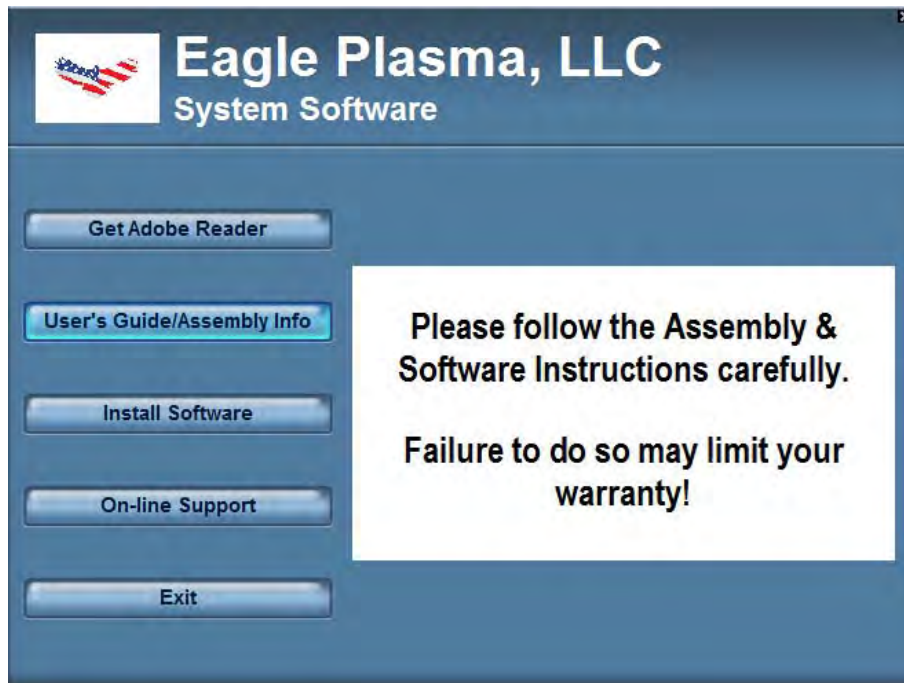
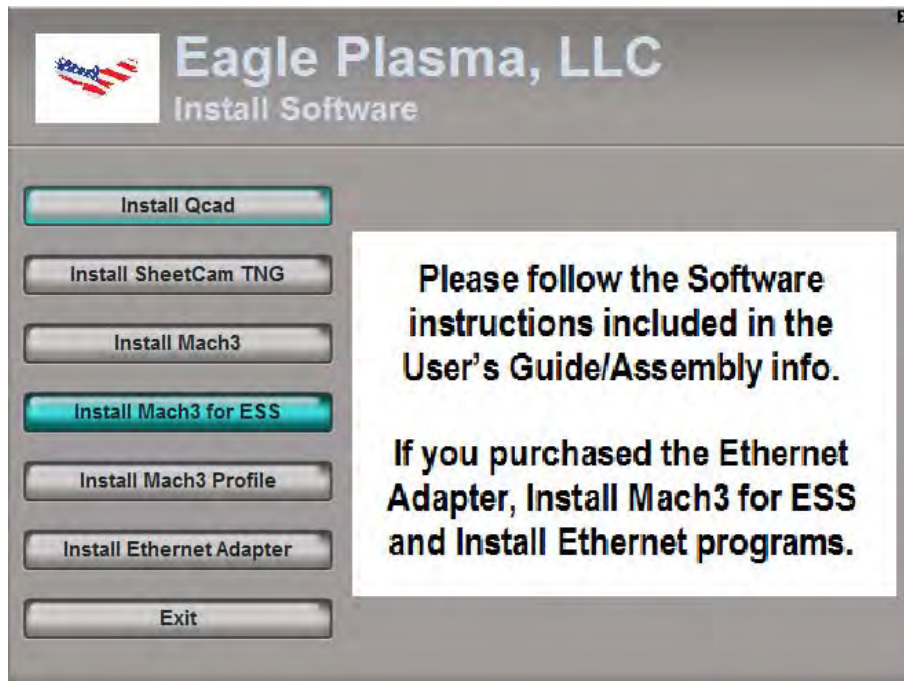


Installing Software – Qcad

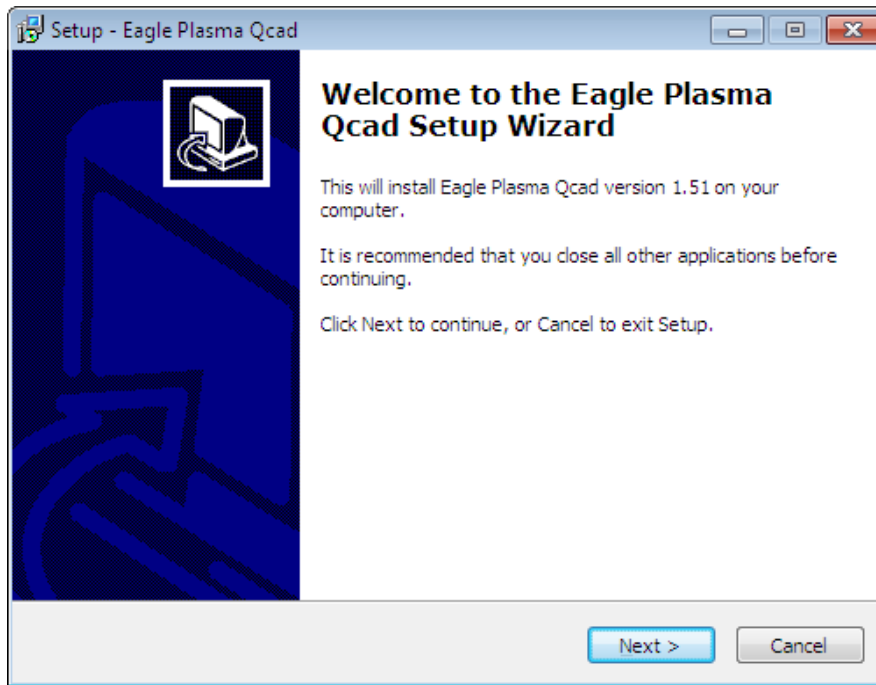


At the System Software Menu, select Install Software.



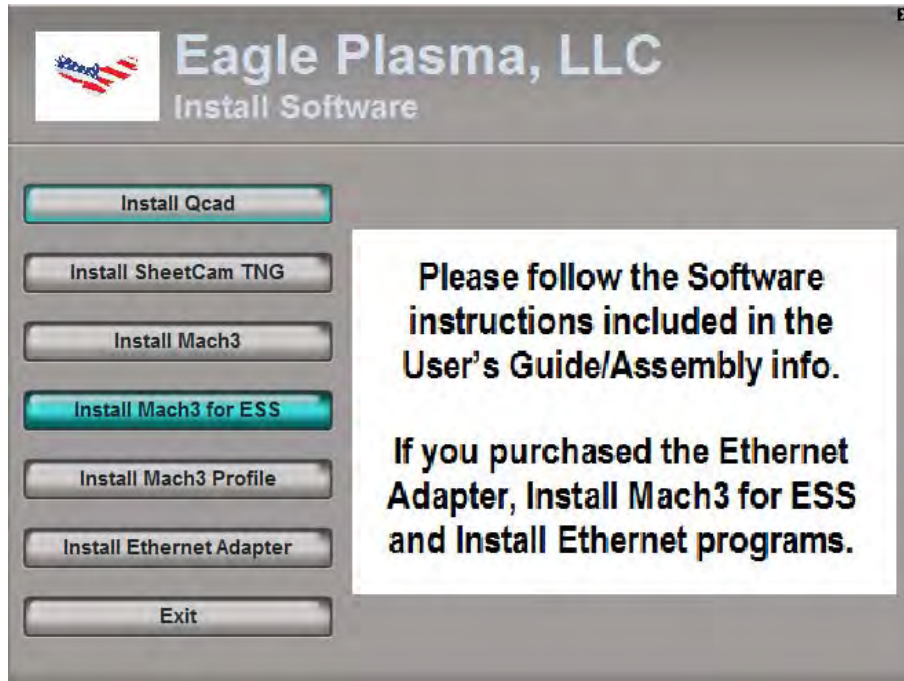
The Eagle Plasma Install Software menu will appear; select Qcad.

Installing Software – Qcad

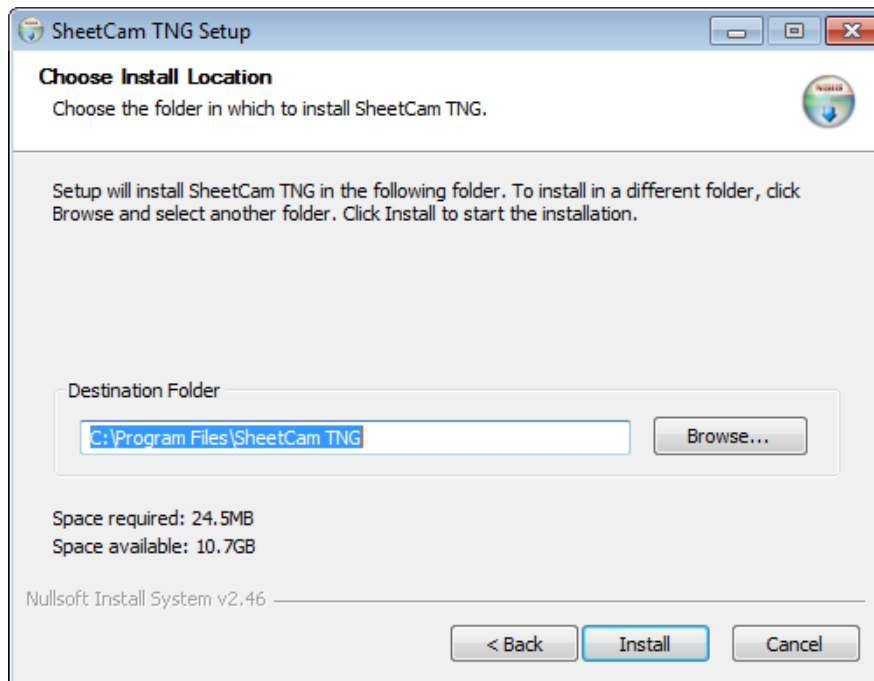


The Qcad Setup Wizard will appear; select Next, Next, Install. The Wizard will install the necessary files on your computer. Click Finish to exit the Wizard and return to the Install Software menu.

