



SIDEWINDER **XPR**

[USER GUIDE]



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Version 2021.5

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GENERAL INFORMATION

For your Safety

As with all machinery, there are certain hazards involved with the operation and use of your router. Use it with caution and at your own risk. Ignoring safety precautions may result in physical injury. When in doubt regarding its installation and operation, do NOT use the equipment until you have consulted a CNC Factory technician.

Read the following carefully and fully before operating the router:

1. Keep the work area clean and ensure adequate lighting is available.
2. Do NOT wear loose clothing, gloves, bracelets, necklaces, or ornaments that may be caught in the router.
3. Do wear face masks, safety goggles, ear muffs, and other body protection applicable for the operation or environment.
4. Make sure the emergency stop 'E-stop' button is pressed when entering the router work area.
5. Ensure that the power is disconnected from the router before servicing.
6. Never leave the router running without supervision.
7. Do not use dull, deformed, or broken cutting tools.
8. Ensure that keys, adjusting wrenches, and all loose items have been removed from the router and stored in a safe place.
9. Make sure all the nuts and bolts are secured in place.

Noise Emission

This router is noise-emitting. However, the operator's exact exposure to noise cannot be determined precisely to set supplementary precautions, as it is affected by different factors, such as: duration of exposure, noise from adjacent machines and other sources, characteristics of the work environment, etc. Noise emission standards also vary country to country and we recommend consulting your local regulations. Wearing a hearing protection device is highly recommended when operating this machine.

Router Specifications

This guide is for the general operation of the **Sidewinder XPR CNC Router**. Since most routers are made-to-order, the exact specifications of your router is found in your purchase order and its requirements in your pre-install guide.

Limited Warranty

CNC Factory provides lifetime router support and warrants that it will be free of defects in workmanship and materials for a period of 18 months beginning on the date of delivery. This warranty does not include (wearable) parts consumed during normal operation or maintenance required in the ordinary course of operation. For full warranty details, refer to the General Terms and Conditions for the Sale of Products and Services signed during the purchase of this router.

General Warnings



Improper operations that may cause the router to fail, damage it, or cause bodily injury to the operator are prefaced with this warning sign.



The program does NOT have an Undo button/option. If you configure and save the wrong values by mistake, your only option to revert to the original is to type back the original values and save again. If you do not remember the original values or are in doubt, please contact your CNC Factory technician for help reverting to the original settings. Using incorrect values may cause damage to your router or make it fail.



Critical interfaces that may cause irreparable damage to your router are usually password-protected. This password is available upon request from your CNC Factory technician. There will be advanced segments of the program that you will not need for your day-to-day operations and are reserved for technicians' use only, and they will be identified as such. Please avoid tinkering with advanced features, which may or may not be password-protected.

Contacting Support

Your lifetime technical support can be accessed by calling 714-581-5999* or online via:

LOG IN TO ZENDESK

If you do not have a Zendesk log-in, please contact support@cncfactory.com.

OPEN KNOWLEDGE CENTER

We will try to resolve your issue as quickly as possible via phone call or remote access. Should those not suffice, you may contact us at 714-581-5999 to talk about an on-site visit by a technician. Separate charges may apply.

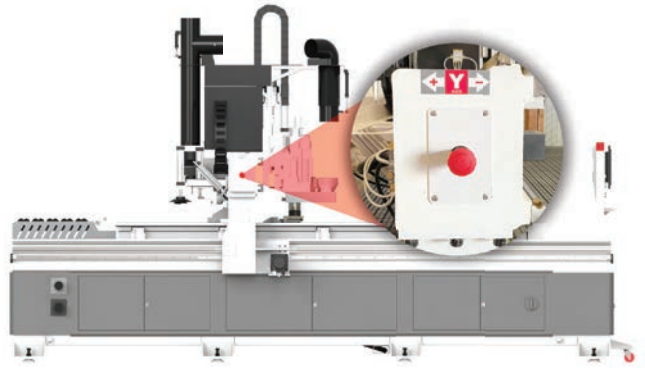
**only available during regular office hours*

The Emergency Stop or E-stop

The E-stop is a safety feature that stops all operations of the router. You have three (3) emergency stop buttons that are easily accessible while the router is operating:



On the controller



On both sides of the gantry

To initiate an emergency stop, press the red button. Once pressed, the controller & router safety lights will turn red to alert you that your router is stopped.



Pressing the E-stop sends an electrical pulse to the entire router that shuts all operations down instantly—we recommend using it sparingly for emergencies and should not be utilized to pause or as a regular stop button, as frequent use may damage your motors.



To turn the router back on from an E-stop, turn the E-stop button clockwise, in the same direction as the arrows shown. The red safety lights will then turn to white.



For those on the gantry, a green ring appears when the E-stop is disengaged. When pressed and engaged, the green ring will disappear.

Maintenance



Lubrication

Our routers come with a fully automated, pressurized lubrication system for all the liner guides and ball screws. For best results, use 000 Semi-Fluid Lithium Grease.

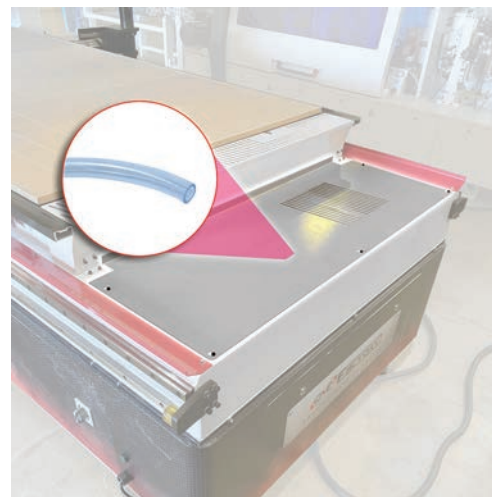
All helical racks & drill blocks require manual lubrication with Klüber Isoflex Topas L32N Special low-temperature grease. As a rule of thumb, apply 5cc of lubrication after every 40 hours of operation.



When lubricating, jog the machine all the way up to the area without the spoilboard, to avoid damaging it in case of leaks or drips. Oil on the spoilboard can clog it and affect material work holding.

Daily Checks

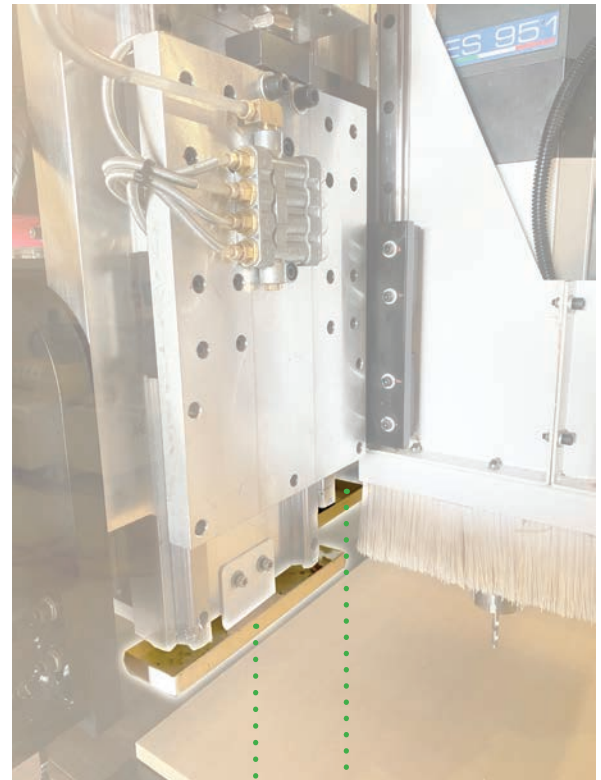
1. Clean the router, wipe off any excess oil, and buff with a dry polishing cloth. This will reduce the chance for dust build up.
2. Check all liner guides and ball screws. Make sure there is a thin layer of oil on it.
3. Check cutter teeth for chips and dullness.
4. Collets and spindle collet holes must be cleaned regularly. Ensure that the slots in the collets are free of sawdust, as it can build up and prevent the collet from compressing. If the collet or spindle holes are clogged, the router bit may vibrate or get loose while cutting. Serious spindle damage or bodily injury may occur.
5. Check the AC unit drain, make sure it is not twisted or leaking into the control cabinet under the router bed.



AC drain hose inside control cabinet

Weekly Checks

1. Clean grease and dirt off the helical racks. Apply gear grease on all helical racks.
2. Check the dust collection pipe and brush hood. Clean off all debris and dust build up.
3. Generally inspect the router for any damage or loose/worn parts.
4. Empty oil tray under the liner carts.



Oil trays

Quarterly Checks

Conduct a drill block grease check.

Annual Checks

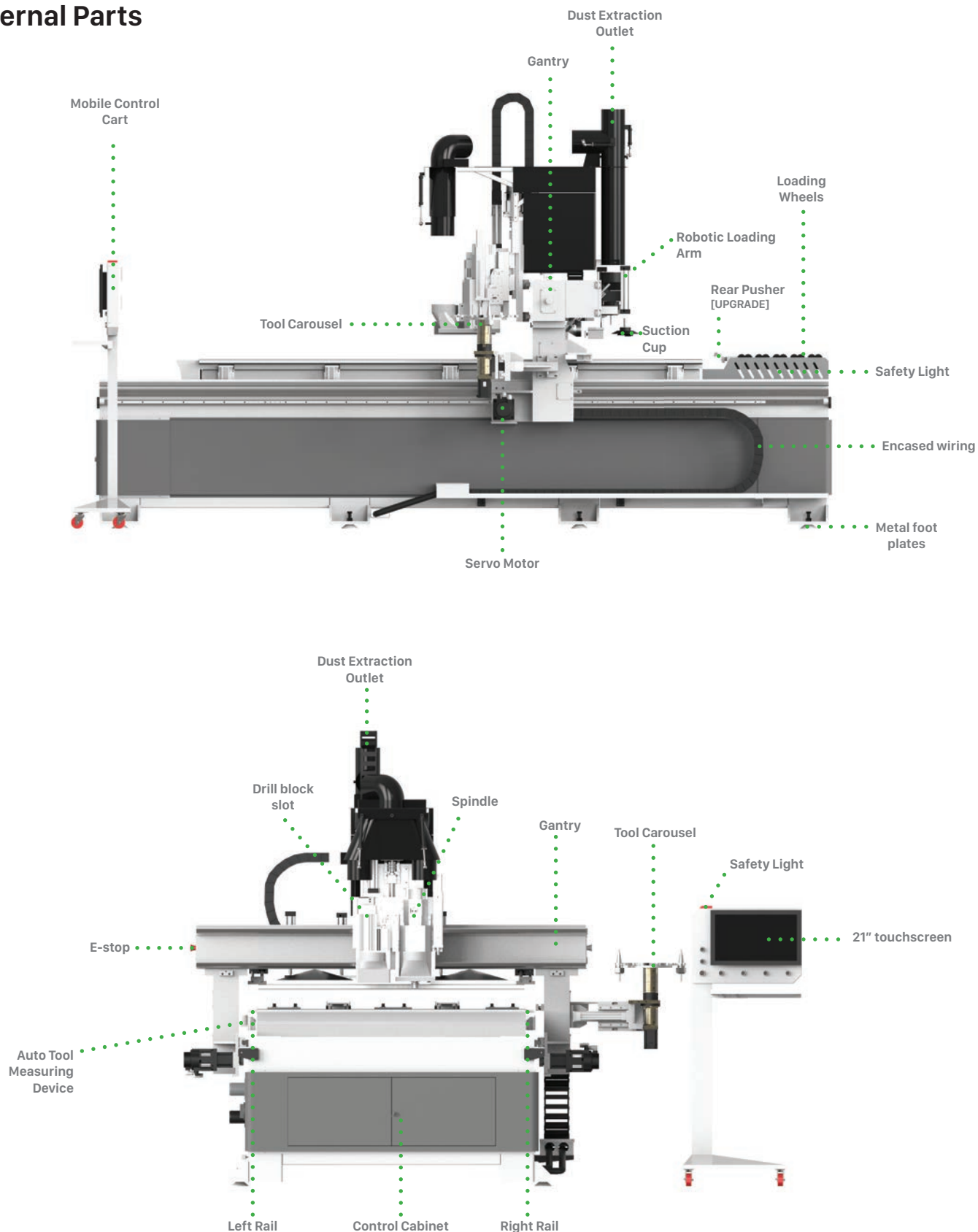
Schedule an on-site service with a CNC Factory technician.

