

COMMISSIONING PARAMETERS

LOOP1 POSITION CONTROL PARAMETERS

No:	NAME	UNITS	COMMISSIONING VALUE
1	Kerf	0.1mm	
2	Probe Offset	0.1mm	
3	Back Limit	0.1mm	
5	Dogs-in / Forward Limit	0.1mm	
6	Dogs-out Limit	0.1mm	
7	Forward Limit 4	0.1mm	
8	Forward Limit 5	0.1mm	
9	Forward Limit 6	0.1mm	
10	Flipper Limit	0.1mm	
11	Probe Stroke	0.1mm	
12	Probe Max Count	1	
13	Probe Min Count	1	
14	Electrical Offset Distance	0.1mm	
15	Slow Valve Delay	0.1s	
16	Park Position	0.1mm	
17	Forward Drift Distance	0.1mm	
18	Back Drift Distance	0.1mm	
19	Min Set Distance	0.1mm	
20	Back Up Distance	0.1mm	
21	Probe Type	1	
22	Set Mode	1	
23	Valve Forward Max %	0.1%/mm	
24	Valve Back Max %	0.1%/mm	
25	Max Forward Speed %	0.1%/mm	
26	Forward Deadband.	0.1%/mm	
28	Max Back Speed %	0.1%/mm	
29	Back Deadband.	0.1%/mm	
31	Forward Ramp Up	0.1%/mm	
32	Back Ramp Up	0.1%/mm	
33	Jog Forward Speed %	0.1%/mm	
34	Jog Back Speed %	0.1%/mm	
35	Slow Jog Forward Speed %	0.1%/mm	
36	Slow Jog Back Speed %	0.1%/mm	

37	Forward Ramp Down	0.1%/mm	
38	Back Ramp Down	0.1%/mm	
39	Kp (pos hold)	0.1%/mm	
42	Kp limit	0.1%/mm	
53	Jog Limit Ramp	0.1%/mm	
54	Limit Type	0.1%	
55	Valve Dither %	0.1%	
56	Loop Type	1	
57	Valve Null Back %	0.1%	
58	Valve Null Forward %	0.1%	
59	Probe Invert	1	
60	Valve Output Invert	1	
62	Output Drive Select	1	
63	Ramp Up Boost	0.1%	
64	Ramp Down Boost	0.1%	
65	Jog Fwd Ramp Down	0.1%/mm	
66	Jog Back Ramp Down	0.1%/mm	
67	Jog Back Flag Override	1	
68	Jog Button Invert	1	
74	Auto-Calibrate Inhibit	1	
75	Run Confirm Bypass	1	
76	Flag Operation	1	
77	Auto Pullback	1	
78	Pullback Delay	0.1s	
79	Flag Filtering Delay	0.1s	

LOOP2 POSITION CONTROL PARAMETERS

No:	NAME	UNITS	COMMISSIONING VALUE
201	Kerf	0.1mm	
202	Probe Offset	0.1mm	
203	Back Limit	0.1mm	
205	Dogs-in / Forward Limit	0.1mm	
206	Dogs-out Limit	0.1mm	
207	Forward Limit 4	0.1mm	
208	Forward Limit 5	0.1mm	
209	Forward Limit 6	0.1mm	
210	Flipper Limit	0.1mm	
211	Probe Stroke	0.1mm	
212	Probe Max Count	1	
213	Probe Min Count	1	
214	Electrical Offset Distance	0.1mm	
215	Slow Valve Delay	0.1s	
216	Park Position	0.1mm	
217	Forward Drift Distance	0.1mm	
218	Back Drift Distance	0.1mm	
219	Min Set Distance	0.1mm	
220	Back Up Distance	0.1mm	
221	Probe Type	1	
222	Set Mode	1	
223	Valve Forward Max %	0.1%/mm	
224	Valve Back Max %	0.1%/mm	
225	Max Forward Speed %	0.1%/mm	
226	Forward Deadband.	0.1%/mm	
228	Max Back Speed %	0.1%/mm	
229	Back Deadband.	0.1%/mm	
231	Forward Ramp Up	0.1%/mm	
232	Back Ramp Up	0.1%/mm	
233	Jog Forward Speed %	0.1%/mm	
234	Jog Back Speed %	0.1%/mm	
235	Slow Jog Forward Speed %	0.1%/mm	
236	Slow Jog Back Speed %	0.1%/mm	
237	Forward Ramp Down	0.1%/mm	
238	Back Ramp Down	0.1%/mm	
239	Kp (pos hold)	0.1%/mm	

242	Kp limit	0.1%/mm	
253	Jog Limit Ramp	0.1%/mm	
254	Limit Type	0.1%	
255	Valve Dither %	0.1%	
256	Loop Type	1	
257	Valve Null Back %	0.1%	
258	Valve Null Forward %	0.1%	
259	Probe Invert	1	
260	Valve Output Invert	1	
262	Output Drive Select	1	
263	Ramp Up Boost	0.1%	
264	Ramp Down Boost	0.1%	
265	Jog Fwd Ramp Down	0.1%/mm	
266	Jog Back Ramp Down	0.1%/mm	
267	Jog Back Flag Override	1	
268	Jog Button Invert	1	
274	Auto-Calibrate Inhibit	1	
275	Run Confirm Bypass	1	
276	Flag Operation	1	
277	Auto Pullback	1	
278	Pullback Delay	0.1s	
279	Flag Filtering Delay	0.1s	
280	At target tolerance	0.1mm	
290	Set window 1 lower value	0.1mm	
291	Set window 1 upper value	0.1mm	
292	Set window 2 lower value	0.1mm	
293	Set window 2 upper value	0.1mm	
294	Set window 3 lower value	0.1mm	
295	Set window 3 upper value	0.1mm	
296	Set window 4 lower value	0.1mm	
297	Set window 4 upper value	0.1mm	
298	Set window 5 lower value	0.1mm	
299	Set window 5 upper value	0.1mm	

CONSOLE PARAMETERS

No:	NAME	UNITS	COMMISSIONING VALUE
100	Display Rounding	1	
101	Setting Mode	1	
102	PIN Required	1	
103	Retract Position (V1-7 & earlier only)	1mm	
104	Display Flash Time	1	
105	Setworks Type	1	
106	Display Brightness	1	
107	Number of Layers	1	
108	Matrix filter count	0.1	
109	Fwdset Counter Control	1	
110	Crash / Rack Tolerance	0.1mm	
111	Loop2 Position Displayed	1	
112	Throat Max	0.1mm	
113	VPD Select	1	
114	Loop1 Negative Offset	0.1mm	
115	Loop2 Negative Offset	0.1mm	
116	Loop1 Retract Position	0.1mm	
117	Loop2 Retract Position	0.1mm	
197	Software Version	0.1	