

FLASHCUT CNC

CONTROL MADE SIMPLE

®

Control Pendant



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Revised 11/02/2010

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1. Introduction

Thank you for purchasing the FlashCut CNC Control Pendant. In your package you should have:

- (1) Control Pendant
- (1) USB Extension Cable
- (1) Protective Cover
- (1) Sheet of Button Labels



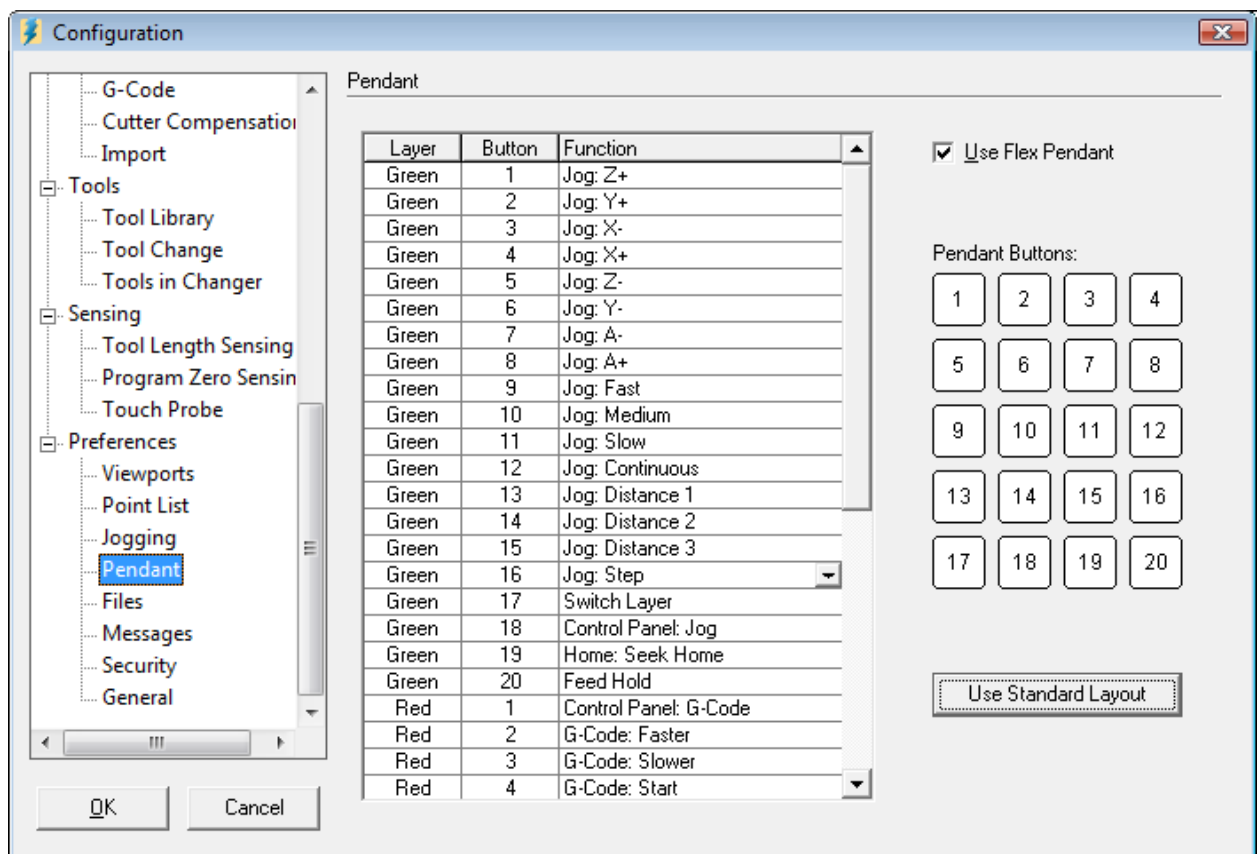
2. To prepare your device:

1. Remove Clear Plastic Button Covers
2. Place Button Labels on white part of button. Make sure that you keep the same order as is on the label sheet.
3. Replace Button Covers
4. Place Protective Cover over pendant. The protective cover can be permanently installed by removing the paper strips on the edges to expose the adhesive. This protects your pendant from chips and oil, etc, but does not provide a complete seal to protect against immersion or heavy spraying.
5. If needed, install the extension cable on the end of the black cable on the unit.



