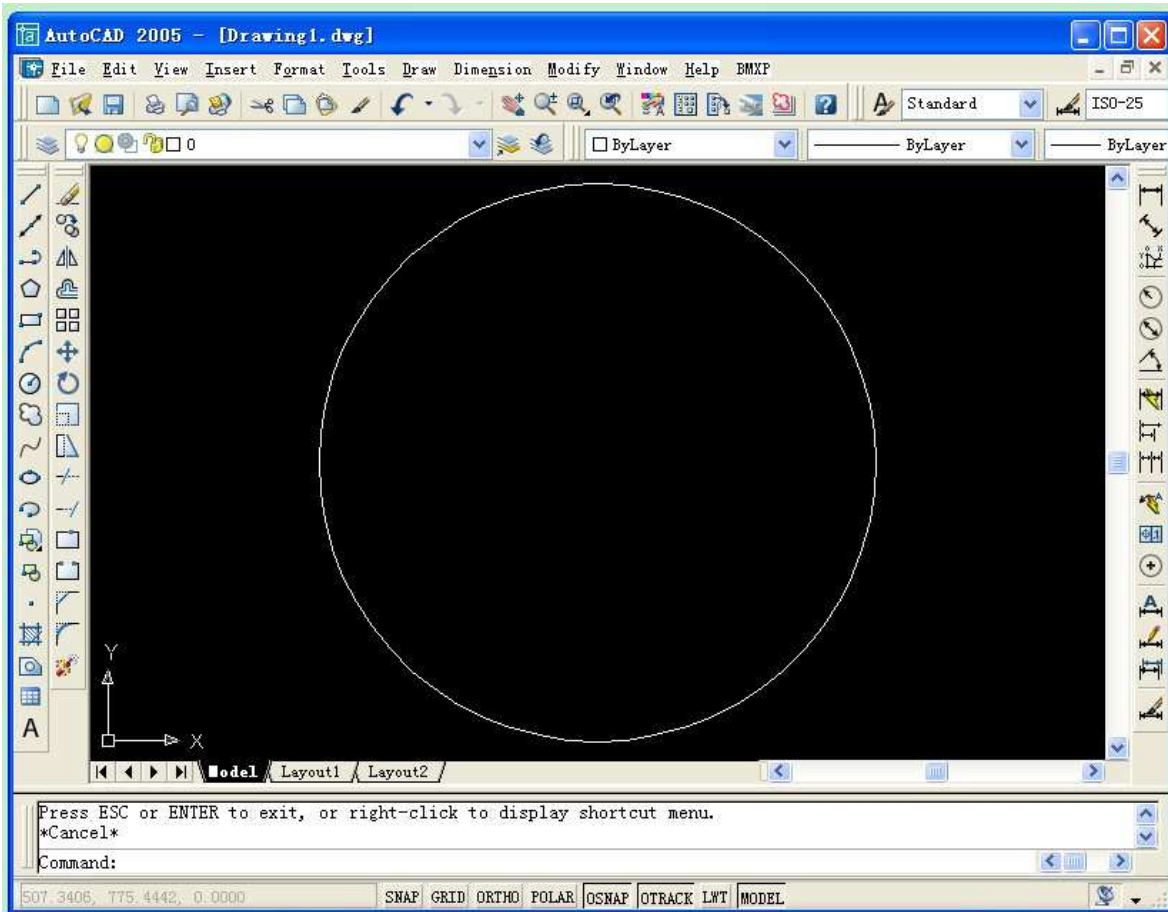
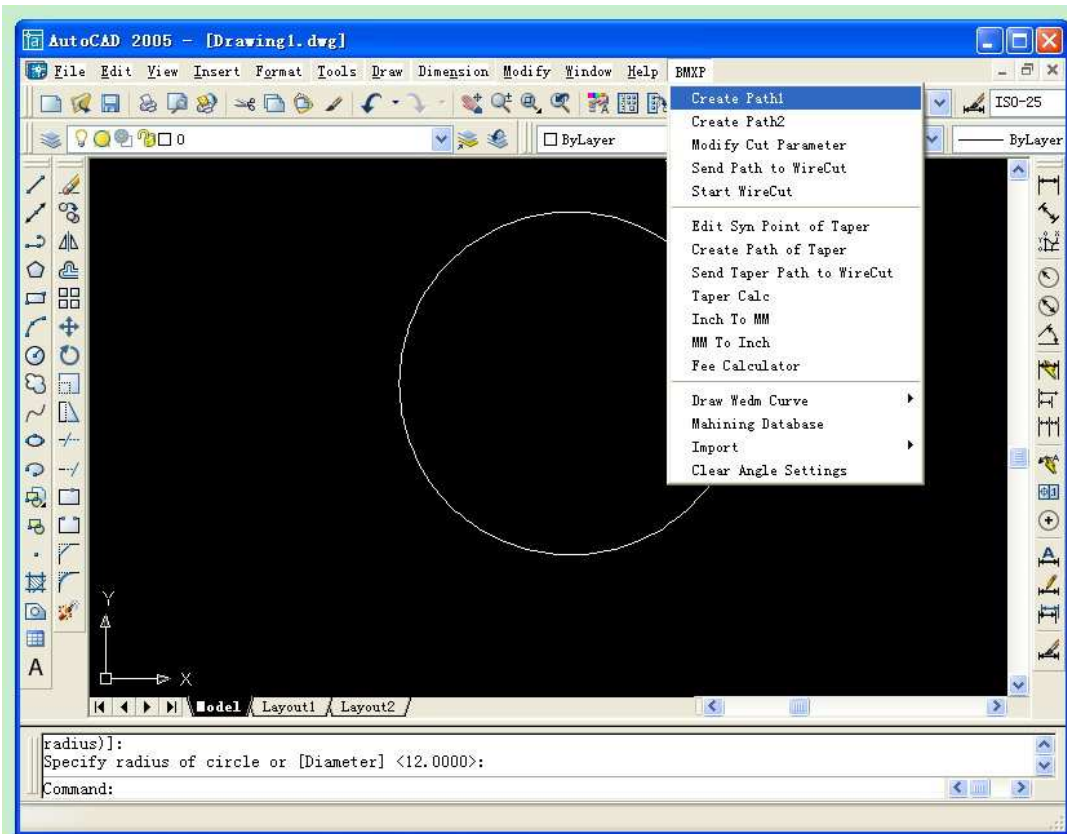


