

CNC Table

Power & Control System – V1

Michael Aimino

2026-01-15

Contents

Readme	2
Build-Order Dependency Chart	3
Power & Control System Configuration	5
Wiring Shopping List	6
Wire Gauge Specification	9
Terminal-by-Terminal Wiring Table	12
DMA860S Tuning	16
DDCSV4.1 Axis and Dual-X Homing Configuration	19
Steps-Per-Unit Calibration	24
Enable and Configure Soft Limits	28
Configure Acceleration and Maximum Velocity	30
Validate Spindle Speed Scaling	31
Dry-Run G-code Test	33
Control Cabinet Physical Plan	34
Commissioning Checklist	35
Pre-Cut Checklist	38

Readme

Proverbs 15:32 - “Whoever ignores instruction despises himself, but he who listens to reproof gains understanding.” Proverbs 12:15 - “The way of a fool is right in his own eyes, but a wise man listens to advice.” Proverbs 13:18 - “Poverty and shame come to him who ignores instruction, but whoever heeds reproof is honored.”

Reference Materials

1. 3 Axis Table and Gantry System Configuration - V1
2. Power and Control System Configuration - V1
3. Wiring Shopping List

Build and Commissioning Order (Authoritative)

Build Order Dependency Chart

All setup, configuration, and commissioning steps must follow this order.
Mechanical and electrical systems are interdependent and must be validated at their defined gates.

3 Axis Table and Gantry System - V1 - Instructions

1. Mechanical Leveling and Squaring

Power and Control System - V1 - Instructions

1. Wire Gauge Specification
2. Terminal-by-Terminal Wiring Table
3. DMA860S Tuning
4. DDCSV4.1 Axis and Dual-X Homing Configuration
5. Steps-Per-Unit Calibration
6. Enable and Configure Soft Limits
7. Configure Acceleration and Maximum Velocity
8. Validate Spindle Speed Scaling
9. Dry-Run G-code Test
10. Control Cabinet Physical Plan

Commissioning

Commissioning validates the combined mechanical and power/control systems.
Neither system is considered complete in isolation.

1. Commissioning Checklist
2. Pre-Cut Checklist

Build-Order Dependency Chart

Power & Control System – V1

Each section **depends on all sections above it**. If work stops and resumes later, restart at the highest unchecked section.

Administrative Baseline

- System named and labeled as Power & Control System – V1
- Component selection frozen
- Wiring, configuration, and commissioning documents created

Mechanical Foundation

- CNC table assembled
- Frame leveled relative to gravity
- X, Y, and Z axes mechanically square
- Linear motion smooth across full travel
- Mechanical alignment declared valid

This section is a hard gate for electrical motion testing.

Electrical Infrastructure

- Cabinet installed
- Ground bar installed and bonded to earth
- Main disconnect installed
- Branch protection installed
- AC integrity verified with no loads

Power Conversion and Distribution

- Control PSU installed and verified
- Stepper PSU installed and verified
- DC distribution terminals installed
- Voltage domains labeled

Motion and Logic Hardware

- DDCSV4.1 installed
- DMA860S drivers installed
- DIN-rail terminals installed
- Device frames bonded to ground
- Controller boots normally

Signal Wiring

- Step, direction, and enable signals wired
- Driver-to-motor wiring complete
- Limit and home switches wired
- E-stop logic wired
- Spindle control signals wired

Static Electrical Verification

- Continuity checks complete
- Ground isolation verified
- Shield termination verified
- Power-up with motors disabled
- No faults or overheating

Motion Enablement

- Drivers enabled
- Individual axis jogging verified
- Axis directions verified
- Dual-X coherence verified
- Motion disabled and inspected

Homing and Squaring

- Homing directions configured
- Home switches verified
- Dual-X homing enabled
- Gantry squaring verified
- Homing repeatability confirmed

Motion Calibration

- Driver current and microsteps set
- Initial steps-per-unit entered
- X axis calibrated
- X calibration copied to A
- Y axis calibrated
- Z axis calibrated under load

Safety Envelope

- Soft limits enabled
- Soft limits verified

- Hard limits verified
- E-stop removes motion power
- E-stop stops spindle

Spindle Validation

- Cooling system verified
- VFD terminal control verified
- 0–10 V scaling validated
- Commanded RPM matches actual RPM
- Thermal behavior observed

Integrated Testing

- Dry-run G-code loaded
- Full dry-run executed
- Axis coordination verified
- No lost steps
- No limit faults

Commissioning Complete

- Configuration values recorded
- Cabinet closed and ventilated
- Wiring labeled
- V1 declared commissioned

