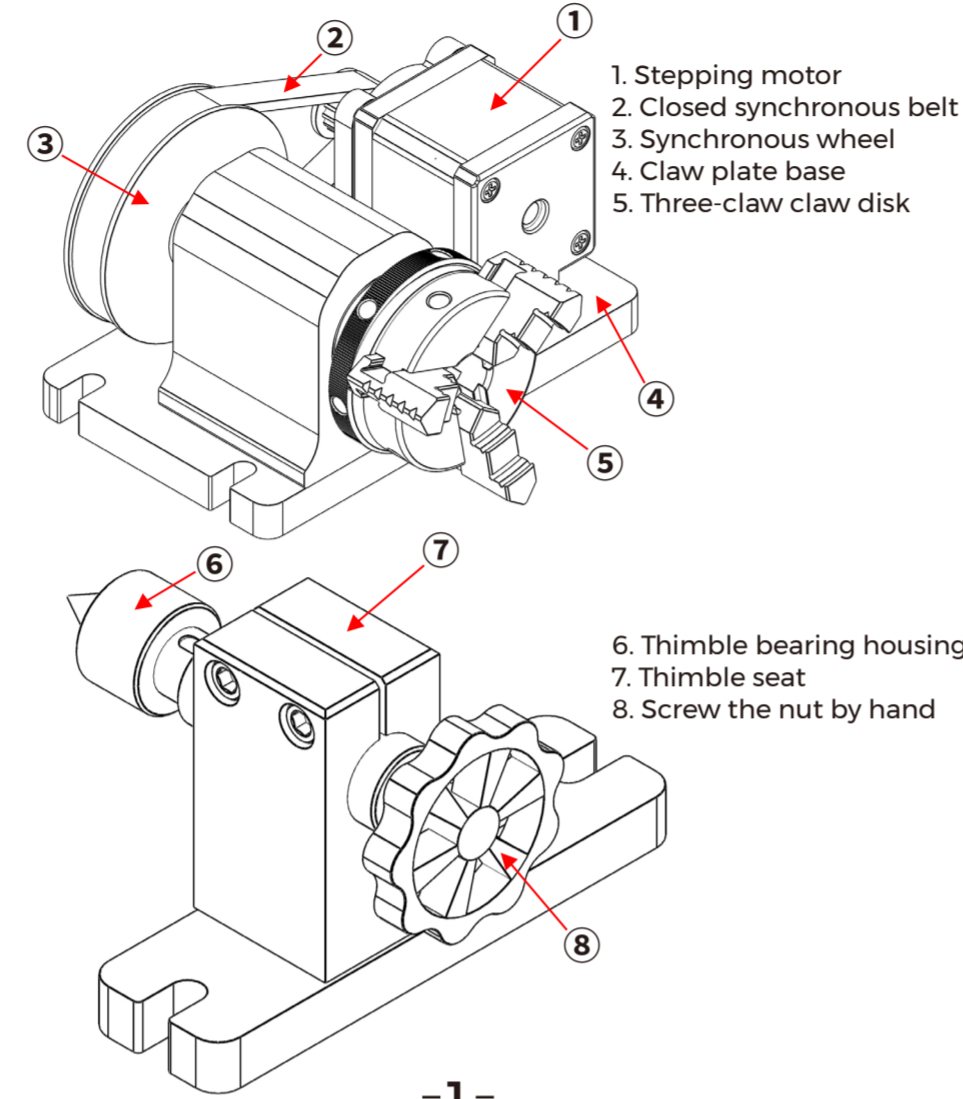


### Parameter description

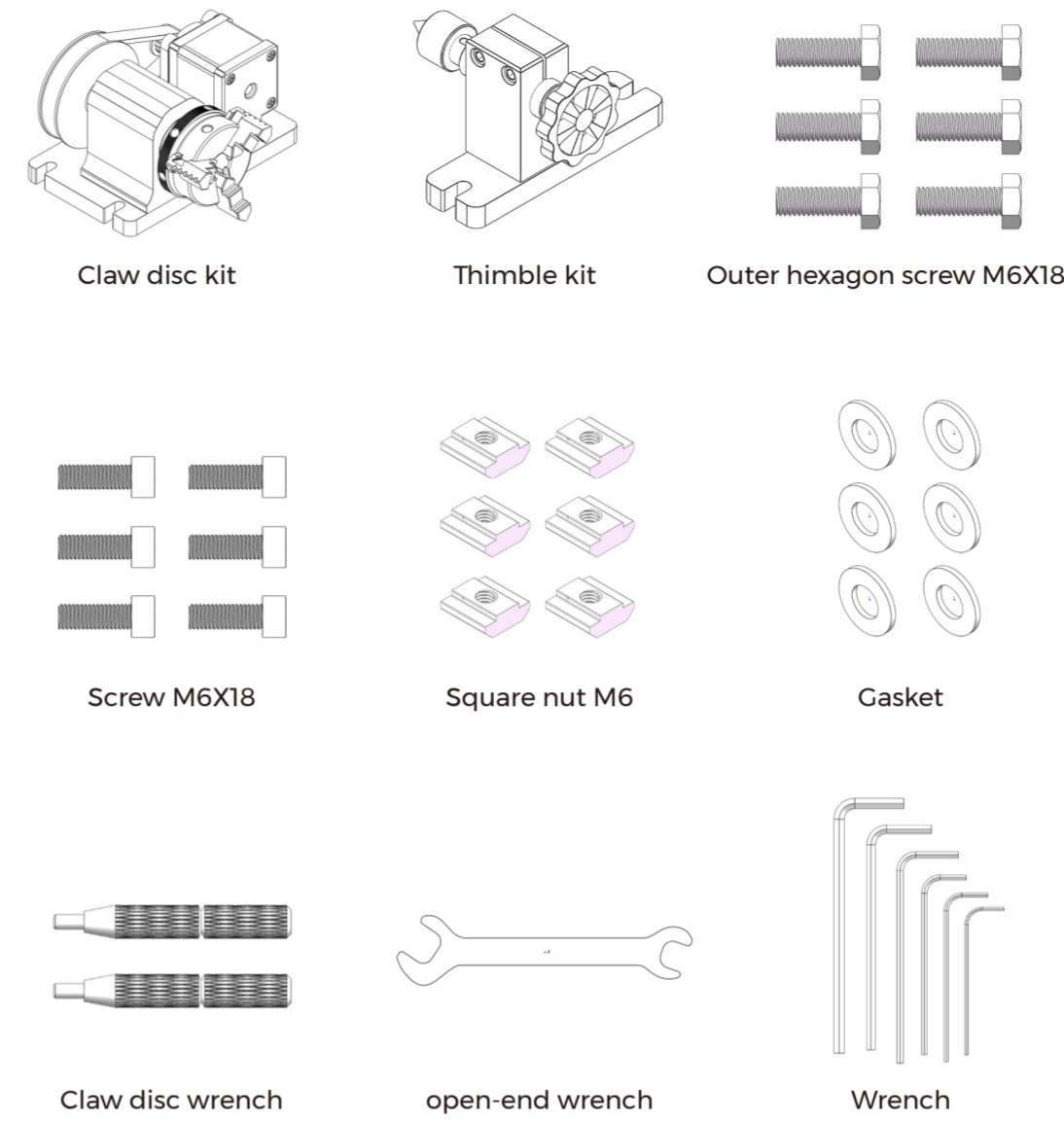
Maximum diameter of clamping cylinder: 60mm  
 Minimum diameter of clampable cylinder: 4mm  
 Maximum length of clamping cylinder: according to the working length of the machine. (Need to subtract the distance between claw disk kit and thimble kit)  
 Shortest length of clamping cylinder: according to machine tool head. (If it is too short, it will cause the cutter head to hit the claw disc)  
 The subtraction ratio of claw disk is 4: 1

