

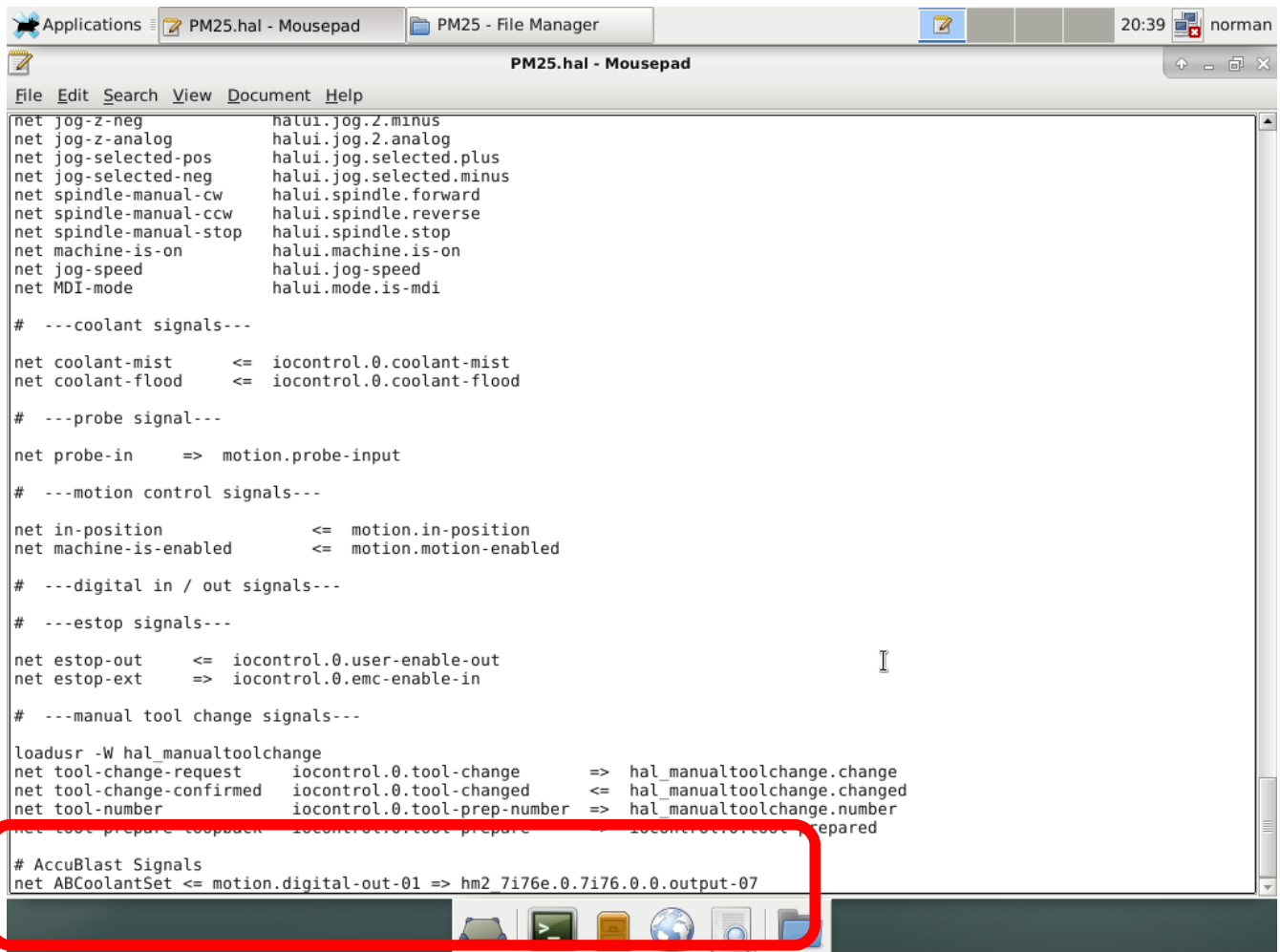
LinuxCNC AccuBlast Configuration

Assumptions

This document assumes that you have a working LinuxCNC configuration and that your AccuBlast unit is correctly wired. Choose an output to wire to the Pulse pin of the AccuBlast controller. Note which output is wired to the AccuBlast unit.

