



University of Aalen



## Mechatronic Project - Electronic Lead Screw

January 2022 - Lukas Schwörer



# Preface

This project is part of the master's degree program "System engineering" of Aalen University and is scheduled to be performed during the first two semesters of the program. This report covers the work realized from April 2021 to February 2022.

The practical work and the writing for this project was performed from home due to the Covid-19 Pandemic.

Dieses Projekt ist Teil des Masterstudiengangs "System Engineering" der Hochschule Aalen und muss während der ersten beiden Semester absolviert werden. Die in diesem Bericht beschriebene praktische Arbeit wurde von April 2021 bis zum Februar 2022 realisiert.

Die praktische Arbeit, wie auch das Schreiben des Berichts wurde Zuhause ausgeführt aufgrund der Covid-19 Pandemie.

# **Abstract**

This Project is about the development, setup, testing and qualification of an Electronic Lead screw (ELS). This project was proposed to the university by myself because of the limited possibilities of practical projects due to the Covid-19 pandemic. Its aim is to develop a system to replace the gearbox inside a conventional lathe, which will synchronize the rotation of the Lead screw to the rotation of the main spindle. The ELS need to be able to keep up with the spindle rotation during conventional turning with different feeds and speeds. In addition to this, it should be possible to cut precise metric and imperial threads.

The electromechanical system of the ELS is build around an encoder to read the rotational position of the main spindle and a servo motor to control the position of the Lead screw. A microcontroller computes the information gathered by the encoder and commands the servo-motor to the correct positions.

To be able to easily change and add features as well as to predict the behavior of the system, the development of the ELS needs to be model based. This model needs to incorporate all aspects of the system including the spindle, the encoder, the microcontroller and the servo motor. As comparison, the conventional gearbox should also be modeled.

# **Kurzfassung**

Dieses Projekt beschäftigt sich mit der Entwicklung, dem Aufbau, dem Testen und Qualifizieren einer Elektronischen Leitspindel (ELS). Dieses Projekt wurde der Universität von mir vorgeschlagen, da es aufgrund der Covid-19 Pandemie nur begrenzt möglich war praktische Projekte durchzuführen. Sein Ziel ist es ein System zu entwickeln, dass das Getriebe in einer konventionellen Drehbank ersetzt und die Rotation der Leitspindel zu der Rotation der Hauptspindel synchronisiert. Die ELS muss fähig sein, mit der Rotation der Hauptspindel mitzuhalten während einer konventionellen Drehbearbeitung mit unterschiedlichen Drehzahlen und Vorschüben. Zusätzlich muss es möglich sein, präzise metrische und imperische Gewinde herzustellen.

Das elektromechanische System der ELS besteht aus einem Encoder, der die Position der Hauptspindel ausliest und einem Servomotor, der die Position der Leitspindel kontrolliert. Ein Mikrocontroller verarbeitet die vom Encoder gesammelten Informationen und bestimmt die korrekte Position des Servomotors.

Um ein einfaches Ändern und Entfernen von Features zu ermöglichen und das Verhalten des Systems vorherzusagen, muss die Entwicklung der ELS Modellbasiert durchgeführt werden. Dieses Modell muss alle Komponenten des reellen Systems beinhalten, eingeschlossen der Spindel, des Encoders, dem Mikrocontroller und dem Servomotor. Zum Vergleich sollte auch ein System mit einem konventionellen Getriebe modelliert werden.

# Acknowledgement

At this point I would like to thank the following people who made this project possible:

- **Prof. Dr. Markus Glaser** For supervising and supporting my project.
- **James Clough (Clough42)** For helping me to find hardware matching my specifications and supplying me with the great documentation about his own ELS project.

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# **1. Introduction**

This chapter will highlight the working environment, the project background as well as its aim.

## **1.1. Working environment**

### **1.1.1. University of Aalen**

The university of Aalen was founded in 1962 and by now is one of the leading university's of applied sciences in Germany. It has a focus in technical and economic research and has approximately 6000 students. The University is located in Aalen, a smaller city in the south of Germany. The University has ongoing cooperations with many companies in the region such as Zeiss, Mapal and Trumpf. Further, Aalen University has international cooperations with 136 other Universities.[1]

### **1.1.2. Workshop**

The practical part of this project was carried out in my home workshop. The workshop has tools for basic metal work, wood work, a 3D-Printing as well as some tools for the development of electronics. Further, equipment for welding, conventional milling and turning is available.

## **1.2. Project background**

The mechatronic project is fixed part of the masters program "System Engineering" at Aalen University. It is supposed to cover both practical and theoretical work for solving a mechatronic problem.

In the theoretical part of the project, the problem needs to be split in smaller individual issues. In the next step, solutions for each of the issues need to be found by thoroughly analyzing the requirements of the projects.

In the practical part of the project, the previously discovered issues and the solutions for it are supposed to be translated and tested to their functionality in practice.

This development process can be summarized in the so called V-Modell. The V-Modell is shown in 1.1.

The motivation and idea of this project were founded by my interest in metal work as well as online sources about similar projects.[2]

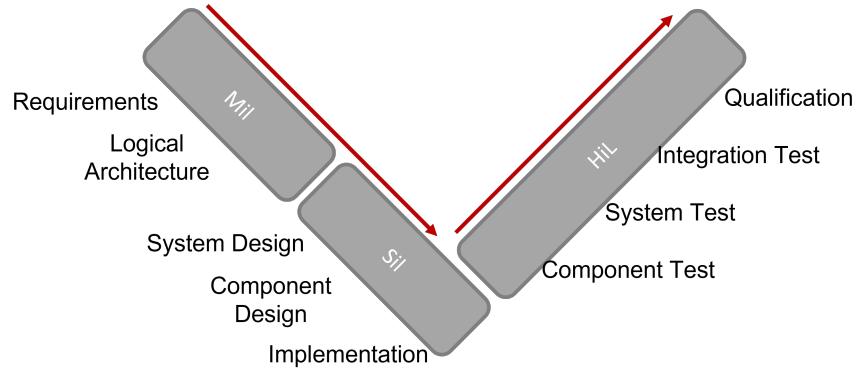


Figure 1.1.: V-Model

### 1.2.1. Aim of study

The aim of this project is to add the Electronic Lead screw system to the Lathe so that this modification is reversible. This is important in order to remain the value of the mechanics of the lathe. Further, the ELS system is supposed to be an addition that speeds up and simplifies the manual operation of the lathe. For this reason, it is not planned to add servos to the other axis of the lathe in the future.

## 2. Theoretical Background

This chapter will discuss the theoretical background knowledge that was part of the decision-making during the development process.

### 2.1. Numerical Mathematics

The science of the numerical mathematics is a branch of mathematics that concentrates on the research of solving continuous problems with discrete systems, such as a computer. One of the main issues in numerical mathematics is the representation of fractional numbers. This is because computers can only represent a finite subset of decimals, due to memory and processing limitations. This can lead to rounding errors that can have a significant impact on the precision of any calculation with fractional numbers. Further, calculations with numbers that have a large amount of decimal places, require more calculation steps by the processor and therefore slow down the computation.[3]

#### 2.1.1. Floating-Point Arithmetic

One way to represent fractional number is the floating point number system. With this system are stored in memory in two parts: the significant and its base. The significant represents the number as an integer, without the decimal point. The base ( $10^x$ ) describes the position of the decimal point in the original number.[3]

#### 2.1.2. Fixed-Point Arithmetic

The fixed point representation of numbers on a numerical system, defines the fractional number with a fixed amount of rational numbers. Further, the amount of significant numbers and decimal places is fixed. The intention behind this number representation is to simplify and therefore speed up numerical calculations.[3]

### 2.2. Manufacturing Methods

Nowadays, engineers have a broad spectrum of different manufacturing methods available when it comes to producing a part. The decision which to choose should incorporate component specific properties such as the desired amount to be produced, the general shape and material of the part, as well as the environment the part will be used in.

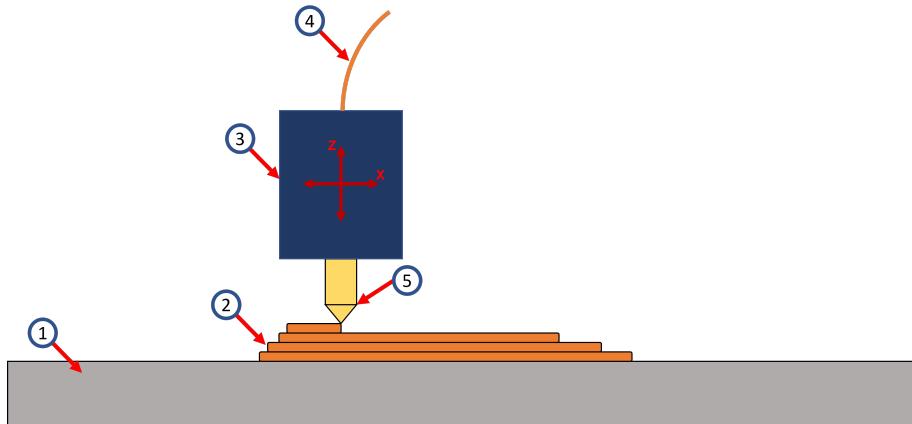


Figure 2.1.: 2D Drawing of the 3D-Printing Process; 1 - Print bed, 2 - Plastic layers, 3 - Print head, 4 - Plastic filament, 5 - Nozzle

### 2.2.1. Additive Manufacturing

Additive manufacturing (AM) is a process, where material is build up in order to create the desired shape. AM has first appeared in 1981, with the first commercial available machine in 1988. Additive manufacturing incorporates a wide variety of different manufacturing methods. The most well know Additive manufacturing method today probably is Fused Deposition Modeling (FDM), also known as 3D-Printing. With FDM, a thin thermoplastic filament is molten in a "Print head" and then squeezed through a nozzle. The molten plastic is then laid down in layers onto a print bed, in order to create a 3D shape. This process is shown in Figure 2.1. The core advantages of FDM are its speed and flexibility. This makes prototyping and small production batches very cost-effective and easy. Further, because 3D-Printing is a layer by layer process, almost any shape can be created, this is especially important for shapes with undercuts and included geometry's.[4]

### 2.2.2. Subtractive Manufacturing

Subtractive manufacturing is a process, where material is removed from a stock material in order to create a 2D or 3D shape. Two of the most common subtractive manufacturing processes are turning and milling.

Turning is a process where the stock material is rotated in a lathe and cut with a non-rotating tool. The tool itself only moves in X and Z direction. This process is shown in Figure 2.2. For this reason, turning is especially well suited for the production of round parts.

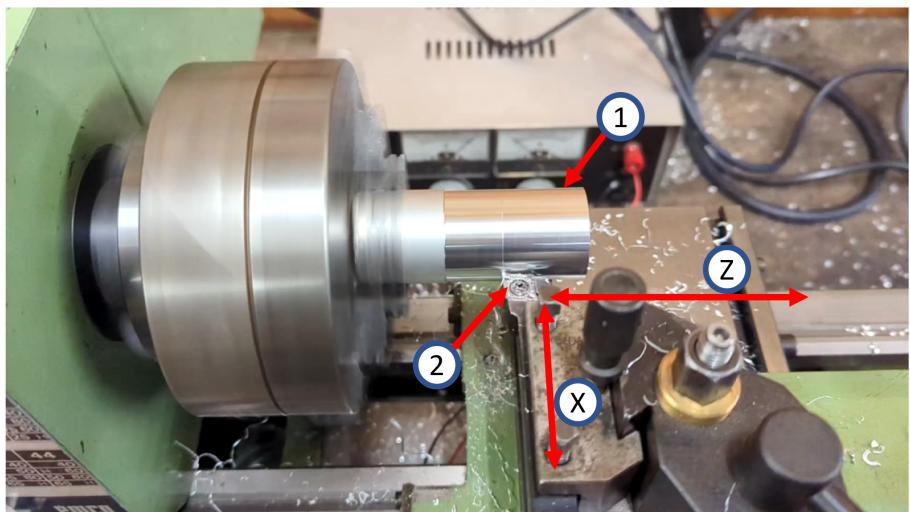


Figure 2.2.: Picture of a turning process; 1 - Rotating work piece, 2 - Cutting tool, X - X Axis, Z - Z axis

# **3. Hardware and Software**

This chapter will give an in-depth look into the hardware and software used to complete the project. This knowledge is necessary to understand the design decisions made.

## **3.1. Hardware**

### **3.1.1. Rotary Encoder**

A rotary encoder is an electromechanical transducer to convert a rotary movement into an electrical signal. One of the most commonly used rotary encoders is the optical rotary encoder. Its working principle is based on a Light emitting diode and a photo sensitive device, such as a photo-transistor or photo-resistor. The diode and the photo-sensitive device are located on opposite sides of a light blocking disk. This is illustrated in Figure 3.1.

