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Service Bulletin

Number: 0023

Title: Changing Default Step Sizes

Date: April 21, 2008

Product Identification: PCNC 1100 Milling Machine & Duality Lathe

Summary:

Machine configuration (XML file) contains default step sizes for incremental motion. These are the discrete steps available through keyboard jogging in step mode, keypad jog pendant (PN 30552) jogging, or using the inner wheel of the jog shuttle (PN: 30616). An update to the XMLTweak program allows the default step sizes to be changed to the machine owner's preference.

Background:

Machine owners using the jog shuttle have reported, due to the ease of velocity jogging (outer wheel of the jog shuttle), they find large step sizes associated with position jogging (inner wheel) to be inconvenient. Many operators would like to keep default sizes small such that the inner wheel is dedicate to very small motion while the outer wheel is used for large motions.

Additionally, operators using metric operations find the default step sizes to be so small they become impractical. The step sizes have no units so a step size of 0.005 means 0.005" while G20 (imperial mode) is active, yet it means 0.005 mm when G21 (metric mode) is active. The resolution of this is to allow user configuration of the default step sizes.

Installation:

The XMLTweak program available is an update, not a complete installation. The original installation is part of the installation program for the PCNC1100 and should already be installed on your machine control computer. XMLTweak is also available as an independent installation at:

http://www.tormach.com/document_library/XMLTweakPackage.exe

To update the program, download XMLTweak.exe from the Tormach web site. This can be found at:

http://www.tormach.com/document_library/XMLTweak.exe

Download the file XMLTweak.exe and put it in the directory C:\ProgramFiles/XMLTweak. This will overwrite the original XMLTweak.exe program. The program can be started from Windows Start > Programs.



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Notice: The XMLTweak program is also used to fine tune your spindle speed calibration as described in section 9.5.6 of the owner's manual (Rev C3-1). Any time you reinstall the machine control software you will overwrite the configuration XML file. This will set your spindle speed tuning, step sizes, and printer port address to the original defaults. Take note, restoring the system via a complete software reinstallation will require resetting the speed calibration and port setting, as well as the step sizes. XMLTweak can be used to edit any of these parameters.