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Service Information

This section contains information regarding factory service for the ESP300 System. The user should not attempt any maintenance or service of the system or optional equipment beyond the procedures outlined in this manual. Any problem that cannot be resolved should be referred to Newport Corporation.
EU DECLARATION OF CONFORMITY

We declare that the accompanying product, identified with the ČE mark, complies with requirements of the Electromagnetic Compatibility Directive, 89/336/EEC and Low Voltage Directive 73/23/EEC.

Model Number: ESP300
Year ČE mark affixed 1999

Type of Equipment:
Electrical equipment for measurement, control and laboratory use

Standards Applied:
Compliance was demonstrated to the following standards to the extent applicable:

BS EN61326: 1998 “Electrical equipment for measurement, control and laboratory use – EMC requirements”

This equipment meets the CISPR 11 Class A radiated and conducted emission limits.

BS EN 61000-3-2, Harmonic current emissions, Class A
BS EN 61000-3-3, Voltage fluctuations and flicker
BS EN 61010-1 “Safety requirements for electrical equipment for measurement, control and laboratory use”

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EU Declaration of Conformity
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1.1 Scope

This manual provides descriptions and operating procedures for the integrated 3 axis ESP300 Controller/Driver (ESP = Enhanced System Performance). There are two configurations available:

ESP300 - XXXXX1: 150W Power Supply Models
ESP300 – XXXXX2: 400W Power Supply Models

Safety considerations, conventions and definitions, and a system overview are provided in Section 1, Introduction.

Procedures for unpacking the equipment, hardware and software requirements, descriptions of controls and indicators, and setup procedures are provided in Section 1, Introduction.

Instructions for configuring and powering up the ESP300 and stage motors, for home and jog motions, and for system shut-down are provided in Section 1, Introduction.

Overview of operating modes (LOCAL and REMOTE) and Menu Options in LOCAL Mode are provided in Section 2, Modes of Operation.

Motion commands, language-specific information, and error-handling procedures are provided in Section 3, Remote Mode.

An overview of motion parameters and equipment is provided in Section 4, Motion Control Tutorial.

Servo tuning principles and procedures are given in Section 5.

Procedures for ordering, installing, and using optional equipment are provided in Section 6.

The following information is provided in the Appendices:

- Error messages
- Trouble-shooting and maintenance
- Connector pin assignments
- Decimal/ASCII/binary conversion table
- System upgrades for software and firmware
- Factory service
The following general safety precautions must be observed during all phases of operations of this equipment. Failure to comply with these precautions or with specific warnings elsewhere in this manual violates safety standards of design, manufacture, and intended use of the equipment.

Disconnect or do not plug in the power cord in the following circumstances:

- If the power cord or any other attached cables are frayed or damaged.
- If the power plug or receptacle is damaged.
- If the unit is exposed to rain or excessive moisture, or liquids are spilled on it.
- If the unit has been dropped or the case is damaged.
- If you suspect service or repair is required.
- When you clean the case.

To protect the equipment from damage and avoid hazardous situations, follow these recommendations:

- Do not make modifications or parts substitutions.
- Return equipment to Newport Corporation for service and repair.
- Do not touch, directly or with other objects, live circuits inside the unit.
- Keep air vents free of dirt and dust.
- Do not block air vents.
- Keep liquids away from unit.
- Do not expose equipment to excessive moisture (>90% humidity).

**WARNING**

All attachment plug receptacles in the vicinity of this unit are to be of the grounding type and properly polarized. Contact an electrician to check faulty or questionable receptacles.
WARNING

This product is equipped with a 3-wire grounding type plug. Any interruption of the grounding connection can create an electric shock hazard. If you are unable to insert the plug into your wall plug receptacle, contact an electrician to perform the necessary alterations to assure that the green (green-yellow) wire is attached to earth ground.

WARNING

This product operates with voltages that can be lethal. Pushing objects of any kind into cabinet slots or holes, or spilling any liquid on the product, may touch hazardous voltage points or short out parts.

WARNING

When opening or removing covers observe the following precautions:

- Turn power OFF and unplug the unit from its power source
- Remove jewelry from hands and wrists
- Use insulated hand tools only
- Maintain grounding by wearing a wrist strap attached to instrument chassis.

1.3 Conventions and Definitions

This section provides a list of symbols and their definitions, and commonly used terms found in this manual.

1.3.1 Definitions and Symbols

The following are definitions of safety and general symbols used on equipment or in this manual.
WARNING

Calls attention to a procedure, practice or condition which, if not correctly performed or adhered to, could result in injury or death.

CAUTION

Calls attention to a procedure, practice, or condition which, if not correctly performed or adhered to, could result in damage to property or equipment.

NOTE

Calls attention to a procedure, practice, or condition that is considered important to remember in the context.

This symbol indicates the principle On/Off push-push switch is in the ON position when pressed in, and in the OFF position when depressed.

Protective conductor terminal

Caution, risk of electric shock

Caution (refer to accompanying documents)
1.3.2 Terminology

The following is a brief description of the terms specific to motion control and the ESP300 Motion Controller/Driver.

**Axis** – a logical name for a stage/positioner/motion device

**Encoder** – a displacement measuring device, term usually used for both linear and rotary models.

**ESP** – Enhanced System Performance motion system is comprised of compatible stage(s). ESP is synonymous with a plug-and-play motion system.

**ESP – compatible** – refers to Newport Corporation stage with its own firmware-based configuration parameters. Newport stages or other stages without this feature are referred to as being not ESP-compatible and must be uniquely configured by the user.

**Home (position)** – the unique point in space that can be accurately found by an axis, also called origin.

**Jog** – a motion of undetermined-length, initiated manually.

**Motion device** – electro-mechanical equipment. Used interchangeably with stage and positioner.

**Move** – a motion to a destination

**Origin** – used interchangeably with home

**PID** – a closed loop algorithm using proportional, integral, and derivative gain factors for position control

**Positioner** – used interchangeably with stage and motion device

**Stage** – used interchangeably with motion device and positioner
1.4 System Overview

The Enhanced System Performance (ESP) architecture consists of the ESP300 Controller/Driver and ESP-compatible stages. The ESP300 is an advanced stand-alone controller with integrated motor drivers. It can control and drive up to 3 axes of motion in any stepper and DC motor configuration.

The ESP plug-and-play concept significantly increases user friendliness and improves overall motion performance.

The ESP300 is used as a stand-alone controller to drive an ESP motion device. All components are designed for optimal performance.

1.4.1 Features

A number of advanced features make the ESP300 an excellent choice for many applications:

- Integrated controller and driver design is cost effective and space saving
- Compact, standard 2U height rack mountable or bench-top enclosure
- Allows any combination of motor types (2 phase stepper and brush DC) up to 3A, 48V per axis
- Digital Signal Processing architecture
- Real-time high speed command processing
- Powerful commands for most demanding applications
- Motion program storage (up to 99 programs) in 64kB non-volatile memory
- Advanced motion programming capabilities and complex digital I/O functions
- User selectable displacement units
- Optional full-featured front panel with position and status displays for each axis, push-buttons for simple motion sequences and access to an elaborate menu that allows setup of the system without use of a computer
- Optional handheld keypad for full access to ESP300 command set without computer.
1.4.2 Specifications Function:

- Integrated motion controller and driver.

Number of motion axes:

- 1 to 3, in any combination or order of 2 phase stepper and brush DC motors, up to 48VDC, 3A per axis.

Trajectory type:

- Trapezoidal velocity profile
- S-curve velocity profile.

Motion device compatibility:

- Family of motorized Newport motion devices, using either stepper or DC motors
- Custom motion devices (call for compatibility).

DC motor control:

- 18 bit DAC resolution
- 4 MHz maximum encoder input frequency
- Digital PIDFF servo loop, 0.4 ms update rate.

Stepper motor control:

- Up to 1000 microstep resolutions per full step.

Computer Interface:

- RS232-C, 19200 baud, 8 bits, 8, N, 1
- IEEE-488 – optional, Please contact Newport for information

Utility interfaces:

- 16 bit digital inputs/outputs, user definable, in blocks of 8.
- Remote motor off input (interlock).

User Memory:

- 64 KB non-volatile program memory
- 512 byte command buffer

Operating modes:

- Local mode – stand-alone operation, executing motion from the front panel
- Remote mode – executing commands received over one of the computer interfaces or the optional handheld keypad
- Program execution mode – execution of a stored program.
Optional display:
- 80 character alpha-numeric LCD display
- Displays position, status, utility menus and setup screens.

Dimensions:
- 3" (2U) H x 16.5" W x 12" D (75 x 412 x 300 mm) for ESP300-XXXXX1 Models
- 3" (2U) H x 16.5" W x 13.5" D (75 x 412 x 342.9 mm) for ESP300-XXXXX2 Models

Power requirements:
- 100-240VAC ±10%, 50/60 Hz
- 4A max for ESP300 - XXXXX1 Models
- 6.3A max for ESP300 - XXXXX2 Models

Fuses:
- T4A / 250VAC for XXXXX1 Models
- T6.3A/250VAC for XXXXX2 Models

Weight:
- 10.90Lbs. max (4.9kg) max for ESP300 - XXXXX1 Models
- 14.05Lbs. max (6.37kg) max for ESP300 - XXXXX2 Models

Operating conditions:
- Temperature: 0°C to 40°C
- Humidity: 20% to 90% RH, non-condensing

Other:
- Pollution degree :2
- Installation category: II
- Altitude: <2000m
- Instrument use: the model ESP300 is intended for indoor use only.

1.4.3 Descriptions of Front Panel Versions
The ESP300 is available with either a blank front panel or a front panel with LCD display and manual control buttons. With the display version, a menu allows the user to change velocities, accelerations and more, without a computer interface.
FRONT PANEL DISPLAY
A general view of the front panel is shown in (Figure 1.2). There are two distinct areas: a display/menu section and a motion/home section that allows simple manual motion sequence like JOG and HOMING.

![ESP300 Front Panel with Displays](image)

Figure 1.2: ESP300 Front Panel with Displays

BLANK FRONT PANEL
This version does not provide a display or local operation.

Power Section
The black push button type switch on the lower left corner is used to turn power On or Off. The on state is indicated with a green LED above the push-button.

1.4.4 Rear Panel Description

NOTE
See Appendix C for pin-outs.

AXIS CONNECTORS (AXIS 1 – AXIS 3)
There are up to three 25-pin D-Sub connectors on the rear panel, one for each axis. Unused axes have blank panels.
+/-GPIO CONNECTOR

This is a 37-pin D-Sub connector used for general purpose, digital Input/Output signals. A variety of commands are available to control these ports. See Section 3, Remote Mode and Appendix C for Connector Pin Outs.

AUXILIARY ENCODER

This 25 pin D-Sub connector provides input for 3 auxiliary encoder channels (axis 4, 5, 6). For signal description, see Section C.1.4. These channels can be used for master-slaving (see Section 4.2), trackball and other applications. Additionally, 4 digital I/O pins are provided (See Section C.1.2).

MOTOR INTERLOCK CONNECTOR

The coaxial connector provides remote motor power interlock capability. One or more external switches can be wired to remotely inhibit the motor power in a way similar to the Stop All button on the front panel.

The controller is shipped with a mating connector that provides the necessary wiring to enable proper operation without an external switch.

RS232-C CONNECTOR

The RS232-C interface to a host computer or terminal is made through this 9 pin D-Sub connector. The pin out enables the use of an off-the-shelf, pin-to-pin cable.

IEEE-488 CONNECTOR
This is a standard 24 pin connector to interface with a standard IEEE-488 device.

Note:
This is an optional feature.

POWER ENTRY MODULE

The power entry section on the right side of the rear panel provides a standard IEC 320 inlet, a fuse holder, and a binding post to ground the controller if the main power supply wiring does not provide earth ground terminals.

1.5 System Setup

This section guides the user through the proper set-up of the motion control system.

Carefully unpack and visually inspect the controller and stages for any damage.

Place all components on a flat and clean surface.

1.5.1 Line Voltage

NOTE

The controller can operate from 100-240VAC, ±10%, at a frequency of 50/60 Hz.

1.5.2 First Power ON

Plug the AC line cord supplied with the ESP300 into the power entry module on the rear panel.

CAUTION

Do not block AC line cord entry area for disconnecting purpose.

Plug the AC line cord into the AC wall-outlet.

Push in the POWER switch on the lower left side of the front panel.

Shortly after the power is switched on, the ESP300 with front panel display will perform a start-up sequence as described below.

• Momentarily display: "Newport ESP300" and the Firmware Version
• Momentarily show the stage type that is connected. Since there should be no stages connected at this point, the "NO STAGE" message is displayed for all axes.

**NOTE**

Any time you call for technical support, the firmware version is essential to trouble-shoot a problem. It is displayed every time the controller power is turned on. Users of the blank front panel can query the version with the "VE" command (see Section 3, Remote Mode).

# 1.6 Quick Start

This section serves as a quick start for ESP300 with front panel display only.

The following paragraphs guide you through a very basic motion sequence that verifies that the system is working properly.

## 1.6.1 Connecting Motion Devices

**NOTE**

Never connect/disconnect stages while the ESP300 is powered on. Power the ESP300 off.

If an ESP motion control system was purchased, all necessary hardware for set-up is included.

With ESP compatible stages, the configuration of each axis is identified automatically by the ESP300 at power up. ESP compatible stages are visually identified with a blue "ESP Compatible" sticker, on the stage.

Carefully connect one end of the supplied cables to the stage and the other end to the appropriate axis connector on the rear of the controller. Secure both connectors with the locking thumb-screws.
Users of the ESP300 with blank front panel can skip to Section 3, Remote Mode.

1.6.2 Motor On

After the controller and the stages are connected as described, the motors can be powered on.

Make sure that the motion devices are placed on a flat surface and their full travel is not obstructed.

---

**CAUTION**

Be prepared to quickly turn the motor power off by pressing the STOP ALL button or power switch if any abnormal operation is observed.

---

After the power switch is pushed in, the controller performs the start-up sequence as described in Section 1.5.2.

The default state after start-up is motor power off:

To apply power to the motors, press the button on the right of the display to enable power for the respective axis. The ON state of the motor power is indicated on the display. Blank Front Panel must use external interface to enable motor power.

1.6.3 Homing

**HOME Search**

The HOME Search routine is a sequence of motion segments through which the controller determines the exact location of a home (origin) switch. A detailed description of the algorithm can be found in the Motion Control Tutorial (Section 5).

---

**NOTE**

It is recommended that the user perform a home search routine after each controller power-on. The controller must know the exact initial position of the motion device not only to accurately repeat a motion sequence (program) but also to prevent it from hitting the travel limits (limit switches).

---

To perform a home search routine, press the home function key for the respective axis.
The display will indicate that a home routine is in progress with to the left of the axis number.

NOTE

The position value is reset at the home position.

Only one axis can be homed at a time; i.e., even if multiple homing commands are issued, the prior axis has to finish homing before the second can start homing.

1.6.4 First Jog

If left jog key is pressed, the selected axis will move slowly in the negative direction. To move a single step at a time, press this switch once. See Section 2.2.4 for details.

If right jog key is pressed, the selected axis will move slowly in the positive direction. To move a single step at a time, press this switch once. See Section 2.2.4 for details.

If the HIGH SPEED key between the jog keys is pressed simultaneously with one of the jog keys, the axis will jog fast in the selected direction. See Section 2 for setting of high speed rate.

At this point, you may proceed to Section 2 of this manual, to get familiar with the controller and the local motion modes.

NOTE

Remember that only motions inside the software travel limits are allowed (see 'SL' command in Section 3, Remote Mode). Any move outside these limits will be ignored.
Section 2 – Modes of Operation

2.1 Overview of Operating Modes

The ESP300 can be operated in two basic modes:

- LOCAL mode
- REMOTE mode

2.1.1 LOCAL Mode

This mode is applicable only if your unit is equipped with the optional front panel display. If your ESP300 is equipped with the blank front panel, you may skip to the REMOTE Mode Section 3.

In LOCAL Mode the user has access to a sub-set of the ESP300 command set. In this Mode, the ESP300 is controlled by pressing the menu key and axis push-buttons on the front panel.

Using this mode, the user can adjust motion parameters like velocity and acceleration without using a computer or terminal.

NOTE

See Section 2.2 for a detailed description of the front panel.

2.1.2 REMOTE Mode

In COMMAND Mode, the ESP300 receives motion commands through one of its interfaces (IEEE488 or RS232-C) using a computer or terminal. Additionally, an optional alphanumeric keypad with an LCD display enables the user to access the full command set of the ESP300 without the use of a computer interface (See Section 7.1.2).

In this mode, the ESP300 employs a set of over 100 commands. Please refer to Section 3 (Remote Mode) for a detailed description of the ESP300 command set.

In Program Execution Mode, internally stored programs are executed (See Section 3.1)
2.2 Operation in LOCAL Mode

This section provides a detailed explanation of the LOCAL mode. Typical parameters that can be set are velocity, acceleration, PID values for DC motors, and many more. Please remember that all menu items can also be accessed with remote commands (See Section 3, Remote Mode).

2.2.1 Accessing the Menu

(Figure 2.1) shows the menu section of the front panel. The menu listing can be accessed by pressing the Menu key at the bottom of the display.

![Menu Section Diagram]

2.2.2 Navigating the Menu

Once in the menu listing, the x-y buttons shown on the left become active, as indicated with a green LED in the center of the buttons. With these four buttons, it is possible to access all available menu items and change values where applicable.

The Up and Down arrow buttons scroll through the available Menu list.

The Right arrow button selects a menu item, the Left arrow button de-selects a menu item.

2.2.3 Changing Values

This example serves as an illustration of how to change values within a menu item.
1. Press *Menu* to enter the menu listing.
2. Press the *Down Arrow* repeatedly until the cursor (diamond shaped) is aligned with the SET VELOCITY menu item.
3. Press the *Right Arrow* button once. Now, a sub-menu list becomes available.
4. Press the *Right Arrow* button to select the SET LO JOG VEL menu item. The screen shown below is displayed at this time.

![Figure 2.2: Menu Item](image)

5. Press the *Right Arrow* button once. One digit on the display flashes at this point indicating that it can be changed. The digit can be incremented with the *Up Arrow* button or decremented using the *Down Arrow* button. Other digits can be changed similarly.
6. The set value can now be validated by pressing the *OK* button or cancelled by pushing the *CX* button. Also, if you choose to exit this menu item with the *Left Arrow* key, the set value will also be valid.

**2.2.4 Motion from the Front Panel**

As shown in *(Figure 2.3)*, the right side of the front panel accommodates simple manual notion capabilities.

![Figure 2.3: Motion from the Front Panel Displayed](image)
Move in Negative Direction with low speed. This button can be programmed to cause motion in user definable increments or to move as long as it is pressed. See SET JOG MODE and SET VELOCITY menu items in Section 2.2.5.

Move in Positive Direction with low speed. This button can be programmed to cause motion in user definable increments or to move as long as it is pressed. See SET JOG MODE and SET VELOCITY menu items in Section 2.2.5.

Move with High Speed. This button is active only when pushed simultaneously with either move button above. See SET VELOCITY menu items in Section 2.2.5.

Home Respective Axis. See SET HOME MODE and SET VELOCITY menu items in Section 2.2.5.

Stop All Motion. When this button is pressed, all motion is stopped and the red LED above the button is illuminated temporarily. This button is equivalent to the Interlock connector on the rear of the unit. The LED is also illuminated when the interlock connector on the rear of the unit is activated. See ZE command in Section 3: Remote Mode, for further information.

An optional handheld keypad can be connected to the ESP300 through this receptacle. Refer to Section 7: Optional Equipment, for a detailed description of the keypad.
2.2.5 Detailed Description of Menu Items

**TOP OF MENU**

- **GET ERRORS**
  - **Note**: This menu item is only displayed if there is an error in the queue.

- **RESET POSITION**

- **RUN PROGRAMM**

- **SET VELOCITIES**
  - **SET LO JOG VEL**
  - **SET HIGH JOG VEL**
  - **SET HOME VEL**

- **SET ACCEL/DECEL**
  - **SET ACCELERATION**
  - **SET DECELERATION**

- **SET JOG MODE**
  - **RUN INCREMENT**

- **SET HOME MODE**
  - **SW / INDEX**
  - **SW**

- **SET PID**
  - **SET KP**
  - **SET Ki**
  - **SET KD**
  - **SET IL**
  - **SET FE**

- **GET STAGE MODEL**

- **GET RS232 CONFIG.**

- **SAVE PARAMETERS**
GET ERRORS
This menu item allows the user to get the errors that are stored in the error queue. The error queue can store up to 10 errors. If the number of errors exceeds ten, the oldest errors are created.

TE or TB - Tell error or Tell buffer

RUN PROGRAM
Programs can be entered or downloaded to the ESP300 through its standard interfaces (IEE-488 or RS-232). The ESP300 is capable of storing up to 99 different programs in its non-volatile program memory (25KB total). This menu allows execution of any of the stored programs.

1EX - Execute program 1

SET VELOCITIES
This menu makes it possible to change velocities that are used with the jog and home search buttons. The following sub-menus are available:

SET LOW JOG VEL
Sets the velocity of the stage when either jog button is pushed.

JL - Set low jog velocity

SET HI JOG VEL
Sets the velocity of the stage when either jog button is pushed simultaneously with the High Speed button.

JH - Set high jog velocity
**SET HOME VEL**

Sets the velocity used during homing sequences. Refer to Section 1.6.3 for details on homing.

| OH  | -     | Set home velocity |

**SET ACCEL/DECEL**

This menu makes it possible to change acceleration and deceleration that are used with the jog and home search buttons. The following sub-menus are available:

**SET ACCELERATION**

Sets the acceleration that is used to accelerate to the desired velocity when the jog buttons are used.

| AC  | -     | Set Acceleration |

**SET DECELERATION**

Sets the deceleration that is used to decelerate to the standstill when the jog buttons are released.

| AG  | -     | Set Deceleration |

**SET JOG MODE**

Sets the mode used when either jog button is pressed. There are two modes:

**RUN**

In this mode, the stage moves as long as either jog button is pressed.

**INCR value**

In this mode, the stage moves an incremental distance determined by value when either jog button is pressed.

| PR  | -     | Move Relative |
SET HOME MODE

This menu allows the user to choose between two homing modes. Please refer to Section 5.4.3 for a detailed description of homing.

Please note that this menu only selects the homing method, but does not initiate a home search. Home searches are initiated by pressing the HOME button for the respective axis.

The following sub-menus are available:

SW

SW home search means the controller returns the stage to a position determined by the home switch only. No index pulse is required.

| OR2 | - | Set Home Mode to Switch only |

SW/INDEX

SW/Index home search means the controller returns the stage to a position determined by the home switch in connection with an index pulse.

| OR1 | - | Set Home Mode to Switch/Index |

POSITION 0

Moves to zero position count.

| OR0 | - | Set Home Mode 0 |

SET PID

This menu allows the user to modify the digital PID filter. All ESP compatible motion devices offered with the ESP300 have a set of conservative PID parameters that are loaded when the controller is powered up.

To change them, some knowledge of motion control loops is needed. Therefore, it is not recommended to modify the pre-set values before reading some general guidelines in Section 6: Servo Tuning.

The following sub-menus are available:
**SET KP**
Sets the integral gain of the digital PID filter.

**KP**  -  Set proportional gain

**SET KI**
Sets the integral gain of the digital PID filter.

**KI**  -  Set integral gain

**SET KD**
Sets the derivative gain of the digital PID filter.

**KD**  -  Set derivative gain.

**SET IL**
Sets the limit for the integrated value due to the integral gain KI factor of the digital PID filter.

**IL**  -  Set integration limit

**SET FE**
Sets the maximum following error before motion is aborted.

**FE**  -  Set following error

**GET STAGE MODELS**
This menu allows the user to retrieve the model numbers of the stages that are connected to the respective axes.

**ID**  -  Get stage identifier
GET RS232 CONFIG
This menu allows the user to retrieve the current RS232 configuration settings.

SAVE PARAMETERS
This menu allows the users to save all current settings (velocity, acceleration, etc.) to the ESP300 non-volatile memory.
Section 3 – Remote Mode

3.1 Programming Modes

The ESP is a command driven system. In general commands are a series of two letter ASCII characters preceded by an axis number and followed by parameters specific to the command. To communicate with the ESP controller, a host terminal has to transfer ASCII character commands according to the respective communication protocol (See Section 3.2 for IEEE-488 or RS232 interfaces).

As briefly mentioned in Section 2, the ESP distinguishes between two different programming modes:

COMMAND MODE

In this mode, the ESP controller provides a command input buffer enabling the host terminal (e.g., PC) to download a series of commands and then proceed to other tasks while the ESP controller processes the commands.

As command characters arrive from the host terminal, they are placed into the command buffer. When a carriage-return (ASCII 13 decimal) terminator is received, the command is interpreted. If the command is valid and its parameter is within the specified range, it will be executed. If the command contains an error, it will not be executed and a corresponding error message will be stored in the error buffer.

NOTE

The ESP power up state is command mode.

An example of a typical command sequence is shown below:

Example 1:

1PA + 30  move axis 1 to absolute position 30 units
1WS       wait for axis 1 to stop
2PR-10    move axis 2 to relative position 10 units
Assuming that axis 1 and 2 are configured, Example 1 instructs the ESP controller to move axis 1 to absolute position +30 units, wait for it to stop, and then move axis 2 motor to relative –10 units.

Note that a command prefix identifies the axis or group that should execute a command. Commands received without an axis prefix generate an error. If a command is referenced to a non-existing axis, an error is also generated. See Section 3.4 for further details on the command syntax.

Also note that it is necessary to explicitly instruct the ESP controller with the WS (Wait for Stop) command to wait for axis 1 motion to stop. This is necessary because the ESP controller executes commands continuously as long as there are commands in the buffer unless a command is fetched from the buffer that instructs the controller to wait. Executing a move does not automatically suspend command execution until the move is complete. If the WS command were not issued in Example 1, the controller would start the second move immediately after the first move begins and simultaneously move axis 1 and axis 2.

NOTE

Unless instructed otherwise, the ESP controller executes commands in the order received without waiting for completion of previous commands.

Remember that commands must be terminated with a carriage-return (ASCII 13 decimal). Until a terminator is received, characters are simply kept in contiguous buffer space without evaluation.

Example 2:
1PA+30; 1WS; 2PR-10

Example #1 and Example #2 perform the same operations. In Example #2 however, semicolons are used in place of carriage-returns as command delimiters, keeping the ESP controller from interpreting any commands on that line until the carriage-return terminator is received at the very end of the string.
PROGRAM EXECUTION MODE

The ESP controller also implements an internal program execution mode that enables the user to store up to 100 programs in a 64kB non-volatile memory.

Even while executing stored programs, the ESP controller maintains open communication channels so that the host terminal can continue to direct the ESP to report any desired status, and even execute other motion commands.

Let’s illustrate program execution mode using the previous example:

**Example 3:**

<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>EP</td>
<td>invoke program entry mode</td>
</tr>
<tr>
<td>1PA+30</td>
<td>enter program</td>
</tr>
<tr>
<td>1WS</td>
<td></td>
</tr>
<tr>
<td>2PR-10</td>
<td></td>
</tr>
<tr>
<td>QP</td>
<td>exit program entry mode</td>
</tr>
<tr>
<td>1EX</td>
<td>execute compiled program #1</td>
</tr>
</tbody>
</table>

As shown above, the sequence of commands has to be downloaded into the ESP controller program memory without inadvertently executing them. To facilitate this, the system provides the EP (Enter Program) command; characters received thereafter are redirected to program memory. Command syntax and parameters are not evaluated (even after the carriage-return). Instead, they are treated as a series of characters to be stored in contiguous memory.
3.2 Remote Interfaces

In this manual, *Remote Interface* refers to the two communication interfaces that the controller can use to communicate with a computer or a terminal via commands in ASCII format. It is not called a *Computer Interface* since any device capable of sending ASCII characters can be interfaced with the controller.

The remote interface should not be confused with the General Purpose Input/Output (digital I/Os, a.k.a. GPIO).

3.2.1 RS-232C Interface

HARDWARE CONFIGURATION

The serial (RS-232C) communication interface on the ESP controller is accessed through the 9 pin Sub-D connector located on the rear panel. The pin out is designed to interface directly with an IBM PC or compatible computer, using a straight through cable.

Appendix C shows the pin out of the RS-232C connector and different cable types that may be used to interface to a computer.

COMMUNICATION PROTOCOL

The RS-232C interface must be properly configured on both devices communicating. A correct setting is one that matches all parameters (baud rate, number of data bits, number of stop bits, parity type and handshake type) for both devices.

**NOTE**

The ESP RS-232C configuration is fixed at 8 data bits, no parity, and 1 stop bit (Baud rate factory default = 19200) - can not be changed by user.

To prevent buffer overflow when data is transferred to the ESP controller input buffer, a CTS/RTS hardware handshake protocol is implemented. The host terminal can control transmission of characters from the ESP by enabling the Request To Send (RTS) signal once the controller’s Clear To Send (CTS) signal is ready. Before sending any further characters, the ESP will wait for a CTS from the host.

As soon as its command buffer is full, the controller de-asserts CTS. Then, as memory becomes available because the controller reads and executes commands in its buffer, it re-asserts the CTS signal to the host terminal.
3.2.2 IEEE-488 Interface

HARDWARE CONFIGURATION

A typical IEEE-488 setup consists of a controller (host terminal) and several devices connected to the bus. All devices are connected in parallel to the data lines, data management and synchronization lines.

As a result of this type of connection, each device on the bus must have a unique address so that the controller can selectively communicate with it.

The address can be set through the optional front panel display or with the SA (set address) command. (Note: that the factory default is address 1)

COMMUNICATION PROTOCOL

The IEEE-488 interface is implemented on the motion controller somewhat differently from a typical instrument because the standard IEEE-488.2 command set and command format are inadequate for a complex motion control. Since the ESP controller has its own language and command set, the IEEE-488 interface is used only as a communication port. The extended protocol is not supported.

The ESP controller has an ASCII command set and also outputs system status in ASCII format. It features a command input buffer. If the buffer fills up, the ESP will not allow further communication until memory becomes available to accept new characters.

To send a command to the ESP controller, use the command specific to your IEEE-488 terminal [e.g., output (ASCII)].

If the host terminal asks the controller for a response [e.g., input (ASCII)] and no response is obtained, the controller will eventually will time-out.

USE OF SRQ LINE

The ESP controller can be instructed to generate an IEEE-488 service request (SRQ) upon processing the RQ command. This allows the user to generate SRQs anywhere within the ESP command stream thereby facilitating efficient event synchronization capability with the host computer.

The following example illustrates the use of the RQ command:
In the above example, the SRQ line is asserted only after execution of the sequence preceding the RQ command is finished.

SERIAL POLL

When the IEEE-488 controller senses a service request on the bus, it creates an interrupt to the application program (if configured to do so). The application program must contain a service routine for this interrupt. First, the program must determine which device on the bus generated the service request. This is usually achieved with a function called Serial Poll. The exact syntax for the serial poll command depends on the IEEE-488 controller.

Using that interrupt service routine, a serial poll command can be issued to each device. The device polled at each instance will respond with a status byte. Bit 6 of the status byte indicates whether a specific device (i.e., ESP controller) generated the service request or not. Bits 0 through 5 are under user control and are set with the RQ command. For example, command “RQ5” sets bits 0 and 2. This is useful in helping the application program determine which RQ in a program with multiple RQs generated the SRQ.

3.3 Software Utilities

In order to communicate with the controller, the user must have a terminal or a computer capable of communicating through RS-232C or IEEE-488. One approach is to use a computer with communications software that can emulate a terminal. Windows 95 provides an RS232 terminal emulation program named Hyper Terminal (HyperTrm.Exe) located in Accessories. HyperTrm allows the user to send ASCII commands to the motion controller. The user can even download text files with stored programs. Additionally, it can be used to download controller firmware for future upgrades.

For IEEE-488 communications National Instruments Inc. provides a program named IBIC with their products that allow the user to send and receive ASCII characters and download files. This could be useful in determining that the interface is working.
3.4 Command Syntax

As mentioned previously, the ESP controller utilizes an ASCII command set and also outputs system status in ASCII format. Commands may be either upper or lower case characters. The diagram below illustrates the ESP controller command syntax. As indicated in this diagram, a valid command consists of three main fields. The first field consists of a numerical parameter “xx”, the second field consists of a two letter ASCII mnemonic, and the third field consists of numerical parameter “nn”. The command is finally terminated by a carriage return. For example, 3PA10.0 is a valid command.

If a command does not require parameter “xx” and/or parameter “nn”, that field may be skipped by leaving a blank character (space). For example, BO1, 3WS, and AB are all valid commands.

If a command requires multiple parameters in the third field, all these parameters must be comma delimited. For example, 1HN1,2 is a valid command.

In a similar fashion, multiple commands can be issued on a single command line by separating the commands by a semi-colon (;). For example, 3MO; 3PA10.0; 3WS; 3MF is a valid command line.

Figure 3.1: Command Syntax Diagram

NOTE

A controller command (or a sequence of commands) has to be terminated with a carriage return character. However, responses from the controller are always terminated by a carriage return/line feed combination. This setting may not be changed. If the IEEE interface is used, the IEEE controller has to be configured to terminate the input (read) function when it senses the line feed character.
3.4.1 Summary of Command Syntax

**COMMAND FORMAT**

\[ \text{COMMAND FORMAT} \quad XX \quad AA \quad nn \]

The general format of a command is a two character mnemonic (AA). Both upper and lower case are accepted. Depending on the command, it could also have optional or required preceding (xx) and/or following (nn) parameters.

**BLANK SPACES**

Blank spaces are allowed and ignored between parameters and commands. For the clarity of the program and memory saving considerations, use blank spaces with restraint. The following two commands are equivalent.

- 2 PA 1000
- 2PA1000

but the first example is very confusing and uses more than twice the memory.

**COMMAND LINE**

Commands are executed line by line. A line can consist of one or a number of commands. The controller will interpret the commands in the order they are received and execute them sequentially. This means that commands issued on the same line are executed significantly closer to each other than if they would be issued on separate lines. The maximum number of characters allowed on a command line is 80.

**SEPARATOR**

Commands issued on the same line must be separated by semicolons (;).

Multiple parameters issued for the same command are separated by commas (,).

**TERMINATOR**

Each command line must end with a line terminator, i.e., carriage return.
The controller understands many commands. The following tables list all of them, sorted first by category and then alphabetically. The tables also show the operating modes in which each command can be used. The acronyms used in the tables have the following meaning:

**IMM**  IMMediate mode  Controller is idle and the commands will be executed immediately.

**PGM**  ProGraM mode  Controller does not execute but stores all commands as part of a program. EP activates this mode and QP exits it.