Power & Control System Configuration

Power & Control System – V1

- **Controller:** CNCTOPBAOS DDCSV4.1 (stand-alone, PLC-capable, MPG)
- **Axes:** 4 total
 - X axis: dual NEMA 34 (slaved, auto-squaring)
 - Y axis: single NEMA 34
 - Z axis: single NEMA 34
- **Motors:** HobbyUnlimited NEMA 34, 6 A, 12 Nm, 156 mm
- **Drivers:** 4 × DMA860S digital stepper drivers
- **Stepper power:** Single high-voltage DC bus (60–72 VDC class)
- **Control power:** 24 VDC logic and I/O supply

- **Spindle system:** Huanyang 2.2 kW VFD + 80 mm water-cooled spindle, 0–10 V speed, relay run control
- **Safety model:** Hardware E-stop cutting stepper power and spindle run, plus controller awareness
- **Architecture:** Fully stand-alone, no PC dependency during runtime

Wiring Shopping List

Power & Control System – V1

1. AC Mains and Power Distribution Wire

High-current AC (cabinet internal)

- **10 AWG stranded copper wire (green)**
 - Purpose: main cabinet ground bond
 - Buy: 10–15 ft
- **10 AWG stranded copper wire (black/red)**
 - Purpose: main AC feed inside cabinet
 - Buy: 10–15 ft
- **12 AWG stranded copper wire (black/red)**
 - Purpose: VFD input power
 - Buy: 10–15 ft
- **14 AWG stranded copper wire (black/red)**
 - Purpose: stepper PSU AC feed
 - Buy: 10–15 ft
- **16 AWG stranded copper wire**
 - Purpose: control PSU AC feed
 - Buy: 10 ft

Insulation type:

- MTW or THHN, 600 V rated, 75 °C or higher

2. VFD to Spindle Cable (critical item)

- **Shielded VFD motor cable, 4-conductor**
 - Conductors: **14 AWG**
 - Configuration: 3 phases + ground

- Shield: braided or foil + drain
- Length: machine dependent
 - * Typical router: **15–25 ft**

Do not substitute generic SOOW here. This cable matters.

3. Stepper DC Power Wiring

DC bus (PSU to distribution)

- **10 AWG stranded copper wire (red and black)**
 - Purpose: stepper PSU DC output to terminal block
 - Buy: 10 ft each color

DC distribution to drivers

- **14 AWG stranded copper wire (red and black)**
 - Purpose: terminal block to each DMA860S
 - Buy: 25–30 ft total (covers all four drivers)

4. Stepper Motor Cables

You have **4 NEMA 34 motors**.

- **Shielded motor cable, 4-conductor**
 - Conductors: **14 AWG**
 - Twisted pairs preferred
 - Shield with drain wire
 - Length per motor:
 - * X motors: gantry travel + service loop
 - * Y motor: full axis travel
 - * Z motor: shorter run
 - Typical total buy: **60–80 ft**

Label both ends before installing.

5. Control Power (24 VDC)

- **16 AWG stranded copper wire**
 - Purpose: 24 VDC PSU to distribution
 - Buy: 10 ft

- **18 AWG stranded copper wire**
 - Purpose: distribution to DDCSV, relays, fans
 - Buy: 30–40 ft

Color suggestion:

- Red = +24 V
- Black or blue = 0 V

6. Step / Direction / Enable Signal Wiring

- **Shielded, twisted-pair control cable**
 - Conductors: **22 AWG**
 - Pairs: at least 2 pairs per axis
 - Shield with drain wire

Usage:

- DDCSV → DMA860S (Step, Dir, Enable)

Buy:

- **30–40 ft total**

You can run one multi-pair cable per driver or bundle pairs neatly.

7. Limits, Homes, and E-stop Wiring

Limit and home switches

- **Shielded control cable**
 - Conductors: **22 AWG**
 - 2–3 conductors per switch
 - Buy: **40–60 ft** (depends on machine size)

E-stop control loop

- **18 or 20 AWG stranded copper**
 - Purpose: E-stop logic loop
 - Buy: 15–20 ft

8. Analog Spindle Speed Control (0–10 V)

- **Shielded twisted-pair cable**
 - Conductors: **22 AWG**
 - Buy: 10–15 ft

This must be its own cable. Do not bundle with step/dir.

9. Grounding and Shield Termination

- **14 AWG green stranded copper wire**
 - Purpose: bonding PSUs, drivers, VFD chassis
 - Buy: 15–20 ft
- **Drain wire (18–22 AWG)**
 - Purpose: shield termination to ground bar
 - Usually included in shielded cable, but have extra on hand

10. Optional but strongly recommended

- Ferrules for:
 - 10 AWG
 - 12 AWG
 - 14 AWG
 - 16 AWG
 - 18–22 AWG
- Heat-shrink labels
- Cable clamps and strain reliefs
- Wire duct (slotted)

Wire Gauge Specification

Power & Control System – V1

Conventions used

- Copper conductors, 75 °C minimum insulation (THHN/MTW inside cabinet)
- Stranded wire for anything that moves or lands on terminals
- Shielded cable where noted
- All grounds bonded to a single cabinet ground bar

