TB135 (Rev2) - Adding W Axis Buttons to the CAM Menu

Purpose:

The following describes the method of setting up the Centroid control and modifying the CNC7CAMS.TXT file to add buttons for turning the 4th axis on and off for the CNC7 software up to v8.00. After CNC7 v8.00, parameter 131 was added to make this process easier. Please see the operator's manual on a more detailed description of parameter 131.

Procedure:

1 – Exit to DOS by pressing **CTRL+ALT+X** from the main screen. It will close out of the CNC7 software and bring you to the DOS command prompt, C:\CNC7\. Type the following.

- • a. **cd** and press **ENTER**
- • b. **md won** and press **ENTER**
- • c. **md woff** and press **ENTER**
- • d. **cd\cnc7** and press **ENTER**
- • e. **copy cnc7.cfg c:\won** and press **ENTER**
- • f. **copy cnc7.hom c:\won** and press **ENTER**
- • g. **cnc7m4** and press **ENTER**

2 – From the main screen press **F1(Setup)**->**F3(Config)**->default password is 137->**F2(Mach)**->F2**(Motor)**. Disable the 4th axis by setting its label to N. Press the **ESC** until you are at the main screen. Use the **EDIT** screen to edit the "cnc7.hom" file and remove the lines with the 4th axis commands. Save the file.

3 – Exit to DOS by pressing **CTRL+ALT+X** from the main screen. It will close out of the CNC7 software and bring you to the DOS command prompt, C:\CNC7\. Type the following.

- • a. **copy cnc7.cfg c:\woff** and press **ENTER**
- • b. **copy cnc7.hom c:\woff** and press **ENTER**
- • c. **edit cnc7cams.txt** and press **ENTER**

4 – Use the arrow keys to move the cursor below the last line of text in the cnc7cams.txt file.

Add the following lines:

```
W on:W axis on
    copy /y \won\*.*
W off:W axis off
    copy /y \woff\*.*
```

The format for the first line of information is a short name that appears on the function key label followed by a colon and a long name description that appears in the center of the screen. The short name is limited to seven (7) characters. The second and continuing lines are to be preceded by an indentation, followed by text that will be placed into a batch file and executed.

5 – Save the file by pressing **ALT+F** to bring the file menu down. Then press **S**. These keys are **NOT** hit at the same time, but one key after the other.

6 – Exit the editor by pressing **ALT+F** to bring the file menu down. Then press **X.** You should now be at the DOS command prompt again. Type the following.

- • a. **cd\cnc7** and press **ENTER**
- • b. **cnc7m4** and press **ENTER**

Document History

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