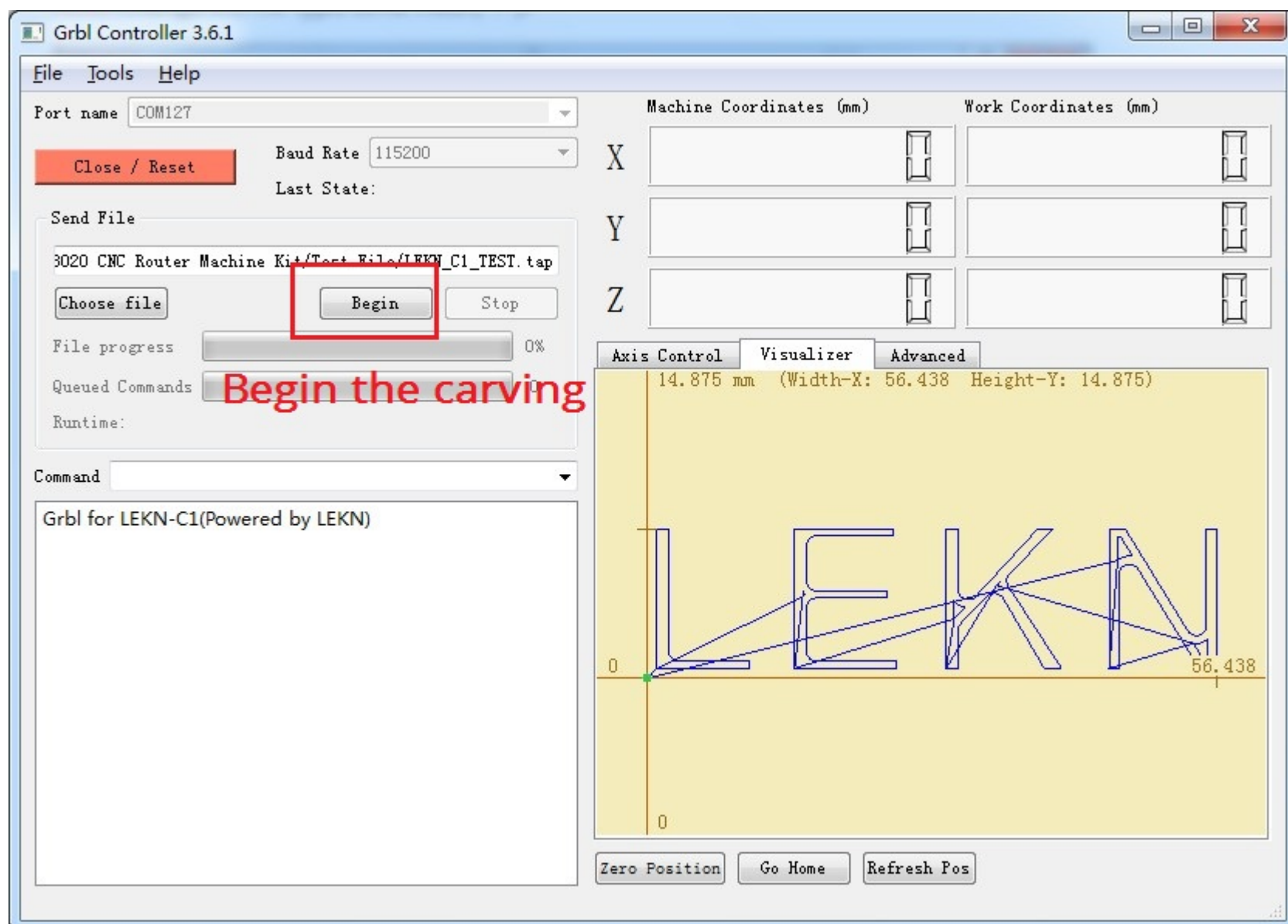


[step4] Begin carving

Before starting processing, click the "Zero Position" button to set the current coordinate as (0,0,0).



Then click the Begin button to Begin the carving



Processing complete

