WR-84V with Wiehong CONTROLLER QUICK REFERENCE GUIDE

Set X, Y Origin

- ➢ → Y+ 8 Y− 2 X− 4 X+ 6 to move to desired location for origin
- ➢ → XY=0 Z=0 location is now saved

Set Z Origin

- ➢ → Z− 3 lower tool approx. 1” above workpiece.
- ➢ → Place C.A.D. disk on workpiece directly under the tool → Shift + , release.
- ➢ Tool will lower to touch off on disk; Z origin is now set.

Adjust Speed During the Cut

- ➢ Spindle → Shift + 7 or 1 one step with each compound press. Will display on 1Y row as: F# (F0 -F7)

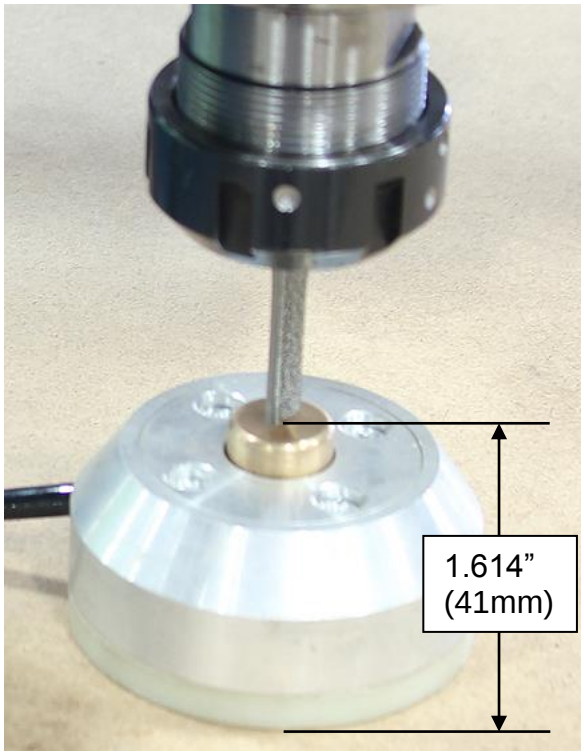
Feedrate → 7 or 1 10% change with each press. Will display on bottom row as: % (0% - 120%)

Load and Run Program

- ➢ Insert USB → → Udisk file OK
- ➢ → → highlight desired program
- ➢ → OK to select → 1 to load.
- ➢ → to start program.
- ➢ → to pause cut, ESC to stop cut.
- ➢ → Shift + restart at current location and point in program.
- ➢ → restart from beginning of program.

Setting the Z origin point

1. Install the desired bit into the spindle.
2. Move the spindle over the highest point of the workpiece to be machined.
3. Place the CAD disk on the material directly under the tip of the bit (will require it to be held in position)
4. Press the compound keys of Shift + and release at the same time to access the C.A.D function.
5. The Z axis will lower slowly. When it reaches the C.A.D., it will go up slightly. The Z axis working origin (zero point) is now set.
6. **Note:** Be prepared to press the ESC key if needed. Pressing the ESC key will cancel the C.A.D. function and no Z zero position will be recorded.



Single Key Functions

Key icon	Key name	Function
	Override+	Increase of feed rate override (This will increase the feed rate at 10% increments to a maximum of 120% of the set feed rate.); Input of number 7; Increase of spindle speed with the help of auxiliary key when spindle port has input.
	Y+	Positive shift of Y axis; input of number 8; switch between MCS and WCS with the help of auxiliary key.
	Z+	Positive shift of Z axis; input of number 9.
	X-	Negative shift of X axis; input of number 4; returning to mechanical origin (Home) with the help of auxiliary key.
	Spindle start/stop	Start or stop of spindle under manual mode; input of number 5; back to workpiece origin with the help of auxiliary key.
	X+	Positive shift of X axis; input of number 6.
	Override-	Decrease of feed rate override (This will decrease the feed rate at 10% increments to zero [travel stopped].); Input of number 1; Decrease of spindle speed with the help of auxiliary key when spindle port has input.
	Y-	Negative shift of Y axis; input of number 2.
	Z-	Negative shift of Z axis; input of number 3.
	Speed switchover	Switch between manual high/low speed; input of number 0; Tool touch-off setting with the help of auxiliary key.
	Setting origin	Sets (zeros) the workpiece origin of X and Y axes; Input of minus; Sets (zeros) the origin of Z axis with the help of auxiliary key.
	Menu	Entering menu page; input of decimal point; entering image update page at the time of system start-up.
	Start	Start key; breakpoint resuming with the help of auxiliary key.
	Up	Suspend (pause) processing; Up direction key. Moves the cursor up in the various menus.
	ESC	Stop processing; cancellation of various selections, inputs and operations.
	Shift	Auxiliary key
	Down	Down direction key. Moves the cursor down in the various menus.
	OK	Entering manual high/low speed adjustment page under menu page; confirmation of various selections, inputs and operations

Combination Key Functions

Use as follows: press the first key then the second; release the two keys simultaneously after the corresponding content appears.

Key icon	Function
Shift + 	Increase of spindle speed (rpm)
Shift + 	Switch between WCS and MCS
Shift + 	Back to mechanical origin (Homing all axes)
Shift + 	Back to workpiece origin
Shift + 	Decrease of spindle speed (rpm)
Shift + 	Tool Touch-off Setting (Sets the length of the bit.)
Shift + 	Z clear
Shift + 	Breakpoint resuming
Shift + 	Entering help page
Shift + 	Jiggle at pause