PhD Proposal Writeup

A realtime and parallel look-ahead control and feedrate compensation strategy for CNC reference-pulse interpolation.

Faculty of Mechanical Engineering,
Universiti Malaysia Pahang (UMP),
26600 Pekan, Pahang Darul Makmur,
Malaysia.

PhD Program Registration Details		
1	Name of Student	**Wan Ruslan bin W Yusoff**
2	Student ID	**PFD18001**
3	National Reg. ID	**560911-03-5067**
4	Faculty	**Faculty of Mechanical Engineering**
5	Program	**Doctor of Philosophy (PhD)**
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10	Supervisor	**Dr. Fadhlur Rahman bin Mohd Romlay**
12	External Advisor	**Prof. Yashwant Prasad Singh**
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15	Contact EMail	**wruslandr@gmail.com**
16	Contact Mobile	**6012-3218120**

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1 Simulation Results

1.1 The Parametric Equations

The images of the UMP 3-axis CNC research machine for our previous work are provided in next three figures. It is an experimental CNC router-type, that instead of a tool cutter, uses a pen to create drawings on paper in the X-Y plane. The Z-axis motion is used to raise and lower the pen. As a consequence, circular arc (G02, G03 G-Code) moves are applicable to the X and Y axes only, while linear (G01 G-Code) moves are applicable to all three X, Y and Z axes.

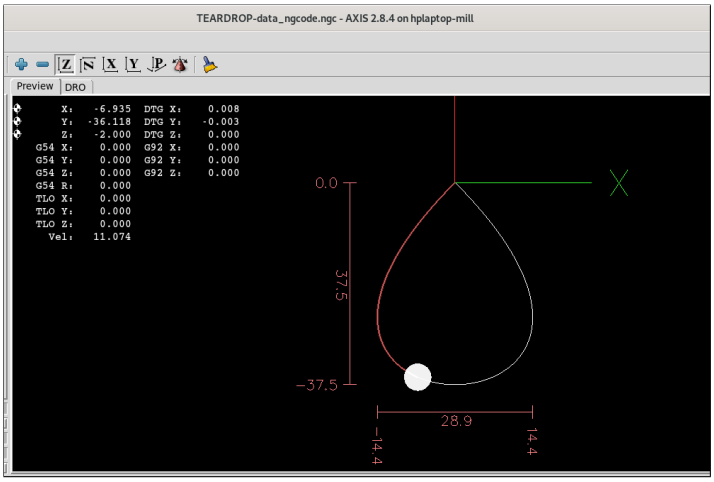
Electrical signal pulses sent to the servo-driver provide information like rotate clockwise (CW), rotate counter-clockwise(CCW), travel distance to rotate, speed to rotate, and so on. The actuation using electrical pulses makes the physical CNC machine instantaneously active.

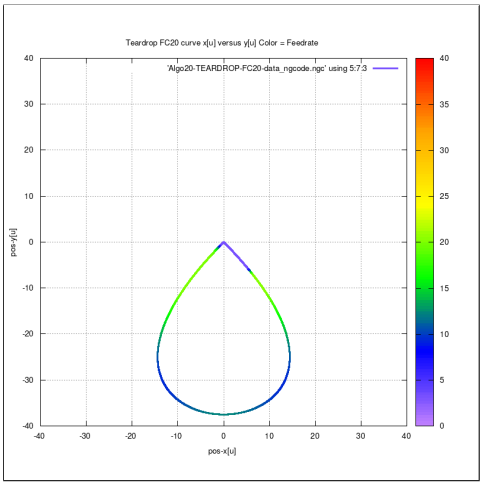
Part 1/5 Teardrop and Butterfly parametric curves

Teardrop parametric curve

$$\begin{aligned} x(u) &= -150u + 450u^2 - 300u^3 \\ y(u) &= -150u + 150u^2 \\ u &\in [0.0, 1.0] \end{aligned}$$

Closed loop
Overall Single loop
Reflection x-axis: non-symmetrical
Reflection y-axis: symmetrical