**MIP**  Motion In Progress  Controller executes command on the specified axis while in motion.
### Table 3.5.1 – Command List by Category

**In a PDF format you may click on a page number to automatically be connected to the corresponding Command Page**

#### General Mode Selection

<table>
<thead>
<tr>
<th>Cmd.</th>
<th>Description</th>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>DP</td>
<td>Get target position</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 52</td>
</tr>
<tr>
<td>DV</td>
<td>Get working speed</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 53</td>
</tr>
<tr>
<td>ID</td>
<td>Get stage model and serial number</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 86</td>
</tr>
<tr>
<td>MD</td>
<td>Get axis motion status</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 96</td>
</tr>
<tr>
<td>PH</td>
<td>Get hardware status</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 109</td>
</tr>
<tr>
<td>TB</td>
<td>Get error message</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 138</td>
</tr>
<tr>
<td>TE</td>
<td>Get error number</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 139</td>
</tr>
<tr>
<td>TP</td>
<td>Get position</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 141</td>
</tr>
<tr>
<td>TS</td>
<td>Get controller status</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 142</td>
</tr>
<tr>
<td>TV</td>
<td>Get velocity</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 143</td>
</tr>
<tr>
<td>TX</td>
<td>Get controller activity</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 144</td>
</tr>
<tr>
<td>VE</td>
<td>Get firmware version</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 150</td>
</tr>
<tr>
<td>XM</td>
<td>Get available program memory</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 156</td>
</tr>
</tbody>
</table>

#### Motion & Position Control

<table>
<thead>
<tr>
<th>Cmd.</th>
<th>Description</th>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>AB</td>
<td>Abort motion</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 20</td>
</tr>
<tr>
<td>DH</td>
<td>Define home</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 49</td>
</tr>
<tr>
<td>MT</td>
<td>Move to hardware travel limit</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 99</td>
</tr>
<tr>
<td>MV</td>
<td>Move indefinitely</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 100</td>
</tr>
<tr>
<td>MZ</td>
<td>Move to nearest index</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 102</td>
</tr>
<tr>
<td>OR</td>
<td>Origin searching</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 106</td>
</tr>
<tr>
<td>PA</td>
<td>Move absolute</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 108</td>
</tr>
<tr>
<td>PR</td>
<td>Move relative</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 112</td>
</tr>
<tr>
<td>ST</td>
<td>Stop motion</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 136</td>
</tr>
</tbody>
</table>

#### Motion Device Parameters

<table>
<thead>
<tr>
<th>Cmd.</th>
<th>Description</th>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>FE</td>
<td>Set following error threshold</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 59</td>
</tr>
<tr>
<td>FR</td>
<td>Full step resolution</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 61</td>
</tr>
<tr>
<td>GR</td>
<td>Set gear ratio</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 62</td>
</tr>
<tr>
<td>QG</td>
<td>Set gear constant</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 114</td>
</tr>
<tr>
<td>QI</td>
<td>Motor current</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 115</td>
</tr>
<tr>
<td>QM</td>
<td>Define motor type</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 116</td>
</tr>
<tr>
<td>Cmd.</td>
<td>Description</td>
<td>IMM</td>
<td>PGM</td>
<td>MIP</td>
<td>Page</td>
</tr>
<tr>
<td>------</td>
<td>-------------------------------------------</td>
<td>-----</td>
<td>-----</td>
<td>------</td>
<td>------</td>
</tr>
<tr>
<td>QR</td>
<td>Torque reduction</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3-118</td>
</tr>
<tr>
<td>QS</td>
<td>Set microstep factor</td>
<td>♦</td>
<td>♦</td>
<td></td>
<td>3-119</td>
</tr>
<tr>
<td>QT</td>
<td>Define tachometer constant</td>
<td>♦</td>
<td>♦</td>
<td></td>
<td>3-120</td>
</tr>
<tr>
<td>QV</td>
<td>Set motor voltage</td>
<td>♦</td>
<td>♦</td>
<td></td>
<td>3-121</td>
</tr>
<tr>
<td>SI</td>
<td>Set master-slave jog update interval</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3-129</td>
</tr>
<tr>
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### PROGRAMMING

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### TRAJECTORY DEFINITION

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### FLOW CONTROL & SEQUENCING

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### I/O FUNCTIONS

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### GROUP FUNCTIONS

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Section 3 – Remote Mode
| HE | Set group E-stop deceleration | ♦ | ♦ | ♦ | 3-70 |
| HF | Group motor power OFF | ♦ | ♦ | ♦ | 3-71 |
| HJ | Set group jerk | ♦ | ♦ | ♦ | 3-72 |
| HL | Move group along a line | ♦ | ♦ | ♦ | 3-73 |
| HN | Create new group | ♦ | ♦ | ♦ | 3-75 |
| HO | Group motor power ON | ♦ | ♦ | ♦ | 3-77 |
| HP | Get group position | ♦ | ♦ | ♦ | 3-78 |
| HQ | Wait for group via point buffer near empty | ♦ | ♦ | ♦ | 3-79 |
| HS | Stop group motion | ♦ | ♦ | ♦ | 3-80 |
| HV | Set group velocity | ♦ | ♦ | ♦ | 3-81 |
| HW | Wait for group motion to stop | ♦ | ♦ | ♦ | 3-82 |
| HX | Delete a group | ♦ | ♦ | ♦ | 3-84 |
| HZ | Get group size | ♦ | ♦ | ♦ | 3-85 |

**DIGITAL FILTERS**

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**MASTER-SLAVE MODE DEFINITION**

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<td>Enter program mode</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3- 55</td>
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<tr>
<td>ES</td>
<td>Define event action command string</td>
<td>♦</td>
<td>♦</td>
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<td>3- 56</td>
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<td>EX</td>
<td>Execute a program</td>
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<td>♦</td>
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<tr>
<td>FE</td>
<td>Set maximum following error threshold</td>
<td>♦</td>
<td>♦</td>
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</tr>
<tr>
<td>Cmd.</td>
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<td>PGM</td>
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<tr>
<td>FP</td>
<td>Set position display resolution</td>
<td>♦</td>
<td>♦</td>
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<tr>
<td>FR</td>
<td>Set full step resolution</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
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<tr>
<td>GR</td>
<td>Set master-slave reduction ratio</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
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</tr>
<tr>
<td>HA</td>
<td>Set group acceleration</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
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</tr>
<tr>
<td>HB</td>
<td>Read list of groups assigned</td>
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<td>♦</td>
<td>♦</td>
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</tr>
<tr>
<td>HC</td>
<td>Move group along an arc</td>
<td>♦</td>
<td>♦</td>
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<tr>
<td>HD</td>
<td>Set group deceleration</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
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</tr>
<tr>
<td>HE</td>
<td>Set group e-stop deceleration</td>
<td>♦</td>
<td>♦</td>
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<tr>
<td>HF</td>
<td>Group motor power off</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
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<tr>
<td>HJ</td>
<td>Set group jerk</td>
<td>♦</td>
<td>♦</td>
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<td>HL</td>
<td>Move group along a line</td>
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<tr>
<td>HN</td>
<td>Create new group</td>
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<td>♦</td>
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<tr>
<td>HO</td>
<td>Group on</td>
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<td>♦</td>
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<td>HS</td>
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<td>♦</td>
<td>♦</td>
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<td>HV</td>
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<td>HW</td>
<td>Wait for group motion stop</td>
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<td>♦</td>
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<td>ID</td>
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<td>JH</td>
<td>Set jog high speed</td>
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<td>♦</td>
<td>♦</td>
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<td>JK</td>
<td>Set jerk rate</td>
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<td>♦</td>
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<td>JL</td>
<td>Jump to label</td>
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<td>JW</td>
<td>Set jog low speed</td>
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<td>♦</td>
<td>♦</td>
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<td>KD</td>
<td>Set derivative gain</td>
<td>♦</td>
<td>♦</td>
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<td>KI</td>
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<tr>
<td>KS</td>
<td>Set saturation level of integral factor</td>
<td>♦</td>
<td>♦</td>
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<td>LP</td>
<td>List program</td>
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<td>MD</td>
<td>Read motion done status</td>
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<td>MF</td>
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<td>♦</td>
<td>♦</td>
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<td>MO</td>
<td>Motor power on</td>
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<td>♦</td>
<td>♦</td>
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<tr>
<td>MT</td>
<td>Move to hardware travel limit</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
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<td>MV</td>
<td>Move indefinitely</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
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<tr>
<td>MZ</td>
<td>Move to nearest index</td>
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<td>♦</td>
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<tr>
<td>OH</td>
<td>Set home search high speed</td>
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<td>♦</td>
<td>♦</td>
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<td>OL</td>
<td>Set home search low speed</td>
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<td>♦</td>
<td>♦</td>
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<td>OM</td>
<td>Set home search mode</td>
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<tr>
<td>OR</td>
<td>Search for home</td>
<td>♦</td>
<td>♦</td>
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<tr>
<td>PA</td>
<td>Move to absolute position</td>
<td>♦</td>
<td>♦</td>
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<td>PH</td>
<td>Get hardware status</td>
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<td>PR</td>
<td>Move to relative position</td>
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<td>♦</td>
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<td>QD</td>
<td>Update motor driver settings</td>
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<td>Set gear constant</td>
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<td>QI</td>
<td>Set maximum motor current</td>
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<td>QM</td>
<td>Set motor type</td>
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<td>QP</td>
<td>Quit program mode</td>
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<td>QR</td>
<td>Reduce motor torque</td>
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<td>♦</td>
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<td>QS</td>
<td>Set microstep factor</td>
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<td>QT</td>
<td>Set tachometer gain</td>
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<td>QV</td>
<td>Set average motor voltage</td>
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<td>RQ</td>
<td>Generate service request</td>
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<td>♦</td>
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<td>RS</td>
<td>Reset the controller</td>
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<td>SA</td>
<td>Set device address</td>
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<tr>
<td>SB</td>
<td>Set/get DIO port A, B, C bit status</td>
<td>♦</td>
<td>♦</td>
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<td>3-125</td>
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<tr>
<td>SH</td>
<td>Set home preset position</td>
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<td>♦</td>
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<tr>
<td>SI</td>
<td>Set master-slave jog velocity update interval</td>
<td>♦</td>
<td>♦</td>
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<td>SK</td>
<td>Set master-slave jog velocity scaling coefficients</td>
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<td>♦</td>
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<td>SL</td>
<td>Set level travel limit</td>
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<td>♦</td>
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<td>SM</td>
<td>Save settings to non-volatile memory</td>
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<td>SN</td>
<td>Set axis displacement units</td>
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<td>SR</td>
<td>Set right travel limit</td>
<td>♦</td>
<td>♦</td>
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<td>SS</td>
<td>Define master-slave relationship</td>
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<tr>
<td>ST</td>
<td>Stop motion</td>
<td>♦</td>
<td>♦</td>
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<td>SU</td>
<td>Set encoder resolution</td>
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<td>♦</td>
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<td>TB</td>
<td>Read error message</td>
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<td>TE</td>
<td>Read error code</td>
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<td>TJ</td>
<td>Set trajectory mode</td>
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<td>TP</td>
<td>Read actual position</td>
<td>♦</td>
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<td>Get controller status</td>
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<td>Get controller activity</td>
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<td>UF</td>
<td>Update servo filter</td>
<td>♦</td>
<td>♦</td>
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<tr>
<td>UH</td>
<td>Wait for DIO bit high</td>
<td>♦</td>
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</table>
TABLE 3.5.2 – Command List – Alphabetical (Continued)

In a PDF format you may click on a page number to automatically be connected to the corresponding Command Page

<table>
<thead>
<tr>
<th>Cmd.</th>
<th>Description</th>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
<th>Page</th>
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<tbody>
<tr>
<td>UL</td>
<td>Wait for DIO bit low</td>
<td>♦</td>
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<td>♦</td>
<td>3-147</td>
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<tr>
<td>VA</td>
<td>Set velocity</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3-148</td>
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<tr>
<td>VB</td>
<td>Set base velocity for step motors</td>
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<td>♦</td>
<td>♦</td>
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<tr>
<td>VE</td>
<td>Read controller firmware version</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3-150</td>
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<td>VF</td>
<td>Set velocity feed-forward gain</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
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<tr>
<td>VU</td>
<td>Set maximum velocity</td>
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<td>♦</td>
<td>♦</td>
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<tr>
<td>WP</td>
<td>Wait for absolute position crossing</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3-153</td>
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<tr>
<td>WS</td>
<td>Wait for motion stop</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>3-154</td>
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<tr>
<td>WT</td>
<td>Wait</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
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<td>XM</td>
<td>Get available program memory</td>
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<td>XX</td>
<td>Delete a stored program</td>
<td>♦</td>
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<td>♦</td>
<td>3-157</td>
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<td>ZA</td>
<td>Set amplifier I/O configuration</td>
<td>♦</td>
<td>♦</td>
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<td>ZB</td>
<td>Set feedback configuration</td>
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<td>♦</td>
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<td>ZE</td>
<td>Set E-stop configuration</td>
<td>♦</td>
<td>♦</td>
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<td>3-163</td>
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<td>ZF</td>
<td>Set following error configuration</td>
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<td>♦</td>
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<td>3-165</td>
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<tr>
<td>ZH</td>
<td>Set hardware limit configuration</td>
<td>♦</td>
<td>♦</td>
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<td>ZS</td>
<td>Set software limit configuration</td>
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<td>♦</td>
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<td>3-169</td>
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<tr>
<td>ZU</td>
<td>Get ESP system configuration</td>
<td>♦</td>
<td>♦</td>
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<td>3-171</td>
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<tr>
<td>ZZ</td>
<td>Set system configuration</td>
<td>♦</td>
<td>♦</td>
<td></td>
<td>3-173</td>
</tr>
</tbody>
</table>

3.6 Description of Commands

The extensive ESP controller command set exists to facilitate application development for wide range of application and needs. However, most simple positioning can be done with just a few commands:

- **VA** – set velocity
- **AC** – set acceleration
- **AG** – set deceleration
- **PR** – position relative
- **PA** – position absolute
- **TP** – tell position
- **WS** – wait for stop
NOTE

Most of the commands take an axis number as a parameter (xx). For such commands, the valid range of axis number is from 1 to MAX AXES, where MAX AXES is dependant on the configuration of the ESP motion controller.

Commands related to coordinated motion and contouring (group commands) take a group number as a parameter. For such commands, the valid range of group number is from 1 to MAX GROUPS, where MAX GROUPS is one-half the MAX AXES.
**AA – (command mnemonic) (brief definition) (motor type)** *

(the diamonds mark which mode the command can be used in)

**USAGE**

<table>
<thead>
<tr>
<th>Mode</th>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
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<td></td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
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<tr>
<td>(modes of operation)</td>
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**SYNTAX**

xxAAnn (generic syntax format)

**PARAMETERS**

**Description**

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<tr>
<th>Description</th>
<th>xx [int]</th>
<th>--</th>
<th>(description of parameter)</th>
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<tbody>
<tr>
<td></td>
<td>Nn [float]</td>
<td>--</td>
<td>(description of parameter)</td>
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</tbody>
</table>

(parameter could be integer number, floating point number, character or string)

**Range**

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<tr>
<th>xx</th>
<th>--</th>
<th>(minimum value to maximum value)</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>--</td>
<td>(minimum value to maximum value)</td>
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**Units**

<table>
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<th>xx</th>
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<th>(units description)</th>
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<tbody>
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<td>(units description)</td>
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**Defaults**

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<th>xx</th>
<th>missing:</th>
<th>(default or error if parameter is missing)</th>
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</thead>
<tbody>
<tr>
<td></td>
<td>out of range:</td>
<td>(default or error if parameter is out of range)</td>
</tr>
<tr>
<td>nn</td>
<td>missing:</td>
<td>(default or error if parameter is missing)</td>
</tr>
<tr>
<td></td>
<td>out of range:</td>
<td>(default or error if parameter is out of range)</td>
</tr>
</tbody>
</table>

**DESCRIPTION**

(detailed description of the command)

**Note:**

(notes, reminders and things to consider when using the command, if any)

**RETURNS**

(Type, format and description of the return the command is generating, if any)

**ERRORS**

(Error Code) – (description of errors the command could generate if misused)

**REL. COMMANDS**

(brief definition of related commands)

**EXAMPLE**

(Command Discussed) | (description) |
(Other command) | (description) |
(Controller return) | (description) |

*(motor type)* – if the command is specific for a motor type (DC or stepping) it will be labeled here, otherwise this field is blank.

** The mode mnemonics has the following meanings:

**IMM**ediate mode – controller is in idle mode and the commands are executed immediately.

**ProGraM** mode – controller does not execute but stores all commands as part of a program.

**Motion in** Progress – controller is executing a motion on all or the specified axis.
**AB**  abort motion

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

**SYNTAX**  AB

**PARAMETERS**  None.

**DESCRIPTION**  This command should be used as an emergency stop. On reception of this command, the controller invokes emergency stop event processing for each axis as configured by ZE (e-stop event configuration) command.

By default axes are configured to turn motor power OFF, however, individual axes can be configured to stop using emergency deceleration rate set by AE command and maintain motor power.

It should be used only as an immediate command, not in a program.

**Note:**

This command affects all axes, however the action taken is determined by each individual’s axis ZE command configuration.

**RETURNS**  none

**REL. COMMANDS**

| ST  | - | stop motion |
| AE  | - | e-stop deceleration |
| ZE  | - | e-stop deceleration |
| MF  | - | motor OFF |
| MO  | - | motor ON |

**EXAMPLE**

AB  | used as an immediate command to stop all motion
**AC**  
**set acceleration**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

```
xxACnn or xxAC?
```

**PARAMETERS**

- **Description**
  
<table>
<thead>
<tr>
<th>Description</th>
<th>xx [int]</th>
<th>nn [float]</th>
</tr>
</thead>
<tbody>
<tr>
<td>axis number</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>acceleration value</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

- **Range**
  
  | xx | N | 1 to MAX AXES | 0 to the maximum programmed value in AU command or ? to read current setting |

- **Units**
  
  | xx | - | none |

- **Defaults**
  
  | xx | missing: | error 37, AXIS NUMBER MISSING |
  |    | out of range: | error 9, AXIS NUMBER OUT OF RANGE |
  
  | nn | missing: | error 38, COMMAND PARAMETER MISSING |
  |    | out of range: | error xx11, MAXIMUM ACCELERATION EXCEEDED |

**DESCRIPTION**

This command is used to set the acceleration value for an axis. Its execution is immediate, meaning that the acceleration is changed when the command is processed, even while a motion is in progress.

It can be used as an immediate command or inside a program. If the requested axis is a member of a group, the commanded acceleration becomes effective only after the axis is removed from the group. (Refer to Advanced Capabilities section for a detailed description of grouping and related commands)

Avoid changing the acceleration during the acceleration or deceleration periods. For better predictable results, change acceleration only when the axis is not moving or when it is moving with a constant speed.

**RETURNS**

If the “?” sign takes the place of nn value, this command reports the current setting

**REL. COMMANDS**

- **VA** - set velocity
- **PA** - execute an absolute motion
- **PR** - execute a relative motion
- **AU** - set maximum acceleration and deceleration
- **AG** - set deceleration

**EXAMPLE**

```
2AU?  | read maximum allowed acceleration/deceleration of axis # 2
```
<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>10</td>
<td>controller returns a value of 10 units/s$^2$</td>
</tr>
<tr>
<td>2AC9</td>
<td>set acceleration to 9 units/s$^2$</td>
</tr>
<tr>
<td>2AG6</td>
<td>set deceleration to 6 units/s$^2$</td>
</tr>
<tr>
<td>2AU15</td>
<td>set axis # 2 maximum acceleration/deceleration to 15 units/s$^2$</td>
</tr>
<tr>
<td>2AU?</td>
<td>read maximum allowed acceleration &amp; deceleration of axis # 2</td>
</tr>
<tr>
<td>15</td>
<td>controller returns a value of 15 units</td>
</tr>
</tbody>
</table>
### AE

**set e-stop deceleration**

<table>
<thead>
<tr>
<th>USAGE</th>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

```
xxAE
```

**PARAMETERS**

**Description**

- **xx** [int] - axis number
- **nn** [float] - e-stop deceleration value

**Range**

- **xx** - 1 to MAX AXES
- **nn** - current normal deceleration value to \(2e9 \times \text{encoder resolution}\) or `?` to read current setting

**Units**

- **xx** - none
- **nn** - predefined units / second²

**Defaults**

- **xx** missing: error 37, AXIS NUMBER MISSING
  out of range: error 9, AXIS NUMBER OUT OF RANGE
- **nn** missing: error 38, COMMAND PARAMETER MISSING
  out of range: error 1, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to set the e-stop deceleration value for an axis. Its execution is immediate, meaning that the e-stop deceleration value is changed when the command is processed, even while a motion is in progress.

It can be used as an immediate command or inside a program. If the requested axis is a member of a group, the commanded e-stop deceleration becomes effective only after the axis is removed from the group. (Refer to Advanced Capabilities section for a detailed description of grouping and related commands)

E-stop deceleration is invoked upon a local e-stop condition (e.g., front panel Stop All pushbutton, Interlock, etc.) has occurred, if configured to do so, or if the AB (abort motion) command is processed.

**Note:**

E-stop deceleration value cannot be set lower than the normal deceleration value. Refer the description of “AG” command for range of deceleration values.

**RETURNS**

If the “?” sign takes the place of **nn** value, this command reports the current setting

**REL. COMMANDS**

- **VA** - set velocity
- **PA** - execute an absolute motion
- **PR** - execute a relative motion
AU - set maximum acceleration and deceleration
AG - set deceleration
AC - set acceleration

**EXAMPLE**

2AE? | read e-stop deceleration of axis # 2
100  | controller returns a value of 100 units/s²
2AE150 | set e-stop deceleration to 150 units/s²
AF

set acceleration feed-forward gain

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

xxAFnn or xxAF?

**PARAMETERS**

**Description**

- xx [int] - axis number
- nn [float] - acceleration feed-forward gain factor

**Range**

- xx - 1 to MAX AXES
- nn - 0 to 2e9, or ? to read current setting

**Units**

- xx - none
- nn - none

**Defaults**

- xx missing: error 37, AXIS NUMBER MISSING
- out of range: error 9, AXIS NUMBER OUT OF RANGE
- nn missing: error 38, COMMAND PARAMETER MISSING
- out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command sets the acceleration feed-forward gain factor Af. It is active for any DC servo based motion device. See the "Feed-Forward Loops" in Motion Control Tutorial section to understand the basic principles of feed-forward.

**Note:**

The command can be sent at any time but it has no effect until the UF (update filter) is received.

**RETURNS**

If the “?” sign takes the place of nn value, this command reports the current setting

**REL. COMMANDS**

- KI - set integral gain factor
- KD - set derivative gain factor
- KP - set proportional gain factor
- KS - set saturation gain factor
- VF - set velocity feed-forward gain
- UF - update filter

**EXAMPLE**

- 3VF1.5 | set acceleration feed-forward gain factor for axis # 3 to 1.5
- 3AF? | report present axis-3 acceleration feedforward setting
- 0.9 | controller returns a value of 0.9
- 3AF0.8 | set acceleration feed-forward gain factor for axis # 3 to 0.8
- 3UF | update PID filter; only now the AF command takes effect
AG

set deceleration

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**USAGE**

**SYNTAX**

xxAGnn or xxAG?

**PARAMETERS**

**Description**

xx [ int ] - axis number
nn [float] - acceleration value

**Range**

xx - 1 to MAX AXES
Nn - to the maximum programmed value in AU command
or ? to read current setting

**Units**

xx - none
Nn - predefined units / second²

**Defaults**

xx missing: error 37, AXIS NUMBER MISSING
out of range: error 9, AXIS NUMBER OUT OF RANGE

nn missing: error 38, COMMAND PARAMETER MISSING
out of range: error xx11, MAXIMUM ACCELERATION EXCEEDED

**DESCRIPTION**

This command is used to set the deceleration value for an axis. Its execution is immediate, meaning that the deceleration is changed when the command is processed, even while a motion is in progress.

It can be used as an immediate command or inside a program. If the requested axis is a member of a group, the commanded deceleration becomes effective only after the axis is removed from the group. (Refer to Advanced Capabilities section for a detailed description of grouping and related commands)

Avoid changing the deceleration during the acceleration or deceleration periods. For better predictable results, change deceleration only when the axis is not moving or when it is moving with a constant speed.

**RETURNS**

If the “?” sign takes the place of nn value, this command reports the current setting

**REL. COMMANDS**

| VA  | - | set velocity |
| PA  | - | execute an absolute motion |
| PR  | - | execute a relative motion |
| AU  | - | set maximum acceleration and deceleration |
| AC  | - | set acceleration |

3-26          Section 3 – Remote Mode
<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>2AU?</td>
<td>read maximum allowed acceleration/deceleration of axis # 2</td>
</tr>
<tr>
<td>10</td>
<td>controller returns a value of 10 units/s²</td>
</tr>
<tr>
<td>2AC9</td>
<td>set acceleration to 9 units/s²</td>
</tr>
<tr>
<td><strong>2AG6</strong></td>
<td>set deceleration to 6 units/s²</td>
</tr>
<tr>
<td><strong>2AG?</strong></td>
<td>read maximum current deceleration of axis # 2</td>
</tr>
<tr>
<td>6</td>
<td>controller returns a value of 6 units/s²</td>
</tr>
</tbody>
</table>
AP  abort program

**USAGE**

IMM  PGM  MIP

♦   ♦   ♦

**SYNTAX**

AP

**PARAMETERS**

none

**DESCRIPTION**

This command is used to interrupt a motion program in execution. It will not stop a motion in progress. It will only stop the program after the current command line finished executing.

It can be used as an immediate command or inside a program.

Inside a program it is useful in conjunction with program flow control commands. It could, for instance, terminate a program on the occurrence of a certain external event, monitored by an I/O bit.

**RETURNS**

none

**REL. COMMANDS**

EX  -  execute a program

**EXAMPLE**

3EX  | execute program # 3

.  

.  

AP  | stop program execution
**AU**

set maximum acceleration and deceleration

<table>
<thead>
<tr>
<th>USAGE</th>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

`xAU nn` or `xAU?`

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [int]</th>
<th>-</th>
<th>axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn [float]</td>
<td>-</td>
<td>acceleration value</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Range</th>
<th>xx -</th>
<th>1 to MAX AXES</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>-</td>
<td>0 to 2e+9, or ? to read current setting</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Units</th>
<th>xx -</th>
<th>none</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>-</td>
<td>predefined units / second^2</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Defaults</th>
<th>xx missing:</th>
<th>error 37, AXIS NUMBER MISSING</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>out of range:</td>
<td>error 9, AXIS NUMBER OUT OF RANGE</td>
</tr>
<tr>
<td></td>
<td>nn missing:</td>
<td>error 38, COMMAND PARAMETER MISSING</td>
</tr>
<tr>
<td></td>
<td>out of range:</td>
<td>error xx11, MAXIMUM ACCELERATION EXCEEDED</td>
</tr>
<tr>
<td></td>
<td></td>
<td>error xx1, PARAMETER OUT OF RANGE</td>
</tr>
</tbody>
</table>

**DESCRIPTION**

This command is used to set the maximum acceleration and deceleration value for an axis. This command remains effective even if the requested axis is member of a group. In this case, two error messages "GROUP MAXIMUM ACCELERATION EXCEEDED" or "GROUP MAXIMUM DECELERATION EXCEEDED" are generated if the commanded value is less than group acceleration or deceleration respectively. (Refer to Advanced Capabilities section for a detailed description of grouping and related commands)

**RETURNS**

If the “?” sign takes the place of `nn` value, this command reports the current setting

**REL. COMMANDS**

<table>
<thead>
<tr>
<th>VA</th>
<th>-</th>
<th>set velocity</th>
</tr>
</thead>
<tbody>
<tr>
<td>PA</td>
<td>-</td>
<td>execute an absolute motion</td>
</tr>
<tr>
<td>PR</td>
<td>-</td>
<td>execute a relative motion</td>
</tr>
<tr>
<td>AG</td>
<td>-</td>
<td>set deceleration</td>
</tr>
<tr>
<td>AC</td>
<td>-</td>
<td>set acceleration</td>
</tr>
</tbody>
</table>

**EXAMPLE**

```
AU? | read maximum allowed acceleration/deceleration of axis # 2
10  | controller returns a value of 10 units/s^2
2AC9 | set acceleration to 9 units/s^2
2AG6 | set deceleration to 6 units/s^2
2AU15 | set axis # 2 maximum acceleration/deceleration to 15 units/s^2
2AU? | read maximum allowed acceleration & deceleration of axis # 2
15  | controller returns a value of 15 units/s^2
```
BA set backlash compensation

**USAGE**

```latex
\begin{array}{ccc}
\text{IMM} & \text{PGM} & \text{MIP} \\
\text{♦} & \text{♦} & \text{♦}
\end{array}
```

**SYNTAX**

```
xxBAnn  or  xxBA?
```

**PARAMETERS**

**Description**

- `xx` [ int ] - axis number
- `nn` [ float ] - backlash compensation value

**Range**

- `xx` - 1 to MAX AXES
- `nn` - to distance equivalent to 10000 encoder counts

**Units**

- `xx` - none
- `nn` - user units

**Defaults**

- `xx` missing: error 37, AXIS NUMBER MISSING
  out of range: error 9, AXIS NUMBER OUT OF RANGE
- `nn` missing: error 38, COMMAND PARAMETER MISSING
  out of range: error 7, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command initiates a backlash compensation algorithm when motion direction is reversed. The controller keeps track of the motion sequence and for each direction change it adds the specified `nn` correction. Setting `nn` to zero disables the backlash compensation.

**NOTE:** The command is affective only after a home search (OR) or define home (DH) is performed on the specified axis.

**RETURNS**

If “?” sign takes the place of `nn` value, this command reports the current setting.

**REL. COMMANDS**

None

**EXAMPLE**

```latex
1BA0.0012  \mid Set backlash compensation value for axis #1 to 0.0012 units
1BA? \mid Query backlash compensation value for axis #1
0.0012 \mid Controller returns a value of 0.0012 units
1OR \mid Perform home search on axis #1
1PA10 \mid Move axis #1 to absolute 10 units
1PA0 \mid Move axis #1 to absolute 0 units
```
**BG**

**assign DIO bits to execute stored programs**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

**USAGE**

<table>
<thead>
<tr>
<th>xxBGnn or xxBG?</th>
</tr>
</thead>
</table>

**SYNTAX**

**PARAMETERS**

- **Description**
  - xx [ int ] - bit number used to trigger stored program execution
  - nn [ char ] - name of stored program to be executed

- **Range**
  - xx - 0 to 15
  - nn - None or ? to read current setting

- **Units** None

- **Defaults**
  - xx missing: error 7, PARAMETER OUT OF RANGE
  - out of range: error 7, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to assign DIO bits for initiating the execution of a desired stored program. Execution of the stored program begins when the specified DIO bit changes its state from HIGH to LOW logic level.

**Note:**

Each DIO bit has a pulled-up resistor to +5V. Therefore, all bits will be at HIGH logic level if not connected to external circuit and configured as input.

**RETURNS**

If the "?" sign takes the place of nn value, this command reports the current setting.

**REL. COMMANDS**

- BO - Set DIO port A, B, direction
- EP - Enter program mode
- EX - Execute stored program
- AP - Abort stored program execution

**EXAMPLE**

- **BO 0H** | Set DIO ports A and B to input
- **0 BG 1** | Start execution of a stored program 1 when DIO bit #0 changes state from HIGH to LOW

Section 3 – Remote Mode 3-31
**BK**

**assign DIO bits to inhibit motion**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

xxBKnn1, nn2 or xxBK?

**PARAMETERS**

**Description**

- **xx** [ int ] - axis number
- **nn1** [ int ] - bit number for inhibiting motion
- **nn2** [ int ] - bit level when axis motion is inhibited

**Range**

- **xx** - 1 to MAX AXES
- **nn1** - 0 to 15
- **nn2** - 0 = LOW and 1 = HIGH or ? to read current setting

**Units**

None

**Defaults**

- **xx** missing: error 37, AXIS NUMBER MISSING
- **nn1** missing: error 38, COMMAND PARAMETER MISSING
- **nn2** missing: error 38, COMMAND PARAMETER MISSING

**DESCRIPTION**

This command is used to assign DIO bits for inhibiting the motion of a selected axis. If the selected axis is already in motion, and DIO bit is asserted, e-stop is executed per E-stop configuration (Refer "ZE" command for further details). If the axis is not moving, any new move commands are refused as long as the DIO bit is asserted. In either case, "DIGITAL I/O INTERLOCK DETECTED" error is generated.

**Note:**

The direction of the DIO port (A, B or C) the desired bit belongs to, should be set to "input" in order for the DIO bit to be read accurately. Refer "BO" command for further details.

**RETURNS**

If the "?" sign takes the place of **nn** value, this command reports the current assignment.

**REL. COMMANDS**

- **BL** - Enable DIO bits to inhibit motion
- **BO** - Set DIO port A, B direction
- **BM** - Assign DIO bits to notify motion status

**EXAMPLE**

- **BO 0H** | Set DIO ports A, B to input
- **2BK 1, 1** | Use DIO bit #1 to inhibit motion of axis #2. This DIO bit should be HIGH when axis #2 motion is inhibited
- **2BL 1** | Enable inhibition of motion using DIO bits for axis #2
- **2BK?** | Query the DIO bit assignment for axis #2
- **1, 1** | The controller responds with the assigned values
enable DIO bits to inhibit motion

**SYNTAX**

```plaintext
xxBLnn or xxBL?
```

**PARAMETERS**

- **Description**: 
  - `xx` [int]: axis number
  - `nn` [int]: disable or enable

- **Range**:
  - `xx`: 1 to Max Axes
  - `nn`: 0 = disable, and 1 = enable or ? to read current setting

- **Units**: None

- **Defaults**
  - `xx` missing: error 37, AXIS NUMBER MISSING
  - out of range: error 9, AXIS NUMBER OUT OF RANGE
  - `nn` missing: error 38, COMMAND PARAMETER MISSING
  - out of range: error `xx1`, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to disable or enable motion inhibition of requested axes through DIO bits.

**RETURNS**

If the "?" sign takes the place of `nn` value, this command reports the current status.

**REL. COMMANDS**

- **BK** - Assign DIO bits to inhibit motion.
- **BO** - Set DIO port A, B direction
- **BM** - Assign DIO bits to notify motion status
- **BN** - Enable DIO bits to notify motion status.

**EXAMPLE**

- **BO 0H** | Set DIO ports A and B to input
- **2BK 1, 1** | Use DIO bit #1 to inhibit motion of axis #2. This DIO bit should be HIGH when axis #2 motion is inhibited
- **2BL 1** | Enable inhibition of motion using DIO bits for axis #2
- **2BK?** | Query the DIO bit assignment for axis #2
- **1, 1** | The controller responds with the assigned values
- **2BL?** | Query the status of inhibiting motion for axis #2 through DIO
- **1** | The controller responds with 1 indicating feature is enabled
**BM** assign DIO bits to notify motion status

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

`xxBMnn1, nn2` or `xxBM?`

**PARAMETERS**

**Description**

- `xx` [int] - axis number
- `nn1` [int] - bit number for notifying motion status
- `nn2` [int] - bit level when axis is not moving

**Range**

- `xx` - 1 to MAX AXES
- `nn1` - 0 to 15
- `nn2` - `0 = LOW` and `1 = HIGH` or `?` to read current setting

**Units**

None

**Defaults**

- `xx` missing: error 37, AXIS NUMBER MISSING
- `nn1` missing: error 38, COMMAND PARAMETER MISSING
- `nn2` missing: error 38, COMMAND PARAMETER MISSING

**DESCRIPTION**

This command is used to assign DIO bits for notifying the motion status – moving or not moving – of a selected axis. When the selected axis is not moving, the DIO bit state changes to the level specified with this command (refer parameter `nn2`).

**Note:**

The direction of the DIO port (A or B) the desired bit belongs to, should be set to "output" in order for the DIO bit to be set accurately. Refer "BO" command for further details.

**Note:**

If a motion feature, such as origin search, involves a sequence of moves, the motion status will be set to not moving only after the entire sequence of moves has completed.

**RETURNS**

If the "?" sign takes the place of `nn` value, this command reports the current assignment.

**REL. COMMANDS**

- **BN** - Enable DIO bits to notify motion status
- **BO** - Set DIO port A, B direction

**EXAMPLE**

```
BO 2H  | Set DIO port A to input and B to output
2BM 9, 1 | Use DIO bit #9 to indicate motion status of axis #2. This DIO bit should be HIGH when axis #2 is not moving
2BN 1  | Enable notification of motion using DIO bits for axis #2
2BM?  | Query the DIO bit assignment for axis #2
9, 1   | The controller responds with the assigned values
```
### BN

**enable DIO bits to notify motion status**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

`xxBNnn` or `xxBN?`

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ]</th>
<th>nn [ int ]</th>
</tr>
</thead>
<tbody>
<tr>
<td>Description</td>
<td>axis number</td>
<td>disable or enable</td>
</tr>
<tr>
<td>Range</td>
<td>xx</td>
<td>1 to MAX AXES</td>
</tr>
<tr>
<td></td>
<td>nn</td>
<td>0 = disable, and 1 = enable or ? to read current setting</td>
</tr>
</tbody>
</table>

**Units**

None

**Defaults**

<table>
<thead>
<tr>
<th>xx</th>
<th>missing: error 37, AXIS NUMBER MISSING</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>out of range: error 9, AXIS NUMBER OUT OF RANGE</td>
</tr>
<tr>
<td>nn</td>
<td>missing: error 38, COMMAND PARAMETER MISSING</td>
</tr>
<tr>
<td></td>
<td>out of range: error xx1, PARAMETER OUT OF RANGE</td>
</tr>
</tbody>
</table>

**DESCRIPTION**

This command is used to disable or enable notification of requested axis' motion status through DIO bits.