1. Program a drawing, we take a circle for example



2. After drawing, please choose “BMXP” →
- Create Path1 ( use for one time cutting )
  - Create Path2 ( use for multi-pass cutting )
  - Create Path Taper( Use for taper cutting )



3. Input all the parameters for the drawing and click “OK” to next step

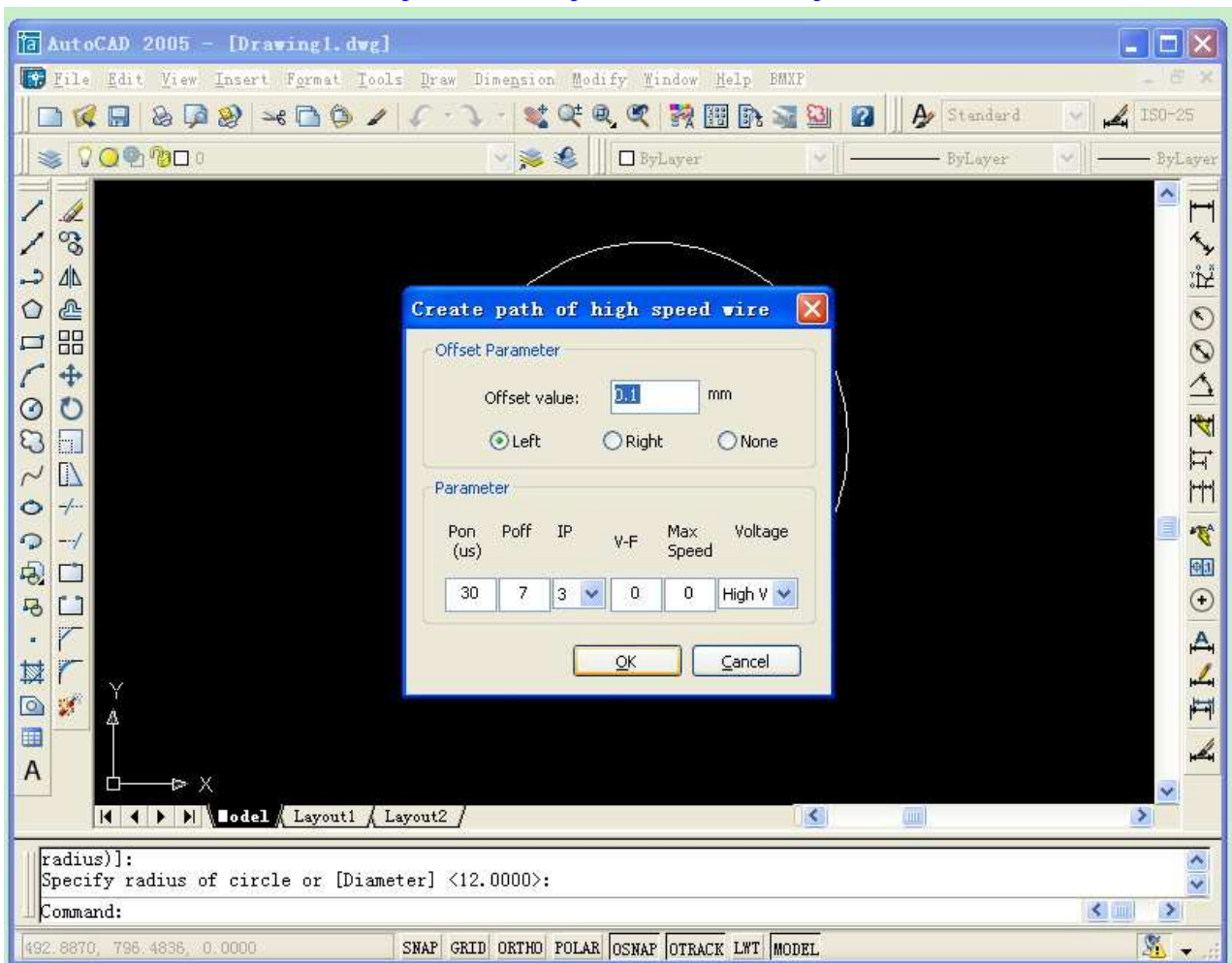
Pon, means the pulse on time, the bigger you choose the Pon, the cutting speed will be higher, but the surface finishing will be worse and the wire easy to be broken.