Installing Software – SheetCam

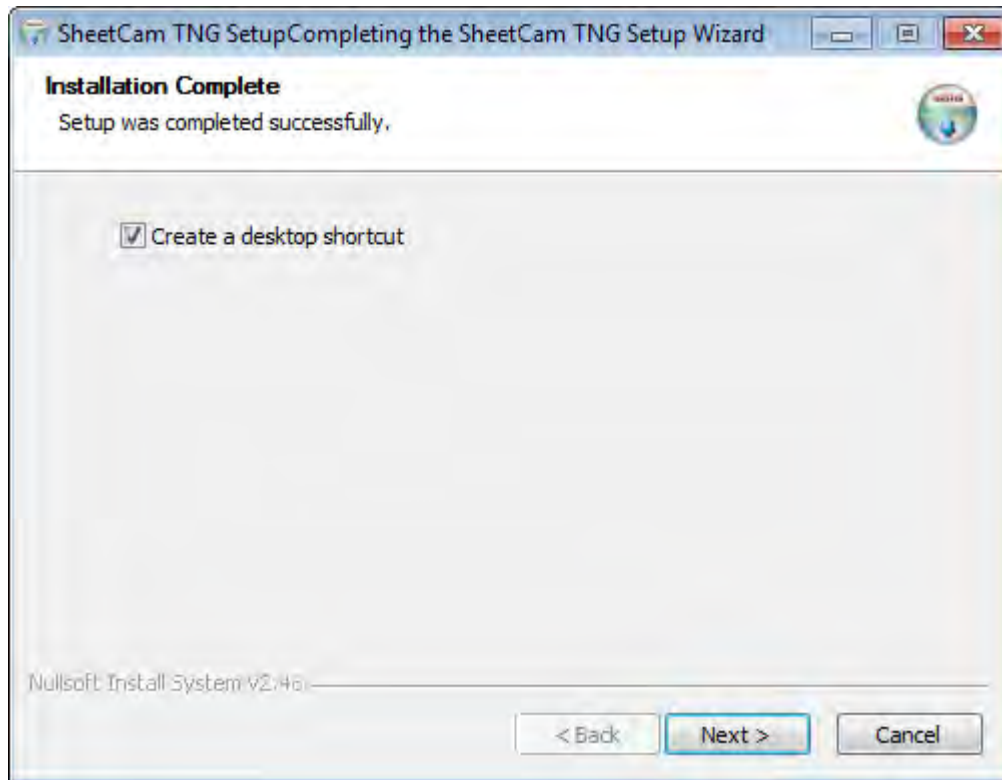


Select the SheetCam TNG button.

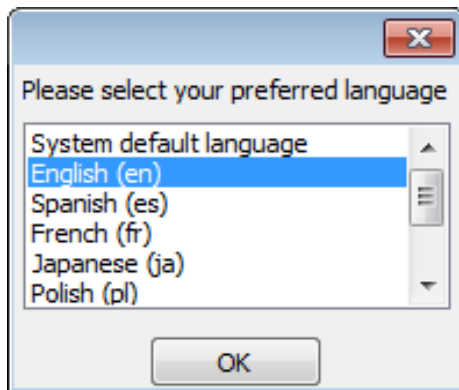


The SheetCam TNG Setup Wizard will appear; select Next, Install.

Installing Software – SheetCam

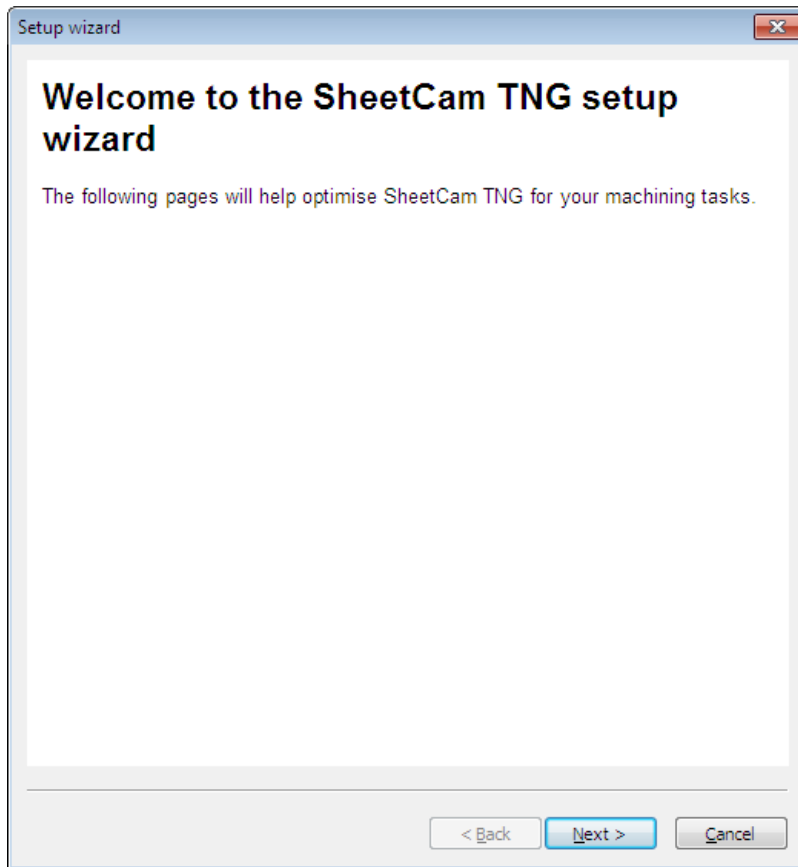


The Wizard will install the necessary files on your computer. Choose to add a desktop shortcut if you like; click Next, Click Finish to exit the Wizard and run SheetCam TNG.

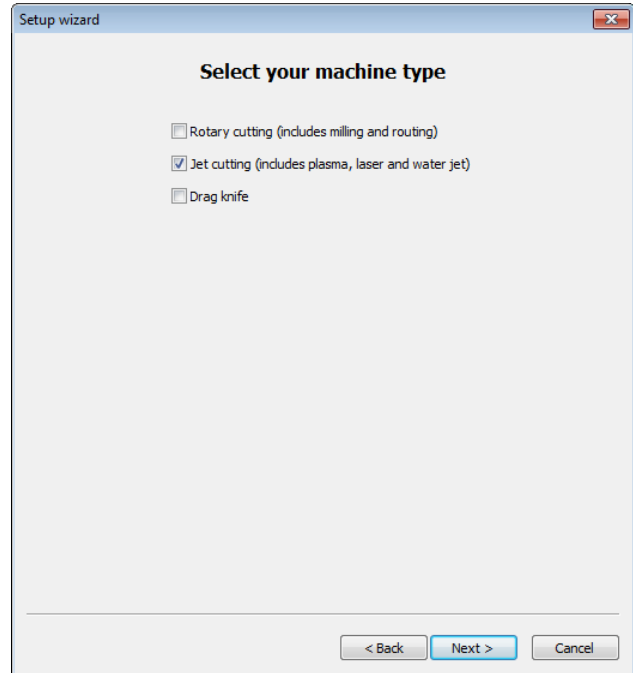
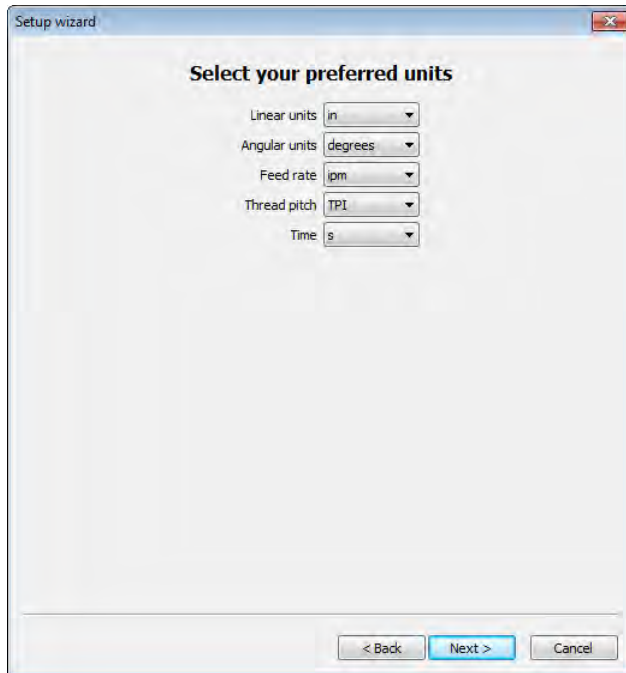


Select a language, click OK; click OK to accept the License Agreement.

Installing Software – SheetCam

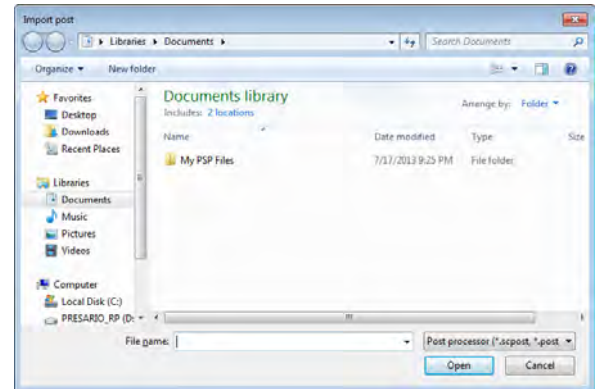
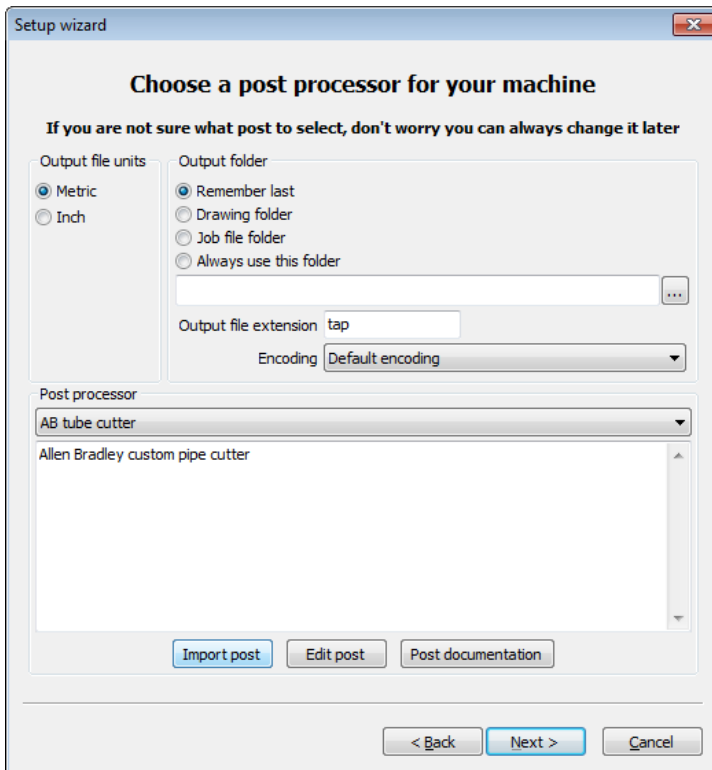


Another wizard will start; click Next to optimize SheetCam settings.

