

DRO PROS 3M CHEAT SHEET

Set current position to zero

Switch display between inches and metric

Set Current Position to a set value

Finding the centerpoint of a workpiece

Position your tool against an edge Reposition against opposite edge Move table to 0.0000

Switch between ABS and INC mode:

Enter / exit calculator function

Result Transfer

Compute desired value Transfer result to X axis Move table to 0.0000

SDM Entry

Move table to desired point Zero X and Y

Find REF

Arrow until = "FIND REF" Push Axis to find Move table until digits count

Recall 0

Arrow until = "RECALL 0" Push Axis to find Move table until digits count

Linear Hole Tool Position

Enter angle Enter Distance Enter Holes

Incline Tool Position

Enter angle Zero the X Axis

Bolt Hole Circle

Enter Center coord's Enter Diameter
Enter # Hole's Start Angle End Angle

Smooth ARC

Select Work Plane "R - XZ" Center coord's
ARC radius Start coord's
End Point Tool Diameter
Tool Radius R + TOOL

Simple ARC

Select Work Plane "S.R - XZ" Select ARC Type
Select Radius Select Tool Diameter

Parameters Setup

QUIT ⇒ AXIS NO. ⇒ DIRECTN ⇒ RESOLU ⇒ RAD/DIA ⇒ LIN COMP ⇒
NLERROR ⇒ Z DIAL ⇒ DIAL INC ⇒ R MODE ⇒ FLTR. PR ⇒ QUIT ⇒