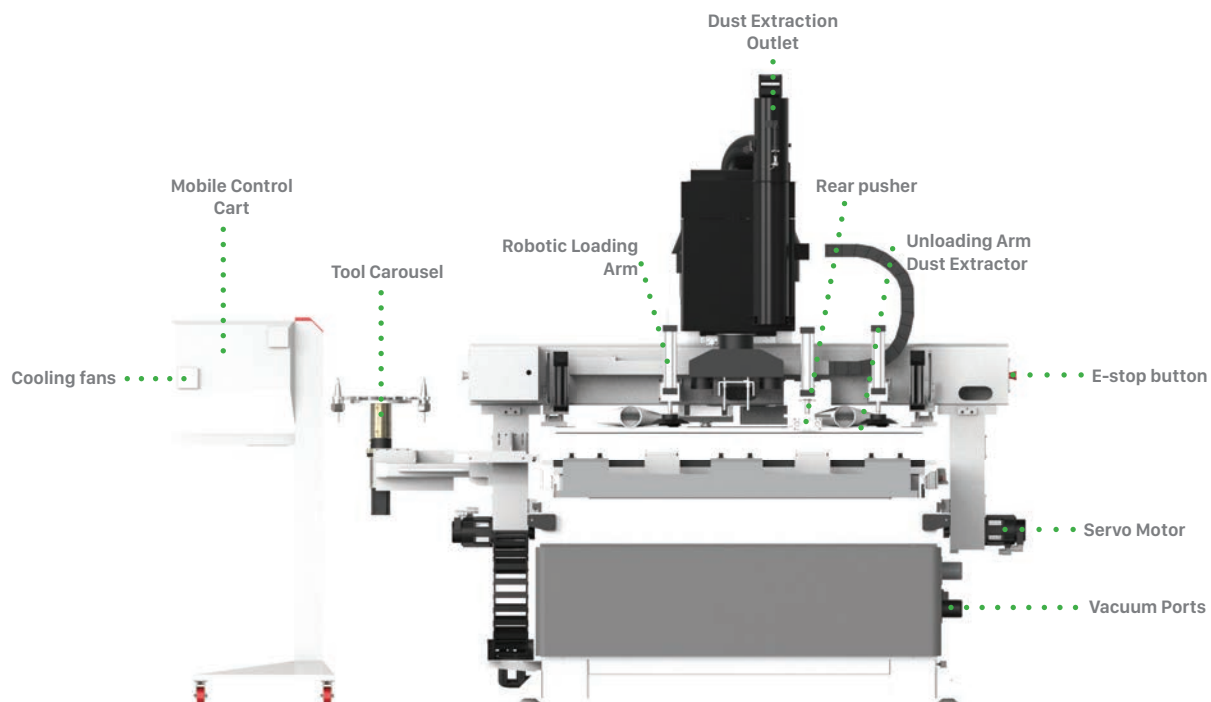
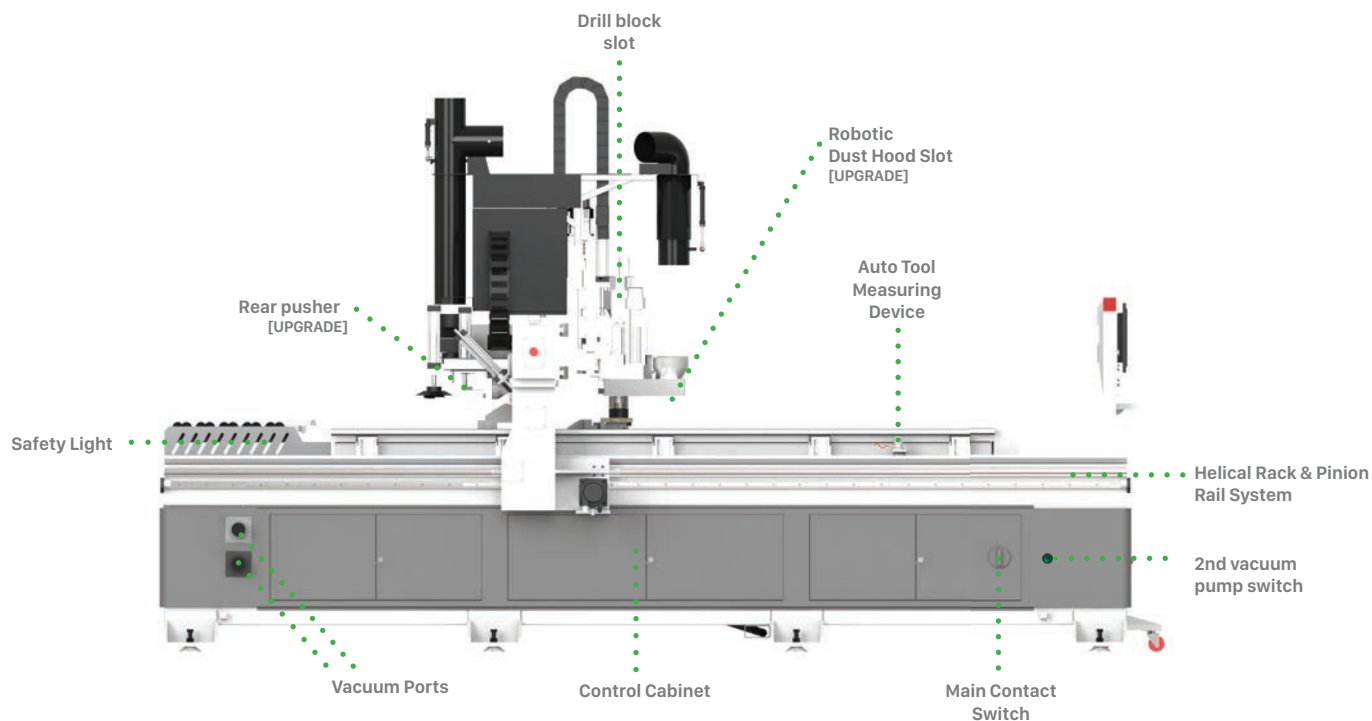
Connectivity

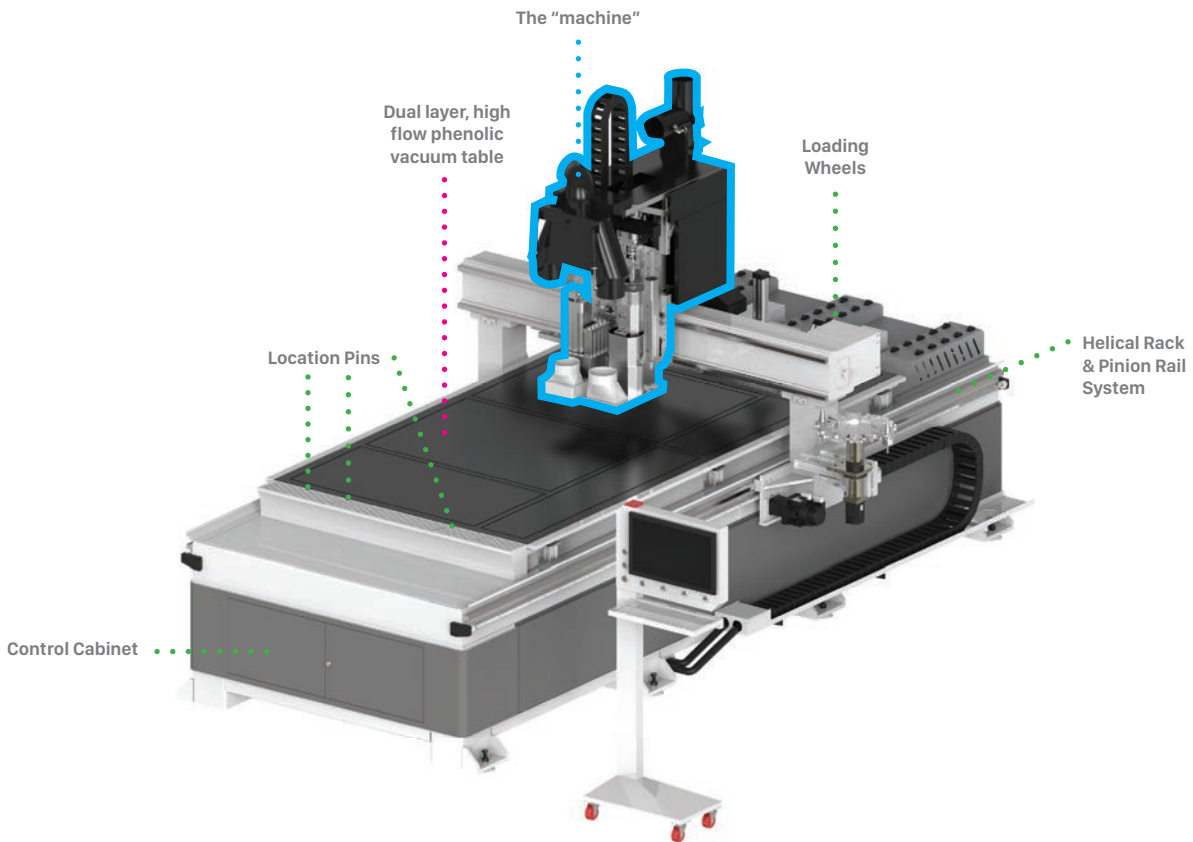
The Sidewinder has USB, WiFi and ethernet connections. It only requires the internet for virtual/remote access. Configurations for your router's connectivity will already be set-up by your technician during installation.

PARTS OF YOUR ROUTER

External Parts







Notable Terminology

Router

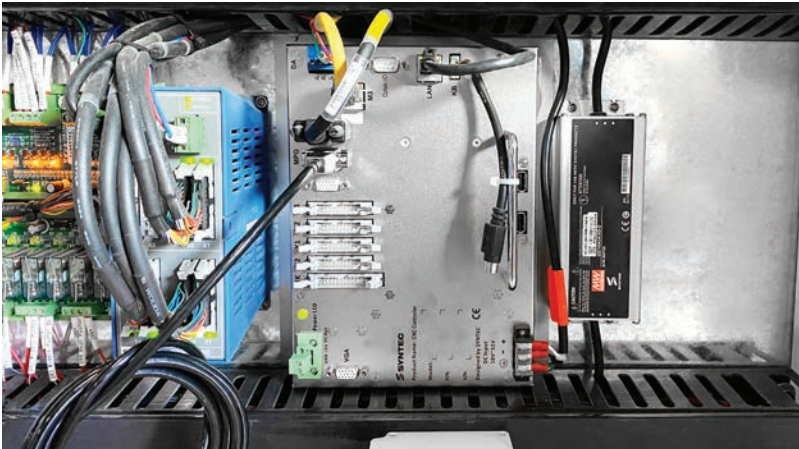
Refers to the entire Sidewinder XPR, including its controller/control cart.

Machine

Refers to the block of components responsible for cutting that is anchored to the gantry—includes the spindle, drill block, and dust hood (upgrade). Whenever there is a mention of machine movement, it refers to this block (and not to be confused with the router, since the router, after all, is stationary during operations).

UNDERSTANDING YOUR CONTROLLER

Main Controller vs. Control Cart



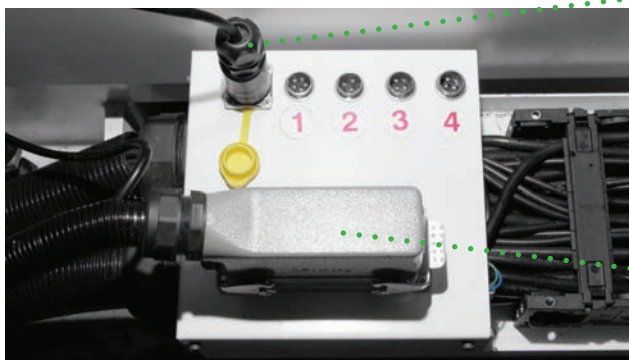
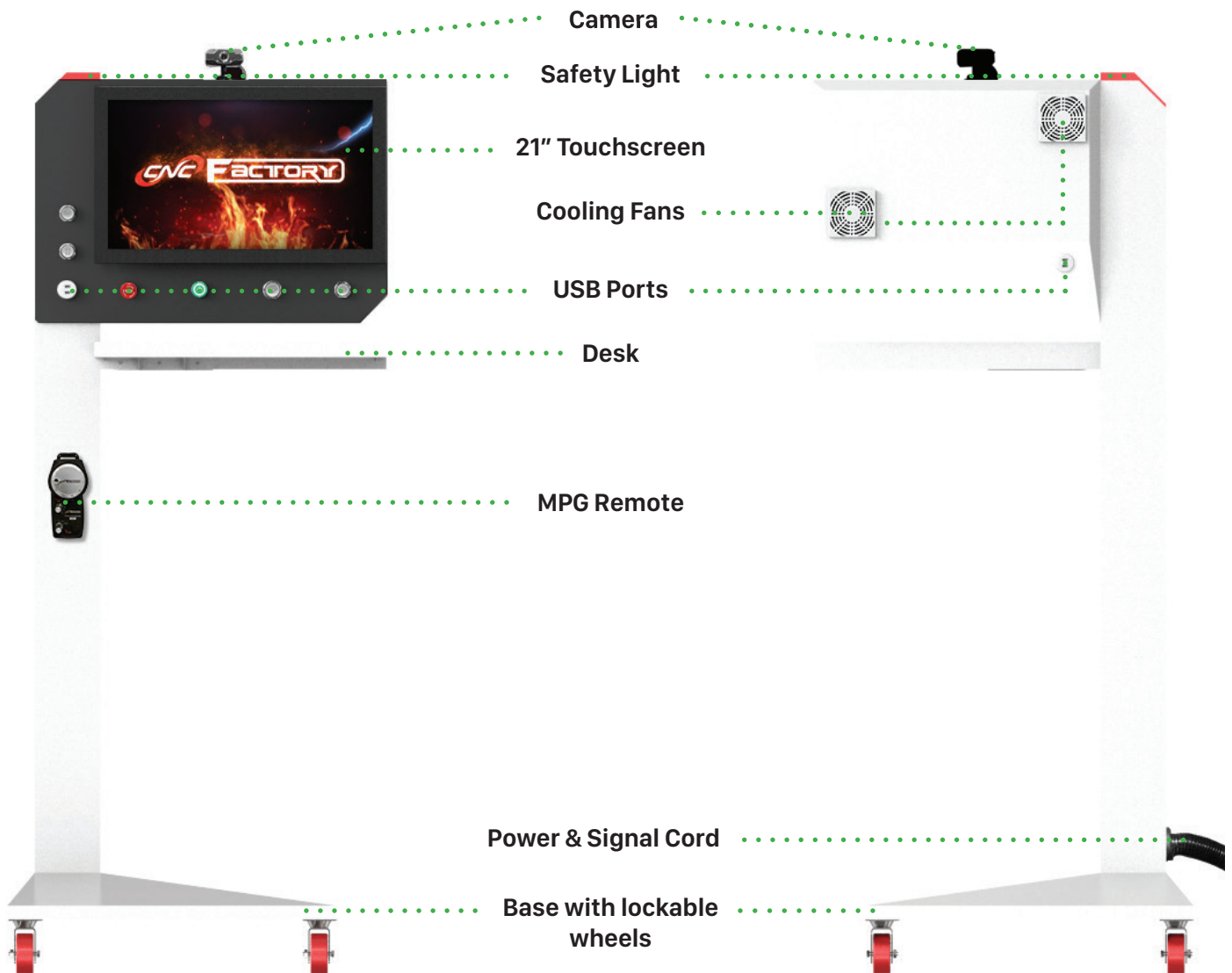
(ABOVE) Your actual, *main* controller is located inside your router cabinet. This is the brain of the machine. You may operate the router directly by connecting a screen directly to its VGA port, and importing files through its USB ports. We recommend this option for advanced technicians.

(RIGHT) This “controller” is a PC with a Windows operating system, and is sometimes referred to as the “control cart”. An emulator allows this to behave similarly to your main controller. We recommend using this in operating the router since it has a bigger, touchscreen display, as well as the familiar Windows system that is more user-friendly.



It is important to note the difference since some operations on the Sidewinder are typically used only for the main controller and not for the PC controller/control cart. In this manual, we may also use the term “controller” interchangeably for both. However, for clarity, when talking about the “main controller”, we are only referring to the one inside your router.

Parts of your Control Cart



Signal Cord

Sends a network signal to the main controller.

1: Loading table power

3: Unloading table data

2: Unloading table power

4: Light curtain

**Soon, a 5th port for loading table data will be available.*

Power Cord

Powers up the CPU & Screen.



Safety Light

Tells the router's current operating status. For the XPR series, the rear side of the routers have similar safety lights.

