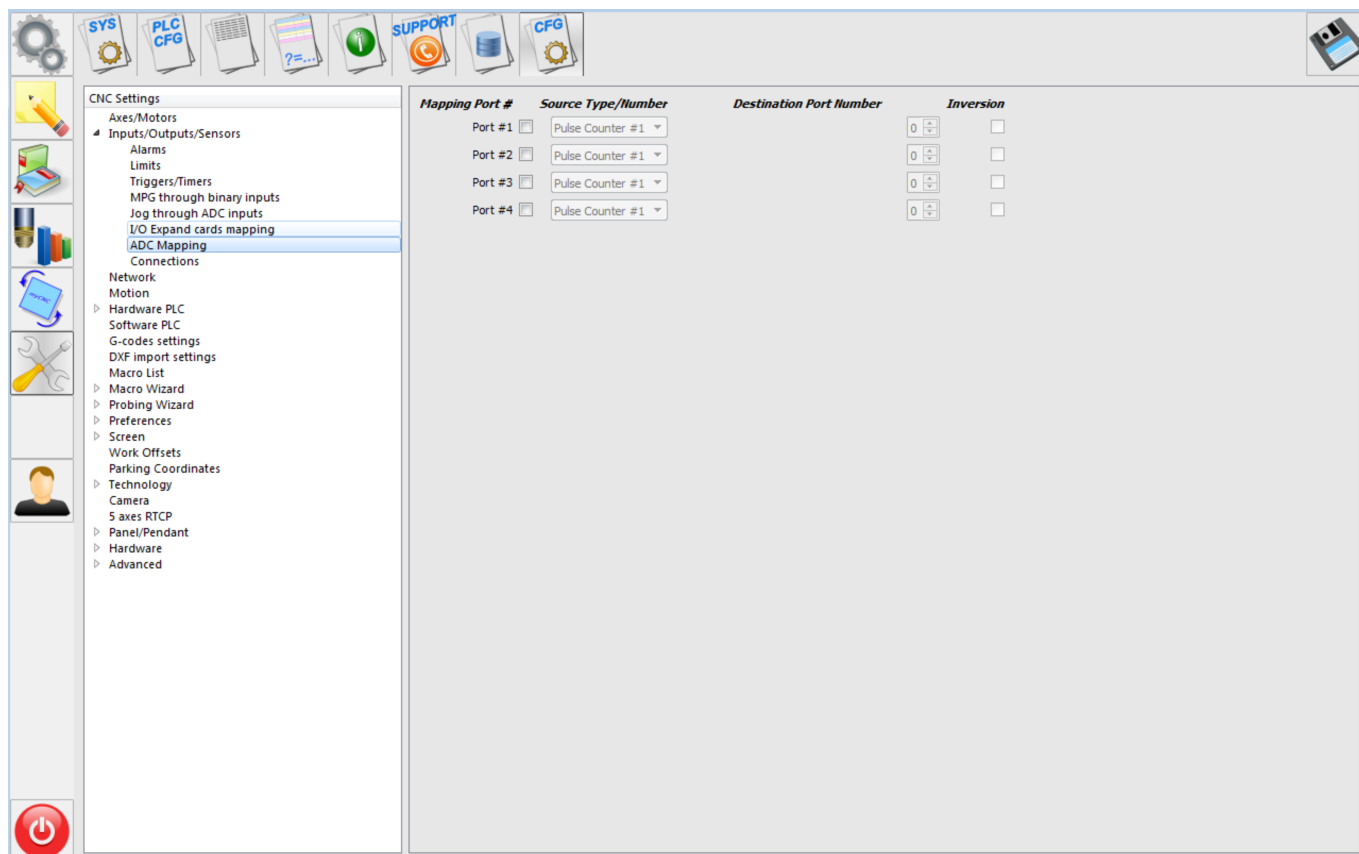


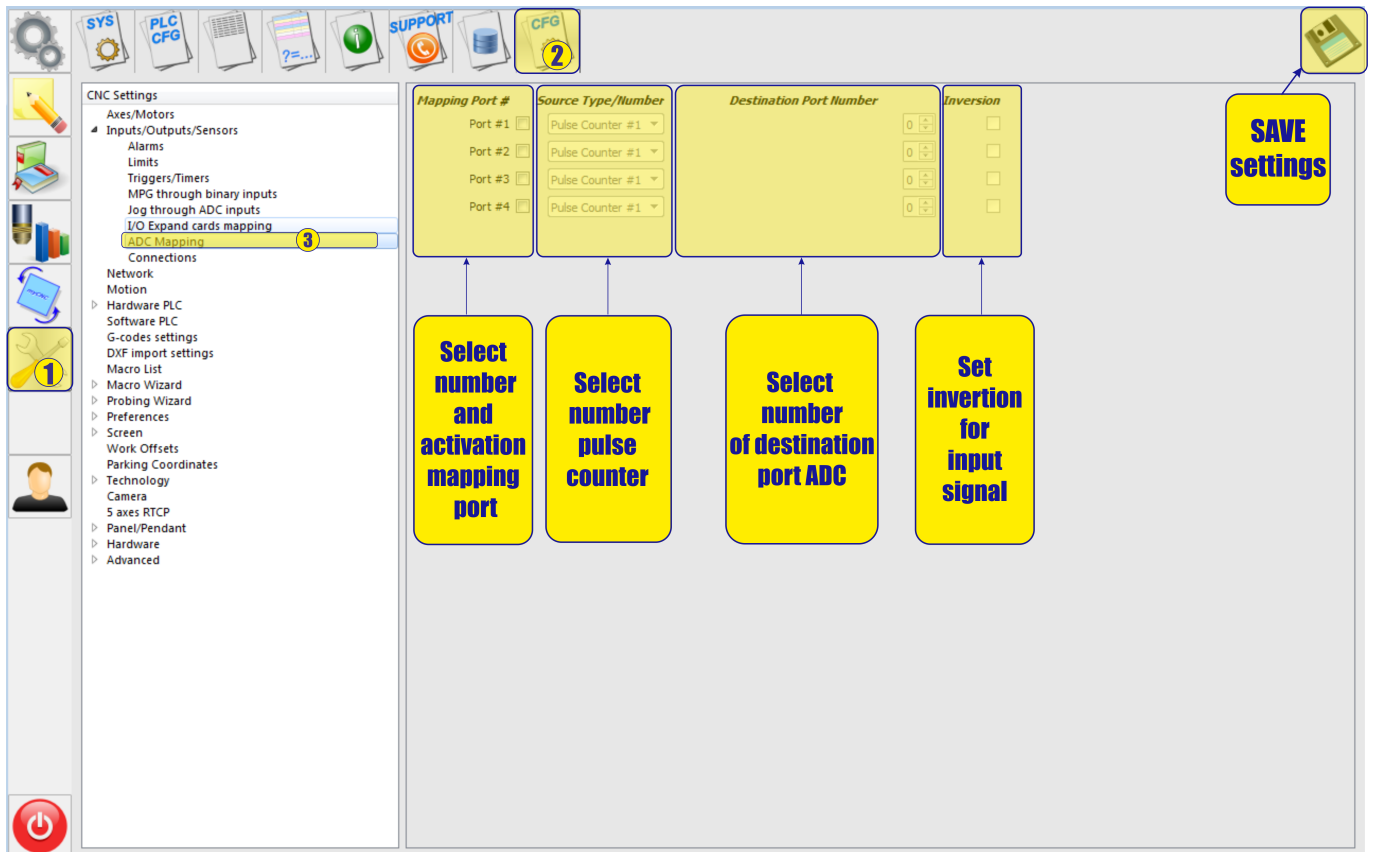
ADC Mapping

- These settings are designed to use sensors with pulse, frequency outputs. The mapping function allows to obtain the calculated pulse value from the sensor and write this value to the register of the selected virtual ADC channel for further processing. For example, this function allows the use of inductive or capacitive sensors with an impulse, frequency output as an odometer for monitoring the height of the instrument.

