

Configuration

General MotorPlanner Special IO FRO/SRO Homing order Axes Modules Spindle MPG THC PyActions

Mode
THC mode: Digital
Torch on mode: Digital

Signals
THC Up: CSMIO-IP, Input 8, Inverted
THC Down: CSMIO-IP, Input 9, Inverted
THC Torch On Digital: CSMIO-IP, Input 12, Inverted
THC Torch Voltage: Disabled, Inverted

Potentiometer settings
Potentiometer: Disabled, Inverted
Potentiometer enable: Disabled, Inverted

Parameters
Thc velocity: 2000 mm/min
Thc max deviation positive: 20 mm
Thc max deviation negative: 20 mm
Torch voltage threshold: 100 V
Thc reverse direction:

Anti Dive
To disable Anti-dive function, set Anti-dive velocity = 0
Anti-dive velocity: 30 %
Anti-dive delay: 200 ms

Torch on voltage
Torch on voltage min: 100 V
Torch on voltage max: 150 V

Movement dynamics
Thc smart analog amplification: 1 mm/s
Thc voltage deadband: 2 V

Plasma
Torch voltage division factor 1/10

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CSMIO-IP CSMIO-ENC

Motion Kits IO Signals

Probe [0]: CSMIO-IP, Input 10, Inverted
Probe [1]: Disabled, Inverted
Probe [2]: Disabled, Inverted
Probe [3]: Disabled, Inverted

