

Config file settings

```
=====
[Setup]
=====
    BoardType=4
    Microsteps_Spindle=32
    StepsPer360_Spindle=200
    GearRatio_Spindle=9
    Polarity_Spindle=1

;Z Axis
    Microsteps_Z=32
    StepsPer360_Z=200
    DistancePer360_Z=.02
    Polarity_Z=1

;X Axis
    Microsteps_X=32
    StepsPer360_X=200
    DistancePer360_X=.02
    Polarity_X=1

;B Axis
    Microsteps_B=32
    StepsPer360_B=200
    GearRatio_B=150
    Polarity_B=1
    DistancePer360_B=1.02
    RadialOrLineal=0
    BRadius=5

=====
[Limits]
=====
;Limit Switches
    Min_Z=34
    Max_Z=35
    Min_X=36
    Max_X=37
    Min_B=38
    Max_B=39

=====
[Returns]
=====
;Return
    MaxSpeed_Spindle=15011
    Accel_Spindle=15012

    MaxSpeed_Axis_Z=15013
    Accel_Axis_Z=15014

    MaxSpeed_Axis_X=15015
    Accel_Axis_X=15016

    MaxSpeed_Axis_B=15017
    Accel_Axis_B=15018
```

```
=====
[Main]
=====
;Axis Ids:
;-----
;Z=0
;X=1
;B=2
;Spindle=3

;-----
    AxisId=0
;Spindle
    MaxSpeed_Spindle=15000
    Accel_Spindle=15001
    SpeedPercentage_Spindle=30

;Z Axis
    MaxSpeed_Z=4001
    Accel_Z=5002
    SpeedPercentage_Z=53

;X Axis
    MaxSpeed_X=4000
    Accel_X=5005
    SpeedPercentage_X=10

;B Axis
    MaxSpeed_B=5007
    Accel_B=5008
    SpeedPercentage_B=59

=====
[One]
=====
    AxisId=3
;Spindle
    MaxSpeed_Spindle=25060
    Accel_Spindle=20061
    SpeedPercentage_Spindle=61

;Z Axis
    MaxSpeed_Z=5062
    Accel_Z=5063
    SpeedPercentage_Z=64

;X Axis
    MaxSpeed_X=5065
    Accel_X=5066
    SpeedPercentage_X=67

;B Axis
    MaxSpeed_B=5068
    Accel_B=5069
    SpeedPercentage_B=70
```

```

=====
[Ind]
=====
      IndexId=1
      MaxSpeed_Spindle=5070
      Accel_Spindle=5071
      SpeedPercentage_Spindle=72
;-----
;Division:0 Degrees:2
;Fixed:0 File:1
;-----
;Index 1
      DivisionsOrDegrees_1=2
      FixedOrFile_1=0
      Size_1=1.875
;Index 2
      DivisionsOrDegrees_2=2
      FixedOrFile_2=0
      Size_2=24.375
;Index 3
      DivisionsOrDegrees_3=2
      FixedOrFile_3=0
      Size_3=90

```

```

=====
[Mov]
=====
      AxisId=0
;Z Axis
      MaxSpeed_Z=5080
      Accel_Z=5081
      SpeedPercentage_Z=82
      Distance_Z=3
;X Axis
      MaxSpeed_X=5083
      Accel_X=5084
      SpeedPercentage_X=85
      Distance_X=5.75
;B Axis
      MaxSpeed_B=5086
      Accel_B=5087
      SpeedPercentage_B=88
      Distance_B=5.78

```

```

=====
[BE]
=====
      AxisId=0
;Spindle
      MaxSpeed_Spindle=5090
      Accel_Spindle=5091
      SpeedPercentage_Spindle=92
;Z Axis
      MaxSpeed_Z=5093
      Accel_Z=5094
      SpeedPercentage_Z=95
;X Axis
      MaxSpeed_X=5096
      Accel_X=5097
      SpeedPercentage_X=98
;B Axis
      MaxSpeed_B=5099
      Accel_B=5100
      SpeedPercentage_B=50

```

```

=====
[Sync]
=====
      AxisId=0
      HelixType=0
      Revolutions=.3
      Distance=10
;Spindle
      MaxSpeed_Spindle=5040
      Accel_Spindle=5041
      SpeedPercentage_Spindle=42
;Z Axis
      MaxSpeed_Z=5043
      Accel_Z=5044
      SpeedPercentage_Z=45
;X Axis
      MaxSpeed_X=5046
      Accel_X=5047
      SpeedPercentage_X=48
;B Axis
      MaxSpeed_B=5048
      Accel_B=5049
      SpeedPercentage_B=49

```

```

=====
[Rec]
=====
      AxisId=0
      RadialOrAxial=0
;Spindle
      MaxSpeed_Spindle=5030
      Accel_Spindle=5031
      SpeedPercentage_Spindle=32

;Z Axis
      MaxSpeed_Z=5033
      Accel_Z=5034
      SpeedPercentage_Z=35

;X Axis
      MaxSpeed_X=5036
      Accel_X=5037
      SpeedPercentage_X=38

;B Axis
      MaxSpeed_B=5039
      Accel_B=5040
      SpeedPercentage_B=39

;Radial
      Radial_Waves=5
      Radial_Spindle_Amplitude=20
      Radial_Axis_Distance=5

;Axial
      Axial_Waves=4
      Axial_Spindle_Degrees=25
      Axial_Axis_Amplitude=7

```

```

=====
[Grk]
=====
      AxisId=0
      FileOrPattern=0
;Spindle
      MaxSpeed_Spindle=5020
      Accel_Spindle=5021
      SpeedPercentage_Spindle=22

;Z Axis
      MaxSpeed_Z=5023
      Accel_Z=5024
      SpeedPercentage_Z=25

;X Axis
      MaxSpeed_X=5026
      Accel_X=5027
      SpeedPercentage_X=28

;B Axis
      MaxSpeed_B=5028
      Accel_B=5029
      SpeedPercentage_B=29

;Pattern page
      RadialOrAxial_Pattern=0
;4a: 2 4b: 3 3a: 6 3b: 7 2a: 4 2b: 5
      PatternType=4
      Pattern_PatternsPer360=8
      Pattern_PatternCount=1
      Pattern_SegmentLength=1

;File page
      RadialOrAxial_File=0
      File_PatternsPer360=7
      File_PatternCount=1
      File_SegmentLength=1

;Segments: 2 Actual: 3
      File_SegmentsOrActual=2

```

```
;=====
[Geo]
;=====
    AxisId=0
    RadialOrAxial=0
    Rose_n=7
    Rose_d=5

;Spindle
    MaxSpeed_Spindle=5010
    Accel_Spindle=5011
    SpeedPercentage_Spindle=12

;Z Axis
    MaxSpeed_Z=5013
    Accel_Z=5014
    SpeedPercentage_Z=15
    RadialAmplitude_Z=2
    AxialAmplitude_Z=2.5

;X Axis
    MaxSpeed_X=5016
    Accel_X=5017
    SpeedPercentage_X=18
    RadialAmplitude_X=2
    AxialAmplitude_X=2.5

;B Axis
    MaxSpeed_B=5018
    Accel_B=5019
    SpeedPercentage_B=19
    RadialAmplitude_B=3
    AxialAmplitude_B=3.5
```