3. To install on your system:

1. Open up FlashCut CNC (**Must be version 3.0.14 or greater**) **If you have an earlier version, then you must install version 3.0.14 or greater before proceeding.**
2. Plug the end of the USB cable into an empty USB port on your computer.
3. Select Configuration on the Main Screen's Pull-Down menu, followed by Preferences and Pendant
4. In the Pendant Configuration Menu, select the check box next to "Use Flex Pendant."
5. Then press the "Use Standard Layout" button and select OK to set the pendant buttons to their default functions.



6. The pendant is then configured to work with the FlashCut CNC software.
7. Press the buttons to perform each of the functions. Note that there are two layers that you can choose using the Layer Key on the bottom left. This key chooses between the Green and the Red layers. Note that all of the Jog and Home functions are in the Green layer. All other functions are on the Red layer.
8. There is a dial on the upper right edge of the pendant that is taped in one position for normal operation. Please do not remove the tape or try to reposition the dial.

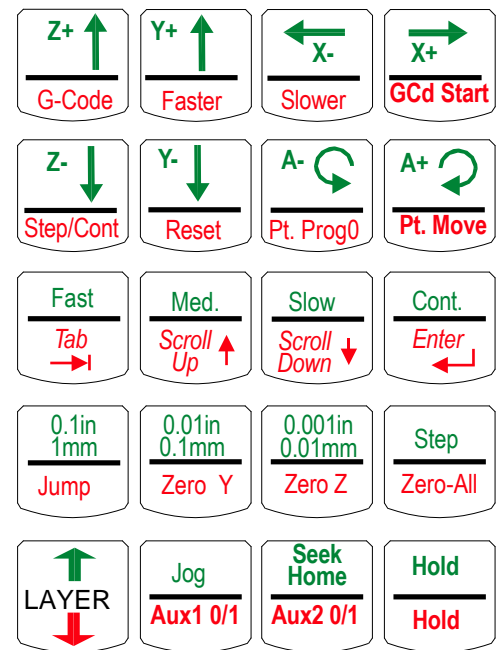
4. The Keys:

Green Layer

Z+, Z-, Y+, Y-, X+, X-, A+, A- These keys will jog the machine in the specified axis and direction. Holding the key down will move the axis continuously if in continuous mode. If you are not in continuous mode, i.e. 0.1, 0.001, 0.001 or step mode, tap the key for each incremental movement you want to make.

Fast, Med., Slow – These keys choose between the Fast, Medium and Slow Jog Feedrates as defined in the Configuration...Feedrate Ramping Dialog Box.

Cont., 0.1in/1mm, 0.01in/0.1mm, 0.001in/0.001mm, Step – These keys choose between Continuous Jog movement and incremental movement for the specified key. Note that if you are in metric mode, the increments are different than in inch mode. Step mode will move one motor step (Stepper Systems) or encoder pulse (Servo Systems)



Layer – This key will toggle between the Green Layer and the Red Layer of the keyboard.

Jog – This key puts the unit in Jog Mode. Note that the above keys will automatically place the unit in Jog mode.

Seek Home – This key will automatically command the machine to Seek the Home Switches as defined in the Configuration...Homing Dialog box.

Hold – This button will stop the movement of the machine in any layer in any function.

Red Layer

G-Code – Puts the unit in G-Code mode so that you can run your G-Code Program.

Faster, Slower – These buttons are used for federate override. In version 2.1.0 and lower, they can only be used when the machine is idle.

G-Cd Start – This Starts the G-Code program at the current point in the program.

Step/Cont. – This toggles between the step and continuous modes of running a G-Code file. (Step mode automatically stops at the end of each G-Code Line)

Reset – This resets the G-Code Program.

Pt. Prog0 – This places the unit in Point Mode and Chooses the Program Zero Point. It does not move to that point automatically. To choose a different point from the list, use the Scroll Up and Scroll Down Keys. You can use the Tab Key to choose a different coordinate system.

Tab, Scroll Up, Scroll Down – This is for general purpose cursor movement in and around the different text boxes and menus.

Enter – This is for choosing the enter key for messages that come up.

Zero X, Zero Y, Zero Z, Zero All – These keys will zero out the Program Coordinates. It is especially useful when jogging your machine to find your program zero position.

Layer – This key will toggle between the Green Layer and the Red Layer of the keyboard.

Aux1 0/1, Aux2 0/1 – This button turns the device connected to the Auxiliary 1 and 2 outputs on and off.

Hold – This button will stop the movement of the machine in any layer in any function.