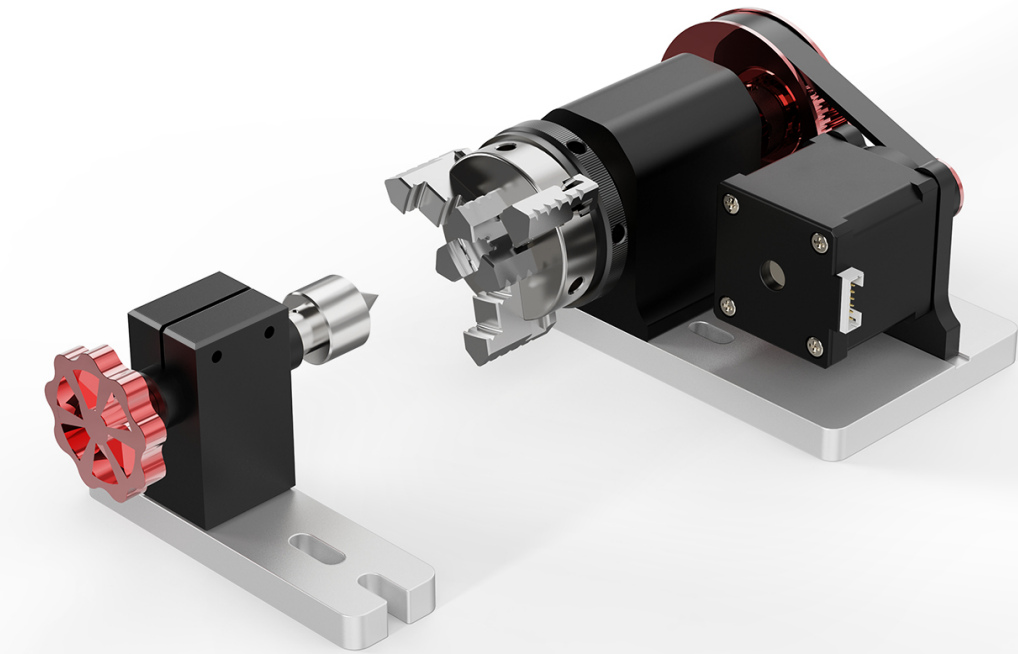
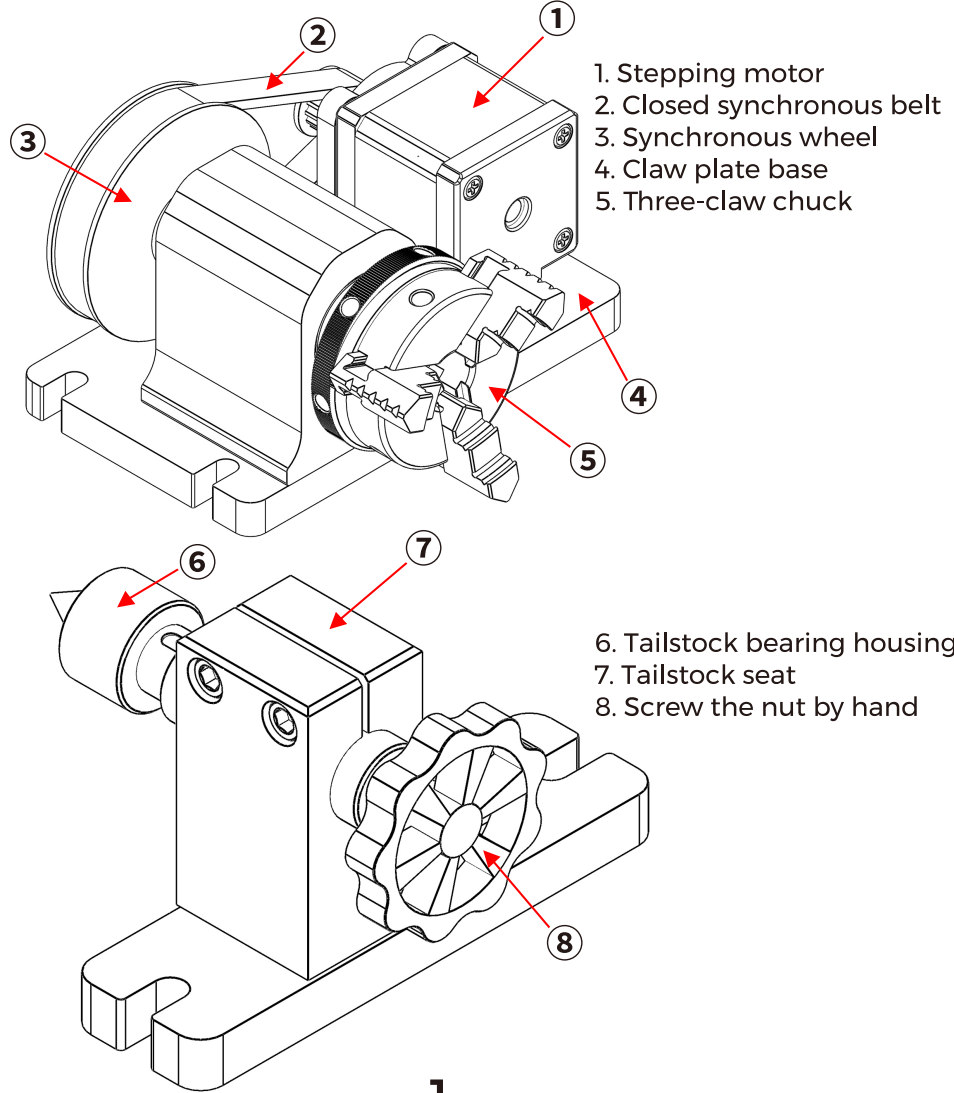