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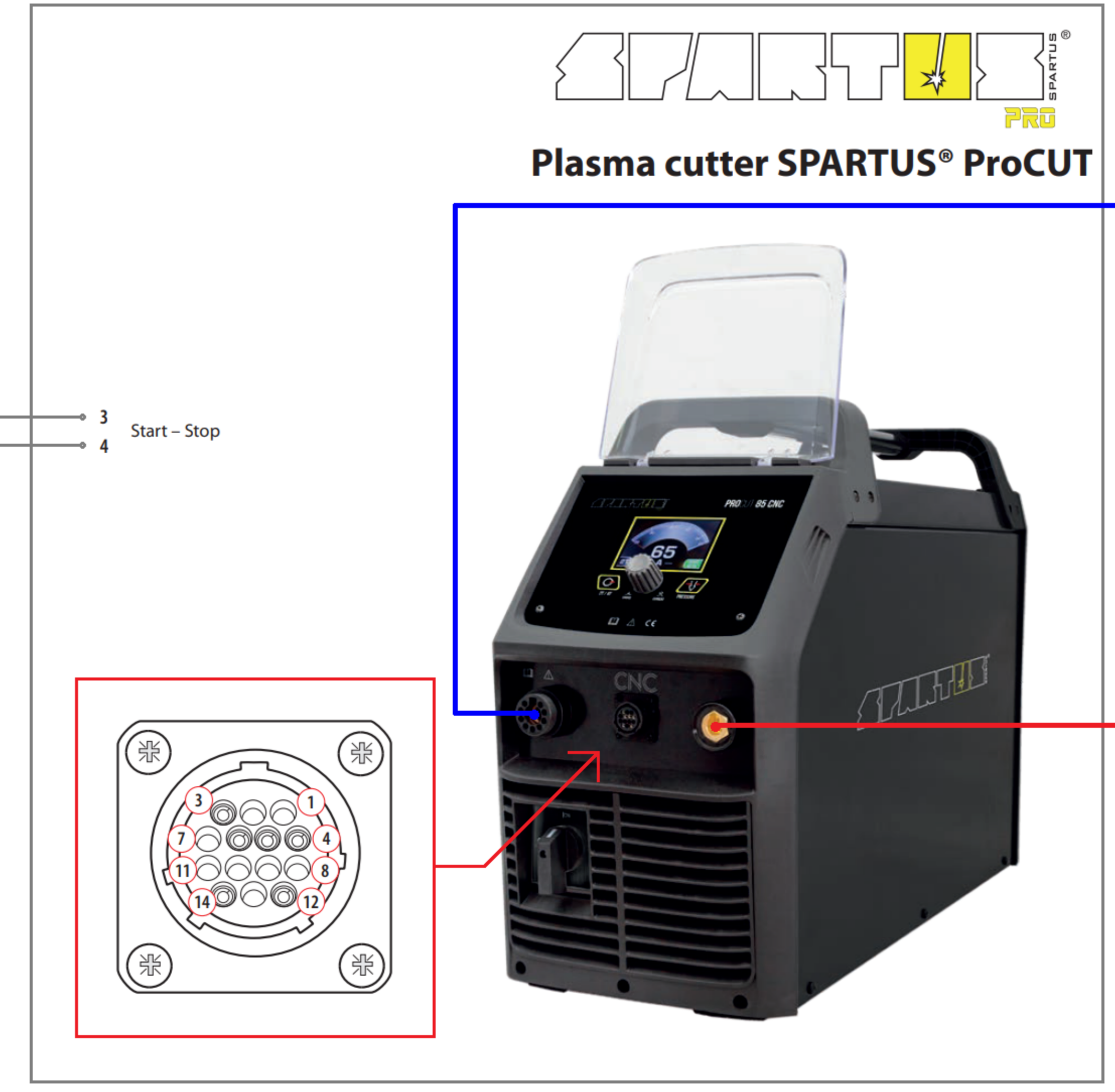
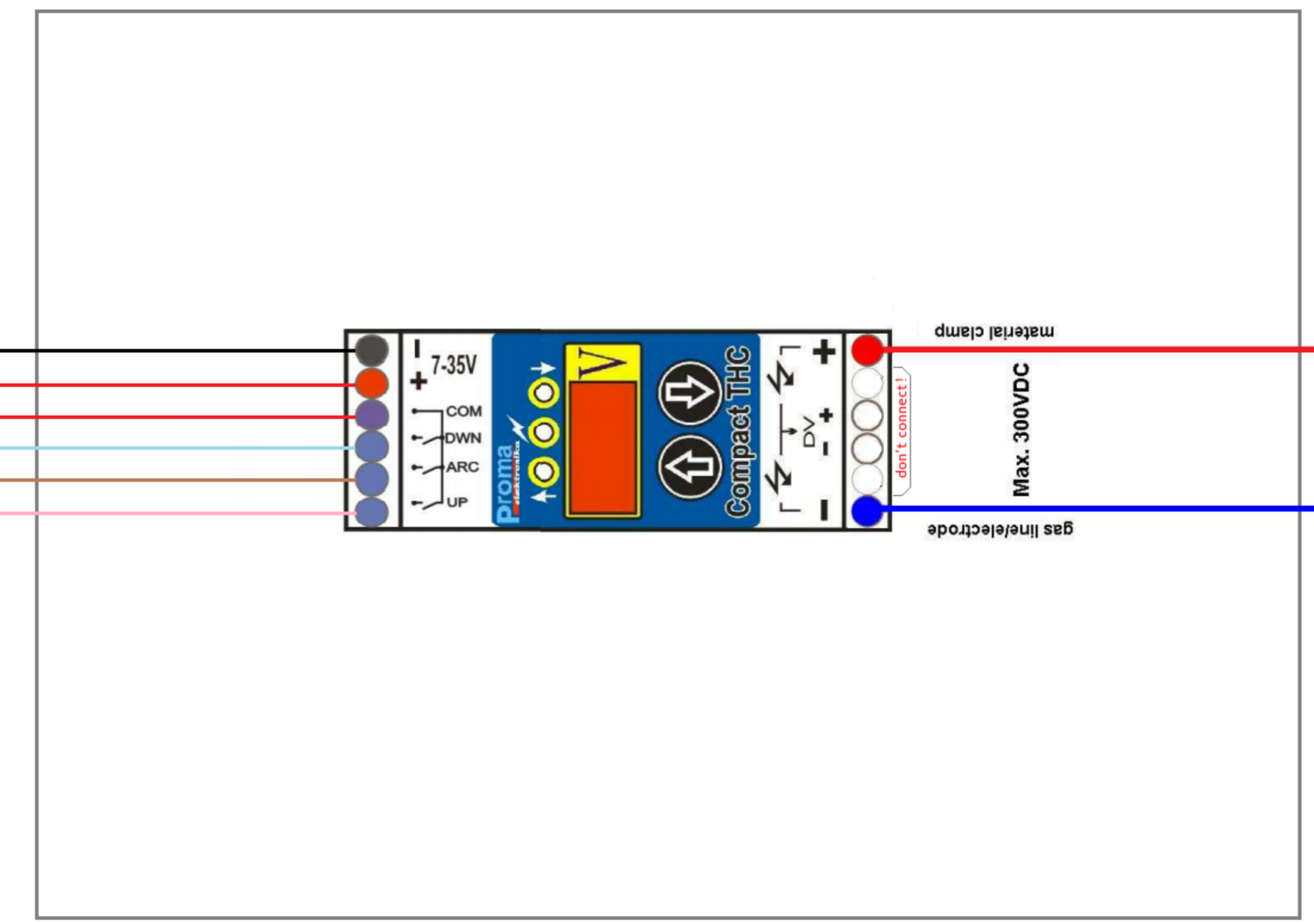
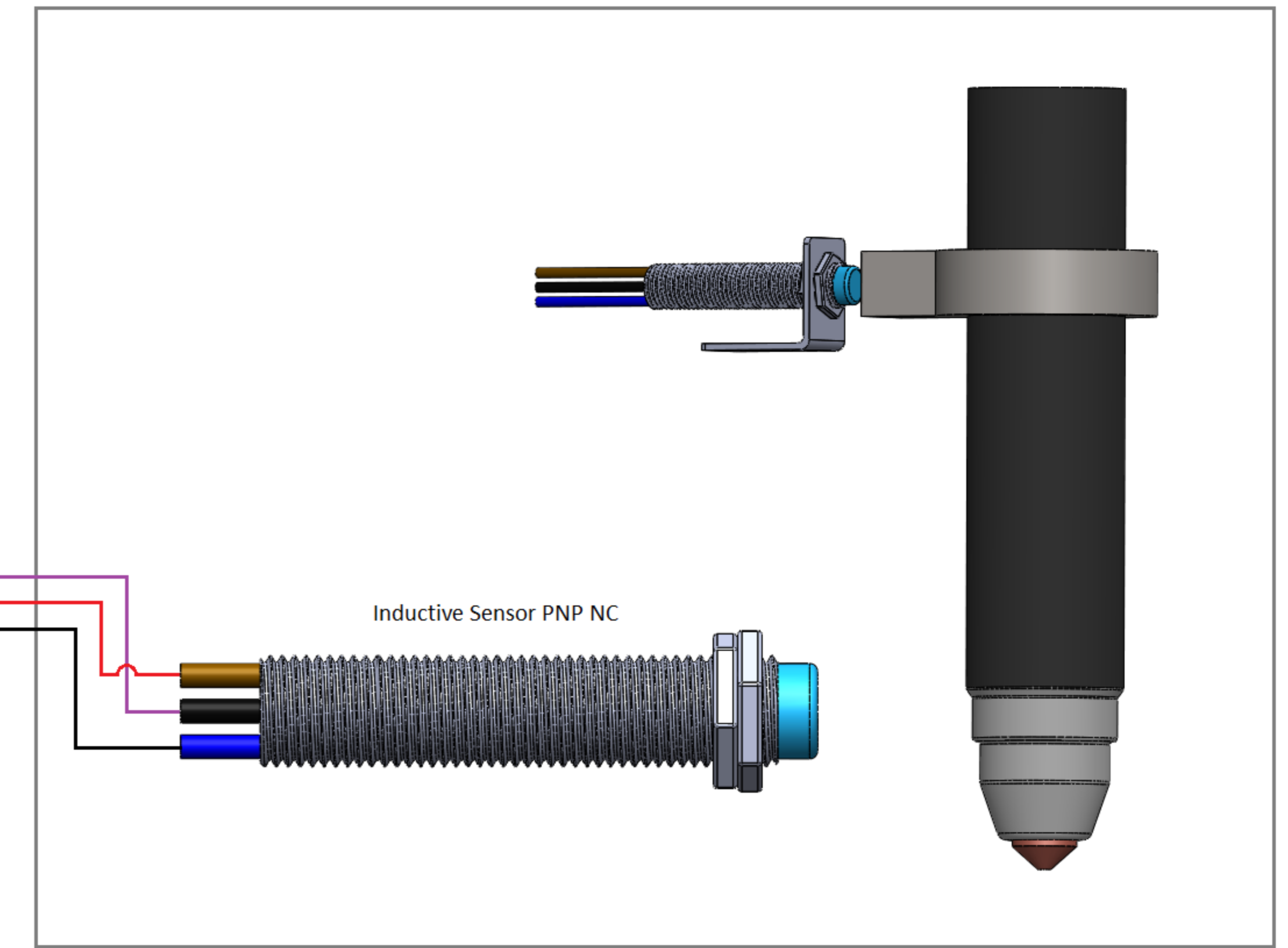
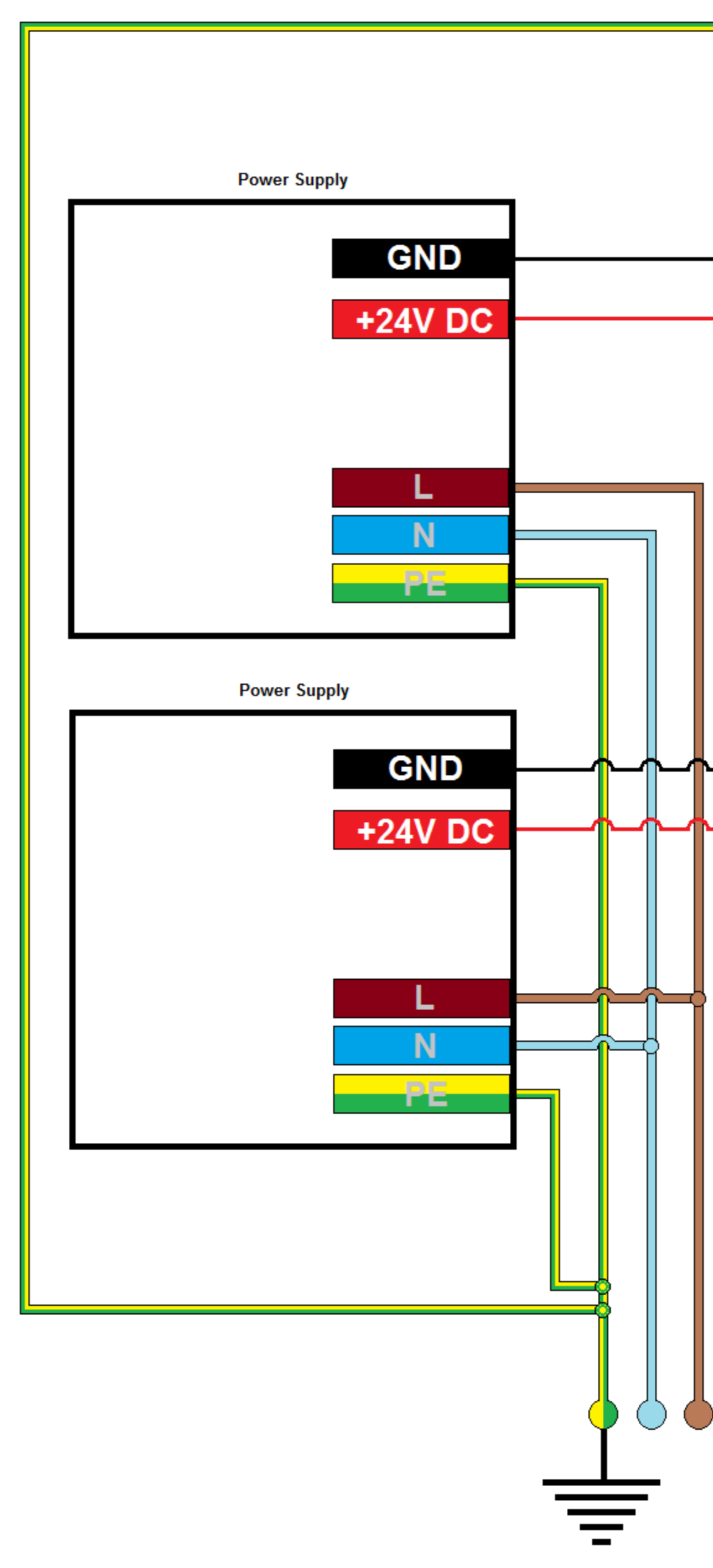