Main window:



Basic functions:



- To activate this function, simply check the box next to the selected port.

Mapping Port #	Source Type/Number	Destination Port Number	Inversion
Port #1 <input checked="" type="checkbox"/>	Pulse Counter #1 ▼	0	<input type="checkbox"/>
Port #2 <input type="checkbox"/>	Pulse Counter #1 ▼	0	<input type="checkbox"/>
Port #3 <input type="checkbox"/>	Pulse Counter #1 ▼	0	<input type="checkbox"/>
Port #4 <input type="checkbox"/>	Pulse Counter #1 ▼	0	<input type="checkbox"/>

- Next, you must select the counter number to which the sensor is connected. The number of the counter depends on the version of the controller, so please refer to the controller documentation for the correct definition of the counter number.

Mapping Port #	Source Type/Number	Destination Port Number	Inversion
Port #1 <input checked="" type="checkbox"/>	Pulse Counter #1 ▼	1	<input type="checkbox"/>
Port #2 <input type="checkbox"/>	Pulse Counter #1 ▼	0	<input type="checkbox"/>
Port #3 <input type="checkbox"/>	Pulse Counter #1 ▼	0	<input type="checkbox"/>
Port #4 <input type="checkbox"/>	Pulse Counter #1 ▼	0	<input type="checkbox"/>

- Next, select the virtual channel number of the ADC, in which the counter value will be placed in the register. Virtual channels begin their numbering right after the numbers of real ADC channels. I.e. if you have on the controller for example four channels of ADC (ADC0, APC1, APC2, APC3), then the first channel number will be ATSTS5 and you accordingly need to select channel number 5.

Mapping Port #	Source Type/Number	Destination Port Number	Inversion
Port #1 <input checked="" type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #2 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #3 <input type="checkbox"/>	Pulse Counter #2	0	<input type="checkbox"/>
Port #4 <input type="checkbox"/>	Pulse Counter #3	0	<input type="checkbox"/>
	Pulse Counter #4	0	<input type="checkbox"/>
	Pulse Counter #1	0	<input type="checkbox"/>

- Setting channel number 5 of the ADC

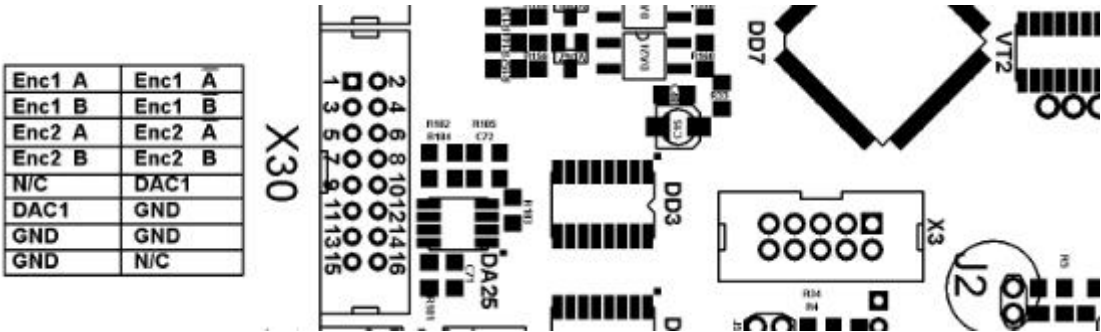
Mapping Port #	Source Type/Number	Destination Port Number	Inversion
Port #1 <input checked="" type="checkbox"/>	Pulse Counter #1	5	<input checked="" type="checkbox"/>
Port #2 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #3 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #4 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>

If it is necessary to invert the value of the sensor, simply check the check box for the desired inversion. Inversion can be useful if, for example, the value from the sensor increases as the distance decreases, but it is necessary that the value of the sensor decreases when the distance is changed.

