

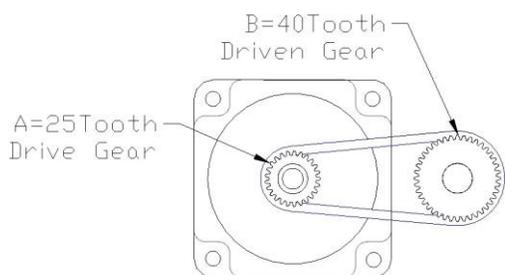
# Rotary System Parameters Setting Instructions For Chuck Style Attachment



*Rabbit Laser USA*

We are using the Chuck rotary device on our laser engraving system. We have a cylinder in the chuck. The chuck spins the cylinder according to the center axis of the cylinder.

Measure the diameter of the cylinder before you engrave on it. The calculation requires the variable D: the Diameter of the cylinder (measured in millimeter (mm)) surface to engrave onto.



A=(Number of Teeth on Gear A)  
B=(Number of Teeth on Gear B)

M=(Micro-steps per Revolution of motor) \*\*\*\* Read the switch settings on the amplifier

$$\text{(Pulse Size in millimeters)} = D / ( M / \pi * B / A )$$

Calculation formula (for systems with micro-stepper settings of 6400 Pulses per rev):

$$\text{Pulse Y} = D / ( 6400 / \pi * 40 / 25 )$$

$$\text{Pulse Y} = D / 3259.493$$

Calculation formula (for systems with micro-stepper settings of 12800 Pulses per rev):

$$\text{Pulse Y} = D / ( 12800 / \pi * 40 / 25 )$$

$$\text{Pulse Y} = D / 6518.986$$

Example:

The diameter is measured as 78.74 mm .. This is easy to recognize as about 3.1 inches.  
(78.74 mm) / 3259.493 = 0.024157

You should go to the LaserCut 5.3 software... This value of “0.024157” needs to be set into the Y-Pulse parameter of the software WorkTable section of "Machine Settings". After the value is stored into the Y-Pulse value, then press “Save”. You then need to use the "Download Manager" to "Download CFG". This will set the motion controller to use the new value for the rotary chuck.

\*Reminder: After you are done using the rotary chuck, change the Y-Pulse back to the original table-pulse value. Use the “Download” button to access the “Stand alone file Manager”. Download the configuration using the “Download CFG” button. This will be needed to use the standard flat working surface.