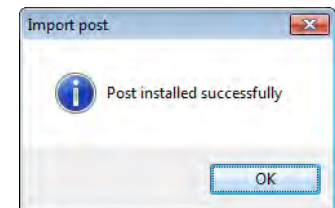
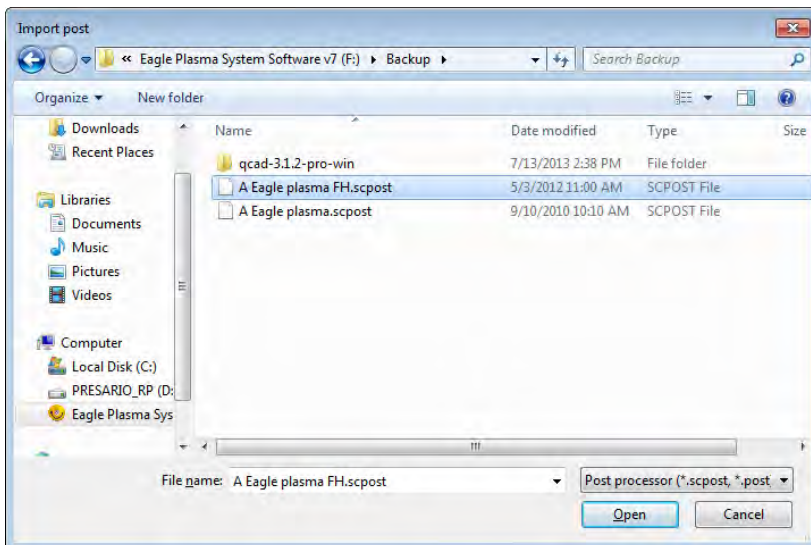


Click Next preserving the default units; select your Machine Type, click Next.

Installing Software – SheetCam

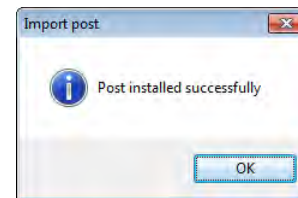
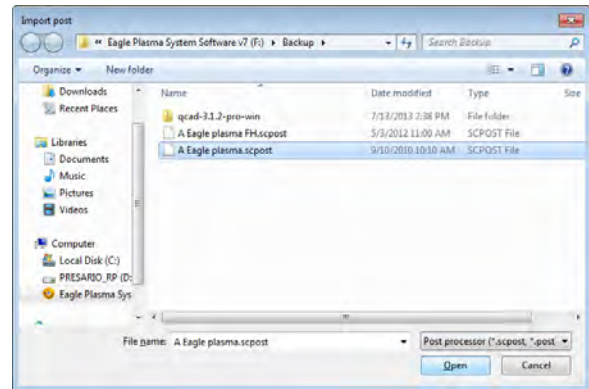
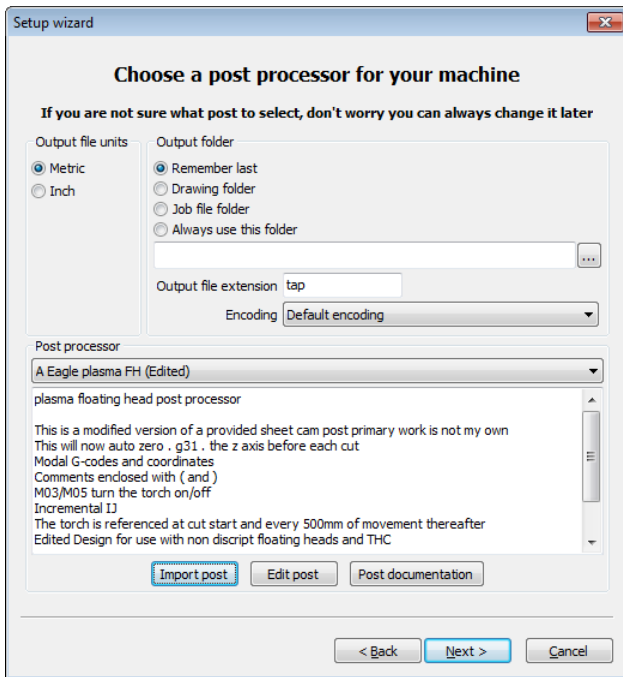


Select Import post; SheetCam will open the default PSP file location.

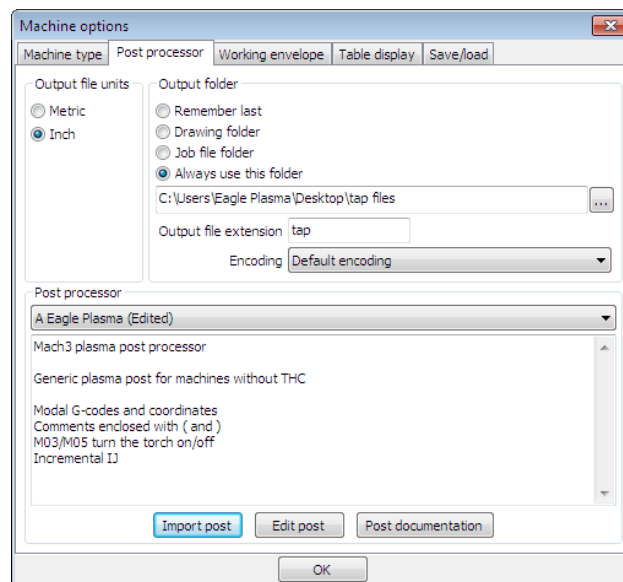


Navigate to Eagle Plasma System Software - Backup folder. Select the file A Eagle plasma FH.scpost; click Open; click OK.

Installing Software – SheetCam



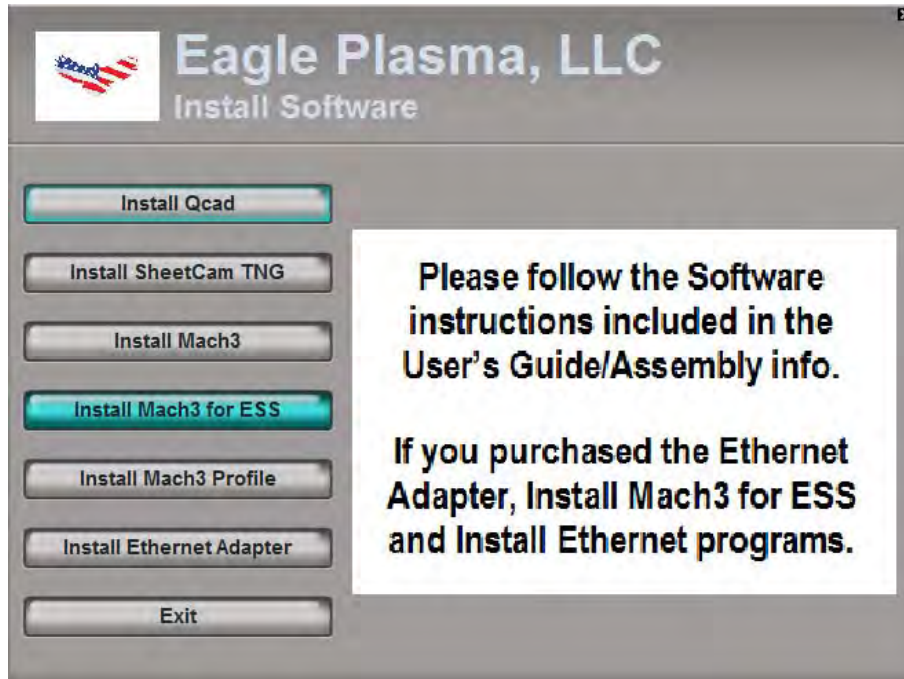
Select Import post; navigate to Eagle Plasma System Software – Backup – A Eagle Plasma.scpost; click Open; click OK.



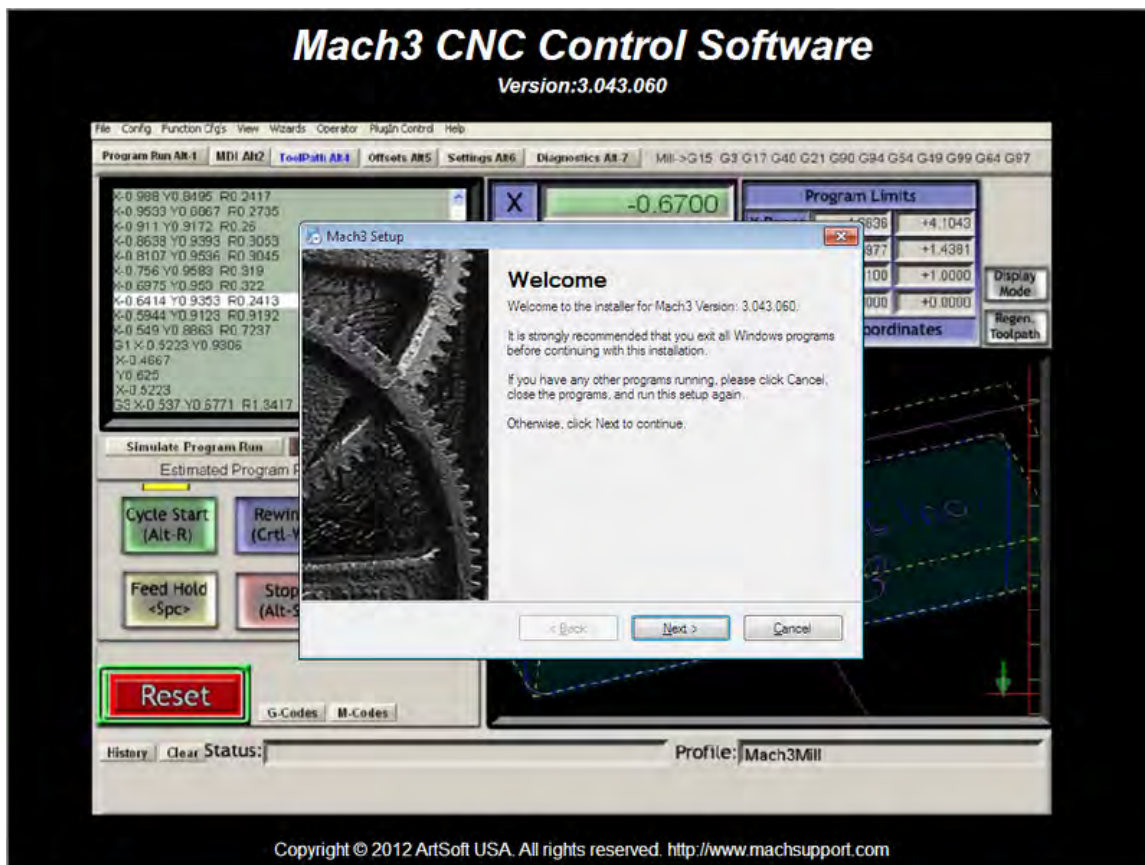
Select Inch for the Output file units. At this point it is a good idea to create an Output folder; select Always use this folder. I created a new folder on the Desktop and named it tap files. This extra step will save you the aggravation of trying to locate your output files. You can change these options at any time by selecting Options/Machine or Help/Setup Wizard.

