

```
# Erstellt von PNCconf am Mon Aug 26 07:49:46 2024
# Using LinuxCNC version: 2.8
# Änderungen an dieser Datei werden beim nächsten
# overwritten when you run PNCconf again
```

```
[EMC]
```

```
MACHINE = Mesaswiss
DEBUG = 0
VERSION = 1.1
```

```
[DISPLAY]
```

```
DISPLAY = gmoccapy
POSITION_OFFSET = RELATIVE
POSITION_FEEDBACK = ACTUAL
MAX_FEED_OVERRIDE = 2.000000
MAX_SPINDLE_OVERRIDE = 1.000000
MIN_SPINDLE_OVERRIDE = 0.500000
INTRO_GRAPHIC = linuxcnc.gif
INTRO_TIME = 5
PROGRAM_PREFIX = /home/rexomat/linuxcnc/nc_files
INCREMENTS = 5mm 1mm .5mm .1mm .05mm .01mm .005mm
POSITION_FEEDBACK = ACTUAL
DEFAULT_LINEAR_VELOCITY = 6.000000
MAX_LINEAR_VELOCITY = 25.000000
MIN_LINEAR_VELOCITY = 0.500000
DEFAULT_ANGULAR_VELOCITY = 12.000000
MAX_ANGULAR_VELOCITY = 180.000000
MIN_ANGULAR_VELOCITY = 1.666667
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
```

```
[TASK]
```

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

```
[RS274NGC]
```

```
PARAMETER_FILE = linuxcnc.var
RS274NGC_STARTUP_CODE = G21 G40 G90 G94 G97 G64 P0.025
```

```
[EMCMOT]
```

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

```
[HMOT]
```

```
# **** This is for info only ****
CARD0=hm2_7i96s.0
```

```
[HAL]
```

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

```
[HALUI]
```

```
[KINS]
JOINTS = 3
KINEMATICS = trivkins coordinates=XYZ
```

```
[TRAJ]
COORDINATES = XYZ
LINEAR_UNITS = mm
ANGULAR_UNITS = degree
DEFAULT_LINEAR_VELOCITY = 3.67
MAX_LINEAR_VELOCITY = 36.67
NO_FORCE_HOMING = 1
```

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

```
*****
```

```
[AXIS_X]
MAX_VELOCITY = 36.6666666667
MAX_ACCELERATION = 600.0
MIN_LIMIT = -0.01
MAX_LIMIT = 530.0
```

```
[JOINT_0]
TYPE = LINEAR
HOME = 0.0
FERROR = 10.0
MIN_FERROR = 1.0
MAX_VELOCITY = 36.6666666667
MAX_ACCELERATION = 600.0
# The values below should be 25% larger than MAX_VELOCITY and MAX_ACCELERATION
# If using BACKLASH compensation STEPGEN_MAXACCEL should be 100% larger.
STEPGEN_MAXVEL = 45.83
STEPGEN_MAXACCEL = 750.00
P = 1000.0
I = 0.0
D = 0.0
FF0 = 0.0
FF1 = 1.0
FF2 = 0.0
BIAS = 0.0
DEADBAND = 0.0
MAX_OUTPUT = 0.0
# these are in nanoseconds
DIRSETUP = 10000
DIRHOLD = 10000
STEPLEN = 5000
STEPSPACE = 5000
STEP_SCALE = -160.0
MIN_LIMIT = -0.01
MAX_LIMIT = 530.0
HOME_OFFSET = 0.000000
HOME_SEARCH_VEL = 33.316667
HOME_LATCH_VEL = -2.500000
HOME_FINAL_VEL = 0.000000
HOME_USE_INDEX = NO
HOME_SEQUENCE = 1
```

```
*****
```

```
*****
```

```
[AXIS_Y]
```

MAX_VELOCITY = 36.6666666667
MAX_ACCELERATION = 600.0
MIN_LIMIT = -0.01
MAX_LIMIT = 300.0

[JOINT_1]

TYPE = LINEAR
HOME = 0.0
FERROR = 10.0
MIN_FERROR = 1.0
MAX_VELOCITY = 36.6666666667
MAX_ACCELERATION = 600.0
The values below should be 25% larger than MAX_VELOCITY and MAX_ACCELERATION
If using BACKLASH compensation STEPGEN_MAXACCEL should be 100% larger.
STEPGEN_MAXVEL = 45.83
STEPGEN_MAXACCEL = 750.00
P = 1000.0
I = 0.0
D = 0.0
FF0 = 0.0
FF1 = 1.0
FF2 = 0.0
BIAS = 0.0
DEADBAND = 0.0
MAX_OUTPUT = 0.0
these are in nanoseconds
DIRSETUP = 10000
DIRHOLD = 10000
STEPLEN = 5000
STEPSPACE = 5000
STEP_SCALE = 160.0
MIN_LIMIT = -0.01
MAX_LIMIT = 300.0
HOME_OFFSET = 0.000000
HOME_SEARCH_VEL = 33.316667
HOME_LATCH_VEL = -2.500000
HOME_FINAL_VEL = 0.000000
HOME_USE_INDEX = NO
HOME_SEQUENCE = 2
#*****

#*****

[AXIS_Z]

MAX_VELOCITY = 36.6666666667
MAX_ACCELERATION = 600.0
MIN_LIMIT = -285.0
MAX_LIMIT = 0.01

[JOINT_2]

TYPE = LINEAR
HOME = 0.0
FERROR = 10.0
MIN_FERROR = 1.0
MAX_VELOCITY = 36.6666666667
MAX_ACCELERATION = 600.0
The values below should be 25% larger than MAX_VELOCITY and MAX_ACCELERATION
If using BACKLASH compensation STEPGEN_MAXACCEL should be 100% larger.
STEPGEN_MAXVEL = 45.83
STEPGEN_MAXACCEL = 750.00
P = 1000.0
I = 0.0
D = 0.0
FF0 = 0.0
FF1 = 1.0

```
FF2 = 0.0
BIAS = 0.0
DEADBAND = 0.0
MAX_OUTPUT = 0.0
# these are in nanoseconds
DIRSETUP = 10000
DIRHOLD = 10000
STEPLEN = 5000
STEPSPACE = 5000
STEP_SCALE = 160.0
MIN_LIMIT = -285.0
MAX_LIMIT = 0.01
HOME_OFFSET = 0.000000
HOME_SEARCH_VEL = 33.316667
HOME_LATCH_VEL = 2.500000
HOME_FINAL_VEL = 0.000000
HOME_USE_INDEX = NO
HOME_SEQUENCE = 0
#*****
```

```
[SPINDLE_0]
```

```
P = 0.0
I = 0.0
D = 0.0
FF0 = 1.0
FF1 = 0.0
FF2 = 0.0
BIAS = 0.0
DEADBAND = 0.0
MAX_OUTPUT = 24000.0
```