- **White Light**- Static mode: no operation is in progress and the router is ready for a command. In this mode, the bottom right of the screen will display "Ready"
- **Red Light**- Alarm mode: there is an operational issue or error. In this mode, the 'Alarm' display at the bottom right of the screen will blink red with "Not Ready" beside it.
- **Green Light**- Operation mode: operation is in progress. No other command may be executed unless the current operation is stopped. In this mode, the bottom right of the screen will display "Busy".

Start Button

Press to start operation. You will have to physically press the button to run a program. This is intentional to prevent unintended starting from accidental pressing of touchscreen buttons or to prevent people with internet access to your controller from operating your router remotely.

Pause Button

Pauses the operation. While on pause, your router is still fully powered, motors are still running, the spindle or drill block are still spinning (although the feed will be zero), and it will not affect all other commands that are queued up. To resume operation, press the Start button again.

USB Ports

Dual ports for importing files or connecting wireless devices (keyboard, mouse).

E-Stop Button

Instantly shuts everything down including power to the loading and unloading tables. You will need to restart all files interrupted by this shutdown.

Power Button

Turns the controller and the router on/off. When turning it on, allow a few seconds for the controller to power up. Once the safety light turns white, it means the main controller is operational and you may click on the Viper icon on your desktop.



If there are pending alarms, the safety light may light up red after powering on.

Before turning off your router, we recommend shutting down the PC before pressing the power button. Skipping this step may degrade your PC over time.

Vacuum Buttons

Sends signals to the vacuum box to turn on/off your vacuum pumps. Each button corresponds to a designated pump (maximum of 2 vacuum pumps).

Wireless Handheld MPG Remote



Move clockwise to move on an axis' positive direction. Move counterclockwise to move on an axis' negative direction.

Controls the axes

- Turning all the way counterclockwise turns the remote off. Selecting an axis automatically turns it on.

Controls the range of movement (either by 1mm, 10mm, or 100mm increments).

Status lights (1st bar: power indicator, 2nd bar: signal quality, 3rd bar: low battery).

The MPG remote requires two AA batteries. Remove the protective rubber case to access the battery terminal (at the back).

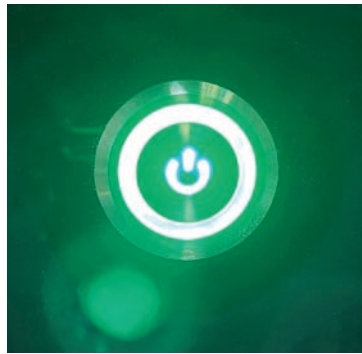
BASIC OPERATIONS

Turning On the Router

1. Make sure there is no object or person around the router's motion area to prevent collision.
2. Make sure power and air are connected to the router.
3. Make sure all the E-Stop buttons are released.
4. Rotate the main contact switch clockwise until it clicks in place.
5. Press the green power button on the control cart. The power is on once it turns red.
It may seem counterintuitive, but **RED** light = controller is **ON**
GREEN light = controller is **OFF**
6. After booting into Windows, wait for the Safety Light to turn on, then double click the Sidewinder icon on the desktop and wait for the program to initialize. If you click the Sidewinder icon before the safety light comes on, a Connection Setting window may appear. Just press [F2 IP Connection] to resolve this error.
7. Press and hold the button on the spindle to put the previous tool back into the spindle. Release the button to lock the tool.
8. Make sure no alarm is pending or flashing. Go to the Utilities screen, click [Spindle warm up].
9. Once the spindle warm up is completed, the machine is ready to use.



Main contact switch at the side of the router.



Power button on the control cart.



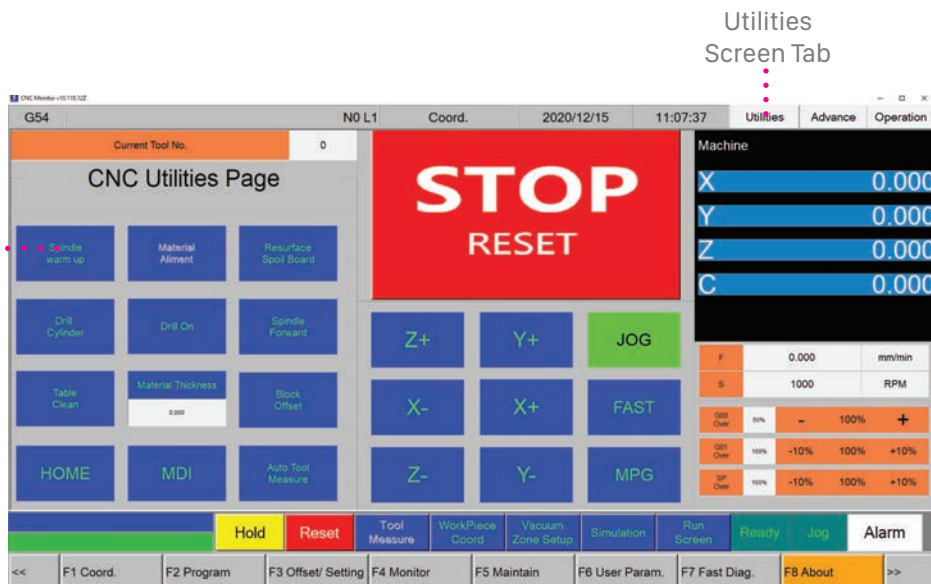
Wait for the safety light to turn white before starting the program.



Sidewinder program icon on the controller desktop.

Spindle Warm Up button

Warm up the spindle only during initial spindle setup or when not in use for a prolonged time. Otherwise, you can warm it up once a month.

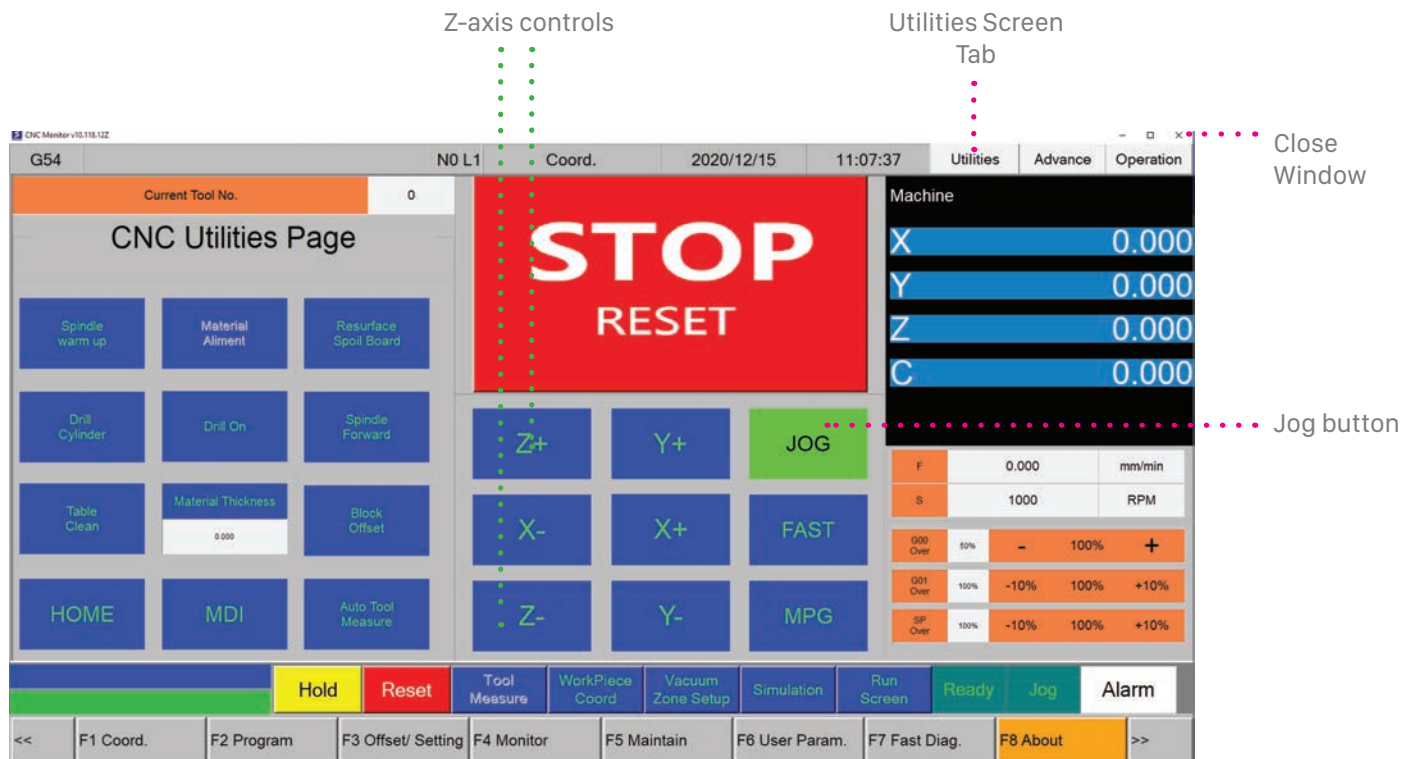


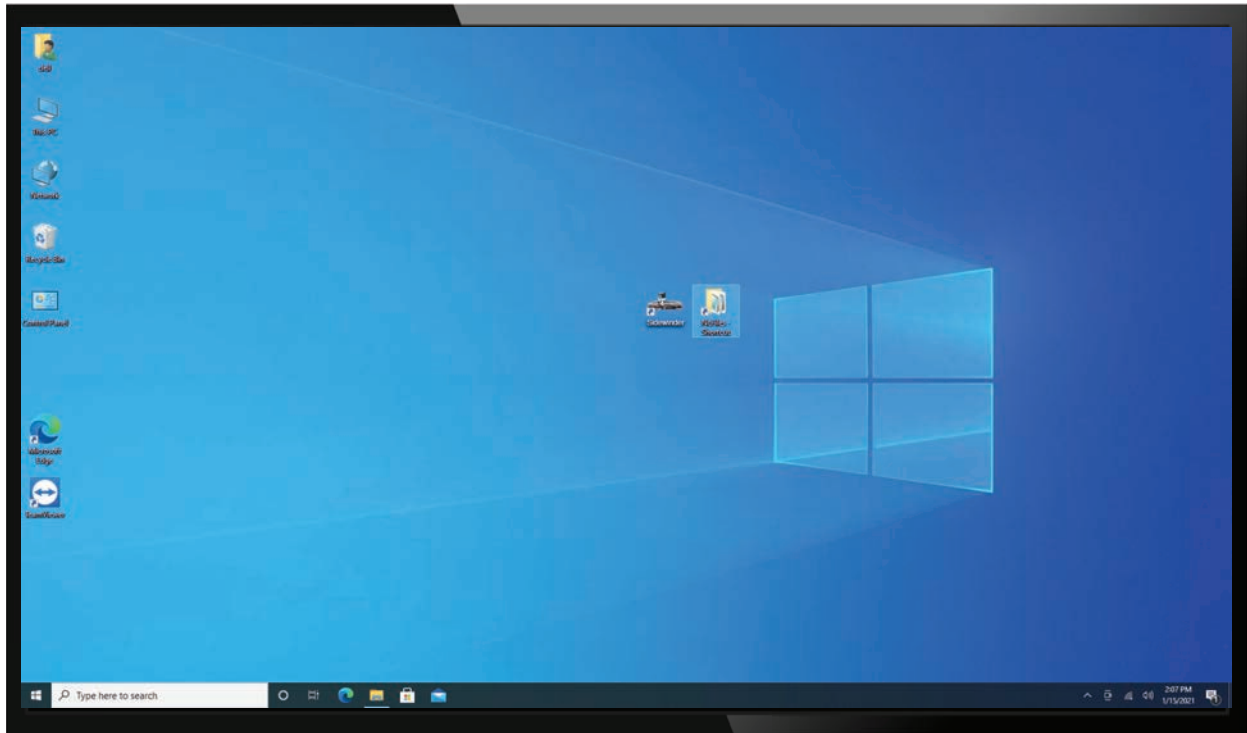
Turning Off the Router

1. On the Utilities screen, switch to Jog Mode by clicking on the [Jog] button.
2. Jog the machine to the tool changer side, press and hold the button on the spindle to release tool and put that tool in the tool changing station.
3. Jog the Z-axis all the way up.
4. Close the Sidewinder software by click the top right X.
5. Shut down Windows.
6. Press the power button on the control cart.
7. Rotate the main contact switch to the OFF position.
8. Disconnect air from the router. Your drill block will drop down after air is disconnected.



As long as you jog the Z-axis all the way up BEFORE turning the machine off, it should not hit your vacuum table.





Getting Started with your Shortcuts

By default, you will have the following shortcuts pre-installed on your controller's desktop:

- Sidewinder icon

To begin operating, click on the Sidewinder icon on your desktop. After loading, you will see the Main Screen.



The program contains all the controls for *all* functionalities of CNC Factory 5th generation routers. Further upgrades may be required on your router to perform all these functionalities. Please contact **support@cncfactory.com** if you wish to upgrade your router.

- CNC File folder [This PC > Local Disk (C:) > Network > CNC > NcFiles]

This is where you upload all your files from your CAD/CAM software. When saving files here, we recommend saving all files of a single job in 1 folder. We do not recommend saving a folder inside another folder (or multiple file levels) as this may cause a program error.

Main Screen

This is the first screen you see after opening the Sidewinder shortcut. It shows real-time information of your machine location and speed. These will make better sense once you have gone through the rest of the operations in this manual. There is no action needed on your part for this screen.

This standard CNC display shows the following information:

The screenshot shows the CNC Factory Sidewinder XPR Main Screen. The interface is divided into several sections:

- Top Bar:** Contains the Current File (G54), Date (2021/1/9), Time (13:35:25), and Main Tabs (Utilities, Advance, Operation).
- Axes Info:** Displays Machine XYZ coordinates (0.000) and Relative XYZ coordinates (0.000).
- Feed Speed:** Shows F (1000.0 mm/min, 100 %) and S (1000 RPM, 100 %).
- Main Navigation Belt:** Includes buttons for Hold, Reset, Cool Measure, WorkPiece Coord, Vacuum Zone Setup, Simulation, Run Screen, Ready, Auto, and Alarm.
- Function Keys Menu:** Includes buttons for F1 Coord., F2 Program, F3 Offset/ Setting, F4 Monitor, F5 Maintain, F6 User Param., F7 Fast Diag., and F8 About.

Annotations point to specific elements:

- Current File:** Points to G54.
- Date:** Points to 2021/1/9.
- Time:** Points to 13:35:25.
- Main Tabs:** Points to the Utilities, Advance, and Operation tabs.
- Axes Info:** Points to the Machine XYZ coordinates.
- Feed Speed:** Points to the F and S values.
- Main Navigation Belt:** Points to the Hold and Reset buttons.
- Function Keys Menu:** Points to the F1 Coord. button.
- Spindle Speed:** Points to the S value.