1. AC mains and protection

Circuit	Voltage	Current (typical)	Wire gauge	Notes
Main AC feed (to cabinet disconnect)	240 VAC	≤ 30 A	10 AWG	Headroom, mechanical robustness
Disconnect → VFD input	240 VAC	$\sim 10\text{--}12$ A	12 AWG	Dedicated run
Disconnect → Stepper PSU	240 VAC	$\sim 8\text{--}10$ A	14 AWG	Separate branch
Disconnect → Control PSU	120/240 VAC	< 2 A	16 AWG	Light load
Safety ground (PE)	—	—	10 AWG	Cabinet ground bond

2. VFD to spindle (noise-critical)

Circuit	Voltage	Current	Wire gauge	Cable type
VFD → spindle	0–240 VAC, 3-phase	$\sim 6\text{--}9$ A	14 AWG	Shielded VFD motor cable
Spindle ground	—	—	14 AWG	Bond to spindle body

Rules:

- Shield grounded at **VFD end only**
- Route alone, no parallel signal wiring

3. Stepper DC power distribution

Circuit	Voltage	Current	Wire gauge	Notes
Stepper PSU DC output → distribution	60–72 VDC	up to 20 A	10 AWG	Short run to terminal block
Distribution → each DMA860S	60–72 VDC	≤ 6 A per driver	14 AWG	Star topology, not daisy-chain
DC negative return	60–72 VDC	—	10–14 AWG	Match positive size

4. Stepper drivers to motors

Circuit	Voltage	Phase current	Wire gauge	Cable type
DMA860S → NEMA 34 motor	Pulsed DC	6 A	14 AWG	Shielded, twisted pairs

Notes:

- One cable per motor
- Shield grounded at cabinet end only
- Keep away from VFD output cable

5. Control power (24 VDC)

Circuit	Voltage	Current	Wire gauge	Notes
Control PSU output → distribution	24 VDC	≤5 A	16 AWG	Short internal run
Distribution → DDCSV4.1	24 VDC	<1 A	18 AWG	Clean logic feed
Distribution → relays, MPG, fans	24 VDC	<1 A each	18 AWG	Label circuits

6. Step/Dir and enable signals (DDCSV → DMA860S)

Signal type	Voltage	Current	Wire gauge	Cable type
Step / Dir / Enable	5–24 V logic	mA	22 AWG	Shielded, twisted pairs

Notes:

- Differential wiring preferred where available
- Shield grounded at controller end only

7. Limits, homes, E-stop

Circuit	Voltage	Current	Wire gauge	Cable type
Limit & home switches	24 VDC	mA	22 AWG	Shielded if long runs
E-stop loop (control)	24 VDC	mA	18–20 AWG	Robust insulation
E-stop power interrupt	AC	varies	Same as interrupted circuit	Through contactor/relay

8. Analog spindle speed control (DDCSV → VFD)

Circuit	Voltage	Current	Wire gauge	Cable type
0–10 V analog	0–10 VDC	mA	22 AWG	Shielded twisted pair

Rules:

- Shield grounded at DDCSV end only
- Never share conduit with VFD output

9. Grounding and shields

Purpose	Wire gauge
Cabinet ground bar → earth	10 AWG
PSU frames → ground bar	12–14 AWG
Driver frames → ground bar	14 AWG
Cable shields → ground bar	Drain wire, 18–22 AWG

Terminal-by-Terminal Wiring Table

Power & Control System – V1

1. Power distribution (AC side)

1.1 Main AC → devices

From	Terminal	To	Terminal	Notes
AC mains L1	—	Main disconnect	L1	240 VAC
AC mains L2	—	Main disconnect	L2	240 VAC
Earth	—	Ground bar	GND	10 AWG

1.2 Main disconnect → VFD

From	Terminal	To	Terminal	Notes
Disconnect L1	—	VFD	R	12 AWG
Disconnect L2	—	VFD	T	12 AWG
Ground bar	GND	VFD	GND	Chassis ground

(Do not connect S for single-phase unless your VFD manual explicitly instructs it.)

1.3 Main disconnect → power supplies

From	Terminal	To	Terminal	Notes
Disconnect L1	—	Stepper PSU	L	14 AWG
Disconnect L2	—	Stepper PSU	N	14 AWG
Disconnect L1	—	Control PSU	L	16 AWG
Disconnect L2	—	Control PSU	N	16 AWG
Ground bar	GND	All PSUs	GND	Bond frames

2. Stepper DC power

2.1 Stepper PSU → DC distribution

From	Terminal	To	Terminal	Notes
Stepper PSU	V+	DC terminal block	+	10 AWG
Stepper PSU	V-	DC terminal block	-	10 AWG