**RETURNS**

If the "?" sign takes the place of `nn` value, this command reports the current status.

**REL. COMMANDS**

<table>
<thead>
<tr>
<th>BM</th>
<th>Assign DIO bits to notify motion status</th>
</tr>
</thead>
<tbody>
<tr>
<td>BO</td>
<td>Set DIO port A, B</td>
</tr>
<tr>
<td>BK</td>
<td>Assign DIO bits to inhibit motion</td>
</tr>
<tr>
<td>BL</td>
<td>Enable DIO bits to inhibit motion</td>
</tr>
</tbody>
</table>

**EXAMPLE**

<table>
<thead>
<tr>
<th>BO 2H</th>
<th>Set DIO port A to input and ports B to output</th>
</tr>
</thead>
<tbody>
<tr>
<td>2BM 9, 1</td>
<td>Use DIO bit #9 to indicate motion status of axis #2. This DIO bit should be HIGH when axis #2 is not moving</td>
</tr>
<tr>
<td>2BN 1</td>
<td>Enable notification of motion using DIO bits for axis #2</td>
</tr>
<tr>
<td>2BM?</td>
<td>Query the DIO bit assignment for axis #2</td>
</tr>
<tr>
<td>9, 1</td>
<td>The controller responds with the assigned values</td>
</tr>
<tr>
<td>2BN?</td>
<td>Query the status of notifying motion status of axis #2 through DIO bits</td>
</tr>
<tr>
<td>1</td>
<td>The controller responds with 1 indicating feature is enabled</td>
</tr>
</tbody>
</table>
BO set DIO port A, B direction

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

BO\(n\) or BO\(?

**PARAMETERS**

**Description**

\(nn\) [ int ] - hardware limit configuration

**Range**

\(nn\) - 0 to 03H (hexadecimal with leading zero(0)) on ESP100 and ESP300 or ? to read current setting

**Units**

\(nn\) - None

**Defaults**

\(nn\) missing: error 38, COMMAND PARAMETER MISSING
out of range: error 7, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to set digital I/O (DIO) port A, B, and C direction where bit-0 corresponds to port A, bit-1 to port B, and bit-2 to port C. If any bit is set to zero(0) then its corresponding port will become an input only. If any bit is set to one(1) then its corresponding port will becomes an output only. Ports A and B only are available on the ESP100 and ESP300.

A DIO within a port configured as an input can only report its present HIGH or LOW logic level. Whereas a DIO bit within a port configured as an output can set(1) or clear(0) the corresponding DIO hardware to HIGH or LOW logic level. Reading the status of a port configured as output returns its present output status.

**Note:**

All direction bits are automatically zeroed, or cleared, after a system reset. Therefore all DIO ports default to input by default.

**Note:**

Each DIO bit has a pulled-up resistor to +5V. Therefore, all bits will be at HIGH logic level if not connected to external circuit and configured as input.

<table>
<thead>
<tr>
<th>BIT#</th>
<th>VALUE</th>
<th>DEFINITION</th>
</tr>
</thead>
<tbody>
<tr>
<td>*0</td>
<td>0</td>
<td>port A (DIO bit-0 through bit-7) assigned as input</td>
</tr>
<tr>
<td>0</td>
<td>1</td>
<td>port A (DIO bit-0 through bit-7) assigned as output</td>
</tr>
<tr>
<td>*1</td>
<td>0</td>
<td>port B (DIO bit-8 through bit-15) assigned as input</td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>port B (DIO bit-8 through bit-15) assigned as output</td>
</tr>
</tbody>
</table>

\* default setting after system reset

**RETURNS**

If the “?” sign takes the place of \(nn\) value, this command reports the current setting in hexadecimal notation.
### Section 3 – Remote Mode

<table>
<thead>
<tr>
<th>REL. COMMANDS</th>
<th>SB</th>
<th>set/clear DIO bits</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>EXAMPLE</strong></td>
<td><strong>BO?</strong></td>
<td><strong>read DIO port direction configuration</strong></td>
</tr>
<tr>
<td></td>
<td>0H</td>
<td><strong>controller returns a value of 0H (all ports are input)</strong></td>
</tr>
<tr>
<td></td>
<td><strong>BO 1H</strong></td>
<td><strong>configure DIO port A as output</strong></td>
</tr>
<tr>
<td></td>
<td><strong>SB 0FFH</strong></td>
<td><strong>set all port A DIO output HIGH</strong></td>
</tr>
</tbody>
</table>
BP assign DIO bits for jog mode

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

`xBPnn1,nn2` or `xBP?`

**PARAMETERS**

**Description**

- `xx` [int] - axis number
- `nn1` [int] - bit number for jogging in negative direction
- `nn2` [int] - bit number for jogging in positive direction

**Range**

- `xx` - 1 to MAX AXES
- `nn_i` - 0 to 15

**Units**

- `xx` - none
- `nn_i` - none

**Defaults**

- `xx` missing: error 37, AXIS NUMBER MISSING
- out of range: error 9, AXIS NUMBER OUT OF RANGE
- `nn` missing: error 38, COMMAND PARAMETER MISSING
- out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to assign DIO bits for jogging axes in either negative or positive directions.

**RETURNS**

If "?" sign is issued along with command, the controller returns the DIO bits used for jogging in negative and positive directions respectively.

**REL. COMMANDS**

- `BO` - enable usage of DIO bits for jogging axes

**EXAMPLE**

- `1BP3, 4` | set DIO bit #3 to jog axis #1 in negative direction and DIO bit #4 to jog axis #1 in positive direction
- `1BP?` | query the DIO bits assigned for jogging
- `3,4` | controller returns the bit assignment
- `1BQ1` | enable axis #1 jogging through DIO bits.
**BQ**

### enable DIO bits for jog mode

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

#### USAGE

**IMM**

**PGM**

**MIP**

#### SYNTAX

- xxBQnn
- BQ?

#### PARAMETERS

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ]</th>
<th>-</th>
<th>axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Range</td>
<td>nn [ int ]</td>
<td>-</td>
<td>disable or enable</td>
</tr>
<tr>
<td>Units</td>
<td>xx</td>
<td>none</td>
<td></td>
</tr>
<tr>
<td></td>
<td>nn</td>
<td>one</td>
<td></td>
</tr>
</tbody>
</table>

**Defaults**

- xx missing: error 37, AXIS NUMBER MISSING
- xx out of range: error 9, AXIS NUMBER OUT OF RANGE
- nn missing: error 38, COMMAND PARAMETER MISSING
- nn out of range: error xx2, PARAMETER OUT OF RANGE

#### DESCRIPTION

This command is used to disable or enable jogging of a requested axis through DIO bits.

#### RETURNS

If “?” sign is issued along with command, the controller returns the status of jog through DIO bits.

#### REL. COMMANDS

BP - assign DIO bits for jog mode

#### EXAMPLE

1BP3,4 | set DIO bit #3 to jog axis #1 in negative direction and
       | DIO bit #4 to jog axis #1 in positive direction
1BP?  | query the DIO bits assigned for jogging
3,4   | controller returns the bit assignment
1BQ1  | enable axis #1 jogging through DIO bits.
**CL**  
set closed loop update interval

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**  
xxCLnn or xxCL?

**PARAMETERS**

| Description | xx [ int ] - axis number  
nn [ int ] - closed loop update interval |
|-------------|---------------------------------------|
| **Range**   | xx - 0 to MAX AXES                  
nn - 0 to 60000                        |
| **Units**   | xx - none                             
nn - milliseconds                      |

**Defaults**

| Description | xx missing: error 37, AXIS NUMBER MISSING  
            | out of range: error 9, AXIS NUMBER OUT OF RANGE  
nn missing: error 38, COMMAND PARAMETER MISSING  
            | out of range: error 7, PARAMETER OUT OF RANGE |

**DESCRIPTION**

This command is used to set the closed loop update interval for an axis. This will be the time duration between position error corrections during closed loop stepper positioning. Note that this command is effective only for stepper motors.

Furthermore, note that encoder feedback and closed loop positioning must be enabled for this command to be effective. Refer to feedback configuration (**ZB**) command for enabling these features in the case of stepper motors.

If "0" is used as an axis number, this command will set the specified interval to all the axes.

**RETURNS**

If "?" sign takes the place of nn value, this command reports the current setting.

**REL. COMMANDS**

| ZB | set feedback configuration  
| DB | set position deadband value |

**EXAMPLE**

- 3ZB300 | enable encoder feedback and closed loop positioning of axis #3
- 3DB1 | set position deadband value to 1 encoder count
- 3DB? | query deadband value
- 1 | controller returns a value of 1 encoder count
- 3CL100 | set closed loop update interval to 100 milliseconds
- 3CL? | query closed loop update interval
- 100 | controller returns a value of 100 milliseconds
### CO

**set linear compensation**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

#### USAGE

- **xxCO**nn or xxCO?

#### SYNTAX

- xx [ int ] - axis number
- nn [ float ] - linear compensation value

#### PARAMETERS

**Description**
- **xx** - axis number
- **nn** - linear compensation value

**Range**
- xx - 1 to MAX AXES
- nn - 0 to 2e+9

**Units**
- xx - none
- nn - none

**Defaults**
- **xx** missing: error 37, AXIS NUMBER MISSING
  out of range: error 9, AXIS NUMBER OUT OF RANGE
- **nn** missing: error 38, COMMAND PARAMETER MISSING
  out of range: error 7, PARAMETER OUT OF RANGE

#### DESCRIPTION

This command allows users to compensate for linear positioning errors due to stage inaccuracies. Such errors decrease or increase actual motion linearly over the travel range.

The linear compensation value, **nn** is calculated according to the formula given below:

\[
nn = \left( \frac{error}{travel} \right)
\]

where,
- \(travel\) = measured travel range
- \(error\) = error accumulated over the measured travel range

**Note:**

The command is affective only after a home search (OR) or define home (DH) is performed on the specified axis.

#### RETURNS

- If “?” sign takes the place of **nn** value, this command reports the current setting.

#### REL. COMMANDS

- None

#### EXAMPLE

If a stage has a travel range of 100 mm and it accumulates an error of 0.003 mm over the complete travel range,

\[
nn = \left( \frac{0.003}{100} \right) = 0.00003
\]

| 1CO0.00003 | Set linear compensation value for axis #1 to 0.00003 |
| 1CO? | Query linear compensation value for axis #1 |
| 0.00003 | Controller returns a value of 0.00003 |
| IOR | Perform home search on axis #1 |
| 1PA10 | Move axis #1 to absolute 10 units |
**DB**  set position deadband

<table>
<thead>
<tr>
<th>USAGE</th>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

**SYNTAX**

`xxDBnn` or `xxDB?`

**PARAMETERS**

- **Description**: `xx` [ int ] - axis number
  - `nn` [ int ] - deadband value
- **Range**: `xx` - 0 to MAX AXES
  - `nn` - to 2e9
- **Units**: `xx` - none
  - `nn` - encoder counts
- **Defaults**: `xx` missing:  error 37, AXIS NUMBER MISSING
  - out of range:  error 9, AXIS NUMBER OUT OF RANGE
  - `nn` missing:  error 38, COMMAND PARAMETER MISSING

**DESCRIPTION**

This command is used to set the position deadband value for an axis. Since a majority of electro-mechanical systems have mechanical backlash or frictional hysteresis, closed-loop positioning can at times lead to oscillation or limit cycling of the systems around a desired position. In such situations, setting position deadband value judiciously can avoid limit cycling of the systems.

Note that this command is effective only during position regulation (holding position) as opposed to moving.

Furthermore, note that encoder feedback and closed loop positioning must be enabled for this command to be effective. Refer to feedback configuration (`ZB`) command for enabling these features in the case of stepper motors.

If “0” is used as an axis number, this command will set the specified deadband value to all the axes.

**RETURNS**

If “?” sign takes the place of `nn` value, this command reports the current setting.

**REL. COMMANDS**

- `ZB` - set feedback configuration
- `CL` - set closed loop update interval

**EXAMPLE**

<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZB300</td>
<td>enable encoder feedback and closed loop positioning of axis#3</td>
</tr>
<tr>
<td>3DB1</td>
<td>set position deadband value to 1 encoder count</td>
</tr>
<tr>
<td>3DB?</td>
<td>query deadband value</td>
</tr>
<tr>
<td><code>l</code></td>
<td>controller returns a value of 1 encoder count</td>
</tr>
<tr>
<td>3CL100</td>
<td>set closed loop update interval to 100 milliseconds</td>
</tr>
<tr>
<td>3CL?</td>
<td>query closed loop update interval</td>
</tr>
<tr>
<td>100</td>
<td>controller returns a value of 100 milliseconds</td>
</tr>
</tbody>
</table>
**DC**

**setup data acquisition**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

**USAGE**

DCnn1,nn2,nn3,nn4,nn5,nn6

**SYNTAX**

**PARAMETERS**

**Description**

- **nn1** [ int ] - data acquisition mode
- **nn2** [ int ] - axis used to trigger data acquisition
- **nn3** [ int ] - data acquisition parameter 3
- **nn4** [ int ] - data acquisition parameter 4
- **nn5** [ int ] - data acquisition rate
- **nn6** [ int ] - number of data samples to be acquired

**Range**

- **nn1** -
  - 0: Start data acquisition immediately
  - 1: Start data acquisition when trigger axis starts motion
  - 2: Start data acquisition when trigger axis reaches slew speed
- **nn2** - 1 to MAX AXES
- **nn3** - 0
- **nn4** - 0 to 7
- **nn5** - 0 to 1000
- **nn6** - to 1000

**Units**

None

**Defaults**

nn missing: error 38, COMMAND PARAMETER MISSING
out of range: error 7, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to setup data acquisition—analog data acquisition (ADC) as well as acquisition of certain trace variables—using ESP motion controller.

**PARAMETER nn1:** Data acquisition modes 0—2 support different ways in which position feedback data can be collected.

**PARAMETER nn2:** Data acquisition—is triggered by the motion of an axis specified through this parameter. Exceptions to this requirement is in the case of data acquisition mode 0. For this case enabling data acquisition is sufficient to start the data acquisition process. For all other modes, two conditions—enabling of data acquisition and any mode dependent conditions such as trigger axis starting motion or reaching slew speed—must be met in order to start the data acquisition process.

**PARAMETER nn3:** Set this value to 0.

**PARAMETER nn4:** This parameter is used to identify the position feedback channels to be collected. Please refer to table below.
PARAMETER nn5: The rate at which data is to be acquired is specified through this parameter. The rate specified is in multiples of the servo cycle rate. For example, a value of 0 implies data acquisition every servo cycle, a value of 1 implies every other servo cycle, and so on.

PARAMETER nn6: The number of samples of data to be acquired is specified through this parameter. Data acquisition process is considered to be "done" only after the number of samples specified by this parameter are acquired by the controller. The status of data acquisition process may be found by issuing ASCII command, DD. Once the data acquisition is done, ASCII command, DG may be used to collect the data from the controller.

**Note:**
The controller responds with a servo cycle tick count along with every data sample collected.

**RETURNS**
None.

**REL. COMMANDS**
- DD - get data-acquisition done status
- DE - enable / disable data-acquisition
- DF - get data-acquisition status – number of samples collected
- DG - get data-acquisition data

**EXAMPLE**
```
DC1,1,0,4,1,500
```
- **nn1=1**: Start data acquisition when trigger axis start motion
- **nn2=1**: Trigger axis is 1
- **nn3=0**
- **nn4=4**: Position feedback from channel 3
- **nn5=1**: Collect data entry often servo cycle
- **nn6=500**: Collect 500 samples

Enable data acquisition

```
DE1
```

```
DD
```
- Get data acquisition sample count

```
500
```
- Controller responds with number samples collected

```
DG
```
- Get data collected

---

<table>
<thead>
<tr>
<th>nn4</th>
<th>Position feedback channels collected</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>none</td>
</tr>
<tr>
<td>1</td>
<td>channel 1</td>
</tr>
<tr>
<td>2</td>
<td>channel 2</td>
</tr>
<tr>
<td>3</td>
<td>channel 1 &amp; 2</td>
</tr>
<tr>
<td>4</td>
<td>channel 3</td>
</tr>
<tr>
<td>5</td>
<td>channel 1 &amp; 3</td>
</tr>
<tr>
<td>6</td>
<td>channel 2 &amp; 4</td>
</tr>
<tr>
<td>7</td>
<td>channel 1,2,3</td>
</tr>
</tbody>
</table>
**DD**

get data acquisition done status

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

DD

**PARAMETERS**

none

**DESCRIPTION**

This command returns the status of a data acquisition request.

**RETURNS**

aa, where: 

\[ aa = \begin{cases} 1 & \text{for True} \\ 0 & \text{for False} \end{cases} \]

**REL. COMMANDS**

DC - setup data acquisition request

DG - get acquired data

DF - data acquisition status, returns # of samples collected

DE - enable / disable data acquisition

**EXAMPLE**

DC1,1,0,4,1,500

\[ \begin{align*}
\text{nn1} &= 1: \text{Start data acquisition when trigger axis start motion} \\
\text{nn2} &= 1: \text{Trigger axis is 1} \\
\text{nn3} &= 0 \\
\text{nn4} &= 4: \text{Position feedback from channel 3} \\
\text{nn5} &= 1: \text{Collect data entry often servo cycle} \\
\text{nn6} &= 500: \text{Collect 500 samples}
\end{align*} \]

DE1

\( \text{Enable data acquisition} \)

DD

\( \text{Query data acquisition done status} \)

1 = true 0 = false

If true,

DE0

\( \text{Disable data acquisition} \)

DF

\( \text{Get data acquisition sample count} \)

500

\( \text{Controller responds with number samples collected} \)

DG

\( \text{Get data collected} \)
**DE**

**enable/disable data acquisition**

**PARAMETERS**

<table>
<thead>
<tr>
<th>PARAMETER</th>
<th>DESCRIPTION</th>
<th>RANGE</th>
<th>NOTES</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**DESCRIPTION**

This command is used to enable / disable the data acquisition request.

**SYNTAX**

DE nn

**RETURNS**

None

**REL. COMMANDS**

DC - setup data acquisition request  
DG - get acquired data  
DF - data acquisition status, returns # of samples collected  
DD - data acquisition done status

**EXAMPLE**

DC1,1,0,4,1,500

| nn1=1 : Start data acquisition when trigger axis start motion |
| nn2=1 : Trigger axis is 1 |
| nn3=0 |
| nn4=4 : Position feedback from channel 3 |
| nn5=1 : Collect data entry often servo cycle |
| nn6=500 : Collect 500 samples |
| DE1 Enable data acquisition |
| DD Query data acquisition done status |

If true, DEO Disable data acquisition  
DF Get data acquisition sample count  
500 Controller responds with number samples collected  
DG Get data collected
**DF**  
get data acquisition sample count

<table>
<thead>
<tr>
<th>USAGE</th>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>♦</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>SYNTAX</th>
<th>DF</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>PARAMETERS</th>
<th>none</th>
</tr>
</thead>
</table>

| DESCRIPTION | This command returns the number of a data acquisition collected to the point of this request. |

| RETURNS     | aa, where:  
|-------------| aa = number of samples |

| REL. COMMANDS | DC - setup data acquisition request  
|---------------| DG - get acquired data  
|               | DD - data acquisition done status  
|               | DE - enable / disable data acquisition |

| EXAMPLE      | DC1,1,0,4,1,500  
|--------------| nn1=1 : Start data acquisition when trigger axis start motion  
|              | nn2=1 : Trigger axis is 1  
|              | nn3=0  
|              | nn4=4 : Position feedback from channel 3  
|              | nn5=1 : Collect data entry often servo cycle  
|              | nn6=500 : Collect 500 samples  
|              | DE1  
|              | Enable data acquisition  
|              | DD  
|              | Query data acquisition done status  
|              | 1 = true  
|              | 0 = false  
| If true,     |  
| DEO          | Disable data acquisition  
| DF           | Get data acquisition sample count  
| 500          | Controller responds with number samples collected  
| DG           | Get data collected  

Section 3 – Remote Mode
DG  get acquisition data

**USAGE**  IMM    PGM    MIP
*v*      *v*

**SYNTAX**  DG

**PARAMETERS**  None

**DESCRIPTION**  This command is used to retrieve data acquired from a data acquisition request.

**RETURNS**  This command returns byte wide binary data. Each four bytes represents one DSP 32 bit word. The number of bytes returned depends on the setup request. (See DC command).

**REL. COMMANDS**
- DC  - setup data acquisition request
- DE  - enable / disable data acquisition
- DF  - data acquisition status, returns # of samples collected
- DD  - data acquisition done status

**EXAMPLE**

```
DC1,1,0,4,1,500  
| nn1=1  : Start data acquisition when trigger axis start motion  
| nn2=1  : Trigger axis is 1  
| nn3=0  
| nn4=4  : Position feedback from channel 3  
| nn5=1  : Collect data entry often servo cycle  
| nn6=500 : Collect 500 samples  
DE1          | Enable data acquisition  
DD           | Query data acquisition done status  
1 = true 0 = false
```

If true,
- DEO  | Disable data acquisition
- DF  | Get data acquisition sample count
- 500 | Controller responds with number samples collected
- DG  | Get data collected
DH define home

**USAGE**

**IMM** PGM MIP

**SYNTAX**

`xxDHnn`

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [int]</th>
<th>axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn [float]</td>
<td>position value</td>
</tr>
</tbody>
</table>

- **Range**
  - `xx` - 1 to MAX AXES
  - `nn` - 0 to ±2e+9

- **Units**
  - `xx` - none
  - `nn` - predefined units

- **Defaults**
  - `xx` missing: error 37, AXIS NUMBER MISSING
  - Out of range: error 9, AXIS NUMBER OUT OF RANGE
  - `nn` missing: error 38, COMMAND PARAMETER MISSING
  - Out of range: error `xx2`, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to define current position, HOME position. This means that the current position will be preset to the value defined by parameter ‘nn’.

**RETURNS**

If the “?” sign takes the place of `nn` value, this command reports the current setting

**REL. COMMANDS**

**OR** - execute a home search cycle

**EXAMPLE**

- `3OR1` | perform a home search on axis # 3
- `3DH` | define current position on axis # 3 HOME as 0 units
- `3DH 20.0` | define current position on axis # 3 HOME as 20.0 units
**DL** define label

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**SYNTAX**

xxDL

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ]</th>
<th>-</th>
<th>label number</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Range</strong></td>
<td>xx</td>
<td>-</td>
<td>1 to 100</td>
</tr>
<tr>
<td><strong>Units</strong></td>
<td>xx</td>
<td>-</td>
<td>none</td>
</tr>
</tbody>
</table>
| **Default**       | xx         |   | missing: error 38, COMMAND PARAMETER MISSING  
|                   |            |   | out of range: error xx2, PARAMETER OUT OF RANGE |

**DESCRIPTION**

This command defines a label inside a program. In combination with JL (jump to label) command, they offer significant program flow control.

The operation of the DL / JL command pair is similar to commands in other computer languages that allow conditional jumps (or GOTO's) to predefined labels in a program.

**Note:**

This command does not generate an error when not used inside a program. Since it can not do any harm, it is only ignored.

**RETURNS**

none

**REL. COMMANDS**

JL - jump to label

**EXAMPLE**

3XX | clear program 3 from memory, if any  
3EP | create program 3  
1DL | define label 1  
   |  
   |  
1JL 5 | jump to label 1 five(5) times  
QP | end entering program and quit programming mode  
3EX | run stored program number 3
**DO**

**set dac offset**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

`xxDOnn` or `xxDO?`

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ]</th>
<th>nn [ float ]</th>
<th>xx [ int ]</th>
<th>nn [ float ]</th>
</tr>
</thead>
<tbody>
<tr>
<td>DAC channel number</td>
<td>-</td>
<td>DAC offset value</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>Range</td>
<td><code>xx</code></td>
<td><code>1 to MAX AXES</code></td>
<td><code>nn</code></td>
<td><code>-10.0 to 10.0</code> or <code>?</code> to read the current setting</td>
</tr>
<tr>
<td>Units</td>
<td><code>xx</code></td>
<td>None</td>
<td><code>nn</code></td>
<td>Volts</td>
</tr>
<tr>
<td>Defaults</td>
<td><code>xx</code></td>
<td>missing: error 37, AXIS NUMBER MISSING</td>
<td><code>nn</code></td>
<td>missing: error 38, COMMAND PARAMETER MISSING</td>
</tr>
<tr>
<td></td>
<td>out of range: error 9, AXIS NUMBER OUT OF RANGE</td>
<td>out of range: error xx16, MAXIMUM DAC OFFSET EXCEEDED</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**DESCRIPTION**

This command is used to set the DAC offset compensation for the specified DAC channel. In the case of ESP6000 and ESP7000 motion controllers, there is only one DAC channel associated with every axis: DAC channel #1 is associated with axis #1, DAC channel #2 with axis #2 etc. In the case of ESP100 and ESP300 motion controllers, however, there are two DAC channels associated with every axis: DAC channels 1 and 2 are associated with axis #1, DAC channels 3 and 4 with axis #2 etc.

In order for the DAC offset to take affect, this command must be followed by the ASCII command, `UF` (Update Filter). This offset may be saved to non-volatile flash memory by issuing the ASCII command, `SM`. This will cause the DSP to automatically use the saved value after system reset or reboot.

**Note:**

DAC offset compensation is necessary on servo axes to prevent motor drift during motor off conditions.

**RETURNS**

If the “?” sign takes the place of `nn` value, this command reports the current setting.

**REL. COMMANDS**

None

**EXAMPLE**

1DO0.05 | Set the offset for DAC channel #1 to 0.05V
1UF | Update the filter settings
SM | Save parameters to non-volatile flash memory

---

Section 3 – Remote Mode
### DP

**read desired position**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

#### USAGE
xxDP?

#### SYNTAX

#### PARAMETERS

**Description**

| xx   | [ int ] | - | axis number |

**Range**

| xx   | - | 1 to MAX AXES |

**Units**

| xx   | - | none |

**Defaults**

| xx   | missing: | error 37, AXIS NUMBER MISSING |
|      | out of range: | error 9, AXIS NUMBER OUT OF RANGE |

#### DESCRIPTION

This command is used to read the desired position. It returns the instantaneous desired position.

The command could be sent at any time but its real use is while a motion is in progress.

#### RETURNS

nn where nn = desired position, in pre-defined units

#### REL. COMMANDS

| PA  | - | move to an absolute position |
| PR  | - | move to a relative position |
| TP  | - | read actual position |

#### EXAMPLE

| 3TP? | read position on axis # 3 |
| 5.32 | controller returns position 5.32 for axis # 3 |
| 3PR2.2 | start a relative motion of 2.2 on axis # 3 |
| 3DP? | read desired position on axis # 3 |
| 7.52 | controller returns desired position 7.52 for axis # 3 |
**DV**  
*read desired velocity*

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

`xxDV`

**PARAMETERS**

**Description**

`xx [ int ]` - axis number

**Range**

`xx` - 1 to MAX AXES

**Units**

`xx` - none

**Defaults**

缺省：错误37，轴号缺省。

范围外：错误9，轴号超出范围。

**DESCRIPTION**

此命令用于读取轴的期望速度。此命令可在任何时候发送，但其实际使用是在运动过程中。

**RETURNS**

`nn`, 其中`nn` = 轴的期望速度，单位为预定义单位。

**REL. COMMANDS**

PA - move to an absolute position
PR - move to a relative position

**EXAMPLE**

```
3TP?  | read position on axis #3
5.32  | controller returns position 5.32 units for axis #3
3PR2.2 | start a relative motion of 2.2 units on axis #3
3DV   | read desired velocity on axis #3
0.2   | controller returns velocity 0.2 units/sec for axis #3
3DP?  | read desired position on axis #3
7.52  | controller returns desired position 7.52 units for axis #3
```
EO  automatic execution on power on

**USAGE**

xxEO\(nn\) or xxEO?

**SYNTAX**

**PARAMETERS**

- **Description**: xx [ int ] - program number
- **Range**: xx - 1 to 100
- **Units**: xx - none
- **Defaults**: None

**DESCRIPTION**

This command sets the program number that is automatically executed on power on. If nn is missing, the xx numbered program is executed once.

**RETURNS**

If the sign “?” takes place of nn value, this command reports the number of the program that is executed on power on and the number of times of execution.

**REL. COMMANDS**

- QP - quit programming mode
- EX - execute stored program
- AP - abort stored program execution
- XX - erase program

**EXAMPLE**

- 3EO | set program #3 to be executed once on power on
- EO? | query the program number executed on power on
- EO,3,1 | controller returns program #3 executed once on power on
- EO | Reset automatic program execution – no program is executed on power on
**EP**  
enter program mode

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**USAGE**

**SYNTAX**

xxEP

**PARAMETERS**

**Description**

xx [ int ] - program number

**Range**

xx - 1 to 100

**Units**

xx - none

**Defaults**

xx missing: error 38, COMMAND PARAMETER MISSING

out of range: error 7, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command sets the controller in programming mode. All the commands following this one will not be executed immediately but stored in memory as part of program number xx. To exit program entry mode and return to immediate mode, use QP command. Programs can be entered in any order. If a program already exists then it must be first deleted using XX command.

**Note:**

Programs are automatically stored into non-volatile memory when created.

**RETURNS**

none

**REL. COMMANDS**

QP - quit programming mode

EX - execute stored program

AP - abort stored program execution

XX - erase program

**EXAMPLE**

3XX | clear program 3 from memory, if any
3EP | activate program mode and enter following commands as
   | program 3
   .
   .
   .
   QP | end entering program and quit programming mode
3EX | run stored program number 3
**ES**

**define event action command string**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

ESnn or ES?

**PARAMETERS**

- **Description**
  - nn [ string ] - ASCII command string (184 characters max)
- **Range**
  - nn - Limited to existing (non-query) command support or ? to read the current setting

**Units**

None

**Defaults**

nn missing: To clear command string and disable event action

**DESCRIPTION**

This command is used to define (and enable) or disable (if null string) an event action command string to be performed when an external trigger occurs.

This command is effective only if it is used in conjunction with ASCII command, DC with data acquisition mode set to either 3 or 33. If the number of samples to be collected is specified to be 1 using DC command, the event action is initiated immediately following the detection of an external trigger. However, if the number of samples is specified to be greater than 1, the event action is initiated only after all the external triggers—equal to the number of samples required to complete the data acquisition—are detected by the controller.

**Note:**

The external source for triggering data acquisition process (modes 3, 33 and 39) should be connected to pin #20 on the auxiliary I/O connector. Please refer to the appendix on Connector Pin Assignments for further details.

**RETURNS**

If the “?” sign takes the place of nn value, this command reports the current ASCII command string for event trigger command processing.

**REL. COMMANDS**

- DC - setup data acquisition
- DD - get data-acquisition done status
- DE - enable / disable data-acquisition
- DF - get data-acquisition status – number of samples collected
- DG - get data-acquisition data
| Example | DC3,1,3,5,0,1 | Param. #1: Acquire analog data on an external trigger  
| | Param. #2: No consequence for this data acquisition mode  
| | Param. #3: Acquire analog channels 1 & 2 ($3_{10} = (11)_2$)  
| | Param. #4: Acquire feedback channels 1 & 3 ($5_{10} = (101)_2$)  
| | Param. #5: No consequence for this data acquisition mode  
| | Param. #6: Acquire one sample of data  
| ES 1MF | Turn OFF motor #1 when the external event trigger occurs  
| | DE1 | Enable analog data acquisition  
| | DD | Query data-acquisition done status  
| | | 1 = true, 0 = false.  
| | If true, | Disable trace variable data acquisition  
| | DE0 | Get data collected  
| | DG | Get data collected |
**EX**

**execute a program**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIPO</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

**SYNTAX**

xxEXnn

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ] -</th>
<th>nn [ int ] -</th>
</tr>
</thead>
<tbody>
<tr>
<td>Program number</td>
<td>number of times to execute the program</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>xx</th>
<th>-</th>
<th>1 to 100</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>-</td>
<td>1 to 2147385345</td>
</tr>
</tbody>
</table>

**Defaults**

- xx missing: error 38, COMMAND PARAMETER MISSING
- xx out of range: error 7, PARAMETER OUT OF RANGE
- nn missing: 1 assumed
- nn out of range: error 7, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to start executing a program. When the command is received the controller executes the program line by line or according to the flow control instructions.

During program execution, only commands that ask for information and that stop the motion are still allowed. Any of the following commands will terminate a program, in one way or another: AB, AP, MF, RS and ST. Most natural way to just stop a program execution is by using the AP command, the other ones having a more drastic effect.

**RETURNS**

none

**REL. COMMANDS**

- QP - quit programming mode
- EP - enter program mode
- AP - abort stored program execution
- XX - erase program

**EXAMPLE**

3XX | clear program 3 from memory, if any
3EP | activate program mode and enter following commands as program 3
    | .
    | .
QP | end entering program and quit programming mode
3EX | run stored program number 3
**FE**

set maximum following error threshold

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

xxFE

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ]</th>
<th>axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn [float]</td>
<td></td>
<td>maximum allowed following error</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Range</th>
<th>xx</th>
<th>1 to MAX AXES</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td></td>
<td>0 to (2e9 \times \text{encoder resolution}),</td>
</tr>
<tr>
<td></td>
<td></td>
<td>or ? to read current setting</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Units</th>
<th>xx</th>
<th>none</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td></td>
<td>predefined units</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Defaults</th>
<th>xx</th>
<th>missing: error 37, AXIS NUMBER MISSING</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>out of range: error 9, AXIS NUMBER OUT OF RANGE</td>
</tr>
<tr>
<td>nn</td>
<td>missing:</td>
<td>error 38, COMMAND PARAMETER MISSING</td>
</tr>
<tr>
<td></td>
<td></td>
<td>out of range: error xx2, PARAMETER OUT OF RANGE</td>
</tr>
</tbody>
</table>

**DESCRIPTION**

This command sets the maximum allowed following error threshold for an axis. This error is defined as the difference between the real position and the theoretical position of a motion device. The real position is the one reported by the position sensing device (encoder, scale, etc.) and the theoretical position is calculated by the controller each servo cycle. If, for any axes and any servo cycle, the following error exceeds the preset maximum allowed following error, the controller invokes the following error event handling process which is defined with the **ZF** command. By default motor power is turned OFF.

**Note:**

Using the **ZF** command each axis can be individually configured to either turn motor power OFF, abort motion using e-stop deceleration, or ignore the error.

**RETURNS**

If the “?” sign takes the place of **nn** value, this command reports the current setting.

**REL. COMMANDS**

**ZF**  -  set following error event configuration

**EXAMPLE**

3FE ?  | read maximum following error for axis # 3  
0.5    | controller returns for axis # 3 following error of 0.5 unit  
3FE 1.0 | set maximum following error for axis # 3 to 1 unit
### FP

**set position display resolution**

<table>
<thead>
<tr>
<th>USAGE</th>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

```
xxFPnn  or  xxFP?
```

**PARAMETERS**

**Description**

- `xx` [int] - axis number
- `nn` [int] - display resolution

**Range**

- `xx` - 1 to MAX AXES
- `nn` - 0 to 7
  - or `?` to read present setting

**Units**

- `xx` - none
- `nn` - none

**Defaults**

- `xx` missing: error 37, AXIS NUMBER MISSING
- out of range: error 9, AXIS NUMBER OUT OF RANGE
- `nn` missing: error 38, COMMAND PARAMETER MISSING
- out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to set the display resolution of position information. For instance, if `nn = 4`, the display will show values as low as 0.0001 units. If `nn = 7`, the display will show values in exponential form. If the user units (refer SN command) are in encoder counts or stepper increments, the position information is displayed in integer form, independent of the value set by this command.