Poff, means the pulse off time, the bigger you choose the Poff, the cutting speed will be lower, but the surface finishing will be better. And the chips will be easy to remove.

IP, means the Power you choose, the higher you choose, the cutting speed will be faster, but easy to broken the wire and the surface finishing will be worse

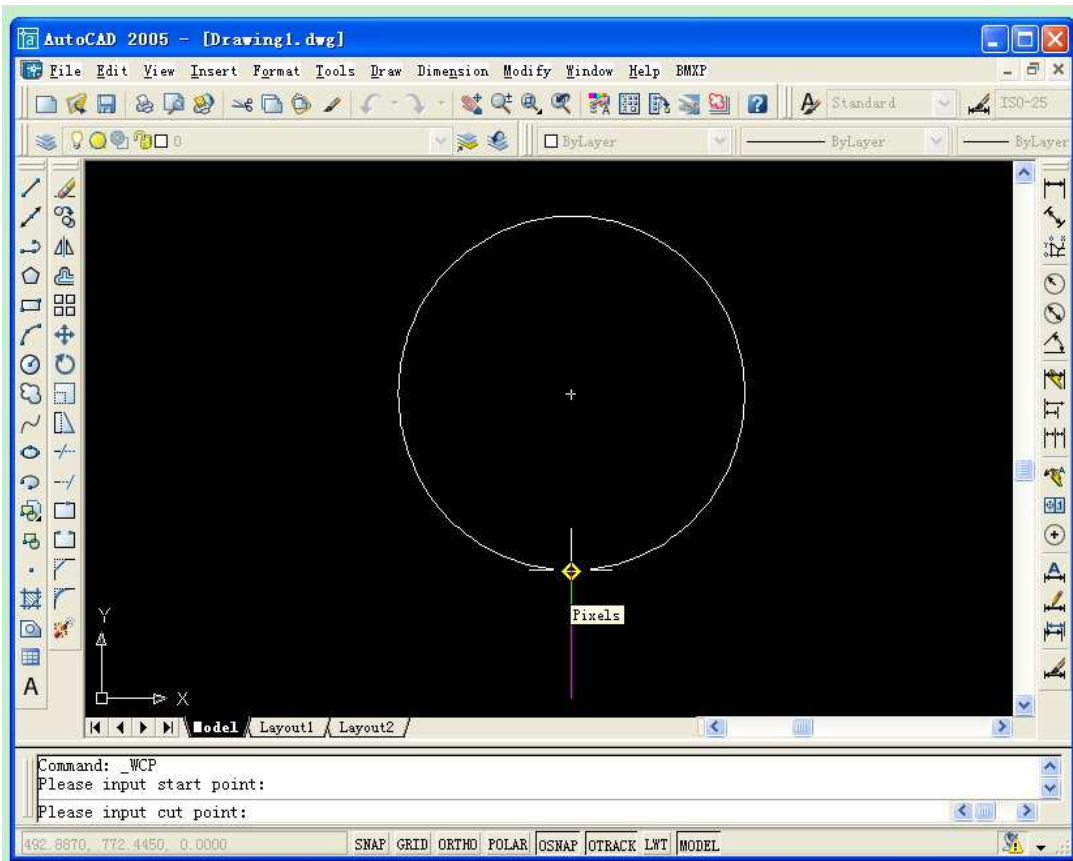
Max speed, means the wire winding drum running speed. During putting the wire to the drum , you should choose the lowest speed level “3”. For normal cutting, we always use level “0” the highest speed.

offset, here we choose Left for example.( we will explain this in follow step)