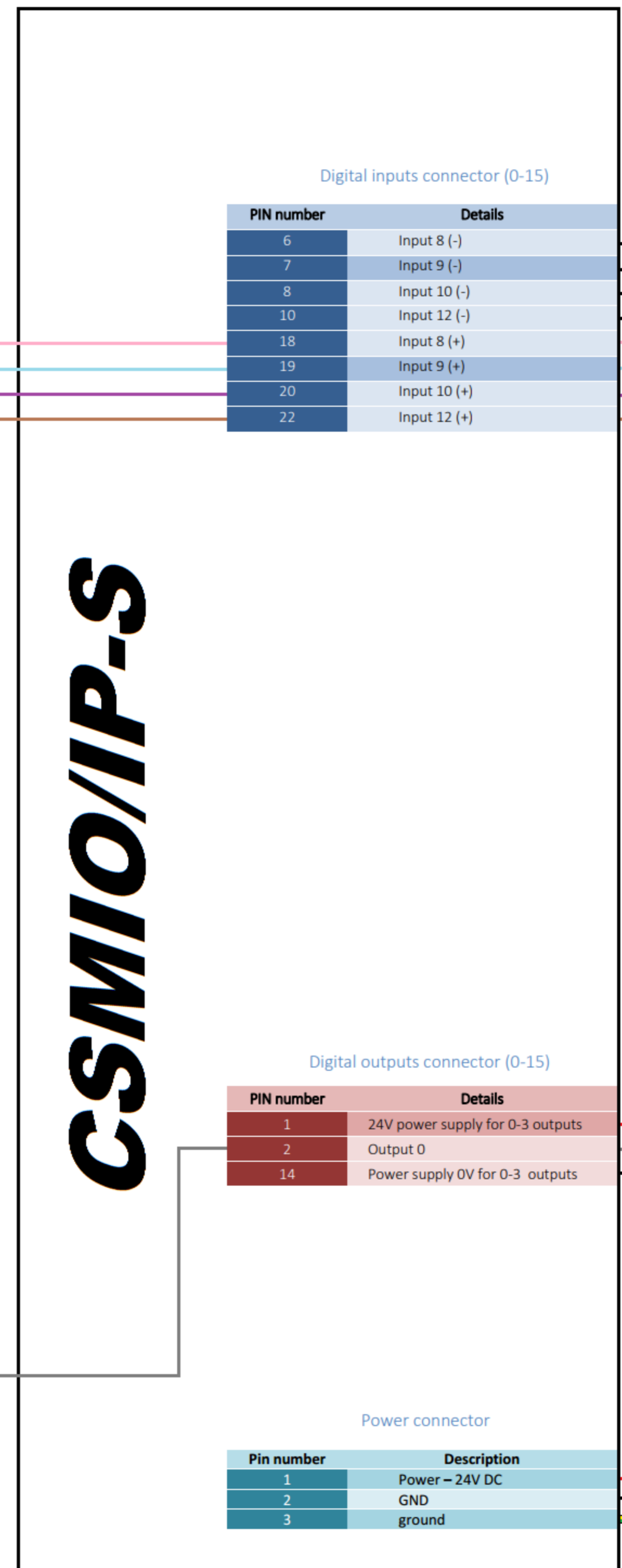
General Gears

Spindle IO
Spindle CW: CSMIO-IP, Output 0, Inverted
Spindle CCW: Disabled, Inverted
Spindle Analog: Disabled, Inverted
Spindle Speed: Disabled, Inverted
Traj Trigger: Disabled, Inverted
Spindle Drive Fault: Disabled, Inverted

Coolant IO
Coolant Flood: Disabled, Inverted
Coolant Mist: Disabled, Inverted

Spindle Parameters
Max Motor Speed: 18000 RPM
Spindle Ready Level: 90 %
Alarm level: 70 %

Start / stop / finish reaction
Actions on start trajectory
Spindle reaction: NONE
Execute M8:
Execute M7:
Actions on stop trajectory
Execute M5:
Execute M9:



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