

Configuration

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

Mode

THC mode Smart analog

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 CSMIO-IP Analog Input 3 Inverted

Potentiometer settings

Potentiometer CSMIO-IP Analog Input 2 Inverted

Potentiometer enable CSMIO-IP Input 11 Inverted

Scaling

Torch potentiometer position min 100 V

Torch potentiometer position max 200 V

Parameters

Thc velocity 2000 mm/min

Thc max deviation positive 20 mm

Thc max deviation negative 20 mm

Torch voltage threshold 150 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 150 V

Torch on voltage max 200 V

Movement dynamics

Thc smart analog amplification 3 mm/V

Thc voltage deadband 2 V

Plasma

Torch voltage division factor 1 / 20

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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

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 M8

Execute M9

Digital inputs connector (0-15)

PIN number	Details
6	Input 8 (-)
7	Input 9 (-)
8	Input 10 (-)
9	Input 11 (-)
10	Input 12 (-)
18	Input 8 (+)
19	Input 9 (+)
20	Input 10 (+)
21	Input 11 (+)
22	Input 12 (+)

Analog inputs/outputs connector

PIN number	Details
2	GND
4	Analog input 2
5	10V (max. 50mA)
8	GND
9	Analog input 3

Digital outputs connector (0-15)

PIN number	Details
1	24V power supply for 0-3 outputs
2	Output 0
14	Power supply 0V for 0-3 outputs

Power connector

Pin number	Description
2	Power = 24V DC
2	GND
3	ground