Back Button

Press to go back to the previous page, or multiple times to return to the Main Screen.

Operation Page

[MAIN SCREEN > OPERATION TAB]

You will use this screen about 98% of the time, and it is made up of the following components below. Activated buttons are in green.

Current tool
⚠ When switching tools, make sure this is updated. The machine may crash if the numbers are incorrectly assigned.

Name of current file

Main Tabs

CNC Operation Page

Current Tool No. 3

Machine

X	45.355
Y	2944.561
Z	-0.132
A	6.000
C	-0.705

F 0.000 mm/min
S 24000 RPM

G00 Over 100% - 100% +
G01 Over 100% -10% 100% +10%
SP Over 100% -10% 100% +10%

Hold Reset Tool Measure WorkPiece Coord Vacuum Zone Setup Simulation Run Screen Jog Ready Alarm

<< F1 Coord. F2 Program F3 Offset/ Setting F4 Monitor F5 Maintain F6 User Param. F7 Fast Diag. F8 About >>

CNC Operation Controls

Standard Controls

These appear in both Utilities & Operation tabs

CNC Operation Controls

AUTO

AUTO

Tells the router to automatically perform its functions. **Automatic operations** will not activate unless the router is on Auto Mode.

4*8
Material

Material Selection

Lets you select different material sizes. By default, it starts with the 4'x8' size. When you switch between sizes, the router's vacuum hold down locations will adjust to match your selected size. Other size-dependent features, such as unloading and unloading, will also refer to the size indicated here.

Smaller models, such as the 4'x8' Sidewinder, may only have 1 size option. In this case, the button is automatically selected.

Simulation

Simulation Mode

A simulation of the Auto function. If you click on Simulation while the machine is performing an operation on Auto mode, it will *pause* that operation. You may then use the **MPG remote** to manually go forward or go in reverse for that operation, one movement at a time.

Example: When you press Simulation while automatically loading material, the operation will pause. You can then use the MPG remote to manually control the pace of loading by turning the MPG dial clockwise or counterclockwise.

File
Import

File Import

To import files directly into the *main* controller in your router cabinet, via the USB ports.

Select
File

Select File

Selects files you want to use. By default, it imports files that are placed in the **CNC File folder**.

Working
File

Working File

Selects a group of files you want to use. Pressing this button takes you to the Workinglist System Page which lets you control the execution of multiple files, including label printing.

Load

Load [requires upgrade]

Loads the raw material from the hydraulic loading table and aligns it with the spoilboard.

Unload

Unload [requires upgrade]

Unloads the processed material to the unloading conveyor. While unloading, a central vacuum suction extracts dust from the spoilboard, and two side nozzles blow air to the railings to clean the process area for the next material.

Load
Un-Load

Load and Unload [requires upgrade]

Loads raw material from the hydraulic loading table, cleans the spoilboard, and unloads processed material into the unloading conveyor.

Dust Hood

Dust Hood [requires upgrade]

Moves the dust hood up and down. There is no need to press this button once the machine is on Auto mode. On rare occasions, you may want to raise the hood while the router is cutting to see it in action. This will cause the dust/debris to fly all over your work area though.

Location
Pins

Location Pins

Moves the pins up and down. This is usually pressed when aligning manually loaded material. If you are on Auto mode, the location pins will automatically activate during the alignment phase of loading.

JOG

Jog

Click to activate Jog Mode. Here, you can manually control the movement of the machine according to each axis.

Z+

Y+

X-

X+

Z-

Y-

Axis buttons (for X, Y & Z)

Each axis has a button for positive and negative directions. The machine moves at a maximum speed of 15,000mm/min to the corresponding direction each time an axis button is pressed.

FAST

Fast

For a faster jog. Click while on Jog mode to move the machine at a maximum speed of 55,000mm/min to the corresponding direction each time an axis button is pressed.

MPG

MPG (Manual Pulse Generator)

Click to use the wireless handheld remote.

Machine

X	0.000
Y	0.000
Z	0.000
C	0.000

Machine Coordinates

These are informational only and cannot be pressed nor altered. Indicates the exact, real-time position of the machine per axis.

- A (Alpha) - location reference for the ATC carousel
- C (Charlie) - location reference for the robotic dust hood motor

** Both are advanced controls for technicians' use.*

F	0.000	mm/min
---	-------	--------

Feed Rate

Indicates the exact, real-time cutting speed of the machine in millimeters per minute (mm/min). In G-code programming, the feed rate value is found in the G01 (or G1) line.

S	1000	RPM
---	------	-----

Spindle Rate

Indicates the exact, real-time rotational speed of the spindle in revolutions per minute (RPM).

Press on the numbers with the +/- sign to change values. The new values will appear in the adjacent white box. By default, the rates are set to 100% of the speed indicated in your G-code.

G00 Over	25%	-	100%	+
-------------	-----	---	------	---

G00 Over

Increases or decreases the rapid movement (or travel speed) of the machine in increments of 25%, from 0% to 100%.

G01 Over	100%	-10%	100%	+10%
-------------	------	------	------	------

G01 Over

Increases or decreases the cutting feed rate in increments of 10%, from 10% to 150%.

SP Over	100%	-10%	100%	+10%
------------	------	------	------	------

SP Over

Increases or decreases the spindle rate in increments of 10%, from 50% to 120%.



Changes to these values will immediately take effect upon pressing the buttons while the machine is in operation. NEVER stop the machine while the router or drill bit is inside your material as it may cause fire.

If you have an unloading table: On rare occasions, the G01 changes its value during unloading when it triggers a sensor by accident. In this case, you would need to manually press 100% again to make sure the machine runs the next file properly.

AUTO vs SIMULATION Mode

Auto Mode

Each operation in Auto Mode contains a sequence of instructions for different parts.

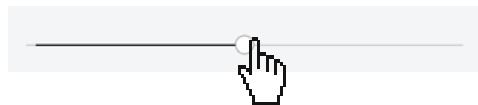
Example: [Auto] Unloading instructs the router to:

- Turn off the vacuum flow
- Travel to the end of the material
- Start the unloading table
- Drop the unloading arm
- Activate the dust extraction suction
- Push the material towards the unloading table
- Raise the location pins after pushing all materials to the unloading table

Simulation Mode

A simulation of the Auto function. If you click on Simulation while the machine is performing an operation on Auto mode, it will pause that operation. You may then use the MPG remote to manually go forward or go in reverse for that operation's sequence, one movement at a time.

Think of Simulation Mode as pausing a video, and then moving the slider left or right to rewind or fastforward the clip one frame at a time.



AUTO vs JOG Mode

Simulation Mode

Lets you control different parts independently, manually. If you just want to control the Unloading arm movement, switch to Jog Mode.

IN THE UTILITIES PAGE

Auto Exclusive Operations

The following are operations that work only in Auto Mode:

- Material Alignment **[requires upgrade]**
- Resurface Spoilboard
- Table Clean
- Auto Tool Measure

Jog Exclusive Operations*

The following are operations that work only in Jog Mode:

- Spindle warm up
- Drill Cylinder **[requires upgrade]**
- Drill On **[requires upgrade]**
- Spindle Forward
- Block Offset **[requires upgrade]**

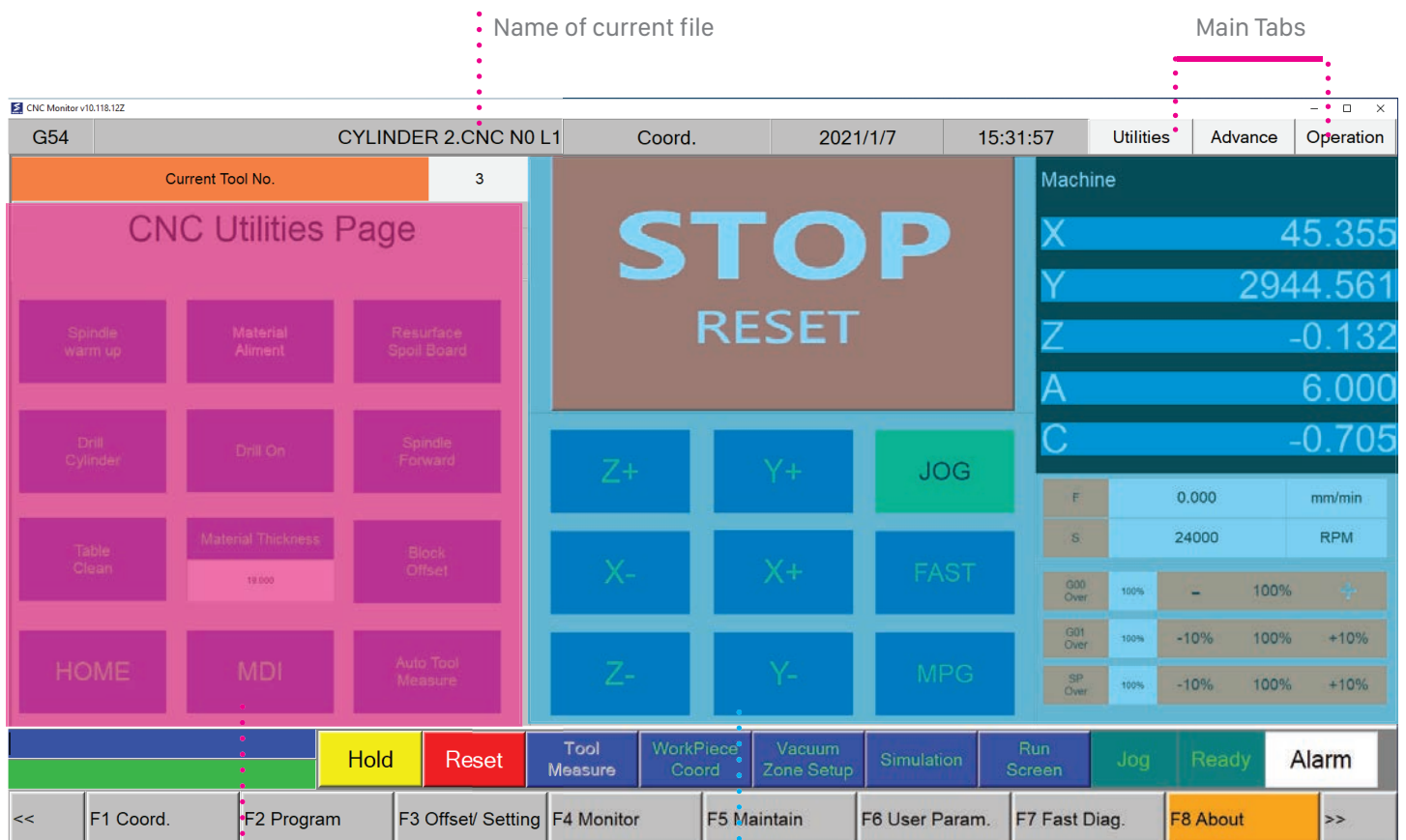
*These, however, are activated in Auto mode if they are part of an automatic sequence.

IN THE ADVANCED PAGE

Buttons of individual parts can only be activated when in Jog Mode.

Utilities Page

[MAIN SCREEN > UTILITIES TAB]



CNC Utilities Controls

Standard Controls

These appear in both Utilities & Operation tabs

CNC Utilities Controls



Spindle Warm Up

Warms up the spindle by running it and increasing its speed gradually. This process takes about 1-2 hours. We recommend warming up the spindle when it is unused for a prolonged time (over the weekend) or when a new one is installed. Pressing on this button also activates the "Spindle Forward" button.

Material Alignment

Material Alignment [requires upgrade]

Automatically aligns material. Works on Auto Mode. Some models have the material alignment as an upgrade.

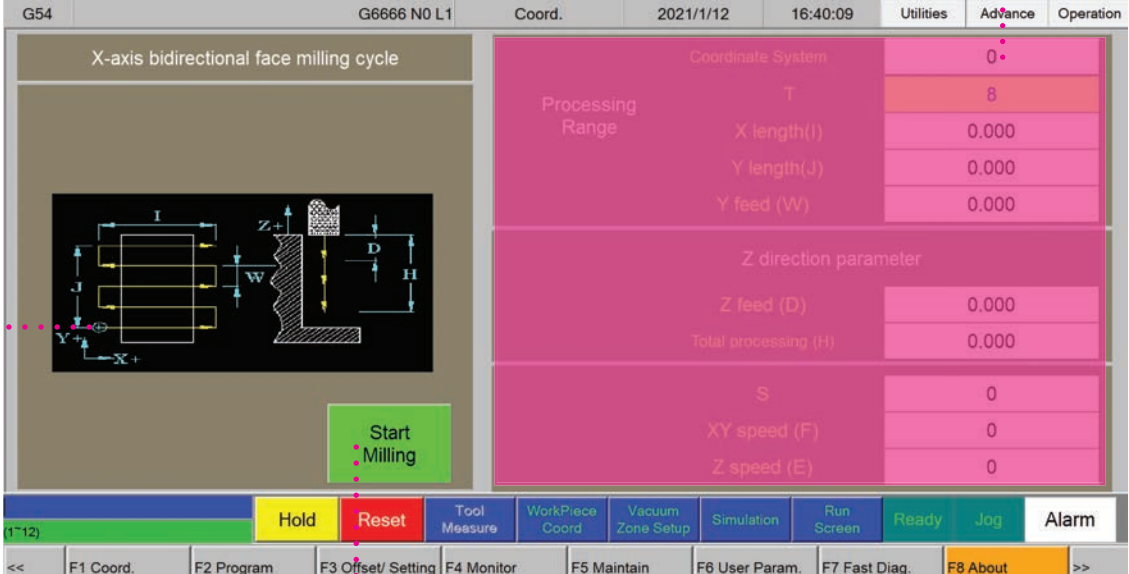
Resurface Spoil Board

Resurface Spoilboard

Opens the resurface spoilboard screen. Once on the screen, press the [Start Milling] button to start resurfacing. The machine will start only on Auto mode.

*This part is for advanced use by technicians.
 The letters in the parenthesis correspond to the graph on the left.*

During resurfacing, the machine will first switch to the fly cutter tool then cut in a zigzagging motion as shown on this graph.



Coordinate System		0
Processing Range	T	8
	X length(I)	0.000
	Y length(J)	0.000
	Y feed (W)	0.000
Z direction parameter		
	Z feed (D)	0.000
	Total processing (H)	0.000
S		0
XY speed (F)		0
Z speed (E)		0

Hold Reset Tool Measure WorkPiece Coord Vacuum Zone Setup Simulation Run Screen Ready Jog Alarm

<< F1 Coord. F2 Program F3 Offset/ Setting F4 Monitor F5 Maintain F6 User Param. F7 Fast Diag. F8 About >>

Press this to start resurfacing.