The light blocking disk is perforated with small slits in a rotational symmetric and regular pattern. As soon as the disc is rotated between the diode and the photo-sensitive device, the light is transmitted and blocked in an alternating pattern. This creates a square wave on the output of the photo-sensitive device, which frequency is dependent on the rotational speed of the disk.[5]

### **3.1.2. Stepper Motors**

A stepper motor is an electrical, synchronous motor. Its rotor follows the magnetic field created in the stator exactly. In contrast to commonly known DC or AC motors, a stepper motor has a minimum angle that it needs to be rotated. This has the big advantage, that the position is always a multiple of this angle, the so-called step angle. Therefor, a sensor is not necessary to rotate the motor by a very precise amount. A stepper motor is a cheap alternative to closed loop controlled motors. Here, an additional sensor has to determine the positional error of the motor in order to move the motor precisely.

The disadvantage of stepper motors usually is their low rpm limit. At a certain speed, the rotor of the motor is no longer able to follow the magnetic field created by the stator. This can also happen when the motor is under high load. When this happens, the motor will skip steps. Therefore, stepper motors are often combined with rotational sensors in order to detect skipped steps and compensate for it.[6]

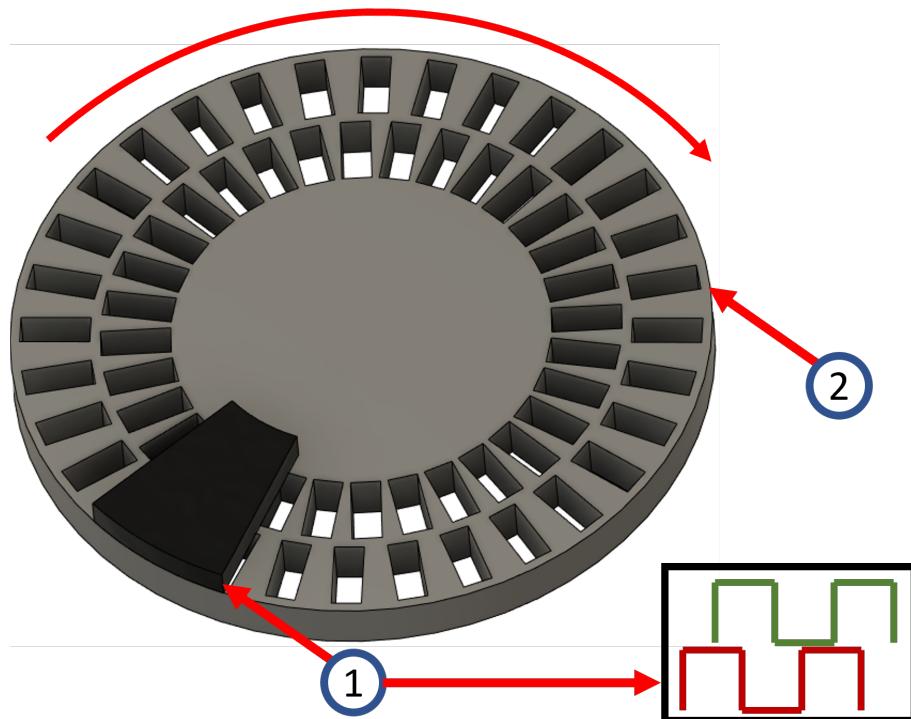


Figure 3.1.: Illustration of an optical encoder; 1 - Detector unit and detector unit signal, 2 - Encoder disk

### 3.1.3. Closed Loop Servos

Closed Loop Servos are an electromechanical actuator with a continuous feedback loop between its output (speed, torque, position, etc...) and input (Voltage, Current). Servos require additional electronics to compute the difference between its desired output and its current state. These electronics are typically referred to as "controller" or "driver". Servos are used in a wide variety of mechatronic applications when high precision, reliability or dynamics are required.[7]

### 3.1.4. Microcontroller

A microcontroller is an integrated circuit designed to serve a specific task in a system. Microcontroller consist of a processing unit, memory as well as In- and outputs. Within a system, a microcontroller can be used for a wide variety of tasks such as communication, data acquisition or actuator control. For mechatronic tasks, microcontrollers are commonly used as a so called embedded system. An embedded system is designed around a microcontroller and a specific task within a project.[8]

#### TI LaunchXL F280049C

The Texas Instruments Launchpad F280049C is a prototyping board designed around the Texas Instruments Picolo F280049C Real-Time microcontroller as an embedded system. Its design specifically targets highly dynamic control tasks while maintaining a

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low unit cost. The Picolo F280049C is a 32bit floating point microcontroller with 256 KB Flash memory, 100 KB RAM and an operation frequency of 100MHz. Further, the microcontroller has hardware support for up to two rotary encoders, a wide variety of communication protocol's as well as general purpose I/O. In addition, the LaunchPad development board build around the microcontroller offers a debugging probe. This probe can be used to flash the microcontroller with software or observe and direct the operation of the microcontroller. This way, it is for example possible to stop the execution of the program on the microcontroller to access and change the value of every bit in every register of the microcontroller.[9]

### **Logic Level Shifter**

A logic level shifter is an electronic circuit designed to convert one logic voltage level into another one, while maintaining the signal integrity. In modern mechatronic systems, it is often necessary that different electronic systems can communicate with each other. In some cases, however, it is not possible that all components work on the same voltage level. This makes it inevitable to use a logic level shifting circuit.[10]

#### **3.1.5. Raspberry Pi**

A Raspberry Pi is a Single board computer that features a full graphic operating system based on Linux. Further, it offers wireless connectivity as well as general purpose I/O's. The Raspberry Pi is mostly open source and very cost-effective. Because it has a very wide customer base, the Raspberry Pi has a wide variety of hardware and software add-ons available.[11]

## **3.2. Software**

### **3.2.1. Matlab and Matlab-Simulink**

MATrix LABoratory (MATLAB) is an Integrated Development Environment (IDE) and programming language. MATLAB was developed in the need of a numerical algebraic system at the university of New Mexico. On this base, the company MathWorks (see A) was created. Since 1984 MathWorks is further developing MATLAB and additional software for numerical algebraic computing. To support different hardware packages MathWorks offers so-called toolboxes. These toolboxes contain functions and scripts for communication, data acquisition, motion control etc. MATLAB is mainly used in technical development and research.[12]

### **3.2.2. Programming Language C**

C is a high level programming language. It is most commonly used to write applications for embedded systems. It is chosen over low level programming languages such as Assembly because of the increasing complexity of programs for embedded systems. C is

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a compiled programming language. This means that a program needs to be translated (compiled) to machine code before it can be executed. This translation is done with a program called "compiler". Compared to lower level languages such as Assembly, the code reusability of C has proven to be a step forward in the development of embedded systems.[13]

### **3.2.3. Programming Language Python**

Python is a high level object-oriented programming language. In contrast to C, Python is an interpreted language. This means, an Interpreter translates source code into machine commands in real time, while the program is executed. Python features a good combination of capability and ease of uses. This makes the language easy to learn for beginners while remaining very powerful. Python further features a huge variety of proprietary and community build support packages and is based on the one of the most used programming languages used today.[14]

#### **Kivy**

Kivy is an open source Python library for the rapid development of graphical user interfaces and apps. It is script based and its scripting language can be directly implemented in Python. Further, Kivy supports use with touch screens. During this project, Kivy was used in order to develop the software for the Human Machine Interface.[15]

### **3.2.4. Code Composer Studio**

Code Composer Studio is an Integrated Development Environment produced by Texas Instruments. It presents an interface to the Hardware produced by Texas Instruments and offers optimizing compilers for C and C++. Further, Code Composer Studio features support packages for the development and deployment of software to Texas Instruments Hardware, such as the TI LaunchXL F280049C. These support packages, in combination with a hardware debugging probe, enable the programmer to interact with the processor in real time.[16]

### **3.2.5. Git**

Git is a software tool for source code management and versioning, as well as for parallel development. Git was developed by Linus Torvald in 2005. Git was developed in the need of source code management software for the development of the operating system Linux. Git allows development in so-called branches. These are independent copies of an already existing and probably used software. This ensures that modifications or enhancements are not affecting already used software. If a feature is finished, it can be merged back into the higher-level branch. Merging is the process of bringing two files, directories or branches together. Different developers, working on different

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features of the same project, is called parallel development. Further, Git is a tool for software versioning. Software versioning is a tracking of changes in a project. In case of a mistake, the project can be recovered to every tracked point.

During this project, Git was very heavily used for software versioning as well as backup tool. This way, it was possible to revert changes to the software with very little work.

# 4. Experimental

This chapter will show the complete development process of the Electronic Lead screw and how it was executed based on the V-Modell.

## 4.1. Requirements and Logical Architecture

In this section, the development process in the first part of the V-Modell will be described. As shown in figure 4.1 this part is split into two sections. The requirements describe the fundamental properties of the system in order to function. The system Logical Architecture describes how the different system components are supposed to interact with each other.

### 4.1.1. Requirements

The development of the System requirements was the first step in the development process. This first step is one of the most important steps in the development process, because it defines the functions and properties of all System components. A selection of the requirements for the Human Machine Interface (HMI), the microcontroller ( $\mu$ C), the motor and the motor controller are shown in Table 4.1. The full list of requirements can be found in Appendix B.

### 4.1.2. Logical Architecture

The next step in the development process of the ELS was to create the Logical Architecture of the System. This was done as a Top level block diagram as shown in Figure 4.2.

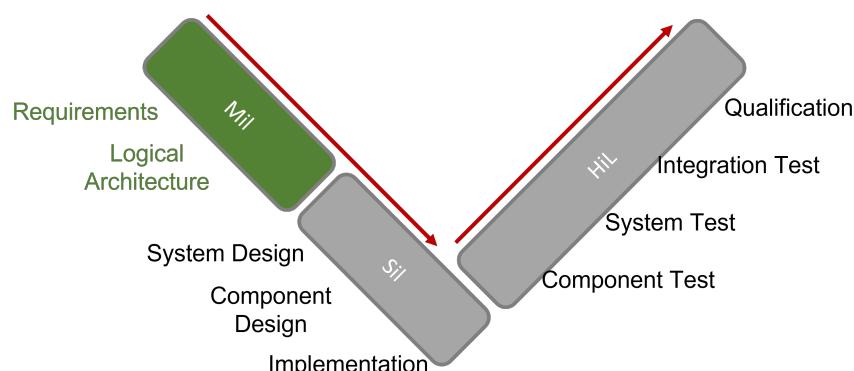


Figure 4.1.: V Model Requirements Stage; Green - Development status

Req. Nr.	HMI	$\mu$ C	Motor	Motor Controller
1	Touch	Real Time	Max. Torque	Closed Loop
2	Modular	Matlab Code Gen.	Min. Torque	Supply Voltage
3	UART Com.	UART Com.	Max. Speed	Programmable
4	Separate PS	Quad. Encoder	Min. Speed	Resolution
5	Mount	GPIO	Space Claim	Communication

Table 4.1.: Selection of Key Requirements for the ELS

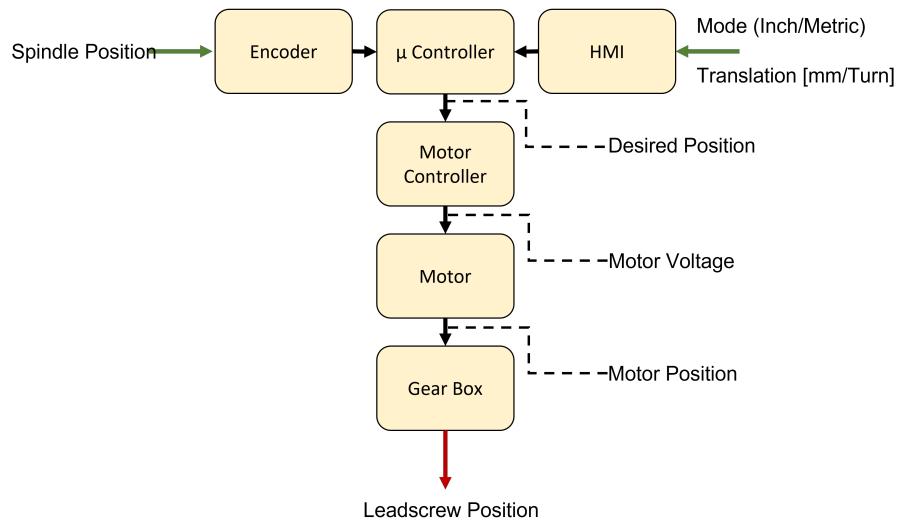


Figure 4.2.: Logical Architecture

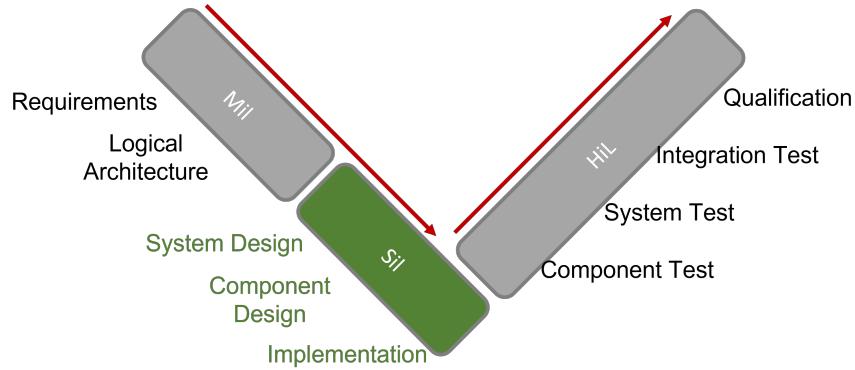


Figure 4.3.: V Model SIL Stage; green - Developement steps SIL stage

## 4.2. System Design and Implementation

This section describes the second half of the development process, divided into system and component design, as well as the integration of the components. This is the most time-consuming process of the development. For the system and component design, every function of each system and subsystem must be specified in detail. During the implementation phase, these functions are then transferred into the real system. This development stage is represented by the Software in the Loop (SIL) stage and is shown in Figure 4.3.