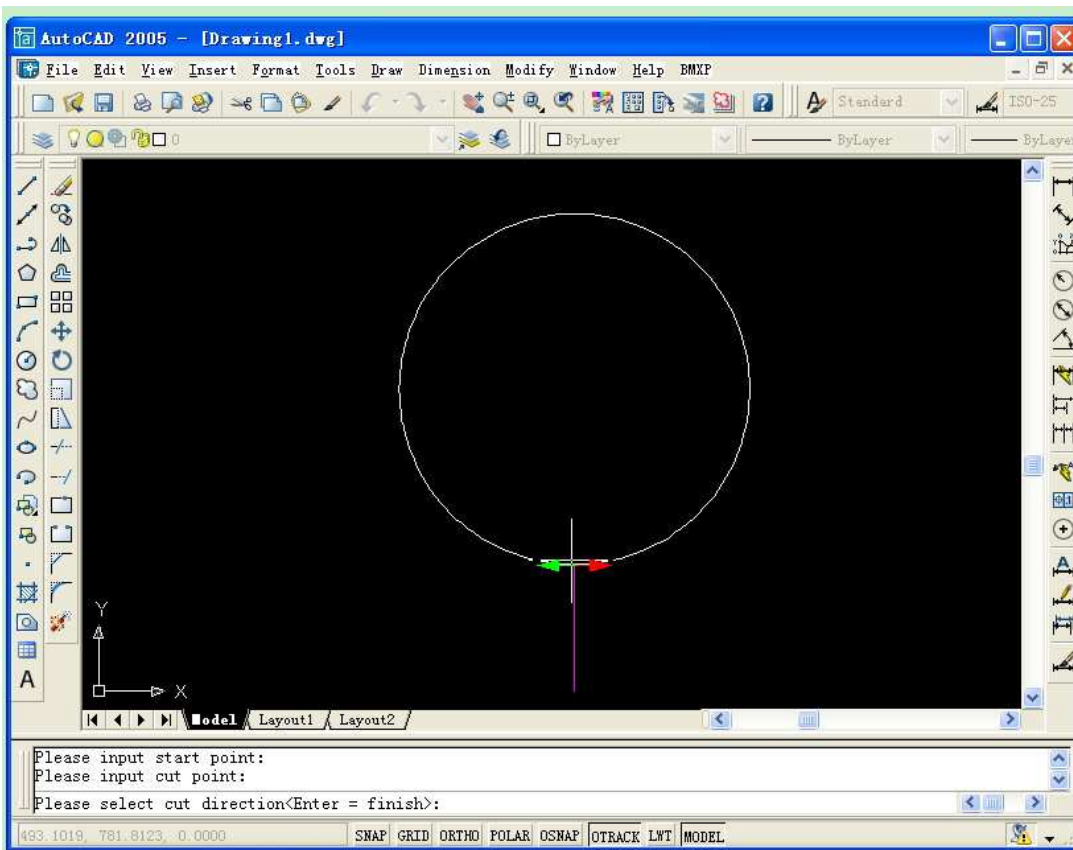


4.This step is for adding the lead-in-out line. You can choose one point out of the drawing as the start point of the line, and choose one point on the drawing as the end point of the line.

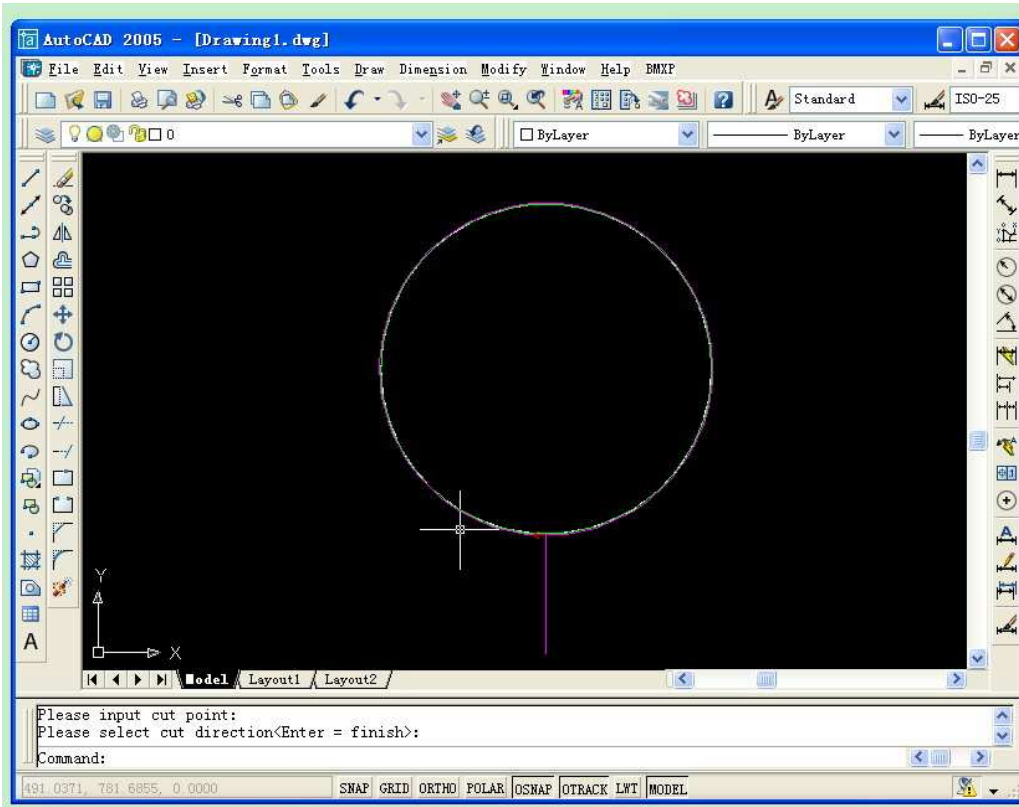
(please attention, the first point should out of the drawing, the second one should on the drawing)



