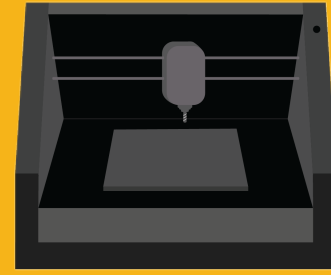# HOW TO MAINTAIN THE CNC ROLAND MDX 40-A

Machine Maintenance

1

Vacuum the bed. **Do not use** an air hose, as this may lodge debris in areas of the Roland MDX 40-A that will prevent it from operating property
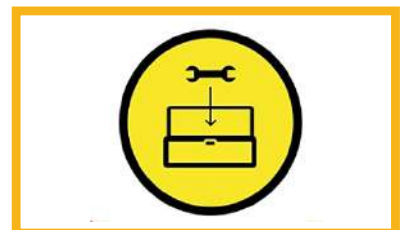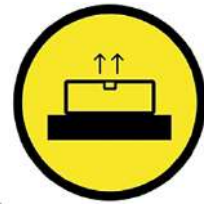
2

Remove double-stick tape from the bed

3

Return all tools to their plastic sleeves and place them in the toolbox

Machine Maintenance

4

Place the toolbox on top of the Roland MDX 40-A or at a safe place where children is out of reach

5

Shut down the computer

Machine Do's and Don'ts

1

Never use a pneumatic blower

Machine Do's and Don'ts

2

Never use a solvent such as gasoline, alcohol, or thinner to perform cleaning

3

Disconnect the power cord before performing cleaning or maintenance

4

When using vacuum cleaner to take up cutting waste, exercise caution to prevent fire or dust explosion
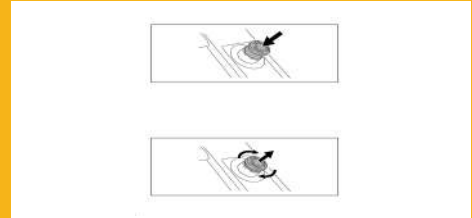
5

Be sure to keep tools detached

How to Perform an Emergency Stop? How to release emergency stop button?

To perform emergency stop you just simply press the emergency switch. And to release the emergency button just, Turn the switch in the direction of the arrow to releases the emergency stop switch.

What Is Command Set?

Select the appropriate command mode to match the software to be used.
- [RML-11- select this command set when you want to use software that was included with the machine.
- [NC-CODE]- select this command set when you want to use NC code.
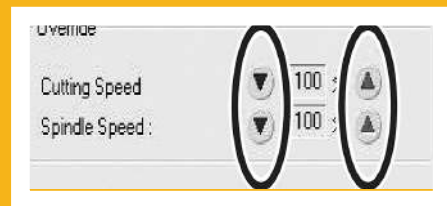
What's an Override?

An override is a feature for adjusting the feed rate or spindle speed while cutting is in progress. This is useful when you want to change the feed rate or speed as you monitor the status of cutting.
- Cutting Speed Override – This works on the tool movement speed of when the workpiece is being cut. The speed specified by the command in the cutting data is taken to be 100%.
- Spindle Speed Override – This works on the rotation speed of the spindle. The speed specified by the command in the cutting data is taken to be 100%. This is also effective when rotating the spindle during manual operations.

How to Make the Settings for Overrides?

Important Notes on Overrides.
Setting an override does not let you perform operation beyond the machine's maximum or minimum speeds.
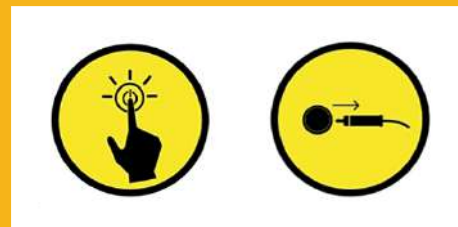

What is the operational temperature limit?

The operational temperature limits to 41 to 104°F (5 to 40°C) If and only if the spindle driver IC becomes too hot. Kindly turn off the machine's power. Relax the cutting parameters, allow the machine cool downg then carry out cutting again.

What to do when sensor is not working?

If the sensor is not working, the origin detection cannot be performed. Switch off the power and detach the connector for the sensor. Then switch the power back on and connect the connector for the sensor.

What to do if a Flashing Error Is Displayed?

If the lights are flashing as shown below, then an error has occurred on the machine. To correct the error, follow the steps described below:

The **MODELING** and **SCANNING** lights.

- An error occurred during initialization of the machine or during origin detection by the sensor.
- Switch the power off, then back on. If the error is not cleared when you switch the power on again, the machine maybe malfunctioning, contact your authorized Roland DG Corp. dealer or service center.

The **MODELING** and **VIEW** lights.

- The front cover was opened while cutting was in progress. Operation cannot be continued. Close the front cover and press the sub power button.

The **MODELING** lights

- The spindle motor error occurred. Operation cannot be continued. Press the sub power button to clear the error. Make the program's cutting parameters more relaxed to lessen the load applied to the spindle.

What other things can be done with the MDX 40A machine?

- Product prototypes
- Snap-fit parts
- Toys and figurines
- 3D art and sculpture
- Replacement parts
- 3D molds and stamps
- Electrical casings
- Plaques and engravings