**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