At this point, you are using SheetCam TNG in Demo mode. Send an email request for license files to eagle.plasma@gmail.com and we will forward your license files for SheetCam & Mach3.

Installing Software – Mach3

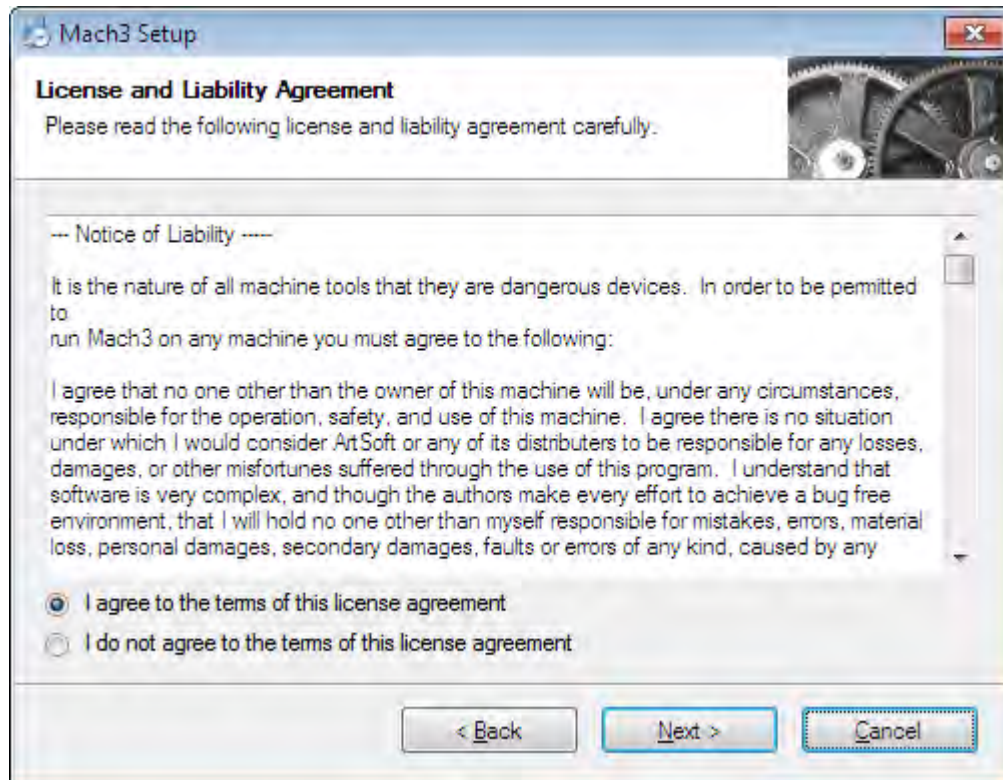


Select the Mach3 button. If you have purchased the Ethernet Adapter, choose Install Mach3 for ESS and follow those instructions.



You will see the Mach3 Setup screen. Press Enter from the keyboard or click the Next button with the mouse.

Installing Software – Mach3

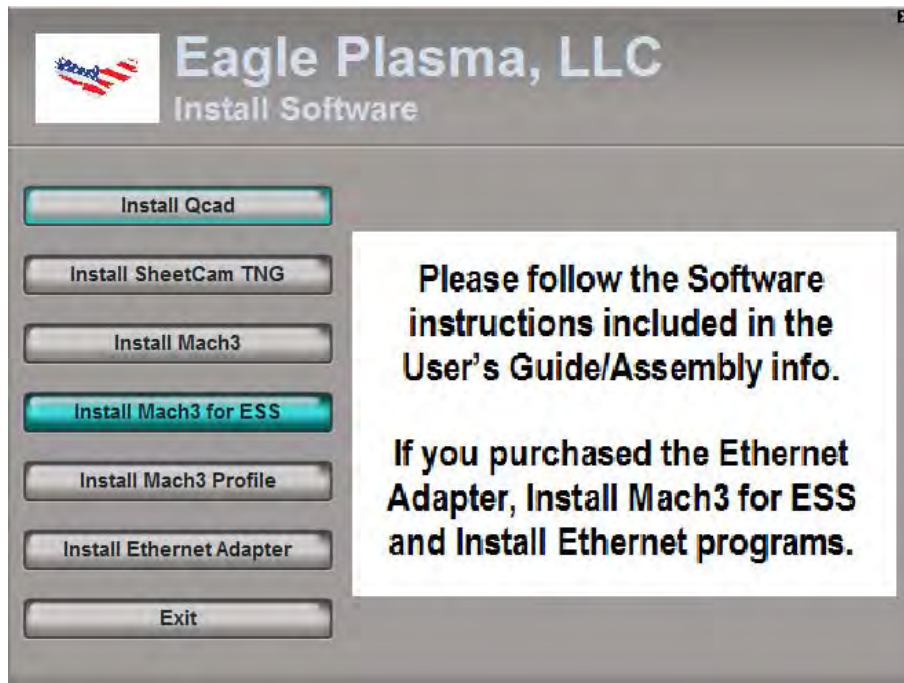


Accept the Licensing Agreement and continue the install using the default settings (Next, Next, Next, etc.).

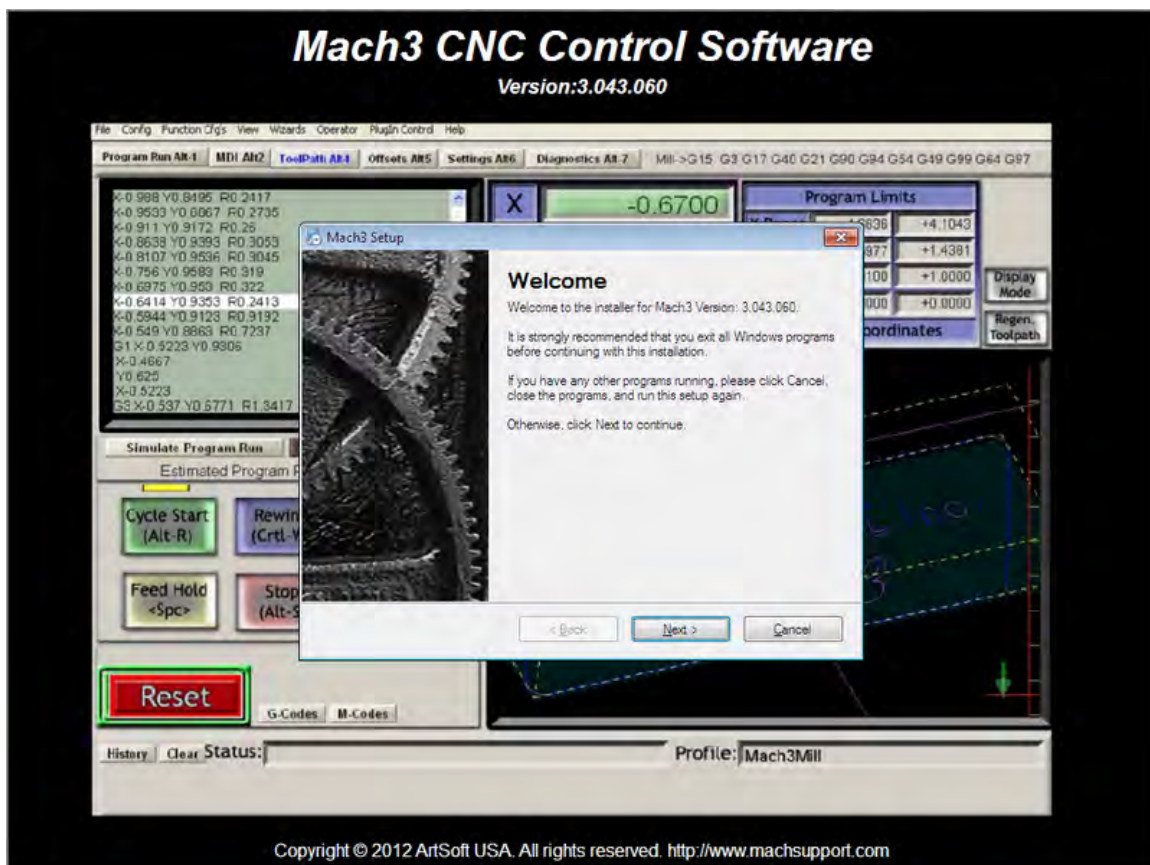


At this point Mach3 may try to Reboot your computer. You will need to return to the Eagle Plasma CD to install the Mach3 Profile.

Installing Software – Mach3 for ESS



Select the Install Mach3 for ESS button.

