

# DC

## FUNCTION

**F**

All of operation for function starts from F key

- F**
- 1. LATHE : Summing function for lathe (38p)
  - 2. CIRCLE : Bolt hole circle (22 ~ 24p)
  - 3. SCALE : Changing resolution
  - 4. DIR : Changing processing direction
  - 5. RATE : Rate, Correction or Compensation.
  - 6. DIA : Double counting for lathe (39 ~ 40p)
  - 7. RESET: Initializing function
  - 8. TEST: FND (Flexible Numeric Display) testing

# 1. Changing resolution (SCALE)

1) 5/1000mm (3.SCALE)  
(0.0002 inch)

<p><b>F</b> → <b>▶</b> → <b>▶</b> → <b>ENT</b> → <b>X</b> → <b>ENT</b> → <b>5</b> → <b>ENT</b></p>		<p>After applying new resolution, 0.000 will be displayed. Resolution should be set according to the scale's resolution</p>
<p><b>F</b> <b>▶</b> <b>▶</b> (Double)</p>	<p>X 35cALE Y 0.0000 Z 0.0000 INCH/EUN</p>	
<p><b>ENT</b></p>	<p>X 35cALE Y SEL RH 15 Z 0.0000 INCH/EUN</p>	
<p><b>X</b></p>	<p>X 5.0000 Y SEL RH 15 Z 0.0000 INCH/EUN</p>	
<p><b>ENT</b></p>	<p>X 5.0000 Y SEL RH 15 Z 0.0000 INCH/EUN</p>	
<p><b>5</b></p>	<p>X 5.0000 Y SEL RH 15 Z 0.0000 INCH/EUN</p>	
<p><b>ENT</b></p>	<p>X 0.0000 Y 0.0000 Z 0.0000 INCH</p>	

2) 1/1000mm (3.ScALE)  
 (0.00004 inch)

F → [▶] → [▶] → ENT → X → ENT → 1 → ENT

After applying new resolution, 0.000 will be displayed.  
 Resolution should be set according to the scale's resolution

F [▶] [▶]  
 (Double)

X 35cALE  
 Y 00000  
 Z 00000  
 INCH/FUN

ENT

X 35cALE  
 Y SEL RH 15  
 Z 00000  
 INCH/FUN

X

X 5.0000  
 Y SEL RH 15  
 Z 00000  
 INCH/FUN

ENT

X 5.0000  
 Y SEL RH 15  
 Z 00000  
 INCH/FUN

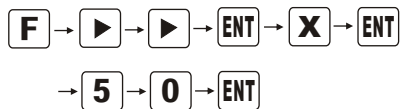
1

X 10000  
 Y SEL RH 15  
 Z 00000  
 INCH/FUN

ENT

X 0.0000  
 Y 0.0000  
 Z 0.0000  
 INCH

3) 5/100mm (3.ScALE)  
(0.002 inch)



After applying new resolution, 0.000 will be displayed.  
Resolution should be set according to the scale's resolution

F [▶] [▶]  
(Double)

X 35cALE  
Y 00000  
Z 00000  
INCH/EUN

ENT

X 35cALE  
Y SEL RH 15  
Z 00000  
INCH/EUN

X

X 5.0000  
Y SEL RH 15  
Z 00000  
INCH/EUN

ENT

X 5.0000  
Y SEL RH 15  
Z 00000  
INCH/EUN

5 0

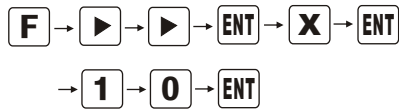
X 500000  
Y SEL RH 15  
Z 00000  
INCH/EUN

ENT

X 00000  
Y 00000  
Z 00000  
INCH

4) 1/100mm (3.ScALE)

(0.0004 inch)



After applying new resolution, 0.000 will be displayed.  
Resolution should be set according to the scale's resolution

F ▶ ▶  
(Double)

