

TB106 (Rev1) - Using 4th Axis on Offline Mill Intercon

Overview

In order to enable 4th axis support using Off-line Intercon, the control parameter and configuration files must be set correctly. Follow the steps below to enable 4th axis in off-line programming.

Setting correct parameters on the control:

1. At the control, be sure that parameter 94 = 1.0, which is a signal to Intercon that, the 4th axis is rotary. To access the parameters screen starting from the main screen, use **F1 - Setup, F3 - Config**, enter the password of **137**, and then **F3 - Params**. Remember to press **F10 - Save** to save changes.
2. The 4th axis should be labeled in the Machine Configuration with a letter other than N, typically B or W. To access the Machine Configuration screen starting from the main screen, use **F1 - Setup, F3 - Config**, enter the password of **137**, and then **F2 - Machine**, followed by **F2 - Motor**. Remember to press **F10 - Save** to save changes.
3. Another good idea is to set the Console type in the Control Configuration to be Offline, so that the function keys will also be labeled, as the off-line keyboard function keys obviously will not line up with the off-line computer monitor. To access the Control Configuration screen starting from the main screen, use **F1 - Setup, F3 - Config**, enter the password of **137**, and then **F1 - Control**. Remember to press **F10 - Save** to save changes. The console type should be changed back to the original setting after the files have been copied to a floppy disk.

Copying the information from the control to a floppy disk

4. Insert a blank, formatted floppy disk into the floppy drive.
5. From the main screen, exit to DOS by pressing **CTRL + ALT + X**, i.e., all three keys at the same time.
6. Execute the following commands: copy cnc7.prm a:\ press - **ENTER**

```
copy cnc7.cfg a:\ press - ENTER
```

Copying the information from the floppy disk to the off-line system

There are several ways to accomplish this task, especially when the off-line computer operating system is Windows. What needs to be done is that the two files on the floppy disk (cnc7.prm and cnc7.cfg) must be copied into the **VCNC7** directory of the off-line computer system, replacing the ones that are there.

Assuming the off-line system is DOS based, here would be the commands to type at the command line. Using a Windows 9x operating system, the same commands could be typed into the Run dialog box accessible via the Start Menu.

```
copy a:\*. * c:\cnc7 press - ENTER
```

Try using the offline Intercon and verify that 4th axis is enabled.

Document History

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