Simulating axes

$AX_SIM_ON

Axes that are not actually present can be simulated.

Syntax

$AX_SIM_ON = Value Example:

Simulate axis 3 $AX_SIM_ON='B0100'

Argument	Type	Explanation
Value	INT	This bit-coded value specifies which axes are being simulated. 1: Axis is simulated 0: Axis is moved

Simulating axes

$AX_SIM_ON

$AX_SIM_ON can be used to simulate axes.
No hardware actually needs to be connected.

If hardware is present, it must be borne in mind that the braking channel is activated which can result in the simulated axis sagging.

→ The brake cable should thus be disconnected first!

Once a simulated axis has been reset from bit 1 to bit 0 it must be mastered.

This machine datum may only be modified if it is absolutely certain that the modification will not endanger persons.

Simulating axes

$SIMULATED_AXIS

Axes that are present can be simulated.

In this case, the corresponding hardware must be connected.
Axes are included in the planning, but are not moved.
Modification of this machine datum does not necessitate mastering of the axis.
The brakes are activated, but the axis is regulated and does not sag.

Syntax

$SIMULATED_AXIS = Value

Example: Simulate axis 3 → $SIMULATED_AXIS='B0100'

Argument	Type	Explanation
Value	INT	This bit-coded value specifies which axes are being simulated. 1: Axis is simulated 0: Axis is moved

Modification of individual machine data in the GUI

- Open $MACHINE.DAT
- Select Configure → Miscellaneous → Editor → DEF line
- Enter the data line directly before the "ENDDAT" line
- Close
- The existing data are automatically overwritten by the new data when the file is closed.

No additional lines can be inserted into $MACHINE.DAT.
The machine data editor only permits modifications to existing lines!

Additional lines before the ENDDAT line cause the previous lines to be overwritten!

Loading user-created file fragments

- Enter data lines in a text document, with the file extension ".txt", using NOTEPAD.
- Save text document on C:\ (not in the KRC directory!).

- Open the text document in the GUI (at Expert level) and select and copy its contents.
- Close the text document.
- Open $MACHINE.DAT.
- Select Configure → Miscellaneous → Editor → DEF line
- Create a blank line before the "ENDDAT" line.
- Position the cursor in the blank line.
- Program → Paste
- Close
- The existing data are automatically overwritten by the new data when the file is closed.

Loading file fragments from the external axis configurator

- Create data using the external axis configurator.
- The data are saved to floppy disk with the name "ExtAxisMach.dat".
- There is a version identifier at the start of this file to prevent data from different software versions from becoming mixed.

- Before the data are loaded, the external axis configurator must be started at Expert level.
- File → Load from floppy
- Carry out any modification.
- When the program is closed, a request for confirmation is generated, asking whether the changes are to be saved.
- Answer "Yes" and wait until the message "Download completed" appears.