X 35cALE  
Y 00000  
Z 00000  
INCH/EUN

ENT

X 35cALE  
Y SEL RH 15  
Z 00000  
INCH/EUN

X

X 5.0000  
Y SEL RH 15  
Z 00000  
INCH/EUN

ENT

X 5.0000  
Y SEL RH 15  
Z 00000  
INCH/EUN

1 0

X 10.0000  
Y SEL RH 15  
Z 00000  
INCH/EUN

ENT

X 0.0000  
Y 00000  
Z 00000  
INCH

## 2. Changing direction (4.dlr)

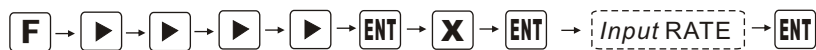
	<p>Processing direction can be changed as below Left (+), Right(-) → Left (-), Right (+)</p>								
<p><b>F</b>  (3 times)</p>	<table border="1"> <tr><td>X</td><td>4d 1r</td></tr> <tr><td>Y</td><td>00000</td></tr> <tr><td>Z</td><td>00000</td></tr> <tr><td colspan="2" style="text-align: center;">INCH/EUN</td></tr> </table>	X	4d 1r	Y	00000	Z	00000	INCH/EUN	
X	4d 1r								
Y	00000								
Z	00000								
INCH/EUN									
<p><b>ENT</b></p>	<table border="1"> <tr><td>X</td><td>4d 1r</td></tr> <tr><td>Y</td><td>SEL RH 15</td></tr> <tr><td>Z</td><td>00000</td></tr> <tr><td colspan="2" style="text-align: center;">INCH/EUN</td></tr> </table>	X	4d 1r	Y	SEL RH 15	Z	00000	INCH/EUN	
X	4d 1r								
Y	SEL RH 15								
Z	00000								
INCH/EUN									
<p><b>X</b></p>	<table border="1"> <tr><td>X</td><td>d 1r ---]</td></tr> <tr><td>Y</td><td>SEL RH 15</td></tr> <tr><td>Z</td><td>00000</td></tr> <tr><td colspan="2" style="text-align: center;">INCH/EUN</td></tr> </table>	X	d 1r ---]	Y	SEL RH 15	Z	00000	INCH/EUN	
X	d 1r ---]								
Y	SEL RH 15								
Z	00000								
INCH/EUN									
<p> } </p>	<table border="1"> <tr><td>X</td><td>d 1r [----</td></tr> <tr><td>Y</td><td>SEL RH 15</td></tr> <tr><td>Z</td><td>00000</td></tr> <tr><td colspan="2" style="text-align: center;">INCH/EUN</td></tr> </table>	X	d 1r [----	Y	SEL RH 15	Z	00000	INCH/EUN	
X	d 1r [----								
Y	SEL RH 15								
Z	00000								
INCH/EUN									
<p><b>ENT</b></p>	<table border="1"> <tr><td>X</td><td>00000</td></tr> <tr><td>Y</td><td>00000</td></tr> <tr><td>Z</td><td>00000</td></tr> <tr><td colspan="2" style="text-align: center;">INCH</td></tr> </table>	X	00000	Y	00000	Z	00000	INCH	
X	00000								
Y	00000								
Z	00000								
INCH									

### 3. Rate or Correction (5.rAtE)

<p> <b>F</b> → <b>▶</b> → <b>▶</b> → <b>▶</b> → <b>▶</b> → <b>ENT</b> → <b>X</b> → <b>ENT</b>          → <span style="border: 1px dashed black; padding: 2px;">Input RATE</span> → <b>ENT</b> </p>	<ul style="list-style-type: none"> <li>In case measured distance(value) is different from real distance.</li> <li>Initial value from factory is "1.000000".</li> <li>Input range is 0.000001~9.999999.</li> <li>If 0.000000 is set, there will not be displayed anything but "0".</li> </ul>								
<p> <b>F</b> <b>▶</b> <b>▶</b> <b>▶</b> <b>▶</b>          (4 times)       </p>	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td style="text-align: right;">X</td><td>5.rAtE</td></tr> <tr><td style="text-align: right;">Y</td><td>00000</td></tr> <tr><td style="text-align: right;">Z</td><td>00000</td></tr> <tr><td colspan="2" style="text-align: center;">INCH/FUN</td></tr> </table>	X	5.rAtE	Y	00000	Z	00000	INCH/FUN	
X	5.rAtE								
Y	00000								
Z	00000								
INCH/FUN									
<p><b>ENT</b></p>	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td style="text-align: right;">X</td><td>5.rAtE</td></tr> <tr><td style="text-align: right;">Y</td><td>SEL RH IS</td></tr> <tr><td style="text-align: right;">Z</td><td>00000</td></tr> <tr><td colspan="2" style="text-align: center;">INCH/FUN</td></tr> </table>	X	5.rAtE	Y	SEL RH IS	Z	00000	INCH/FUN	
X	5.rAtE								
Y	SEL RH IS								
Z	00000								
INCH/FUN									
<p><b>X</b></p>	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td style="text-align: right;">X</td><td>1000000</td></tr> <tr><td style="text-align: right;">Y</td><td>SEL RH IS</td></tr> <tr><td style="text-align: right;">Z</td><td>00000</td></tr> <tr><td colspan="2" style="text-align: center;">INCH/FUN</td></tr> </table>	X	1000000	Y	SEL RH IS	Z	00000	INCH/FUN	
X	1000000								
Y	SEL RH IS								
Z	00000								
INCH/FUN									
<p><b>ENT</b></p>	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td style="text-align: right;">X</td><td>1000000</td></tr> <tr><td style="text-align: right;">Y</td><td>SEL RH IS</td></tr> <tr><td style="text-align: right;">Z</td><td>00000</td></tr> <tr><td colspan="2" style="text-align: center;">INCH/FUN</td></tr> </table>	X	1000000	Y	SEL RH IS	Z	00000	INCH/FUN	
X	1000000								
Y	SEL RH IS								
Z	00000								
INCH/FUN									
<p><span style="border: 1px dashed black; padding: 2px;">Input RATE</span></p>	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td style="text-align: right;">X</td><td>1000000</td></tr> <tr><td style="text-align: right;">Y</td><td>SEL RH IS</td></tr> <tr><td style="text-align: right;">Z</td><td>00000</td></tr> <tr><td colspan="2" style="text-align: center;">INCH/FUN</td></tr> </table>	X	1000000	Y	SEL RH IS	Z	00000	INCH/FUN	
X	1000000								
Y	SEL RH IS								
Z	00000								
INCH/FUN									
<p><b>ENT</b></p>	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td style="text-align: right;">X</td><td>00000</td></tr> <tr><td style="text-align: right;">Y</td><td>00000</td></tr> <tr><td style="text-align: right;">Z</td><td>00000</td></tr> <tr><td colspan="2" style="text-align: center;">INCH</td></tr> </table>	X	00000	Y	00000	Z	00000	INCH	
X	00000								
Y	00000								
Z	00000								
INCH									