### 4.2.1. System Design

The system design is executed based on the previously developed system requirements and its logical architecture. The system design was approached by filling the requirements list as well as the block diagram of the logical architecture with component specific parameters. These parameters either need to be defined or found during the system design process.

A good example for this process is the required torque of the Lead screw servo during a cutting process. This parameter can be found by measuring the power consumption of the AC motor for different cutting parameters with the old Lead screw drive train. However, while disassembling the original Lead screw drive train in order to find a good place to mount the servo motor, an easier way to determine the required motor torque was found. In order to protect the Lead screw, the manufacturer secured the gear, that is, driving the Lead screw with a brass pin (see Figure 4.4). According to the manufacturer, this pin will shear off when more than 1.2Nm is acting on the Lead screw. After this, all other parameters were determined similarly. The resulting logical structure is shown in Figure 4.5.

### 4.2.2. Component Design

During the component design phase, the function of each component is developed based on the previous development steps. However, the components are not yet put together

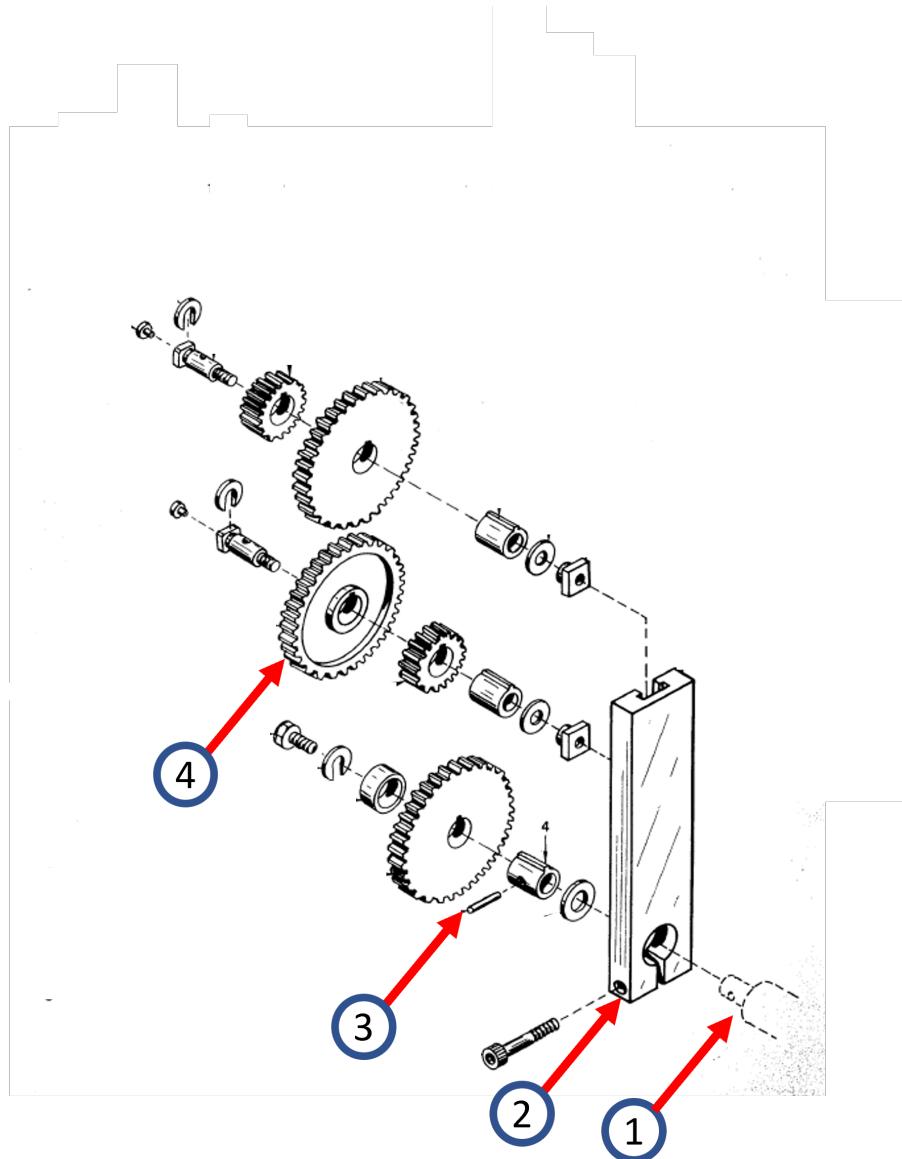


Figure 4.4.: Exploded view of the old drive train; 1 - Lead Screw, 2 - Gear Holder, 3 - Security Pin, 4 - Change Gears

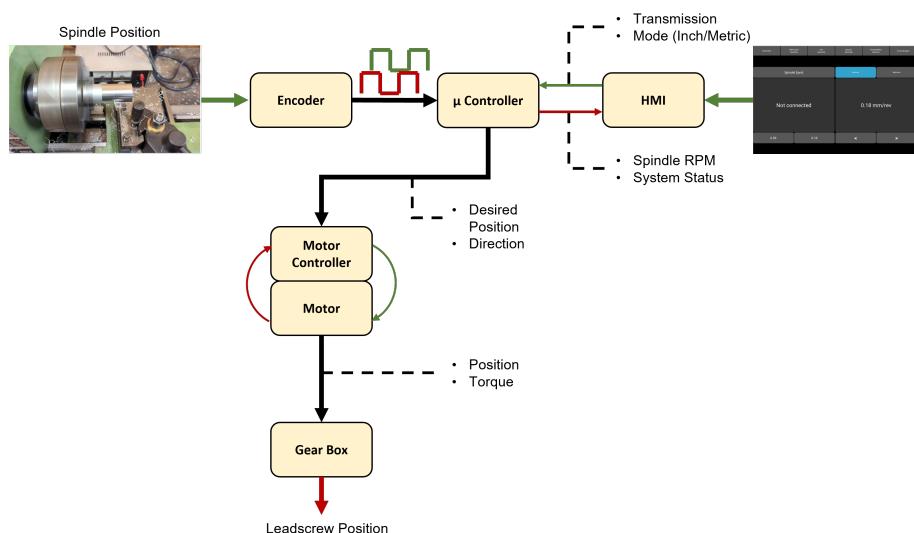


Figure 4.5.: Block diagram of the system design

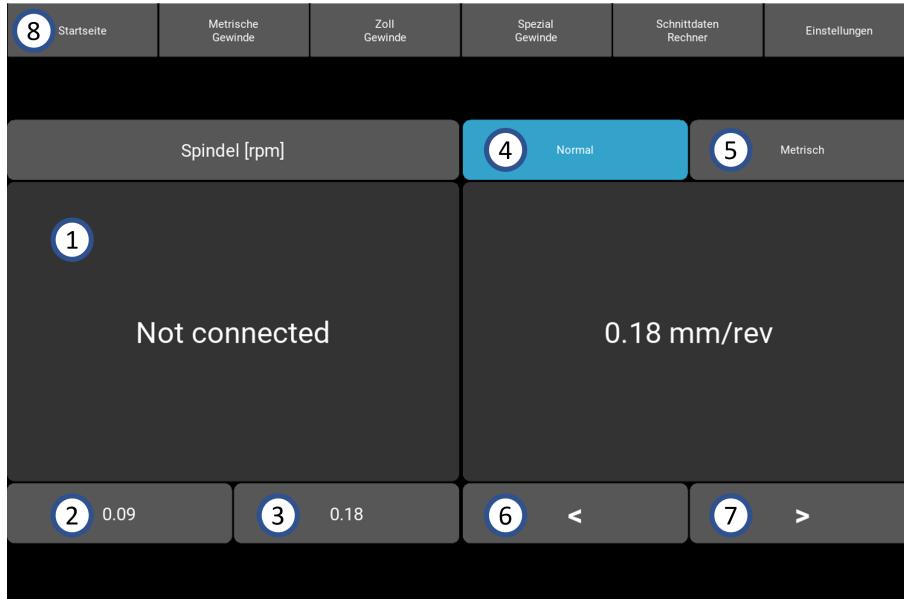


Figure 4.6.: Picture of the main HMI screen; 1 - Main spindle rpm display, 2+3 - Shortcuts to most common feed rates, 4+5 - Mode selection, 6 - Step back, 7 - Step forward, 8 - Submenus

as a system.

## HMI

Because the HMI was required to be as modular as possible, a Raspberry Pi 4 was chosen as the main component. It was combined with a 7" capacitive Touchscreen that can be bought as an accessory for the Raspberry Pi.

The software for the HMI was developed a main screen that shows the current RPM of the main spindle as well as the currently selected feed. Further, the main screen incorporates buttons to change the current feed rate or mode. The mode dictates how the ELS is working. Three options are available:

- **Normal Mode** Mode for normal turning. The feed rate (mm/revolution) is selectable in 0.01 mm/rev increments.
- **Metric Mode** Mode for metric thread cutting. The step buttons allow to step through a list of predefined thread pitches.
- **Imperial Mode** Mode for imperial thread cutting. The step buttons allow to step through a list of predefined thread pitches (threads/inch).

Further, the HMI offers submenus for all available thread pitches and various other functions. The main screen of the HMI is shown in Figure 4.6.

## Micro Controller

The first step of the design of the microcontroller was its selection. This was done based on the requirements and the work of James Clough. As a result, the microcontroller

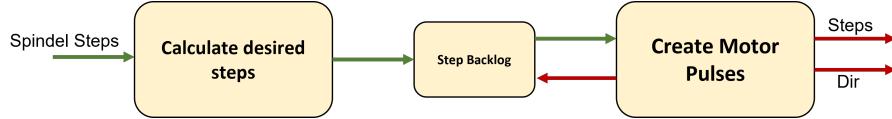


Figure 4.7.: Block diagram of the functional software on the TI Launchpad

platform TI LaunchXL F280049C was selected. Because of the Matlab support and the hardware ports for encoder, this was a perfect match for this project.

The software for the Texas Instruments microcontroller was developed in two parts. First, a detailed block diagram of the intended function of the software was created. This was done to keep the structure of the software as simple as possible. As shown in Figure 4.7, the functional software, running on the microcontroller, is build around two main functions. The first function calculates the number of desired steps based on the steps generated by the encoder on the main spindle. The second function generates the motor control signals. These are represented by a logical signal for the intended motor direction and a logical puls with a width of  $1\mu s$  and a duty cycle of 50%. These actions need to be performed in real-time. This means that those functions need to be executed cyclic within a certain time limit, the so-called "real time requirement". In the case of the ELS, the real time requirement is the  $1\mu s$  pulse length that is needed for the motor signal. However, this time frame is so short that the microcontroller could not execute both functions within the given real-time requirement. For this reason, two real time loops were created, one with a 100ms cycle time to calculate the Desired Steps, the other with a  $1\mu s$  cycle time to generate the motor pulses. These functions work with a shared memory, the "step backlog". Every time the calculation of the desired steps is done, the steps in the backlog are incremented. Whenever the pulse function is finished with one pulse, the step backlog is decremented.

In the second part of the software development the previously discussed steps were translated into a Matlab-Simulink Model. This had two big advantages: First, in addition to the software model, it is possible to model the complete electromechanical system of the ELS. This is very helpful while testing and debugging the developed code. Second, it is possible to generate C code for the Texas Instruments microcontroller directly from the Simulink model. This function code is then guaranteed to work in the exact same way it did in the model environment inside of Simulink when implemented correctly. In Figure 4.8 the complete Simulink Model is shown.

## Encoder

The design or in this case selection of the encoder was purely based on the previously defined requirements. The most significant requirements are shown in Table 4.2.