### Accessories introduction



-1-

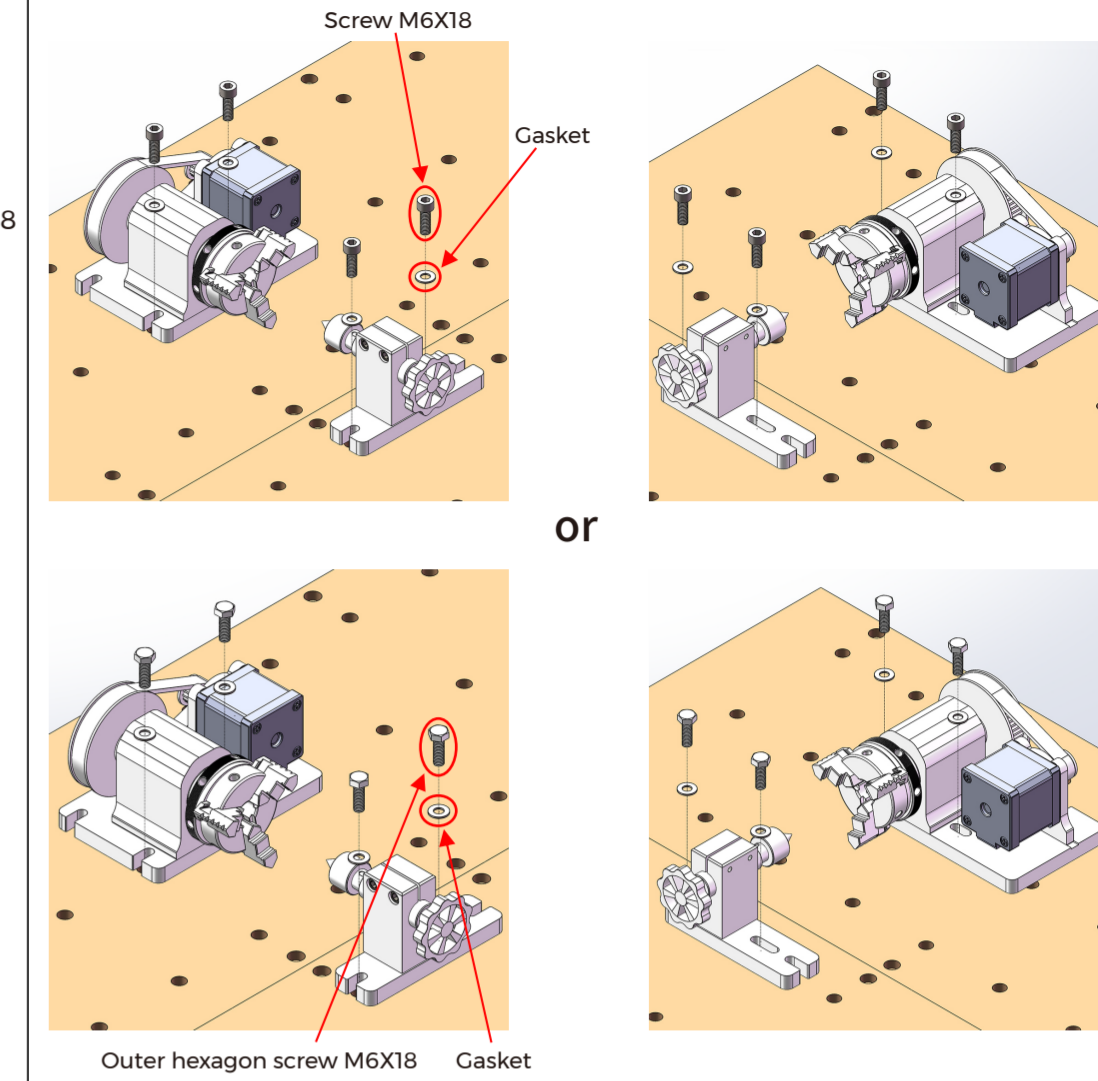
### PARTS LIST



-2-

### Instructions for TTC450 Machine

- Materials used:**
1. Screw M6X18 x4
  2. Gasket x4
  - or else
  3. Outer hexagon screw M6X18 x4
  4. Gasket x4