2.2 DC distribution → DMA860S (repeat for each driver)

From	Terminal	To	Terminal	Notes
DC block +	+	DMA860S	V+	14 AWG
DC block -	-	DMA860S	V-	14 AWG
Ground bar	GND	DMA860S	GND	Frame ground

3. DMA860S → stepper motors

(Repeat per motor)

Driver terminal	Motor lead	Notes
A+	Phase A+	Twisted pair
A-	Phase A-	
B+	Phase B+	Twisted pair
B-	Phase B-	
Shield drain	—	To ground bar only

4. DDCSV4.1 → DMA860S (motion signals)

Axis assignment

- X → X-Left motor
- A → X-Right motor

- Y → Y motor
- Z → Z motor

4.1 Step / Direction / Enable (per axis)

DDCSV terminal	To driver	Driver terminal	Notes
XPUL+	X driver	PUL+	Shielded
XPUL-	X driver	PUL-	
XDIR+	X driver	DIR+	
XDIR-	X driver	DIR-	
XENA+	X driver	ENA+	Optional but recommended
XENA-	X driver	ENA-	

(Repeat the same mapping for A, Y, Z using APUL, YPUL, ZPUL, etc.)

5. DDCSV4.1 power (logic)

From	Terminal	To	Terminal	Notes
Control PSU +24 V	+	DDCSV	+24 V	18 AWG
Control PSU 0 V	-	DDCSV	GND	Common reference

6. Limit and home switches

(Recommended: normally closed switches)

6.1 Home switches

Switch	From	To	Notes
X-Left home	DDCSV X-HOME	Switch → GND	Independent
X-Right home	DDCSV A-HOME	Switch → GND	Enables squaring
Y home	DDCSV Y-HOME	Switch → GND	
Z home	DDCSV Z-HOME	Switch → GND	

6.2 Limit switches (if separate)

Axis	From	To	Notes
X limits	DDCSV X-LIMIT	Switch chain → GND	Series NC
Y limits	DDCSV Y-LIMIT	Switch chain → GND	
Z limits	DDCSV Z-LIMIT	Switch chain → GND	

7. E-stop wiring

7.1 E-stop logic input

From	Terminal	To	Terminal	Notes
DDCSV	E-STOP IN	E-stop NC contact	—	24 V logic
E-stop	—	DDCSV GND	—	Controller awareness

7.2 E-stop power interruption

Circuit interrupted	Method	Notes
Stepper PSU AC	Contactor or relay	Motion stops
VFD Run	Relay opens FOR	Spindle stops

(Do not rely on software stop alone.)

8. DDCSV4.1 → Huanyang VFD (control)

8.1 Run / Stop

From	Terminal	To	Terminal	Notes
DDCSV relay COM	—	VFD	DCM	Digital common
DDCSV relay NO	—	VFD	FOR	Run forward

8.2 Speed control (0–10 V)

From	Terminal	To	Terminal	Notes
DDCSV analog out	0–10 V	VFD	AVI	Shielded pair
DDCSV analog GND	GND	VFD	ACM	Shared analog ref

9. VFD → spindle

From	Terminal	To	Terminal	Notes
VFD	U	Spindle	Phase 1	14 AWG
VFD	V	Spindle	Phase 2	
VFD	W	Spindle	Phase 3	
Ground bar	GND	Spindle	GND	Bond body

10. Grounding summary

Item	To
Cabinet	Earth
VFD frame	Ground bar
PSU frames	Ground bar
Driver frames	Ground bar
Cable shields	Ground bar (cabinet end only)

DMA860S Tuning

Power & Control System – V1

Scope

This section covers:

- Output current settings for your 6 A NEMA 34 motors
- Microstep selection appropriate for machine mass and controller pulse rate
- Idle current reduction
- Direction, enable, and signal integrity notes
- A safe initial steps-per-unit baseline

Motor facts

- Motor type: NEMA 34
- Rated current: 6.0 A per phase
- Rated torque: 12 Nm
- Application: Large CNC router, dual-X gantry
- Controller: DDCSV4.1 (500 kHz capable)

1. Output current setting

Set the DMA860S **peak current to 6.0 A.**

Do not overshoot the motor rating. These motors already have ample torque, and excess current only adds heat.

Typical DMA860S current table mapping

DMA860S labels vary slightly, but most follow this pattern.

Peak current (A)	Switch setting
5.6 A	Near but under rated
6.0 A	Recommended
6.8 A	Not recommended
7.2 A	Do not use

If the driver only offers 5.6 A and 6.8 A options, choose **5.6 A** for initial testing. You can increase later after thermal checks.

Thermal check rule

After 20 to 30 minutes of holding torque:

- Driver case should be warm, not hot
- Motor case should be touchable for several seconds

If either is too hot to touch, reduce current one step.

2. Idle current reduction

Enable idle current reduction at **50 percent**.

This reduces heat when the axis is stationary without sacrificing holding accuracy during motion.