5. Choose the cutting direction. We choose offset "left" in the 3 step. Now is we choose the "red" direction, it will cut along inside of the circle, the hole surface will finishing. (we get female mould)  
 If we choose the green direction, it will cut along outside of the circle, the small circle column will get better finishing. ( we will get male mould)



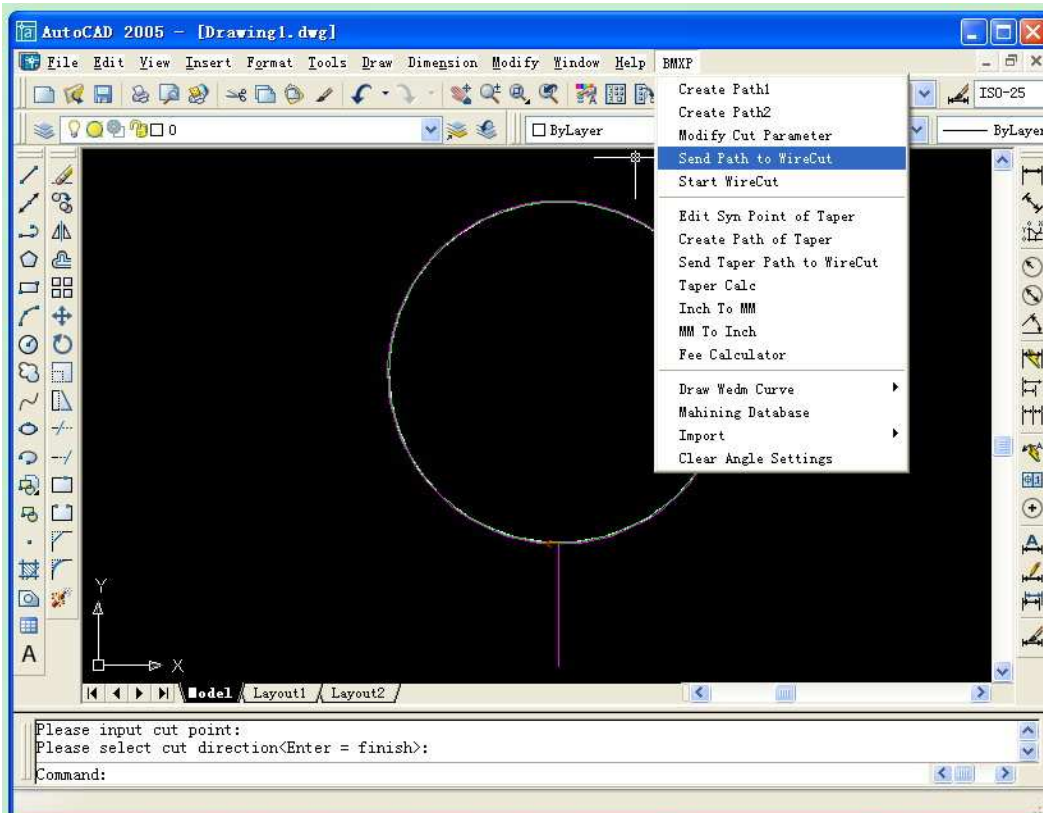
6. You can choose direction by clicking the red or green “arrow”



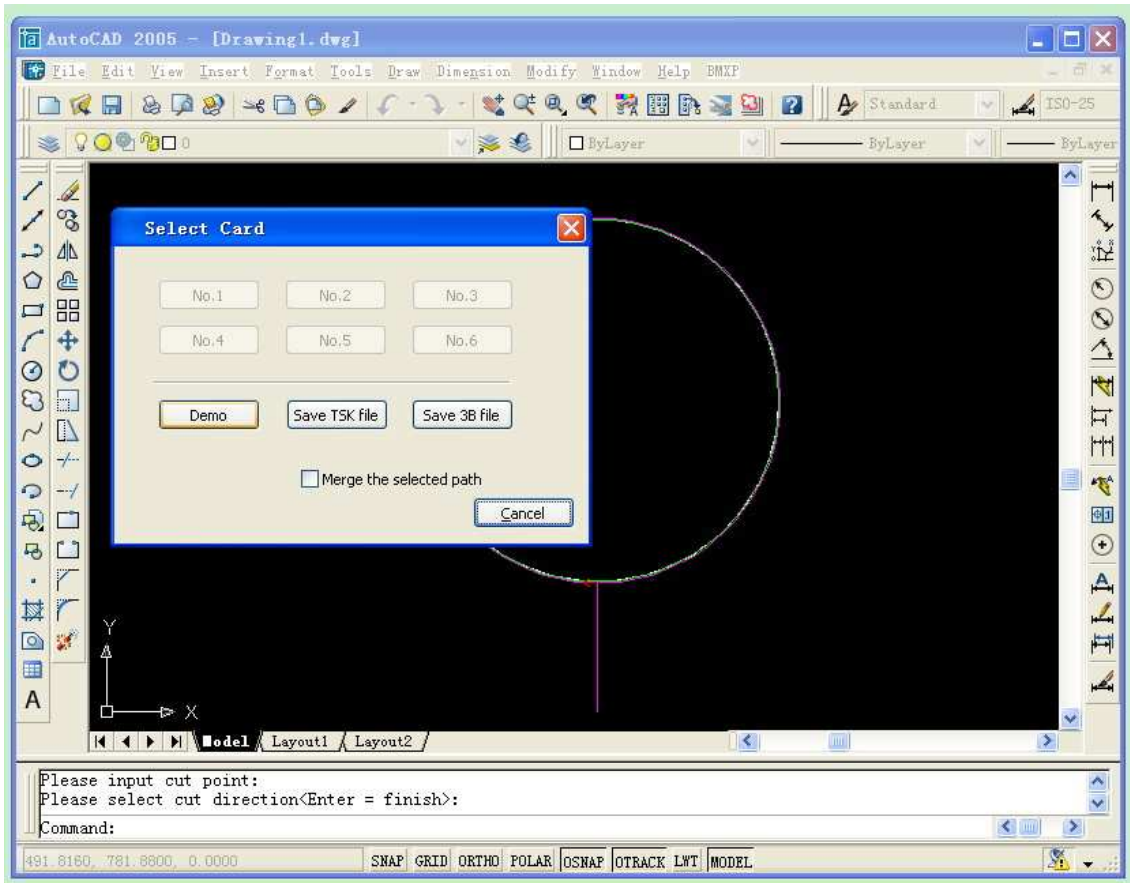
7. If you choose 1,2 in step 2, here you should choose “send path to Wirecut”