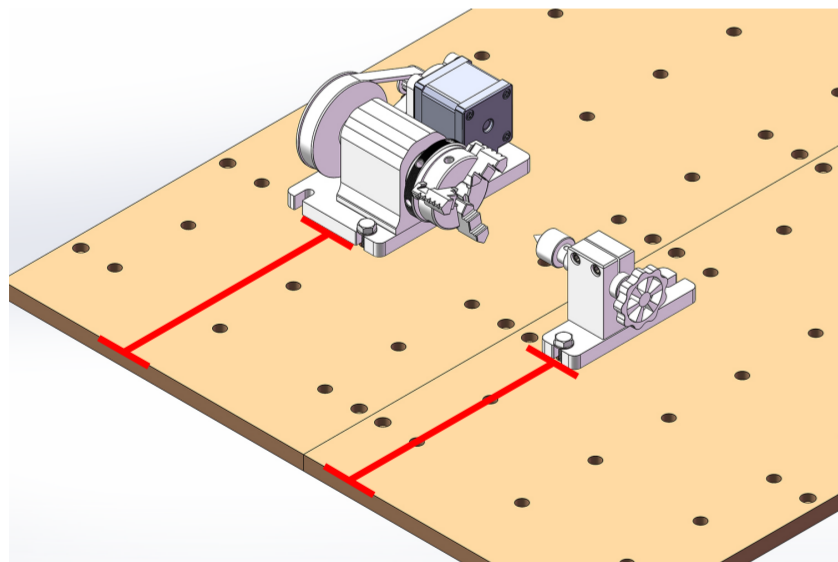


-3-

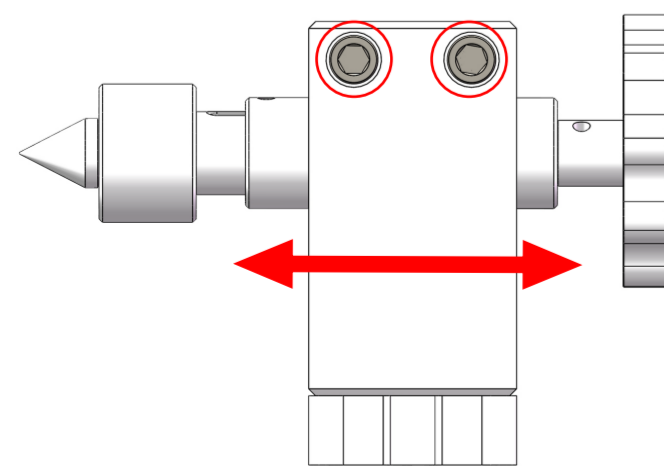
After confirming the position, use screws and gaskets to fix the claw disk kit and thimble kit through the bottom hole. The two screw fixing methods can be selected by oneself.

### Matters needing attention in using TTC450 machine

It is necessary to control that the distance from the bottom plate of the claw disk kit and the thimble kit to the edge of the MDF is consistent.