If the DMA860S offers multiple idle options:

- Choose 50 percent or equivalent
- Avoid aggressive reductions below 30 percent on Z

3. Microstep selection

Design goals

- Smooth motion
- Reasonable top speed
- No unnecessary pulse load on the controller
- Identical behavior on X and A axes

Recommended starting microstep

10 microsteps per full step

This is a very common and well-balanced choice for large NEMA 34 systems.

Why not higher

- Above 10 to 16 microsteps, torque per microstep drops

- Mechanical stiffness dominates accuracy, not microstep count
- Higher microsteps increase pulse rate with no real gain

4. Steps per revolution and steps per unit

Motor basics

- Full steps per revolution: 200
- Microsteps: 10

Steps per motor revolution = $200 \times 10 = 2000$

Leadscrew or rack conversion

You will calculate steps per unit later based on:

- Ballscrew pitch or rack travel per revolution
- Gear reduction, if any

For now, lock **2000 steps per motor revolution** as the electrical constant.

5. Signal polarity and enable behavior

Direction signal

- Default direction polarity is acceptable
- Reverse direction in DDCSV if needed
- Do not swap motor phase wiring to fix direction unless necessary

Enable signal

- Use ENA on all axes
- Active-low enable is typical
- Confirm behavior by disabling the axis in DDCSV and verifying free rotation

6. Pulse timing considerations

The DMA860S is tolerant, but best practice is:

- Step pulse width: ≥ 5 microseconds
- Direction setup time: ≥ 5 microseconds before step

The DDCSV4.1 defaults are usually safe here. No special tuning required initially.

7. Axis-specific notes

X and A axes (dual gantry)

- Identical driver settings

- Identical microstep and current
- Mechanical squaring handled in homing, not in driver tuning

Y axis

- Same settings as X and A
- No special handling required

Z axis

- Same current and microstep initially
- If Z runs warmer, reduce idle current only, not peak

8. Initial verification checklist

Before commanding motion:

- All four drivers set identically
- DIP switches documented or photographed
- Motors rotate smoothly by hand when disabled
- No driver fault LEDs active

During first motion:

- Jog at low speed only
- Listen for harsh resonance or growling
- Confirm correct direction per axis
- Confirm X and A move together

DDCSV4.1 Axis and Dual-X Homing Configuration

Power & Control System – V1

1. Axis role definition

You have four motors and four driver channels.

Axis mapping (locked)

Physical axis	DDCSV axis	Notes
X-Left gantry motor	X	Master
X-Right gantry motor	A	Slaved to X
Y axis motor	Y	Independent
Z axis motor	Z	Independent

Do not attempt to electrically tie the two X motors together. Slaving is done in software.

2. Entering axis configuration mode

1. Power on the DDCSV4.1
2. From the main screen, enter:
 - **System Settings**
 - **Axis Settings**

All configuration below happens in this area.

3. Enable and assign axes

For each axis (X, A, Y, Z):

- Axis enabled: **Yes**
- Axis type: **Linear**
- Units: **mm** (recommended, even if you think in inches)

Confirm that **all four axes are enabled**.

4. Axis direction check (before homing)

This step prevents crashes.

For each axis:

1. Exit settings
2. Use jog mode at **very low speed**
3. Jog positive direction

If motion is reversed:

- Return to Axis Settings
- Invert direction for that axis
- Do not swap motor wires unless absolutely necessary

Repeat until:

- X jogs in expected machine +X
- A jogs in the same physical direction as X
- Y and Z jog correctly

5. Steps per unit configuration

This connects driver tuning to motion.

Electrical constant (from DMA860S tuning)

- Steps per motor revolution: **2000**

Enter preliminary values

In Axis Settings for X, A, Y, Z:

- Steps per unit: **TEMPORARY VALUE**
 - Use a safe placeholder such as **200 steps/mm**
 - Final calibration comes later

The critical rule here:

- **X and A must have identical steps-per-unit values**

6. Axis slaving configuration (dual-X)

Navigate to:

- **System Settings**
- **Axis Relation / Slave Settings**

Configure:

Master axis	Slave axis
X	A

Rules:

- Only A is slaved
- X remains the master
- Do not slave in reverse

Save settings.

7. Homing switch assignment

This is the heart of gantry squaring.

Required switches (already wired)

- X-Left home switch
- X-Right home switch
- Y home switch
- Z home switch

DDCSV home input mapping

In I/O Settings:

Axis	Home input
X	X-HOME
A	A-HOME
Y	Y-HOME
Z	Z-HOME

Each switch must be independent.

8. Homing direction and order

Navigate to:

- **Homing Settings**

Homing direction

Set per your machine geometry. Typical example:

Axis	Direction
Z	Positive
X	Negative
A	Negative
Y	Negative

Direction must move the axis **toward its home switch**.

