



## Tool Setup | Trajectory Planner | Jog Speeds support U and V axes

Tool Setup Screen

M0 - M30 M100-M119 User Buttons Tool/Setup Files Trajectory Planner

Trajectory Planner

Break Angle  degrees Look ahead  seconds Collinear Tolerance  in Corner Tolerance  in Facet Angle  degrees

Arcs to Segments

Joystick/Jog

Jog Speeds X  Y  Z  A  B  C  U  V  in/sec 25 Slow\* units  mm  inch

Step Increments        Reverse R/Z  Enable Gamepad

Axis Parameters

	Counts/inch	Vel in/sec	Accel in/sec	
X	<input type="text" value="10000"/>	<input type="text" value="10"/>	<input type="text" value="30"/>	
Y	<input type="text" value="10000"/>	<input type="text" value="10"/>	<input type="text" value="30"/>	
Z	<input type="text" value="10000"/>	<input type="text" value="10"/>	<input type="text" value="30"/>	
U	<input type="text" value="100"/>	<input type="text" value="10"/>	<input type="text" value="0.01"/>	
V	<input type="text" value="100"/>	<input type="text" value="10"/>	<input type="text" value="0.01"/>	

	Cnts/deg	Vel deg/sec	Accel deg/sec2	Degrees	Radius inches
A	<input type="text" value="100"/>	<input type="text" value="10"/>	<input type="text" value="10"/>	<input checked="" type="checkbox"/>	<input type="text" value="0"/>
B	<input type="text" value="100"/>	<input type="text" value="10"/>	<input type="text" value="10"/>	<input checked="" type="checkbox"/>	<input type="text" value="0"/>
C	<input type="text" value="100"/>	<input type="text" value="10"/>	<input type="text" value="10"/>	<input checked="" type="checkbox"/>	<input type="text" value="0"/>

Threading

Sensor Type  0=none 1=encoder Encoder Axis  Update Time  secs

Motion Filter Time  secs Count/Rev

Lathe Options

Lathe  Diameter Mode

X Positive Front

Feed Rate Override

Hardware Range

Max Rapid FRO

Rapids as Feeds

Display Encoders

Zero Using Fixture Offsets

Tool Length/Offset Immediately

M6 on Tool Table Changes

Confirm Program Exit

Arc beg/end radius Tol  inch

Arc radius small Tol  inch

Cancel OK Help

Added KMotionCNC Tool Setup Password Protection if file \KMotion\Data\ToolSetupPassword.txt exists it is enforced.

Enter Password

Password

Cancel OK

Help Screens Describe Password Protection of Tool Setup Parameters

Fix issue with persistent screen positions when on 2<sup>nd</sup> monitor

Improve Tab Order on Dialogs

## **KMotionCNC Screen Editor**

Allow Pasting settings from one control to multiple controls. Select one Control – Copy. Select one or more Controls – Paste. Only Font, Style, Bitmaps, and Colors will be copied. User will be queried to copy Size (Width and Height).

Controls with default Bitmaps (used when no Bitmap files are specified) can be reverted to Text by specifying “none” as Bitmap File 1.

## **KMotion**

Fix issue with persistent screen positions when on 2<sup>nd</sup> monitor

## **C Programs**

Example 8 Axis configuration \KStep\InitStepDir8Axis.c