**RETURNS**

If “?” sign takes the place of `nn` value, this command reports current setting.

**REL. COMMANDS**

None

**EXAMPLE**

```
1FP?    | read position display resolution for axis #1
4     | controller returns a value of 4
1TP    | read actual position of axis #1
5.0001 | controller returns position value
1FP2   | set position display resolution for axis #1 to 2
1TP    | read actual position of axis #1
5.00   | controller returns position value
1FP7   | set position display resolution for axis #1 to 7
1TP    | read actual position of axis #1
5.000000E+0 | controller returns position value
```
FR

set encoder full-step resolution

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

SYNTAX

xxFRnn or xxFR?

PARAMETERS

**Description**

- **xx** [int] - axis number
- **nn** [float] - encoder full step resolution

**Range**

- **xx** - 1 to MAX AXES
- **nn** - 2e-9 to 2e+9 in user defined units or ? to read present setting

**Units**

- **xx** - none
- **nn** - none

**Defaults**

- **xx** missing: error 37, AXIS NUMBER MISSING
- **nn** missing: error 38, COMMAND PARAMETER MISSING
- out of range: error 9, AXIS NUMBER OUT OF RANGE
- or ? to read present setting

**DESCRIPTION**

This command is used to set the encoder full step resolution for a Newport Unidrive compatible programmable driver with step motor axis.

**RETURNS**

If “?” sign takes the place of **nn** value, this command reports current setting.

**REL. COMMANDS**

- QS - set microstep factor
- SU - set encoder resolution

**EXAMPLE**

- 2FR?
- 0.0001
- 2FR0.0005
- SM

<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>2FR?</td>
<td>read encoder full-step resolution setting of axis # 2</td>
</tr>
<tr>
<td>0.0001</td>
<td>controller returns a value of 0.0001 units for axis #2</td>
</tr>
<tr>
<td>2FR0.0005</td>
<td>set encoder full-step resolution to 0.0005 units for axis # 2</td>
</tr>
<tr>
<td>SM</td>
<td>save all controller settings to non-volatile memory</td>
</tr>
</tbody>
</table>
GR

set master-slave reduction ratio

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

`xxGRnn` or `xxGR?`

**PARAMETERS**

**Description**

<table>
<thead>
<tr>
<th>xx</th>
<th>int</th>
<th>axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>float</td>
<td>reduction ratio</td>
</tr>
</tbody>
</table>

**Range**

<table>
<thead>
<tr>
<th>xx</th>
<th>1 to MAX AXES</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>±1,000,000</td>
</tr>
</tbody>
</table>

**Units**

<table>
<thead>
<tr>
<th>xx</th>
<th>none</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>none</td>
</tr>
</tbody>
</table>

**Defaults**

<table>
<thead>
<tr>
<th>xx</th>
<th>error 37, AXIS NUMBER MISSING</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>error 9, AXIS NUMBER OUT OF RANGE</td>
</tr>
</tbody>
</table>

**DESCRIPTION**

This command sets the master-slave reduction ratio for a slave axis. The trajectory of the slave is the desired trajectory or actual position of the master scaled by reduction ratio. Refer to the TJ command to specify the desired trajectory mode for a slave axis.

**Note:**

Use this command very carefully. The slave axis will have its speed and acceleration in the same ratio as the position. Also, ensure that the ratio used for the slave axis does not cause overflow of this axis’ parameters (speed, acceleration), especially with ratios greater than 1.

**RETURNS**

If “?” sign is issued along with command, the controller returns master-slave reduction ratio.

**REL. COMMANDS**

SS - define master-slave relationship

**EXAMPLE**

- `2SS1` | set axis 2 to be the slave of axis 1
- `2SS?` | query the master axis number for axis 2
- `1` | controller returns a value of 1
- `2TJ5` | set axis 2 trajectory mode to 5
- `2GR0.5` | set the reduction ratio of axis 2 to 0.5
- `2GR?` | query the reduction ratio of axis 2
- `0.5` | controller returns a value of 0.5
## HA

**set group acceleration**

### Usage

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

### Syntax

`xxHAnn` or `xxHA?`

### Parameters

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ] -</th>
<th>nn [ float ] -</th>
</tr>
</thead>
<tbody>
<tr>
<td>group number</td>
<td>vector acceleration value</td>
<td></td>
</tr>
</tbody>
</table>

**Range**

<table>
<thead>
<tr>
<th>xx</th>
<th>1 to MAX GROUPS</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>0 to minimum of the maximum acceleration values of all axes assigned to this group.</td>
</tr>
</tbody>
</table>

**Units**

<table>
<thead>
<tr>
<th>xx</th>
<th>none</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>predefined units / second²</td>
</tr>
</tbody>
</table>

**Defaults**

- xx missing: error 13, GROUP NUMBER MISSING
- out of range: error 14, GROUP NUMBER OUT OF RANGE
- not assigned: error 15, GROUP NUMBER NOT ASSIGNED
- floating point: truncated
- nn missing: error 7, PARAMETER OUT OF RANGE
- negative: error 22, GROUP PARAMETER OUT OF RANGE
- out of range: error 24, GROUP MAXIMUM ACCELERATION EXCEEDED

### Description

This command is used to set the vectorial acceleration value for a group. This value will be used during coordinated motion of axes assigned to the group. It will override any original acceleration values specified for individual axes using AC command. The axes’ original values will be restored when the group to which they have been assigned is deleted.

This command takes effect immediately. It can be executed when controller is idling or motion is in progress or inside a program.

**Note:**

Avoid changing acceleration during acceleration or deceleration phases of a move. For better predictable results, change acceleration only when all the axes assigned to this group are not in motion.

### Returns

If “?” sign takes the place of nn value, this command reports the current setting.

### Related Commands

- AU - set maximum acceleration and deceleration for an axis
- HN - create a new group
- HD - set vectorial deceleration for a group
<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1HN1,2</td>
<td>create a new group (#1) with physical axes 1 and 2</td>
</tr>
<tr>
<td>1AU?</td>
<td>query maximum acceleration of axis #1</td>
</tr>
<tr>
<td>50</td>
<td>controller returns a value of 50 units/second(^2)</td>
</tr>
<tr>
<td>2AU?</td>
<td>query maximum acceleration of axis #2</td>
</tr>
<tr>
<td>60</td>
<td>controller returns a value of 60 units/second(^2)</td>
</tr>
<tr>
<td>1HA50</td>
<td>set vectorial acceleration of group #1 to 50 units/second(^2)</td>
</tr>
<tr>
<td>1HA?</td>
<td>query vectorial acceleration of group #1</td>
</tr>
<tr>
<td>50</td>
<td>controller returns a value of 50 units/second(^2)</td>
</tr>
</tbody>
</table>
HB  read list of groups assigned

**Usage**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**Syntax**

HB

**Parameters**

None

**Description**

This command is used to read the group numbers that have already been created or assigned.

**Returns**

This command reports the current setting. If no groups have been created, controller returns error number 15, GROUP NUMBER NOT ASSIGNED.

**Rel. Commands**

HN - create a new group
HX - delete a group

**Example**

1HN1,2 | create a new group (#1) with physical axes 1 and 2
1HN? | read axes assigned to group #1
1,2 | controller returns the axes assigned to group #1
2HN3,4 | create a new group (#2) with physical axes 3 and 4
2HN? | read axes assigned to group #2
3,4 | controller returns the axes assigned to group #2
HB | read list of groups created
I 2 | controller returns 1 and 2
**HC**

move group along an arc

**USAGE**

```
IMM   PGM   MIP
♦     ♦     ♦
```

**SYNTAX**

```
xxHC nn1, nn2, nn3 or xxHC?
```

**PARAMETERS**

**Description**

- `xx` [ int ] - group number
- `nn1` [ float ] - first coordinate of arc center
- `nn2` [ float ] - second coordinate of arc center
- `nn3` [ float ] - arc sweep angle

**Range**

- `xx` - 1 to MAX GROUPS
- `nn1, nn2` - any position within the travel limits
- `nn3` - any angle

**Units**

- `xx` - none
- `nn1, nn2` - predefined units
- `nn3` - degrees

**Defaults**

- `xx` missing: error 13, GROUP NUMBER MISSING
- `nn1` out of range: error 14, GROUP NUMBER OUT OF RANGE
- not assigned: error 15, GROUP NUMBER NOT ASSIGNED
- floating point: truncated

**DESCRIPTION**

This command initiates motion of a group along an arc. It causes all axes assigned to the group to move with predefined vectorial (tangential) velocity, acceleration and deceleration along an arc. The group target position is determined based on the position of axes at the beginning of move, center of arc and sweep angle.

If this command is received while a group move is in progress, the new command gets enqueued into a “via point” buffer. Please refer to Advanced Capabilities section for a detailed description of via point buffer implementation. The enqueued commands get executed on a FIFO basis when the move already in progress has reached its destination. The group does not come to a stop at the end of last move. Instead, there will be a smooth transition to the new move command, just as if it were one compound move (combination of multiple moves).

**Note:**

Only trapezoid velocity profile is employed linear interpolation motion.

**Note:**

The transition from last move to new move will be smooth if tangential velocity at the end of last move is the same as that at the beginning of new move.
RETURNS  
If "?" sign takes the place of nn values, this command reports the commanded center position of arc and sweep angle.

REL. COMMANDS

<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>HN</td>
<td>create a new group</td>
</tr>
<tr>
<td>HV</td>
<td>set vectorial velocity for a group</td>
</tr>
<tr>
<td>HA</td>
<td>set vectorial acceleration for a group</td>
</tr>
<tr>
<td>HD</td>
<td>set vectorial deceleration for a group</td>
</tr>
<tr>
<td>HO</td>
<td>enable a group</td>
</tr>
<tr>
<td>HF</td>
<td>disable a group</td>
</tr>
<tr>
<td>HL</td>
<td>move a group of axes to desired position along a line.</td>
</tr>
</tbody>
</table>

EXAMPLE

1HN1,2 | create a new group (#1) with physical axes 1 and 2
1HV10 | set vectorial velocity of group #1 to 10 units/second
1HA50 | set vectorial acceleration of group #1 to 50 units/second²
1HD50 | set vectorial deceleration of group #1 to 50 units/second²
1HO | enable group #1
1HP? | query current group position
50,50 | controller returns axis #1 = 50 units and axis #2 = 50 units
1HC40,60,180 | set axis #1 arc center = 40 units
set axis #2 arc center = 60 units
set sweep angle of arc = 180 degrees
1HC? | query target position of the commanded move
40, 60, 180 | controller returns axis #1 arc center = 40 units, axis #2 arc center = 70 units and arc sweep angle = 180 degrees
**HD**

**set group deceleration**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

```
xxHDnn or xxHD?
```

**PARAMETERS**

**Description**

- `xx` [int] - group number
- `nn` [float] - vector deceleration value

**Range**

- `xx` - 1 to MAX GROUPS
- `nn` - 0 to minimum of the maximum deceleration values of all axes assigned to this group.

**Units**

- `xx` - none
- `nn` - predefined units / second^2

**Defaults**

- `xx` missing: error 13, GROUP NUMBER MISSING
- `xx` out of range: error 14, GROUP NUMBER OUT OF RANGE
- `xx` not assigned: error 15, GROUP NUMBER NOT ASSIGNED
- `nn` floating point: truncated
- `nn` missing: error 7, PARAMETER OUT OF RANGE
- `nn` negative: error 22, GROUP PARAMETER OUT OF RANGE
- `nn` out of range: error 25, GROUP MAXIMUM DECELERATION EXCEEDED

**DESCRIPTION**

This command is used to set the vectorial deceleration value for a group. This value will be used during coordinated motion of axes assigned to the group. It will override any original deceleration values specified for individual axes using **AG** command. The axes’ original values will be restored when the group to which they have been assigned is deleted.

This command takes effect immediately. It can be executed when controller is idling or motion is in progress or inside a program.

**Note:**
Avoid changing deceleration during acceleration or deceleration phases of a move. For better predictable results, change deceleration only when all the axes assigned to this group are not in motion.

**RETURNS**

If “?” sign takes the place of `nn` value, this command reports the current setting.

**REL. COMMANDS**

- AU - set maximum acceleration and deceleration for an axis
- HN - create a new group
- HA - set vectorial acceleration for a group
EXAMPLE

1HN1,2 | create a new group (#1) with physical axes 1 and 2
1AU? | query maximum deceleration of axis #1
50  | controller returns a value of 50 units/second²
2AU? | query maximum deceleration of axis #2
60  | controller returns a value of 60 units/second²
1HD50 | set vectorial deceleration of group #1 to 50 units/second²
1HD? | query vectorial deceleration of group #1
50  | controller returns a value of 50 units/second²
HE  set group e-stop deceleration

Usage

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

Syntax

xxHEnn or xxHE?

Parameters

Description

<table>
<thead>
<tr>
<th>xx</th>
<th>[ int ]</th>
<th>-</th>
<th>group number</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>[ float ]</td>
<td>-</td>
<td>vector e-stop deceleration value</td>
</tr>
</tbody>
</table>

Range

<table>
<thead>
<tr>
<th>xx</th>
<th>-</th>
<th>1 to MAX GROUPS</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>-</td>
<td>maximum of deceleration values assigned to all axes in the group to $2e9 \times$ encoder resolution.</td>
</tr>
</tbody>
</table>

Units

<table>
<thead>
<tr>
<th>xx</th>
<th>-</th>
<th>none</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>-</td>
<td>predefined units / second$^2$</td>
</tr>
</tbody>
</table>

Defaults

xx missing: error 13, GROUP NUMBER MISSING
nn out of range: error 14, GROUP NUMBER OUT OF RANGE
not assigned: error 15, GROUP NUMBER NOT ASSIGNED
floating point: truncated
nn missing: error 7, PARAMETER OUT OF RANGE
negative: error 22, GROUP PARAMETER OUT OF RANGE
out of range: error 22, GROUP PARAMETER OUT OF RANGE

Description

This command is used to set the vectorial e-stop deceleration value for a group. This value will be used during coordinated motion of axes assigned to the group. It will override any original e-stop deceleration values specified for individual axes using AE command. The axes’ original values will be restored when the group to which they have been assigned is deleted.

This command takes effect immediately. It can be executed when controller is idling or motion is in progress or inside a program.

E-stop deceleration is invoked upon a local e-stop condition (e.g., front panel “Stop All” push button, interlock, etc…) has occurred, if configured to do so, or if the AB (abort motion) command is processed.

Returns

If “?” sign takes the place of nn value, this command reports the current setting.

Rel. Commands

HN - create a new group
HV - set vectorial velocity for a group
HA - set vectorial acceleration for a group
HD - set vectorial deceleration for a group

Example

1HN1,2 | create a new group (#1) with physical axes 1 and 2
1HE100 | set vectorial e-stop deceleration of group #1 to 100 units/second$^2$
1HE?100 | query vectorial e-stop deceleration of group #1
          | controller returns a value of 100 units/second$^2$
HF

**group off**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

xxHF or xxHF?

**PARAMETERS**

- **Description**: xx [ int ] - group number
- **Range**: xx - 1 to MAX GROUPS
- **Units**: xx - none
- **Defaults**: xx missing: error 13, GROUP NUMBER MISSING
  out of range: error 14, GROUP NUMBER OUT OF RANGE
  not assigned: error 15, GROUP NUMBER NOT ASSIGNED
  floating point: truncated

**DESCRIPTION**

This command turns power OFF of all axes assigned to a group. Refer MF command to turn the power OFF of individual axes. The group power is assumed to be OFF if power to any one of the axes in the group is OFF.

**RETURNS**

If “?” sign is issued along with command, the controller returns:

| 1   | group power is ON |
| 0   | group power is OFF |

**REL. COMMANDS**

- HN - create a new group
- HO - turn group power ON

**EXAMPLE**

- 1HN1,2 | create a new group (#1) with physical axes 1 and 2
- 1HO | turn group #1 power ON
- 1HF? | query group #1 power status
- 1 | controller returns a value of 1
- 1HF | turn group #1 power OFF
- 1HF? | query group #1 power status
- 0 | controller returns a value of 0
**HJ**

**set group jerk**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**USAGE**

`xxHJnn` or `xxHJ?`

**SYNTAX**

`xxHJnn` or `xxHJ?`

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ]</th>
<th>nn [ float ]</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>group number</td>
<td>vector jerk value</td>
</tr>
</tbody>
</table>

**Range**

<table>
<thead>
<tr>
<th>xx</th>
<th>1 to MAX GROUPS</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>0 to 2e9</td>
</tr>
</tbody>
</table>

**Units**

<table>
<thead>
<tr>
<th>xx</th>
<th>none</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>predefined units / second</td>
</tr>
</tbody>
</table>

**Defaults**

- xx missing: error 13, GROUP NUMBER MISSING
- out of range: error 14, GROUP NUMBER OUT OF RANGE
- not assigned: error 15, GROUP NUMBER NOT ASSIGNED
- floating point: truncated
- nn missing: error 7, PARAMETER OUT OF RANGE
- negative: error 22, GROUP PARAMETER OUT OF RANGE
- out of range: error 22, GROUP PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to set the vectorial jerk value for a group. This value will be used during coordinated motion of axes assigned to the group. It will override any original jerk values specified for individual axes using **JK** command. The axes’ original values will be restored when the group to which they have been assigned is deleted.

If vectorial jerk is set to zero, a trapezoid velocity profile is employed during motion. Otherwise, an S-curve velocity profile is employed.

This command takes effect immediately. It can be executed when controller is idling or motion is in progress or inside a program.

**Note:**

Avoid changing jerk during acceleration or deceleration phases of a move. For better predictable results, change jerk only when all the axes assigned to this group are not in motion.

**RETURNS**

If “?” sign takes the place of `nn` value, this command reports the current setting.

**REL. COMMANDS**

- **HN** - create a new group
- **HV** - set vectorial velocity for a group
- **HA** - set vectorial acceleration for a group
- **HD** - set vectorial deceleration for a group
- **HK** - set vectorial e-stop jerk for a group

**EXAMPLE**

```
1HN1,2  | create a new group (#1) with physical axes 1 and 2
1HJ50   | set vectorial jerk of group #1 to 50 units/second
1HJ?    | query vectorial deceleration of group #1
50      | controller returns a value of 50 units/second
```
**HL**

**move group along a line**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**USAGE**

Immediate: PGM: MIP

**SYNTAX**

`xxHL nn_1, nn_2, ...nn_i` or `xxHL?`

**PARAMETERS**

**Description**

- `xx` [int] - group number
- `nn_1` [float] - target position of first axis in a group
- `nn_2` [float] - target position of second axis in a group
- `nn_i` [float] - target position of `i`th axis in a group, where `i` can vary from 1 to 6

**Range**

- `xx` - 1 to MAX GROUPS
- `nn_i` - any position within the travel limits

**Units**

- `xx` - none
- `nn_i` - redefined units

**Defaults**

- `xx` missing: error 13, GROUP NUMBER MISSING
- `nn_i` out of range: error 14, GROUP NUMBER OUT OF RANGE
- `nn_i` not assigned: error 15, GROUP NUMBER NOT ASSIGNED
- `nn_i` floating point: truncated

**DESCRIPTION**

This command initiates motion of a group along a line. It causes all axes assigned to the group to move with predefined vectorial (tangential) velocity, acceleration and deceleration along a line. A trapezoid velocity profile is employed when vectorial jerk is set to zero. Otherwise, an S-curve velocity profile is employed.

If this command is received while a group move is in progress, the new command gets enqueued into a “via point” buffer. Please refer Advanced Capabilities section for a detailed description of via point buffer implementation. The enqueued commands get executed on a FIFO basis when the move already in progress has reached its destination. The group does not come to a stop at the end of last move. Instead, there will be a smooth transition to the new move command, just as if it were one compound move (combination of multiple moves).

**Note:**

The transition from last move to new move will be smooth if tangential velocity at the end of last move is the same as that at the beginning of new move.

**RETURNS**

If “?” sign takes the place of `nn` values, this command reports the target positions of axes assigned to the group.
<table>
<thead>
<tr>
<th>REL. COMMANDS</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>HN</td>
<td>create a new group</td>
</tr>
<tr>
<td>HV</td>
<td>set vectorial velocity for a group</td>
</tr>
<tr>
<td>HA</td>
<td>set vectorial acceleration for a group</td>
</tr>
<tr>
<td>HD</td>
<td>set vectorial deceleration for a group</td>
</tr>
<tr>
<td>HO</td>
<td>enable a group</td>
</tr>
<tr>
<td>HF</td>
<td>disable a group</td>
</tr>
<tr>
<td>HC</td>
<td>move a group of axes to desired position along an arc.</td>
</tr>
</tbody>
</table>

**EXAMPLE**

<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1HN1,2</td>
<td>create a new group (#1) with physical axes 1 and 2</td>
</tr>
<tr>
<td>1HV10</td>
<td>set vectorial velocity of group #1 to 10 units/second</td>
</tr>
<tr>
<td>1HA50</td>
<td>set vectorial acceleration of group #1 to 50 units/second²</td>
</tr>
<tr>
<td>1HD50</td>
<td>set vectorial deceleration of group #1 to 50 units/second²</td>
</tr>
<tr>
<td>1HO</td>
<td>enable group #1</td>
</tr>
<tr>
<td>1HP?</td>
<td>query current group position</td>
</tr>
<tr>
<td>0,0</td>
<td>controller returns axis #1 = 0 units and axis #2 = 0 units</td>
</tr>
<tr>
<td>1HL50, 50</td>
<td>move axis #1 to a target position = 50 units&lt;br&gt;move axis #2 to a target position = 50 units</td>
</tr>
<tr>
<td>1HL?</td>
<td>query target position of the commanded move</td>
</tr>
<tr>
<td>50,50</td>
<td>controller returns axis #1 = 50 units and axis #2 = 50 units</td>
</tr>
</tbody>
</table>
**HN** create new group

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

```plaintext
xxHNnn_1, nn_2, ...nn_i or xxHN?
```

**PARAMETERS**

**Description**

<table>
<thead>
<tr>
<th>xx</th>
<th>[ int ]</th>
<th>-</th>
<th>group number</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn_1</td>
<td>[ int ]</td>
<td>-</td>
<td>physical axis number to be assigned as first axis in this group</td>
</tr>
<tr>
<td>nn_2</td>
<td>[ int ]</td>
<td>-</td>
<td>physical axis number to be assigned as second axis in this group</td>
</tr>
<tr>
<td>nn_i</td>
<td>[ int ]</td>
<td>-</td>
<td>physical axis number to be assigned as i-th axis in this group</td>
</tr>
</tbody>
</table>

**Range**

<table>
<thead>
<tr>
<th>xx</th>
<th>-</th>
<th>1 to MAX GROUPS</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn_i</td>
<td>-</td>
<td>1 to MAX AXES</td>
</tr>
</tbody>
</table>

**Units**

<table>
<thead>
<tr>
<th>xx</th>
<th>-</th>
<th>none</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn_i</td>
<td>-</td>
<td>none</td>
</tr>
</tbody>
</table>

**Defaults**

<table>
<thead>
<tr>
<th>xx</th>
<th>missing:</th>
<th>error 13, GROUP NUMBER MISSING</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>out of range:</td>
<td>error 14, GROUP NUMBER OUT OF RANGE</td>
</tr>
<tr>
<td></td>
<td>not assigned:</td>
<td>error 15, GROUP NUMBER NOT ASSIGNED</td>
</tr>
<tr>
<td></td>
<td>already assigned:</td>
<td>error 16, GROUP NUMBER ALREADY ASSIGNED</td>
</tr>
<tr>
<td></td>
<td>floating point:</td>
<td>truncated</td>
</tr>
<tr>
<td>nn_i</td>
<td>out of range:</td>
<td>error 17, GROUP AXIS OUT OF RANGE</td>
</tr>
<tr>
<td></td>
<td>already assigned:</td>
<td>error 18, GROUP AXIS ALREADY ASSIGNED</td>
</tr>
<tr>
<td></td>
<td>duplicated:</td>
<td>error 19, GROUP AXIS DUPLICATED</td>
</tr>
<tr>
<td></td>
<td>Missing parameter:</td>
<td>error 21, GROUP PARAMETER MISSING</td>
</tr>
</tbody>
</table>

**DESCRIPTION**

This command is used to create a new group. A few rules are in place to facilitate easy management of groups.

- A group has to be created with at least two axes assigned to it before any command related to groups can be issued. The controller returns error 15, GROUP NUMBER NOT ASSIGNED, if, for instance, one tries to set velocity for group #1, before creating group #1.
- A group has to be deleted (refer HX command) before axes assigned to the group can be changed. The controller returns error 16, GROUP NUMBER ALREADY ASSIGNED, if one attempts to change axes assigned to a group already created. Please see the following table for correct method to change axes assigned to a group:

<table>
<thead>
<tr>
<th>Correct Method</th>
<th>Incorrect Method</th>
</tr>
</thead>
<tbody>
<tr>
<td>1HN1,2</td>
<td>1HN1,2</td>
</tr>
<tr>
<td>1HX</td>
<td>1HN2,3</td>
</tr>
<tr>
<td>1HN2,3</td>
<td></td>
</tr>
</tbody>
</table>

- An axis cannot be a member of (or assigned to) different groups at the same time. The controller returns error 18, GROUP AXIS ALREADY ASSIGNED, if one
attempts to assign an axis under such circumstances. Refer HX command to delete a group.

- An axis cannot be assigned more than once in a group. The controller returns error 19, GROUP AXIS DUPLICATED, if one attempts to assign an axis more than once to a group.
- The order in which axes are assigned to a group is very important. This is because it specifies the frame of reference in which coordinated motion of axes takes place. For instance, the command 1HN,2 assigns axis numbers 1 and 2 to group number 1, where axis #1 is equivalent to X-axis and axis #2 is equivalent to Y-axis in a traditional cartesian coordinate system. Reversing the ordering of axes (viz. 1HN2,1) reverses the axis assignment.
- If a group has more than two axes assigned to it, and the group was commanded to make an arc (refer to HC command), the first two axes in the group are used to make the desired move.

**RETURNS**

If “?” sign takes the place of nn values, this command reports the axes assigned to the group in the order of their assignment.

**REL. COMMANDS**

<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>HV</td>
<td>set vectorial velocity for a group</td>
</tr>
<tr>
<td>HA</td>
<td>set vectorial acceleration for a group</td>
</tr>
<tr>
<td>HD</td>
<td>set vectorial deceleration for a group</td>
</tr>
<tr>
<td>HO</td>
<td>enable a group</td>
</tr>
<tr>
<td>HF</td>
<td>disable a group</td>
</tr>
<tr>
<td>HC</td>
<td>move a group of axes to desired position along an arc.</td>
</tr>
<tr>
<td>HL</td>
<td>move a group of axes to desired position along a line.</td>
</tr>
</tbody>
</table>

**EXAMPLE**

- **1HN1,2** | create a new group (#1) with physical axes 1 and 2
- **1HN?** | query axis assigned to group #1
- 1,2 | controller returns the axes assigned to group #1
- **1HN2,3** | create a new group (#1) with physical axes 1 and 2
- **1HN?** | query axis assigned to group #1
- 1,2 | controller returns the axes assigned to group #1
- **TB?** | read error message
- 0, 450322, GROUP NUMBER ALREADY ASSIGNED
- **1HX** | delete group #1
- **1HN2,3** | create a new group (#1) with physical axes 1 and 2
- **1HN?** | query axis assigned to group #1
- 2,3 | controller returns the axes assigned to group #1
- **2HN?** | query axis assigned to group #2
- **TB?** | read error message
- 0, 475322, GROUP NUMBER NOT ASSIGNED
- **2HN3,4** | create a new group (#2) with physical axes 3 and 4
- **2HN?** | query axis assigned to group #2
- **TB?** | read error message
- 0, 500322, GROUP AXIS ALREADY ASSIGNED
- **2HN4,4,5** | create a new group (#2) with physical axes 4, 4 and 5
- **2HN?** | query axis assigned to group #2
- **TB?** | read error message
- 0, 525322, GROUP AXIS DUPLICATED
**HO**

**group on**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

`xxHO` or `xxHO?`

**PARAMETERS**

- **Description**
  - `xx` [ int ] - group number

- **Range**
  - `xx` - 1 to MAX GROUPS

- **Units**
  - `xx` - none

- **Defaults**
  - `xx` missing: error 13, GROUP NUMBER MISSING
  - out of range: error 14, GROUP NUMBER OUT OF RANGE
  - not assigned: error 15, GROUP NUMBER NOT ASSIGNED
  - floating point: truncated

**DESCRIPTION**

This command turns power ON of all axes assigned to a group. Refer **MO** command to turn the power ON of individual axes. The group power is assumed to be ON if power to all axes in the group is ON.

**RETURNS**

If “?” sign is issued along with command, the controller returns:

- `1` - group power is ON
- `0` - group power is OFF

**REL. COMMANDS**

- **HN** - create a new group
- **HF** - turn group power OFF

**EXAMPLE**

1HN1,2 | create a new group (#1) with physical axes 1 and 2  
1HO | turn group #1 power ON  
1HO? | query group #1 power status  
1 | controller returns a value of 1  
1HF | turn group #1 power OFF  
1HO? | query group #1 power status  
0 | controller returns a value of 0
**HP**  
*read group position*

**USAGE**  
IMM  PGM  MIP  

**SYNTAX**  
xxHP

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ]</th>
<th>-</th>
<th>group number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Range</td>
<td>xx</td>
<td>-</td>
<td>1 to MAX GROUPS</td>
</tr>
<tr>
<td>Units</td>
<td>xx</td>
<td>-</td>
<td>none</td>
</tr>
</tbody>
</table>

**Defaults**

<table>
<thead>
<tr>
<th>xx</th>
<th>missing:</th>
<th>error 13, GROUP NUMBER MISSING</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>out of range:</td>
<td>error 14, GROUP NUMBER OUT OF RANGE</td>
</tr>
<tr>
<td></td>
<td>not assigned:</td>
<td>error 15, GROUP NUMBER NOT ASSIGNED</td>
</tr>
<tr>
<td></td>
<td>floating point:</td>
<td>truncated</td>
</tr>
</tbody>
</table>

**DESCRIPTION**

This command is used to read the actual position, the instantaneous real position of all axes assigned to a group.

**RETURNS**

nn₁, nn₂, … nnᵢ where nnᵢ = actual position of iᵗʰ axis in the group.

**REL. COMMANDS**

HN - create a new group  
HC - move a group of axes to desired position along an arc.  
HL - move a group of axes to desired position along a line.

**EXAMPLE**

1HN1,2 | create a new group (#1) with physical axes 1 and 2
1HP | read position of group #1
10,50 | controller returns axis #1 = 10 units, axis #2 = 50 units
HQ  
wait for group command buffer level

**USAGE**

IMM  PGM  MIP

**SYNTAX**

xxHQnn  or  xxHQ?

**PARAMETERS**

Description  

xx  [ int ]  -  group number  
nn  [ float ]  -  level in group via point buffer

Range  

xx  -  1 to MAX GROUPS  
nn  -  to 10 (default for maximum targets in via point buffer)

Units  

xx  -  none  
nn  -  milliseconds

**Defaults**

xx  missing: error 13, GROUP NUMBER MISSING  
out of range:  error 14, GROUP NUMBER OUT OF RANGE  
not assigned:  error 15, GROUP NUMBER NOT ASSIGNED  
floating point: truncated

nn  
Missing parameter:  error 21, GROUP PARAMETER MISSING

**DESCRIPTION**

This command stops enqueuing new commands into the via point buffer until the buffer level equals nn. As commands in the buffer get executed on a FIFO basis and the buffer level equals nn, commands issued subsequent to this one get executed.

**RETURNS**

If “?” sign takes the place of nn value, the controller returns the room available in via point buffer for more commands.

**REL. COMMANDS**

HN  -  create a new group  
HL  -  move group to target position along a line  
HC  -  move group to target position along an arc

**EXAMPLE**

1HN1,2  | create a new group (#1) with physical axes 1 and 2  
1HV10  | set vectorial velocity of group #1 to 10 units/second  
1HA50  | set vectorial acceleration of group #1 to 50 units/second squared  
1HD50  | set vectorial deceleration of group #1 to 50 units/second squared  
1HO  | enable group #1  
1HL10,10  | move group #1 to target pos. 10,10 (ax. #1 = 10, #2 = 10 units)  
1HL20,20  | move group #1 to target pos. 20,20 (ax. #1 = 20, #2 = 20 units).  
1HL50,50  | move group #1 to target pos. 50,50 (ax. #1 = 50, #2 = 50 units).  
1HQ10  | wait until the via point buffer level equals 10 commands  
1HC40,60,180  | move group #1 along an arc with center of arc at (40,60) units, by a sweep angle of 180 deg. from current position.
**HS**  
**stop group motion**

<table>
<thead>
<tr>
<th>USAGE</th>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

**SYNTAX**

`xxHS` or `xxHS?`

**PARAMETERS**

**Description**

`xx` [ int ] - group number

**Range**

`xx` - 1 to MAX GROUPS

**Units**

`xx` - none

**Defaults**

- missing: error 13, GROUP NUMBER MISSING
- out of range: error 14, GROUP NUMBER OUT OF RANGE
- not assigned: error 15, GROUP NUMBER NOT ASSIGNED
- floating point: truncated

**DESCRIPTION**

This command stops the motion of all axes assigned to a group using vector deceleration set using `HD` command.

**RETURNS**

If “?” sign is supplied along with the command, the controller returns:

- 1 - group motion is stopped
- 0 - group motion is in progress

**REL. COMMANDS**

- `HN` - create a new group
- `HC` - move a group of axes to desired position along an arc.
- `HL` - move a group of axes to desired position along a line.

**EXAMPLE**

```
1HN1,2 | create a new group (#1) with physical axes 1 and 2
1HV10 | set vectorial velocity of group #1 to 10 units/second
1HA50 | set vectorial acceleration of group #1 to 50 units/second^2
1HD50 | set vectorial deceleration of group #1 to 50 units/second^2
1HO   | enable group #1
1HP?  | query current group position
0,0   | controller returns axis #1 = 0 units and axis #2 = 0 units
1HL50, 50 | move axis #1 to a target position = 50 units
           move axis #2 to a target position = 50 units
1HS?  | query if motion of group #1 is stopped
0     | controller returns 0, meaning group #1 is in motion
1HS   | stop motion of group #2
1HS?  | query if motion of group #1 is stopped
1     | controller returns 1, meaning group #1 motion has stopped
```
**HV**

**set group velocity**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**USAGE**

xxHV nn or xxHV?

**SYNTAX**

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ]</th>
<th>nn [ float ]</th>
</tr>
</thead>
<tbody>
<tr>
<td>Group number</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Vector velocity value</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Range**

<table>
<thead>
<tr>
<th>xx</th>
<th>nn</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
</tr>
</tbody>
</table>

1 to MAX GROUPS

0 to minimum of the maximum velocity values of all axes assigned to this group.

**Units**

<table>
<thead>
<tr>
<th>xx</th>
<th>nn</th>
</tr>
</thead>
<tbody>
<tr>
<td>none</td>
<td>predefined units / second</td>
</tr>
</tbody>
</table>

**Defaults**

xx missing: error 13, GROUP NUMBER MISSING

out of range: error 14, GROUP NUMBER OUT OF RANGE

not assigned: error 15, GROUP NUMBER NOT ASSIGNED

floating point: truncated

nn missing: error 7, PARAMETER OUT OF RANGE

negative: error 22, GROUP PARAMETER OUT OF RANGE

out of range: error 23, GROUP MAXIMUM VELOCITY EXCEEDED

**DESCRIPTION**

This command is used to set the vectorial velocity value for a group. This value will be used during coordinated motion of axes assigned to the group. It will override any original acceleration values specified for individual axes using VA command. The axes’ original values will be restored when the group to which they have been assigned is deleted.

This command takes effect immediately. It can be executed when controller is idling or motion is in progress or inside a program.

**Note:**

Avoid changing velocity during acceleration or deceleration phases of a move. For better predictable results, change velocity only when all the axes assigned to this group are not in motion.

**RETURNS**

If “?” sign takes the place of nn value, this command reports the current setting.

