

## Auto tune machine - Drag

Auto Tune is used by qualified technicians to automatically determine values for Max Rate, Accel / decel time, and Dead start as well as the PID parameters for each installed axis. Before running auto tune, jogging all axis to the middle machine. Make sure the machine is clear to move +/- 2 inches.

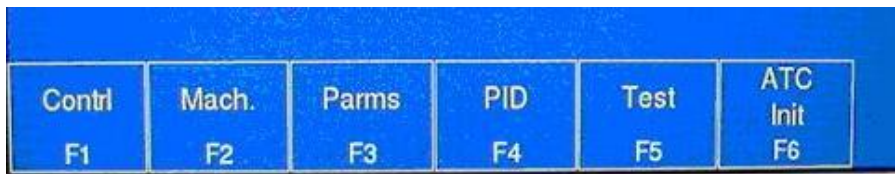
Select F1- Set up



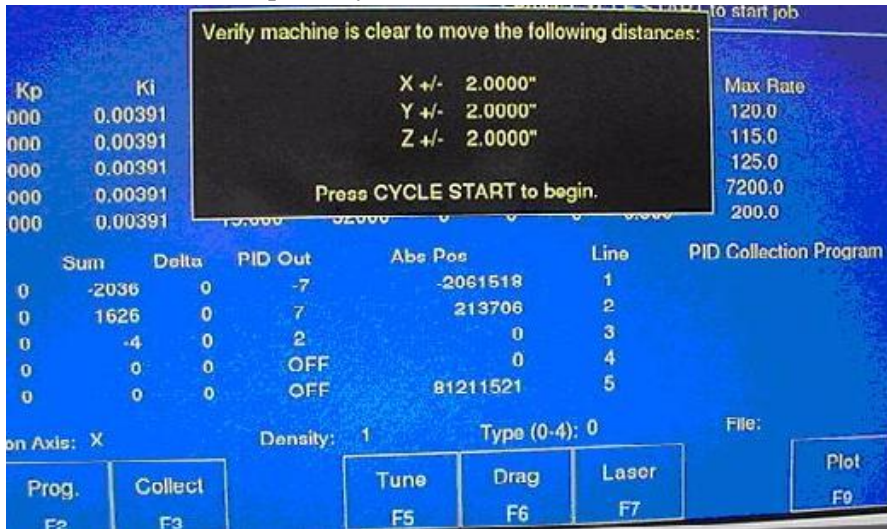
F3 - Config, enter the password 137 and press Enter



Select F4 - PID



Select F5 - Tune, and press Cycle Start



Drag:

Drag is used by qualified technicians to determine whether your machine is binding anywhere along the axis travel.

To run a drag test press F6 –Drag to begin the drag test.

Press F1 - Next axis to select the axis you wish to check and hit the Cycle Start.