This led to the selection of an Encoder from the manufacturer Opkon (see Appendix A). The Encoder creates 4096 pulses/revolution, with half of them phase shifted by  $90^\circ$  in order to determine the turning direction. Further, the encoder covers an input voltage

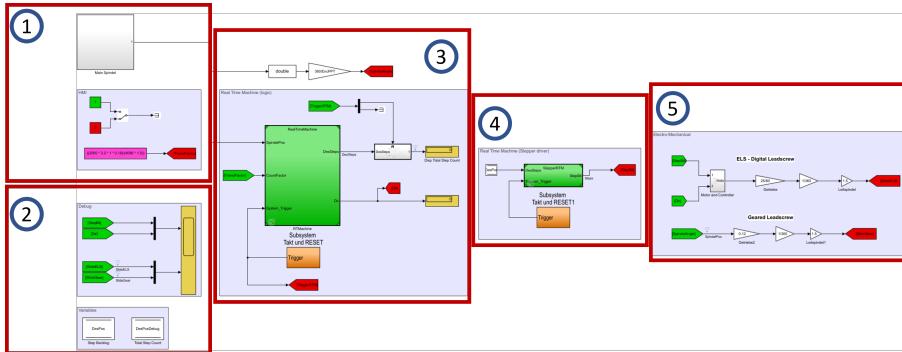


Figure 4.8.: Picture of the created Simulink Model; 1 - Model of the Spindle and the Encoder, 2 - Outputs of the Model, 3 - Model of the function calculating the desired Steps, 4 - Model of the function generating the motor pulses, 5 - Model of the Leadscrew with ELS and with the original drive train

Req. Nr.	Requirement	Value
1	Physical Size	60 mm
2	Supply Voltage	5V
3	Resolution	4096 ppt
4	Directional	Yes

Table 4.2.: Selection of Key Requirements for the ELS

range from 5V - 30V, which is compatible with the Encoder Pins on the Launchpad XL. With a high of 57 mm, the Encoder just fits into the previously determined specifications.

### **Motor and Motor Controller**

The motor was selected based on the requirements list as well as recommendations from James Clough [2]. The selected motor is from the company Steppers Online (see Appendix A). It is a so-called "integrated servo motor". This means, the motor consist of a brushless DC-motor, an encoder as well as the corresponding motor controller. All three of these parts are packaged into one unit as shown in Figure 4.9.

The motor features an RPM range from 0 to 4000 rpm and a very constant maximum torque of 0.4 nm. Further, it has the right dimensions in order to fit the space claim requirements.

The motor controller in combination with the required software represent an easy programming interface. Via this interface, control parameters as well as parameter for the dynamics and precision of the motor can be set. As a starting value, the motor stiffness (responsiveness) gain was set to its maximum. Based on the software design of the microcontroller, the precision of the motor was set to 2000 steps/revolution.

The interface to the motor is provided by a simple digital protocol. It consists of a direction and a step pin. The direction reacts to a logical 5V signal, where a logical 1 (5V) corresponds to clockwise rotation and a logical 0 (0V) corresponds to counterclockwise

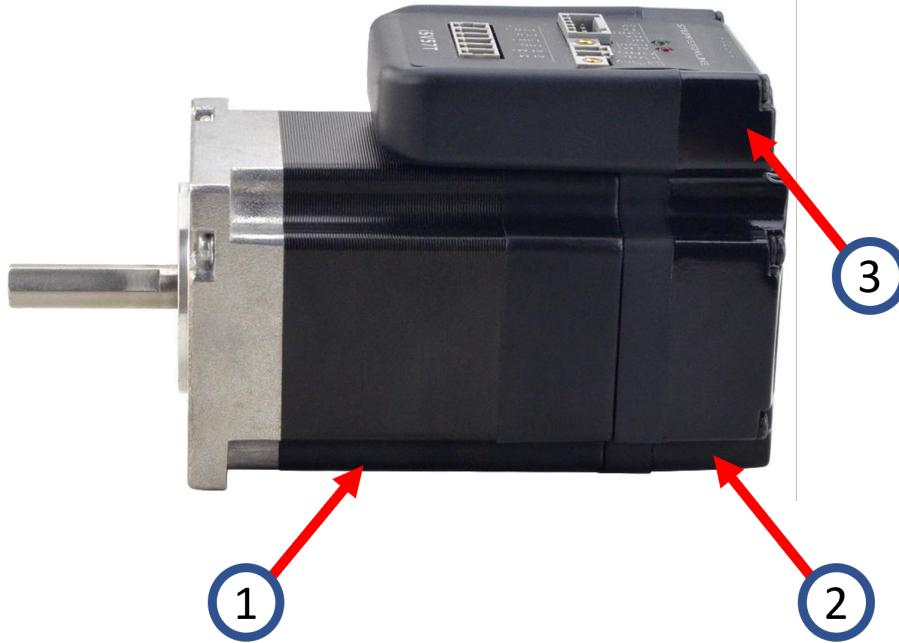


Figure 4.9.: Integrated Servo Motor; 1 - BLDC Motor, 2 - Encoder Unit, 3 - Control Unit

rotation. The step input reacts to logical pulses with a minimum pulse width of  $1\mu s$ . Each pulse will then move the motor by  $\frac{1}{motor-resolution}$ .

### **Gearbox**

Because the motor is mounted underneath the Lead screw, a coupling between both elements was needed. This was done with the already existing gears from the old gearbox of the lathe. This decision was made because it required the least modification (only a coupler from the motor to the gear had to be manufactured) and was the cheapest option. The gear ratio of 25/80 was selected to optimize the feed range of the lathe with the available RPM of the motor. This is shown in Figure 4.10.

The transmission of the gearbox also increases the torque of the motor by a factor of 3.2. This way, the motor meets the specified torque of 1.2 Nm.

#### **4.2.3. Software Implementation**

The task during the implementation of the software was to deploy the developed code to the according hardware. Further, the communication between the HMI and the real time controller needed to be established.

#### **Micro Controller**

The implementation of the software design for the microcontroller was one of the biggest tasks during the development of the Electronic Lead screw System. It was done in multiple steps.

First, the functional part of the software was created using Matlab and Matlab Simulink. In the functional software, a series of logical actions were needed in order to compute

Leitspindel Drehzahlen							
Steigung	Einheit	Übersetzung	100	250	350	500	1700
0,4	mm	0,266666667	26,66666667	66,66666667	93,33333333	133,33333333	453,3333333
0,5	mm	0,333333333	33,33333333	83,33333333	116,6666667	166,6666667	566,6666667
0,7	mm	0,466666667	46,66666667	116,6666667	163,3333333	233,3333333	793,3333333
0,8	mm	0,533333333	53,33333333	133,33333333	186,6666667	266,6666667	906,6666667
1	mm	0,666666667	66,66666667	166,6666667	233,3333333	333,3333333	1133,3333333
1,25	mm	0,833333333	83,33333333	208,3333333	291,6666667	416,6666667	1416,666667
1,5	mm	1	100	250	350	500	1700
1,75	mm	1,166666667	116,6666667	291,6666667	408,3333333	583,3333333	1983,3333333
2	mm	1,333333333	133,3333333	333,3333333	466,6666667	666,6666667	2266,666667
2,5	mm	1,666666667	166,6666667	416,6666667	583,3333333	833,3333333	2833,3333333
3	mm	2	200	500	700	1000	3400
10	TPI	1,692307692	169,230769	423,076923	592,307692	846,153846	2876,92308
11	TPI	1,538461538	153,846154	384,615385	538,461538	769,230769	2615,38462
13	TPI	1,3	130	325	455	650	2210
19	TPI	0,888888889	88,8888889	222,222222	311,111111	444,444444	1511,111111
20	TPI	0,846153846	84,6153846	211,538462	296,153846	423,076923	1438,46154
22	TPI	0,769230769	76,9230769	192,307692	269,230769	384,615385	1307,69231
40	TPI	0,423076923	42,3076923	105,769231	148,076923	211,538462	719,230769
44	TPI	0,384615385	38,4615385	96,1538462	134,615385	192,307692	653,846154
0,09	mm/REV	0,05859375	5,859375	14,6484375	20,5078125	29,296875	99,609375
0,018	mm/REV	0,1171875	11,71875	29,296875	41,015625	58,59375	199,21875

Figure 4.10.: Chart of the Lead screw dynamics; green - reachable Lead screw RPM with a 25/80 transmission, red - not reachable Lead screw RPM with a 25/80 transmission

the required motor signal based on the encoder position. The task of the first software part was it to process the position data coming from the encoder and calculate the desired motor position. This process is shown in form of a block diagram in figure 4.11.

Because the encoder is constantly incrementing the value of a 16bit register, it is possible that the value reaches the maximum or minimum possible value. In this case, the register value will "overflow" and jump from its maximum to its minimum or from its minimum to its maximum value. This would result in a very big but wrong movement of the motor. The first step of the functional software is to detect such an overflow and correct for it. This way, the calculation of the desired steps is always performed with the absolute movement of the encoder. Next, the direction of rotation of the spindle needs to be detected and the direction output to the motor need to be set accordingly. In the last step of the functional software, the desired steps are calculated. This is done by multiplying the steps of the encoder by a previously determined translation factor.

The second part of the functional software generates the logical pulses in order to move the motor. Therefore, it checks the register value of the desired steps on a cyclic basis. If this value is not zero, the software will create a one micro second logical pulse and decrement the register value afterwards by one. These steps are also shown in figure 4.11.

During the second part of the software implementation, the functional code was translated to C Code using Matlabs Code generation toolbox and deployed to the hardware. To be able to use the functional code on the microcontroller, an implementation routine needed to be created. This routine was used in order to read all inputs, such as the encoder position, and the communication interface relay this information to the func-

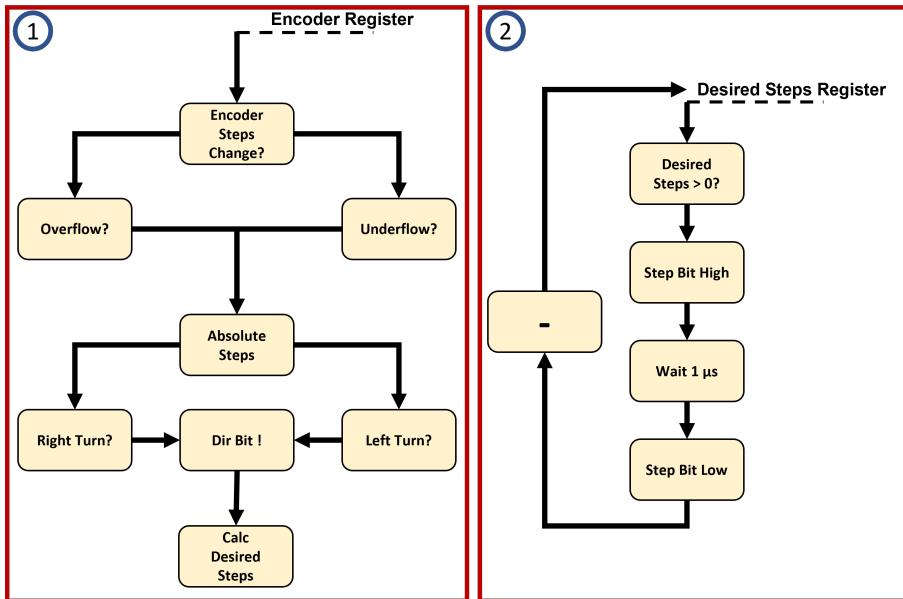


Figure 4.11.: Block diagram of the first part of the functional software; 1 - Functional Software first part, 2 - Functional Software second part

tional code. Further, the implementation routine enabled the functional code to use the GPIO module of the microcontroller and send out the current RPM of the spindle via the communication interface.

## HMI

After the creation of the graphical interface during the design phase, the HMI needed to be connected to the microcontroller. For this purpose, a UART communication interface was used. To transmit Mode and translation factor and receive the spindle RPM simultaneously, a custom communication protocol was created. This protocol consist of 5 bytes of data. The first and last byte are so-called start and stop bytes, used in order to determine between different data packages. They have the value 0xFF. The second byte is an integer with a value between 0 and 2 in order to communicate normal, metric or imperial mode to the microcontroller. The third and fourth bytes represent the determined translation factor. Because it is not possible to transmit fractional numbers via a UART communication interface, the integer part of the translation factor is transmitted in the third byte. The fractional value of the translation factor is then converted to an integer and transmitted in the fourth byte. This process has then to be reversed on the microcontroller.

### 4.2.4. Hardware Implementation

For the implementation of the Hardware, the main task was to solve mechanical problems. This was done with the extensive use of a CAD Software, a 3-D Printer as well as the Lathe.