Your fly cutter is typically set in tool holder #8. Your machine may fail if you move the fly cutter to a different tool holder without adjusting the settings on this screen. If you are switching to a different fly cutter, contact your CNC Factory technician to set up this page for you.

Drill
Cylinder

Drill Cylinderb [requires upgrade]

Moves the drill block up or down.

Drill On

Drill On [requires upgrade]

Turns the drill block on/off.

Spindle
Forward

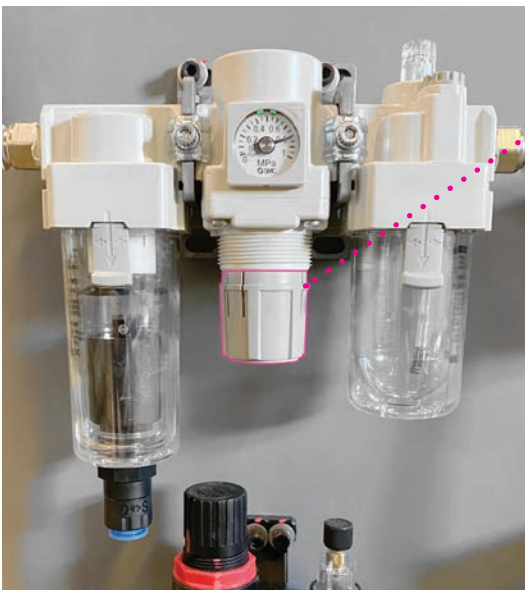
Spindle Forward

Runs the spindle.

Table
Clean

Table Clean

Cleans the table with the central dust extraction and the side air nozzles. The side nozzles require air pressure of at least 0.8 mPa in the main air system. The system will alert you if there is insufficient air pressure as you press this button.



You can raise air pressure by pulling the gray cap down (exposing an orange ring) and turning to the right to increase and left to decrease air pressure. Push the cap back up until the orange ring disappears to lock in the new pressure.



Do not use air pressure over 0.8 mPa as too much air pressure may damage the joints of the air lines of your router.

Material Thickness

0.000

Material Thickness

Click to specify the thickness of your material. The dust hood will hover just above the thickness that you specify.



- If the value indicated is *below* the actual material thickness, there will be a gap between the dust hood and the material where dust and debris may escape.
- If the value indicated is *above* the actual material thickness, it will squish the dust hood brush.

For both scenarios, the depth of the cut will also be inaccurate.

Block Offset

Block Offset [requires upgrade]

Opens the block offset options. This is an advanced feature for technicians. See the Step-by-Step chapter at the end of this manual for [Adjusting Drill Block Offsets](#).

Shows the reference values from the spindle to each drill block port

G54	G6666 N0 L1	Coord.	2021/1/12	17:02:38	Utilities	Advance	Operation
Drill No.	X Comp.	Y Comp.	Z Comp.	Drill No.	X Comp.	Y Comp.	Z Comp.
T21	0.000	0.000	0.000	T34	0.000	0.000	0.000
T22	0.000	0.000	0.000	T35	0.000	0.000	0.000
T23	0.000	0.000	0.000	T36	0.000	0.000	0.000
T24	0.000	0.000	0.000	T37	0.000	0.000	0.000
T25	0.000	0.000	0.000	T38	0.000	0.000	0.000
T26	0.000	0.000	0.000	T39	0.000	0.000	0.000
T27	0.000	0.000	0.000	Preservation			
T28	0.000	0.000	0.000				
T29	0.000	0.000	0.000				
T31	0.000	0.000	0.000				
T32	0.000	0.000	0.000				
T33	0.000	0.000	0.000				
				Hold	Reset	Tool Measure	WorkPiece Coord
				Vacuum Zone Setup	Simulation	Run Screen	Ready
				Jog	Alarm		
<<	F1 Coord.	F2 Program	F3 Offset/ Setting	F4 Monitor	F5 Maintain	F6 User Param.	F7 Fast Diag.
				F8 About	>>		

Tool block info

(Buttons are active only on Jog mode. Clicking on the buttons sends a signal to release air to the solenoid that pops the tool out)

- **T21 to T29:** for the drill block
- **T31 to T39:** for air solenoid tools or marking blocks
- **Preservation Button** - saves edited values (requires password)

HOME

Home

Since your router does not require homing, this feature is only for technicians when they perform absolute encoding during installation.

MDI

MDI (or Manual Data Input)

Allows advanced operators to manually input their own G-code data.

1. After entering the G-code, press [F1 Ok]. The code will then appear in the filename portion of the screen.
2. Press the Start button to execute.

Auto Tool Measure

Auto Tool Measure

If activated, it will prompt the machine to measure a tool before using it. If you have already measured a tool previously, there is no need to leave this activated.

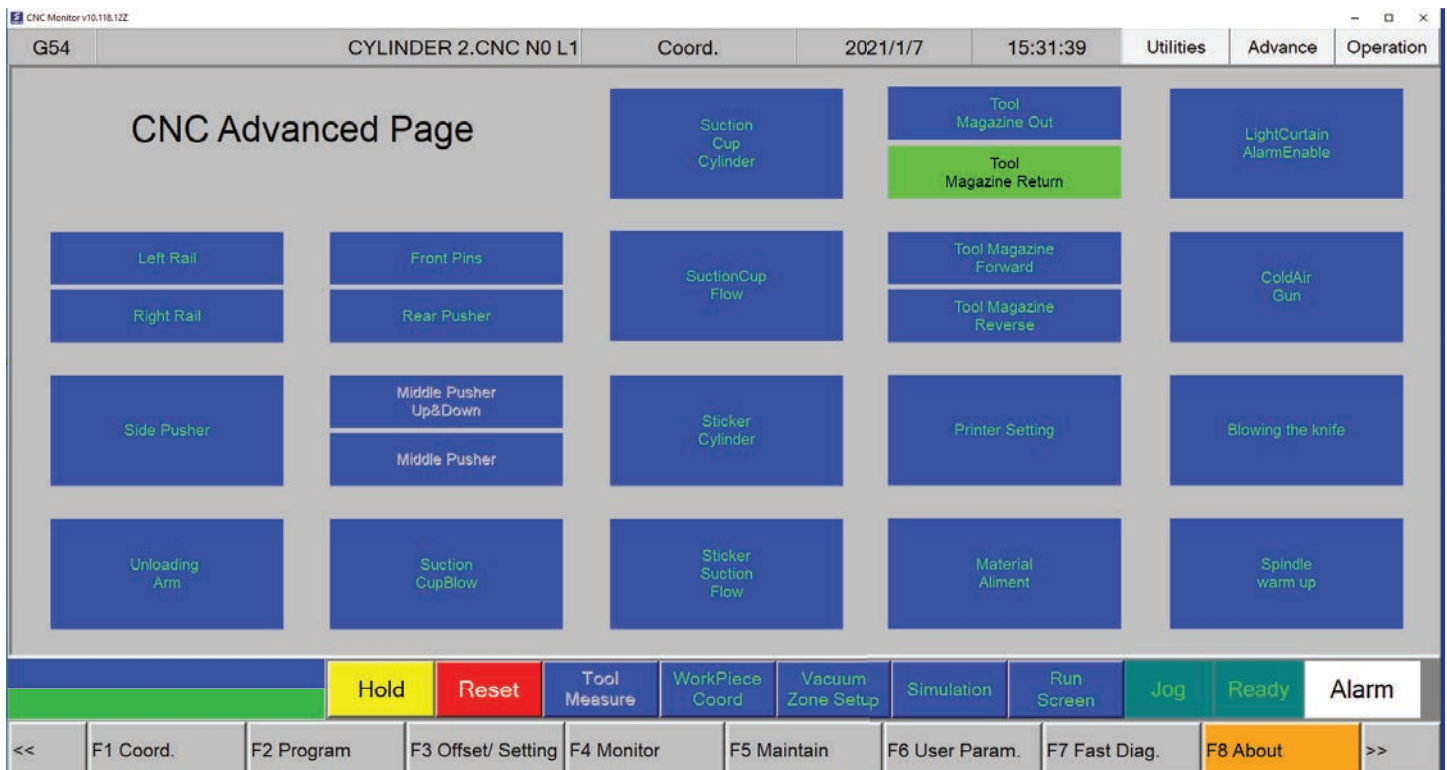
Once activated/deactivated, this alarm appears: "MLCHint 2 Automatic knife close (R590.2) PLC Hint". The 'alarm' is a misnomer since this is just an informational alert that states you have switched modes. It is not an error alarm and does not cause your Alarm display or safety lights to turn red.

Advanced Page

[MAIN SCREEN > ADVANCED TAB]

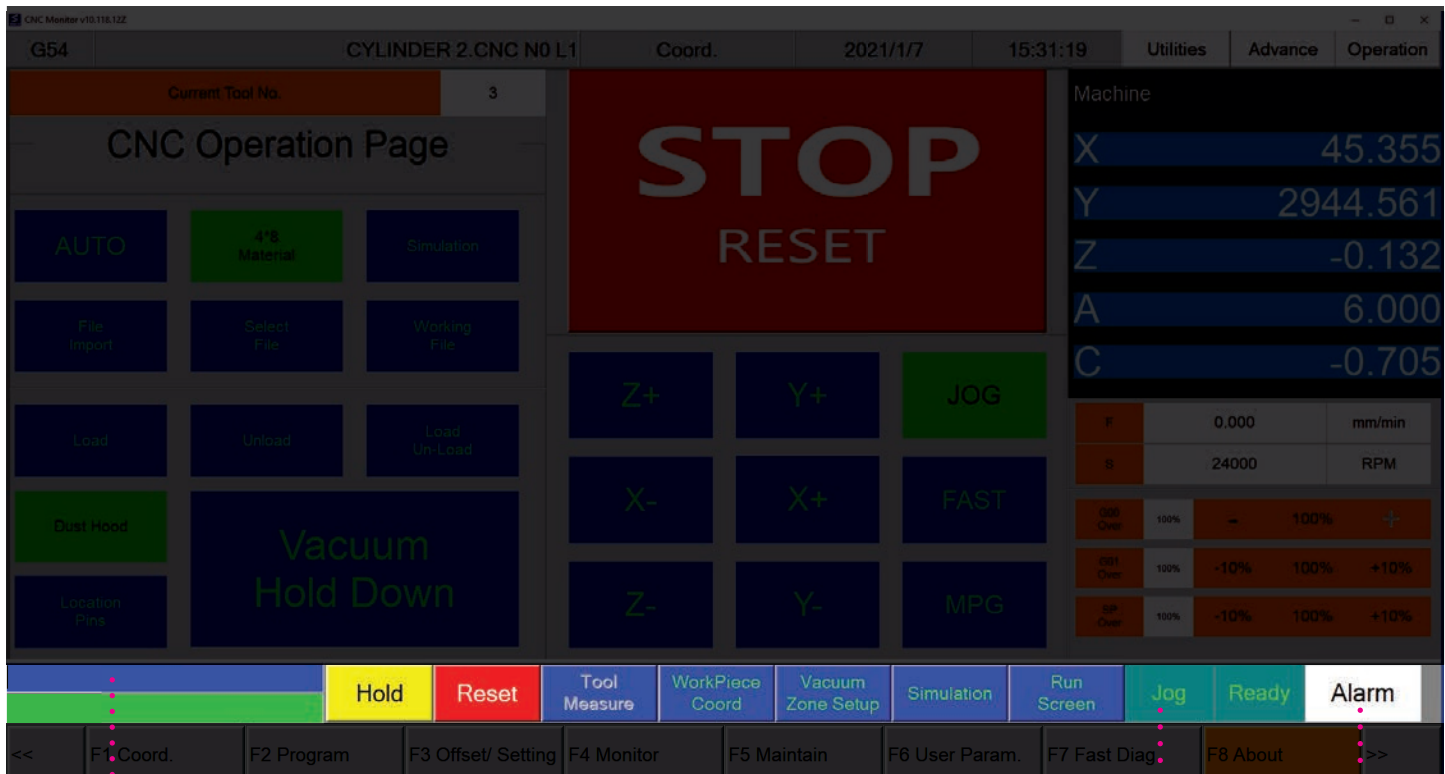
Shows controls for individual parts and is activated when in Jog Mode. Buttons are just toggle switches to activate/deactivate individual parts. This is an advanced area used by technicians for troubleshooting. Parts not included in your router model are deactivated by default.

For example, pressing on the "Left Rail" button will raise or lower it.



Main Navigation Belt

[APPEARS ON ALL TABS]



Input preview (blue) field

Whenever you input values in an editable field, those values are previewed here.

Machine status

- If on Auto or Jog Mode
- If Ready or Busy
- Any alarms

- **Hold** - stops an operation. Despite its name, this does not pause an operation and let you resume after. It works similarly to the reset/stop buttons.
- **Reset** - stops or resets the operation
- **Tool Measure** - to change tools. Opens the tool measure screen. Only works if you are on Auto mode in the Operation tab.
- **Work Piece Coord** - to change workpiece starting points. Opens the workpiece coordinate screen.
- **Vacuum Zone Setup** - to change vacuum zones. Opens a pop-up window.
- **Simulation** - goes to a simulation of the Auto function. Pauses all active operations.
- **Run Screen** - shows the G-code of your current file as well as repeats information from the Main Screen.

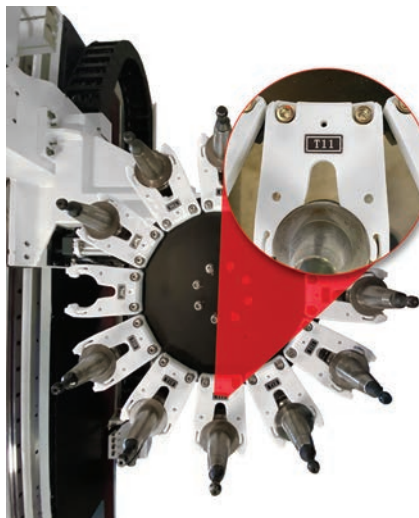
Tool Measure Screen

The Tool Measure Screen lets you measure tools automatically. You need to measure tools **only when you (a) change/adjust a bit, or (b) rearrange the position of your tools.** For simplicity of use, **only configure the Workpiece No. P field.** The rest of the controls are for advanced use of technicians.