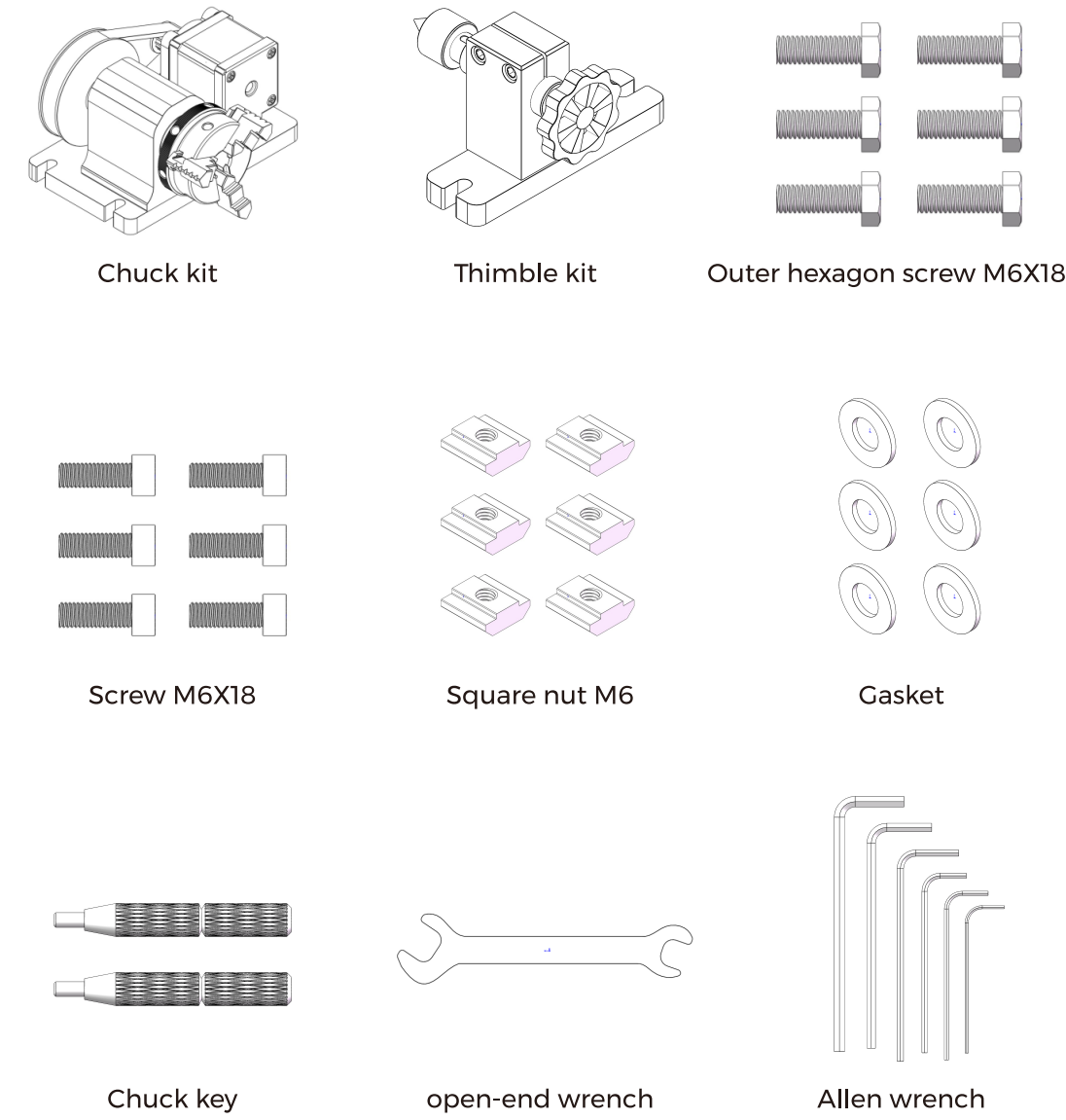
Parameter description

Maximum diameter of clamping cylinder: 60mm
Minimum diameter of clamping cylinder: 4mm
Maximum length of clamping cylinder: according to the working length of the machine. (Need to subtract the distance between chuck kit and tailstock kit)
Shortest length of clamping cylinder: according to machine tool head. (If it is too short, it will cause the cutter head to hit the chuck)
The subtraction ratio of chuck is 4: 1