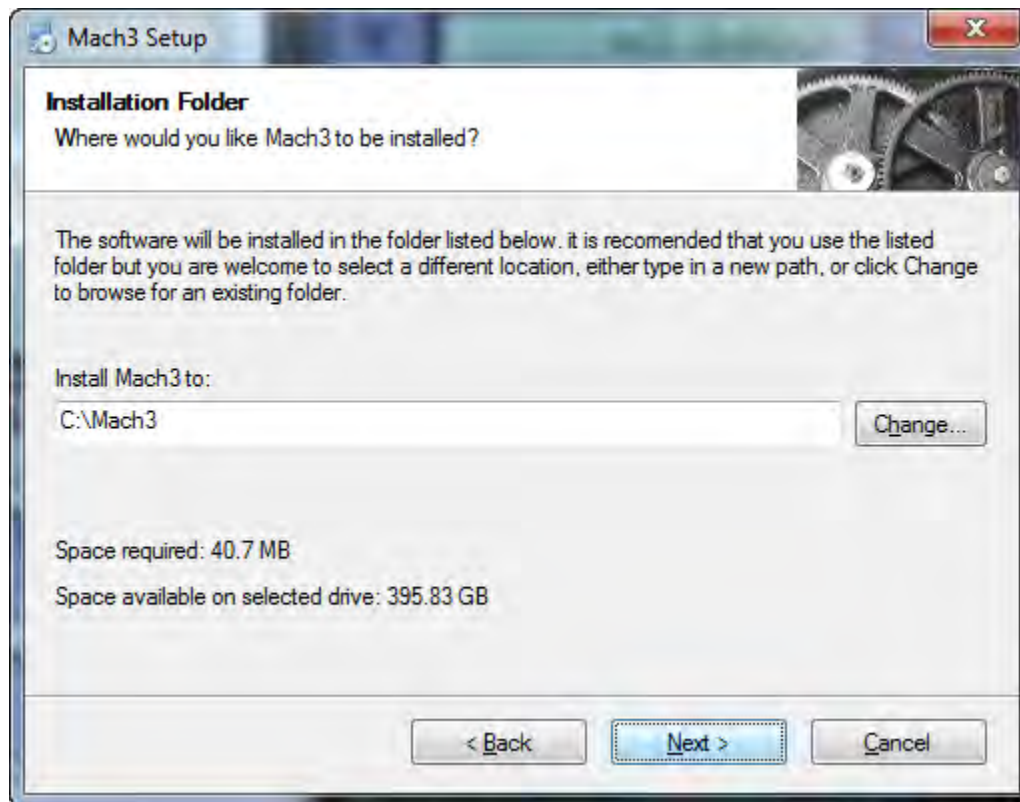


You will see the Mach3 Setup screen. Press Enter from the keyboard or click the Next button with the mouse.

Installing Software – Mach3 for ESS

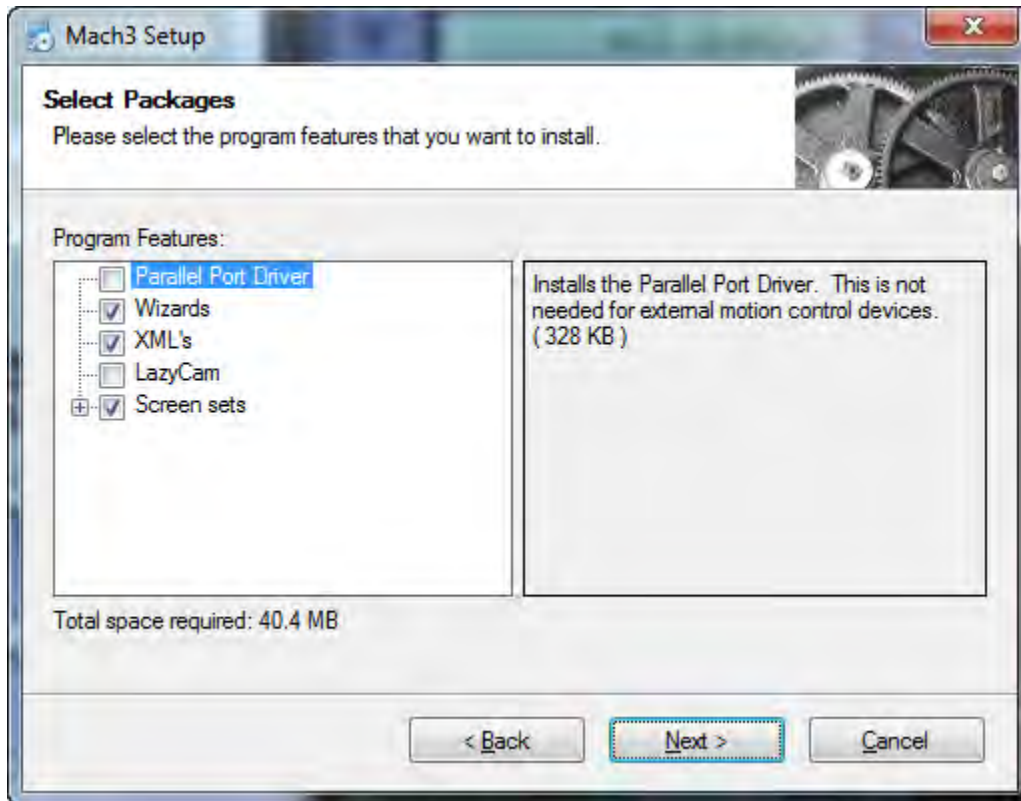


Accept the Licensing Agreement and continue the install (Next).

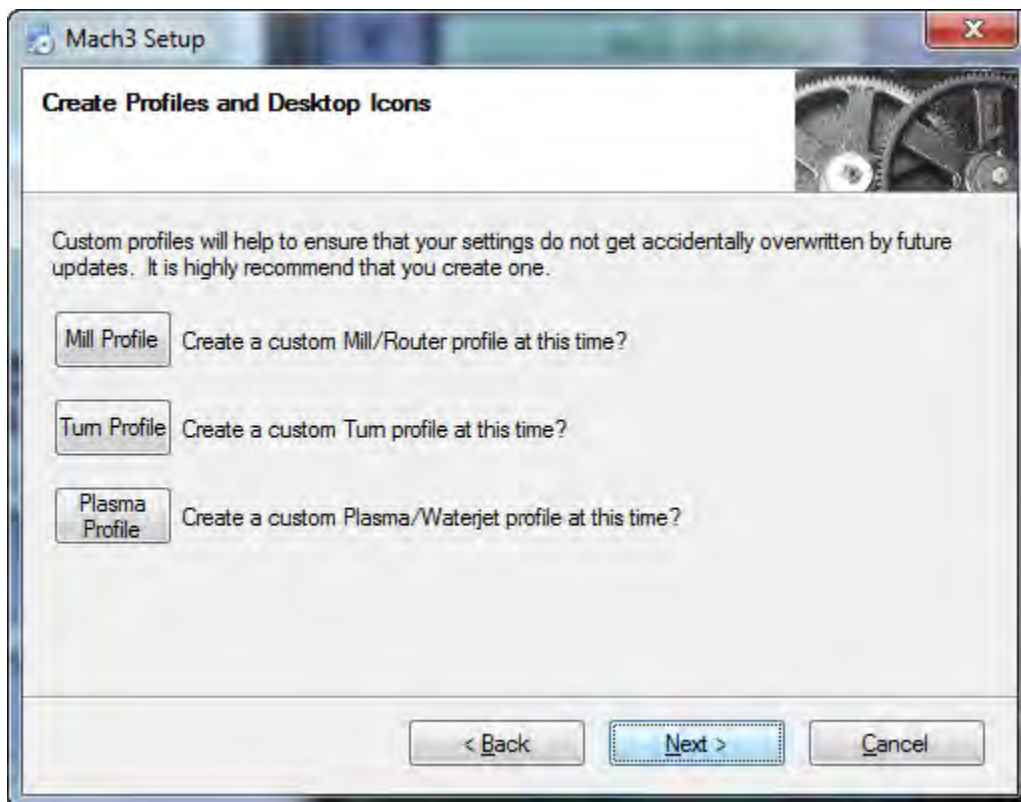


Install Mach3 to the default folder, click Next.

Installing Software – Mach3 for ESS

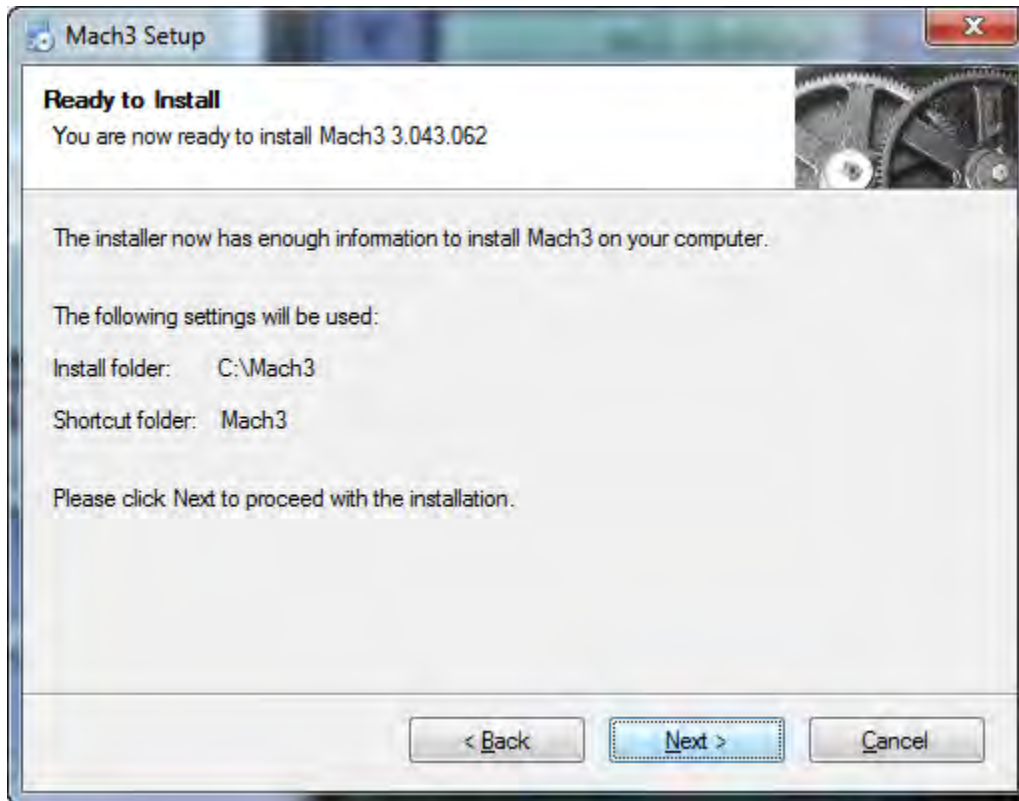


Do not install the Parallel Port Driver, click next.