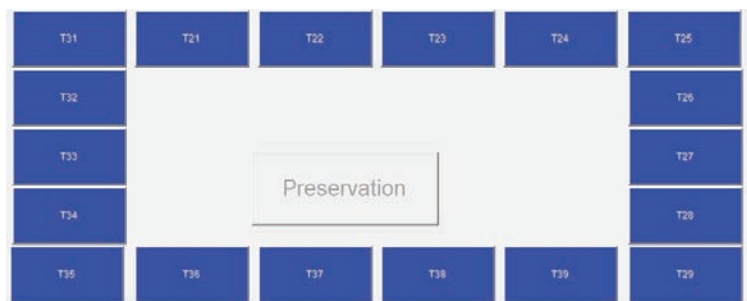


Only change the Workpiece No. P field. On some router models, this appears as the **"Tool Number T"** field.

1. In the Tool Measure screen, click on the Workpiece No. P field. Once highlighted in yellow, type in the number corresponding to the tool you would want to measure. You can find your tool's number at:



The ATC tool carousel



In Utilities > Block Offset > Tool block info
(for drill and marking blocks)

2. Press Enter to save.
3. Press F1 to start.
4. The tool measuring is completed once your safety light goes from green to white.



Entering the wrong tool number (or even entering a non-existent or empty tool holder number) may damage your machine and/or cause it to fail.



When you command the machine to measure a tool, it will return whatever tool is currently on the spindle to its original place first, then proceed to measuring. The machine with the new tool will then go down to the tool measuring device three times to take the measurements.



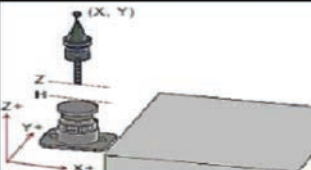
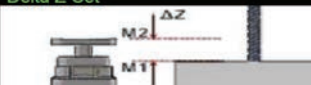
This next part is for informational purposes only. Changing the default values may cause your machine to fail.

Mode

You router should always be in Mode 3:
Multi-tool, multi-workpiece.

Feedrate F

Speed the machine will be moving
as it goes through the tool change in
mm/min.

Auto Tool Function		WorkPiece No. P	Machine
Mode	1	0.000	X 0.000
1:Single tool Single workpiece	0	0.000	Y 0.000
2:Single tool Multi-workpiece	0.000	0.000	Z 0.000
3:Multi-tool Multi-workpiece	0.000	0.000	C 0.000
4:Five axes	0.000	0.000	
		Min. Z Mach. H	Relative
		Safe Z After Measure	X 0.000
Select if use Ref Point 1:Set All measure parameter 2.If not use Ref, Take tool tip to upper of measurement 3:Press F1, Measure Start		Delta Z Set	Y 0.000
		Do tool tip measure before do Delta Z	Z 0.000
		1:Take tool tip to top of good	C 0.000
		2:Press F3, Delta Z Set	
		Gauge Air Blow: ON: M 0 OFF: M 0	Aux. Coord.
			X 0.000
			Y 0.000
			Z 0.000

Use Reference

Grants or denies
permission to use the
succeeding reference
coordinate values. "1"
means "true" or allows
you to use the reference.
"0" means "false" or does
not allow you to use the
reference.

Reference Coordinates

Identifies the location of/
directional limits for your tool
measuring device.

Workpiece Coordinates Screen

The Workpiece Coordinates Screen lets you use alternate workpiece starting points, instead of your default G54 coordinates. You can create and save up to 100 workpiece coordinates here.

External Shift

Any value placed here will be added or subtracted to the value of the G54.

G54 Slot

Default Points

G54	G6666 N0 L1	Coord.	2021/1/12	17:47:58	Utilities	Advance	Operation		
External Shift		G54P1(G54)		G54P2(G55)		Machine X 0.000 Y 0.000 Z 0.000 C 0.000 Relative X 0.000 Y 0.000 Z 0.000 C 0.000 Aux. Coord. X 0.000 Y 0.000 Z 0.000			
X	0.000	X	0.000	X	10.000				
Y	0.000	Y	0.000	Y	11.000				
Z	0.000	Z	0.000	Z	0.000				
C	0.000	C	0.000	C	0.000				
MPG Shift		G54P3(G56)		G54P4(G57)					
		X	0.000	X	0.000			X	0.000
		Y	0.000	Y	0.000			Y	0.000
		Z	0.000	Z	0.000			Z	0.000
C	0.000	C	0.000	C	0.000				

Hold **Reset** **Tool Measure** **WorkPiece Coord.** **Vacuum Zone Setup** **Simulation** **Run Screen** **Ready** **Auto** **Alarm**

<< F1 Apply Mach. Coord. F2 Apply Rel. Coord. F3 Apply Aux. Coord. F4 Inc. Input F5 Manual Center F6 Apply Mach. Coord. Inc. F8 Next Coord. Page >>

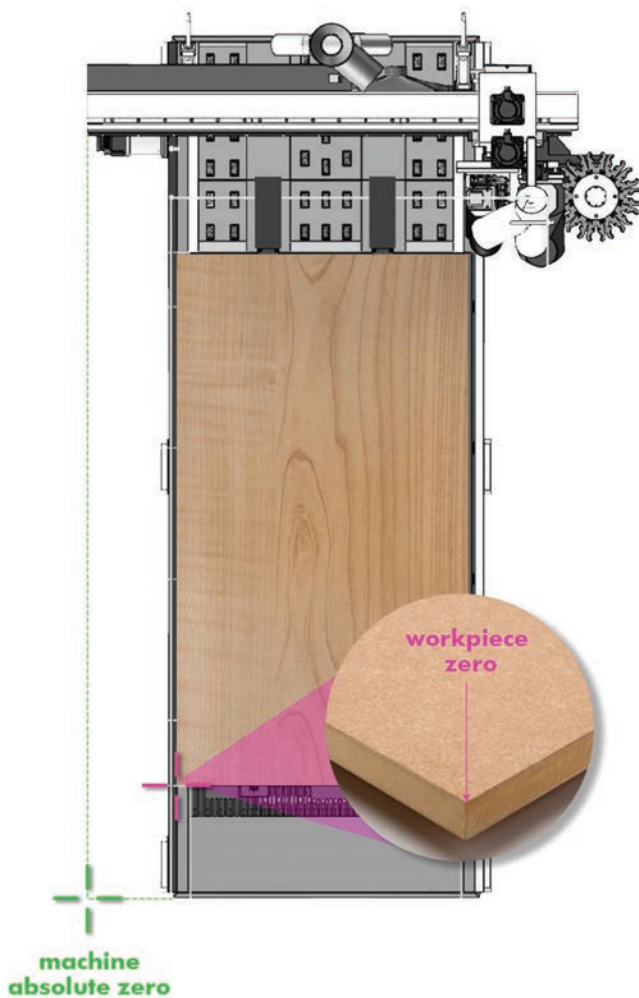
Coordinate Slots

Empty slots by default for customization. Goes from (from G54P2 to G54P100).

Coordinate Info Panel

- Machine- the current, exact position of the machine.
- Relative - a position relative to another specified position. This is an advanced feature for technicians.

The screen shows the first 6 workpiece coordinates, to view the rest, press [Page Up] or [Page Down] on your keyboard.



Machine Absolute Zero Vs. Workpiece Zero

The **machine's absolute zero** is the lowest value the machine can go in the X & Y axis. It's usually at the lower leftmost point of your router.

The **workpiece zero** (or G54) is an offset to the workpiece home position. It's usually at the lower leftmost point of your work piece. Most of the code executed by the router will be based on your G54; these coordinates will already be set-up in your router.

To save a new workpiece coordinate:

1. Set your Operation page to Jog mode.
2. Jog your machine to your chosen location using the on-screen controls or MPG remote.
3. Go back to the Workpiece Coordinate screen.
4. Select an empty coordinate slot.
5. Copy the machine's current location from the Coordinate Info panel into the empty coordinate slot:
 - Manually by highlighting and typing on each axis. Press enter to save the new values. You can edit one axis at a time.
 - Automatically by pressing the [F1 Apply Mach Coord] function key. A pop up will appear each time to confirm your choice.



When will I need to use this?

Since cuts, by default, are referenced from the G54 location, the area close to your G54 can be subject to overcutting. Setting workpiece coordinates farther from your G54 from time to time can extend the life of your spoilboard.

Vacuum Zone Setup Screen

Appears as a pop-up screen once clicked. This screen allows you to select which vacuum zones to activate. Depending on your router model, you may activate between 4-6 zones. By default, all zones are activated. And should you have 2 vacuum pumps, both will provide equal suction on activated zones.



To customize vacuum zones:

1. Select the letters of the zones corresponding to your choice. Selected zones are in green, deselected zones in blue.
2. Press the "Save As New Zone Setting" button.
3. Close the Vacuum Zone Setup window.



We recommend sticking to the default settings where all zones are activated, since having only partial hold down may cause your spoilboard to bow.

Reset to Default Zone

Activates all zones. Make sure to click 'Save As New Zone Setting' after resetting to keep this setting.

Vacuum Pressure Alarm Enable

If enabled, the router will alert you in all instances where the vacuum pressure is not enough (Usually when the pressure is under 0.5 mPa).



The vacuum pressure gauge is very sensitive and will alert you of low pressure even on operations that do not require vacuum (such as tool changing). You may keep this deactivated to avoid having constant alerts. Your router will still function properly even if deactivated. Even if the alerts are off, your router will continue to cut *only* if there is sufficient hold down.

Run Screen

Shows the G-code of your current file as well as repeats information from the Main Screen.

Run Time: Running time of the current file

Accu. Time: Accumulated or total running time of the router. It goes back to zero whenever the router is reset or by pressing [F8 Clear Accum. Cycle Time]

Information you can reference when editing G-code

Your G-code will appear here



You can preview your tool path here by pressing [F2 Simulation Switch]

F1 Edit

To edit the G-code for advanced users.



Keyboard commands:

- Arrows to move the cursor
- [Page Up] & [Page Down] to switch pages
- [Home] and [End] to bring the cursor to the start or end of a line

F2 Simulation Switch

Shows a graphical representation of the G-code and displays the tool trajectory of the current file.

F3 MDI Input

Stands for Manual Data Input. This is an advanced feature used for testing purposes by technicians. This is deactivated by default.

F4 Param Set

Switches the screen between machine settings and information. This is an advanced feature for technicians.

F5 Tool Wear Set

To modify the new diameter and height of tools when they wear down. This is an advanced machining technique. We recommend using tool providers such as [Deluche by CNC Factory](#), which provide you brand new bits for the same price as sharpening. Brand new bits do not require Tool Wear Set modifications.

F6: Start MPG Shift

Shows coordinates when on MPG simulation mode.

F7 Work Record

Shows the current machining record. Pressing F1 allows you to export the record to an external device. Pressing F2 clears the work record.

F8 Clear Accum. Cycle Time

Clears the accumulated cycle time.

more options [>>]

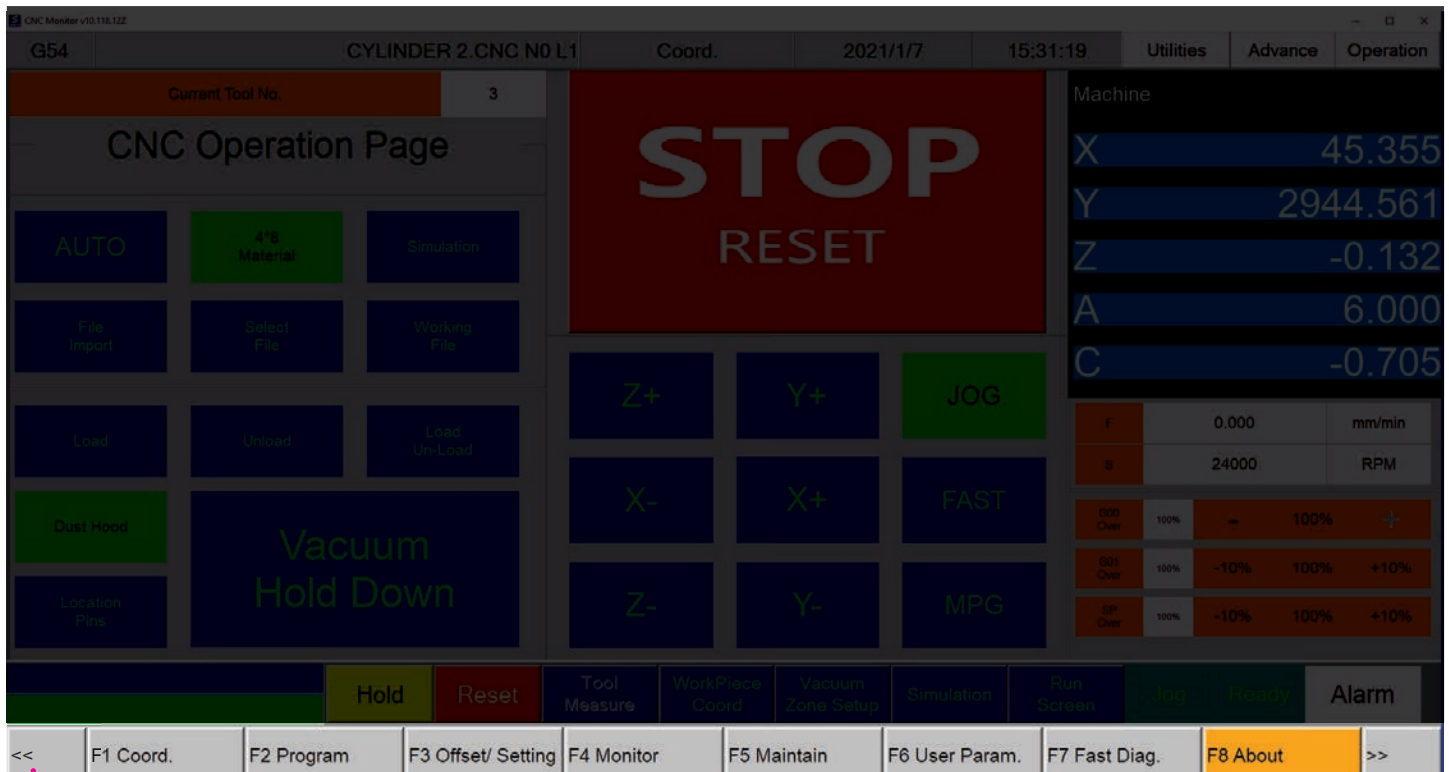
F1 Graph Adjust

Allows zooming in and out of the simulation graph. This is enabled if you are on Simulation mode.

Function Keys Menu

[APPEARS ON ALL TABS]

Below are the main Function Keys on your Main Screen & Tab Pages. Function Key options usually vary according to the active operation/screen. Most function keys are for advanced use by technicians.



Back Button

Press to go back to the previous page, or multiple times to return to the Main Screen.

F1 Coord

For resetting and switching coordinates.

F2 Program

For editing G-code.

F3 Offset/Setting

For workpiece coordinate info and tool setting/measurement.