Homing order (recommended)

Order	Axis	Reason
1	Z	Get tool out of the way
2	X and A	Gantry squaring
3	Y	Table reference

If the DDCSV allows grouping:

- Home X and A together
- Ensure they stop independently on their own switches

9. Dual-X squaring behavior

During homing:

1. X and A move toward home
2. One side hits its switch first and stops
3. The other side continues until its switch triggers
4. Gantry is squared mechanically
5. X and A zeroed together

This only works if:

- Switches are wired independently
- X and A are not electrically tied
- Slaving is configured correctly

10. Homing speed and backoff

Recommended initial values:

- Homing speed: **Slow**
- Backoff distance: **2 to 5 mm**
- Second approach (if available): **Enabled, slow**

This improves repeatability and reduces switch stress.

11. Soft limits (enable later)

For initial testing:

- Soft limits: **Disabled**

After calibration:

- Enable soft limits
- Set travel ranges per axis
- X and A must match exactly

12. First homing test procedure

Perform this sequence exactly:

1. Power on control PSU only
2. Enable DDCSV
3. Enable stepper PSU
4. Jog each axis slightly away from home
5. Press **Home All**

Observe:

- Z homes first

- X and A home together and square
- Y homes last
- No axis stalls or overshoots

If any axis moves the wrong way:

- Abort immediately
- Fix direction setting
- Retry

Steps-Per-Unit Calibration

Power & Control System – V1

1. Preconditions

Before calibrating, confirm:

- DDCSV4.1 axis and dual-X homing are working
- X and A home independently and square the gantry
- DMA860S drivers are set identically on X and A
- All axes jog smoothly at low speed
- No binding across full travel

Do not calibrate until the machine can home reliably.

2. What steps-per-unit actually is

Steps-per-unit expresses the relationship between:

- Electrical pulses from the controller
- Mechanical motion of the axis

The formula is:

```
Steps per unit =
( Motor steps per revolution × Microsteps × Gear ratio )
/ Linear travel per revolution
```

3. Electrical constants (locked)

- Motor full steps per revolution: 200
- Microsteps: 10
- Steps per motor revolution: 2000

These values apply to **all axes**, including X and A.

4. Mechanical inputs you must supply

You need one of the following per axis:

Ballscrew-driven axis

- Ballscrew pitch in mm per revolution Example: 10 mm per revolution

Rack-and-pinion axis

- Pinion circumference in mm Example: 20-tooth, module 1.5 gear

If an axis uses reduction:

- Include gear or belt ratio

Each axis can differ mechanically.

5. Initial calculation (example)

Example: 10 mm ballscrew

Steps per mm = 2000 / 10

Steps per mm = 200

Enter 200 as the initial value.

Example: rack-and-pinion

Pinion circumference = $\pi \times$ pitch diameter

Steps per mm = 2000 / circumference

Use this value only as a starting point.

6. Enter initial values in DDCSV4.1

1. Go to **System Settings**
2. Open **Axis Settings**
3. For each axis:
 - Enter the calculated steps-per-unit
 - Ensure X and A are identical
4. Save settings

Do not attempt fine tuning yet.

7. Measurement setup

You need a reliable reference.

Recommended tools:

- Dial indicator with magnetic base or
- Steel rule with fine graduations

Measurement rules:

- Measure along the axis line of travel
- Do not measure diagonally
- Use at least **100 mm of travel** if possible

Longer moves reduce error.

8. Calibration move procedure

For each axis independently:

1. Home the machine
2. Zero the axis DRO
3. Command a move of a known distance Example: 100.000 mm
4. Measure actual movement

Record:

- Commanded distance
- Actual distance

9. Correction calculation

Use this exact formula:

```
New steps per unit =  
( Current steps per unit × Commanded distance )  
/ Actual distance
```

Example

- Current value: 200
- Commanded: 100.000 mm
- Actual: 99.600 mm

```
New value = (200 × 100.000) / 99.600  
New value ≈ 200.80
```

Enter the new value.

10. Apply and repeat

1. Enter corrected value
2. Save settings
3. Re-home
4. Repeat the same move
5. Re-measure

Stop when:

- Error is less than 0.05 mm over 100 mm
- Or better, depending on your goals

11. Dual-X axis rule

- Calibrate **X only**
- Copy the final X value to A
- Never calibrate A independently

If the gantry does not square:

- Fix homing switch alignment
- Do not alter steps-per-unit to compensate

12. Z-axis special notes

Z axes often have:

- Higher friction
- Gravity load

Calibrate Z with:

- Tool holder installed
- Normal operating load

If Z error differs up vs down:

- That is mechanical, not steps-per-unit
- Do not compensate electrically

13. Verify full-travel accuracy

After fine calibration:

1. Move the axis close to maximum travel
2. Measure cumulative error
3. Confirm no binding or missed steps

If error grows with distance:

- Check mechanical alignment
- Check couplings
- Check rack mounting

14. Lock the values

Once satisfied:

- Record final steps-per-unit values
- Store them as **Power & Control System – V1 calibration**
- Photograph or document DDCSV screens

These values should not change unless mechanics change.