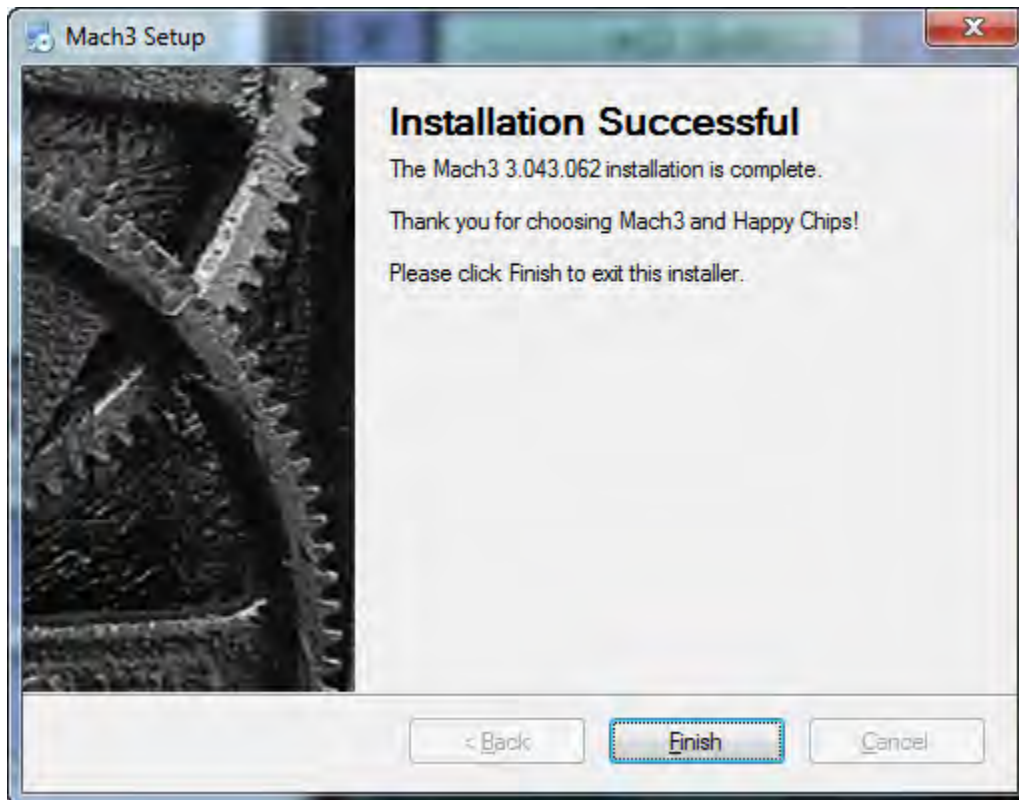


There is no need to create a profile. We will install the Eagle Plasma profile later.

Installing Software – Mach3 for ESS

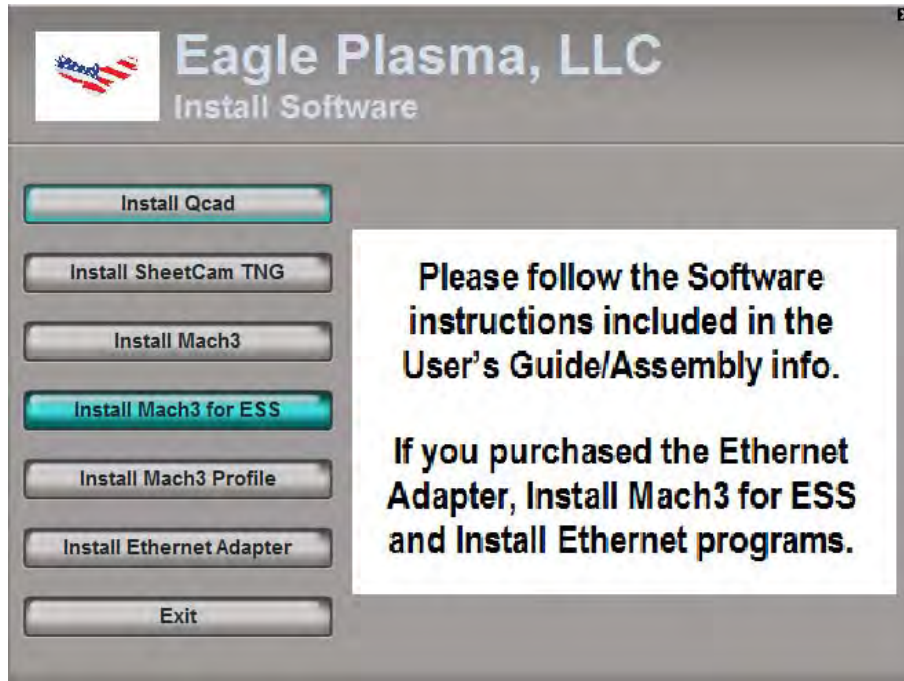


Select Next to proceed with the installation.

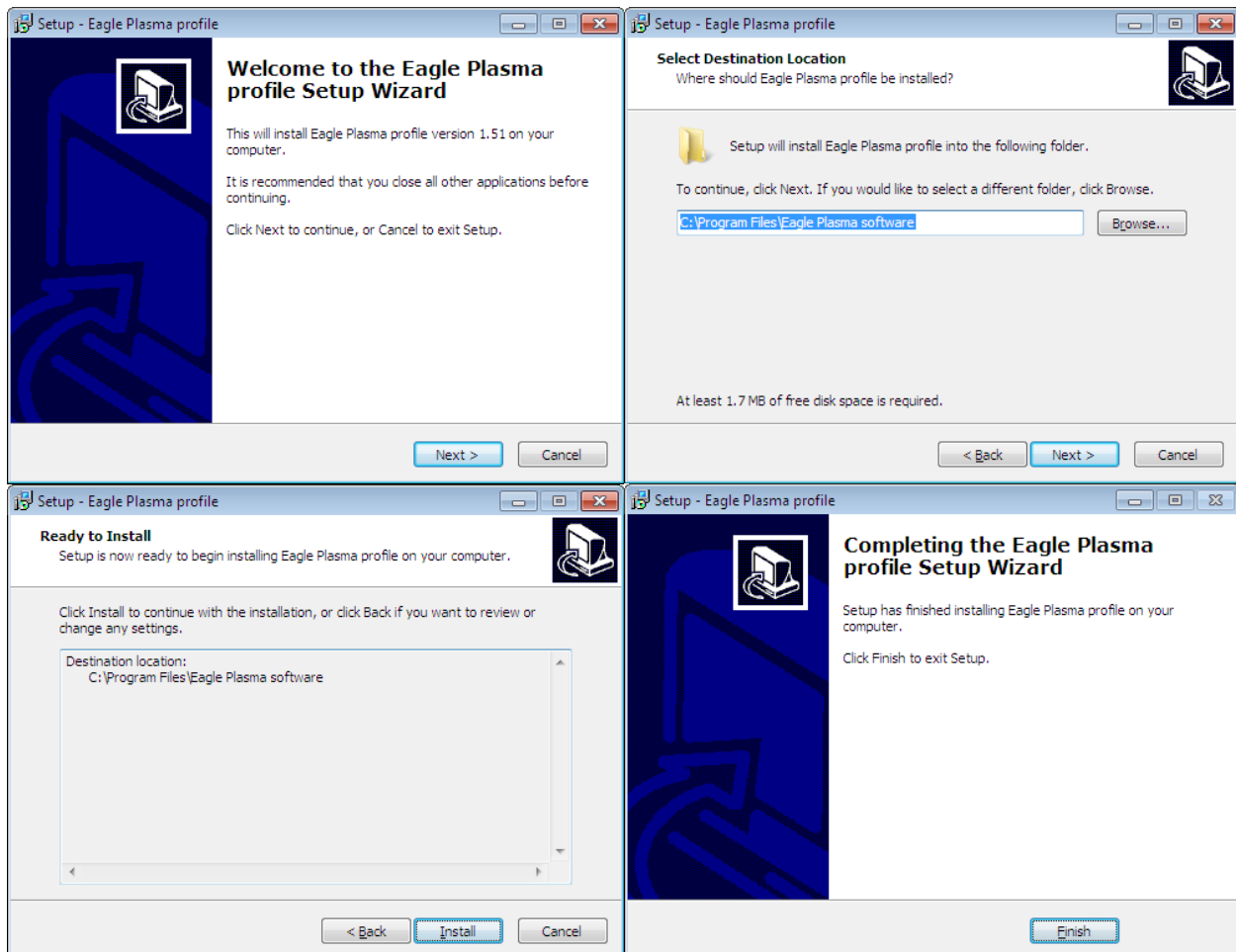


At this point Mach3 may try to Reboot your computer. You will need to return to the Eagle Plasma CD to install the Mach3 Profile and the Ethernet Adapter.

Installing Software – Mach3 Profile



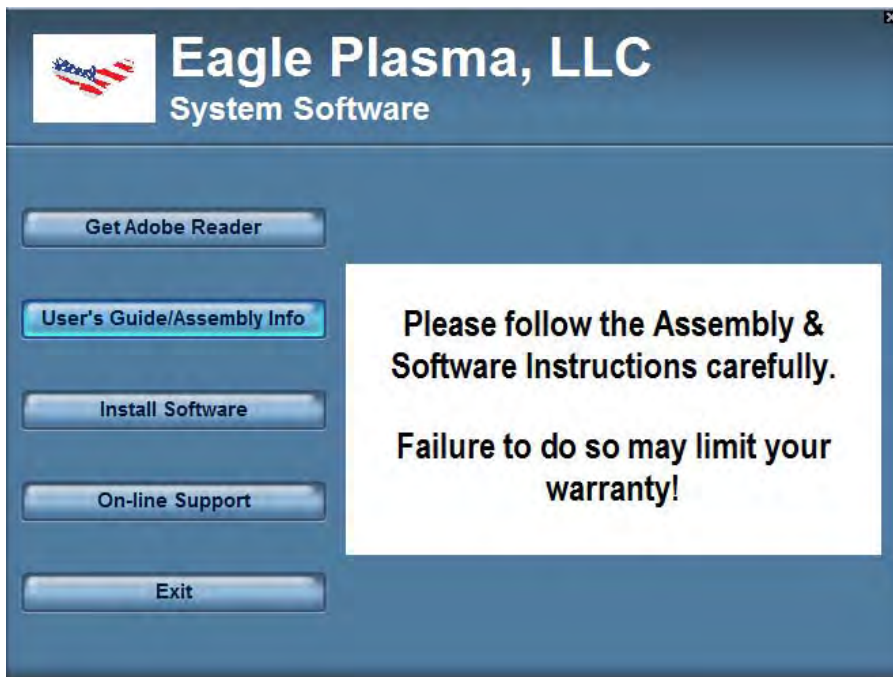
Select the Install Mach3 Profile button.



