

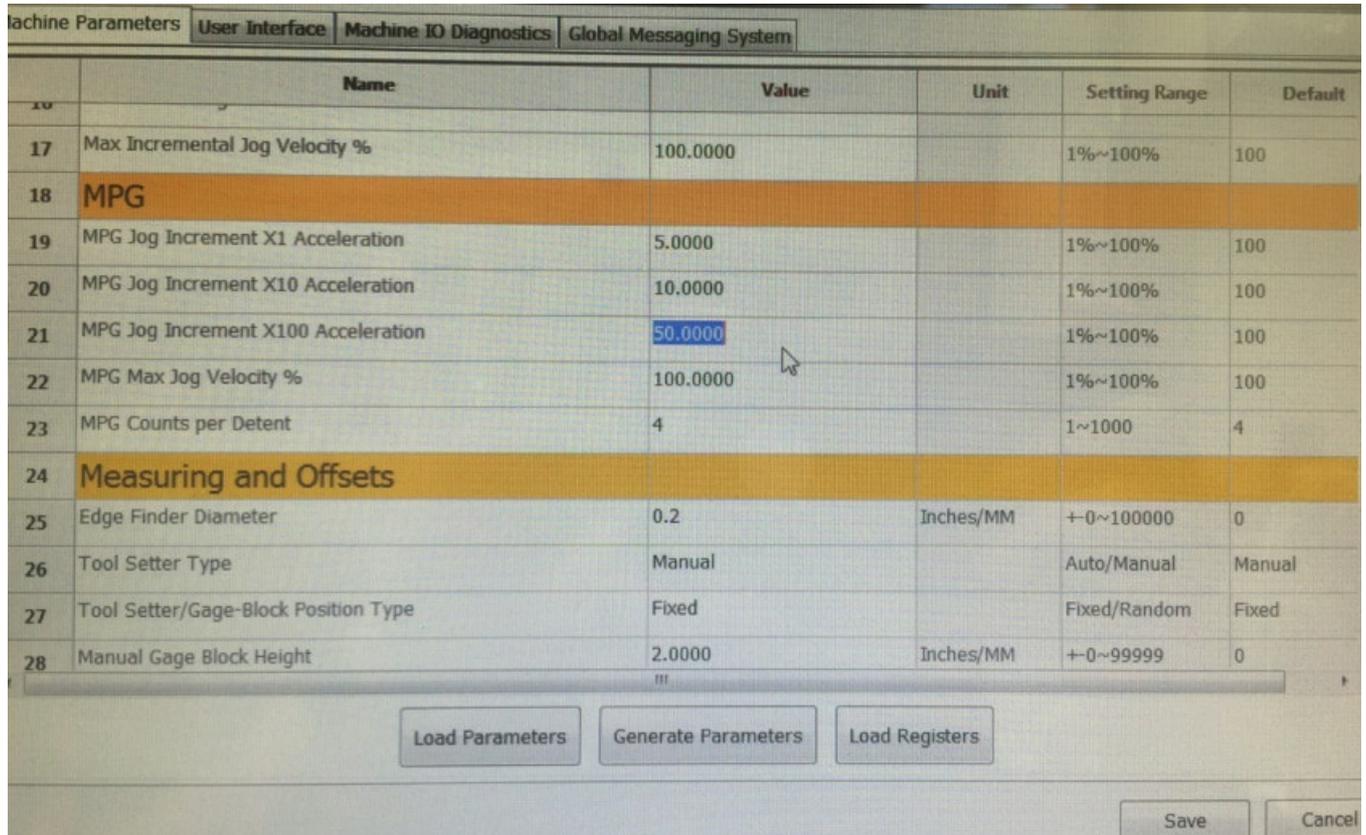
# Pendant Info-Mach4

## Adjusting Pendant Acceleration

You can adjust the pendant acceleration by going to the Settings Tab and selecting Machine Calibration (2000 series select service tab, then Interface config button under settings section).

Scroll down until you see MPG Jog Increment Acceleration (or use search box: MPG).

You can enter in values between 1-100. You should test the jogging with the pendant to make sure that it is jogging smoothly on all increments.



The screenshot shows a software interface for configuring machine parameters. At the top, there are tabs for 'Machine Parameters', 'User Interface', 'Machine IO Diagnostics', and 'Global Messaging System'. Below the tabs is a table with columns for 'No.', 'Name', 'Value', 'Unit', 'Setting Range', and 'Default'. The table lists various parameters, with rows 17 through 23 highlighted in orange. Row 21, 'MPG Jog Increment X100 Acceleration', has its value '50.0000' highlighted in blue. Below the table are three buttons: 'Load Parameters', 'Generate Parameters', and 'Load Registers'. At the bottom right, there are 'Save' and 'Cancel' buttons.

No.	Name	Value	Unit	Setting Range	Default
17	Max Incremental Jog Velocity %	100.0000		1%~100%	100
18	MPG				
19	MPG Jog Increment X1 Acceleration	5.0000		1%~100%	100
20	MPG Jog Increment X10 Acceleration	10.0000		1%~100%	100
21	MPG Jog Increment X100 Acceleration	50.0000		1%~100%	100
22	MPG Max Jog Velocity %	100.0000		1%~100%	100
23	MPG Counts per Detent	4		1~1000	4
24	Measuring and Offsets				
25	Edge Finder Diameter	0.2	Inches/MM	+0~100000	0
26	Tool Setter Type	Manual		Auto/Manual	Manual
27	Tool Setter/Gage-Block Position Type	Fixed		Fixed/Random	Fixed
28	Manual Gage Block Height	2.0000	Inches/MM	+0~99999	0

## Adjusting Jog Increments

**NOTE:** The Jog Increments section (shown below) can be accessed from the configure menu option, then control. The on-screen Jogging Increments cycles through the entire Jog Increments section positions, while the Pendant X1, X10, and X100 knob settings increments through positions 3, 4, and 5 if units mode is inches (outlined in blue below), and positions 8, 9, and 10 (outlined in green below) if units mode is metric. The image below has the position numbers entered in as the values for better explanation. Your values would more likely be 1, .100, .01, .001 or 25.4, 2.54, .254 for example.

Jog Increments (0 = disable)

Position 1	1
	2
inches	3
	4
	5
	6
	7
mm	8
	9
Position 10	10

- If a position has a 0 then it will not be cycled through the jog increments for on-screen jogging
- X1, X10, and X100 on pendant is position 5, 4, and 3 in the jog increments setting for inches or 10, 9, and 8 for metric, respectively (X1 is position 5 and 10, X10 is position 4 and 9, and X100 is position 3 and 8). For example, using the photo above:
  - An X1 pendant setting with units setup for inches, would be a commanded move of 5 inches and if setup for metric units would be 10mm.
  - An X100 pendant setting with units setup for inches, would be a commanded move of 3 inches and if setup for metric units would be 8mm.

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