

Laser_Tests_02

September 2, 2017

1 CNC Laser Power Settings Test 2

1.1 Objective:

- Make more functions for testing.
- Figure out constant vs dynamic power results.
- Test between 10 & 25

2 Code:

```
In [2]: import GCode
import GRBL
```

```
In [3]: cnc = GRBL.GRBL(port="/dev/cnc_3018")

print("Laser Mode: {}".format(cnc.laser_mode))
```

Laser Mode: 1.0

```
In [4]: from enum import IntEnum
class Tool(IntEnum):
    SPINDLE = 0
    LASER = 1
```

```
In [5]: from enum import IntEnum
class LaserPower(IntEnum):
    CONSTANT = 0
    DYNAMIC = 1
```

```
In [6]: LaserPower.CONSTANT
```

```
Out[6]: <LaserPower.CONSTANT: 0>
```

```
In [7]: def init(power = LaserPower(0), feed = 200, laser = 25):
    program = GCode.GCode()
    program.G21() # Metric Units
    program.G91() # Absolute positioning.
```

```

        program.G1(F=feed) #
        if power==LaserPower.CONSTANT:
            program.M3(S=laser) # Laser settings
        else:
            program.M4(S=laser) # Laser settings
        return program

In [8]: def end():
        program = GCode.GCode()
        program.M5() # Laser settings.
        return program

In [8]: def square(size=20):
        program = GCode.GCode()
        program.G1(X=size)
        program.G1(Y=size)
        program.G1(X=-size)
        program.G1(Y=-size)
        return program



## 2.1 Test Setup



Position the paper & other things.

In [13]: cnc.cmd("M5") # Laser off

Out[13]: ['ok', 'ok']

In [12]: # Set minimal power setting to focus and position laser
        for i in range:
            cnc.cmd("M3 S255")
            cnc.cmd("G1 X0") # Laser On

Out[12]: ['ok', 'ok']

In [51]: def jogx(x=10):
        program = GCode.GCode()
        program.G0(X=x)
        cnc.run(program)
        def jogy(y=10):
            program = GCode.GCode()
            program.G0(Y=y)
            cnc.run(program)
        def jogz(z=10):
            program = GCode.GCode()
            program.G0(Z=z)
            cnc.run(program)

In [13]: def kill_cnc():
        # TODO:
        pass

```

```

In [14]: workspace = 220 # mm

In [15]: square_size = 10
         spacing = 5

In [16]: test_space = square_size + spacing

In [17]: test_space

Out[17]: 15

In [22]: tests = workspace / test_space
         tests

Out[22]: 14.666666666666666

In [25]: import numpy as np

In [26]: tests = np.floor(tests)
         tests

Out[26]: 14.0

14 tests.

In [61]: laser_pwms = np.linspace(10, 50, 14, dtype=np.uint8)
         laser_pwms

Out[61]: array([10, 13, 16, 19, 22, 25, 28, 31, 34, 37, 40, 43, 46, 50], dtype=uint8)

In [62]: laser_powers = [LaserPower.CONSTANT, LaserPower.DYNAMIC]

In [63]: jogx(-1*test_space)

In [60]: jogy(10)

In [59]: def init(power = LaserPower(0), feed = 200, laser = 25):
         program = GCode.GCode()
         program.G21() # Metric Units
         program.G91() # Absolute positioning.
         program.G1(F=feed) #
         if power==LaserPower.CONSTANT:
             program.M3(S=laser) # Laser settings
         else:
             program.M4(S=laser) # Laser settings
         return program

for laser_power in laser_powers:
    for laser_pwm in laser_pwms:
        print("Lasers Set To: {} {}".format(laser_power, laser_pwm))
        program = init(power=laser_power, laser=laser_pwm) + square(size=square_size) +

```

```

        print(".", end="")
        cnc.run(program)
        jogx(square_size)
        jogx(spacing)
        print("")
    jogx((-1*test_space)*tests)
    jogy(spacing)

```

Lasers Set To: 0 10

.

Lasers Set To: 0 13

.

Lasers Set To: 0 16

.

Lasers Set To: 0 19

.

Lasers Set To: 0 22

.

Lasers Set To: 0 25

.

Lasers Set To: 0 28

.

Lasers Set To: 0 31

.

Lasers Set To: 0 34

.

Lasers Set To: 0 37

.

Lasers Set To: 0 40

.

Lasers Set To: 0 43

.

Lasers Set To: 0 46

.

Lasers Set To: 0 50

.

Lasers Set To: 1 10

.

Lasers Set To: 1 13

.

KeyboardInterrupt

Traceback (most recent call last)

```

<ipython-input-59-334601ea897c> in <module>()
    16         print(".", end="")

```

```

17         cnc.run(program)
--> 18         jogx(square_size)
19         jogx(spacing)
20         print("")

<ipython-input-51-b27fb8b7e610> in jogx(x)
2     program = GCode.GCode()
3     program.G0(X=x)
----> 4     cnc.run(program)
5 def jogy(y=10):
6     program = GCode.GCode()

~/python_cnc3018/python_rs274/GRBL/__init__.py in run(self, program, compact)
117
118         while len(results) == 0:
--> 119             sleep(0.5)
120             results = self.read(multiline=True, timeout=0.1)
121

```

KeyboardInterrupt:

3 Experimental Setup.

Assembled Chinese CNC 3018. GRBL Version

```

In [66]: cnc.cmd("$ $")
Out[66]: ['ok', 'error:8']

In [67]: cnc.cmd("$ #")
Out[67]: ['ok', 'error:8']

In [68]: cnc.cmd("$ I")
Out[68]: ['ok', 'error:8']

In [69]: cnc.cmd("$ N")
Out[69]: ['ok', 'error:8']

```

4 Results

4.1 M3

- Laser needs to 'warm up' (?) on constant power mode

- Starts to smoke @ 22 on graphite.
- Starts showing up @ 25, 40 nearly completed a cut, but laser wasn't on whole cycle. 43+ all cut.
- 40 barely marked second paper.
- 1 Can not be seen.
- 10 Can not be seen.
- 50 Cut through 1 piece of paper & marked one under it.
- 100 cut through 2 pieces and light etch on clipboard.
- 150 Cut through 2 pieces and dark etch on clipboard.
- 255 & 1024 look identical. Etched 'well' into clipboard.

4.2 M4

- Very intermittent.
- 50 didn't cut all the way through. Almost no marking on second paper.

5 Test Conclusion.

- Need to wrap Keyboard Kill with a CNC Kill.
- Need more tests.