**REL. COMMANDS**

VU - set maximum velocity for an axis

HN - create a new group

**EXAMPLE**

1HN1,2 | create a new group (#1) with physical axes 1 and 2
1VU? | query maximum velocity of axis #1
10 | controller returns a value of 10 units/second
2VU? | query maximum velocity of axis #2
15 | controller returns a value of 15 units/second
1HV10 | set vectorial velocity of group #1 to 10 units/second
1HV? | query vectorial velocity of group #1
10 | controller returns a value of 10 units/second
**HW**

wait for group motion stop

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

xxHWnn

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ] -</th>
<th>group number</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn [ float ] -</td>
<td>delay after group motion is complete</td>
</tr>
</tbody>
</table>

**Range**

<table>
<thead>
<tr>
<th>xx</th>
<th>1 to MAX GROUPS</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>0 to 60000</td>
</tr>
</tbody>
</table>

**Units**

<table>
<thead>
<tr>
<th>xx</th>
<th>none</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>milliseconds</td>
</tr>
</tbody>
</table>

**Defaults**

xx missing: error 13, GROUP NUMBER MISSING
out of range: error 14, GROUP NUMBER OUT OF RANGE
not assigned: error 15, GROUP NUMBER NOT ASSIGNED
floating point: truncated
nn missing: error 7, PARAMETER OUT OF RANGE
negative: error 22, GROUP PARAMETER OUT OF RANGE
out of range: error 26, MAXIMUM WAIT DURATION EXCEEDED

**DESCRIPTION**

This command stops execution of any commands subsequent to it until the one prior to it has been completed. For instance, if a command preceding it is a group move command such as HL or HC, it stops execution of any commands following it until the group has reached target position. If nn is not equal to zero, the controller waits an additional nn milliseconds after the group motion is complete before executing any further commands.

**RETURNS**

none

**REL. COMMANDS**

<table>
<thead>
<tr>
<th>HN</th>
<th>create a new group</th>
</tr>
</thead>
<tbody>
<tr>
<td>HL</td>
<td>move group to target position along a line</td>
</tr>
</tbody>
</table>

**EXAMPLE**

1HN1,2 | create a new group (#1) with physical axes 1 and 2
2HN3,4 | create a new group (#2) with physical axes 3 and 4
1HV10 | set vectorial velocity of group #1 to 10 units/second
1HA50 | set vectorial acceleration of group #1 to 50 units/second^2
1HD50 | set vectorial deceleration of group #1 to 50 units/second^2
2HV10 | set vectorial velocity of group #2 to 10 units/second
2HA50 | set vectorial acceleration of group #2 to 50 units/second^2
2HD50 | set vectorial deceleration of group #2 to 50 units/second^2
1HO | enable group #1
2HO | enable group #2
1HL50, 50; 1HW500; 2HL30,20 | move group #1 to a target position = 50, 50
| units (axis #1 = 50 units and axis #2 = 50 units), wait for the
group to reach target position, wait an additional 500 ms, and then move group #2 to a target position = 30, 20 units (axis #3 = 30 units and axis #4 = 20 units)
HX delete group

**USAGE**

```
IMM   PGM   MIP
♦   ♦   ♦
```

**SYNTAX**

```
xxHX
```

**PARAMETERS**

**Description**

```
xx  [ int ]  -  group number
```

**Range**

```
xx  -  1 to MAX GROUPS
```

**Units**

```
xx  -  none
```

**Defaults**

```
xx  missing:  error 13, GROUP NUMBER MISSING
out of range:  error 14, GROUP NUMBER OUT OF RANGE
not assigned:  error 15, GROUP NUMBER NOT ASSIGNED
```

**DESCRIPTION**

This command deletes a group and makes available any axes that were assigned to it for future assignments.

**RETURNS**

none

**REL. COMMANDS**

```
HN  -  create a new group
```

**EXAMPLE**

```
1HN1,2  | create a new group (#1) with physical axes 1 and 2
1HN?   | query axes assigned to group #1
I,2    | controller returns the axes assigned to group #1
1HX    | delete group #1
1HN?   | query axis assigned to group #1
TB?    | read error message
        | 0, 475322, GROUP NUMBER NOT ASSIGNED
```
HZ

read group size

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

USAGE

IMM PGM MIP

SYNTAX

xxHZ

PARAMETERS

Description

xx [ int ] - group number

Range

xx - 1 to MAX GROUPS

Units

xx - none

Defaults

xx missing: error 13, GROUP NUMBER MISSING
out of range: error 14, GROUP NUMBER OUT OF RANGE
not assigned: error 15, GROUP NUMBER NOT ASSIGNED

DESCRIPTION

This command is used to read the number of axes assigned to a group.

RETURNS

This command reports the current setting.

REL. COMMANDS

HN - create a new group
HX - delete a group

EXAMPLE

1HN1,2 | create a new group (#1) with physical axes 1 and 2
1HN? | read axes assigned to group #1
1,2 | controller returns the axes assigned to group #1
1HZ | read size of group #1
2 | controller returns 2
**ID**  
read stage model and serial number

**USAGE**  

```
IMM   PGM   MIP
♦     ♦     ♦
```

**SYNTAX**  

```
ID ? or IDxx
```

**PARAMETERS**

- **Description**:  
  
  xx [ int ] - axis number

- **Range**:  
  
  xx - 1 to MAX AXES

- **Units**:  
  
  xx - none

- **Defaults**:  
  
  xx missing: error 37, AXIS NUMBER MISSING
  out of range: error 9, AXIS NUMBER OUT OF RANGE
  timeout: error 2, RS-232 COMMUNICATION TIME-OUT

**DESCRIPTION**

This command is used to read and write (up to 16 character custom ID) Newport ESP compatible positioner (stage) model and serial number.

**Note:**

An important information needed when asking for help with the motion control system or when reporting a problem is the stage model and serial number. Use this command to determine the positioner model and serial number.

**RETURNS**

```
xx,yy
```

- xx = model number
- yy = serial number

**REL. COMMANDS**

none

**EXAMPLE**

```
1 ID ?
```

| read axis-1 positioner model and serial number |
| controller returns model and serial number |
**JH**

**set jog high speed**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

```
xxJHnn or xxJH?
```

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ]</th>
<th>axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn [ float ]</td>
<td>high speed value</td>
</tr>
</tbody>
</table>

**Range**

- xx: 1 to MAX AXES
- nn: 0 to maximum value allowed by VU command or ? to read present setting

**Units**

- xx: none
- nn: preset units/second

**Defaults**

- xx missing: error 37, AXIS NUMBER MISSING
- nn missing: error 38, COMMAND PARAMETER MISSING
- out of range: error 9, AXIS NUMBER OUT OF RANGE
- out of range: error xx10, MAXIMUM VELOCITY EXCEEDED

**DESCRIPTION**

This command is used to set the high speed for jogging an axis. Its execution is immediate, meaning that the value is changed when the command is processed, including when motion is in progress. It can be used as an immediate command or inside a program.

**RETURNS**

If “?” sign takes the place of nn value, this command reports current setting.

**REL. COMMANDS**

- JW: set jog low speed
- VU: set maximum velocity

**EXAMPLE**

- `2VU?` | read maximum velocity allowed axis # 2
- `10`   | controller returns a value of 10.0 units/second for axis #2
- `2JH7.5` | set jog high speed to 7.5 units/second for axis #2
- `2JH?`  | read jog high speed value for axis #2
- `7.5`   | controller returns a value of 7.5 units/second for axis #2
JK set jerk rate

**USAGE**

IMM PGM MIP

**SYNTAX**

xxJKnn or xxJK?

**PARAMETERS**

**Description**

- **xx** [int] - axis number
- **nn** [float] - jerk value

**Range**

- **xx** - 1 to MAX AXES
- **nn** - 0 to 2e9

**Units**

- **xx** - none
- **nn** - preset units / second³
  or ? to read current setting

**Defaults**

- **xx** missing: error 37, AXIS NUMBER MISSING
- out of range: error 9, AXIS NUMBER OUT OF RANGE

- **nn** missing: error 38, COMMAND PARAMETER MISSING
- out of range: error xx15, MAXIMUM JERK EXCEEDED

**DESCRIPTION**

This command is used to set the jerk (i.e., rate of change in acceleration) value for an axis. Its execution is immediate, meaning that the jerk is altered when the command is processed and trajectory mode is set to S-curve, even while a motion is in progress. It can be used as an immediate command or inside a program.

**Note:**

Avoid changing the jerk during the acceleration or deceleration periods. For better predictable results, change jerk only when the axis is not moving.

**RETURNS**

none

**REL. COMMANDS**

- **AC** - set acceleration
- **TJ** - set trajectory mode
- **VA** - set velocity

**EXAMPLE**

2JK? | read desired velocity of axis # 2
10.5 | controller returns a velocity value of 10.5 units/s³
2JK15 | set axis #2 jerk to 15 units/s³
**JL**  
**jump to label**

**USAGE**  
IMM  PGM  MIP  
♦   ♦

**SYNTAX**  
xxJLnn

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx</th>
<th>nn</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>[int]</td>
<td>[int]</td>
</tr>
</tbody>
</table>

- **Range**  
  - xx - 1 to 100  
  - nn - 1 to 65535

- **Units**  
  - xx - none  
  - nn - none

- **Default**  
  - xx missing: error 38, COMMAND PARAMETER MISSING  
  - out of range: error x2, PARAMETER OUT OF RANGE  
  - nn missing: assume infinite  
  - out of range: error x2, PARAMETER OUT OF RANGE

**DESCRIPTION**  
This command changes the flow of the program execution by jumping to a pre-defined label **xx**. This is a flow control command that alters the normal sequential flow of a program. It must be used in conjunction with the DL command which defines a label. Parameter **nn** determines the number of times to repeat the jump before allowing the program to flow passed.

**RETURNS**  
none

**REL. COMMANDS**

JL  -   jump to label

**EXAMPLE**

<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>3XX</td>
<td>clear program 3 from memory, if any</td>
</tr>
<tr>
<td>3EP</td>
<td>create program 3</td>
</tr>
<tr>
<td>1DL</td>
<td>define label 1</td>
</tr>
<tr>
<td></td>
<td></td>
</tr>
<tr>
<td>1JL 5</td>
<td>jump to label 1 five(5) times</td>
</tr>
<tr>
<td>QP</td>
<td>end entering program and quit programming mode</td>
</tr>
<tr>
<td>3EX</td>
<td>run stored program number 3</td>
</tr>
</tbody>
</table>
**JW**

**set jog low speed**

**USAGE**


**SYNTAX**

```
xxJWnn  or  xxJW?
```

**PARAMETERS**

**Description**

- **xx** [ int ] - axis number
- **nn** [ float ] - low speed value

**Range**

- **xx** - 1 to MAX AXES
- **nn** - 0 to maximum value allowed by VU command or ? to read present setting

**Units**

- **xx** - none
- **nn** - reset units/second

**Defaults**

- **xx** missing: error 37, AXIS NUMBER MISSING
- **xx** out of range: error 9, AXIS NUMBER OUT OF RANGE
- **nn** missing: error 38, COMMAND PARAMETER MISSING
- **nn** out of range: error xx10, MAXIMUM VELOCITY EXCEEDED

**DESCRIPTION**

This command is used to set the low speed for jogging an axis. Its execution is immediate, meaning that the value is changed when the command is processed, including when motion is in progress. It can be used as an immediate command or inside a program.

**RETURNS**

If “?” sign takes the place of **nn** value, this command reports current setting.

**REL. COMMANDS**

- **JH** - set jog high speed
- **VU** - set maximum velocity

**EXAMPLE**

```
2VU?    | read maximum velocity allowed axis # 2
10     | controller returns a value of 10.0 units/second for axis #2
2JW2.5 | set jog low speed to 2.5 units/second for axis #2
2JW?   | read jog low speed value for axis #2
2.5    | controller returns a value of 2.5 units/second for axis #2
```
**KD**

**set derivative gain**

**Usage**

**IMM**  **PGM**  **MIP**

![Image](image_url)

**Syntax**

`xxKDnn` or `xxKD?`

**Parameters**

<table>
<thead>
<tr>
<th>Description</th>
<th><code>xx</code> [int]</th>
<th>axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td><code>nn</code> [float]</td>
<td>derivative gain factor Kd</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Range</th>
</tr>
</thead>
<tbody>
<tr>
<td><code>xx</code></td>
</tr>
<tr>
<td><code>nn</code></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Units</th>
</tr>
</thead>
<tbody>
<tr>
<td><code>xx</code></td>
</tr>
<tr>
<td><code>nn</code></td>
</tr>
</tbody>
</table>

**Defaults**

- `xx` missing: error 37, AXIS NUMBER MISSING
- `xx` out of range: error 9, AXIS NUMBER OUT OF RANGE
- `nn` missing: error 38, COMMAND PARAMETER MISSING
- `nn` out of range: error xx2, PARAMETER OUT OF RANGE

**Description**

This command sets the derivative gain factor Kd of the PID closed loop. It is active for any DC servo based motion device that has been selected to operate in closed loop.

The command can be sent at any time but it has no effect until the `UF` (update filter) is received.

See the "Servo Tuning" chapter on how to adjust the PID filter parameters.

**Returns**

If the “?” sign takes the place of `nn` value, this command reports the current setting.

**Rel. Commands**

- `KI` - set integral gain factor
- `KP` - set proportional gain factor
- `KS` - set saturation gain factor
- `UF` - update filter

**Example**

```
3KD0.01 | set derivative gain factor for axis # 3 to 0.01
3UF    | update PID filter; only now the KD command takes effect
```
**KI**

**set integral gain**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

xxKI\(n\) or xxKI?  

**PARAMETERS**

**Description**

- xx [int] - axis number
- nn [float] - integral gain factor \(K_i\)

**Range**

- xx - 1 to MAX AXES
- nn - 0 to 2\(e9\), or ? to read current setting

**Units**

- xx - none
- nn - one

**Defaults**

- xx missing: error 37, AXIS NUMBER MISSING  
  out of range: error 9, AXIS NUMBER OUT OF RANGE

- nn missing: error 38, COMMAND PARAMETER MISSING  
  out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command sets the integral gain factor \(K_i\) of the PID closed loop. It is active for any DC servo based motion device that has been selected to operate in closed loop. The command can be sent at any time but it has no effect until the UF (update filter) is received.

See the "Servo Tuning" chapter on how to adjust the PID filter parameters.

**RETURNS**

If the “?” sign takes the place of nn value, this command reports the current setting

**REL. COMMANDS**

- KD - set integral gain factor
- KP - set proportional gain factor
- KS - set saturation gain factor
- UF - update filter

**EXAMPLE**

3KI 0.01 | set integral gain factor for axis # 3 to 0.01

...  

3UF | update PID filter; only now the KI command takes effect
### KP

**set proportional gain**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

```
xxKPnn or xxKP?
```

**PARAMETERS**

**Description**
- **xx** [int] - axis number
- **nn** [float] - proportional gain factor Kp

**Range**
- **xx** - 1 to **MAX AXES**
- **nn** - 0 to \(2\times10^9\), or ? to read current setting

**Units**
- **xx** - none
- **nn** - none

**Defaults**
- **xx** missing: error 37, AXIS NUMBER MISSING
- out of range: error 9, AXIS NUMBER OUT OF RANGE
- **nn** missing: error 38, COMMAND PARAMETER MISSING
- out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command sets the proportional gain factor Kp of the PID closed loop. It is active for any DC servo based motion device that has been selected to operate in closed loop.

The command can be sent at any time but it has no effect until the UF (update filter) is received.

See the "Servo Tuning" chapter on how to adjust the PID filter parameters.

**RETURNS**

If the "?" sign takes the place of **nn** value, this command reports the current setting.

**REL. COMMANDS**

- **KI** - set integral gain factor
- **KD** - set proportional gain factor
- **KS** - set saturation gain factor
- **UF** - update filter

**EXAMPLE**

```
3KP0.01 | set proportional gain factor for axis # 3 to 0.01

3UF | update PID filter; only now the KP command takes effect
```
KS

set saturation level of integral factor

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

xxKSnn or xxKS?

**PARAMETERS**

**Description**

- xx [int] - axis number
- nn [float] - saturation level of integrator KS

**Range**

- xx - 1 to MAX AXES
- nn - 0 to 2e9, or ? to read current setting

**Units**

- xx - none
- nn - none

**Defaults**

- xx missing: error 37, AXIS NUMBER MISSING
  out of range: error 9, AXIS NUMBER OUT OF RANGE
- nn missing: error 38, COMMAND PARAMETER MISSING
  out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command sets the saturation level of the integral factor of the PID closed loop and is useful for preventing integral wind-up. It is active for any DC servo based motion device that has been selected to operate in closed loop.

The command can be sent at any time but it has no effect until the UF (update filter) is received.

See the "Servo Tuning" chapter on how to adjust the PID filter parameters.

**RETURNS**

If the “?” sign takes the place of nn value, this command reports the current setting.

**REL. COMMANDS**

KI - set integral gain factor
KP - set proportional gain factor
KD - set derivative gain factor
UF - update filter

**EXAMPLE**

3KS0.01 | set saturation level for axis # 3 to 0.01

   3UF | update PID filter; only now the KS command takes effect
**LP**  
list program

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

**USAGE**

**SYNTAX**

xxLP

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ]</th>
<th>-</th>
<th>program number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Range</td>
<td>xx</td>
<td>-</td>
<td>1 to 100</td>
</tr>
<tr>
<td>Units</td>
<td>xx</td>
<td>-</td>
<td>none</td>
</tr>
</tbody>
</table>

**Defaults**

xx missing: error 38, COMMAND PARAMETER MISSING  
out of range: error 7, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command reads a specified program from non-volatile memory and sends it to the selected communication port (RS232 or IEEE488). During the transmission no other command should be sent to the controller.

**Note:**
The program list always terminates with the word “END”

**RETURNS**

program listing

**REL. COMMANDS**

EP - enter program mode

**EXAMPLE**

3LP | list program number 3  
3MO | enable axis 3 motor power  
IDL | define return label 1  
3PR+10 | move axis 3 relative +10 units  
3WS500 | wait 500ms after axis 3 stops  
3PR-10 | move axis 3 relative -10 units  
3WS500 | wait 500ms after axis 3 stops  
1JL5 | jump to label 1 location 5 times  
END | end of program list
**MD**

**read motion done status**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td></td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

xxMD?

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ]</th>
<th>-</th>
<th>axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Range</td>
<td>xx</td>
<td>-</td>
<td>1 to MAX AXES</td>
</tr>
<tr>
<td>Units</td>
<td>xx</td>
<td>-</td>
<td>none</td>
</tr>
</tbody>
</table>

**Defaults**

| xx missing: | error 37, AXIS NUMBER MISSING |
| out of range: | error 9, AXIS NUMBER OUT OF RANGE |

**DESCRIPTION**

This command is used to read the motion status for the specified axis n. The MD command can be used to monitor Homing, absolute, and relative displacement move completion status.

**RETURNS**

nn -

0 or 1 where

0 = motion not done (FALSE)

1 = motion done (TRUE)

**REL. COMMANDS**

<table>
<thead>
<tr>
<th>PA</th>
<th>-</th>
<th>move to an absolute position</th>
</tr>
</thead>
<tbody>
<tr>
<td>PR</td>
<td>-</td>
<td>move to a relative position</td>
</tr>
<tr>
<td>OR</td>
<td>-</td>
<td>move to home position</td>
</tr>
</tbody>
</table>

**EXAMPLE**

3MD? | read axis #3 move done status
l 1  | controller returns status 1 (motion done) for axis # 3
3PR2.2 | start a relative motion of 2.2 on axis # 3
3MD? | read axis #3 move done status
0 0  | controller returns status 0 (motion not done) for axis # 3
### MF  
**motor off**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**USAGE**

- **xxMF** or **xxMF?**

**SYNTAX**

**PARAMETERS**

**Description**

- **xx [ int ] -**  axis number

**Range**

- **xx -**  1 to **MAX AXES**

**Units**

- **xx -**  none

**Defaults**

- **xx** missing: error 37, AXIS NUMBER MISSING  
  out of range: error 9, AXIS NUMBER OUT OF RANGE

**DESCRIPTION**

This command turns power OFF of the specified motor (axis).

**RETURNS**

- If “?” sign is issued along with command, the controller returns:
  - 1 - motor power is ON
  - 0 - motor power is OFF

**REL. COMMANDS**

- **AB** - abort motion
- **ST** - stop motion
- **MO** - turn motor power ON

**EXAMPLE**

- **2MF** | *turn axis #2 motor power OFF*
- **2MF?** | *query axis #2 motor power status*
- **0** | *controller returns a value of 0*
- **2MO** | *turn axis #2 motor power ON*
- **2MF?** | *query axis #2 motor power status*
- **1** | *controller returns a value of 1*
**MO**  
**Motor on**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

xxMO or xxMO?

**PARAMETERS**

**Description**

- **xx** [ int ] - axis number

**Range**

- **xx** - to **MAX AXES**

**Units**

- **xx** - none

**Defaults**

- **xx** missing: error 37, AXIS NUMBER MISSING
- **xx** out of range: error 9, AXIS NUMBER OUT OF RANGE

**DESCRIPTION**

This command turns power **ON** of the specified motor (axis).

---

**CAUTION**

*If the motor power was turned off by the controller detecting a fault condition, before turning the power back on, make sure that the cause of the fault was corrected.*

---

**RETURNS**

If “?” sign is issued along with command, the controller returns:

- **1** - motor power is **ON**
- **0** - motor power is **OFF**

**REL. COMMANDS**

- **AB** - abort motion
- **ST** - stop motion
- **MF** - turn motor power **OFF**

**EXAMPLE**

- **MO** | turn axis #2 motor power **ON**
- **2MO?** | query axis #2 motor power status
- **1** | controller returns a value of **1**
- **2MF** | turn axis #2 motor power **OFF**
- **2MO?** | query axis #2 motor power status
- **0** | controller returns a value of **0**
MT
move to hardware travel limit

USAGE

IMM   PGM   MIP
   ♦      ♦

SYNTAX

xxMTnn  or  xxMT?

PARAMETERS

Description
xx  [ int ]  -  axis number
nn  [ char ]  -  direction of motion

Range
xx  -  1 to MAX AXES
nn  -  + for positive direction or - for negative direction

Units
xx  -  none
nn  -  none

Defaults
xx  missing:  error 37, AXIS NUMBER MISSING
out of range:  error 9, AXIS NUMBER OUT OF RANGE
nn  missing: positive direction

DESCRIPTION

This command is used to move an axis to its limit (positive or negative). It uses the home search speed during travel to hardware limit.

Note: This command cannot be issued after enabling DAQ (refer ASCII command, DE).

RETURNS

If “?” sign takes the place of nn value, this command reports 1 if motion is done, or 0 if motion is in progress.

REL. COMMANDS

OR  -  home location search
OH  -  set home search speed

EXAMPLE

3MT+  |  move axis #3 to positive travel limit
3MT?  |  query motion status
0     |  controller returns 0 indicating motion is in progress
MV  move indefinitely  

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

```
xxMVnn  or  xxMV?
```

**PARAMETERS**

**Description**

<table>
<thead>
<tr>
<th>xx</th>
<th>int</th>
<th>- axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>char</td>
<td>- direction of motion</td>
</tr>
</tbody>
</table>

**Range**

<table>
<thead>
<tr>
<th>xx</th>
<th>1 to MAX AXES</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>+ for positive direction or – for negative direction</td>
</tr>
</tbody>
</table>

**Units**

<table>
<thead>
<tr>
<th>xx</th>
<th>none</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>none</td>
</tr>
</tbody>
</table>

**Defaults**

- **xx** missing: error 37, AXIS NUMBER MISSING
- **out of range:** error 9, AXIS NUMBER OUT OF RANGE
- **nn** missing: positive direction
- **out of range:** error xx04, POSITIVE HARDWARE LIMIT EXCEEDED
- **out of range:** error xx05, NEGATIVE HARDWARE LIMIT EXCEEDED
- **out of range:** error xx06, POSITIVE SOFTWARE LIMIT EXCEEDED
- **out of range:** error xx07, NEGATIVE SOFTWARE LIMIT EXCEEDED

**DESCRIPTION**

This command initiates infinite motion. When received, the selected axis **xx** will move indefinitely, with the predefined acceleration and velocity, in the direction specified by **nn**. If the requested axis is member of a group, this command does not initiate the desired motion. Instead, error xx31, "COMMAND NOT ALLOWED DUE TO GROUP ASSIGNMENT" is generated. Refer HL and HC commands to move along a line or an arc.

If this command is issued when trajectory mode for this axis is not in trapezoidal or s-curve mode, the controller returns error xx32, “INVALID TRAJECTORY MODE FOR MOVING”.

**Note:**

Although the command is accepted while a motion is in progress, care should be taken not to reverse direction of motion.

**RETURNS**

If the “?” sign takes the place of **nn** value, this command reports the motion done status.
| REL. COMMANDS | PA | move to absolute position |
|               | PR | move to relative position |
|               | ST | stop motion               |
|               | MD | move done status          |

| EXAMPLE       | 3MV+ | move axis #3 indefinitely in positive direction |
|               | 3MV? | query status of move       |
|               | 0    | controller returns 0 meaning, motion is in progress |
|               | 3ST  | stop axis #3 motion        |
|               | 3MV− | move axis #3 indefinitely in negative direction |
**MZ**

move to nearest index

**Usage**

IMM  PGM  MIP

**Syntax**

`xxMZnn` or `xxMZ?`

**Parameters**

**Description**

- `xx` [int] - axis number
- `nn` [char] - direction of motion

**Range**

- `xx` - 1 to MAX AXES
- `nn` - + for positive direction or − for negative direction

**Units**

- `xx` - none
- `nn` - none

**Defaults**

- `xx` missing: error 37, AXIS NUMBER MISSING
- out of range: error 9, AXIS NUMBER OUT OF RANGE
- `nn` missing: positive direction

**Description**

This command is used to move an axis to its nearest index (positive or negative). It uses the home search speed during travel to nearest index.

**Note:** This command cannot be issued after enabling DAQ (refer ASCII command, **DE**).

**Returns**

If “?” sign takes the place of `nn` value, this command reports 1 if motion is done, or 0 if motion is in progress.

**Related Commands**

- OR - home location search
- OH - set home search speed

**Example**

```
3MZ+ | move axis #3 to nearest index in positive direction
3MZ? | query motion status
0    | controller returns 0 indicating motion is in progress
```
OH | set home search high speed

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

xxOHnn or xxOH?

**PARAMETERS**

**Description**

- **xx** [int] - axis number
- **nn** [float] - high speed value

**Range**

- **xx** - 1 to MAX AXES
- **nn** - 0 to maximum value allowed by VU command or ? to read present setting

**Units**

- **xx** - none
- **nn** - reset units/second

**Defaults**

- xx missing: error 37, AXIS NUMBER MISSING
- out of range: error 9, AXIS NUMBER OUT OF RANGE
- nn missing: error 38, COMMAND PARAMETER MISSING
- out of range: error xx10, MAXIMUM VELOCITY EXCEEDED
- error xx24, SPEED OUT OF RANGE

**DESCRIPTION**

This command sets the high speed used to search for home location for an axis. Its execution is immediate, meaning that the value is changed when the command is processed, including when motion is in progress. It can be used as an immediate command or inside a program.

**RETURNS**

If “?” sign takes the place of **nn** value, this command reports current setting.

**REL. COMMANDS**

- OR - search for home
- OL - set home search low speed

**EXAMPLE**

- 3OH10 | set home search high speed of axis # 3 to 10 units/sec
- 3OH? | query home search high speed of axis #3
- 10 | controller returns a value of 10.0 units/second
### OL

**set home search low speed**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

#### USAGE

- IMM PGM MIP

#### SYNTAX

- `xxOLnn` or `xxOL?`

#### PARAMETERS

**Description**
- `xx` [ int ] - axis number
- `nn` [ float ] - low speed value

**Range**
- `xx` - 1 to MAX AXES
- `nn` - 0 to maximum value allowed by VU command or ? to read present setting

**Units**
- `xx` - none
- `nn` - preset units/second

**Defaults**
- `xx` missing: error 37, AXIS NUMBER MISSING
- `nn` missing: error 38, COMMAND PARAMETER MISSING
- `nn` out of range: error xx10, MAXIMUM VELOCITY EXCEEDED
- `xx` out of range: error xx24, SPEED OUT OF RANGE

#### DESCRIPTION

This command sets the low speed used to search for home location for an axis. Its execution is immediate, meaning that the value is changed when the command is processed, including when motion is in progress. It can be used as an immediate command or inside a program.

#### RETURNS

If “?” sign takes the place of `nn` value, this command reports current setting.

#### REL. COMMANDS

- **OR** - search for home
- **OH** - set home search high speed
- **OL** - set home search low speed

#### EXAMPLE

- `3OL2` | set home search low speed of axis #3 to 2 units/sec
- `3OL?` | query home search low speed of axis #3
- 2 | controller returns a value of 2 units/second
OM

**set home search mode**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

**PARAMETERS**

**Description**

- **xx** [ int ] - axis number
- **nn** [ int ] - home search mode

**Range**

- **xx** - 1 to MAX AXES
- **nn** - 0 to 6

**Units**

- **xx** - none
- **nn** - none

**Defaults**

- xx missing: error 37, AXIS NUMBER MISSING
- out of range: error 9, AXIS NUMBER OUT OF RANGE
- nn missing: error 38, COMMAND PARAMETER MISSING
- out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command selects the home search type without invoking the home search sequence (see the description of OR command for more information on home search). The seven home search types are +0 Position Count, Home Switch and Index Signals, Home Switch Signal, Positive Limit Signal, Negative Limit Signal, Positive Limit and Index Signals and Negative Limit and Index Signals.

If **nn** = 0 and the front panel HOME search push button is pressed, the axes will search for zero position count. If **nn** = 1 and the front panel HOME search push button is pressed, the axis will search for combined Home and Index signal transitions. The controller responds similarly for other values of **nn**.

The **nn** parameter is overwritten by the **OR** command parameter.

**RETURNS**

If “?” sign takes the place of **nn** value, this command reports current setting.

**REL. COMMANDS**

- **OR** - search for home

**EXAMPLE**

- 3OM1 | set axis #3 home search mode to 1
- 3OR | start home search on axis #3 using mode 1
OR search for home

<table>
<thead>
<tr>
<th>USAGE</th>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>SYNTAX</th>
<th>xxORnn</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>PARAMETERS</th>
<th>Description</th>
<th>xx [ int ]</th>
<th>axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn [ int ]</td>
<td>home mode</td>
<td></td>
</tr>
<tr>
<td>Range</td>
<td>xx</td>
<td>0 to MAX AXES</td>
<td></td>
</tr>
<tr>
<td></td>
<td>nn</td>
<td>0 to 6 where:</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>0 = Find +0 Position Count</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>1 = Find Home and Index Signals</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>2 = Find Home Signal</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>3 = Find Positive Limit Signal</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>4 = Find Negative Limit Signal</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>5 = Find Positive Limit and Index Signals</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>6 = Find Negative Limit and Index Signals</td>
<td></td>
</tr>
<tr>
<td>Units</td>
<td>xx</td>
<td>none</td>
<td></td>
</tr>
<tr>
<td></td>
<td>nn</td>
<td>none</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Defaults</th>
<th>xx missing:</th>
<th>error 37, AXIS NUMBER MISSING</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>out of range:</td>
<td>error 9, AXIS NUMBER OUT OF RANGE</td>
</tr>
<tr>
<td></td>
<td>nn missing:</td>
<td>error 38, COMMAND PARAMETER MISSING</td>
</tr>
<tr>
<td></td>
<td>out of range:</td>
<td>error xx2, PARAMETER OUT OF RANGE</td>
</tr>
</tbody>
</table>

**DESCRIPTION**

This command executes a Home search routine on the axis specified by xx. If xx = 0, a home search routine is initiated sequentially on all installed axes. If nn is missing, the axes will search for home using the mode specified using OM command. If nn = 0, the axes will search for zero position count. If nn = 1, the axis will search for combined Home and Index signal transitions. If nn = 2, the axes will search for Home signal transition only. If nn = 3, the axes will search for positive limit signal transition. If nn = 4, the axes will search for negative limit signal transition. If nn = 5, the axes will search for positive limit and index signal transition. If nn = 6, the axes will search for negative limit and index signal transition.

At the end of a home search routine, the position of axes is reset to the value specified using SH command.

The home search motion status can be monitored with the Motion Done (MD) status command. If a fault condition such as E-stop occurs while home search is in progress or if this command is issued to an axis before enabling it, the controller returns error xx20, “HOMING ABORTED”.

For a detailed description of the home search routine see the **Home - The Axis Origin** chapter in the **Motion Control Tutorial** section.
Note: This command should be executed once every time the controller power is turned ON or the controller performs a complete system reset. There is no need to issue this command in any other case since the controller always keeps track of position, even when the motor power is OFF.

Note: This command cannot be issued after enabling DAQ (refer ASCII command, DE).

RETURNS
none

REL. COMMANDS
- DH  define home
- OH  set home search speed
- OM  set home search mode
- MD  read motion done status
- SH  set home preset position

EXAMPLE
3MO | turn axis #3 motor power ON
3SH0 | set axis #3 home position to 0 units
3OR1 | perform a home search on axis #3
3MD? | query axis #3 motion status
1   | controller returns a value of 1, when motion is done
3TP | query axis #3 position
0   | controller returns a value of 0 units
**PA**  
move to absolute position

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**  
xxPA\text{nn} or xxPA?

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ]</th>
<th>axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn [float]</td>
<td>absolute position destination</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Range</th>
<th>xx</th>
<th>1 to MAX AXES</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn</td>
<td>any position within the travel limits and within ±2e9 * encoder resolution.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Units</th>
<th>xx</th>
<th>none</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn</td>
<td>defined motion units</td>
</tr>
</tbody>
</table>

**Defaults**

- xx missing: error 37, AXIS NUMBER MISSING
- out of range: error 9, AXIS NUMBER OUT OF RANGE
- nn missing: error 38, COMMAND PARAMETER MISSING
- out of range: error xx04, POSITIVE HARDWARE LIMIT EXCEEDED
- out of range: error xx05, NEGATIVE HARDWARE LIMIT EXCEEDED
- out of range: error xx06, POSITIVE SOFTWARE LIMIT EXCEEDED
- out of range: error xx07, NEGATIVE SOFTWARE LIMIT EXCEEDED

**DESCRIPTION**

This command initiates an absolute motion. When received, the selected axis xx will move, with the predefined acceleration and velocity, to the absolute position specified by nn. If the requested axis is member of a group, this command does not initiate the desired motion. Instead, error xx31, "COMMAND NOT ALLOWED DUE TO GROUP ASSIGNMENT" is generated. Refer HL and HC commands to move along a line or an arc.

If this command is issued when trajectory mode for this axis is not in trapezoidal or s-curve mode, the controller returns error xx32, “INVALID TRAJECTORY MODE FOR MOVING”.

**Note:**

Even though the command is accepted while a motion is in progress, care should be taken not to reverse direction of motion. When this command is received, the controller verifies if it will produce a change of direction.

**RETURNS**

If the “?” sign takes the place of nn value, this command reports the current actual the same as TP?.

**REL. COMMANDS**

- AC - set acceleration
- PR - move to relative position
- ST - stop motion
- MD - move done status
- VA - set velocity

**EXAMPLE**

- 3VA8 | set velocity of axis #2 to 8 units / s
- 3PA12.34 | move axis #2 to absolute position 12.34
**PH**  
get hardware status

**USAGE**  
IMM   PGM   MIP
    ♦   ♦   ♦

**SYNTAX**  
PH

**PARAMETERS**  
None

**DESCRIPTION**  
This command is used to get general hardware status for all axes.
This routine allows user to observe the various digital input signals as they appear to the controller.