Input "1.000000" as a rate value

#### Correct or Compensation



Ex. 1

Real distance (100.000) / Measured distance (100.100) = 0.999000

Ex. 2

Real distance (100.000) / Measured distance (099.900) = 1.001001

REF.

Value from a check master or a block gauge  
 Value of display unit

Ex.3

Real distance = 100mm  
Measured distance = 100.4mm

$$\frac{100}{100.4} = 0.996015$$

**F** **▶** **▶** **▶** **▶**  
(4 times)

X	5rAtE
Y	00000
Z	00000

INCH/EUN

**ENT**

X	5rAtE
Y	SEL RH 15
Z	00000

INCH/EUN

**X**

X	1000000
Y	SEL RH 15
Z	00000

INCH/EUN

**ENT**

X	1000000
Y	SEL RH 15
Z	00000

INCH/EUN

**0** **.** **9** **9** **6** **0** **1** **5**

X	0996015
Y	SEL RH 15
Z	00000

INCH/EUN

**ENT**

X	00000
Y	00000
Z	00000

INCH



## 4.Reset function (7.rESEt)

### 1) ABS Reset (Delete ABS data)

<p> <span style="border: 1px solid black; padding: 2px;">F</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">ENT</span>              → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">ENT</span> </p>	<p>Be careful to use ABS reset, as this will delete all saved ABS data.</p>																																	
<p> <span style="border: 1px solid black; padding: 2px;">F</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span>              (6 times)         </p> <p><span style="border: 1px solid black; padding: 2px;">ENT</span></p> <p><span style="border: 1px solid black; padding: 2px;">ENT</span></p>	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 20px;">X</td> <td style="border: 1px solid black; padding: 2px;">7.rESEt</td> </tr> <tr> <td>Y</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td>Z</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td></td> <td style="text-align: center; font-size: small;">INCH/FUN</td> </tr> </table> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 20px;">X</td> <td style="border: 1px solid black; padding: 2px;">1.r5t Ab5</td> </tr> <tr> <td>Y</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td>Z</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td></td> <td style="text-align: center; font-size: small;">INCH/FUN</td> </tr> </table> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 20px;">X</td> <td style="border: 1px solid black; padding: 2px;">1.r5t Ab5</td> </tr> <tr> <td>Y</td> <td style="border: 1px solid black; padding: 2px;">-- 1n 1t --</td> </tr> <tr> <td>Z</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td></td> <td style="text-align: center; font-size: small;">INCH/FUN</td> </tr> </table> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 20px;">X</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td>Y</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td>Z</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td></td> <td style="text-align: center; font-size: small;">INCH</td> </tr> </table>	X	7.rESEt	Y	00000	Z	00000		INCH/FUN	X	1.r5t Ab5	Y	00000	Z	00000		INCH/FUN	X	1.r5t Ab5	Y	-- 1n 1t --	Z	00000		INCH/FUN	X	00000	Y	00000	Z	00000		INCH	<p>Move to No.7</p>
X	7.rESEt																																	
Y	00000																																	
Z	00000																																	
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X	1.r5t Ab5																																	
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Z	00000																																	
	INCH/FUN																																	
X	00000																																	
Y	00000																																	
Z	00000																																	
	INCH																																	