If you choose 3. in step 2, here please choose send Taper path to Wirecut.

1. → Create Path1 ( use for one time cutting )
2. → Create Path2 ( use for multi-pass cutting )
3. → Create Path Taper( Use for taper cutting)

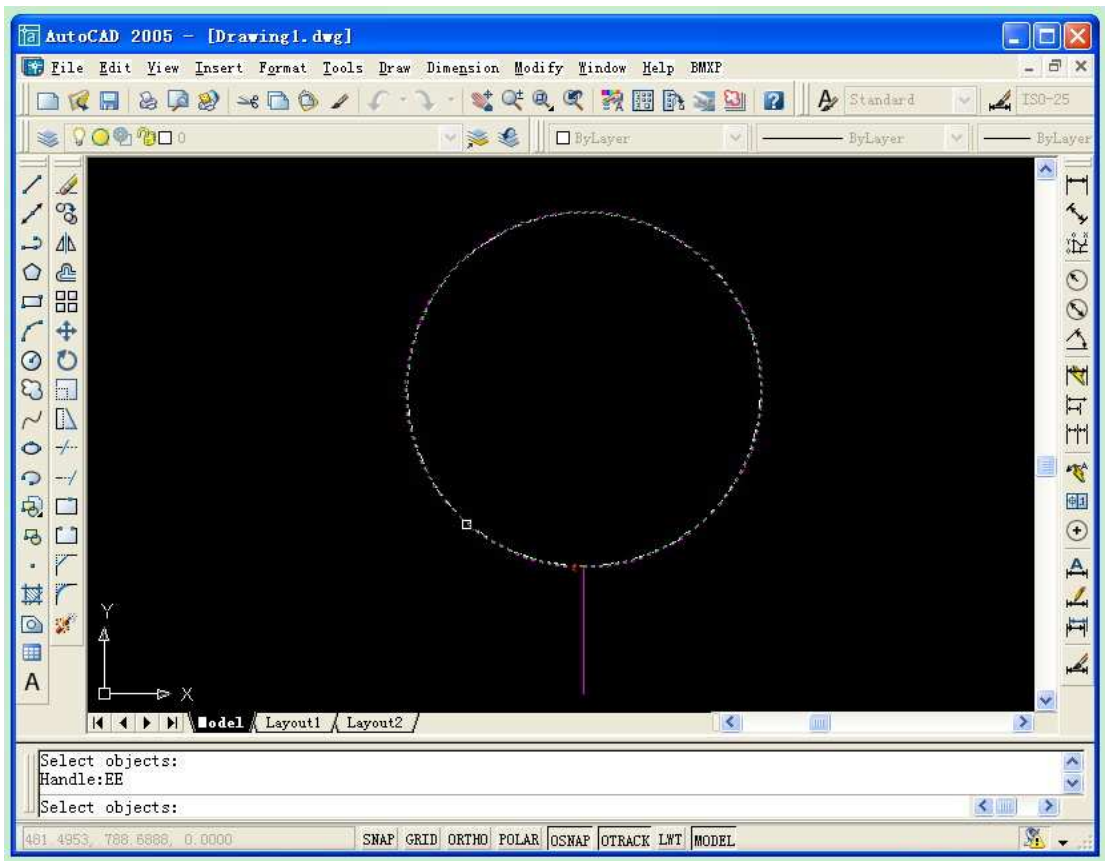


8. Please choose **NO1** card.

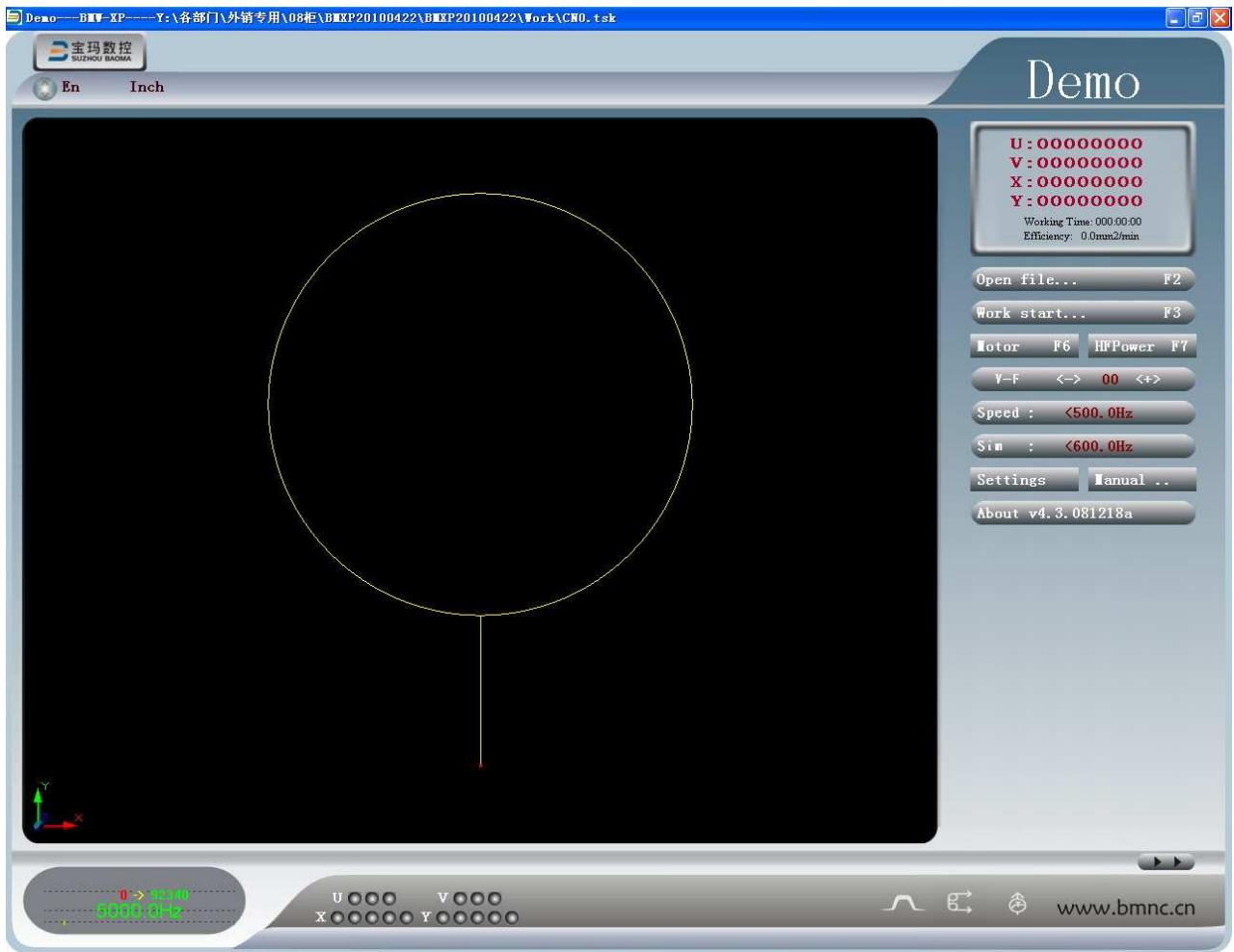