**HARDWARE STATUS REGISTER #1**

<table>
<thead>
<tr>
<th>BIT#</th>
<th>VALUE</th>
<th>DEFINITION</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>0</td>
<td>axis 1 +hardware travel limit low</td>
</tr>
<tr>
<td>0</td>
<td>1</td>
<td>axis 1 +hardware travel limit high</td>
</tr>
<tr>
<td>1</td>
<td>0</td>
<td>axis 2 +hardware travel limit low</td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>axis 2 +hardware travel limit high</td>
</tr>
<tr>
<td>2</td>
<td>0</td>
<td>axis 3 +hardware travel limit low</td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>axis 3 +hardware travel limit high</td>
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<tr>
<td>3</td>
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<tr>
<td>8</td>
<td>0</td>
<td>axis 1 –hardware travel limit low</td>
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<tr>
<td>8</td>
<td>1</td>
<td>axis 1 –hardware travel limit high</td>
</tr>
<tr>
<td>9</td>
<td>0</td>
<td>axis 2 –hardware travel limit low</td>
</tr>
<tr>
<td>9</td>
<td>1</td>
<td>axis 2 –hardware travel limit high</td>
</tr>
<tr>
<td>10</td>
<td>0</td>
<td>axis 3 –hardware travel limit low</td>
</tr>
<tr>
<td>10</td>
<td>1</td>
<td>axis 3 –hardware travel limit high</td>
</tr>
<tr>
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</tr>
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<tr>
<td>BIT #</td>
<td>VALUE</td>
<td>DEFINITION</td>
</tr>
<tr>
<td>-------</td>
<td>-------</td>
<td>-----------------------------------------</td>
</tr>
<tr>
<td>0</td>
<td>0</td>
<td>axis 1 home signal low</td>
</tr>
<tr>
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<td>axis 1 home signal high</td>
</tr>
<tr>
<td>1</td>
<td>0</td>
<td>axis 2 home signal low</td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>axis 2 home signal high</td>
</tr>
<tr>
<td>2</td>
<td>0</td>
<td>axis 3 home signal low</td>
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<td>axis 3 home signal high</td>
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<td>1</td>
<td>reserved</td>
</tr>
<tr>
<td>8</td>
<td>0</td>
<td>axis 1 index signal low</td>
</tr>
<tr>
<td>8</td>
<td>1</td>
<td>axis 1 index signal high</td>
</tr>
<tr>
<td>9</td>
<td>0</td>
<td>axis 2 index signal low</td>
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<tr>
<td>9</td>
<td>1</td>
<td>axis 2 index signal high</td>
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<tr>
<td>10</td>
<td>0</td>
<td>axis 3 index signal low</td>
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<tr>
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<td>axis 3 index signal high</td>
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<tr>
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<tr>
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<tr>
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<td>reserved</td>
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<tr>
<td>16</td>
<td>0</td>
<td>digital input A low</td>
</tr>
<tr>
<td>16</td>
<td>1</td>
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<tr>
<td>17</td>
<td>0</td>
<td>digital input B low</td>
</tr>
<tr>
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<tr>
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</tr>
</tbody>
</table>

**RETURNS**

This command reports the current status in hexadecimal notation.

**REL. COMMANDS**

<p>| | | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>ZU</td>
<td>get ESP system configuration</td>
<td></td>
</tr>
<tr>
<td>ZZ</td>
<td>get system configuration</td>
<td></td>
</tr>
</tbody>
</table>

**EXAMPLE**

<p>| | | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>PH</td>
<td>read hardware status</td>
<td></td>
</tr>
<tr>
<td>18000404H, 4H</td>
<td>controller returns the status of the two hardware resisters</td>
<td></td>
</tr>
</tbody>
</table>
PR  move to relative position

IMM  PGM  MIP

USAGE

SYNTAX  xxPRnn

PARAMETERS

Description  xx  [ int ]  -  axis number
              nn  [ float ]  -  relative motion increment

Range  xx  -  1 to MAX AXES
       nn  -  any value that will not cause exceeding the software
              limits and
              within 2e9 * encoder resolution.

Units  xx  -  none
       nn  -  defined motion units

Defaults  xx  missing:  error 37, AXIS NUMBER MISSING
           out of range:  error 9, AXIS NUMBER OUT OF RANGE

           nn  missing:  error 38, COMMAND PARAMETER MISSING
           out of range:  error xx04, POSITIVE HARDWARE LIMIT EXCEEDED
           out of range:  error xx05, NEGATIVE HARDWARE LIMIT EXCEEDED
           out of range:  error xx06, POSITIVE SOFTWARE LIMIT EXCEEDED
           out of range:  error xx07, NEGATIVE SOFTWARE LIMIT EXCEEDED

DESCRIPTION

This command initiates a relative motion. When received, the selected axis xx will move,
with the predefined acceleration and velocity, to a relative position nn units away from
the current position. If the requested axis is member of a group, this command does not
initiate the desired motion. Instead, error xx31, "COMMAND NOT ALLOWED DUE
TO GROUP ASSIGNMENT" is generated. Refer HL and HC commands to move along
a line or an arc.

If this command is issued when trajectory mode for this axis is not in trapezoidal or s-
curve mode, the controller returns error xx32, "INVALID TRAJECTORY MODE FOR
MOVING".

Note:
Even though the command is accepted while a motion is in progress, care should
be taken not to reverse direction of motion.

RETURNS

none

REL. COMMANDS

AC  -  set acceleration
PA  -  move to absolute position
MD  -  move done status
ST  -  stop motion
VA  -  set velocity

EXAMPLE

3VA8  |  set velocity of axis # 3 to 8 units / s
3PR2.34  |  move axis # 3 2.34 units away from the current position
QD  update motor driver settings

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**USAGE**

**SYNTAX**

\[ xxQD \]

**PARAMETERS**

- **Description**: \[ xx \ [ int \] - \] axis number
- **Range**: \[ xx \ - \] 1 to MAX AXES
- **Units**: \[ xx \ - \] none
- **Defaults**:
  - missing: error 37, AXIS NUMBER MISSING
  - out of range: error 9, AXIS NUMBER OUT OF RANGE
  - missing Unidrive: error xx23, UNIDRIVE NOT DETECTED

**DESCRIPTION**

This command is used to update Newport programmable driver (i.e., Unidrive) settings into working registers.

**Note**: This command should not be issued during motion since the motor power is automatically turned OFF.

**RETURNS**

none

**REL. COMMANDS**

- QS - set microstep factor
- QG - set gear constant
- QT - set tachometer gain
- QV - set average motor voltage

**EXAMPLE**

- \[ 2QI? \] \[ | \] read maximum motor current setting of axis # 2
- \[ 1.6 \] \[ | \] controller returns a value of 1.6 Amp. for axis #2
- \[ 2QI 1.2 \] \[ | \] set maximum motor current to 1.2 Amp. for axis #2
- \[ 2QD \] \[ | \] update programmable driver with latest settings for axis #2
- SM \[ | \] save all controller settings to non-volatile memory

Section 3 – Remote Mode 3-113
**QG**  
set gear constant

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**  
xxQGnn or xxQG?

**PARAMETERS**

- **Description**  
  xx [int] - axis number
  nn [float] - gear constant

- **Range**  
  xx - 1 to MAX AXES
  nn - 0 to \(2^{e9}\)
  or ? to read present setting

- **Units**  
  xx - none
  nn - evolution / unit of measure

- **Defaults**  
  xx missing: error 37, AXIS NUMBER MISSING
  out of range: error 9, AXIS NUMBER OUT OF RANGE
  nn missing: error 38, COMMAND PARAMETER MISSING
  out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to set the gear constant for a Newport Unidrive compatible programmable driver for DC servo axis. This command should be used in conjunction with QT (tachometer gain) command.

The gear constant is defined as the number of revolutions the motor has to make for the motion device to move one displacement.

This command must to be followed by the QD update driver command to take affect.

**RETURNS**

If the “?” sign takes the place of nn value, this command reports the current setting

**REL. COMMANDS**

- SN - set displacement units
- QD - update driver
- QS - set microstep factor
- QI - set motor maximum current
- QV - set average motor voltage

**EXAMPLE**  
2QG? | read gear constant setting of axis #2  
0.3937 | controller returns a value of 0.3937 rev / unit for axis #2  
2QG 0.25 | set gear constant to 0.25 rev / unit for axis #2  
2QT 7.0 | set tachometer gain to 7 V/Krpm for axis #2  
2QD | update programmable driver with latest settings for axis #2
QI

set maximum motor current

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
</table>

**USAGE**

♦ ♦ ♦

**SYNTAX**

xxQI{nn} or xxQI?

**PARAMETERS**

**Description**

```
xx   [ int ]  -  axis number
nn   [ float] -  motor current
```

**Range**

```
xx   -  1 to MAX AXES
nn   -  0 to maximum driver rating (see Specifications section)
       or ? to read present setting
```

**Units**

```
xx   -  none
nn   -  none
```

**Defaults**

```
xx    missing: error 37, AXIS NUMBER MISSING
       out of range: error 9, AXIS NUMBER OUT OF RANGE

nn    missing: error 38, COMMAND PARAMETER MISSING
       out of range: error xx2, PARAMETER OUT OF RANGE
```

**DESCRIPTION**

This command is used to set the maximum motor current output for a Newport Unidrive compatible programmable driver axis. This command must be followed by the QD update driver command to take affect.

**RETURNS**

If the “?” sign takes the place of nn value, this command reports the current setting

**REL. COMMANDS**

```
QG   -  set gear constant
QD   -  update driver
QS   -  set microstep factor
QT   -  set tachometer gain
QV   -  set average motor voltage
```

**EXAMPLE**

```
2QI? | read maximum motor current setting of axis # 2
1.6 | controller returns a value of 1.6 Amp. for axis #2
2QI 1.2 | set maximum motor current to 1.2Amp. for axis #2
2QD | update programmable driver with latest settings for axis #2
SM  | save all controller settings to non-volatile memory
```
QM  set motor type

**IMM**  **PGM**  **MIP**

**USAGE**

♦   ♦

**SYNTAX**

xxQMnn or xxQM?

**PARAMETERS**

**Description**

xx [ int ] - axis number

nn [ int ] - motor type

**Range**

xx - 1 to MAX AXES

nn - 0 to 4 where

0 = motor type undefined (default)
1 = DC servo motor (single analog channel)
2 = step motor (digital control)*
3 = commutated step motor (analog control)†
4 = commutated brushless DC servo motor

or ? to read current setting

**Units**

xx - none

nn - none

**Defaults**

xx missing: error 37, AXIS NUMBER MISSING

out of range: error 9, AXIS NUMBER OUT OF RANGE

nn missing: error 38, COMMAND PARAMETER MISSING

out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to set the motor type for axis xx. Defining motor type is necessary because the ESP needs to apply different control algorithms for different motor types.

* Note:
It will not be possible to control an axis if its motor type is undefined.

* ESP300 motion controller does not support this motor type.
† ESP6000 and ESP7000 motion controllers do not support this motor type.

**RETURNS**

If the “?” sign takes the place of nn value, this command reports the current setting

**REL. COMMANDS**

QV - set average motor voltage

QD - update driver

QI - set maximum motor current

QT - set tachometer gain

QG - set gear constant

**EXAMPLE**

2QM? | read motor type of axis # 2

0 | controller returns a value of 0 (motor undefined) for axis #2

2QM 1 | set motor type to value of 1 (DC servo motor) for axis #2

2QD | update programmable driver with latest settings for axis #2

SM | save all controller settings to non-volatile memory
QP [quit program mode]

USAGE
♦  IMM PGM MIP

SYNTAX
QP

PARAMETERS
None

DESCRIPTION
This command quits the controller from programming mode. All the commands following this one will be executed immediately.

RETURNS
none

REL. COMMANDS
EX - execute stored program
AP - abort stored program execution
XX - erase program

EXAMPLE
3XX | clear program 3 from memory, if any
3EP | activate program mode and enter following commands as
     |   program 3
     .
     .
     .
QP  | end entering program and quit programming mode
3EX | run stored program number 3
### QR

**reduce motor torque**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

#### USAGE

- `xxQR nn1,nn2` or `xxQR?`

#### SYNTAX

- `xxQR nn1,nn2` or `xxQR?`

#### PARAMETERS

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ]</th>
<th>axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn1 [ int ]</td>
<td>delay period</td>
</tr>
<tr>
<td></td>
<td>nn2 [ float ]</td>
<td>motor current reduction percentage</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Range</th>
<th>xx</th>
<th>1 to MAX AXES</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn1</td>
<td>0 to 60000</td>
</tr>
<tr>
<td></td>
<td>nn2</td>
<td>0 to 100</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Units</th>
<th>xx</th>
<th>none</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn1</td>
<td>milliseconds</td>
</tr>
<tr>
<td></td>
<td>nn2</td>
<td>percent of max. motor current</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Defaults</th>
<th>xx</th>
<th>error 37, AXIS NUMBER MISSING</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>missing</td>
<td>error 38, COMMAND PARAMETER MISSING</td>
</tr>
<tr>
<td></td>
<td>out of range</td>
<td>error 9, AXIS NUMBER OUT OF RANGE</td>
</tr>
</tbody>
</table>

#### DESCRIPTION

This command automatically reduces the specified step motor’s current (i.e., torque) output to the requested percentage `nn2` after motion has stopped and the specified time `nn1` has expired. The purpose of this command is to help reduce the motor heating typically generated by stepper motors. If `xx` is equal to 0, the torque reduction parameters get applied to all axes.

**Note:**

This command does not affect DC servo motors and pulse stepper motors.

**Note:**

Time parameter `nn1` is only effective for ESP300 motion controller.

#### RETURNS

If “?” sign is issued along with command, the controller returns the torque reduction settings for the specified axis.

#### REL. COMMANDS

- `QM` - set motor type
- `QI` - et motor current

#### EXAMPLE

- `2QR1000,50`  | reduce motor #2 torque to 50%, 1000 msec after a move done
- `2QR?`  | query motor #2 torque reduction settings
- `1000,50`  | controller returns 1000 msec and 50%
**QS**

set microstep factor

**USAGE**

IMM  PGM  MIP

•  •

**SYNTAX**

xxQSnn  or  xxQS?

**PARAMETERS**

**Description**

xx [ int ] - axis number
nn [ int ] - microstep value

**Range**

xx - 1 to MAX AXES
nn - 1 to 250 for step motors
      1 to 1000 for commutated step motors
      or ? to read current setting

**Units**

xx - none
nn - none

**Defaults**

xx  missing: error 37, AXIS NUMBER MISSING
      out of range: error 9, AXIS NUMBER OUT OF RANGE

nn  missing: error 38, COMMAND PARAMETER MISSING
      out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to set the microstep factor for a Newport Unidrive compatible programmable driver with step motor axis. This command must be followed by the QD update driver command to take effect.

**RETURNS**

If the “?” sign takes the place of nn value, this command reports the current setting

**REL. COMMANDS**

QD - update driver
QI - set maximum motor current
QT - set tachometer gain
QG - set gear constant
QV - set average motor voltage

**EXAMPLE**

2QS?
100 | read microstep factor of axis # 2
2QS 250 | set microstep factor to 250 for axis #2
2QD | update programmable driver with latest settings for axis #2
SM | save all controller settings to non-volatile memory
**QT**

set tachometer gain

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

**SYNTAX**

xxQTnn or xxQT?

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ]</th>
<th>-</th>
<th>axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn [float]</td>
<td>-</td>
<td>tachometer gain</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Range</th>
<th>xx</th>
<th>-</th>
<th>1 to MAX AXES</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn</td>
<td>-</td>
<td>0 to 20</td>
</tr>
<tr>
<td></td>
<td></td>
<td>or ? to read present setting</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Units</th>
<th>xx</th>
<th>-</th>
<th>none</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn</td>
<td>-</td>
<td>Volts/Krpm</td>
</tr>
</tbody>
</table>

**Defaults**

<table>
<thead>
<tr>
<th>xx missing:</th>
<th>error 37, AXIS NUMBER MISSING</th>
</tr>
</thead>
<tbody>
<tr>
<td>out of range:</td>
<td>error 9, AXIS NUMBER OUT OF RANGE</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>nn missing:</th>
<th>error 38, COMMAND PARAMETER MISSING</th>
</tr>
</thead>
<tbody>
<tr>
<td>out of range:</td>
<td>error xx2, PARAMETER OUT OF RANGE</td>
</tr>
</tbody>
</table>

**DESCRIPTION**

This command is used to set the DC motor tachometer gain for a Newport Unidrive compatible programmable driver axis. This command should be used in conjunction with **QG** (gear constant) command. This command must to be followed by the **QD** update driver command to take affect.

**RETURNS**

If the “?” sign takes the place of nn value, this command reports the current setting.

**REL. COMMANDS**

<table>
<thead>
<tr>
<th>QD</th>
<th>-</th>
<th>update driver</th>
</tr>
</thead>
<tbody>
<tr>
<td>QS</td>
<td>-</td>
<td>set microstep factor</td>
</tr>
<tr>
<td>QG</td>
<td>-</td>
<td>set gear constant</td>
</tr>
<tr>
<td>QI</td>
<td>-</td>
<td>set motor maximum current</td>
</tr>
<tr>
<td>QV</td>
<td>-</td>
<td>set average motor voltage</td>
</tr>
</tbody>
</table>

**EXAMPLE**

2QT?

<table>
<thead>
<tr>
<th>read tachometer gain setting of axis # 2</th>
</tr>
</thead>
</table>

7.0

| controller returns a value of 7.0 V/Krpm for axis #2 |

2QT 6.5

| set tachometer gain value of 6.5 V/Krpm for axis #2 |

2QG 0.3937

| set gear constant to 0.3937 rev/unit for axis #2 |

2QD

| update programmable driver with latest settings for axis #2 |

SM

| save all controller settings to non-volatile memory |
QV  
**set average motor voltage**

### USAGE

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

### SYNTAX

```
xxQVnn or xxQV?
```

### PARAMETERS

**Description**

- **xx** [int] - axis number
- **nn** [float] - motor voltage

**Range**

- **xx** - 1 to MAX AXES
- **nn** - 0 to maximum driver rating (see Specifications section) or ? to read present setting

**Units**

- **xx** - none
- **nn** - none

**Defaults**

- **xx** missing: error 37, AXIS NUMBER MISSING
- **xx** out of range: error 9, AXIS NUMBER OUT OF RANGE
- **nn** missing: error 38, COMMAND PARAMETER MISSING
- **nn** out of range: error xx2, PARAMETER OUT OF RANGE

### DESCRIPTION

This command is used to set the average motor voltage output for a Newport Unidrive compatible programmable driver axis. This command must to be followed by the **QD** update driver command to take affect.

### RETURNS

If the “?” sign takes the place of **nn** value, this command reports the current setting

### REL. COMMANDS

- **QD** - update driver
- **QI** - set maximum motor current
- **QG** - set gear constant
- **QS** - set microstep factor
- **QT** - set tachometer gain

### EXAMPLE

```
2QV? | read average motor voltage setting of axis # 2
48.0 | controller returns a value of 48Volts for axis #2
2QV 12 | set average motor voltage to 12 Volts for axis #2
2QD | update programmable driver with latest settings for axis #2
SM | save all controller settings to non-volatile memory
```
**RQ**

**generate service request (SRQ)**

**USAGE**

```
   IMM   PGM   MIP
     ♦     ♦     ♦
```

**SYNTAX**

```
RQnn
```

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>Type</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>nn</td>
<td>int</td>
<td>-</td>
</tr>
<tr>
<td>Range</td>
<td>nn</td>
<td>0 to 31</td>
</tr>
<tr>
<td>Units</td>
<td>nn</td>
<td>none</td>
</tr>
</tbody>
</table>

**Defaults**

- missing: 0
- out of range: error 7, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command generates an interrupt service request to the host computer. The parameter `nn` is used to identify the RQ command that generated the interrupt. Upon receiving the interrupt, the host computer interrupt service routine should perform an IEEE 488 serial poll. If the interrupt was as a result of the `RQ` command, then bit 6 of the response is 1 and the lower five bits equal the parameter `nn`.

This command can be used to notify the host computer of the progress or flow of command execution in the motion controller.

**RETURNS**

None

**REL. COMMANDS**

SA - set device address

**EXAMPLE**

```
2PR200;2WS;1PR100;1WS;RQ3  | generate interrupt when RQ command is encountered and set bit 0 and 2
```

---

Section 3 – Remote Mode
RS
reset the controller

<table>
<thead>
<tr>
<th>USAGE</th>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td></td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>SYNTAX</th>
<th>RS</th>
</tr>
</thead>
<tbody>
<tr>
<td>PARAMETERS</td>
<td>None</td>
</tr>
</tbody>
</table>

**DESCRIPTION**

This command is used to perform a hardware reset of the controller. It performs the following preliminary tasks before resetting the controller:

1. Stop all the axes that are in motion. The deceleration value specified using the command AG is used to stop the axes.
2. Wait for 500 ms to allow the axes to settle.
3. Disable all the axes by turning the power OFF.
4. Reset to the controller card.

Once the command to reset the controller is detected by the DSP, the controller will stay in reset for a minimum of 200 ms. After the reset condition has occurred (i.e., after the 200 ms reset time), the controller firmware reboots the controller. At this point, all the parameters last saved to the non-volatile flash memory on the controller will be restored. Furthermore, the controller will detect any stages (ESP compatible or otherwise) and drivers connected to the controller. This process can take anywhere up to 20 seconds depending upon the controller configuration.

**Note:**

This command is affective only when the watchdog timer is enabled through appropriate jumper setting on the controller card (default factory setting is "enabled"). The following figure illustrates the jumper settings to enable the watchdog timer.

**Note:**

If this command is issued over the PCI bus interface (as in the case of ESP6000 motion controller), all communication between the host PC and the controller over this bus will be interrupted. As a result, **this command is not recommended for use over the PCI bus interface**. Use the binary command, esp_init_system( ) instead.

---

**CAUTION**

Use this command judiciously! It is not intended to be a substitute for an e-stop condition.
For ESP6000 and ESP7000 motion controllers

For ESP100 and ESP300 motion controllers

RETURNS
None

REL. COMMANDS
None

EXAMPLE
RS | Reset the controller
**SA**  
**set device address**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**USAGE**  
SAnn or SA?

**SYNTAX**

**PARAMETERS**

**Description**  
nn [ int ] - address number

**Range**  
nn - 1 to 30

**Units**  
nn - none

**Defaults**  
nn missing: error 38, COMMAND PARAMETER MISSING  
out of range: error 7, PARAMETER OUT OF RANGE

**DESCRIPTION**  
This command is used to set and report the device (i.e., ESP controller) address for use with IEEE-488 or USB communications (if equipped). The address change takes affect immediately after the command is processed.

**Note:**  
Use the SM command to save new address setting to non-volatile memory.

**RETURNS**  
If the “?” sign takes the place of nn value, this command reports the current setting.

**REL. COMMANDS**  
none

**EXAMPLE**

| SA 3 | set device address to 3 |
| SA ? | read present device address setting |
| 3   | controller returns device address #3 |
| SM  | save all settings to non-volatile memory |
SB  set / get DIO port A, B bit status

USAGE

IMM  PGM  MIP
   ⇒   ⇒   ⇒

SYNTAX

SBnn or SB?

PARAMETERS

Description

nn   [ int ]  -  hardware limit configuration

Range

nn   -  0 to 0FFFFFFFFH  (hexadecimal with leading zero(0) )
       or ? to read current setting

Units

nn   -  None

Defaults

nn   missing:  error 38, COMMAND PARAMETER MISSING
           out of range:  error 7, PARAMETER OUT OF RANGE

DESCRIPTION

This command is used to either set all digital I/O (DIO) port A, B, and C logic level or read its present status. Bits 0-7 correspond to port A, bits 8-15 to port B, and bits 16-23 to port C. Each 8-bit port can be set as either input or output with the BO command.

A DIO within a port configured as an input can only report its present HIGH or LOW logic level. Whereas a DIO bit within a port configured as an output can set(1) or clear(0) the corresponding DIO hardware to HIGH or LOW logic level. Reading the status of a port configured as output returns its present output status.

Note:
All direction bits are automatically zeroed, or cleared, after a system reset. Therefore all DIO ports default to input by default.

Note:
Each DIO bit has a pulled-up resistor to +5V. Therefore, all bits will be at HIGH logic level if not connected to external circuit and configured as input.

<table>
<thead>
<tr>
<th>BIT#</th>
<th>VALUE</th>
<th>DEFINITION</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>0</td>
<td>port A bit-0 at logic level 0 (LOW)</td>
</tr>
<tr>
<td>*0</td>
<td>1</td>
<td>port A bit-0 at logic level 1 (HIGH)</td>
</tr>
<tr>
<td>1</td>
<td>0</td>
<td>port A bit-1 at logic level 0 (LOW)</td>
</tr>
<tr>
<td>*1</td>
<td>1</td>
<td>port A bit-1 at logic level 1 (HIGH)</td>
</tr>
<tr>
<td>2</td>
<td>0</td>
<td>port A bit-2 at logic level 0 (LOW)</td>
</tr>
<tr>
<td>*2</td>
<td>1</td>
<td>port A bit-2 at logic level 1 (HIGH)</td>
</tr>
<tr>
<td>3</td>
<td>0</td>
<td>port A bit-3 at logic level 0 (LOW)</td>
</tr>
<tr>
<td>*3</td>
<td>1</td>
<td>port A bit-3 at logic level 1 (HIGH)</td>
</tr>
<tr>
<td>4</td>
<td>0</td>
<td>port A bit-4 at logic level 0 (LOW)</td>
</tr>
<tr>
<td>*4</td>
<td>1</td>
<td>port A bit-4 at logic level 1 (HIGH)</td>
</tr>
</tbody>
</table>

continued
<p>| | | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>5</td>
<td>0</td>
<td>port A bit-5 at logic level 0 (LOW)</td>
</tr>
<tr>
<td>*5</td>
<td>1</td>
<td>port A bit-5 at logic level 1 (HIGH)</td>
</tr>
<tr>
<td>6</td>
<td>0</td>
<td>port A bit-6 at logic level 0 (LOW)</td>
</tr>
<tr>
<td>*6</td>
<td>1</td>
<td>port A bit-6 at logic level 1 (HIGH)</td>
</tr>
<tr>
<td>7</td>
<td>0</td>
<td>port A bit-7 at logic level 0 (LOW)</td>
</tr>
<tr>
<td>*7</td>
<td>1</td>
<td>port A bit-7 at logic level 1 (HIGH)</td>
</tr>
</tbody>
</table>

* default setting

**RETURNS**

If the “?” sign takes the place of nn value, this command reports the current setting in hexadecimal notation.

**REL. COMMANDS**

<table>
<thead>
<tr>
<th>command</th>
<th>description</th>
</tr>
</thead>
<tbody>
<tr>
<td>BO</td>
<td>set DIO port direction</td>
</tr>
</tbody>
</table>

**EXAMPLE**

```
BO? | read DIO port direction configuration
0H  | controller returns a value of 0H (all ports are input)
BO 1H | configure DIO port A as output
SB 0FFH | set all port A DIO output HIGH
```
SH

set home preset position

**IMM**  **PGM**  **MIP**

### USAGE

- ♦  ♦  ♦

### SYNTAX

`xxSHnn` or `xxSH?`

### PARAMETERS

**Description**  
`xx` [int] - axis number  
`nn` [float] - home preset position

**Range**  
`xx` - 1 to **MAX AXES**  
`nn` - any position within the travel limits

**Units**  
`xx` - none  
`nn` - defined motion units

**Defaults**  
`xx` missing: error 37, AXIS NUMBER MISSING  
out of range: error 9, AXIS NUMBER OUT OF RANGE  
`nn` missing: error 38, COMMAND PARAMETER MISSING  
out of range: error xx01, PARAMETER OUT OF RANGE

### DESCRIPTION

This command defines the value that is loaded in the position counter when home is found. The default value for all motion devices is 0. This means that unless a new value is defined using this command, the home position will be set to 0 when a home search is initiated using the OR command or from the front panel (if available).

**Note:**
The change takes effect only when a subsequent home search routine is performed. To make the change permanent, use the SM command to save it in the non-volatile memory.

### RETURNS

If the “?” sign takes the place of `nn` value, this command reports the current setting.

### RELATED COMMANDS

- **DH** - define home

### EXAMPLE

- **3MO** | turn axis #3 motor power ON  
- **3SH75.0** | set axis #3 home position to 75.0 units  
- **3OR1** | perform a home search on axis #3  
- **3MD?** | query axis #3 motion status  
- 1 | controller returns a value of 1, when motion is done  
- **3TP** | query axis #3 position  
- **75.0** | controller returns a value of 75.0 units
**SI**

**set master-slave jog velocity update interval**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

SI\textit{nn} or SI?  

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>\textit{nn} [ int ] - jog velocity update interval</th>
</tr>
</thead>
<tbody>
<tr>
<td>Range</td>
<td>nn - 1 to 1000</td>
</tr>
<tr>
<td>Units</td>
<td>nn - milliseconds</td>
</tr>
</tbody>
</table>

**Defaults**

- missing: error 38, COMMAND PARAMETER MISSING  
- out of range: error 7, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command sets the jog velocity update interval for slave axis. The jog velocity of slave axis is computed once every interval using user specified scaling coefficients and the master axis velocity at the time of computation. Refer SK command to specify slave jog velocity scaling coefficients. Note that appropriate trajectory mode has to be specified using TJ command before this command becomes effective.

**RETURNS**

If “?” sign is issued along with command, the controller returns slave axis jog velocity update interval.

**REL. COMMANDS**

- SS - define master-slave relationship  
- SK - set slave axis jog velocity scaling coefficients

**EXAMPLE**

- 2SS1 | set axis 2 to be the slave of axis 1  
- 2SS? | query the master axis number for axis 2  
- 1 | controller returns a value of 1  
- 2TJ6 | set axis 2 trajectory mode to 6  
- SI\textit{10} | set the jog velocity update interval of slave axis to 10 msec  
- SI? | query the jog velocity update interval of slave axis  
- 10 | controller returns a value of 10  
- SK0.5,0 | set the jog velocity scaling coefficients to 0.5 and 0  
- SK? | query the jog velocity scaling coefficients  
- 0.5,0 | controller returns 0.5 and 0
SK

set master-slave jog velocity scaling coefficients

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

SK nn1, nn2 or SK?

**PARAMETERS**

- **Description**
  - nn_i [ float ] - jog velocity scaling coefficients
- **Range**
  - nn_i - none
- **Units**
  - nn_i - none
- **Defaults**
  - nn_i missing: error 38, COMMAND PARAMETER MISSING

**DESCRIPTION**

This command sets the jog velocity scaling coefficients for slave axis. The jog velocity of slave axis is computed once every interval using user specified scaling coefficients and the master axis velocity at the time of computation. The user specified coefficients are used as follows:

\[
\dot{x}_s = A \dot{x}_m + B \dot{x}_m^2 \text{ sgn}(\dot{x}_m)
\]

where \(\dot{x}_s\) is the jog velocity of the slave and \(\dot{x}_m\) is the velocity of the master axis. Refer **SI** command to specify slave jog velocity update interval.

**Note:**

Appropriate trajectory mode has to be specified using **TJ** command before this command becomes effective.

**RETURNS**

If “?” sign is issued along with command, the controller returns slave axis jog velocity scaling coefficients.

**REL. COMMANDS**

- **SS** - define master-slave relationship
- **SI** - set slave axis jog velocity update interval

**EXAMPLE**

- 2SS1 | set axis 2 to be the slave of axis 1
- 2SS? | query the master axis number for axis 2
- 1 | controller returns a value of 1
- 2TJ6 | set axis 2 trajectory mode to 6
- SI10 | set the jog velocity update interval of slave axis to 10 msec
- SI? | query the jog velocity update interval of slave axis
- 10 | controller returns a value of 10
- SK0.5,0 | set the jog velocity scaling coefficients to 0.5 and 0
- SK? | query the jog velocity scaling coefficients
- 0.5,0 | controller returns 0.5 and 0
SL  
set left travel limit

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

`xxSLnn` or `xxSL?`

**PARAMETERS**

**Description**

- `xx` [int] - axis number
- `nn` [float] - left (negative) software limit

**Range**

- `xx` - 1 to MAX AXES
- `nn` - `-2e9 * encoder resolution` to 0

**Units**

- `xx` - none
- `nn` - predefined motion units

**Defaults**

- `xx` missing: error 37, AXIS NUMBER MISSING
- `nn` missing: error 38, COMMAND PARAMETER MISSING

- `xx` out of range: error 9, AXIS NUMBER OUT OF RANGE
- `nn` out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command defines the value for the negative (left) software travel limit. It should be used to restrict travel in the negative direction to protect the motion device or its load. For instance, if traveling full range, a stage could push its load into an obstacle. To prevent this, the user can reduce the allowed travel by changing the software travel limit.

Since a motion device must be allowed to find its home position, the home switch and/or sensor must be inside the travel limits. This means that both positive and negative travel limits cannot be set on the same side of the home position. A more obvious restriction is that the negative limit cannot be greater than the positive limit. If any of these restrictions is not respected, the controller will return PARAMETER OUT OF RANGE.

**Note:**

If the command is issued for an axis in motion, the new limit should not be set inside the current travel.

**Note:**

For software units to take effect they must be enabled using the `ZS` command.

**CAUTION**

Be careful when using this command. The controller does not know the real hardware limits of the motion device. Always set the software limits inside the hardware limits (limit switches). In normal operation, a motion device should never hit a limit switch.

**RETURNS**

If the “?” sign takes the place of `nn` value, this command reports the current setting.

**REL. COMMANDS**

- `OR` - search for home
- `SR` - set right software limits

**EXAMPLE**

`1SL41.4` | set negative travel limit of axis #1 to 41.4 units
**SM**  
*save settings to non-volatile memory*

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**USAGE**

**SYNTAX**

`SM`

**PARAMETERS**

none

**DESCRIPTION**

This command is used to save system and axis configuration settings from RAM to non-volatile flash memory. It should be used after modifying system and/or axis parameters and settings to assure that the new data will not be lost when the controller is powered off.

*Note:*

User programs created with EP command are automatically saved to non-volatile memory.

**RETURNS**

none

**REL. COMMANDS**

none

**EXAMPLE**

```
3VA12.5  | set axis 3 velocity to 12.5 units/sec
3AC50.0  | set axis 3 acceleration to 50 unit/sec²
.
.
.
SM       | save changes to non-volatile memory
```
SN  set axis displacement units

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>✧</td>
<td>✧</td>
<td></td>
</tr>
</tbody>
</table>

**SYNTAX**

```
xSn n  or  xSn?
```

**PARAMETERS**

- **Description**
  - `xx` [int] - axis number
  - `nn` [int] - displacement units

- **Range**
  - `xx` - 1 to MAX AXES
  - `nn` - 0 to 10

  | 0  | encoder count |
  | 1  | motor step |
  | 2  | millimeter |
  | 3  | micrometer |
  | 4  | inches |
  | 5  | milli-inches |
  | 6  | micro-inches |
  | 7  | degree |
  | 8  | gradient |
  | 9  | radian |
  | 10 | milliradian |

- **Units**
  - `xx` - none
  - `nn` - none

- **Defaults**
  - `xx` missing: error 37, AXIS NUMBER MISSING
  - `nn` missing: error 38, COMMAND PARAMETER MISSING
  - `xx` out of range: error 9, AXIS NUMBER OUT OF RANGE
  - `nn` out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to set the displacement units for the for axis `xx`.  

*Note:*
The unit of measure as used with this controller is intended as a label only. It is the user’s responsibility to convert and resend all affected parameters (e.g., velocity, acceleration, etc…) when switching from one unit of measure to another.

**RETURNS**

If the “?” sign takes the place of `nn` value, this command reports the current setting

**REL. COMMANDS**

- **FR** - set full-step resolution
- **SU** - set encoder resolution

**EXAMPLE**

```
SN  | read displacement unit setting of axis # 2
2   | controller returns a value 2 (millimeter) for axis #2
2Sn 0| set displacement unit to 0 (encoder count) for axis #2
```
**SR**

**set right travel limit**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

`xxSRnn` or `xxSR?`

**PARAMETERS**

**Description**

- `xx` [int] - axis number
- `nn` [float] - right (positive) software limit

**Range**

- `xx` - 1 to MAX AXES
- `nn` - `+2e9 * encoder resolution` to 0

**Units**

- `xx` - none
- `nn` - defined motion units

**Defaults**

- `xx` missing: error 37, AXIS NUMBER MISSING
- `nn` missing: error 38, COMMAND PARAMETER MISSING

**DESCRIPTION**

This command defines the value for the positive (right) software travel limit. It should be used to restrict travel in the positive direction to protect the motion device or its load. For instance, if traveling full range, a stage could push its load into an obstacle. To prevent this, the user can reduce the allowed travel by changing the software travel limit.