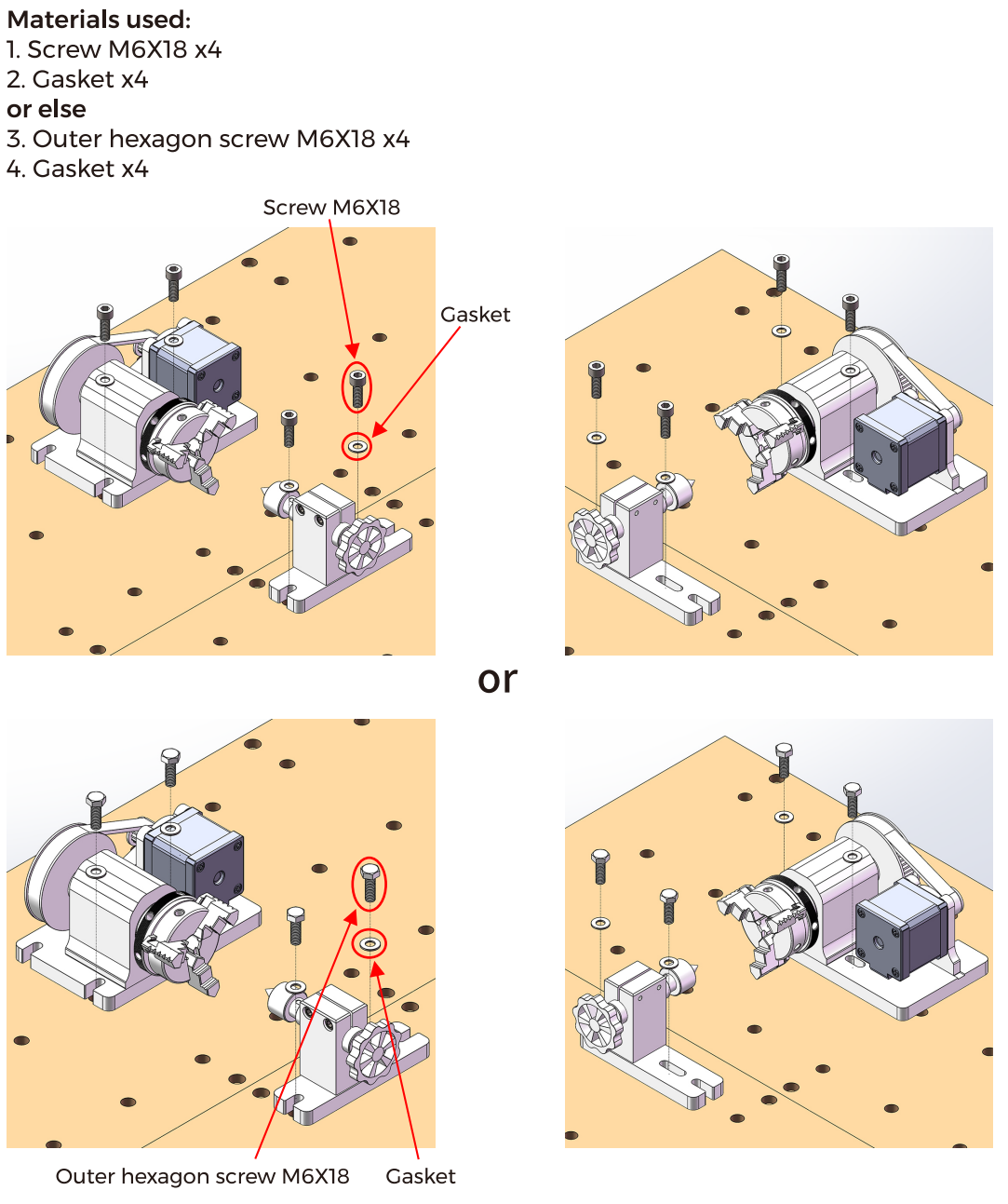
Accessories introduction



PARTS LIST

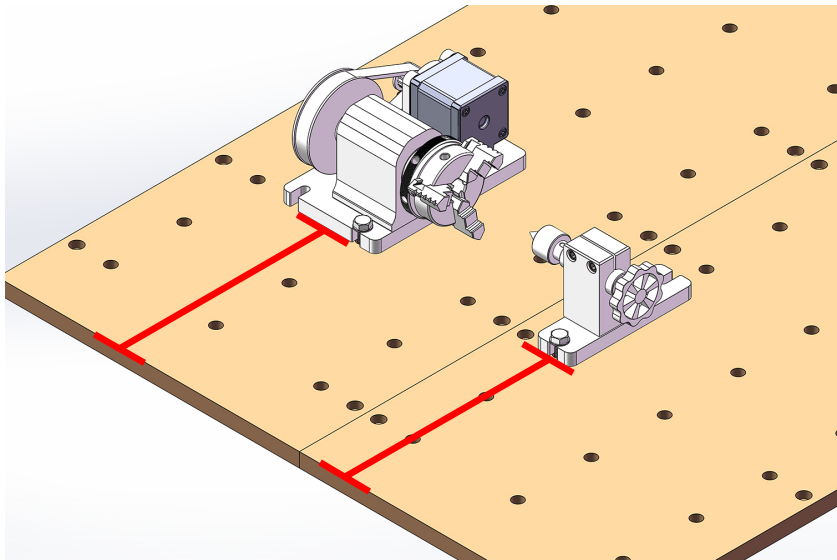


Instructions for TTC450 Machine

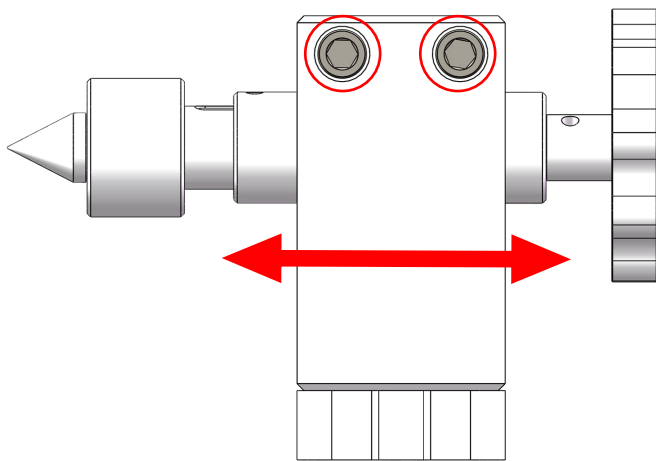


Matters needing attention in using TTC450 machine

It is necessary to control that the distance from the bottom plate of the chuck kit and the tailstock kit to the edge of the MDF is consistent.