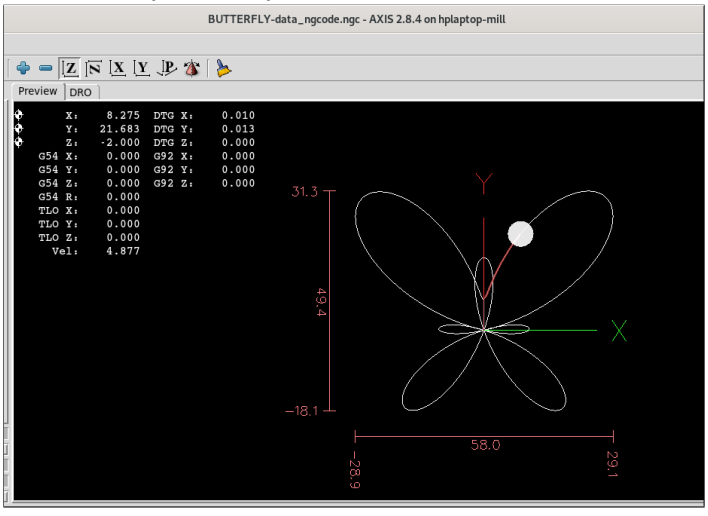


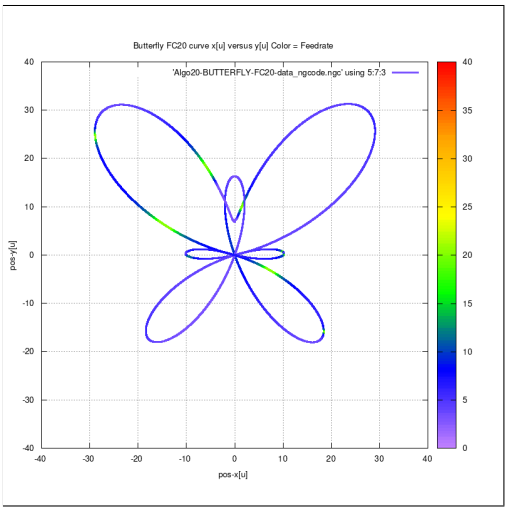


Butterfly parametric curve

$$\begin{aligned} x(u) &= \sin(u)\left[e^{\cos(u)} - 2\cos(4u) - (\sin(u/12))^5\right] \\ y(u) &= \cos(u)\left[e^{\cos(u)} - 2\cos(4u) - (\sin(u/12))^5\right] \\ u &\in [0.0, 2\pi] \end{aligned}$$

Closed loop
Overall Multiple loops
Reflection x-axis: non-symmetrical
Reflection y-axis: symmetrical



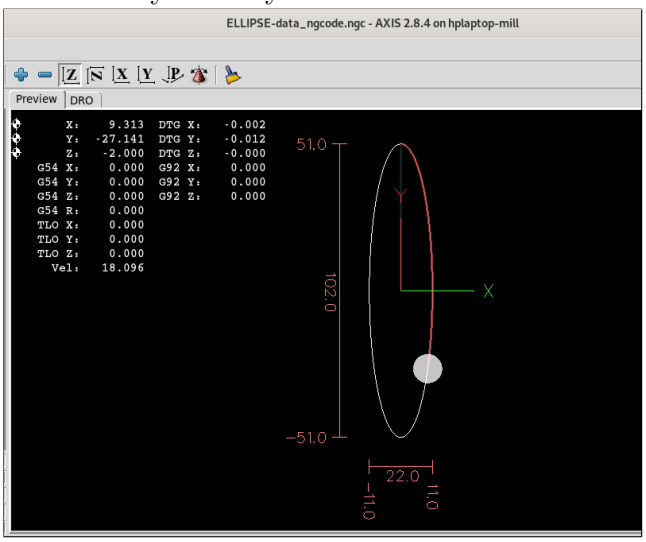


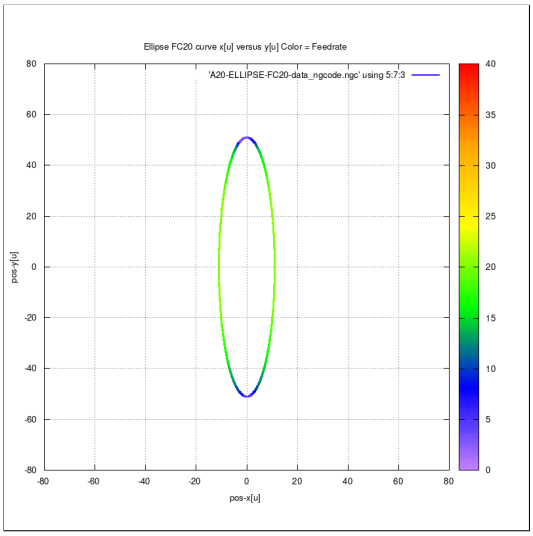
Part 2/5 Ellipse and Skewed-Astroid parametric curves

Ellipse parametric curve

$$\begin{aligned} x(u) &= -150u + 450u^2 - 300u^3 \\ y(u) &= -150u + 150u^2 \\ u &\in [0.0, 1.0] \end{aligned}$$

Closed loop
Overall Single loop, smooth convex curves
Reflection x-axis: symmetrical
Reflection y-axis: symmetrical





Skewed-Astroid parametric curve

$$\begin{aligned} x(u) &= \sin(u)\left[e^{\cos(u)} - 2\cos(4u) - (\sin(u/12))^5\right] \\ y(u) &= \cos(u)\left[e^{\cos(u)} - 2\cos(4u) - (\sin(u/12))^5\right] \\ u &\in [0.0, 2\pi] \end{aligned}$$

Closed loop
Overall Single loop, 4 cusps and 4 concave curves
Reflection x-axis: symmetrical
Reflection y-axis: symmetrical