

## Acramatic Manual

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### Acramatic Manual

The purpose of this manual is to provide the necessary information to enable suitably experienced personnel, to operate the CINCINNATI MACHINE ARROW E/DART (ERM) and ARROW (ERD/ERM) Vertical Machining Centers, when fitted with ACRAMATIC A2100 control. Information contained in this manual is not warranted and is subject to change without notice.

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DNC / file transfer settings for Cincinnati Acramatic 850. Set the following parameters on the machine: Parameter. Value. Baud rate: 9600: Parity: None: Data bits: 8: Stop Bits: 1: Some of the above settings seem to conflict with those in ConnectCNC; but the control counts the even parity bit as a data bit. Set ConnectCNC as follows:

### ConnectCNC settings for Cincinnati Acramatic 950

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using the buttons on the right hand side of screen, in manual mode there should be an option to "jog drum to spindle" and vice versa, also option buttons for rotating the drum back and forth! if memory serves me right you have to get the "jog drum to spindle" highlighted on the screen then press the "mechanisim jog" button above the cycle button to move the atc.

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