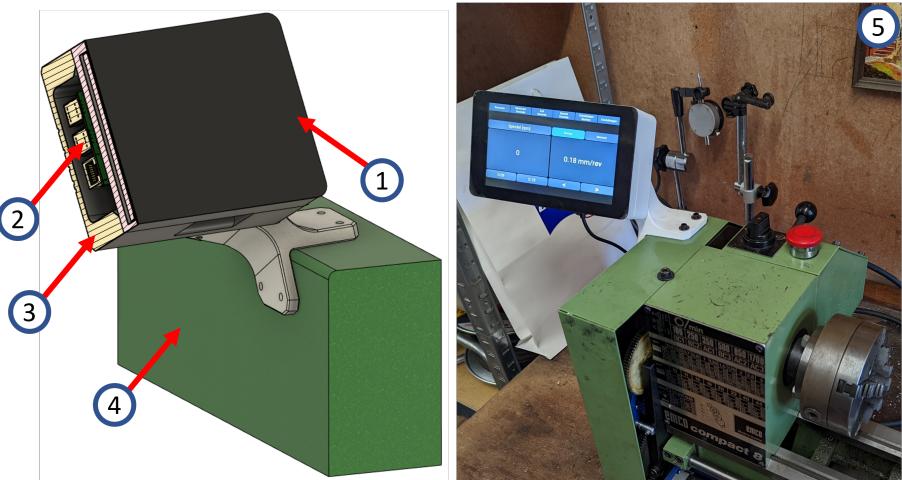


Figure 4.12.: Cross-section of the Touchscreen mount; 1 - Touchscreen, 2 - Raspberry Pi, 3 - Enclosure and mount, 4 - Lathe model, 5 - Picture of the finished implementation

### Touchscreen

In order to mount the touchscreen as well as the Raspberry Pi to the lathe, a housing needed to be created. This was done by first modeling each of the components as well as a section of the lathe in the CAD Software Autodesk Fusion 360. After this, a house was created the positioned the touchscreen in a way that made it convenient to read and operate while working on the lathe. Further, the housing featured an enclosure for the Raspberry Pi that was mounted to the back of the touchscreen.

After the 3-D Model of the touchscreen mount was complete, it was 3-D printed in PETG plastic. Finally, the touchscreen could be mounted to the lathe. The 3-D model and the final result are shown in figure 4.12.

### Encoder

For the implementation of the encoder to, problems needed to be solved. First, a method needed to be developed in order to mount the encoder to the lathe. Second, the RPM of the main Spindle needed to be transferred to the shaft of the rotary encoder. In order to mount the encoder to the lathe, all components were modeled in Fusion 360. As a good mounting point on the lathe, the old gear holder stood out. This way, the encoder position could be changed easily. In the second step, the mount for the encoder was modeled as well as a gear in order to transfer the spindle RPM to the encoder with a 1:1 transmission factor. Both the holder and the gear were 3-D printed. Only the standoffs for the mount were manufactured from Aluminum on the lathe. This was done in order to insure a rigid mounting of the encoder. Figure 4.13 shows the complete mounting of the encoder.

### Motor

Similar to the mount of the encoder and the touchscreen, the motor mount was designed with the use of Fusion 360. Because of the very limited space on the machine, this was

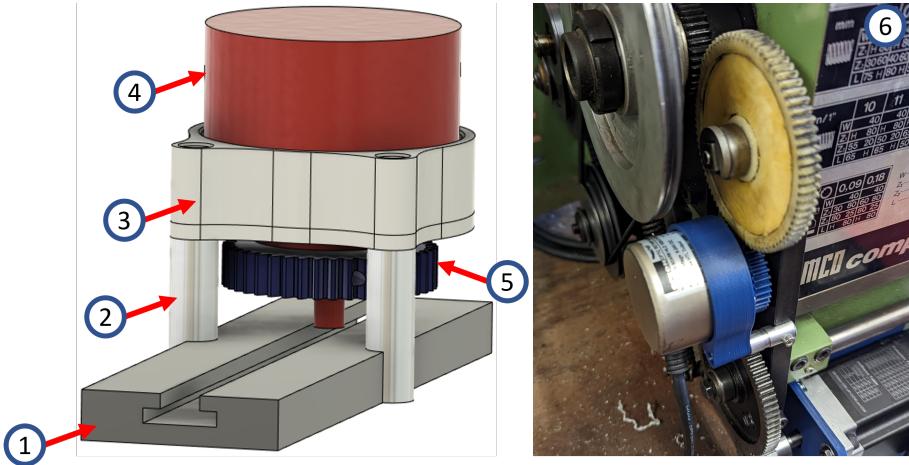


Figure 4.13.: Image of the encoder mount; 1 - Old gear holder, 2 - Machined standoffs, 3 - 3-D printed Encoder mount, 4 - Encoder model, 5 - 3-D printed gear, 6 - Picture of the finished implementation

very important. First, the parts of the Lathe that could possibly interfere with the motor or its mount were modeled. Then, the motor and the motor could be designed. The motor mount was designed, such that the play of the gears can be adjusted by sliding the motor in its mount up and down. This is shown in Figure 4.14. After the model of the motor mount was finished, it was 3-D printed in order to test the fit of the mount. Initially, the motor mount was supposed to be manufactured from steel afterward but during testing the 3-D printed motor mount proved to be rigid enough. In order to connect the motor to the microcontroller a logic level shifter was needed. This was caused, because the motor controller was operating on a 5V logic level, while the microcontroller was operating on a 3.3V logic level.

### 4.3. Testing

During the testing phase of the development process, every part of the system is tested to see if it is functioning as defined in the requirements and the System design. This is done on component level, system level and finally on the integrated system. As shown in Figure 4.15, this is the second part of the V Model development cycle.

#### 4.3.1. Component Test

First, the correct function of each of the components needs to be ensured. This can be done on the finished system, but is often easier to do before the implementation. Because the motor, motor controller and encoder are bought from a third party, they are not included in the component testing.

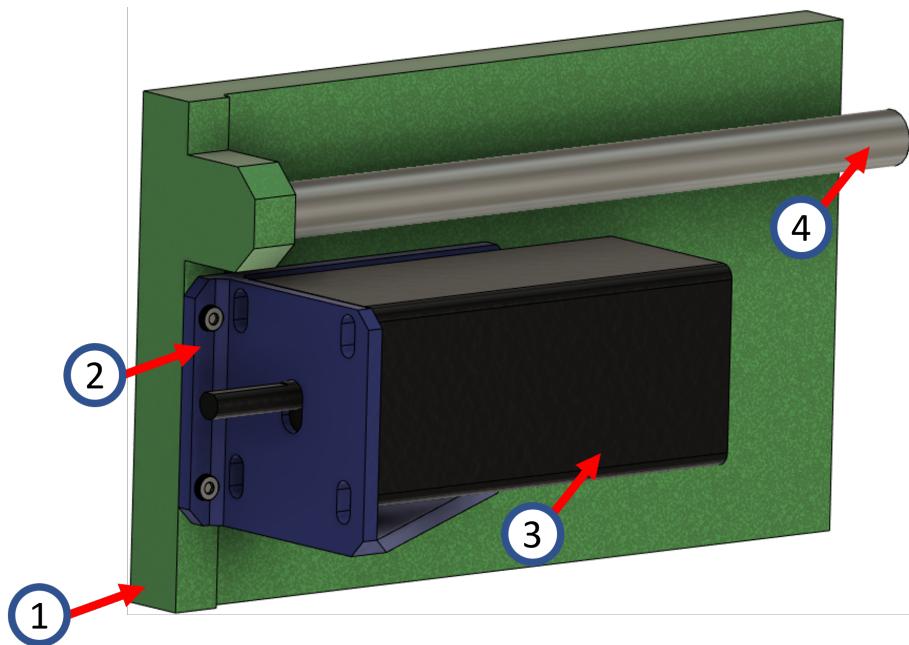


Figure 4.14.: Image of the motor mount; 1 - Old gear holder, 2 - Machined standoffs, 3 - 3-D printed Encoder mount, 4 - Encoder model, 5 - 3-D printed gear, 6 - Picture of the finished implementation

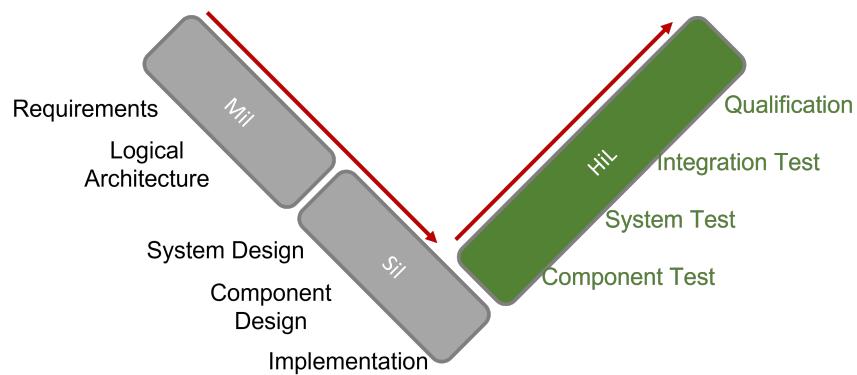


Figure 4.15.: V Model Component Test Stage

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## HMI

In order to test the functionality of the HMI and especially the communication, a special test program was created. This program allowed to monitor the data packages send by the HMI. Further, it was possible to send RPM data to the HMI in order to test the RPM display.

## Micro Controller

During the component testing phase, only the implementation softer on the microcontroller was tested. This step was tremendously simplified by the onboard debugging probe of the TI LAUNCHXL development board. This way, it was able to track every register value on the microcontroller to ensure a correct working behavior. The correct timing of both real time loops were checked by toggling one of the GPIO Pins of the microcontroller and reading its value with the help of an Oscilloscope.

### 4.3.2. System Test

The system testing was done in two stages, the first testing series was done within Matlab Simulink. Secondly, the on a test bench assembled system was tested. Later, the result of both test could be compared.

#### Matlab Simulink

In order to test the system in Matlab Simulink, every component needed to be modeled. The most complex part to model in the Simulink environment was the encoder and the drive train for the Lead screw.

The model of the encoder needed to be able to simulate events like a register overflow, different trajectories as well as constant speeds. The model of the encoder is shown in Figure 4.16.

Every test function of the encoder was then routed over a case-sensitive switch. This switch can be controlled by a variable and connects based on this the according input to the output. This makes switching the test scenario easy and fast.

For the simulation of the drive train, both the electronic and the original gear drive train were modeled. The motor and motor controller were modeled with a library of Simulink called "Simscape". Simscape is designed in order to model complex electromechanical with minimum effort. The model of the electronic drivetrain is shown in Figure 4.17. It features four sections, first the step and direction signal from Simulink are converted to signal that are compatible with the Simscape system. Second, the motor controller is modeled. The third block represents the BLDC motor. However, in this case, a Stepper motor block was used in order to model the stepwise control of the motor. In the last block of the model, the output signal of the motor (angle  $\Theta$ ) is converted back to a numeric Simulink signal.

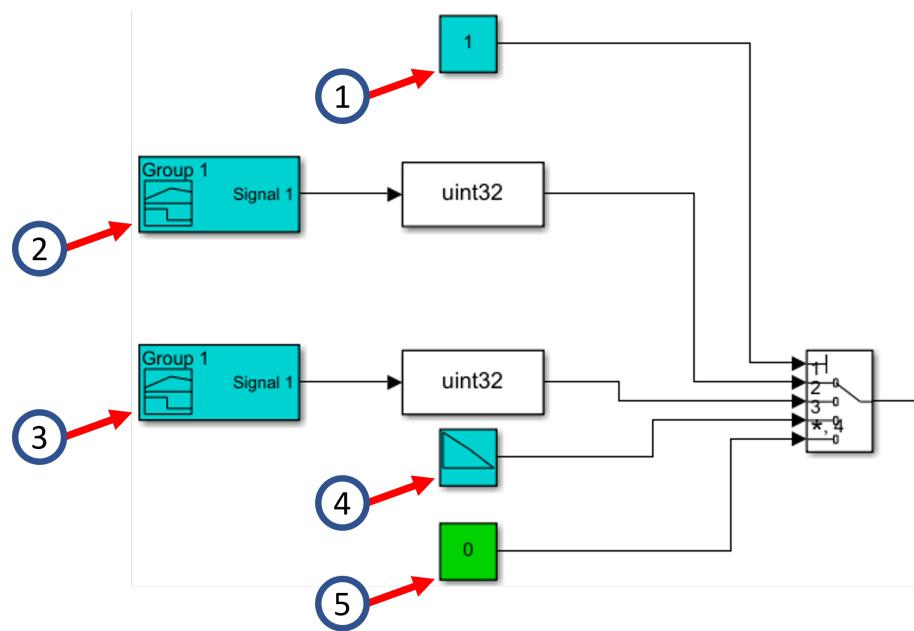


Figure 4.16.: Simulink Model of the encoder; 1 - Constant position, 2 - Trajectory 1, 3 - Trajectory 2, 4 - Register overflow, 5 - Case selector

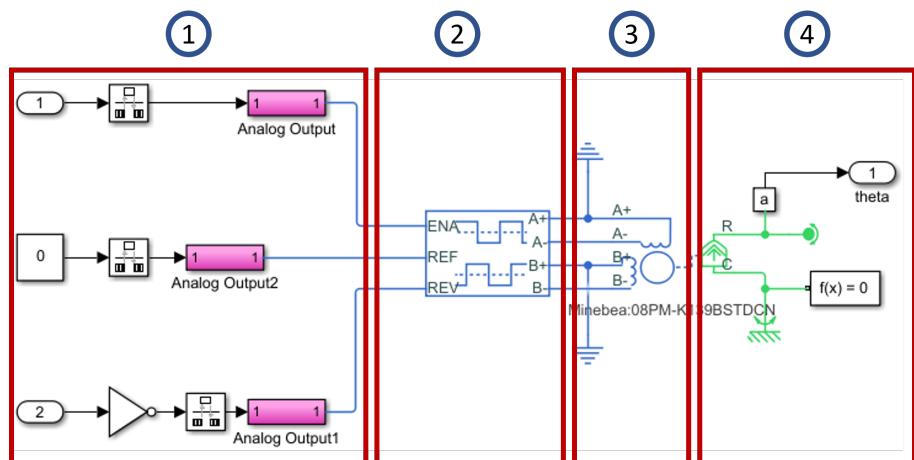


Figure 4.17.: Simulink Model of the electronic drive train; 1 - Input processing, 2 - Motor Controller, 3 - Motor, 4 - Output processing

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## Test Bench

In order to test both hardware and software in a realistic environment, the system was assembled in a "Test Bench" configuration. This means, that the inputs into the system can be tightly controlled, and every output can be observed. For this reason, the encoder was not connected to the system during this test. It was replaced by another microcontroller, which simulated the signal of the encoder. This way, the amount of encoder steps could be precisely determined. The outputs of the system were connected to both, the motor and an Oscilloscope. This way both, the motor movement and the logical signal of the system could be observed.

