

```
# Generated by PNCconf at Tue Dec 27 13:45:21 2011
# If you make changes to this file, they will be
# overwritten when you run PNCconf again
```

[EMC]

```
MACHINE = cinlathe
DEBUG = 0
```

[DISPLAY]

```
DISPLAY = axis
POSITION_OFFSET = RELATIVE
POSITION_FEEDBACK = ACTUAL
MAX_FEED_OVERRIDE = 2.000000
MAX_SPINDLE_OVERRIDE = 1.500000
MIN_SPINDLE_OVERRIDE = 0.500000
INTRO_GRAPHIC = emc2.gif
INTRO_TIME = 5
PROGRAM_PREFIX = /home/srt/emc2/nc_files
PYVCP = pyvcp-panel.xml
INCREMENTS = .1in .05in .01in .005in .001in .0005in .0001in
LATHE = 1
POSITION_OFFSET = RELATIVE
POSITION_FEEDBACK = ACTUAL
DEFAULT_LINEAR_VELOCITY = 0.250000
MAX_LINEAR_VELOCITY = 1.000000
MIN_LINEAR_VELOCITY = 0.010000
DEFAULT_ANGULAR_VELOCITY = 0.250000
MAX_ANGULAR_VELOCITY = 1.000000
MIN_ANGULAR_VELOCITY = 0.010000
EDITOR = gedit
GEOMETRY = xyz
```

[FILTER]

```
PROGRAM_EXTENSION = .png,.gif,.jpg Greyscale Depth Image
PROGRAM_EXTENSION = .py Python Script
png = image-to-gcode
gif = image-to-gcode
jpg = image-to-gcode
py = python
txt = text
```

[TASK]

```
TASK = milltask
CYCLE_TIME = 0.010
```

[RS274NGC]

```
PARAMETER_FILE = emc.var
```

[EMCMOT]

```
EMCMOT = motmod
COMM_TIMEOUT = 1.0
COMM_WAIT = 0.010
SERVO_PERIOD = 1000000
```

[HOSTMOT2]

```
# **** This is for info only ****
# DRIVER0=hm2_pci
# BOARD0=5i23
```

[HAL]

```
HALUI = halui
HALFILE = cinlathe.hal
HALFILE = custom.hal
POSTGUI_HALFILE = postgui_call_list.hal
SHUTDOWN = shutdown.hal
```

[HALUI]

```
[TRAJ]
AXES = 3
COORDINATES = X Z
LINEAR_UNITS = inch
ANGULAR_UNITS = degree
CYCLE_TIME = 0.010
DEFAULT_VELOCITY = 0.17
MAX_LINEAR_VELOCITY = 1.67

[EMCIO]
EMCIO = io
CYCLE_TIME = 0.100
TOOL_TABLE = tool.tbl
TOOLCHANGE_WITH_SPINDLE_ON = 1
```

```
*****
# Axis X
*****
```

```
[AXIS_0]
TYPE = LINEAR
HOME = 5.25
FERROR = 0.005
MIN_FERROR = 0.0005
MAX_VELOCITY = 300
MAX_ACCELERATION = 5
P = 1.0
I = 0.0
D = 0.0
FF0 = 0.0
FF1 = 0.0
FF2 = 0.0
BIAS = 0.0
DEADBAND = 0.0
RESOLVER_SCALE = .2
OUTPUT_SCALE = 10.0
MAX_OUTPUT = 10.0
MIN_LIMIT = -8.5
MAX_LIMIT = 5.251
HOME_OFFSET = 5.25
```

```
*****
# Axis Z
*****
```

```
[AXIS_2]
TYPE = LINEAR
HOME = 22.0
FERROR = 0.005
MIN_FERROR = 0.0005
MAX_VELOCITY = 300
MAX_ACCELERATION = 5
P = 1.0
I = 0.0
D = 0.0
FF0 = 0.0
FF1 = 0.0
FF2 = 0.0
BIAS = 0.0
DEADBAND = 0.0
RESOLVER_SCALE = .2
OUTPUT_SCALE = 10.0
MAX_OUTPUT = 10.0
MIN_LIMIT = -6.5
MAX_LIMIT = 22.001
HOME_OFFSET = 22.0
```

```
*****
# Spindle
```

[SPINDLE_9]

MAX_VELOCITY = 3000

MAX_ACCELERATION = 50

RESOLVER_SCALE = 1

OUTPUT_SCALE = 10.0

MAX_OUTPUT = 10.0