F4 Monitor

Similar to [Run Screen](#).

F5 Maintain

For alarms, server and system settings.

F6 User Param

For editing user parameters.

F7: Fast Diag

Displays system data.

F8 About

Displays general system information.

more options [>>]

F1 PLC Status

Displays info on programmable logic controllers. Each data point corresponds to the PLC in your router.

F2 Diag.

Displays system data, global data, coordinates & operation log.

F3 Param

For editing all user parameters.

F4 Sys Admin

To log-in to system admin with a password.

F5 Auto Labeling

Controls for the label printer.

F8 Working List

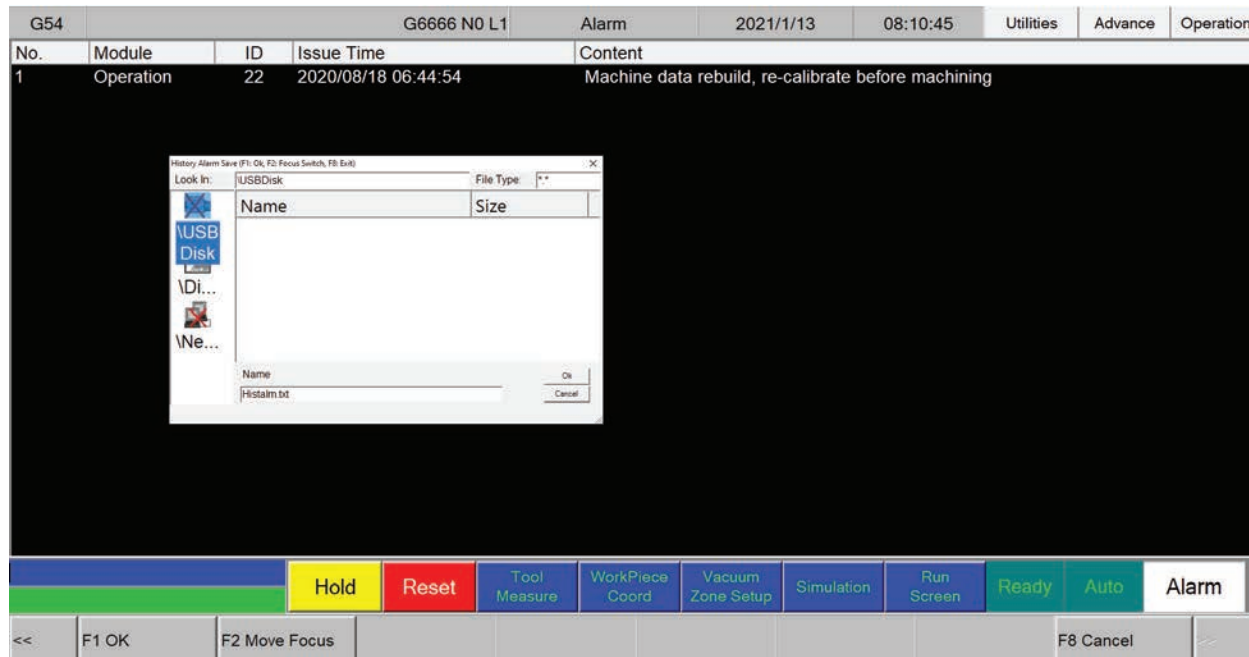
Controls for the [working list](#).

STEP-BY-STEP GUIDES

Checking your Alarm History

If you encounter an alarm (or multiple alarms) and need the assistance of a CNC Factory technician, this page will help provide information to your technician to properly diagnose your issue. We recommend you save/take a screenshot of your most recent alarms and send it as an attachment when requesting for a service ticket.

1. Click [F5 Maintain]
2. Click [F1 Alarm]
3. Click [F2 History Alarm]
4. Save a screenshot OR press [F3 Save Alarm] + [F1 Ok] to save the file



Backing up your Files

For more complicated technical issues, we may ask you to create a backup of your file and send it to us, instead of guiding you remotely with multiple steps, so we can diagnose and correct properly.

1. Click [F5 Maintain]
2. Click [F6 Backup Sys]
3. Click [F1 Next], select a destination and press [Ok]
4. Click [F1 Next] and then [F1 Ok].

Back up takes about 3-20 minutes. Should the window state that it is "not responding", give it a few seconds to process and it should resume back up. Your backup will be saved as a zipped folder in your previously set destination.

Activating Function Keys

If your program does not show Function Key Shortcuts (F1, F2, etc).



What your screen
looks like without
Function Keys

1. From the Main Screen, go to the gray menu buttons at the bottom and press [Maintain]
2. Click [Sys Setting]
3. Click [Set MMI Config]
4. At the bottom of the table, at the "[Fenubar] No Function No." row, select the value "TRUE"
5. Click Modify and a pop-up window will appear.
6. Change the value from "True" to "False" in the pop-up window and click [Ok]
7. Close the program to reset.
8. Open it again by double clicking the Sidewinder icon. The Function keys should be visible.

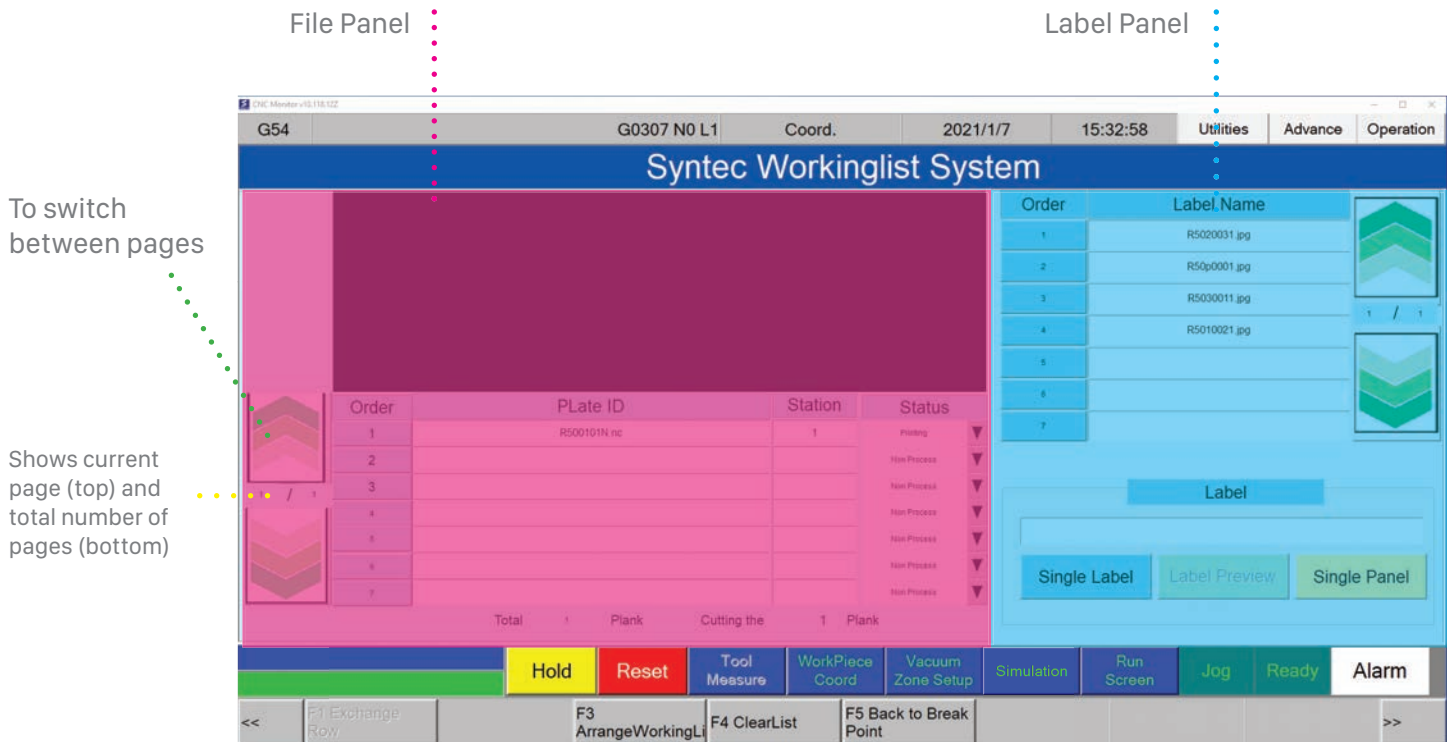
F1 Coord.	F2 Program	F3 Offset/ Setting	F4 Monitor	F5 Maintain	F6 User Param.	F7 Fast Diag.	F8 About
-----------	------------	--------------------	------------	-------------	----------------	---------------	----------

Executing your first (single) file

1. Turn the router on.
2. Save your design file into the **CNC File folder**.
 - Save to the folder if designing from the controller
 - Save to the folder after importing via USB
 - Save to the folder after downloading from the internet (cloud, email)
3. Double click on the Sidewinder icon.
4. From the Main Screen, click on the [Utilities] tab.
5. Click [Front Pins] to activate the loading pins and load and align your material.
6. After, click on the [Operation] tab.
7. Click [Select File].
8. Select the file from the CNC file folder.
9. After you select the file, the top part of the screen should show the filename you selected
10. After you check that the filename is correct, check the material size. If not, click on the [Material Selection] button to switch to your preferred size.
11. Then switch to the Utilities Page by clicking on the [Utilities] tab.
12. On the Utilities page, click on [Material Thickness] and specify the dimensions.
13. Press the [Start] button to begin cutting.

Using Working List/File

A driverless CNC feature that allows queueing of up to 999 files. (*only available in the XPR series and **ideally used with the loading/unloading tables**). Jobs under the working list are executed one after the other. It also shows the real-time status of each file for easy monitoring.



File Panel

Order

Shows the sequence of the jobs in queue.

Plate ID

Shows the filename.


Status


- **Non Process:** no operation is in process.
- **Alignment:** alignment/loading/unloading is in process.
- **Working:** cutting is in process.
- **Printing:** label printing is in process. Printing usually takes place before cutting.
- **Completed:** all file operations are completed.

Label Panel

The label panel info shown corresponds to the selected file from the file panel. Each file can have multiple labels. The label info will automatically change as you go down your file list.

Order	Label Name
1	R5020031.jpg
2	R50p0001.jpg
3	R5030011.jpg
4	R5010021.jpg
5	
6	
7	


1 / 1



Label

Single Label

Label Preview

Single Panel

Order
Shows the sequence of labels in queue.

Label Name
Shows the label filename.

Single Label Button
Selects a single label for printing.

Label Preview Button
Shows a preview of the JPG image of your label.

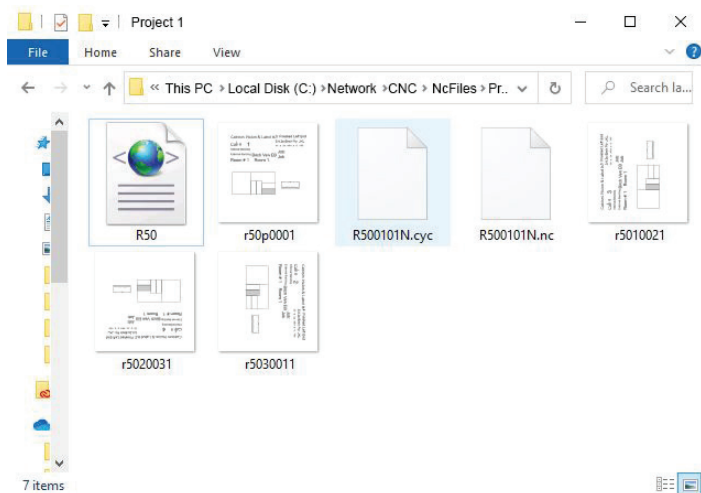
Single Panel Button
Selects the entire panel of labels for printing.

Working List Step-by-Step: [requires upgrade]

1. Save your design file in the **CNC File folder**:
 - Save to the folder if designing from the controller
 - Save to the folder after importing via USB
 - Save to the folder after downloading from the internet (cloud, email)
3. Open the Sidewinder program and go to the Operation Page by clicking on the [Operation] tab.
4. Press [Auto].
5. Go to the Working list page by clicking the [Working File] button.
6. Press [F4 Clear List] and click [Ok] to delete your previous working list. When you clear your list, you are only removing them from the Working List screen and not from your CNC File Folder.
7. Press [F3 Arrange Working List].
8. Select the files you want to use by ticking on the checkbox corresponding to it. You may also click [F2 Select All] to select everything (Note that F2 Select All only selects all individual files, and not folders).
9. Press [F1 Output List].
10. Press [F1 Ok] or click [Ok] from the pop-up window. Your imported files should now appear in your working list, for both the file and label panels (if applicable). If not, **change your file extension**.
11. Press the Start button to begin executing.

What does an imported file look like?

The file you import to the working list typically comprise of the following:



- **XML Document** - links the other files to the Sidewinder program
- **NC*** - contains the G-code for your job
- **CYC** - contains commands on where to place the labels
- **JPG** - the actual images printed on the labels

*file extension may vary and can be changed [See next page].

Changing your File Extension

By default, the program runs “.nc” files. If your G-code file has a different extension (e.g. “.cnc”), you can change them by:

1. You must be on the Working List Page First. Click [Operation] tab, then [Working File].
2. Below, on the Function Keys Menu, click on the right arrow to reveal additional menu items.
3. Select [F1 Set Extension Name].
4. Type in the new extension in the extension filter pop up, then press [Ok].

For files not having a “.nc” extension: If you do not change the extension name to match your files, it will not appear on the working list when you import it.

If your files still do not appear after changing the extension name, or your file appears but not its labels, go to the Working List Parameter Setting Screen**.

1. You must be on the Working List Page First. Click [Operation] tab, then [Working File].
2. Below, on the Function Keys Menu, click on the right arrow to reveal additional menu items.
3. Select [F8 Working List Setting].
4. Go to “Load File Type”, click the arrow to show the dropdown options and select “xml”, then press Enter.
5. Go back to the main Working List Screen.
6. Press [F3 Arrange Working List] and select your files again.
7. Press [F1 Output List] and [Ok].
8. The label panel should show files associated with your G-code file.

*** The other options in the Working List Parameter Settings are for advanced use by technicians.*

Measuring Larger Tools

Follow these steps to measure tools that will not fit your tool holder:

1. On the [Tool Measure] screen, press [F1 Start]. The machine will do a tool change if necessary then move to the tool measuring device.
2. Once it starts to go down to measure it, hit the [Reset] button.
3. Go to the [Operation] page and click [MPG].
4. Use your MPG remote to move the spindle and attach your oversized tool to it.
5. Bring the spindle to the center of your tool measuring device. Remember, the spindle needs to go down 3 times to measure your tool— make sure your oversized tool will not crash into anything as it goes down. You can place the spindle higher to make sure the tool blade is not touching the sensor.
6. Switch back to [Auto] mode.
7. Go back to the [Tool Measure] Screen.
8. Highlight the "Use Reference" area, enter "0" the hit [Enter] to save.
9. After the Use Reference value is turned to zero, press [F1 Start].