2) Program Reset (Delete all saved data)

<p> <span style="border: 1px solid black; padding: 2px;">F</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">ENT</span>              → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">ENT</span> </p>	<p>1) All saved data deleted and return factory setting;</p> <ul style="list-style-type: none"> <li>* Resolution : 5/100.</li> <li>* Bolt hole circle : set as X &amp; Y-axis, radius</li> <li>* Direction : the state from factory</li> <li>* Rate : 1.000000</li> <li>* Removal of double counting function</li> </ul>																																								
<p> <span style="border: 1px solid black; padding: 2px;">F</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span>              (6 times)         </p> <p><span style="border: 1px solid black; padding: 2px;">ENT</span></p> <p><span style="border: 1px solid black; padding: 2px;">▶</span></p> <p><span style="border: 1px solid black; padding: 2px;">ENT</span></p>	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%; text-align: right;">X</td> <td style="border: 1px solid black; padding: 2px;">7rESEt</td> </tr> <tr> <td style="text-align: right;">Y</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td style="text-align: right;">Z</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td></td> <td style="text-align: center; font-size: small;">INCH/EUN</td> </tr> </table> <p style="text-align: right; margin-top: 10px;">Move to No.7</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%; text-align: right;">X</td> <td style="border: 1px solid black; padding: 2px;">1r5t Abs</td> </tr> <tr> <td style="text-align: right;">Y</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td style="text-align: right;">Z</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td></td> <td style="text-align: center; font-size: small;">INCH/EUN</td> </tr> </table> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%; text-align: right;">X</td> <td style="border: 1px solid black; padding: 2px;">2r5t ALL</td> </tr> <tr> <td style="text-align: right;">Y</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td style="text-align: right;">Z</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td></td> <td style="text-align: center; font-size: small;">INCH/EUN</td> </tr> </table> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%; text-align: right;">X</td> <td style="border: 1px solid black; padding: 2px;">2r5t ALL</td> </tr> <tr> <td style="text-align: right;">Y</td> <td style="border: 1px solid black; padding: 2px;">-- in it --</td> </tr> <tr> <td style="text-align: right;">Z</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td></td> <td style="text-align: center; font-size: small;">INCH/EUN</td> </tr> </table> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%; text-align: right;">X</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td style="text-align: right;">Y</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td style="text-align: right;">Z</td> <td style="border: 1px solid black; padding: 2px;">00000</td> </tr> <tr> <td></td> <td style="text-align: center; font-size: small;">INCH</td> </tr> </table>	X	7rESEt	Y	00000	Z	00000		INCH/EUN	X	1r5t Abs	Y	00000	Z	00000		INCH/EUN	X	2r5t ALL	Y	00000	Z	00000		INCH/EUN	X	2r5t ALL	Y	-- in it --	Z	00000		INCH/EUN	X	00000	Y	00000	Z	00000		INCH
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	INCH																																								

## 5. Testing FND (8.tESt)

<p> <span style="border: 1px solid black; padding: 2px;">F</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> </p> <p>             → <span style="border: 1px solid black; padding: 2px;">ENT</span> → <span style="border: 1px solid black; padding: 2px;">CE</span> </p>	<p>Check FND (Flexible Numeric Display)</p>	
<p> <span style="border: 1px solid black; padding: 2px;">F</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> </p> <p>(7 times)</p>	<p>             X <span style="border: 1px solid black; padding: 2px;">8.tESt</span>              Y <span style="border: 1px solid black; padding: 2px;">00000</span>              Z <span style="border: 1px solid black; padding: 2px;">00000</span>  <small>INCH/FUN</small> </p> <p>             X <span style="border: 1px solid black; padding: 2px;">11111111</span> •              Y <span style="border: 1px solid black; padding: 2px;">11111111</span> •              Z <span style="border: 1px solid black; padding: 2px;">11111111</span> •  <small>DIA INCH FUN REF ABS CIR 1 1</small> </p> <p>             X <span style="border: 1px solid black; padding: 2px;">00000</span>              Y <span style="border: 1px solid black; padding: 2px;">00000</span>              Z <span style="border: 1px solid black; padding: 2px;">00000</span>  <small>INCH/FUN</small> </p> <p> <span style="border: 1px solid black; padding: 2px;">CE</span> </p> <p>             X <span style="border: 1px solid black; padding: 2px;">00000</span>              Y <span style="border: 1px solid black; padding: 2px;">00000</span>              Z <span style="border: 1px solid black; padding: 2px;">00000</span>  <small>INCH</small> </p>	<p>Move to No.8</p> <p>During the test, all of the numbers changing from 1 to 8. This is repeated 3 times.</p> <p>To quit testing, push <span style="border: 1px solid black; padding: 2px;">CE</span> key.</p>