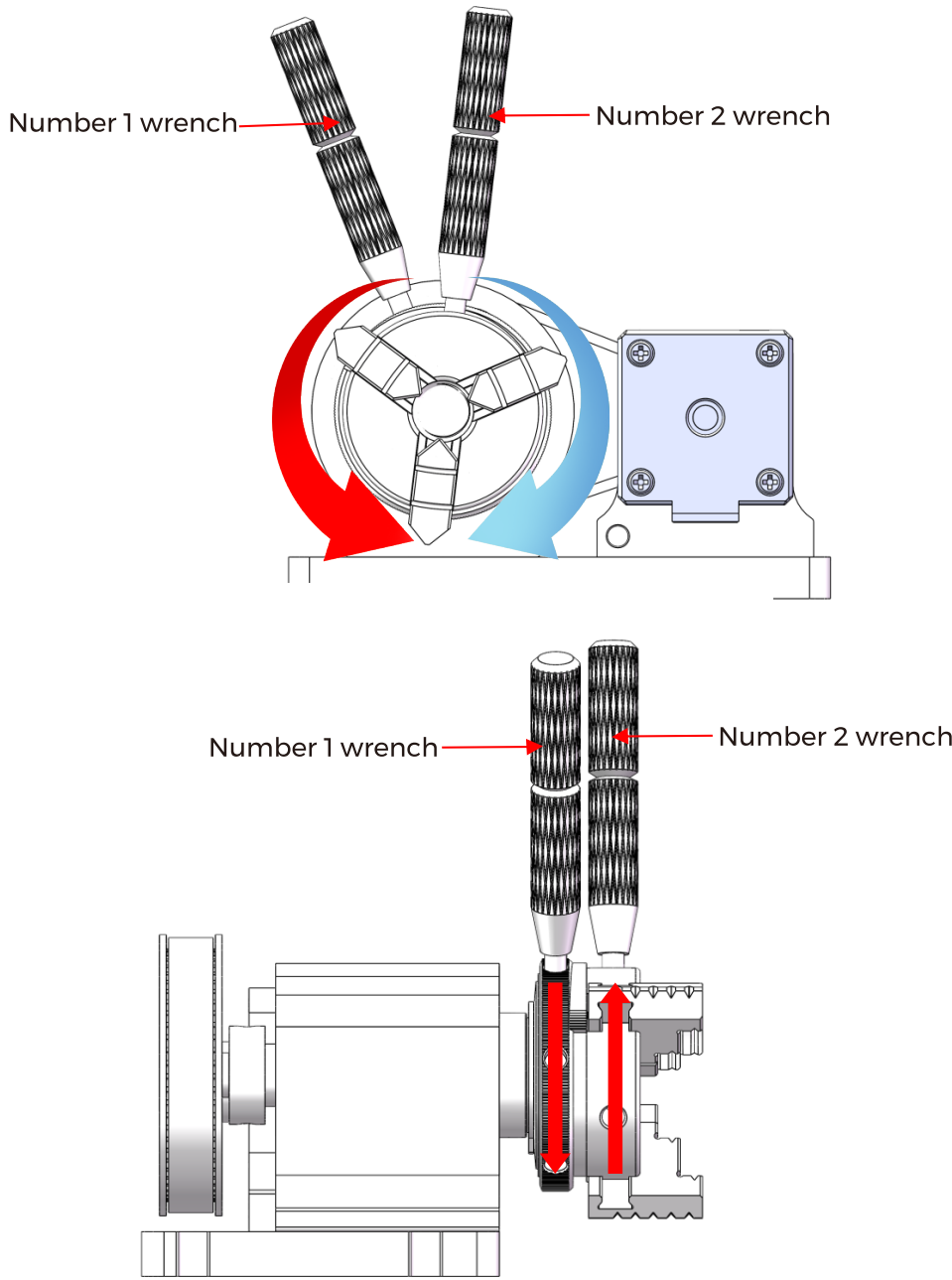


By loosening the screw in the tailstock kit, the thimble can be moved back and forth as a whole to the desired position. After moving to the position, you need to tighten the screws again to fix them.



Instructions for using chuck machine

When the No.1 wrench rotates counterclockwise and the No.2 wrench rotates clockwise, the chuck plate can be relaxed on the contrary clamp.



Instructions for Pulse Setting 1

Pulse calculation formula: (pulse number of motor in one turn x driving subdivision x subtraction ratio)/cylinder circumference. The number of pulses in one cycle of the motor contained in the kit: 200; Subtraction ratio: 4: 1

Example: The number of pulses and the subtraction ratio of the motor are fixed, and the number of pulses of the motor is 200. The subtraction ratio is 4: 1. Take TTC450 motherboard as an example. The diameter of the cylinder is 50mm. So $(200 \times 16 \times 4) / 157 \approx 81.53$. The pulse number is 81.53.

Circumference of cylinder = $2 \times \pi \times \text{radius}$
If there is inexhaustible division, take two decimal places
 $(200 \times 16 \times 4) / 157 \approx 81.53$
Depending on your own motherboard
Subtractive ratio
The motor step angle is 1.8°
It takes 360 to turn around
So the step angle is $360 / 1.8 = 200$

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Instructions for Pulse Setting 2

Modify the pulse with CANDLE control software.
Step 1: Connect the machine.
Step 2: Enter the \$\$ symbol in the lower right corner of the software and call the machine parameters.
Step 3: Enter \$101 = 80 and click Send.
Step 3: Enter the \$\$ symbol again to see if the change is complete. If the parameter changes, the change is successful.



Note: The example in the picture is the Y-axis, \$100 is the X-axis pulse, and \$101 is the Y-axis pulse.