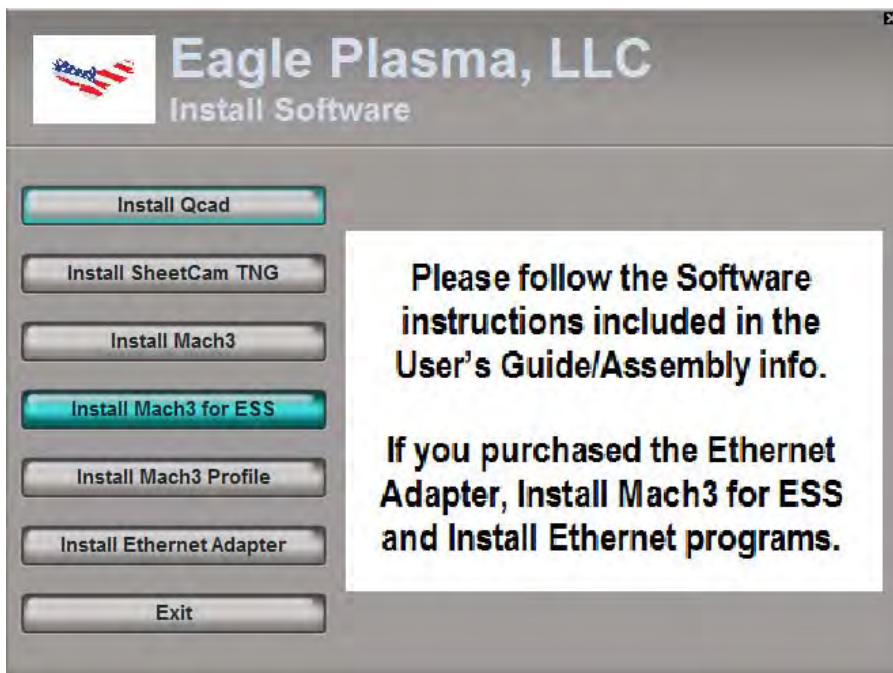
Click Next, Next, Install and Finish. Congratulations, you're one step closer to cutting! If you have purchased the Ethernet Adapter, read further for installation instructions.

Installing Software – Ethernet Adapter

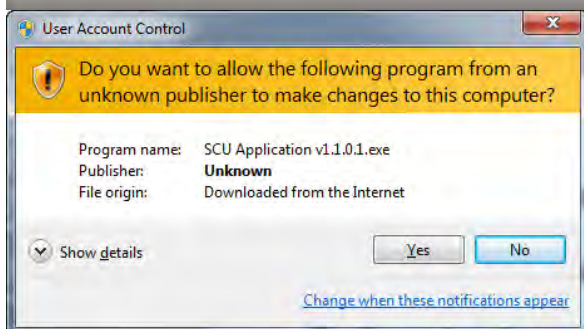
With Mach3 closed, connect the Ethernet adapter to the LAN or Ethernet port on the computer. Make sure it has power. If Windows tries to set network values, click Cancel.



In the System Software Main Menu, select Install Software.

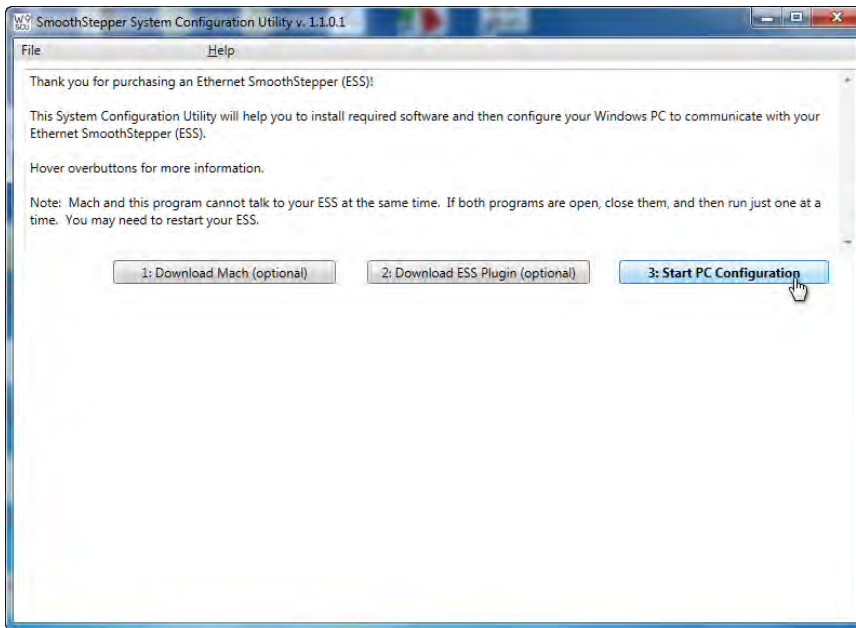


In the Install Software Menu, select Ethernet SS Install.

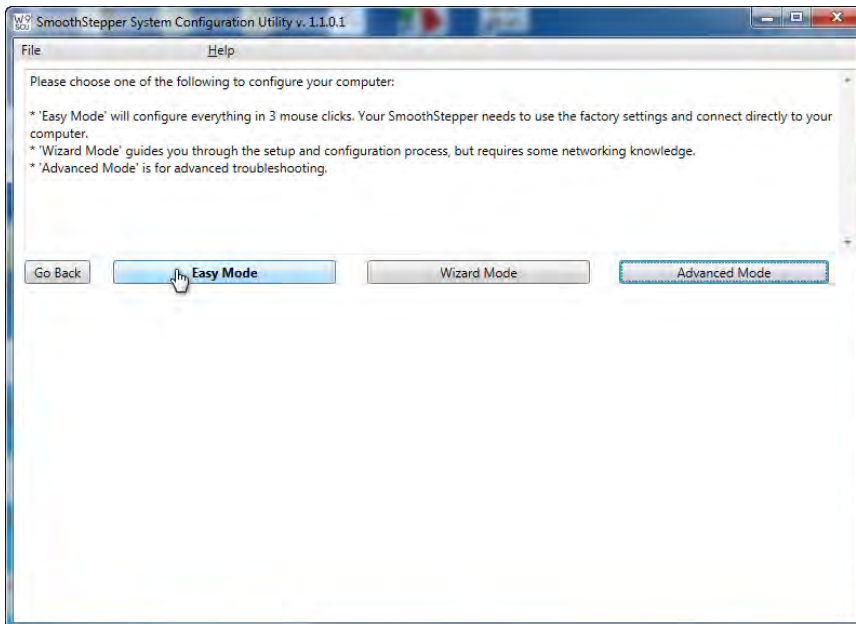


Allow the program to make changes to the controlling computer. Select Yes. Windows will ask several set-up questions. Accept the default settings and install the utility.

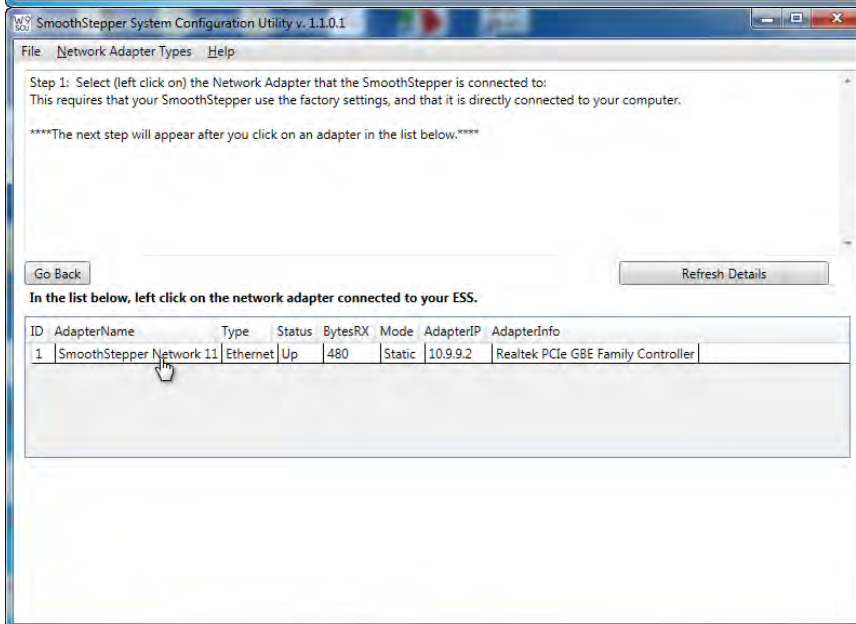
Installing Software - Ethernet Adapter



Select "Start PC Configuration".

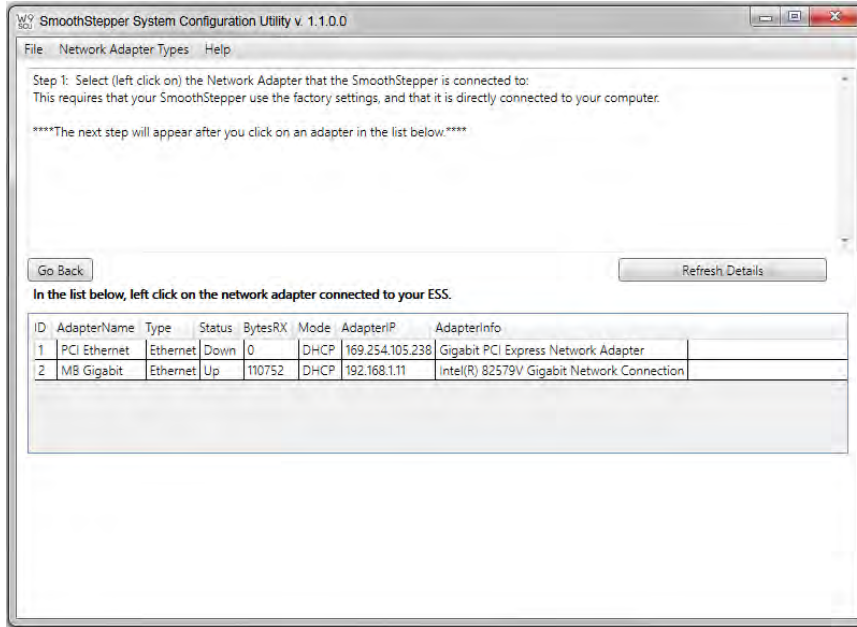


Select "Easy Mode".