Since a motion device must be allowed to find its home position, the home switch and/or sensor must be inside the travel limits. This means that both positive and negative travel limits cannot be set on the same side of the home position. A more obvious restriction is that the negative limit cannot be greater than the positive limit. If any of these restrictions is not respected, the controller will return PARAMETER OUT OF RANGE.

**Note:**

- If the command is issued for an axis in motion, the new limit should not be set inside the current travel.
- Be careful when using this command. The controller does not know the real hardware limits of the motion device. Always set the software limits inside the hardware limits (limit switches). In normal operation, a motion device should never hit a limit switch.

**RETURNS**

- If the “?” sign takes the place of `nn` value, this command reports the current setting

**REL. COMMANDS**

- `OR` - search for home
- `SL` - set left software limit

**EXAMPLE**

`1SR41.4` | *set positive travel limit of axis #1 to 41.4 units*
**SS**

**define master-slave relationship**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

**USAGE**

xxSSnn or xxSS?

**SYNTAX**

**PARAMETERS**

**Description**

- xx [ int ] - axis number to be defined as a slave
- nn [ int ] - axis number to be defined as a master

**Range**

- xx - 1 to MAX AXES
- nn - 1 to MAX AXES

**Units**

- xx - none
- xx - none

**Defaults**

- xx missing: error 37, AXIS NUMBER MISSING
  out of range: error 9, AXIS NUMBER OUT OF RANGE
- nn missing: error 38, COMMAND PARAMETER MISSING
  out of range: error 9, AXIS NUMBER OUT OF RANGE

**DESCRIPTION**

This command defines master-slave relationship between any two axes. A few rules are in place for ease of use.

- The trajectory mode for slave has to be appropriately defined before that axis follows master in a desired fashion.
- An axis cannot be assigned as its own slave if it is already in a trajectory mode that is specific to master-slaving.
- A slave axis cannot be moved individually using **PA** or **PR** commands if its trajectory mode is specific to master-slaving.

This command gets executed immediately, and can also be called from within a program.

**RETURNS**

If “?” sign is issued along with command, the controller returns master axis number.

**REL. COMMANDS**

- TJ - set trajectory mode
- GR - set master-slave reduction ratio

**EXAMPLE**

- 2SS1 | set axis 2 to be the slave of axis 1
- 2SS? | query the master axis number for axis 2
- 1   | controller returns a value of 1
- 2TJ5 | set axis 2 trajectory mode to 5
- 2GR1.0 | set the reduction ratio of axis 2 to 1.0
- 1MO | turn axis 1 motor power ON
- 2MO | turn axis 2 motor power ON
- 1PA10 | move axis 1 to absolute 10 units
- 2PA20 | move axis 2 to absolute 10 units
- TB | read error messages
- 232, 242000, AXIS-2 INVALID TRAJECTORY MODE FOR MOVING | controller returns appropriate error message
### ST  stop motion

#### USAGE

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

#### SYNTAX

`xxST`

#### PARAMETERS

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ] -</th>
<th>axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Range</td>
<td>xx -</td>
<td>1 to MAX AXES</td>
</tr>
<tr>
<td>Units</td>
<td>xx -</td>
<td>none</td>
</tr>
<tr>
<td>Defaults</td>
<td>xx out of range: error 9, AXIS NUMBER OUT OF RANGE</td>
<td></td>
</tr>
</tbody>
</table>

#### DESCRIPTION

This command stops a motion in progress using deceleration rate programmed with `AG` (set deceleration) command on the specified axes. If the ST command is sent with no axis parameter, all axes are stopped.

#### RETURNS

none

#### REL. COMMANDS

- **AB** - abort motion
- **AG** - set deceleration
- **MF** - motor power off

#### EXAMPLE

- 2PA40  | move axis # 2 to absolute position 40  
- 2ST    | stop motion on axis # 2  

---

Section 3 – Remote Mode
SU

set encoder resolution

**USAGE**

IMM | PGM | MIP

* ♦ ♦ *

**SYNTAX**

xxSUmn or xxSU?

**PARAMETERS**

**Description**

xx [ int ] - axis number
nn [float] - encoder resolution

**Range**

xx - 1 to MAX AXES
nn - 2e-9 to 2e+9 in user defined units
or ? to read present setting

**Units**

xx - none
nn - none

**Defaults**

xx missing: error 37, AXIS NUMBER MISSING
out of range: error 9, AXIS NUMBER OUT OF RANGE

nn missing: error 38, COMMAND PARAMETER MISSING
out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to set the encoder resolution for axis xx.

**Note:**

The encoder resolution can only be changed when encoder feedback is enabled. See ZB command.

**RETURNS**

If “?” sign takes the place of nn value, this command reports the current setting

**REL. COMMANDS**

FR - set full-step resolution
SU - set encoder resolution
QD - update driver
ZB - set feedback configuration

**EXAMPLE**

2SU? | read encoder resolution setting of axis #2
0.0001 | controller returns a value of 0.0001 units for axis #2
2SU0.0005 | set encoder resolution to 0.0005 units for axis #2
2QD | update programmable driver with latest settings for axis #2
SM | save all controller settings to non-volatile memory
TB  read error message

USAGE

IMM  PGM  MIP
♦     ♦     ♦

SYNTAX

TB?

PARAMETERS

questions mark (?)

Defaults

DESCRIPTION

This command is used to read the error code, timestamp, and the associated message. The error code is one numerical value up to three (3) digits long. (see Appendix for complete listing) In general, non-axis specific errors numbers range from 1-99. Axis-1 specific errors range from 100-199, Axis-2 errors range from 200-299 and so on.

The timestamp is in terms of servo cycle ticks accumulated since the last System Reset, incrementing at the servo interrupt interval (400us default). The message is a description of the error associated with it. All arguments are separated by commas.

Note:
Errors are maintained in a FIFO buffer ten (10) elements deep. When an error is read using TB or TE, the controller returns the last error that occurred and the error buffer is cleared by one (1) element. This means that an error can be read only once, with either command.

RETURNS

aa, bb, cc
where: aa = error code   cc = error message
      bb = timestamp     (see Appendix for complete listing)

REL. COMMANDS

TE    -    read error code

EXAMPLE

TB?
| read error message
| 0, 451322, NO ERROR DETECTED
| controller returns no error

8PA12.3  | move axis #8 to position 12.3
TB?
| read error message
| 9, 451339, AXIS NUMBER NOT AVAILABLE
| controller returns error code, timestamp, and description
## TE  
**read error code**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

### SYNTAX

TE?

### PARAMETERS

questions mark (?)

### Defaults

timeout: error 2, RS-232 COMMUNICATION TIME-OUT

### DESCRIPTION

This command is used to read the error code.

The error code is one numerical value up to three digits long. (see Appendix for complete listing)

In general, non-axis specific errors numbers range from 1-99. **Axis-1 specific errors** range from **100-199**, **Axis-2 errors** range from **200-299** and so on.

**Note:**

Errors are maintained in a FIFO buffer ten(10) elements deep. When an error is read using TB or TE, the controller returns the last error that occurred and the error buffer is cleared by one(1) element. This means that an error can be read only once, with either command.

### RETURNS

aa

where: aa = error code number (see Appendix for complete listing)

### REL. COMMANDS

TB - read error message

### EXAMPLE

<table>
<thead>
<tr>
<th>TE?</th>
<th>read error message</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>controller returns no error</td>
</tr>
<tr>
<td>8PA12.3</td>
<td>move axis #8 to position 12.3</td>
</tr>
<tr>
<td>TE?</td>
<td>read error message</td>
</tr>
<tr>
<td>9</td>
<td>controller returns error code 9 meaning incorrect axis number</td>
</tr>
</tbody>
</table>
TJ  
set trajectory mode

**IMM**  **PGM**  **MIP**

**USAGE**

♦   ♦

**SYNTAX**

xxTJnn or xxTJ?

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ]</th>
<th>-</th>
<th>axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn [ int ]</td>
<td>-</td>
<td>home mode</td>
</tr>
</tbody>
</table>

**Range**

xx - 1 to MAX AXES

nn - 1 to 6 where

1 = trapezoidal mode
2 = s-curve mode
3 = jog mode
4 = slave to master’s desired position (trajectory)
5 = slave to master’s actual position (feedback)
6 = slave to master’s actual velocity for jogging

<table>
<thead>
<tr>
<th>Units xx</th>
<th>none</th>
</tr>
</thead>
<tbody>
<tr>
<td>Units nn</td>
<td>none</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Defaults xx</th>
<th>missing: error 37, AXIS NUMBER MISSING</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>out of range: error 9, AXIS NUMBER OUT OF RANGE</td>
</tr>
<tr>
<td>Defaults nn</td>
<td>missing: error 38, COMMAND PARAMETER MISSING</td>
</tr>
<tr>
<td></td>
<td>out of range: error xx2, PARAMETER OUT OF RANGE</td>
</tr>
<tr>
<td></td>
<td>during motion: error xx26, PARAMETER CHANGE NOT ALLOWED DURING MOTION</td>
</tr>
</tbody>
</table>

**DESCRIPTION**

This command sets the trajectory mode nn on the axis specified by xx.

Changing trajectory during motion is not allowed. Change trajectory mode only when the axis is not moving.

If the requested axis is member of a group, the controller returns error xx31, “COMMAND NOT ALLOWED DUE TO GROUP ASSIGNMENT”.

For a detailed description of motion profiles see the Motion Control Tutorial section.

**RETURNS**

If the “?” sign takes the place of nn value, this command reports the current setting

**REL. COMMANDS**

JK - set s-curve jerk rate
GR - set master/slave gear ratio

**EXAMPLE**

1TJ? | report current trajectory mode setting on axis #1
1   | controller returns trajectory mode 1 (trapezoidal) for axis #1
1TJ2 | set trajectory mode on axis #1 to 2 (s-curve)
TP  
read actual position

USAGE

IMM PGM MIP

♦      ♦

SYNTAX

xxTP

PARAMETERS

Description  xx [ int ] - axis number

Range  xx - 1 to MAX AXES

Units  xx - none

Defaults  xx missing: error 37, AXIS NUMBER MISSING
out of range: error 9, AXIS NUMBER OUT OF RANGE

DESCRIPTION

This command is used to read the actual position. It returns the instantaneous real position of the specified axis.

RETURNS

nn  where: nn = actual position, in pre-defined units

REL. COMMANDS

PA - move to an absolute position
PR - move to a relative position
DP - read instantaneous desired position

EXAMPLE

3TP  | read real position on axis # 3
5.322 | controller returns real position 5.322 for axis # 3
**TS**  
read controller status

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
</table>

**USAGE**
- ♦
- ♦

**SYNTAX**
TS

**PARAMETERS**
None

**DESCRIPTION**
This command is used to read the controller status byte. The byte returned is in the form of an ASCII character. The value of each bit in the status byte can be deduced after converting the ASCII character into a binary value. Each bit of the status byte represents a particular controller parameter, as described in the following table.

**Note:**
Please refer to the Appendix for a complete ASCII to binary conversion table.

**INTERPRETATION OF LEFT MOST ASCII CHARACTER:**

<table>
<thead>
<tr>
<th>Bit #</th>
<th>Function</th>
<th>Meaning for</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Bit LOW</td>
</tr>
<tr>
<td>0</td>
<td>Axis #1 motor state</td>
<td>Stationary</td>
</tr>
<tr>
<td>1</td>
<td>Axis #2 motor state</td>
<td>Stationary</td>
</tr>
<tr>
<td>2</td>
<td>Axis #3 motor state</td>
<td>Stationary</td>
</tr>
<tr>
<td>3</td>
<td>Reserved</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>Motor power of at least one axis</td>
<td>OFF</td>
</tr>
<tr>
<td>5</td>
<td>Reserved</td>
<td></td>
</tr>
<tr>
<td>6</td>
<td>Reserved</td>
<td></td>
</tr>
<tr>
<td>7</td>
<td>Reserved</td>
<td></td>
</tr>
</tbody>
</table>

**INTERPRETATION OF RIGHT MOST ASCII CHARACTER:**

**Note:**
This ASCII character is returned only if the motion controller supports more than four (4) axes.

<table>
<thead>
<tr>
<th>Bit #</th>
<th>Function</th>
<th>Meaning for</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Bit LOW</td>
</tr>
<tr>
<td>0</td>
<td>Reserved</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>Reserved</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>Reserved</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>Reserved</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>Reserved</td>
<td></td>
</tr>
<tr>
<td>5</td>
<td>Reserved</td>
<td></td>
</tr>
<tr>
<td>6</td>
<td>Reserved</td>
<td></td>
</tr>
<tr>
<td>7</td>
<td>Reserved</td>
<td></td>
</tr>
</tbody>
</table>

**RETURNS**
ASCII character representing the status byte.

**REL. COMMANDS**
TX - read controller activity

**EXAMPLE**
TS ∣ read controller status
    ∣ controller returns characters [ and P indicating axes 1, 2 and 4 are in motion, and motor power of at least one axis is ON.
**TV**

**read actual velocity**

<table>
<thead>
<tr>
<th>USAGE</th>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

**SYNTAX**

xxTV

**PARAMETERS**

**Description**

xx [ int ] - axis number

**Range**

xx - 1 to MAX AXES

**Units**

xx - none

**Defaults**

xx missing: error 37, AXIS NUMBER MISSING
out of range: error 9, AXIS NUMBER OUT OF RANGE

**DESCRIPTION**

This command is used to read the actual velocity of an axis. The command can be sent at any time but its real use is while motion is in progress.

**RETURNS**

nn, where nn = actual velocity of the axis in pre-defined units.

**REL. COMMANDS**

PA - move to an absolute position
PR - move to a relative position

**EXAMPLE**

3TP? | read position on axis # 3
5.32 | controller returns position 5.32 units for axis # 3
3PR2.2 | start a relative motion of 2.2 units on axis # 3
3DV | read desired velocity on axis #3
0.2 | controller returns velocity 0.2 units/sec for axis #3
3TV | read actual velocity on axis #3
0.205 | controller returns velocity 0.205 units/sec for axis #3
3DP? | read desired position on axis # 3
7.52 | controller returns desired position 7.52 units for axis # 3
**TX**  
*read controller activity*

**USAGE**  
IMM | PGM | MIP
--- | --- | ---
♦ | ♦ | ♦

**SYNTAX**
TX

**PARAMETERS**
None

**DESCRIPTION**
This command is used to read the controller activity register. The byte returned is in the form of an ASCII character. The value of each bit in the status byte can be deduced after converting the ASCII character into a binary value. Each bit of the status byte represents a particular parameter, as described in the following table.

**Note:**
Please refer to the Appendix for a complete ASCII to binary conversion table.

<table>
<thead>
<tr>
<th>Bit #</th>
<th>Function</th>
<th>Meaning for</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>At least one program is executing</td>
<td>Bit LOW</td>
</tr>
<tr>
<td>1</td>
<td>Wait command is executing</td>
<td>NO</td>
</tr>
<tr>
<td>2</td>
<td>Manual jog mode is active</td>
<td>NO</td>
</tr>
<tr>
<td>3</td>
<td>Local mode is inactive</td>
<td>Default</td>
</tr>
<tr>
<td>4</td>
<td>At least one trajectory is executing</td>
<td>NO</td>
</tr>
<tr>
<td>5</td>
<td>Reserved</td>
<td>Default</td>
</tr>
<tr>
<td>6</td>
<td>Reserved</td>
<td>—</td>
</tr>
<tr>
<td>7</td>
<td>Reserved</td>
<td>Default</td>
</tr>
</tbody>
</table>

**RETURNS**
ASCII character representing the status byte.

**REL. COMMANDS**
TS - read controller status

**EXAMPLE**
TX | read controller activity
P | controller returns character P indicating at least one trajectory is executing
UF  update servo filter

**USAGE**

IMM  PGM  MIP
   ♦   ♦   ♦

**SYNTAX**

UF

**PARAMETERS**

None.

**DESCRIPTION**

This command is used to make active the latest entered PID parameters. Any new value for Kp, Ki, Kd and maximum following error are not being used in the PID loop calculation until UF command is received. This assures that the parameters are loaded simultaneously, without any transitional glitches in the loop.

If the axis specifier xx is missing or set to 0, the controller updates the filters for all axes. If xx is a number between 1 and 4, the controller updates only the filter for the specified axis.

**RETURNS**

none

**ERRORS**

none

**REL. COMMANDS**

<table>
<thead>
<tr>
<th>FE</th>
<th>set maximum following error</th>
</tr>
</thead>
<tbody>
<tr>
<td>KD</td>
<td>set derivative gain factor</td>
</tr>
<tr>
<td>KI</td>
<td>set integral gain factor</td>
</tr>
<tr>
<td>KP</td>
<td>set proportional gain factor</td>
</tr>
</tbody>
</table>

**EXAMPLE**

3KP0.05  | set proportional gain factor of axis # 3 to 0.05
3KD0.07  | set derivative gain factor of axis # 3 to 0.07
3UF     | update servo loop of axis # 3 with the new parameters
**UH**  
*wait for DIO bit high*

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**SYNTAX**

```
XxUH
```

**PARAMETERS**

**Description**

- Description: DIO bid number
- Range: 0 to 15
- Units: none
- Defaults:  
  - Missing: error 38, COMMAND PARAMETER MISSING
  - Out of range: error 7, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command causes a program to wait until a selected I/O input bit becomes high. It is level, not edge sensitive. This means that at the time of evaluation, if the specified I/O bit `xx` is high already, the program will continue to execute subsequent commands.

**Note:**

All DIO bits are pulled high on the board. Therefore, a missing signal will cause the wait to complete and subsequent commands will continue to be executed.

**RETURNS**

none

**REL. COMMANDS**

UL - Wait for DIO bit low

**EXAMPLE**

1EP  | Enter stored program #1  
1MO  | Turn axis #1 motor power ON  
1MV+ | Move axis #1 indefinitely in positive direction  
13UH | Wait for DIO bit #13 to go HIGH before executing any subsequent commands  
1ST  | Stop axis #1  
WT500 | Wait for 500 ms  
1MV- | Move axis #1 indefinitely in negative direction  
QP  | Quit program mode
## UL  wait for DIO bit low

### IMM  PGM  MIP

### SYNTAX

XxUL

### PARAMETERS

**Description**  
xx [ int ] -  DIO bid number

**Range**  
xx -  0 to 15

**Units**  
xx -  none

**Defaults**  
xx missing:  error 38, COMMAND PARAMETER MISSING  
out of range:  error 7, PARAMETER OUT OF RANGE

### DESCRIPTION

This command causes a program to wait until a selected I/O input bit becomes low. It is level, not edge sensitive. This means that at the time of evaluation, if the specified I/O bit xx is low already, the program will continue to execute subsequent commands.

### RETURNS

none

### REL. COMMANDS

UL -  Wait for DIO bit low

### EXAMPLE

1EP | Enter stored program #1  
1MO | Turn axis #1 motor power ON  
1MV+ | Move axis #1 indefinitely in positive direction  
13UL | Wait for DIO bit #13 to go LOW before executing any subsequent commands  
1ST | Stop axis #1  
WT500 | Wait for 500 ms  
1MV- | Move axis #1 indefinitely in negative direction  
QP | Quit program mode
VA

set velocity

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

xxVA<sup>n</sup> or xxVA?<sup>n</sup>

**PARAMETERS**

**Description**

<sup>xx</sup> [ int ]  -  axis number
<sup>nn</sup> [float]  -  velocity value

**Range**

<sup>xx</sup> - 1 to MAX AXES
<sup>nn</sup> - 0 to maximum value allowed by VU command or ? to read current setting

**Units**

<sup>xx</sup> - none
<sup>nn</sup> - preset units / second

**Defaults**

<sup>xx</sup> missing: error 37, AXIS NUMBER MISSING
out of range: error 9, AXIS NUMBER OUT OF RANGE

<sup>nn</sup> missing: error 38, COMMAND PARAMETER MISSING
out of range: error xx10, MAXIMUM VELOCITY EXCEEDED

**DESCRIPTION**

This command is used to set the velocity value for an axis. Its execution is immediate, meaning that the velocity is changed when the command is processed, even while a motion is in progress.

It can be used as an immediate command or inside a program. If the requested axis is member of a group, the commanded velocity becomes effective only after the axis is removed from the group. (Refer the Advanced Capabilities section for detailed description of grouping and related commands).

Avoid changing the velocity during the acceleration or deceleration periods. For better predictable results, change velocity only when the axis is not moving or when it is moving with a constant speed.

**RETURNS**

If the “?” sign takes the place of <sup>nn</sup> value, this command reports the current setting

**REL. COMMANDS**

<table>
<thead>
<tr>
<th>AC</th>
<th>- set acceleration</th>
</tr>
</thead>
<tbody>
<tr>
<td>VU</td>
<td>- set maximum velocity</td>
</tr>
<tr>
<td>PA</td>
<td>- execute an absolute motion</td>
</tr>
<tr>
<td>PR</td>
<td>- execute a relative motion</td>
</tr>
</tbody>
</table>

**EXAMPLE**

2VA?<sup>4</sup>  | read desired velocity of axis # 2
10  | controller returns a velocity value of 10 units/s
2PA15  | move to absolute position 15
WT500  | wait for 500ms
2VA?<sup>2</sup>  | set axis # 2 velocity to 4 units/s
4  | controller returns a velocity value of 4 units/s
VB

set base velocity for step motors

IMM  PGM  MIP

♦    ♦    ♦

SYNTAX

xxVBnn  or  xxVB?

PARAMETERS

Description  xx [ int ] - axis number
nn [float] - base velocity value

Range  xx - 1 to MAX AXES
nn - 0 to maximum value allowed by VU command
or ? to read current setting

Units  xx - none
nn - preset units / second

Defaults  xx missing: error 37, AXIS NUMBER MISSING
out of range:

nn missing: error 38, COMMAND PARAMETER MISSING
out of range: error xx10, MAXIMUM VELOCITY EXCEEDED
error xx01, Axis-xx PARAMETER OUT OF RANGE

DESCRIPTION

This command is used to set the base velocity, also referred to as start/stop velocity value for a step motor driven axis. Its execution is immediate, meaning that the velocity is changed when the command is processed, even while a motion is in progress. It can be used as an immediate command or inside a program.

Avoid changing the velocity during the acceleration or deceleration periods. For better predictable results, change velocity only when the axis is not moving or when it is moving with a constant speed.

RETURNS

If the “?” sign takes the place of nn value, this command reports the current setting

REL. COMMANDS

AC - set acceleration
VA - set velocity
VU - set maximum velocity
PA - execute an absolute motion
PR - execute a relative motion

EXAMPLE

2VB?  | read desired base velocity of axis # 2
5   | controller returns a velocity value of 5 units/s
2VB10 | set axis # 2 base velocity to 10 units/s
2VB?  | read base velocity of axis # 2
10  | controller returns a velocity value of 10 units/s
**VE**

**read controller firmware version**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

VE ?

**PARAMETERS**

none

**Defaults**

timeout: error 2, RS-232 COMMUNICATION TIME-OUT

**DESCRIPTION**

This command is used to read the controller type and version.

**Note:**

Important information needed when asking for technical support for the motion control system or when reporting a problem is the controller version. Use this command to determine the controller type and in particular, the firmware version.

**RETURNS**

ESP300 Version xx.yy

where: xx.yy = version and release number

**REL. COMMANDS**

none

**EXAMPLE**

VE?

ESP300 Version 3.0.1 6/1/99

controller returns model ESP300

version 3.0 and release date 6/1/99
VF set velocity feed-forward gain

**PARAMETERS**

- **Description**
  - **xx** [int] - axis number
  - **nn** [float] - velocity feed-forward gain factor Vf

- **Range**
  - **xx** - 1 to MAX AXES
  - **nn** - 0 to 2e9, or ? to read current setting

- **Units**
  - **xx** - none
  - **nn** - none

- **Defaults**
  - **xx** missing: error 37, AXIS NUMBER MISSING
    - out of range: error 9, AXIS NUMBER OUT OF RANGE
  - **nn** missing: error 38, COMMAND PARAMETER MISSING
    - out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command sets the velocity feed-forward gain factor Vf. It is active for any DC servo based motion device.

See the "Feed-Forward Loops" in Motion Control Tutorial section to understand the basic principals of feed-forward.

**Note:**

The command can be sent at any time but it has no effect until the UF (update filter) is received.

**RETURNS**

If the “?” sign takes the place of **nn** value, this command reports the current setting

**REL. COMMANDS**

- **KI** - set integral gain factor
- **KS** - set saturation gain factor
- **KD** - set derivative gain factor
- **KP** - set proportional gain factor
- **AF** - set acceleration feed-forward gain
- **UF** - update filter

**EXAMPLE**

- 3AF0.8 | set acceleration feed-forward gain factor for axis # 3 to 0.8
- 3VF? | report present axis-3 velocity feedforward setting
- 1.4 | controller returns a value of 1.4
- 3VF1.5 | set acceleration feed-forward gain factor for axis # 3 to 1.5
- 3UF | update PID filter; only now the VF command takes effect
## VU

**set maximum velocity**

### Usage

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

### Syntax

```
xxVU nn or xxVU?
```

### Parameters

**Description**

- `xx` [int] - axis number
- `nn` [float] - velocity value

**Range**

- `xx` - to **MAX AXES**
- `nn` - `0` to `2e+9`, or `?` to read current setting

**Units**

- `xx` - none
- `nn` - predefined units / second

**Defaults**

- `xx` missing: error 37, AXIS NUMBER MISSING
- `nn` missing: error 38, COMMAND PARAMETER MISSING

**DESCRIPTION**

This command is used to set the maximum velocity value for an axis. This command remains effective even if the requested axis is member of a group. In this case an error message, "GROUP MAXIMUM VELOCITY EXCEEDED", is generated if the commanded value is less than group velocity. (Refer to Advanced Capabilities section for a detailed description of grouping and related commands).

### Returns

If the “?” sign takes the place of `nn` value, this command reports the current setting

### Related Commands

- **VA** - set velocity
- **PA** - execute an absolute motion
- **PR** - execute a relative motion
- **AG** - set deceleration
- **AC** - set acceleration

### Example

```
2VU?  | read maximum allowed velocity of axis # 2
10    | controller returns a value of 10 units/s
2VU8  | set axis # 2 maximum maximum to 8 units/s
2VA6  | set axis #2 working velocity to 6 units/s
```
WP  wait for position

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**USAGE**

xxWPnn

**SYNTAX**

**PARAMETERS**

**Description**

- xx [ int ] - axis number
- nn [ float ] - position value

**Range**

- xx - 1 to MAX AXES
- nn - starting position to destination of axis number xx

**Units**

- xx - none
- nn - predefined units

**Defaults**

- xx missing: error 37, AXIS NUMBER MISSING
- out of range: error 9, AXIS NUMBER OUT OF RANGE
- nn missing: error 38, COMMAND PARAMETER MISSING
- out of range: error 7, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command stops program execution until a user specified position is reached. The program continues executing any subsequent commands only after axis xx has reached position nn.

**Note:**
Ensure that position nn is within the travel range of axis xx. The controller cannot always detect if a value is outside the travel range of an axis to flag an error, especially while making coordinated motion of multiple axes.

Wait commands are primarily intended for use in internal program execution or in combination with the RQ command. If used in command mode, it is important to note that input command processing is suspended until the wait condition has been satisfied.

**RETURNS**

None

**REL. COMMANDS**

- WT - wait
- WS - wait for motion stop

**EXAMPLE**

- 2PA-10; 2WS
- 2PA10; 2WP0; 3PA5

| move axis #2 to position –10 units and wait for stop
| move axis #2 to position 10 units, wait for axis #2 to reach position 0 units and then move axis #3 to position 5 units

Section 3 – Remote Mode 3-153
WS  
**wait for motion stop**

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

`xx WS nn`

**PARAMETERS**

**Description**

- `xx` [int] - axis number
- `nn` [int] - delay after motion is complete

**Range**

- `xx` - 0 to MAX AXES
- `nn` - 0 to 60000

**Units**

- `xx` - none
- `nn` - milliseconds

**Defaults**

- `xx` missing: error 37, AXIS NUMBER MISSING
- Out of range: error 9, AXIS NUMBER OUT OF RANGE
- `nn` missing: error 38, COMMAND PARAMETER MISSING
- Out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command stops the program execution until a motion is completed. The program is continued only after axis `xx` reaches its destination. If `xx` is not specified, the controller waits for all motion in progress to end. If `nn` is specified different than 0, the controller waits an additional `nn` milliseconds after the motion is complete and then executes the next commands.

**Note:**
Wait commands are primarily intended for use in internal program execution or in combination with the RQ command. If used in command mode, it is important to note that input command processing is suspended until the wait condition has been satisfied.

**RETURNS**

none

**REL. COMMANDS**

- `WT` - wait
- `WP` - wait for position

**EXAMPLE**

```
2PA10;2WS500;3PA5  | move axis # 2 to position 10 units, wait for axis # 2 to reach destination, wait an additional 500ms and then move axis # 3 to position 5 units
```
WT wait

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**SYNTAX**

WTnn

**PARAMETERS**

**Description**

- **nn** [ int ] - wait time (delay)

**Range**

- **nn** - 0 to 60000

**Units**

- **nn** - milliseconds

**Defaults**

- **xx** missing: error 37, AXIS NUMBER MISSING
- out of range: error 9, AXIS NUMBER OUT OF RANGE

- **nn** missing: error 38, COMMAND PARAMETER MISSING
- out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command causes the controller to pause for a specified amount of time. This means that the controller will wait **nn** milliseconds before executing the next command.

**Note:**

Even though this command can be executed in immediate mode, its real value is as a flow control instruction inside programs.

Wait commands are primarily intended for use in internal program execution or in combination with the RQ command. If used in command mode, it is important to note that input command processing is suspended until the wait condition has been satisfied.

**RETURNS**

none

**REL. COMMANDS**

- **WS** - wait for stop
- **WP** - wait for position

**EXAMPLE**

2MO;WT400;2PA2.3 | turn axis motor ON, wait an additional
| 400 ms and then move axis 2 to position 2.3 units
**XM**  
**read available memory**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**DESCRIPTION**  
This command reports the amount of unused program memory. The controller has 61440 bytes of non-volatile memory available for permanently storing programs. This command reports the amount not used.

**Note:**
Available memory space is updated only after the stored program memory is purged using **XX** command.

**RETURNS**  
Available storage space

**REL. COMMANDS**  
- **EP** - enter program download mode
- **EX** - execute a stored program
- **LP** - list stored program
- **XX** - delete a stored program

**EXAMPLE**  
```
xm
```
Available storage space = 61440

| read available memory |
| controller reports available storage space |
## XX erase program

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

### USAGE

This command makes the program xx loaded in controller’s non-volatile memory unavailable to user. It does not delete the program from memory. Consequently, the program space does not become available to user immediately after deleting the program. It becomes available to user only after the entire stored program memory is purged by issuing the command “0xx”.

**Note:** Purging the stored program memory takes approximately 3 seconds for completion.

### PARAMETERS

- **Description**: xx [ int ] - program number
- **Range**: xx - 1 to 100
- **Units**: xx - none
- **Defaults**: xx missing: error 38, COMMAND PARAMETER MISSING
  out of range: error 7, PARAMETER OUT OF RANGE

### DESCRIPTION

<table>
<thead>
<tr>
<th>EXAMPLE</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1XX</td>
<td>delete program #1</td>
</tr>
<tr>
<td>XM</td>
<td>read available memory</td>
</tr>
<tr>
<td>2XX</td>
<td>delete program #2</td>
</tr>
<tr>
<td>XM</td>
<td>read available memory</td>
</tr>
</tbody>
</table>

Available storage space = 60228| controller reports available storage space

<table>
<thead>
<tr>
<th>EXAMPLE</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>0XX</td>
<td>purge stored program memory</td>
</tr>
<tr>
<td>XM</td>
<td>read available memory</td>
</tr>
</tbody>
</table>

Available storage space = 61440| controller reports available storage space

### REL. COMMANDS

- **EP** - enter program download mode
- **EX** - execute a stored program
- **LP** - list stored program
- **XM** - read available memory
ZA  set amplifier I/O configuration

** USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

**SYNTAX**

`xxZA nn` or `xxZA?`

**PARAMETERS**

**Description**
- `xx [ int ]` - axis number
- `nn [ int ]` - amplifier I/O configuration

**Range**
- `xx` - 1 to MAX AXES
- `nn` - 0 to `0FFFFH` (hexadecimal with leading zero(0))
or ? to read current setting

**Units**
- `xx` - none
- `nn` - none

**Defaults**
- `xx` missing: error 37, AXIS NUMBER MISSING
- `xx` out of range: error 9, AXIS NUMBER OUT OF RANGE
- `nn` missing: error 38, COMMAND PARAMETER MISSING
- `nn` out of range: error xx2, PARAMETER OUT OF RANGE
- critical setting: error xx17, ESP CRITICAL SETTINGS ARE PROTECTED
- during motion: error xx26, PARAMETER CHANGE NOT ALLOWED DURING MOTION

**DESCRIPTION**

This command is used to set the amplifier I/O polarity, fault checking, and event handling for axis specified with `xx`.

**Note:**
If bit-0 or both bits-1 and -2 are set to zero(0) then no action will be taken by the controller.

**Note:**
The controller always interprets the `nn` value as a hexadecimal number, even when the letter "H" is not appended to the desired value. Since `nn` is a hexadecimal number, it is possible that the most significant character (left most character) is an alphabet (A—F) depending on the choice of values for various bits. In order for the controller to distinguish between an ASCII command and its value, it is recommended that the users always add a leading zero (0) to the `nn` value. See table below for clarification:

**Example:**

<table>
<thead>
<tr>
<th>Command Issued</th>
<th>Controller Interpretation</th>
</tr>
</thead>
<tbody>
<tr>
<td><code>1ZA123H</code></td>
<td><code>nn = 123H = (0001 0010 0011) Binary</code></td>
</tr>
<tr>
<td><code>1ZA123</code></td>
<td><code>nn = 123H = (0001 0010 0011) Binary</code></td>
</tr>
<tr>
<td><code>1ZA0F25H</code></td>
<td><code>nn = F25H = (1111 0010 0101) Binary</code></td>
</tr>
<tr>
<td><code>1ZAF25H</code></td>
<td>Invalid command</td>
</tr>
<tr>
<td>BIT</td>
<td>VALUE</td>
</tr>
<tr>
<td>-----</td>
<td>-------</td>
</tr>
<tr>
<td>#</td>
<td>0</td>
</tr>
<tr>
<td>*0</td>
<td>1</td>
</tr>
<tr>
<td>1</td>
<td>0</td>
</tr>
<tr>
<td>*1</td>
<td>1</td>
</tr>
<tr>
<td>*2</td>
<td>0</td>
</tr>
<tr>
<td>2</td>
<td>1</td>
</tr>
<tr>
<td>3</td>
<td>0</td>
</tr>
<tr>
<td>3</td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>0</td>
</tr>
<tr>
<td>4</td>
<td>1</td>
</tr>
<tr>
<td>5</td>
<td>0</td>
</tr>
<tr>
<td>*5</td>
<td>1</td>
</tr>
<tr>
<td>*6</td>
<td>0</td>
</tr>
<tr>
<td>6</td>
<td>1</td>
</tr>
<tr>
<td>*7</td>
<td>0</td>
</tr>
<tr>
<td>7</td>
<td>1</td>
</tr>
<tr>
<td>8</td>
<td>0</td>
</tr>
<tr>
<td>*8</td>
<td>1</td>
</tr>
<tr>
<td>*9</td>
<td>0</td>
</tr>
<tr>
<td>9</td>
<td>1</td>
</tr>
<tr>
<td>*10</td>
<td>0</td>
</tr>
<tr>
<td>10</td>
<td>1</td>
</tr>
<tr>
<td>*11</td>
<td>0</td>
</tr>
<tr>
<td>11</td>
<td>1</td>
</tr>
<tr>
<td>31</td>
<td>0</td>
</tr>
<tr>
<td>31</td>
<td>1</td>
</tr>
</tbody>
</table>

* default setting

+ This bit assignment is effective only on ESP100 and ESP300 motion controllers. Also, any change in motor winding takes affect only when the controller is reset or power cycled. As a result, amplifier I/O configuration must be saved to memory and controller must be reset for this change to take affect.