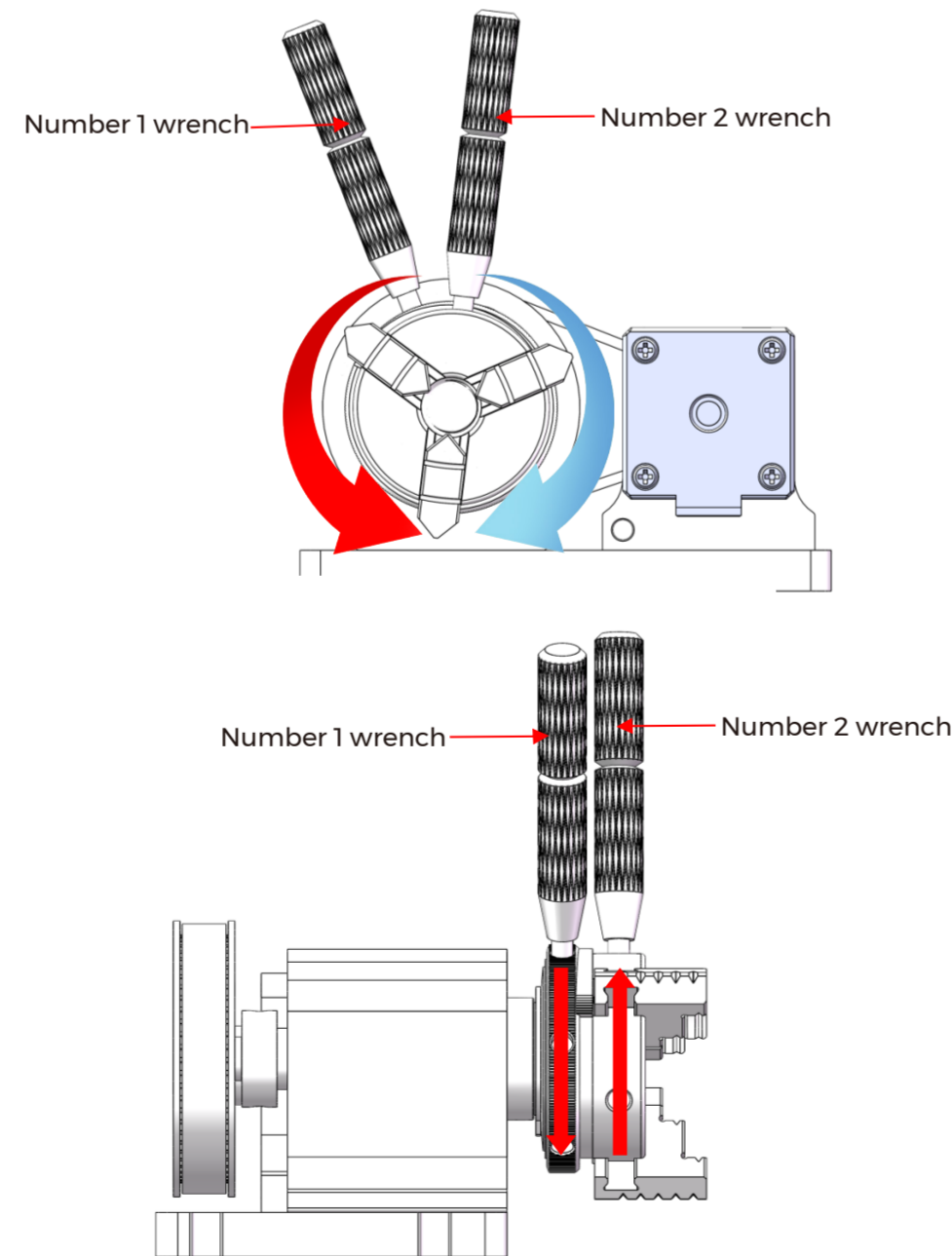
By loosening the screw in the thimble kit, the thimble can be moved back and forth as a whole to the desired position. After moving to the position, you need to tighten the screws again to fix them.



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### Instructions for using claw disc machine

When the No.1 wrench rotates counterclockwise and the No.2 wrench rotates clockwise, the claw plate can be relaxed. On the contrary, clamp.



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### Instructions for Pulse Setting 1

Pulse calculation formula: (pulse number of motor in one turn x driving subdivision x subtraction ratio)/cylinder circumference The number of pulses in one cycle of the motor contained in the kit: 200; Subtraction ratio: 4: 1

Example: The number of pulses and the subtraction ratio of the motor are fixed, and the number of pulses of the motor is 200. The subtraction ratio is 4: 1. Take TTC450 motherboard as an example. The diameter of the cylinder is 50mm. So  $(200 \times 16 \times 4) / 157 \approx 81.53$ . The pulse number is 81.53.