Because the basic functionality of the system was already tested in previous steps, the test performed on the test bench were focused on system performance. System performance was mainly determined by the floating point division that was needed in order to calculate the desired amount of steps. To optimize the processing time of this calculation, two different methods were tested:

For the first method that was tested, the translation factor was calculated beforehand. This way, the predefined translation factor has just to be multiplied with the encoder steps. However, this has the big disadvantage, that it will introduce a cumulating rounding error into the calculation. If this method is later used in the final software version, this rounding error has to be investigated.

For the second method, the translation factor was not calculated beforehand. Everything the encoder position changes, the complete translation calculation is done. The equation to calculate the desired Steps is given by:

$$\text{EncoderSteps} = \frac{\text{MotorSteps} * \text{MotorTransmission} * \text{EncoderTransmission} * \text{FeedSetting}}{\text{EncoderResolution} * \text{LeadscrewSlope}} \quad (4.1)$$

With this calculation method, the rounding error of the calculation will not cumulate because the calculation is done every time a new Desired Step value is calculated.

### 4.3.3. Integration Test

The last step in the testing phase is the integration test. This test determines if the behavior of the fully integrated system is matching the specifications. In case of the Electronic Lead screw, tow different integration tests were performed. First regular turning was tested, second metric and imperial thread cutting was investigated.

#### Turning

The testing of normal turning operation was performed with brass, aluminum and stainless steel. First, the maximum possible feed for each of the metal was investigated.

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This was done with a 1 mm depth of cut. In the second testing phase, the best possible surface quality was investigated. This was done with a depth of cut of 0.05 mm. The feed of the lathe was then adjusted in order to create the best possible surface finish.

### **Threading**

The testing of metric and imperial thread cutting was performed with aluminum and a hand ground HSS threading tool. The main focus during this testing series was the consistency of the thread pitch. For the imperial test, a 3/8" thread with 19 threads per inch was chosen. For the metric test, a standard M8x1.25 thread was selected. Both of these threads are very common and could later be checked with thread gauges.

# 5. Results, Discussion and Conclusion

In this chapter, the results of the testing phase will be shown. Further, the design decisions that were made based on these results will be discussed.

## 5.1. Arithmetic

During the system testing phase, extensive testing was done on the performance of different arithmetic algorithms. The performance of each algorithm was measured by toggling one of the GPIO pins to a HIGH state at the beginning of the calculation and resetting it back to LOW as soon as the calculation was done. This way, the processing time could be measured with an Oscilloscope. It is important to note that the time limit for the real time loop was set to  $100\mu s$ . All steps prior to the floating point calculation were measured to use  $40\mu s$  of time.

### 5.1.1. Floating point arithmetic

First, the floating point algorithm was tested. This algorithm introduces a cumulating rounding error into the calculation, but had the advantage that the calculation done within the real-time loop is as small as possible. The time measurement with the Oscilloscope showed a calculation time of  $40.2\mu s$ . This leaves  $59.8\mu s$  time for other steps. When considering the previously measured time of  $40\mu s$  for the steps needed prior to the floating point calculation, this leaves a time buffer of  $19.8\mu s$ . The measurement result is shown in Figure 5.1.

### 5.1.2. Fractional arithmetic

Second, an algorithm was tested using fractional arithmetic. This algorithm had the big advantage that it did not introduce a cumulating rounding error into the calculation of the desired steps. The measurement of this calculation, as shown in Figure 5.1, resulted in a calculation time of  $55\mu s$ . With the additional  $40\mu s$ , while still being within the specification, this algorithm only leaves  $5\mu s$  of buffer to the real time criteria.

### 5.1.3. Discussion

Based on the previously done measurements, both algorithms will be calculated within the time limit of  $100\mu s$ . However, the fractional arithmetic only leaves  $5\mu s$  of buffer, before breaking the real time limitation. This would render the solution of the algorithm invalid and one complete calculation cycle would be missed by the system. For this

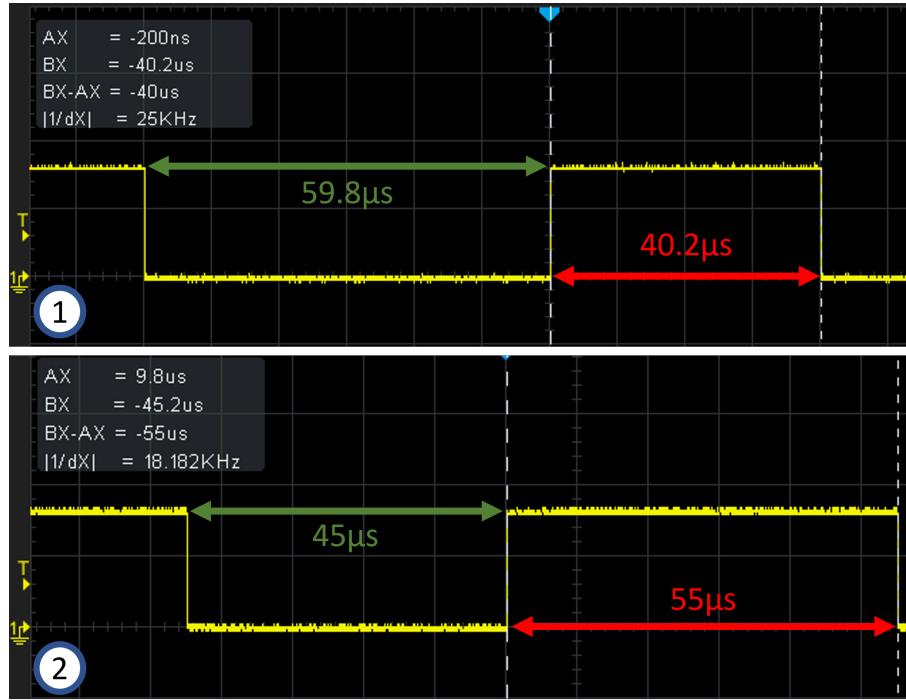


Figure 5.1.: Results of the algorithm testing; 1 - Floating point algorithm, 2 - Fractional arithmetic, red - Time needed for the calculation, green - Time needed for the calculation, blue - Time available for other calculation steps

Test. Nr.	Depth of cut	Feed	Success
1	1 mm	0.09 mm/rev	good
2	1 mm	0.11 mm/rev	good
3	1 mm	0.13 mm/rev	good
4	1 mm	0.15 mm/rev	good
5	1 mm	0.17 mm/rev	good
6	1 mm	0.19 mm/rev	canceled

Table 5.1.: Results material removal performance

reason, a real time violation has to be avoided. Based on this, the floating point algorithm was chosen to be implemented into the system. However, further tests have to show if the accumulation of the rounding error of this algorithm has a significant impact on the performance of the Electronic Lead screw.

## 5.2. Turning

The test of the normal turning performance of the system was part of the integration test. It was aimed to test both material removal performance and surface quality. As shown in Table 5.1 the system performed good up to a feed rate of 0.17 mm/rev. At 0.19 mm/rev the test was canceled because the RPM of the main spindle decreased by  $\sim 200$  rpm.

As shown in table 5.2 the test for surface quality was also performed with a fixed depth

Test. Nr.	Depth of cut	Feed	Success
1	0.05 mm	0.09 mm/rev	ok
2	0.05 mm	0.08 mm/rev	ok
3	0.05 mm	0.07 mm/rev	ok
4	0.05 mm	0.06 mm/rev	ok
5	0.05 mm	0.05 mm/rev	good
6	0.05 mm	0.04 mm/rev	blunt

Table 5.2.: Results of the surface quality testing

of cut and a variable feed rate. With decreasing feed rate, the surface quality was improving consistently, up to a point of 0.05 mm/rev. As soon as the feed was lowered below this point, the surface of the part became blunt. However, it is important to note that the surface quality was determined by eye. This was done because no tool was available to measure the surface quality after each cut.

### 5.3. Threading

The testing of the threading performance of the system was done on two example threads. These threads were chosen, because tools were available to measure the thread precision objectively. Further, it was essential to test both the metric mode of the machine and the transformation into the imperial unit system. In figure 5.2 the final result of both threading tests and the previous surface quality test is shown. Both, the imperial thread and the metric thread, were within the specifications of corresponding thread gauges. This proofed the capability of the machine to transform its motion calculation into another unit system. Further, it was shown that the impact of the cumulating rounding error introduced by the floating point algorithm on normal threading operations is insignificant.

### 5.4. Conclusion

During the testing, the Electronic Lead screw system has proven to meet the initial defined requirements. Further, this system shows to be a very valuable addition to this lathe. It enables the operator to use a wider range of feeds while reducing the setup time of the machine significant. This increases the capability of a small lathe like the Emco Compact 8 to a point where it is a good addition for every home metal workshop.

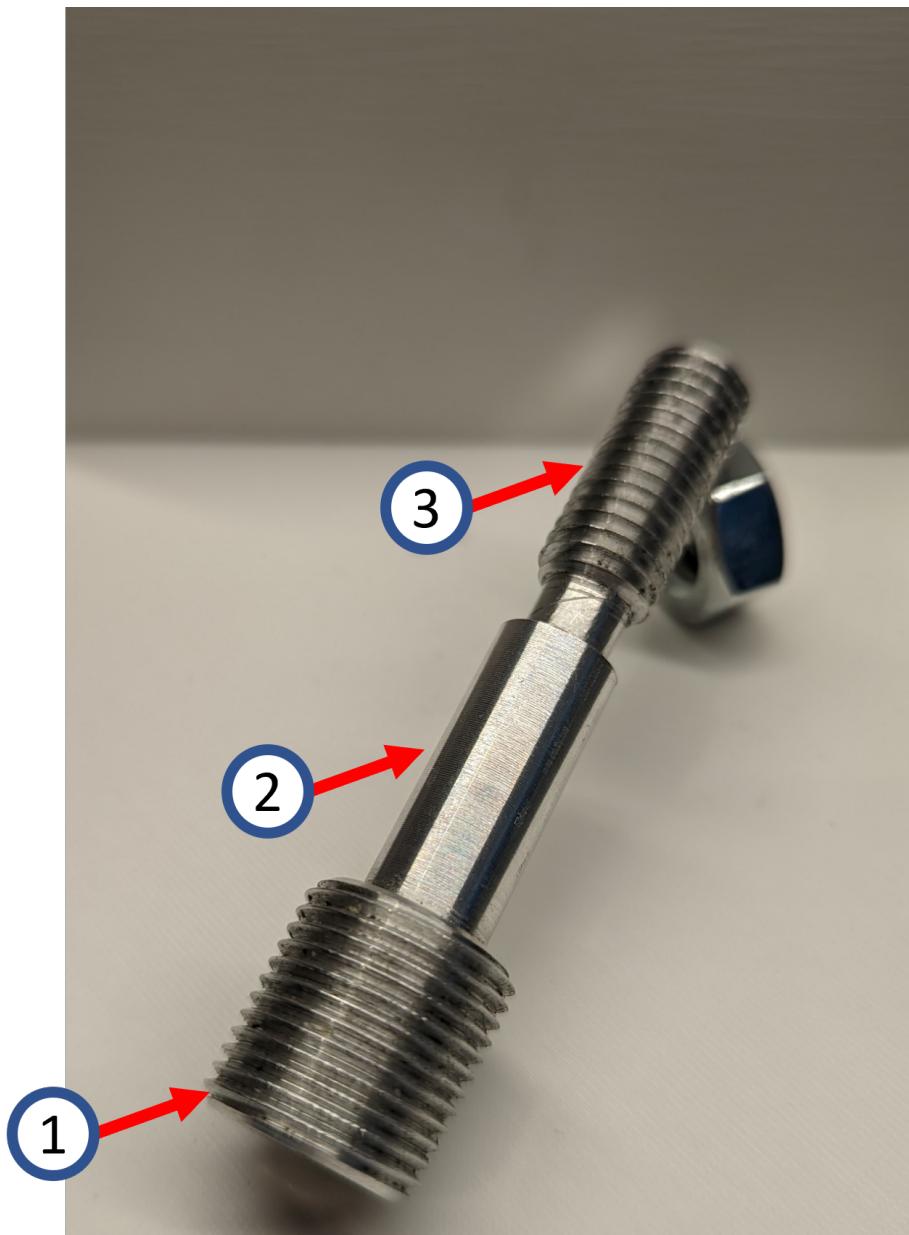


Figure 5.2.: Results of the threading and surface quality test; 1 -  $3/8''$  19G thread, 2 - best surface quality, 3 - M8x1.25 thread

## **6. Outlook**

The Electronic Lead screw system offers due to the modularity of the control software and the interface the opportunity to add further functions to the system. In the future, modes for circular grinding as well as partially automated threading are planned. However, more important additions to the Electronic Lead screw system will be a cabinet for the electronics. This cabinet and its components were already planned and ordered during the project, but did not arrive in time due to a global electronics shortage. Further, a Variable Speed Drive (VSD) will be added to the main spindle in the future. A VSD enables the operator to control the speed of the main spindle step-less. In addition to that, the VSD could be controlled connected to the ELS. This would enable features such as automatic threading or turning.