15. What this completes

At this point, V1 has:

- Electrically correct motion
- Mechanically squared gantry
- Dimensionally accurate axes
- A known-good calibration baseline

Enable and Configure Soft Limits

Power & Control System – V1

Purpose

Soft limits prevent axis motion beyond the usable travel range. They are a software safety layer and must never replace hard limits or E-stop behavior.

Preconditions

- Machine homes reliably on all axes
- Steps-per-unit calibration is complete
- Dual-X homing and squaring are correct
- No binding across full axis travel

Procedure

1. Power on the system
2. Home all axes
3. Navigate to:
 - System Settings

- Axis Settings
- Soft Limits

Configure Travel Limits

For each axis, enter the usable travel range.

Example values only:

- X axis
 - Minimum: 0.0
 - Maximum: measured usable X travel
- Y axis
 - Minimum: 0.0
 - Maximum: measured usable Y travel
- Z axis
 - Minimum: safe lower limit
 - Maximum: safe upper limit

Rules:

- X and A must have identical limits
- Do not include crash margin in usable travel
- Leave mechanical margin at both ends

Enable Soft Limits

- Soft limits: Enabled
- Overtravel action: Stop motion
- Alarm or warning: Enabled if supported

Save settings.

Verification

1. Home the machine
2. Jog toward each soft limit at low speed
3. Confirm motion stops before mechanical end
4. Confirm no false triggering during normal motion

Notes

- Soft limits only function after homing
- Loss of position invalidates soft limits
- Mechanical changes require revalidation

Status

Soft limits enabled and validated for V1.

Configure Acceleration and Maximum Velocity

Power & Control System – V1

Purpose

Acceleration and velocity settings define machine performance and reliability. Overly aggressive values cause missed steps and mechanical stress.

Preconditions

- Steps-per-unit calibration complete
- Motors and drivers tuned
- No axis binding
- Machine fully assembled

Initial Conservative Settings

Use these as safe starting points.

Velocity

- X axis: Low to moderate
- A axis: Same as X
- Y axis: Same as X
- Z axis: Significantly lower

Example approach:

- Start at 25 percent of expected maximum
- Increase incrementally

Acceleration

Acceleration has greater impact than top speed.

- X and A: Moderate
- Y: Moderate
- Z: Low

Start low. Increase only after stable testing.

Configuration Steps

1. Enter System Settings
2. Open Axis Settings
3. For each axis:
 - Set maximum velocity
 - Set acceleration
4. Save settings

Testing Procedure

1. Jog each axis at increasing speeds
2. Listen for harsh noise or stalling
3. Perform rapid direction reversals
4. Observe for missed steps

If any issue occurs:

- Reduce acceleration first
- Reduce velocity second

Locking Values

Once stable:

- Record final values
- Apply identical values to X and A
- Do not exceed tested limits

Status

Acceleration and velocity configured for V1.

Validate Spindle Speed Scaling

Power & Control System – V1

Purpose

Ensure commanded RPM matches actual spindle speed. This validates 0–10 V scaling between DDCSV and Huanyang VFD.

Preconditions

- VFD parameters set
- Spindle cooling operational

- Analog control enabled
- No cutting load applied

Test Setup

Tools:

- Optical tachometer or RPM probe
- Eye protection
- Clear spindle area

Validation Procedure

1. Power on VFD and controller
2. Command spindle on at low RPM
 - Example: S6000
3. Measure actual spindle speed
4. Record commanded vs actual RPM

Repeat at:

- 25 percent
- 50 percent
- 75 percent
- 100 percent of max RPM

Adjustment

If error exists:

- Adjust DDCSV spindle scaling
- Or adjust VFD analog gain
- Never adjust both simultaneously

Repeat measurement until error is acceptable.

Acceptance Criteria

- Linear response across range
- Error less than 2 percent preferred
- Smooth ramping without surging

Status

Spindle speed scaling validated for V1.

Dry-Run G-code Test

Power & Control System – V1

Purpose

Validate coordinated motion without cutting. This is the final logic and motion verification step.

Preconditions

- All axes calibrated
- Soft limits enabled
- Spindle control verified
- No tool installed

Test File Characteristics

The dry-run program should include:

- X, Y, and Z motion
- Direction reversals
- Rapid and feed moves
- Safe Z clearance

No spindle cutting load.

Execution Steps

1. Home the machine
2. Load dry-run G-code
3. Enable single-block mode if available
4. Run program at reduced feed override
5. Observe full execution

Observations to Make

- Axis coordination
- No unexpected pauses
- No limit alarms
- No loss of position
- Correct Z clearances

Failure Handling

If an issue occurs:

- Stop immediately
- Identify root cause
- Correct configuration
- Restart from homing

Status

Dry-run G-code test complete for V1.