Circumference of cylinder =  $2 * \pi * \text{radius}$  If there is inexhaustible division, take two decimal places

$$(200 \times 16 \times 4) / 157 \approx 81.53$$

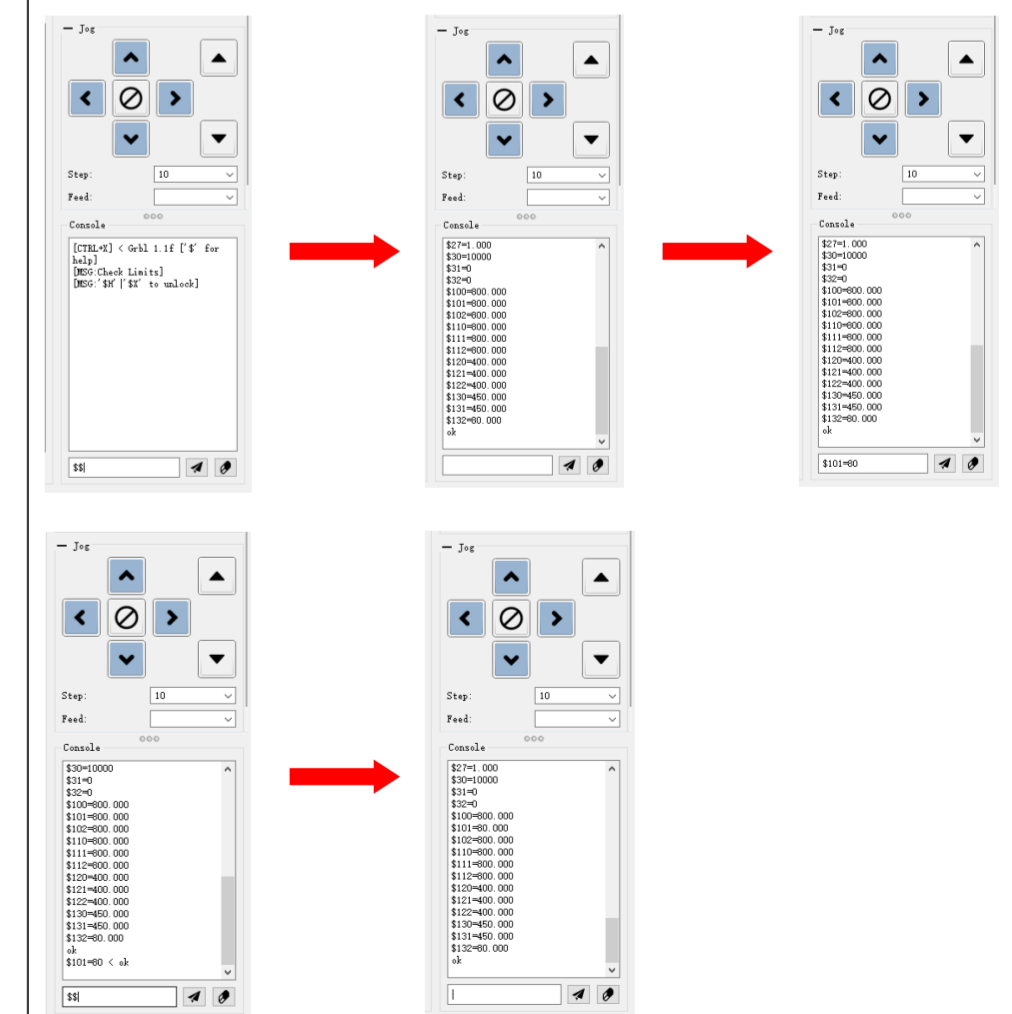
Depending on your own motherboard Subtractive ratio

The motor step angle is  $1.8^\circ$   
 It takes 360 to turn around  
 So the step angle is  $360 / 1.8 = 200$

-6-

### Instructions for Pulse Setting 2

- Modify the pulse with CANDLE control software.
- Step 1: Connect the machine.
  - Step 2: Enter the \$\$symbol in the lower right corner of the software and call the machine parameters.
  - Step 3: Enter \$101 = 80 and click Send.
  - Step 3: Enter the \$\$symbol again to see if the change is complete. If the parameter changes, the change is successful.



Note: The example in the picture is the Y-axis, \$100 is the X-axis pulse, and \$101 is the Y-axis pulse.

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