The tool measuring device near the corner of your router

This will tell the machine that the tool measuring device is already directly under the spindle, so it will prompt it to just go directly down for measurements.

G54	G0307 N0 L1	Coord.	2021/1/15	11:42:23	Utilities	Advance	Operation
Auto Tool Function Mode 1 1:Single tool Single workpiece 2:Single tool Multi-workpiece 3:Multi-tool Multi-workpiece 4:Five axes							
		WorkPiece No. P 3 Feedrate F 0.000 Use Reference 0 Ref Coord. X 0.000 Ref Coord. Y 0.000 Ref Coord. Z 0.000 Min. Z Mach. H 0.000 Safe Z After Measure 0.000 Select if use Ref Point 1:Set All measure parameter 2:If not use Ref, Take tool tip to upper of measurement 3:Press F1, Measure Start Delta Z Set 0.000 Do tool tip measure before do Delta Z 1:Take tool tip to top of good 2:Press F3, Delta Z Set Gauge Air Blow: ON: M 0 OFF: M 0			Machine X 0.000 Y 0.000 Z 0.000 C 0.000 Relative X 0.000 Y 0.000 Z 0.000 C 0.000 Aux. Coord. X 0.000 Y 0.000 Z 0.000		
<div style="display: flex; justify-content: space-between;"> 0*1) 0:Not use Ref, 1:Use Ref Hold Reset Tool Measure WorkPiece Coord Vacuum Zone Setup Simulation Run Screen Ready Auto Alarm </div> <div style="display: flex; justify-content: space-between;"> << F1 Start F2 Reset F3 Z Delta Set F4 Apply XY Ref. Coord. F5 Apply Z Mach. Coord. F7 Gauge Z Coord. Teach >> </div>							

Use Reference Field

10. Once finished, make sure to change your Use Reference value back to "1" for your regular bits.

For advanced users:

Adjusting Drill Block Offsets [requires upgrade]

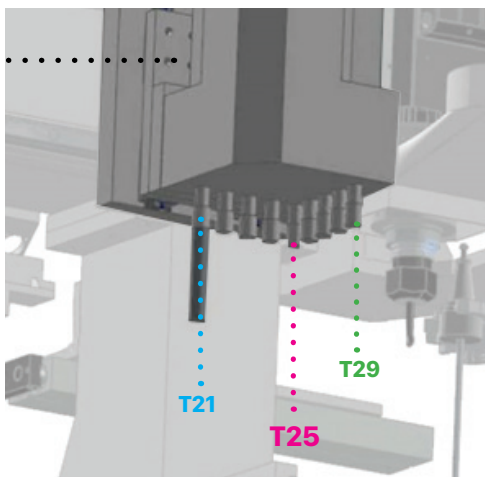
You can adjust the drill block offset to indicate the direction (and by how much) the machine needs to travel in order for the drill block to bore at the same location where the spindle did previously.

1. In the [Operation] page, click [JOG].
2. Go to the [Utilities] page and click [Block Offset].
3. Highlight the field you want to adjust, type in the new value and press [Enter].
4. Once the number has changed, press [Preservation] to save.
5. If prompted for a password, type in "521" and press [F1 Ok].

Adjust T25
first

G54	CIRCLE.NC N0 L1			Alarm	2021/1/15		13:49:10		Utilities	Advance	Operation
Drill No.	X Comp.	Y Comp.	Z Comp.	Drill No.	X Comp.	Y Comp.	Z Comp.				
T21	0.000	0.000	0.000	T34	0.000	0.000	0.000				
T22	0.000	0.000	0.000	T35	0.000	0.000	0.000				
T23	0.000	0.000	0.000	T36	0.000	0.000	0.000				
T24	0.000	0.000	0.000	T37	0.000	0.000	0.000				
T25	160.000	12.000	0.000	T38	0.000	0.000	0.000				
T26	0.000	0.000	0.000	T39	0.000	0.000	0.000				
T27	0.000	0.000	0.000	T40	0.000	0.000	0.000				
T28	0.000	0.000	0.000	T41	0.000	0.000	0.000				
T29	0.000	0.000	0.000	T42	0.000	0.000	0.000				
T30	0.000	0.000	0.000	T43	0.000	0.000	0.000				
T31	0.000	0.000	0.000	T44	0.000	0.000	0.000				
T32	0.000	0.000	0.000	T45	0.000	0.000	0.000				
T33	0.000	0.000	0.000	T46	0.000	0.000	0.000				
				T47	0.000	0.000	0.000				
				T48	0.000	0.000	0.000				
				T49	0.000	0.000	0.000				
				T50	0.000	0.000	0.000				
				T51	0.000	0.000	0.000				
				T52	0.000	0.000	0.000				
				T53	0.000	0.000	0.000				
				T54	0.000	0.000	0.000				
				T55	0.000	0.000	0.000				
				T56	0.000	0.000	0.000				
				T57	0.000	0.000	0.000				
				T58	0.000	0.000	0.000				
				T59	0.000	0.000	0.000				
				T60	0.000	0.000	0.000				
				T61	0.000	0.000	0.000				
				T62	0.000	0.000	0.000				
				T63	0.000	0.000	0.000				
				T64	0.000	0.000	0.000				
				T65	0.000	0.000	0.000				
				T66	0.000	0.000	0.000				
				T67	0.000	0.000	0.000				
				T68	0.000	0.000	0.000				
				T69	0.000	0.000	0.000				
				T70	0.000	0.000	0.000				
				T71	0.000	0.000	0.000				
				T72	0.000	0.000	0.000				
				T73	0.000	0.000	0.000				
				T74	0.000	0.000	0.000				
				T75	0.000	0.000	0.000				
				T76	0.000	0.000	0.000				
				T77	0.000	0.000	0.000				
				T78	0.000	0.000	0.000				
				T79	0.000	0.000	0.000				
				T80	0.000	0.000	0.000				
				T81	0.000	0.000	0.000				
				T82	0.000	0.000	0.000				
				T83	0.000	0.000	0.000				
				T84	0.000	0.000	0.000				
				T85	0.000	0.000	0.000				
				T86	0.000	0.000	0.000				
				T87	0.000	0.000	0.000				
				T88	0.000	0.000	0.000				
				T89	0.000	0.000	0.000				
				T90	0.000	0.000	0.000				
				T91	0.000	0.000	0.000				
				T92	0.000	0.000	0.000				
				T93	0.000	0.000	0.000				
				T94	0.000	0.000	0.000				
				T95	0.000	0.000	0.000				
				T96	0.000	0.000	0.000				
				T97	0.000	0.000	0.000				
				T98	0.000	0.000	0.000				
				T99	0.000	0.000	0.000				
				T100	0.000	0.000	0.000				
				T101	0.000	0.000	0.000				
				T102	0.000	0.000	0.000				
				T103	0.000	0.000	0.000				
				T104	0.000	0.000	0.000				
				T105	0.000	0.000	0.000				
				T106	0.000	0.000	0.000				
				T107	0.000	0.000	0.000				
				T108	0.000	0.000	0.000				
				T109	0.000	0.000	0.000				
				T110	0.000	0.000	0.000				
				T111	0.000	0.000	0.000				
				T112	0.000	0.000	0.000				
				T113	0.000	0.000	0.000				
				T114	0.000	0.000	0.000				
				T115	0.000	0.000	0.000				
				T116	0.000	0.000	0.000				
				T117	0.000	0.000	0.000				
				T118	0.000	0.000	0.000				
				T119	0.000	0.000	0.000				
				T120	0.000	0.000	0.000				
				T121	0.000	0.000	0.000				
				T122	0.000	0.000	0.000				
				T123	0.000	0.000	0.000				
				T124	0.000	0.000	0.000				
				T125	0.000	0.000	0.000				
				T126	0.000	0.000	0.000				
				T127	0.000	0.000	0.000				
				T128	0.000	0.000	0.000				
				T129	0.000	0.000	0.000				
				T130	0.000	0.000	0.000				
				T131	0.000	0.000	0.000				
				T132	0.000	0.000	0.000				
				T133	0.000	0.000	0.000				
				T134	0.000	0.000	0.000				
				T135	0.000	0.000	0.000				
				T136	0.000	0.000	0.000				
				T137	0.000	0.000	0.000				
				T138	0.000	0.000	0.000				
				T139	0.000	0.000	0.000				
				T140	0.000	0.000	0.000				
				T141	0.000	0.000	0.000				
				T142	0.000	0.000	0.000				
				T143	0.000	0.000	0.000				
				T144	0.000	0.000	0.000				
				T145	0.000	0.000	0.000				
				T146	0.000	0.000	0.000				
				T147	0.000	0.000	0.000				
				T148	0.000	0.000	0.000				
				T149	0.000	0.000	0.000				
				T150	0.000	0.000	0.000				
				T151	0.000	0.000	0.000				
				T152	0.000	0.000	0.000				
				T153	0.000	0.000	0.000				
				T154	0.000	0.000	0.000				
				T155	0.000	0.000	0.000				
				T156	0.000	0.000	0.000				
				T157	0.000	0.000	0.000				
				T158	0.000	0.000	0.000				
				T159	0.000	0.000	0.000				
				T160	0.000	0.000	0.000				
				T161	0.000	0.000	0.000				
				T162	0.000	0.000	0.000				
				T163	0.000	0.000	0.000				
				T164	0.000	0.000	0.000				
				T165	0.000	0.000	0.000				
				T166	0.000	0.000	0.000				
				T167	0.000	0.000	0.000				
				T168	0.000	0.000	0.000				
				T169	0.000	0.000	0.000				
				T170	0.000	0.000	0.000				
				T171	0.000	0.000	0.000				
				T172	0.000	0.000	0.000				
				T173	0.000	0.000	0.000				
				T174	0.000	0.000	0.000				
				T175	0.000	0.000	0.000				
				T176	0.000	0.000	0.000				
				T177	0.000	0.000	0.000				
				T178	0.000	0.000	0.000				
				T179	0.000	0.000	0.000				
				T180	0.000	0.000	0.000				
				T181	0.000	0.000	0.000				
				T182	0.000	0.000	0.000				
				T183	0.000	0.000	0.000				
				T184	0.000	0.000	0.000				
				T185	0.000	0.000	0.000				
				T186	0.000	0.000	0.000				
				T187	0.000	0.000	0.000				
				T188	0.000	0.000	0.000				
				T189	0.000	0.000	0.000				
				T190	0.000	0.000	0.000				
				T191	0.000	0.000	0.000				
				T192	0.000	0.000	0.000				
				T193	0.000	0.000	0.000				
				T194	0.000	0.000	0.000				
				T195	0.000	0.000	0.000				
				T196	0.000	0.000	0.000				
				T197	0.000	0.000	0.000				
				T198	0.000	0.000	0.000				
				T199	0.000	0.000	0.000				
				T200	0.000	0.000	0.000				
				T201	0.000	0.000	0.000				
				T202	0.000	0.000	0.000				
				T203	0.000	0.000	0.000				
				T204	0.000	0.000	0.000				
				T205	0.000	0.000	0.000				
				T206	0.000	0.000	0.000				
				T207	0.000	0.000	0.000				
				T208	0.000	0.000	0.000				
				T209	0.000	0.000	0.000				
				T210	0.000	0.000	0.000				
				T211	0.000	0.000	0.000				
				T212	0.000	0.000	0.000				
				T213	0.000	0.000	0.000				
				T214	0.000	0.000	0.000				
				T215	0.000	0.000	0.000				
				T216	0.000	0.000	0.000				
				T217	0.000	0.000	0.000				
				T218	0.000	0.000	0.000				
				T219	0.000	0.000	0.000				
				T220	0.000	0.000	0.000				
				T221	0.000	0.000	0.000				
				T222	0.000	0.000	0.000				
				T223	0.000	0.000	0.000				
				T224	0.000	0.000	0.000				
				T225	0.000	0.000	0.000				
				T226	0.000	0.000	0.000				
				T227	0.000	0.000	0.000				
				T228	0.000	0.000	0.000				
				T229	0.000	0.000	0.000				
				T230	0.000	0.000	0.000				
				T231	0.000	0.000	0.000				
				T232	0.000	0.000	0.000				
				T233	0.000	0.000	0.000				
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				T235	0.000	0.000	0.000				
				T236	0.000	0.000	0.000				
				T237	0.000	0.000	0.000				
				T238	0.000	0.000	0.000				
				T239	0.000	0.000	0.000				
				T240	0.000	0.000	0.000				
				T241	0.000	0.000	0.000				
				T242	0.000	0.000	0.000				
				T243	0.000	0.000	0.000				
				T244	0.000	0.000	0.000				
				T245	0.000	0.000	0.000				
				T246	0.000	0.000					

Drill
block



We recommend adjusting T25 first and then just use the values you placed there as a reference for other numbers. Based on the physical layout of the drill block:

- T25, T26, T27, T28, T29 should have the same X-axis value
- T21, T22, T23, T24, T25 should have the same Y-axis value.
- The distance between tool slots is 32mm.

CHECKLIST

I know how to:

- ☐ Keep a safe working environment
- ☐ Contact customer support
- ☐ Use the emergency stop
- ☐ Perform router maintenance
- ☐ Use the controller
- ☐ Use the MPG remote
- ☐ Turn on the router
- ☐ Turn off the router
- ☐ Import files to my controller desktop
- ☐ Access the Sidewinder program
- ☐ Access the Operation and Utilities pages
- ☐ Switch between Auto & Jog modes
- ☐ Jog my machine
- ☐ Tell which operations work on Auto and on Jog
- ☐ Pause an automatic operation and use the MPG remote for simulation
- ☐ Select my material size
- ☐ Set my material thickness
- ☐ Load and unload my material **[for upgraded models]**
- ☐ Increase or decrease my machine speed
- ☐ Turn my drill block on/off **[for upgraded models]**
- ☐ Resurface my spoilboard
- ☐ Clean my table
- ☐ Measure my tools automatically
- ☐ Control vacuum zones
- ☐ Check my alarm history
- ☐ Back up my files
- ☐ Activate function keys
- ☐ Execute a single file
- ☐ Execute multiple files with the working list **[for upgraded models]**
- ☐ Measure larger tools

If you ticked off all the boxes, congratulations!
You are now ready to use the **5th generation Sidewinder XPR**.

