

SHOPMASTER CNC VFD Settings

Manual FOR/REV Switch Control - Set PO-000 to 1 and P0-002 to 0

This setting is only for PATRIOT machines equipped with a manual Forward- Neutral-Reverse switch

VFD Keypad Control - Set P0-000 to 0 and P0-002 to 0

These settings allow speed control via the knob and Forward-Reverse by the DIR/JOG button. Works with MILL TURNS and PATRIOTS (When Patriot manual switch is kept in the neutral position)

Mach3 Control – Set P0-000 to 1 and P0-002 to 2

These setting allow control of Speed, Start-Stop and Forward-Reverse by Mach 3 commands. (PATRIOTS must be wired for this Option, MILL TURNS are factory wired) Under Mach 3 control, codes P0-007 and P0-024 must always be the same .

P1-000 – Set to 0 to allow editing of the codes below – Set to 1 to prevent editing.

P1-001 – Setting to 1 will reset all codes to Nowforever defaults

PO-XXX	PO-XXX	PO-XXX	PO-XXX
000 See Above	027 0	054 15	081 0
001 0	028 1	055 1	082 0
002 See Above	029 0	056 2	083 0
003 0	030 0	057 0	084 0
004 50	031 0	058 0	085 0
005 5	032 0	059 0	086 0
006 0	033 0	060 1	087 0
007 120	034 0	061 2	088 0
008 0	035 100	062 3	089 0
009 1 .5 Acceleration	036 180	063 4	090 0
010 1 .5 Deceleration	037 130	064 5	091 0
011 6	038 125	065 6	092 0
012 50	039 3	066 7	093 0
013 3 Torque Boost	040 0	067 8	094 15
014 100 Auto Torque	041 0	068 9	095 15
015 100Auto Slip	042 0	069 10	096 15
016 1	043 0	070 11	097 15
017 2	044 0	071 12	098 15
018 4	045 0	072 13	099 15
019 9	046 3	073 14	100 15
020 0	047 0	074 15	101 15
021 0	048 1	075 0	102 0
022 0	049 2	076 0	
023 10	050 0	077 0	
024 120	051 0	078 0	
025 1	052 0	079 0	
026 3	053 15	080 0	

If doing tapping, you may need to change codes 009 and 010 to .5 to allow the spindle to stop and change directions quickly. However in normal spindle speeds a setting of .5 would cause a fault because the spindle cannot start and stop that quickly.

HOW TO CHANGE CODES

- 1. PRESS ENTER- the screen will show P0**
- 2. PRESS ENTER AGAIN the screen will show P0-000**
- 3. PRESS THE UP ARROW TO REACH THE CODE # YOU WANT TO CHANGE**
- 4. PRESS ENTER AGAIN- The screen will flash with the current setting**
- 5. USE THE UP, DOWN AND/OR HORIZONTAL ARROWS TO CHANGE TO THE DESIRED CODE**
- 6. PRESS ENTER TO SET THE CODE**
- 7. USE YOUR UP OR DOWN ARROWS TO MOVE TO THE NEXT CODE AND REPEAT THE PROCEDURE IN 1-6**
- 8. WHEN FINISHED PRESS THE MON/ESC BUTTON TWICE**