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- 
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# **Appendix**

<b>A. List of Companies</b>	<b>II</b>
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## A. List of Companies



Company: Kivy.org

Website: <https://kivy.org/>

---



Company: The MathWorks, Inc.

Website: <https://www.mathworks.com/>

---



Company: OPKON Optic Electronic A.S.

Website: <https://www.opkon.com.tr/>

---



Company: Raspberry Pi Foundation

Website: <https://www.raspberrypi.org/>

---



Company: STEPPERONLINE, Inc.

Website: <https://www.omc-stepperonline.com/>

---



Company: Texas Instruments, Inc.

Website: <https://www.ti.com/>

---

## B. Requirements ELS

<b>Req.Nr/Komponente</b>	<b>Requirement</b>	<b>Design</b>
uC		
1	Takt	100MHz
2	IO-Ports	> 10
3	Flash	> 200kB
4	RAM	> 200kB
5	Hardware Com.	Encoder
6	ADC	> 1
7	Timer	> 2
8	Dokumentation	Ja
9	Kosten	< 100€
<b>Motor</b>		
1	Drehzahl	> 3000rpm
2	Drehmoment	< 0.3Nm
3	Motor Kosten	< 150€
4	Min drehzahl	< 1rpm
5	Motor Größe	
<b>Motor Controller</b>		
1	Closed Loop	Ja
2	Versorgungs Spannung	> 24V < 50V
3	Programmierbar	Ja
4	Ansteuerung	logisch
5	Auflösung	> 1000 ppt
6	Kosten	> 100€
7	Montage	DIN Rail

Figure B.1.: System requirements table 1

---

<b>Encoder</b>		
1	Pulses per Turn	> 2000 ppt
2	Max RPM	> 2000 rpm
3	Größe	< 60mm
4	Richtungs erkennung	Ja
5	Montage	Schrauben
6	Kosten	< 100€
7	Spannungsversorgung	5V
<b>HMI</b>		
1	Touch	Ja
2	Modular	Raspberry Pi
3	UART	Ja
4	Eigene Spannungsversorgung	5V
5	Anbringung	3-D Druck
6	Kosten	< 150€

Figure B.2.: System requirements table 2

## C. Time Plan

Finished In time		Mai	Jun	Jul	Aug	Sep	Okt	Nov	Dez	Jan	Feb
Monat											
Semester											
Meilenstein											
Fertiger Benchtop Prototyp	In work										
Erste Schnitt Versuche											
Fertigstellung ELS											
Systemanforderungen	Extra Time										
Systemarchitektur	A										
Auswahl der Komponenten	b										
Beschaffung Komponenten	e										
Software architecture	i										
Software developement	t										
El. Mech. Aufbau Prototyp	s										
Tests/Validierung Prototyp	p										
Testweise Integration der Einzelkomponenten	a										
Systemtests im Integrierten Zustand	c										
Vollständige Systemintegration	k										
	e										
	t										
	e										

## **D. Source Code**

---

## D.1. main.c

```
1 //  
2 // Included Files  
3 //  
4 #include "F28x_Project.h"  
5 #include "Configuration.h"  
6  
7 #include "..\Matlab\RealTimeMachine_ert_rtw\RealTimeMachine.h"  
8 #include "..\Matlab\RealTimeMachine_ert_rtw\rtwtypes.h"  
9 #include "..\Matlab\RealTimeMachine_ert_rtw\  
    zero_crossing_types.h"  
10 #include "..\Matlab\RealTimeMachine_ert_rtw\  
    RealTimeMachine_data.c"  
11  
12 #include "..\Matlab\StepperRTM_ert_rtw\StepperRTM.h"  
13 #include "..\Matlab\StepperRTM_ert_rtw\rtwtypes.h"  
14 #include "..\Matlab\StepperRTM_ert_rtw\zero_crossing_types.h"  
15  
16 #define _FLASH  
17  
18 //  
19 // Global Variables Inputs  
20 //  
21 static uint32_T arg_SpindelPos = 0U;  
22 volatile real32_T arg_CountFactor = 0;  
23 volatile uint16_T var_StepBacklog;  
24  
25 //  
26 // Global Variables Outputs  
27 //  
28 static uint16_T arg_StepBit;  
29 static uint16_T arg_Dir;  
30 static uint16_T arg_DesSteps;  
31  
32 //  
33 // Global Variables Statemachine Clock  
34 //  
35 static uint16_T System_Trigger[2] = { 0U, 0U };  
36 static boolean_T System_Takt = 0;  
37 static uint16_T Stepper_Trigger[2] = { 0U, 0U };
```

```
38 static boolean_T Stepper_Takt = 0;
39
40 // Global Variables Helpers
41 // 
42 // 
43 volatile uint32_T current = 0;
44 volatile uint32_T count = 0;
45 volatile uint32_T previous = 0;
46 volatile uint16_T RPM;
47
48 volatile int msg[] = {0, 0, 0, 0, 0};
49 volatile int i = 0;
50 volatile float feed = 0.0;
51 volatile int Mode = 1;
52 volatile int TransferComplete = 0;
53
54 void main(void)
55 {
56
57 #ifdef _FLASH
58     // Copy time critical code and Flash setup code to RAM
59     // The RamfuncsLoadStart , RamfuncsLoadEnd , and
60     // RamfuncsRunStart
61     // symbols are created by the linker. Refer to the
62     // linker files .
63     memcpy(&RamfuncsRunStart , &RamfuncsLoadStart , (size_t)
64         &RamfuncsLoadSize) ;
65
66     // Initialize the flash instruction fetch pipeline
67     // This configures the MCU to pre-fetch instructions
68     // from flash .
69     InitFlash();
70
71 #endif
72
73 // Initialize Autocode
74 // 
75 StepperRTM_initialize();
76 RealTimeMachine_initialize();
77 //
```

---

```

75      // Initialize device clock and peripherals
76      //
77      InitSysCtrl();
78
79      //
80      // Initialize GPIO, Timer and EQEP
81      //
82      InitGpio();
83      setupGPIO();
84      setupTimer();
85      setupEQEP();

86
87
88
89
90      //
91      // Initialize UART
92      //
93      initSCIAFIFO();
94      initSCIAEchoback();

95
96
97
98
99
100     while(1)
101     {
102         //
103         // Send RPM via UART
104         //
105         if(EQep1Regs.QFLG.bit.UTO==1)
106         {
107
108             Uint32 current = EQep1Regs.QPOSLAT;
109             Uint32 count = (current > previous) ? current -
110                                         previous : previous - current;
111
112             // deal with over/underflow
113             if( count > _ENCODER_MAX_COUNT/2 )
114             {
115                 count = _ENCODER_MAX_COUNT - count; // just

```

---

```

                subtract from max value
115      }

116
117      RPM = count * 60 * RPMSampleTime / EncoderRes;

118
119      int highbyte = RPM >> 8;
120      int lowbyte = RPM & 0x00ff;

121
122      previous = current;
123      transmitSCIACChar( lowbyte );           // Send RPM
124          out via UART
125      transmitSCIACChar( highbyte );          // Send RPM
126          out via UART
127      EQep1Regs.QCLR.bit.UTO=1;             // Clear interrupt
128          flag
129      }
130
131      // Check for new Messages from the Raspberry Pi
132      //
133      if( SciaRegs.SCIFFRX.bit.RXFFST != 0 )
134      {
135          msg[ i ] = SciaRegs.SCIRXBUF.bit.SAR;
136
137          if( i == 4 )
138          {
139              i = 0;
140              TransferComplete = 1;
141              Mode = msg[ 1 ];
142              feed = msg[ 2 ] + (msg[ 3 ] * 0.01 );
143          }
144          else
145          {
146              i++;
147          }
148      }
149
150      // Calculate Step-factor based on information received
151          via UART
152      //

```

```

151
152     if( TransferComplete && (msg[0] == 0xff) && (msg[4] ==
153         0xff))
154     {
155         TransferComplete = 0;
156         // Normal Feed and metric thread cutting
157         if( Mode == 1 || Mode == 2)
158         {
159             arg_CountFactor = (( Steps * MotorTransmission *
160                 EncoderTransmission * feed )/(EncoderRes *
161                 LeadscrewSlope));
162
163             }
164             arg_CountFactor = (( Steps * MotorTransmission *
165                 EncoderTransmission * OneInch)/(EncoderRes
166                 * LeadscrewSlope * feed ));
167             }
168         }
169
170     //
171     // cpuTimer0ISR - CPU Timer0 ISR
172     //
173     _interrupt void cpuTimer0ISR( void )
174     {
175
176         Stepper_Takt = !Stepper_Takt; // Toggle System Clock
177         Stepper_Trigger[0] = ( uint16_T )Stepper_Takt;
178
179         if( Stepper_Takt == 0)
180         {
181             Stepper_Trigger[1] = 1; //Power on Reset
182         }
183
184         StepperRTM_step( var_StepBacklog , ( uint16_t *)&
185             Stepper_Trigger , &arg_StepBit );

```

```

186    //  

187    // Stepper Clock for Debugging  

188    //  

189  

190    GpioDataRegs.GPASET.bit.GPIO6 = arg_StepBit;  

191    GpioDataRegs.GPADAT.bit.GPIO6 = arg_StepBit;  

192  

193    //  

194    // Acknowledge this interrupt to receive more  

195    //  

196    PieCtrlRegs.PIEACK.all = PIEACK_GROUP1;  

197 }  

198  

199  

200  

201 //  

202 // cpuTimer0ISR - CPU Timer2 ISR  

203 //  

204 __interrupt void cpuTimer2ISR(void)  

205 {  

206     System_Takt = !System_Takt; // Toggle System Clock  

207     System_Trigger[0] = (uint16_T)System_Takt;  

208  

209     if (System_Takt == 0)  

210     {  

211         System_Trigger[1] = 1; //Power on Reset  

212     }  

213  

214     arg_SpindelPos = EQep1Regs.QPOS_CNT;  

215  

216     RealTimeMachine_step(arg_SpindelPos, arg_CountFactor, (  

217         uint16_t *)&System_Trigger,  

218             &arg_DesSteps, &arg_Dir);  

219  

220     var_StepBacklog = var_StepBacklog + arg_DesSteps;  

221  

222     GpioDataRegs.GPBSET.bit.GPIO39 = !arg_Dir;  

223     GpioDataRegs.GPBDAT.bit.GPIO39 = !arg_Dir;  

224  

225     //  

226     // Acknowledge this interrupt to receive more

```

---

```
226     //  
227     PieCtrlRegs.PIEACK.all = PIEACK_GROUP1;  
228 }
```

---

## D.2. MainUI.py

```
1 #!/usr/bin/python
2
3 ## Libraries Import
4 from logging import Manager
5 from time import sleep, time
6 from kivy.app import App
7 from kivy.uix.widget import Widget
8 from kivy.lang import Builder
9 from kivy.uix.screenmanager import ScreenManager, Screen
10 from kivy.core.window import Window
11 from kivy.clock import Clock
12 import serial
13 import RPi.GPIO as GPIO
14
15 class CommunicationClass(object):
16
17     def __init__(self):
18         self.Mode = int(1)
19         self.Feed = 0.09
20         self.serialIndicator = 0
21         self.RPM = 0
22         self.Metric_BTN = 0
23         self.Imperial_BTN = 0
24         self.FeedFeed = 0.09
25
26     def SetBTN(self, Screen, BTN, State):
27
28         if Screen == 1:
29             self.Metric_BTN = BTN
30
31         elif Screen == 2:
32             self.Imperial_BTN = BTN
33
34         if State:
35             kv.screens[Screen].ids[str(BTN)].enabled = 1
36
37         else:
38             for n in range(0,4):
```