Mapping Port #	Source Type/Number	Destination Port Number	Inversion
Port #1 <input checked="" type="checkbox"/>	Pulse Counter #1	1	<input checked="" type="checkbox"/>
Port #2 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #3 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #4 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>

Example task: For example, we have an inductive sensor with an impulse frequency output. As you approach the measurement object, the frequency from the sensor increases, and when you move away from the object, the frequency decreases. We have an ET1 controller with (four real inputs of the ADC and two inputs for the counter). Our task is to adjust the height tracking while working on this sensor.

- Decision:
 - Connect the sensor to the input of the counter 1. For this, the inputs ENC1 A and ENC1 B are used.



- Activate channel 1 in the settings menu of the ADC mapping. Select number of counter # 1.

Mapping Port #	Source Type/Number	Destination Port Number	Inversion
Port #1 <input checked="" type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #2 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #3 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #4 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>

3. Since we are connected to the inputs of counter 1, the counter 1 is selected in the menu.

Mapping Port #	Source Type/Number	Destination Port Number	Inversion
Port #1 <input checked="" type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #2 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #3 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #4 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>

4. Since there are four real ADCs on the controller, the first virtual channel will be channel 5 of the ADC. We choose him for work.

Mapping Port #	Source Type/Number	Destination Port Number	Inversion
Port #1 <input checked="" type="checkbox"/>	Pulse Counter #1	5	<input checked="" type="checkbox"/>
Port #2 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #3 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #4 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>

5. For tracking, it is more convenient if the value of the ADC register increases with increasing distance to the object, and decreases when you approach the object. Our sensor works the other way around. Therefore, set the inversion on the selected port.

Mapping Port #	Source Type/Number	Destination Port Number	Inversion
Port #1 <input checked="" type="checkbox"/>	Pulse Counter #1	5	<input checked="" type="checkbox"/>
Port #2 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #3 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>
Port #4 <input type="checkbox"/>	Pulse Counter #1	0	<input type="checkbox"/>

6. Next, we will configure the gap stabilization system to work with the ADC5 channel, in the corresponding menu.

CNC Settings

- Inputs/Outputs/Sensors
 - Alarms
 - Limits
 - Triggers/Timers
 - MPG through binary inputs
 - Jog through ADC inputs
 - I/O Expand cards mapping
 - ADC Mapping
 - Connections
- Network
- Motion
- Hardware PLC
- Software PLC
- G-codes settings
- DXF import settings
- Macro List
- Macro Wizard
- Probing Wizard
- Preferences
- Screen
- Work Offsets
- Parking Coordinates
- Technology
 - Plasma Cutting
 - THC**
 - Lathe
 - Tools
 - Spindle
 - Gas/Oxyfuel
 - Multi Head
 - Laser control

THC enabled ☒ Number of THC 1

THC feedback channel ADC5 ADC0 ADC0 ADC0

Arc Voltage Ref 1284.99 0 0 0

ADC/Voltage ratio 0.07

Alarm Move Up (if difference between measured and reference voltage more than given value, alarm detected, torch is moved up) 5000

THC Maximum Speed 2000 Acceleration Ratio (20 by default) 20

THC Low Speed (Height control is suspended, when current speed lower than given value) ☒ 60

Alarm Arc Voltage Difference, V (If Difference between Measured Arc Voltage and Reference is more than given value, THC is suspended for "THC delay") 300

Alarm Arc Voltage Rise, V (If Measured Arc Voltage Rise per 8ms is more than given value, THC is suspended for "THC delay") 300

THC delay, s 1

Hi/Lo event output port 63 (*)Default port value is 63

THC PI-control P ratio -10 -10

THC PI-control I ratio 0 0

THC pre-off, s 2 Cutting pre-off, s 0

Accept jog while THC activated ☒

Turn On THC Debug on USB ☐

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