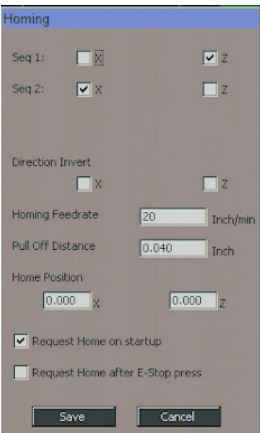
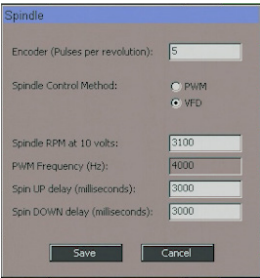


MASSO DEFAULT FUNCTION SETTINGS—CHUCKER LATHES

These are lists of all of the default settings for the “Function Settings” for each Sherline Machine. Scroll through the document to find the settings for your machine. Click the following link for detailed instructions on setting the MASSO default functions. https://www.sherline.com/wp-content/uploads/2020/06/masso_default_settings_inst.pdf

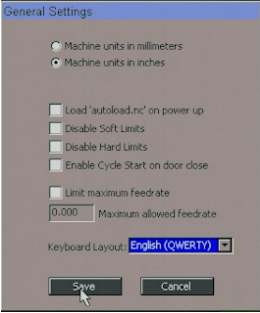
1. First go to the F1 - Setup page. Enter your pass code. Then look at the list of “Function Settings”.
2. The function settings are going to be different for each machine depending on the machine size, the type of leadscrew or ball screw, and which direction the axis must go to home out.
3. All General settings are in Inch. To convert to Metric, just multiply by 25.4.
4. The default settings below are for our standard machines. If you have upgraded your machine to a longer base or table, then you will need to choose the axis information that coincides with the sizes of your axes.

CHUCKER LATHES


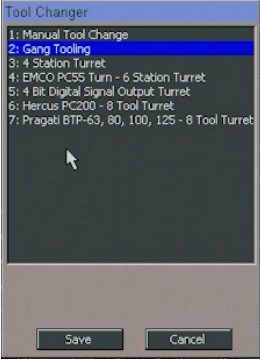
FUNCTION SETTINGS		14" Base, 13" Crossslide	14" Base, 13" Crossslide	18" Base, 18" Crossslide	18" Base, 18" Crossslide
HOMING	SETTINGS	INCH VALUES	METRIC VALUES	INCH VALUES	METRIC VALUES
	SEQ 1	Z	Z	Z	Z
	SEQ 2	X	X	X	X
	Direction Invert	X: NO, Z: NO	X: NO, Z: NO	X: NO, Z: NO	X: NO Z: NO
	Homing Feedrate	20 IN/MIN	508 MM/MIN	20 IN/MIN	508 MM/MIN
	Pull Off Distance	0.040"	1.016MM	0.040"	1.016MM
	Home Position	X:0.00, Y:0.00	X:0.00, Y:0.00	X:0.00, Y:0.00	X:0.00, Y:0.00
	Request Home on Startup	YES/CHECK	YES/CHECK	YES/CHECK	YES/CHECK
	Request Home after E-Stop	NO/BLANK	NO/BLANK	NO/BLANK	NO/BLANK
SPINDLE	Encoder (Pulse per revolution)	5	5	5	5
	Spindle control method (PWM or VFD)	VFD	VFD	VFD	VFD
	Spindle RPM at 10 Volts NOTE: If you have a 10,000 RPM spindle, this must be set to 10,000	3100	3100	3100	3100
	PWM Frequency (Hz)	4000	4000	4000	4000
	Spin Up Delay (Milliseconds)	3000	3000	3000	3000
	Spin Down Delay (Milliseconds)	3000	3000	3000	3000

Continued

CHUCKER LATHES

FUNCTION SETTINGS		14" Base, 13" Crossslide	14" Base, 13" Crossslide	18" Base, 18" Crossslide	18" Base, 18" Crossslide
GENERAL SETTINGS	Choose Millimeter or Inch for your control	Choose Millimeter or Inch for your control	Choose Millimeter or Inch for your control	Choose Millimeter or Inch for your control	Choose Millimeter or Inch for your control
	For our machines, none of the choices from Load "autoload.nc" to "Limit Max Feedrate" are checked.	ALL BLANK	ALL BLANK	ALL BLANK	ALL BLANK
	Max Allowed Feedrate	0.00	0.00	0.00	0.00
	Keyboard Layout: Pick your language of choice.	YOUR CHOICE	YOUR CHOICE	YOUR CHOICE	YOUR CHOICE

NOTE: When you set your "Machine units" to either Inch or Millimeter, you are setting the CONTROL page AND your SETUP page to Inch or Millimeter for data input. You can have an Inch or Metric leadscrew and choose to have your Control page and Setup values in either inch or metric.

		14" Base, 13" Crossslide	14" Base, 13" Crossslide	18" Base, 18" Crossslide	18" Base, 18" Crossslide
LUBRICATION	Does not apply to our machines.				
					
TOOL CHANGER					
	NOTE: All of our Lathes and Chucker Lathes use "Gang Tooling"	GANG TOOLING	GANG TOOLING	GANG TOOLING	GANG TOOLING

Continued

CHUCKER LATHES

FUNCTION SETTINGS		14" Base, 13" Crossslide	14" Base, 13" Crossslide	18" Base, 18" Crossslide	18" Base, 18" Crossslide
X-AXIS	SETTINGS	INCH VALUES	METRIC VALUES	INCH VALUES	METRIC VALUES
	Motor: Distance per Revolution	0.07874"	2.00MM	0.07874"	2.00MM
	Drive: Pulses per Revolution	800	800	800	800
	Maximum Feedrate	32 inch/min	812.8 mm/min	32 inch/min	812.8 mm/min
	Acceleration	2.755 IN/MIN	69.9 MM/SEC2	2.755 IN/MIN	69.9 MM/SEC2
	Travel Minimum	0.00	0.00	0.00	0.00
	Travel Maximum	15.900"	403.86MM	25.900"	657.86MM
	Backlash	0.00	0.00	0.00	0.00
	Invert: Check or Blank	YES/CHECK	YES/CHECK	YES/CHECK	YES/CHECK
		14" Base, 13" Crossslide	14" Base, 13" Crossslide	18" Base, 18" Crossslide	18" Base, 18" Crossslide
Z-AXIS	SETTINGS	INCH VALUES	METRIC VALUES	INCH VALUES	METRIC VALUES
	Motor: Distance per Revolution	0.07874"	2.0MM	0.07874"	2.00MM
	Drive: Pulses per Revolution	800	800	800	800
	Maximum Feedrate	32 inch/min	812.8 mm/min	32 inch/min	812.8 mm/min
	Acceleration	4.724 IN/MIN	119.98 MM/SEC2	4.724 IN/MIN	119.98 MM/SEC2
	Travel Minimum	-5.95	-151.13	-9.95	-252.73
	Travel Maximum	0.00	0.00	0.00	0.00
	Backlash	0.00	0.00	0.00	0.00
	Invert: Check or Blank	YES/CHECK	YES/CHECK	YES/CHECK	YES/CHECK