HAL Changes

Open the HAL file for your LinuxCNC configuration. We will connect the output from your controller to a signal from an M62 code. In this example, a Mesa 7i76e controller is used. Copy the indicated line, replacing “hm2_7i76e.0.7i76.output-07” with the designation for your controller and the appropriate output number. Eg, for a parallel port controller, enter “parport.0.pin-10-out” to connect your AccuBlast unit to pin 10.



```
Applications | PM25.hal - Mousepad | PM25 - File Manager | 20:39 | norman
PM25.hal - Mousepad
File Edit Search View Document Help
net jog-z-neg          halui.jog.2.minus
net jog-z-analog      halui.jog.2.analog
net jog-selected-pos  halui.jog.selected.plus
net jog-selected-neg  halui.jog.selected.minus
net spindle-manual-cw halui.spindle.forward
net spindle-manual-ccw halui.spindle.reverse
net spindle-manual-stop halui.spindle.stop
net machine-is-on     halui.machine.is-on
net jog-speed         halui.jog-speed
net MDI-mode          halui.mode.is-mdi

# ---coolant signals---
net coolant-mist      <= iocontrol.0.coolant-mist
net coolant-flood     <= iocontrol.0.coolant-flood

# ---probe signal---
net probe-in         => motion.probe-input

# ---motion control signals---
net in-position       <= motion.in-position
net machine-is-enabled <= motion.motion-enabled

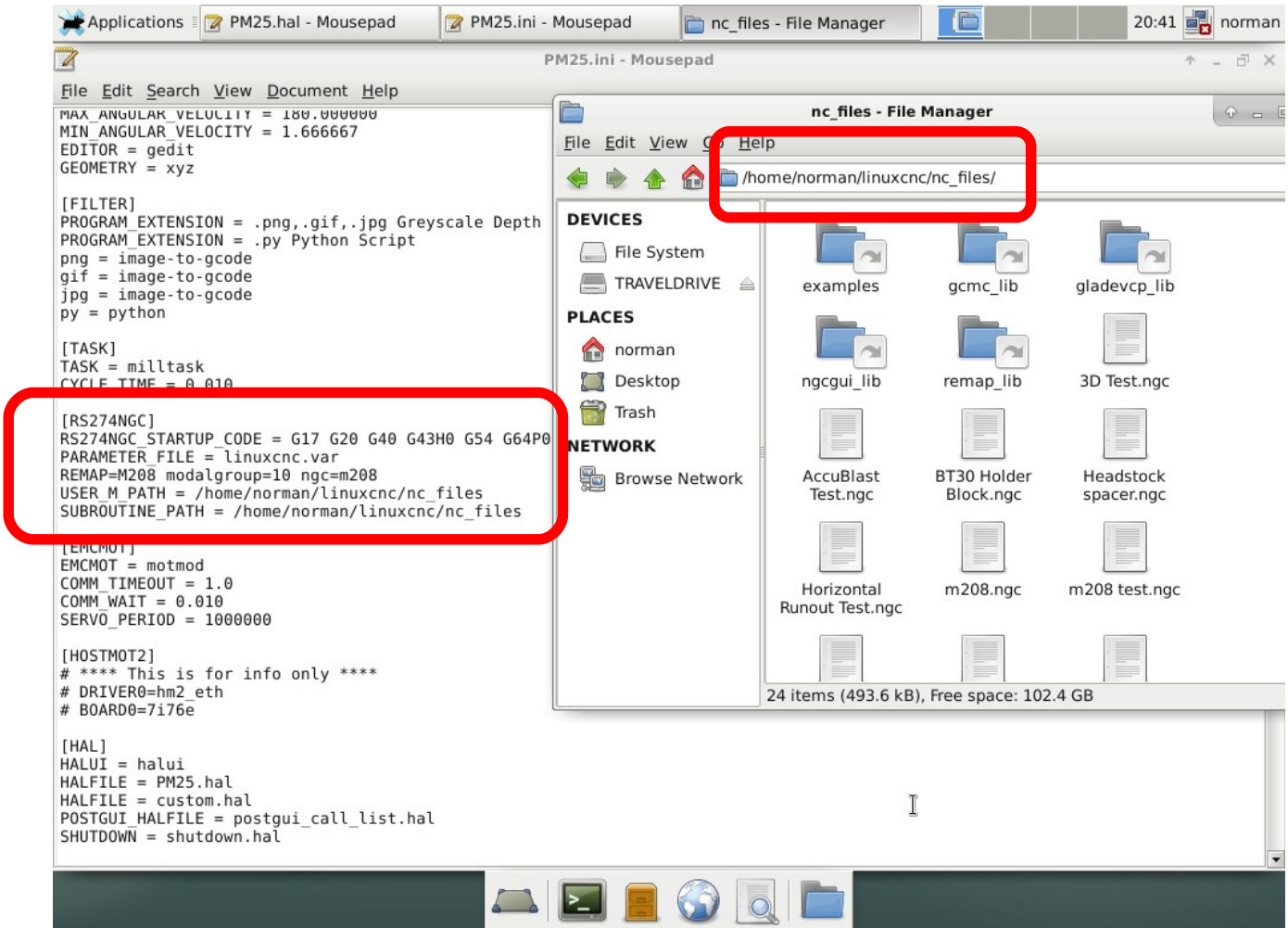
# ---digital in / out signals---
# ---estop signals---
net estop-out         <= iocontrol.0.user-enable-out
net estop-ext         => iocontrol.0.emc-enable-in

# ---manual tool change signals---
loadusr -W hal_manualtoolchange
net tool-change-request iocontrol.0.tool-change => hal_manualtoolchange.change
net tool-change-confirmed iocontrol.0.tool-changed <= hal_manualtoolchange.changed
net tool-number         iocontrol.0.tool-prep-number => hal_manualtoolchange.number
net tool-prep-number    iocontrol.0.tool-prep-number => hal_manualtoolchange.prepared

# AccuBlast Signals
net ABCoolantSet <= motion.digital-out-01 => hm2_7i76e.0.7i76e.0.0.output-07
```

INI Changes

Open the INI file for your LinuxCNC configuration. Here we need to tell LinuxCNC where the M208 macro is located. Copy the “REMAP”, “USER_M_PATH”, and “SUBROUTINE_PATH” lines to your INI file. Replace “norman” with the name of your PC. It is recommended to create a folder just for your macro programs to prevent accidental deletion.



File Changes

In the folder you specified in your INI file, copy the M208 macro.

Macro Operation

After a tool change, add “M208” to your G code file to update the AccuBlast unit’s tool offset. It is not necessary to specify the tool number with M208.

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