

## Setting up Precision Matthews Lathe DRO (supplement to manual):

Before doing anything below, be sure that you have the Cross Slide scale plugged in to the TOP port of the reader head, and the long Bed Scale should be plugged in to the BOTTOM port. This is how this DRO is designed to work, follow this if you want it to work properly.

You will need to get in to the setup parameters to do this. To enter Parameter Setup, please do the following:

1. If DRO is on, switch to off before proceeding.
2. Turn DRO on, and press the number 6 button on the screen about 1 second after you hear the beep. You will see the display say EXIT in the top right display. Now you are in Parameter Setup.
3. Press the down arrow (the arrows in the upper right corner) until you see RESOLUTE on the display.
4. Press Enter (ENT)
5. Look at the digital displays on the left side, top and bottom display. If you have our LATHE DRO Set, the Top readout (Cross slide scale) should be set on .001, and the Bottom readout should read .005. If that is not the case, you need to change it. You change it by simply pressing the blue X button until the reading shows **.001** on top. (repeat the same on the lower display with the Z0/Y Button so that **.005** is displayed)
6. After you complete the above, press Enter (ENT)
7. Now, use the down arrow (Top right corner) press until you see EXIT. Once EXIT is displayed, you will press Enter (ENT), this will exit the Parameter Setup, you can now use the DRO.

You may also change more settings while in the parameter setup mode, Scale Direction, Radius or Diameter reading for the cross slide, and others.

**Radius** setting means, for example, that if you dial in the cross slide .100" on the display, (if you had an indicator on the cross slide it would show that it actually moved .100"), the readout will display .100", but you will actually take .200" off of the diameter of your work piece, so it is .100" Per Side.

**Diameter** setting means, for example, that if you dial in the cross slide .100" on the display, (if you had an indicator on the cross slide, it would have actually moved .050") you will actually remove .100" from the workpiece.