---

```

39                         for m in range(0,14):
40                             try:
41                                 kv.screens[n].
42                                     ids[str(m)]
43                                         ].enabled =
44                                         0
45
46             except:
47                 pass
48
49
50     def getStatus(self):
51         return self.Mode, self.Feed, self.
52             serialIndicator, self.Metric_BTN, self.
53             Imperial_BTN, self.FeedFeed
54
55
56     def initCom(self):
57
58         if self.serialIndicator == 0:
59             try:
60                 self.ser = serial.Serial('/dev
61                     /ttyACM0', 9600, timeout =
62                     0.2)
63                 sleep(1)
64                 self.serialIndicator = 1
65                 self.Mode = 'Normal'
66
67             except:
68                 self.serialIndicator = 0
69
70             pass
71
72
73     def TX(self, Mode, Feed):
74         if Mode == 1:
75             self.FeedFeed = Feed
76
77
78             self.Mode = int(Mode)
79             self.Feed = round(Feed, 2)
80             self.FeedInt = int(Feed)
81             self.FeedDez = int((Feed - int(Feed))*100)
82
83
84             if self.serialIndicator:
85                 self.ser.write(b'\xff')
86                 self.ser.write(self.Mode.to_bytes(1,

```

---

```

                                byteorder='big'))
73      self.ser.write(self.FeedInt.to_bytes
74          (1, byteorder='big'))
75      self.ser.write(self.FeedDez.to_bytes
76          (1, byteorder='big'))
77      self.ser.write(b'\xff')
78      print('Transmission_completed')

79
80      def RX(self):
81
82          lowbyte = 0
83          highbyte = 0
84          TransferComplete = 0
85
86          if self.serialIndicator:
87              while not TransferComplete:
88                  if self.ser.in_waiting == 2:
89                      lowbyte = int(
90                          from_bytes(self.ser
91                          .read(1), 'big',
92                          signed=False))
93                      highbyte = int(
94                          from_bytes(self.ser
95                          .read(1), 'big',
96                          signed=False))
97                      highbyte = highbyte <=
98                          8
99                      self.RPM = lowbyte +
100                         highbyte
101                     self.ser.flushInput()
102                     TransferComplete = 1
103                     return str(self.RPM)

104
105
106                     elif self.ser.in_waiting > 2:
107                         self.ser.flushInput()

108
109                     else:
110                         return str(self.RPM)

111                     else:
112                         return 'Not_connected'

```

---

```

103
104 class Startseite(Screen):
105     def btn_defone(self):
106         MainApp.MainCom.SetBTN(0,0,0)
107         MainApp.MainCom.TX(1, 0.09)
108
109     def btn_deftwo(self):
110         MainApp.MainCom.SetBTN(0,0,0)
111         MainApp.MainCom.TX(1, 0.18)
112
113     def btn_normal(self):
114         feed = MainApp.MainCom.getStatus()[5]
115         MainApp.MainCom.TX(1, feed)
116         MainApp.MainCom.SetBTN(0,0,0)
117
118     def btn_gewinde(self):
119         if MainApp.MainCom.getStatus()[0] == 1:
120             kv.screens[1].ids[str(MainApp.MainCom.
121                             getStatus()[3])].dispatch('on_press')
122
123         elif MainApp.MainCom.getStatus()[0] == 2:
124             kv.screens[2].ids[str(MainApp.MainCom.
125                             getStatus()[4])].dispatch('on_press')
126
127
128     def btn_prev(self):
129         if MainApp.MainCom.getStatus()[0] == 1:
130             MainApp.MainCom.TX(1, MainApp.MainCom.
131                             getStatus()[1] - 0.01)
132             global release_event
133             release_event = Clock.
134             schedule_interval(self.Decrement,
135                               0.2)
136
137         elif MainApp.MainCom.getStatus()[0] == 2:

```

```

135         try:
136             kv.screens[1].ids[str(MainApp.
137                 MainCom.getStatus()[3] - 1)
138                     ].dispatch('on_press')
139
140     elif MainApp.MainCom.getStatus()[0] == 3:
141         try:
142             kv.screens[2].ids[str(MainApp.
143                 MainCom.getStatus()[4] - 1)
144                     ].dispatch('on_press')
145
146     def Decrement(self, *args):
147         MainApp.MainCom.TX(1, MainApp.MainCom.getStatus()
148             ()[1] - 0.01)
149
150     def cancelDec(self):
151         if MainApp.MainCom.getStatus()[0] == 1:
152             release_event.cancel()
153
154     def btn_next(self):
155         if MainApp.MainCom.getStatus()[0] == 1:
156             MainApp.MainCom.TX(1, MainApp.MainCom.
157                 getStatus()[1] + 0.01)
158             global down_event
159             down_event = Clock.schedule_interval(
160                 self.Increment, 0.2)
161
162     elif MainApp.MainCom.getStatus()[0] == 2:
163         try:
164             kv.screens[1].ids[str(MainApp.
165                 MainCom.getStatus()[3] + 1)
166                     ].dispatch('on_press')
167
168     except:
169         pass
170
171
172     elif MainApp.MainCom.getStatus()[0] == 3:
173         try:

```

```
167                     kv.screens[2].ids[str(MainApp.  
168                         MainCom.getStatus()[4] + 1)  
169                         ].dispatch('on_press')  
170  
171             except:  
172                 pass  
173  
174         def Increment(self, *args):  
175             MainApp.MainCom.TX(1, MainApp.MainCom.getStatus()  
176                 ()[1] + 0.01)  
177  
178     class MetrischeGewinde(Screen):  
179         def btn_zero_four(self):  
180             MainApp.MainCom.TX(2, 0.4)  
181             MainApp.MainCom.SetBTN(1, 0, 0)  
182             MainApp.MainCom.SetBTN(1, 0, 1)  
183             pass  
184  
185         def btn_zero_five(self):  
186             MainApp.MainCom.TX(2, 0.5)  
187             MainApp.MainCom.SetBTN(1, 1, 0)  
188             MainApp.MainCom.SetBTN(1, 1, 1)  
189             pass  
190  
191         def btn_zero_seven(self):  
192             MainApp.MainCom.TX(2, 0.7)  
193             MainApp.MainCom.SetBTN(1, 2, 0)  
194             MainApp.MainCom.SetBTN(1, 2, 1)  
195             pass  
196  
197         def btn_zero_eight(self):  
198             MainApp.MainCom.TX(2, 0.8)  
199             MainApp.MainCom.SetBTN(1, 3, 0)  
200             MainApp.MainCom.SetBTN(1, 3, 1)  
201             pass  
202  
203         def btn_one(self):  
204             MainApp.MainCom.TX(2, 1.0)
```

---

```
205             MainApp.MainCom.SetBTN(1, 4, 0)
206             MainApp.MainCom.SetBTN(1, 4, 1)
207             pass
208
209     def btn_one_two_five(self):
210         MainApp.MainCom.TX(2,1.25)
211         MainApp.MainCom.SetBTN(1, 5, 0)
212         MainApp.MainCom.SetBTN(1, 5, 1)
213         pass
214
215     def btn_one_five(self):
216         MainApp.MainCom.TX(2,1.5)
217         MainApp.MainCom.SetBTN(1, 6, 0)
218         MainApp.MainCom.SetBTN(1, 6, 1)
219         pass
220
221     def btn_one_seven_five(self):
222         MainApp.MainCom.TX(2,1.75)
223         MainApp.MainCom.SetBTN(1, 7, 0)
224         MainApp.MainCom.SetBTN(1, 7, 1)
225         pass
226
227     def btn_two(self):
228         MainApp.MainCom.TX(2,2.0)
229         MainApp.MainCom.SetBTN(1, 8, 0)
230         MainApp.MainCom.SetBTN(1, 8, 1)
231         pass
232
233     def btn_two_five(self):
234         MainApp.MainCom.TX(2,2.5)
235         MainApp.MainCom.SetBTN(1, 9, 0)
236         MainApp.MainCom.SetBTN(1, 9, 1)
237         pass
238
239     def btn_three(self):
240         MainApp.MainCom.TX(2,3.0)
241         MainApp.MainCom.SetBTN(1, 10, 0)
242         MainApp.MainCom.SetBTN(1, 10, 1)
243         pass
244     pass
245
```

```
246 class ZollGewinde(Screen):
247     def btn_ten(self):
248         MainApp.MainCom.TX(3,10.0)
249         MainApp.MainCom.SetBTN(2, 0, 0)
250         MainApp.MainCom.SetBTN(2, 0, 1)
251         pass
252
253     def btn_eleven(self):
254         MainApp.MainCom.TX(3,11.0)
255         MainApp.MainCom.SetBTN(2, 1, 0)
256         MainApp.MainCom.SetBTN(2, 1, 1)
257         pass
258
259     def btn_thirteen(self):
260         MainApp.MainCom.TX(3,13.0)
261         MainApp.MainCom.SetBTN(2, 2, 0)
262         MainApp.MainCom.SetBTN(2, 2, 1)
263         pass
264
265     def btn_nineteen(self):
266         MainApp.MainCom.TX(3,19.0)
267         MainApp.MainCom.SetBTN(2, 3, 0)
268         MainApp.MainCom.SetBTN(2, 3, 1)
269         pass
270
271     def btn_twenty(self):
272         MainApp.MainCom.TX(3,20.0)
273         MainApp.MainCom.SetBTN(2, 4, 0)
274         MainApp.MainCom.SetBTN(2, 4, 1)
275         pass
276
277     def btn_twentytwo(self):
278         MainApp.MainCom.TX(3,22.0)
279         MainApp.MainCom.SetBTN(2, 5, 0)
280         MainApp.MainCom.SetBTN(2, 5, 1)
281         pass
282
283     def btn_fourty(self):
284         MainApp.MainCom.TX(3,40.0)
285         MainApp.MainCom.SetBTN(2, 6, 0)
286         MainApp.MainCom.SetBTN(2, 6, 1)
```

---

```
287         pass
288
289     def btn_fourtyfour(self):
290         MainApp.MainCom.TX(3,44.0)
291         MainApp.MainCom.SetBTN(2, 7, 0)
292         MainApp.MainCom.SetBTN(2, 7, 1)
293         pass
294     pass
295
296 class SpezialGewinde(Screen):
297     pass
298
299 class SchnittdatenRechner(Screen):
300     pass
301
302 class Einstellungen(Screen):
303     pass
304
305 class WindowManager(ScreenManager):
306     pass
307
308 kv = Builder.load_file("kvroot.kv")
309
310 class MainApp(App):
311
312     MainCom = CommunicationClass()
313
314     def on_start(self):
315         Clock.schedule_interval(self.Cyclic, 0.1)
316
317     def Cyclic(self, *args):
318         MainApp.MainCom.initCom()
319         self.root.screens[0].ids.rpm_label.text =
320             MainApp.MainCom.RX()
321
322         if MainApp.MainCom.getStatus()[0] == 1:
323             self.root.screens[0].ids.btn_gewinde.
324                 enabled = 0
325             self.root.screens[0].ids.btn_normal.
326                 enabled = 1
327             self.root.screens[0].ids.label_feed.
```

---

```

            text = str(MainApp.MainCom.
getstatus() [1])+'_mm/rev'

325
326     elif MainApp.MainCom.getstatus () [0] == 2:
327         self.root.screens [0].ids.btn_normal.
328             enabled = 0
329         self.root.screens [0].ids.btn_gewinde.
330             enabled = 1
331         self.root.screens [0].ids.table_feed.
332             text = 'Metrisch'
333         self.root.screens [0].ids.table_feed.
334             text = str(MainApp.MainCom.
335                 getstatus () [1])+'_mm'

336
337     elif MainApp.MainCom.getstatus () [0] == 3:
338         self.root.screens [0].ids.btn_normal.
339             enabled = 0
340         self.root.screens [0].ids.btn_gewinde.
341             enabled = 1
342         self.root.screens [0].ids.table_feed.
343             text = 'Zoll'
344         self.root.screens [0].ids.table_feed.
345             text = str(MainApp.MainCom.
346                 getstatus () [1])+'_TPI'

347
348     def build (self):
349         return kv

350
351 if __name__ == '__main__':
352     Raspi = True
353     if Raspi == True:
354         GPIO.setmode(GPIO.BCM)
355         GPIO.setup(2, GPIO.OUT, initial=GPIO.HIGH)
356         sleep(1)
357         GPIO.output(2, GPIO.LOW)
358         sleep(1)
359         GPIO.output(2, GPIO.HIGH)
360
361 MainApp().run()

```