9. Now click the drawing with left button of the mouse to choose the drawing.

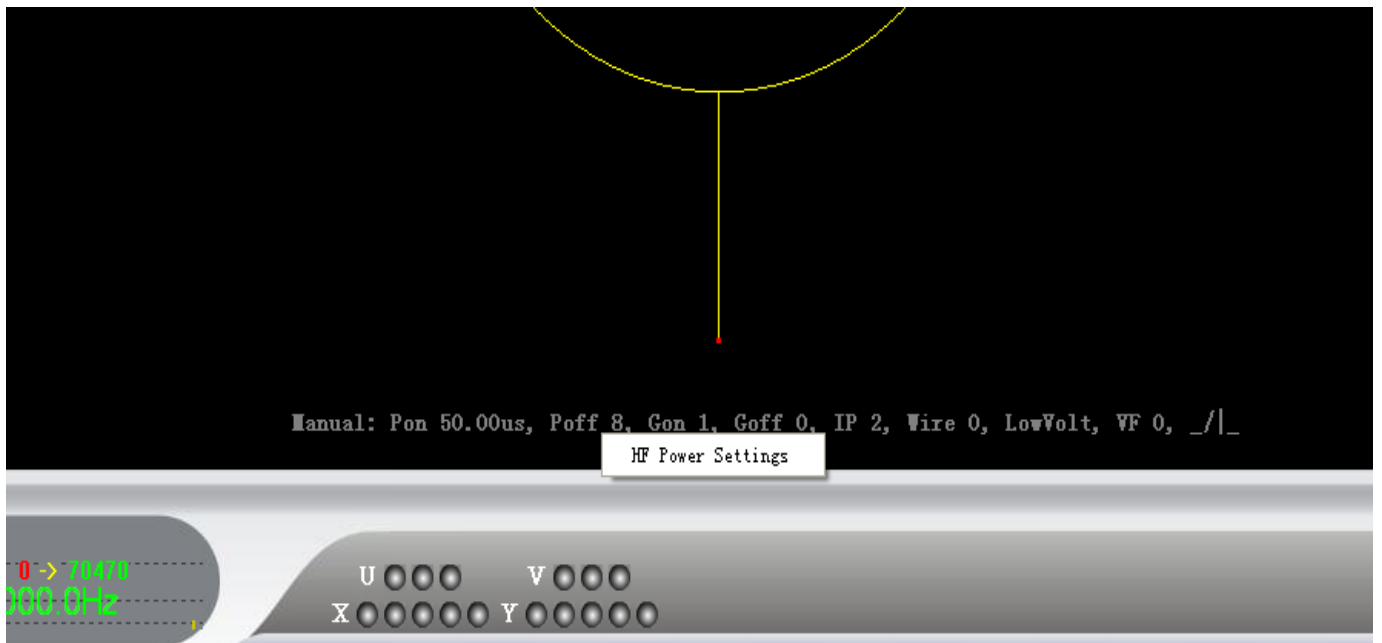
Then click one time the right button of the mouse to send the drawing



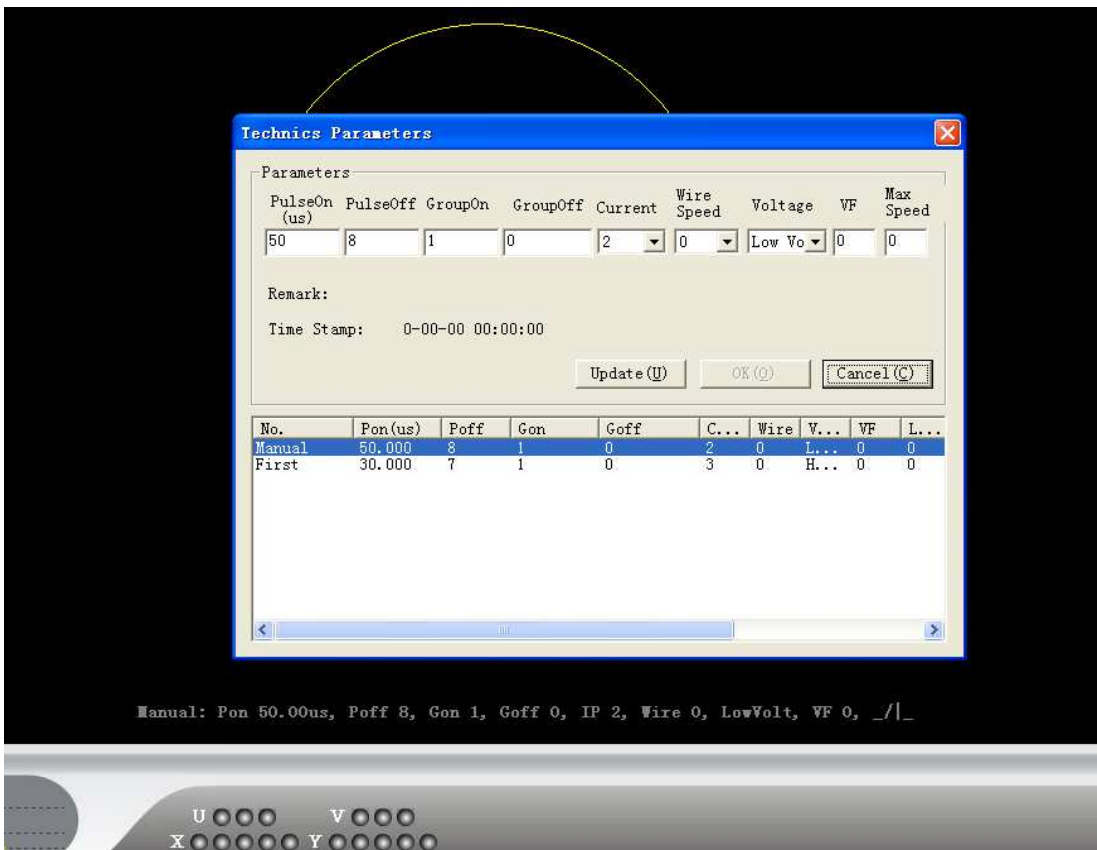
10. You will see the drawing has been send to the processing interface.



11. Setting the parameters. Please –right-click the mouse. And choose the HF power setting.



12. You will see follow Picture. Please change GroupOn is "1", GroupOff is "0", Current you can choose 1-6. The higher you choose, the cutting speed will be higher, but the wire easier to broken.



U ○○○ V ○○○  
X ○○○○ Y ○○○○