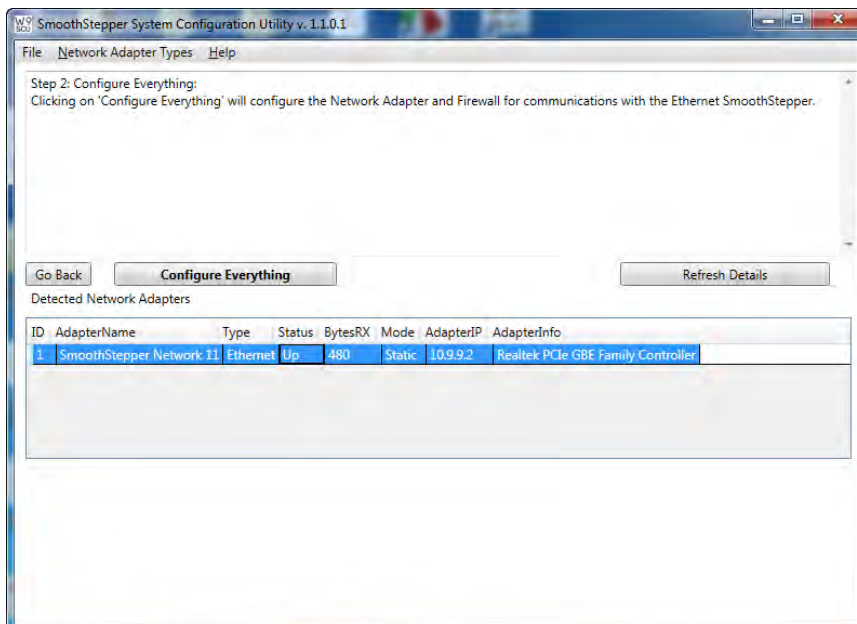


Select the Network Adapter that the ESS is connected to.

Installing Software – Ethernet Adapter

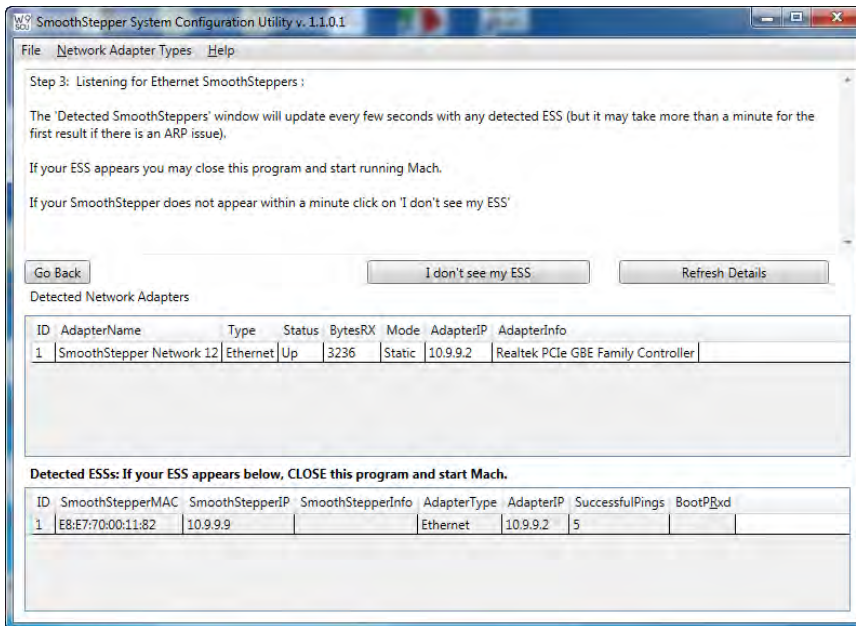


If you see multiple Network Adapters, power down the Ethernet adapter and click "Refresh Details". Under the "Status" column, the Ethernet Adapter will be down. Plug it back in and after a few seconds click "Refresh Details", the screen will show the adapter status as "Up". Left click to select the Ethernet adapter.

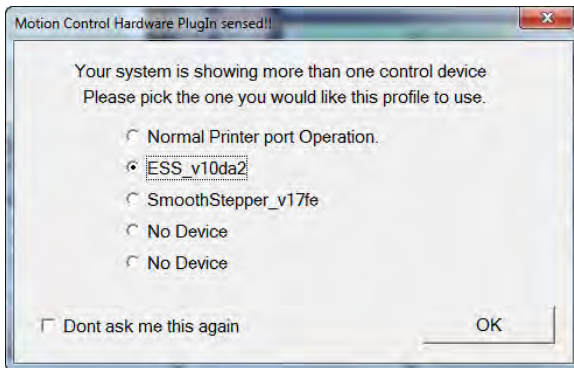


Select "Configure Everything".

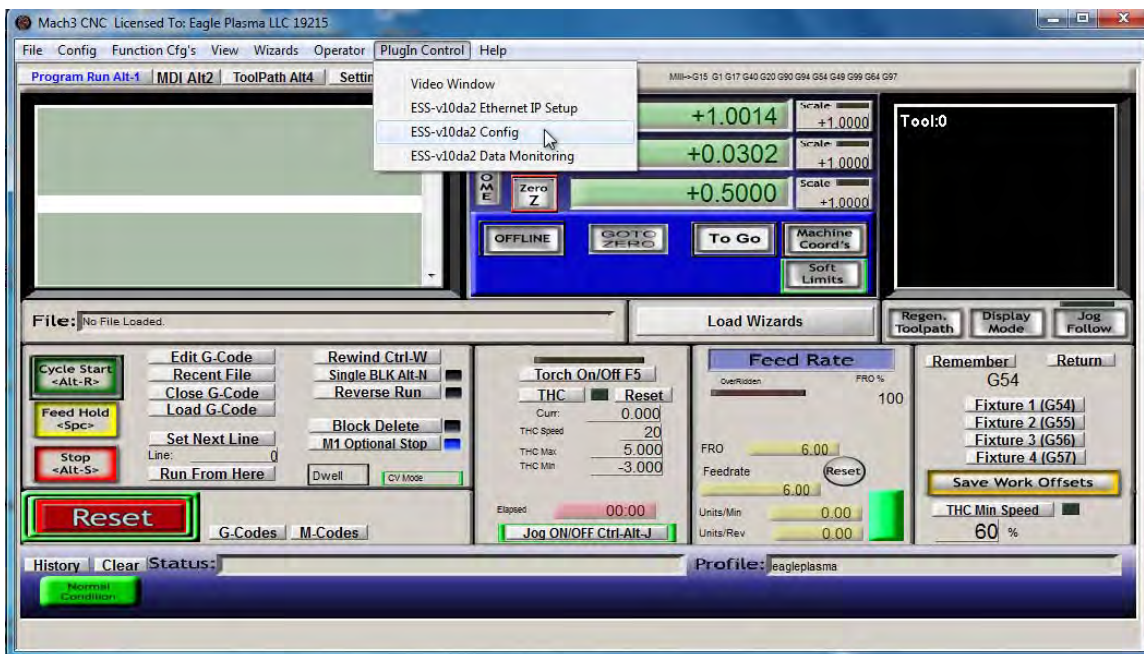
Installing Software - Ethernet Adapter



You will briefly see command screens come and go. The program screen will reappear showing it has detected your ESS. Close the program. Connect the Ethernet adapter to the printer cable included with the control box.



Open Mach3 Loader, be sure to select ESS v10da2 as the motion control device. Try jogging the system using the up/down, left/right arrow keys.



Go to "Plugin Control" and select "ESS-v10da2 Config".

Installing Software – Ethernet Adapter

The screenshot shows a 'Dialog' window with the following sections:

- Controller Frequency:** Set to 1 kHz. Text: 'The Controller Frequency controls how many times per second the velocity is updated when outputting pulses. At 250 Hz, up to 4 seconds of data can be queued up. Each doubling of frequency halves the buffer length, so at 500 Hz, 2 seconds can be buffered, 1 kHz, 1 second, etc.'
- Port 2 Pins 2 through 9 Direction:** In
- Port 3 Pins 2 through 9 Direction:** In
- Max Step Frequency:** X-axis: 256 kHz, Y-axis: 256 kHz, Z-axis: 256 kHz, A-axis: 256 kHz, B-axis: 256 kHz, C-axis: 256 kHz, Spindle: 32 kHz
- Output Mode:** Step and Direction (X, Y, Z, A, B, C checked), Quadrature
- Watchdog:** If the PlugIn fails to communicate with the device within the amount of time listed below, an EStop will be triggered in the device. Time: 2.0 seconds.
- Feed Hold:** Controlled By Mach, Controlled By SmoothStepper
- Spindle:** Relay or None, PWM (Base Hz: 1000), Step and Dir (Pulse Width (us): 4.0)
- Miscellaneous:** De-Reference Axes in EStop, Don't Report Port and Pin Warnings, THC Mode (indicated by a red arrow), 1023 Number of Data Points Mach Should Pre-Calculate
- Noise Filtering of Inputs:** Probe: 0.00, EStop: 0.00, Jog: 0.00, Limits: 0.00, Home: 0.00
- M11Px/M10Px Commands:** M11Px/M10Px Gates Spindle Output: Output Number to use for M11P#/M10P#: 0
- Dwell time associated with M11/M10 Commands:** M11: Dwell selected in this config: Delay: 0 milliseconds; Dwell selected Via User DRO: User DRO #: 0. M10: Dwell selected in this config: Delay: 0 milliseconds; Dwell selected Via User DRO: User DRO #: 0
- Spindle PWM Proportional to XY Feed Rate:** Enable: Mapping Function Filename: _____

On the bottom left portion of the screen, select this check box to allow THC Mode.