Control Cabinet Physical Plan

Power & Control System – V1

Purpose

Define a clean, low-noise, serviceable cabinet layout. This plan prioritizes EMI control, airflow, and maintenance access.

Cabinet Zoning

Divide the cabinet into vertical zones.

Zone 1: High Voltage AC

- Main disconnect
- Circuit breakers
- EMI filter (if used)

Keep wiring short and isolated.

Zone 2: VFD Zone

- Huanyang VFD
- VFD line filter (optional)
- Spindle output exit point

Rules:

- Physical separation from logic
- Dedicated wire routing
- Shielded spindle cable exit

Zone 3: Power Conversion

- Stepper PSU
- Control PSU

- DC distribution terminals

Mount centrally for short DC runs.

Zone 4: Motion and Logic

- DDCSV4.1 controller
- DMA860S drivers
- Signal terminal blocks

Rules:

- DIN rail mounting
- Clear airflow
- Easy access for tuning

Zone 5: Grounding and I/O

- Ground bar
- Shield termination points
- Limit and sensor terminals

Single-point grounding only.

Airflow Plan

- Bottom or side intake
- Top or opposite-side exhaust
- Airflow across drivers and PSUs
- VFD heatsink unobstructed

Use filtered intake.

Serviceability Rules

- No wire crossing zones unnecessarily
- Label both ends of every cable
- Leave service loops
- Keep DIP switches accessible

Status

Cabinet physical plan drafted for V1.

Commissioning Checklist

Power & Control System – V1

This checklist defines when **V1 is complete and safe to operate**. All items should be verified in order. Do not skip steps.

Phase 0: Administrative and Baseline

- Power & Control System labeled as **V1**
- Wiring diagrams match actual build
- All PSU voltages labeled
- Cabinet ground bonded to earth
- Emergency stop physically accessible

Phase 1: Electrical Integrity

Grounding and bonding

- Single ground bar installed
- VFD chassis bonded
- PSU frames bonded
- Stepper driver frames bonded
- Spindle body bonded
- Cable shields terminated at cabinet end only

Power integrity

- Main disconnect interrupts all AC
- Stepper PSU AC feed fused
- Control PSU AC feed fused
- VFD on dedicated branch
- Control PSU stable at 24 VDC
- No unexpected heating under idle power

Phase 2: Controller and Logic

DDCSV4.1 basic operation

- Controller boots normally
- MPG recognized and functional
- Axis enable toggles correctly
- E-stop input recognized by controller

Axis mapping

- X motor responds to X jog
- A motor responds to A jog
- X and A jog in same physical direction
- Y jog correct direction

- Z jog correct direction

Phase 3: Homing and Squaring

- All home switches trigger reliably
- Z homes first
- X and A home independently
- Gantry squares during homing
- Y homes after gantry
- No switch overtravel or chatter

Phase 4: Motion Calibration

Driver configuration

- DMA860S current set correctly
- Microstep settings consistent across axes
- Idle current reduction enabled
- Drivers remain thermally stable

Steps-per-unit

- Initial calculated values entered
- X calibrated and copied to A
- Y calibrated
- Z calibrated under load
- Error less than target tolerance

Phase 5: Limits and Safety

- Soft limits enabled
- X and A soft limits identical
- Soft limits stop motion before mechanical ends
- Hard limits still functional
- E-stop cuts motion power
- E-stop stops spindle

Phase 6: Spindle Validation

- Cooling system operational
- VFD parameters verified
- Spindle runs from controller command
- 0–10 V scaling linear
- Commanded RPM matches measured RPM
- No abnormal noise or vibration

Phase 7: Dry-Run Validation

- Dry-run G-code loads correctly
- No limit alarms during run
- Axis coordination correct
- Z clearance maintained
- No lost steps
- No unexpected pauses or resets

Phase 8: V1 Acceptance

- Cabinet closed and ventilated
- All wiring labeled
- Configuration values recorded
- V1 declared complete

Status

Power & Control System – V1 commissioned.

Pre-Cut Checklist

Power & Control System – V1

This is the checklist you run **right before committing tool to material**.

Mechanical sanity

- Tool properly seated and tightened
- Workpiece clamped securely
- No loose hardware
- Axis travels clear of clamps

Control sanity

- Correct G-code file loaded
- Units verified
- Work offset set
- Z zero verified

Motion sanity

- Run path visually simulated
- Dry-run completed with tool raised
- Feed override available

- E-stop tested immediately before cut

Spindle sanity

- Correct RPM commanded
- Cooling running
- Spindle direction verified
- No abnormal noise

Final decision

- Operator alert and focused
- Hands clear
- One finger near feed hold
- One eye on the machine

Only then:

- Press Cycle Start