



Electronica EL300 Bolt Hole Circle Function

Congratulations on the purchase of your Electronica EL300 series mill kit. This article addresses how to perform the Bolt Hole Circle function.

In order to indicate the correct direction, the EL300 display assumes you have set your scales up as follows: As you cut from left to right on your workpiece (the mill table slides left) the X axis scale should count positive. As you cut from front to back on your workpiece (the mill table slides forward) the Y axis scale should also count positive. While the function will ultimately work with a non-std setup, the following explanations might appear contradictory if the assumed scale directions are not adhered to.

Bolt Hole Circle:

1. To access the Bolt Hole Circle function, start by pushing the "Fn" button. The display will read "SEL Fn".
2. Push the "MILL" button. The x axis display window will immediately read "b hoLE". Also note that "fn" should light on the bottom of the display window in red.
3. Push the "ent" key once. The x axis display window will read "0", and the y axis window will read "EntCnt0".
4. On the keypad, enter the x coordinate value of the center of the circle, followed by the "ent" key. The x axis display window will read "EntCnt1", and the y axis window will read "0".
5. On the keypad, enter the y coordinate value of the center of the circle, followed by the "ent" key. The x axis display window will read "rAdiUS", and the y axis window will read "0".
6. On the keypad, enter the desired radius value of the circle, followed by the "ent" key. The x axis display window will read "AnGLE", and the y axis window will read "0".
7. On the keypad, enter the desired starting angle of the circle, followed by the "ent" key. The x axis display window will read "hoLES", and the y axis window will read "0".
8. On the keypad, enter the desired number of holes, followed by the "ent" key. The x and y axis display windows will both have an extra leading decimal on the far left of the display window, which is a visual reminder you are in a function mode.
 - The "distance to go" to hole position 1 is displayed on the x and y axis windows.
 - To proceed to hole position 1, move your mill such that the x and y windows "zero out".
 - To sequentially advance to the next hole position, push the #6 key.
 - To sequentially return to the previous hole position, push the #4 key.
 - To advance to the hole position of your choice, push the #2 key, then enter the desired hole position number on the keypad, followed by the "ent" key.
 - To check which hole the display is currently indicating, push the #8 key. To return to the normal screen, push the #8 key a second time.
9. To exit the Bolt Hole Circle function, push the "C" button.

Congratulations, you've now accomplished Bolt Hole Circle!

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