RETURNS

If the “?” sign takes the place of nn value, this command reports the current setting in hexadecimal notation.

REL. COMMANDS

<table>
<thead>
<tr>
<th>COMMAND</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZB</td>
<td>set feedback configuration</td>
</tr>
<tr>
<td>ZE</td>
<td>set e-stop configuration</td>
</tr>
<tr>
<td>ZF</td>
<td>set following error configuration</td>
</tr>
<tr>
<td>ZH</td>
<td>set hardware limit configuration</td>
</tr>
<tr>
<td>ZS</td>
<td>set software limit configuration</td>
</tr>
<tr>
<td>ZZ</td>
<td>set general system configuration</td>
</tr>
</tbody>
</table>
EXAMPLE

2ZA? | read amplifier I/O configuration of axis #2
123H | controller returns a value of 123H for axis #2
     | 123H = (0001 0010 0011)Binary
     | Bits 0, 1, 5, 8 = 1. All other bits = 0
2ZA 125H | set amplifier I/O configuration to 125H for axis #2
      | 125H = (0001 0010 0101)Binary
      | Bits 0, 2, 5, 8 = 1. All other bits = 0
SM | save all controller settings to non-volatile memory

Please refer the table above to interpret the affect of these bit values.
ZB  set feedback configuration

**USAGE**

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

**SYNTAX**

`xxZBnn` or `xxZB?`

**PARAMETERS**

**Description**

- `xx` [int] - axis number
- `nn` [int] - feedback configuration

**Range**

- `xx` - 1 to MAX AXES
- `nn` - 0 to `0FFFFH` (hexadecimal with leading zero(0)) or `?` to read current setting

**Units**

- `xx` - none
- `nn` - none

**Defaults**

- `xx` missing: error 37, AXIS NUMBER MISSING
- `nn` missing: error 38, COMMAND PARAMETER MISSING
- Out of range: error 9, AXIS NUMBER OUT OF RANGE
- Out of range: error xx2, PARAMETER OUT OF RANGE
- Critical setting: error xx17, ESP CRITICAL SETTINGS ARE PROTECTED
- During motion: error xx26, PARAMETER CHANGE NOT ALLOWED DURING MOTION

**DESCRIPTION**

This command is used to set the feedback configuration, fault checking, and event handling, as well as stepper closed-loop positioning for axis specified with `xx`.

**Note:**

If bit-0 or both bits-1 and -2 are set to zero(0) then no action will be taken by the controller.

**Note:**

The controller always interprets the `nn` value as a hexadecimal number, even when the letter "H" is not appended to the desired value. Since `nn` is a hexadecimal number, it is possible that the most significant character (left most character) is an alphabet (A—F) depending on the choice of values for various bits. In order for the controller to distinguish between an ASCII command and its value, it is recommended that the users always add a leading zero (0) to the `nn` value. See table below for clarification:

**Example:**

<table>
<thead>
<tr>
<th>Command Issued</th>
<th>Controller Interpretation</th>
</tr>
</thead>
<tbody>
<tr>
<td>1ZB123H</td>
<td><code>nn = 123H = (0001 0010 0011)Binary</code></td>
</tr>
<tr>
<td>1ZB123</td>
<td><code>nn = 123H = (0001 0010 0011)Binary</code></td>
</tr>
<tr>
<td>1ZBF025H</td>
<td><code>nn = F25H = (1111 0010 0101) Binary</code></td>
</tr>
<tr>
<td>1ZBF25H</td>
<td>Invalid command</td>
</tr>
<tr>
<td>BIT#</td>
<td>VALUE</td>
</tr>
<tr>
<td>------</td>
<td>-------</td>
</tr>
<tr>
<td>*0</td>
<td>0</td>
</tr>
<tr>
<td></td>
<td>1</td>
</tr>
<tr>
<td>*1</td>
<td>0</td>
</tr>
<tr>
<td></td>
<td>1</td>
</tr>
<tr>
<td>*2</td>
<td>0</td>
</tr>
<tr>
<td></td>
<td>1</td>
</tr>
<tr>
<td>*3</td>
<td>0</td>
</tr>
<tr>
<td></td>
<td>1</td>
</tr>
<tr>
<td>*4</td>
<td>0</td>
</tr>
<tr>
<td></td>
<td>1</td>
</tr>
<tr>
<td>*5</td>
<td>0</td>
</tr>
<tr>
<td></td>
<td>1</td>
</tr>
<tr>
<td>*6</td>
<td>0</td>
</tr>
<tr>
<td></td>
<td>1</td>
</tr>
<tr>
<td>*7</td>
<td>0</td>
</tr>
<tr>
<td></td>
<td>1</td>
</tr>
<tr>
<td>*8</td>
<td>0</td>
</tr>
<tr>
<td></td>
<td>1</td>
</tr>
<tr>
<td>*9</td>
<td>0</td>
</tr>
<tr>
<td></td>
<td>1</td>
</tr>
<tr>
<td>10</td>
<td>0</td>
</tr>
<tr>
<td></td>
<td>1</td>
</tr>
<tr>
<td>31</td>
<td>0</td>
</tr>
<tr>
<td></td>
<td>1</td>
</tr>
</tbody>
</table>

* default setting

RETURNS  If the “?” sign takes the place of nn value, this command reports the current setting in hexadecimal notation.

REL. COMMANDS

<table>
<thead>
<tr>
<th>COMMAND</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZA</td>
<td>set amplifier I/O configuration</td>
</tr>
<tr>
<td>ZE</td>
<td>set e-stop configuration</td>
</tr>
<tr>
<td>ZF</td>
<td>set following error configuration</td>
</tr>
<tr>
<td>ZH</td>
<td>set hardware limit configuration</td>
</tr>
<tr>
<td>ZS</td>
<td>set software limit configuration</td>
</tr>
<tr>
<td>ZZ</td>
<td>set general system configuration</td>
</tr>
</tbody>
</table>

EXAMPLE

2ZB?   | read amplifier I/O configuration of axis # 2
100H   | controller returns a value of 100H for axis #2
2ZB 105H | set amplifier I/O configuration to 105H for axis #2
SM     | save all controller settings to non-volatile memory
ZE set e-stop configuration

**USAGE**

IMM PGM MIP

- ♦  ♦

**SYNTAX**

xxZE\(nn\) or xxZE?  

**PARAMETERS**

**Description**

- xx [ int ] - axis number
- nn [ int ] - e-stop configuration

**Range**

- xx - 1 to MAX AXES
- nn - 0 to 0xFFFFH (hexadecimal with leading zero(0) ) or ? to read current setting

**Units**

- xx - none
- nn - none

**Defaults**

- xx missing: error 37, AXIS NUMBER MISSING
- out of range: error 9, AXIS NUMBER OUT OF RANGE

- nn missing: error 38, COMMAND PARAMETER MISSING
- out of range: error xx17, ESP CRITICAL SETTINGS ARE PROTECTED

**DESCRIPTION**

This command is used to set the emergency stop (e-stop) configuration, fault checking, and event handling for axis specified with xx.

**Note:**

If bit-0 or both bits-1 and -2 are set to zero(0) then no action will be taken by the controller.

**Note:**

The controller always interprets the nn value as a hexadecimal number, even when the letter "H" is not appended to the desired value. Since nn is a hexadecimal number, it is possible that the most significant character (left most character) is an alphabet (A—F) depending on the choice of values for various bits. In order for the controller to distinguish between an ASCII command and its value, it is recommended that the users always add a leading zero (0) to the nn value. See table below for clarification:

**Example:**

<table>
<thead>
<tr>
<th>Command Issued</th>
<th>Controller Interpretation</th>
</tr>
</thead>
<tbody>
<tr>
<td>1ZE123H</td>
<td>nn = 123H = (0001 0010 0011)Binary</td>
</tr>
<tr>
<td>1ZE123</td>
<td>nn = 123H = (0001 0010 0011)Binary</td>
</tr>
<tr>
<td>1ZE0F25H</td>
<td>nn = F25H = (1111 0010 0101) Binary</td>
</tr>
<tr>
<td>1ZEF25H</td>
<td>Invalid command</td>
</tr>
</tbody>
</table>

Section 3 – Remote Mode 3-163
<table>
<thead>
<tr>
<th>BIT#</th>
<th>VALUE</th>
<th>DEFINITION</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>0</td>
<td>disable E-stop checking</td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>enable E-stop checking</td>
</tr>
<tr>
<td>*0</td>
<td>1</td>
<td>enable E-stop checking</td>
</tr>
<tr>
<td>*1</td>
<td>0</td>
<td>do not disable motor power on E-stop event</td>
</tr>
<tr>
<td>2</td>
<td>0</td>
<td>do not abort motion on E-stop event</td>
</tr>
<tr>
<td>*2</td>
<td>1</td>
<td>abort motion on E-stop event</td>
</tr>
<tr>
<td>3</td>
<td>0</td>
<td>reserved</td>
</tr>
<tr>
<td>4</td>
<td>0</td>
<td>reserved</td>
</tr>
<tr>
<td>5</td>
<td>1</td>
<td>reserved</td>
</tr>
<tr>
<td>6</td>
<td>0</td>
<td>reserved</td>
</tr>
<tr>
<td>7</td>
<td>1</td>
<td>reserved</td>
</tr>
<tr>
<td>31</td>
<td>0</td>
<td>reserved</td>
</tr>
<tr>
<td>31</td>
<td>1</td>
<td>reserved</td>
</tr>
</tbody>
</table>

* default setting

**RETURNS**

If the “?” sign takes the place of nn value, this command reports the current setting in hexadecimal notation.

**REL. COMMANDS**

- **ZA** - set amplifier I/O configuration
- **ZB** - set feedback configuration
- **ZF** - set following error configuration
- **ZH** - set hardware limit configuration
- **ZS** - set software limit configuration
- **ZZ** - set general system configuration

**EXAMPLE**

- **2ZE?**  | read e-stop configuration of axis # 2
- **3H**    | controller returns a value of 3H for axis #2
- **2ZE 5H**| set e-stop configuration to 5H for axis #2
- **SM**    | save all controller settings to non-volatile memory
ZF

set following error configuration

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

**USAGE**

**SYNTAX**

xxZFnn or xxZF?

**PARAMETERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>xx [ int ] -</th>
<th>axis number</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn [ int ] -</td>
<td>following error configuration</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Range</th>
<th>xx -</th>
<th>1 to MAX AXES</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn -</td>
<td>0 to 0FFFFH (hexadecimal with leading zero(0)) or ? to read current setting</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Units</th>
<th>xx -</th>
<th>none</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>nn -</td>
<td>none</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Defaults</th>
<th>xx missing:</th>
<th>error 37, AXIS NUMBER MISSING</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>out of range:</td>
<td>error 9, AXIS NUMBER OUT OF RANGE</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>nn missing:</th>
<th>error 38, COMMAND PARAMETER MISSING</th>
</tr>
</thead>
<tbody>
<tr>
<td>out of range:</td>
<td>error xx2, PARAMETER OUT OF RANGE</td>
</tr>
<tr>
<td>critical setting:</td>
<td>error xx17, ESP CRITICAL SETTINGS ARE PROTECTED</td>
</tr>
</tbody>
</table>

**DESCRIPTION**

This command is used to set the following error configuration, fault checking, and event handling for axis specified with **xx**.

**Note:**

If bit-0 or both bits-1 and -2 are set to zero(0) then no action will be taken by the controller.

**Note:**

The controller always interprets the **nn** value as a hexadecimal number, even when the letter "H" is not appended to the desired value. Since **nn** is a hexadecimal number, it is possible that the most significant character (left most character) is an alphabet (A—F) depending on the choice of values for various bits. In order for the controller to distinguish between an ASCII command and its value, it is recommended that the users always add a leading zero (0) to the **nn** value. See table below for clarification:

**Example:**

<table>
<thead>
<tr>
<th>Command Issued</th>
<th>Controller Interpretation</th>
</tr>
</thead>
<tbody>
<tr>
<td>1ZF123H</td>
<td>nn = 123H = (0001 0010 0011)Binary</td>
</tr>
<tr>
<td>1ZF123</td>
<td>nn = 123H = (0001 0010 0011)Binary</td>
</tr>
<tr>
<td>1ZF0F25H</td>
<td>nn = F25H = (1111 0010 0101) Binary</td>
</tr>
<tr>
<td>1ZFF25H</td>
<td>Invalid command</td>
</tr>
</tbody>
</table>
### BIT# VALUE DEFINITION

<table>
<thead>
<tr>
<th>0</th>
<th>0</th>
<th>disable motor following error checking</th>
</tr>
</thead>
<tbody>
<tr>
<td>*0</td>
<td>1</td>
<td>enable motor following error checking</td>
</tr>
<tr>
<td>1</td>
<td>0</td>
<td>do not disable motor power on following error event</td>
</tr>
<tr>
<td>*1</td>
<td>1</td>
<td>disable motor power on following error event</td>
</tr>
<tr>
<td>*2</td>
<td>0</td>
<td>do not abort motion on following error event</td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>abort motion on following error event</td>
</tr>
<tr>
<td>3</td>
<td>0</td>
<td>reserved</td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>reserved</td>
</tr>
<tr>
<td>4</td>
<td>0</td>
<td>reserved</td>
</tr>
<tr>
<td>4</td>
<td>1</td>
<td>reserved</td>
</tr>
<tr>
<td>5</td>
<td>0</td>
<td>reserved</td>
</tr>
<tr>
<td>5</td>
<td>1</td>
<td>reserved</td>
</tr>
<tr>
<td>6</td>
<td>0</td>
<td>reserved</td>
</tr>
<tr>
<td>6</td>
<td>1</td>
<td>reserved</td>
</tr>
<tr>
<td>7</td>
<td>0</td>
<td>reserved</td>
</tr>
<tr>
<td>7</td>
<td>1</td>
<td>reserved</td>
</tr>
<tr>
<td>31</td>
<td>0</td>
<td>reserved</td>
</tr>
<tr>
<td>31</td>
<td>1</td>
<td>reserved</td>
</tr>
</tbody>
</table>

* default setting

### RETURNS
If the “?” sign takes the place of nn value, this command reports the current setting in hexadecimal notation.

### REL. COMMANDS

<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZA</td>
<td>set amplifier I/O configuration</td>
</tr>
<tr>
<td>ZB</td>
<td>set feedback configuration</td>
</tr>
<tr>
<td>ZE</td>
<td>set e-stop configuration</td>
</tr>
<tr>
<td>ZH</td>
<td>set hardware limit configuration</td>
</tr>
<tr>
<td>ZS</td>
<td>set software limit configuration</td>
</tr>
<tr>
<td>ZZ</td>
<td>set general system configuration</td>
</tr>
<tr>
<td>FE</td>
<td>set following error threshold</td>
</tr>
</tbody>
</table>

### EXAMPLE

<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>2ZF?</td>
<td>read following error configuration of axis # 2</td>
</tr>
<tr>
<td>3H</td>
<td>controller returns a value of 3H for axis #2</td>
</tr>
<tr>
<td>2ZF 5H</td>
<td>set following error configuration to 5H for axis #2</td>
</tr>
<tr>
<td>SM</td>
<td>save all controller settings to non-volatile memory</td>
</tr>
</tbody>
</table>
ZH

set hardware limit configuration

IMM PGM MIP

USAGE

SYNTAX

Example:

xxZHnn or xxZH?

PARAMETERS

Description

xx [ int ] - axis number
nn [ int ] - hardware limit configuration

Range

xx - 1 to MAX AXES
nn - 0 to 0FFFFH (hexadecimal with leading zero(0) )
or ? to read current setting

Units

xx - none
nn - none

Defaults

xx missing: error 37, AXIS NUMBER MISSING
out of range: error 9, AXIS NUMBER OUT OF RANGE

nn missing: error 38, COMMAND PARAMETER MISSING
out of range: error xx2, PARAMETER OUT OF RANGE
critical setting: error xx17, ESP CRITICAL SETTINGS ARE PROTECTED

DESCRIPTION

This command is used to set the hardware limit checking, polarity, and event handling for axis specified with xx.

Note:
If bit-0 or both bits-1 and -2 are set to zero(0) then no action will be taken by the controller.

Note:
The controller always interprets the nn value as a hexadecimal number, even when the letter "H" is not appended to the desired value. Since nn is a hexadecimal number, it is possible that the most significant character (left most character) is an alphabet (A—F) depending on the choice of values for various bits. In order for the controller to distinguish between an ASCII command and its value, it is recommended that the users always add a leading zero (0) to the nn value. See table below for clarification:

Example:

<table>
<thead>
<tr>
<th>Command Issued</th>
<th>Controller Interpretation</th>
</tr>
</thead>
<tbody>
<tr>
<td>1ZH123H</td>
<td>nn = 123H = (0001 0010 0011)Binary</td>
</tr>
<tr>
<td>1ZH123</td>
<td>nn = 123H = (0001 0010 0011)Binary</td>
</tr>
<tr>
<td>1ZH0F25H</td>
<td>nn = F25H = (1111 0010 0101) Binary</td>
</tr>
<tr>
<td>1ZH0F25H</td>
<td>Invalid command</td>
</tr>
<tr>
<td>BIT</td>
<td>VALUE</td>
</tr>
<tr>
<td>-----</td>
<td>-------</td>
</tr>
<tr>
<td>#</td>
<td>0</td>
</tr>
<tr>
<td>*0</td>
<td>1</td>
</tr>
<tr>
<td>*1</td>
<td>0</td>
</tr>
<tr>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td>2</td>
<td>0</td>
</tr>
<tr>
<td>*2</td>
<td>1</td>
</tr>
<tr>
<td>3</td>
<td>0</td>
</tr>
<tr>
<td>3</td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>0</td>
</tr>
<tr>
<td>4</td>
<td>1</td>
</tr>
<tr>
<td>5</td>
<td>0</td>
</tr>
<tr>
<td>*5</td>
<td>1</td>
</tr>
<tr>
<td>6</td>
<td>0</td>
</tr>
<tr>
<td>6</td>
<td>1</td>
</tr>
<tr>
<td>7</td>
<td>0</td>
</tr>
<tr>
<td>7</td>
<td>1</td>
</tr>
<tr>
<td>31</td>
<td>0</td>
</tr>
<tr>
<td>31</td>
<td>1</td>
</tr>
</tbody>
</table>

* default setting

RETURNS

If the “?” sign takes the place of nn value, this command reports the current setting in hexadecimal notation.

REL. COMMANDS

<table>
<thead>
<tr>
<th>COMMAND</th>
<th>PREAMBLE</th>
<th>FUNCTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZA</td>
<td>-</td>
<td>set amplifier I/O configuration</td>
</tr>
<tr>
<td>ZE</td>
<td>-</td>
<td>set e-stop configuration</td>
</tr>
<tr>
<td>ZF</td>
<td>-</td>
<td>set following error configuration</td>
</tr>
<tr>
<td>ZB</td>
<td>-</td>
<td>set feedback configuration</td>
</tr>
<tr>
<td>ZS</td>
<td>-</td>
<td>set software limit configuration</td>
</tr>
<tr>
<td>ZZ</td>
<td>-</td>
<td>set general system configuration</td>
</tr>
</tbody>
</table>

EXAMPLE

<table>
<thead>
<tr>
<th>COMMAND</th>
<th>FUNCTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>2ZH?</td>
<td>read hardware limit configuration of axis # 2</td>
</tr>
<tr>
<td>25H</td>
<td>controller returns a value of 25H for axis # 2</td>
</tr>
<tr>
<td>2ZH 23H</td>
<td>set hardware limit configuration to 23H for axis # 2</td>
</tr>
<tr>
<td>SM</td>
<td>save all controller settings to non-volatile memory</td>
</tr>
</tbody>
</table>
**ZS**

**set software limit configuration**

### USAGE

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

### SYNTAX

`xxZSnn` or `xxZS?`

### PARAMETERS

**Description**

- `xx` [ int ] - axis number
- `nn` [ int ] - hardware limit configuration

**Range**

- `xx` - 1 to MAX AXES
- `nn` - 0 to 0FFFFH (hexadecimal with leading zero(0)) or ? to read current setting

**Units**

- `xx` - none
- `nn` - none

**Defaults**

- `xx` missing: error 37, AXIS NUMBER MISSING
- `xx` out of range: error 9, AXIS NUMBER OUT OF RANGE
- `nn` missing: error 38, COMMAND PARAMETER MISSING
- `nn` out of range: error xx2, PARAMETER OUT OF RANGE
- critical setting: error xx17, ESP CRITICAL SETTINGS ARE PROTECTED

### DESCRIPTION

This command is used to set the software limit checking and event handling for axis specified with `xx`.

**Note:**

If bit-0 or both bits-1 and -2 are set to zero(0) then no action will be taken by the controller.

**Note:**

The controller always interprets the `nn` value as a hexadecimal number, even when the letter "H" is not appended to the desired value. Since `nn` is a hexadecimal number, it is possible that the most significant character (left most character) is an alphabet (A—F) depending on the choice of values for various bits. In order for the controller to distinguish between an ASCII command and its value, it is recommended that the users always add a leading zero (0) to the `nn` value. See table below for clarification:

### Example:

<table>
<thead>
<tr>
<th>Command Issued</th>
<th>Controller Interpretation</th>
</tr>
</thead>
<tbody>
<tr>
<td>1ZS123H</td>
<td><code>nn = 123H = (0001 0010 0011) Binary</code></td>
</tr>
<tr>
<td>1ZS123</td>
<td><code>nn = 123H = (0001 0010 0011) Binary</code></td>
</tr>
<tr>
<td>1ZS0F25H</td>
<td><code>nn = F25H = (1111 0010 0101) Binary</code></td>
</tr>
<tr>
<td>1ZSF25H</td>
<td>Invalid command</td>
</tr>
<tr>
<td>BIT</td>
<td>VALUE</td>
</tr>
<tr>
<td>-----</td>
<td>-------</td>
</tr>
<tr>
<td>#</td>
<td>0</td>
</tr>
<tr>
<td>*0</td>
<td>1</td>
</tr>
<tr>
<td>*1</td>
<td>0</td>
</tr>
<tr>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td>2</td>
<td>0</td>
</tr>
<tr>
<td>*2</td>
<td>1</td>
</tr>
<tr>
<td>3</td>
<td>0</td>
</tr>
<tr>
<td>3</td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>0</td>
</tr>
<tr>
<td>4</td>
<td>1</td>
</tr>
<tr>
<td>5</td>
<td>0</td>
</tr>
<tr>
<td>5</td>
<td>1</td>
</tr>
<tr>
<td>6</td>
<td>0</td>
</tr>
<tr>
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<tr>
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</tr>
<tr>
<td>7</td>
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</tr>
<tr>
<td>31</td>
<td>0</td>
</tr>
<tr>
<td>31</td>
<td>1</td>
</tr>
</tbody>
</table>

* default setting

RETURNS
If the “?” sign takes the place of nn value, this command reports the current setting in hexadecimal notation.

REL. COMMANDS
ZA - set amplifier I/O configuration
ZE - set e-stop configuration
ZF - set following error configuration
ZB - set feedback configuration
ZH - set hardware limit configuration
ZZ - set general system configuration
SL - set left limit
SR - set right limit

EXAMPLE
2ZS? | read software limit configuration of axis #2
4H  | controller returns a value of 4H for axis #2
2ZS 5H | set software limit configuration to 5H for axis #2
SM  | save all controller settings to non-volatile memory
ZU get ESP system configuration

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td></td>
</tr>
</tbody>
</table>

SYNTAX
ZU

PARAMETERS
None

DESCRIPTION
This command is used to get the present ESP system stage/driver configuration. After each system reset or initialization the ESP motion controller detects the presence of Universal drivers and ESP-compatible stages connected.

<table>
<thead>
<tr>
<th>BIT#</th>
<th>VALUE</th>
<th>DEFINITION</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>0</td>
<td>reserved</td>
</tr>
<tr>
<td>0</td>
<td>1</td>
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<td>1</td>
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<tr>
<td>2</td>
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<td>3</td>
<td>0</td>
<td>reserved</td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>reserved</td>
</tr>
<tr>
<td>4</td>
<td>0</td>
<td>reserved</td>
</tr>
<tr>
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<td>1</td>
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<tr>
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<tr>
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<td>reserved</td>
</tr>
<tr>
<td>6</td>
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<td>reserved</td>
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<tr>
<td>6</td>
<td>1</td>
<td>reserved</td>
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<tr>
<td>7</td>
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<td>reserved</td>
</tr>
<tr>
<td>7</td>
<td>1</td>
<td>reserved</td>
</tr>
<tr>
<td>8</td>
<td>0</td>
<td>axis-1 ESP-compatible motorized positioner not detected</td>
</tr>
<tr>
<td>8</td>
<td>1</td>
<td>axis-1 ESP-compatible motorized positioner detected</td>
</tr>
<tr>
<td>9</td>
<td>0</td>
<td>axis-2 ESP-compatible motorized positioner not detected</td>
</tr>
<tr>
<td>9</td>
<td>1</td>
<td>axis-2 ESP-compatible motorized positioner detected</td>
</tr>
<tr>
<td>10</td>
<td>0</td>
<td>axis-3 ESP-compatible motorized positioner not detected</td>
</tr>
<tr>
<td>10</td>
<td>1</td>
<td>axis-3 ESP-compatible motorized positioner detected</td>
</tr>
<tr>
<td>11</td>
<td>0</td>
<td>reserved</td>
</tr>
<tr>
<td>11</td>
<td>1</td>
<td>reserved</td>
</tr>
<tr>
<td>12</td>
<td>0</td>
<td>• • •</td>
</tr>
<tr>
<td>31</td>
<td>0</td>
<td>reserved</td>
</tr>
<tr>
<td>31</td>
<td>1</td>
<td>reserved</td>
</tr>
</tbody>
</table>

RETURNS
This command reports the current setting in hexadecimal notation.

REL. COMMANDS
ZA - set amplifier I/O configuration
ZB - set feedback configuration
ZE - set e-stop configuration
ZF - set following error configuration
ZH - set hardware limit configuration

Section 3 – Remote Mode
**EXAMPLE**

<table>
<thead>
<tr>
<th>ZS</th>
<th>set software limit configuration</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZZ</td>
<td>set system configuration</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>ZU</th>
<th>read ESP system configuration</th>
</tr>
</thead>
<tbody>
<tr>
<td>150015H</td>
<td>controller returns a value of 150015H</td>
</tr>
</tbody>
</table>
**ZZ**

set system configuration

<table>
<thead>
<tr>
<th>IMM</th>
<th>PGM</th>
<th>MIP</th>
</tr>
</thead>
<tbody>
<tr>
<td>♦</td>
<td>♦</td>
<td>♦</td>
</tr>
</tbody>
</table>

**USAGE**

ZZnn or ZZ?

**SYNTAX**

ZZnn or ZZ?

**PARAMETERS**

**Description**

nn [ int ] - system configuration

**Range**

nn - 0 to $0FFFFH$ (hexadecimal with leading zero(0) )

or ? to read current setting

**Units**

nn - none

**Defaults**

nn missing: error 38, COMMAND PARAMETER MISSING

out of range: error xx2, PARAMETER OUT OF RANGE

**DESCRIPTION**

This command is used to configure system fault checking, event handling and general setup for all axes.

**Note:**

If bit-0 or both bits-1 and -2 are set to zero(0) then no action will be taken by the controller.

**Note:**

The controller always interprets the nn value as a hexadecimal number, even when the letter "H" is not appended to the desired value. Since nn is a hexadecimal number, it is possible that the most significant character (left most character) is an alphabet (A—F) depending on the choice of values for various bits. In order for the controller to distinguish between an ASCII command and its value, it is recommended that the users always add a leading zero (0) to the nn value. See table below for clarification:

**Example:**

<table>
<thead>
<tr>
<th>Command Issued</th>
<th>Controller Interpretation</th>
</tr>
</thead>
<tbody>
<tr>
<td>1ZZ123H</td>
<td>nn = 123H = (0001 0010 0011) Binary</td>
</tr>
<tr>
<td>1ZZ123</td>
<td>nn = 123H = (0001 0010 0011) Binary</td>
</tr>
<tr>
<td>1ZZ0F25H</td>
<td>nn = F25H = (1111 0010 0101) Binary</td>
</tr>
<tr>
<td>1ZZF25H</td>
<td>Invalid command</td>
</tr>
<tr>
<td>BI</td>
<td>VAL</td>
</tr>
<tr>
<td>----</td>
<td>-----</td>
</tr>
<tr>
<td>T#</td>
<td>UE</td>
</tr>
<tr>
<td>0</td>
<td>0</td>
</tr>
<tr>
<td>*0</td>
<td>1</td>
</tr>
<tr>
<td>1</td>
<td>0</td>
</tr>
<tr>
<td>*1</td>
<td>1</td>
</tr>
<tr>
<td>2</td>
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<tr>
<td>2</td>
<td>1</td>
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<tr>
<td>3</td>
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<td>3</td>
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<tr>
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<td>*7</td>
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<tr>
<td>7</td>
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<tr>
<td>8</td>
<td>0</td>
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<tr>
<td>*8</td>
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<td>*9</td>
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<td>9</td>
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</tr>
<tr>
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</tr>
<tr>
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<td>10</td>
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</tr>
<tr>
<td>*1</td>
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<tr>
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</tr>
<tr>
<td>31</td>
<td>0</td>
</tr>
<tr>
<td>31</td>
<td>1</td>
</tr>
<tr>
<td></td>
<td>* default setting</td>
</tr>
</tbody>
</table>

RETURNS
If the “?” sign takes the place of nn value, this command reports the current setting in hexadecimal notation.

REL. COMMANDS
ZA  -  set amplifier I/O configuration
ZB  -  set feedback configuration
ZE  -  set e-stop configuration
ZF  -  set following error configuration
ZH  -  set hardware limit configuration
ZS  -  set software limit configuration
ZU  -  get ESP system configuration

EXAMPLE
ZZ?  | read system configuration
113H | controller returns a value of 113H
ZZ 13H | set system configuration to 13H
4.1 Grouping

4.1.1 Introduction – Advanced Capabilities

Coordinated motion of multiple axes is required to produce a desired contour in a multi-dimensional space. For instance, if we want to move from one point to another along a line or along a circle, or a combination of both line and circle, we require coordinated motion of multiple axes. One way to facilitate such coordinated motion is "grouping" the axes involved in producing the desired motion. This is akin to defining the coordinate system in which the desired contour is being made.

Coordinated motion on a 2-D plane, therefore, requires a group comprised of any two axes, while a similar motion in a 3-D space requires a group consisting of any three axes. For sake of simplicity, all further discussion of coordinated motion will be restricted to a 2-D plane.

The procedure for defining a group and all the group parameters required for making coordinated motion is described in Section 4.1.3 discusses the commands that actually make the coordinated motion. The procedure for making "long" moves or contours that involve a combination of circular and linear moves is described in Section 4.1.4. Miscellaneous grouping commands are discussed in Section 4.1.5.

4.1.2 Defining a Group and Group Parameters

This subsection discusses the method for defining a group and all the group parameters.

4.1.2.1 Creating a Group

The ASCII command used to create a new group is HN. For instance, the command 1HN2, 3 assigns axis numbers 2 and 3 to group number 1. One such group must be defined first before those axes can be moved in a coordinated fashion. A group can comprise of axes anywhere from one to six.
If a group has only one axis assigned to it, a linear motion of the group is similar to moving that axis from one point to another. Circular motion of a group with only one axis cannot be made.

If a group has more than two axes assigned to it, circular motion of the group is made using the first two axes in the group.

The order in which axes are assigned to a group is very important. This is because it specifies the frame of reference in which coordinated motion of axes takes place. For instance, the command `1HN2, 3` assigns axis numbers 2 and 3 to group number 1, where axis #2 is equivalent to X-axis and axis #3 is equivalent to Y-axis in a traditional Cartesian coordinate system. Reversing the order of axes (E.G., `1HN3, 2`) reverses the axis assignment.

A few rules that are in place for easy management of group are as follows:

- An axis cannot be a member of different groups at the same time.
- An axis cannot be assigned more than once in a group.
- A group has to be deleted before axes assigned to it can be changed.
- An axis assigned to a group cannot be moved individually using commands such as PA and PR. Use group linear move commands instead.

Refer to the description of this command in the commands section (See Section 3: Remote Mode) for correct syntax, parameter ranges, etc.

4.1.2.2 Defining Group Parameters

Group parameters such as velocity, acceleration, deceleration, jerk, and e-stop deceleration must be defined for every group following the creation of that group. These parameters are used to produce the desired coordinated motion of the group. They override any original values specified for individual axes. The axes’ original values are restored when the group to which they have been assigned is deleted. Refer to the description of HV, HA, HD, HJ, and HE commands in the commands section (See Section 3: Remote Mode) for correct syntax, parameter ranges, etc.

4.1.3 Making Linear and Circular Moves

This subsection discusses the method for making linear and circular moves of groups. While coordinated motion of axes with different motor types and different encoder resolutions is supported, it is assumed that all axes have the same units of measure.
4.1.3.1 Making Linear Move

Once a group has been defined and all group parameters have been specified, the ASCII command `HL` is used to move the group from an initial position to a final position along the line. The current position of axes is the initial position of linear move. The desired final position is specified along with this command.

This command makes all axes assigned to the group move with predefined group (tangential) velocity, acceleration and deceleration along a line. A trapezoidal velocity profile is employed when group jerk is set to zero. Otherwise, an S-curve velocity profile is employed.

The linear move is a true linear interpolation, meaning:

\[
(y - y_0) = m(x - x_0)
\]

\[
m = \frac{(y_f - y_0)}{(x_f - x_0)}
\]

where: \(X_0\) and \(Y_0\) represent initial position of the group. \(X_f\) and \(Y_f\) represent desired final position of the group.

4.1.3.2 Making Circular Move

Once a group has been defined and all group parameters have been specified, the ASCII command `HC` can be used to move the group from an initial position to a final position along a circle. The current position of axes is the initial position of circular move. The final position of move is calculated based on the desired center of circle and sweep angle specified along with this command. All sweep angles are measured in degrees. The sign of angles follow the trigonometric convention: positive angles are measured counterclockwise.

This command makes all axes assigned to the group move with predefined group (tangential) velocity, acceleration and deceleration along a circle. A trapezoid velocity profile is employed to produce the desired motion.

The circular move is a true arc of a circle, meaning:
\[ r = \sqrt{(x_0 - x_c)^2 + (y_0 - y_c)^2} \]

\[ \theta = \alpha \tan \left( \frac{(y_0 - y_c)}{(x_0 - x_c)} \right) \]

\[ \theta_0 [\text{axis#2}] = \theta \]

\[ \theta_0 [\text{axis#3}] = \theta - \frac{\pi}{2} \]

\[ \theta_f [\text{axis#2}] = \theta_0 + \theta_{cmd} \]

\[ \theta_f [\text{axis#3}] = \theta_0 + \theta_{cmd} \]

\[ x_f = r \cdot \cos(\theta_f [\text{axis#2}]) + x_c \]

\[ y_f = r \cdot \cos(\theta_f [\text{axis#3}]) + y_c \]

where:  
- \(X_0\) and \(Y_0\) represent initial position of the group.  
- \(X_c\) and \(Y_c\) represent desired center position of the circular move.  
- \(X_f\) and \(Y_f\) represent calculated final position of the group.  
- \(R\) is radius of the circle.  
- \(\theta_0\) is the base initial angle of an axis.  
- \(\theta_0\) is the final angle of an axis, which is dependant on the sweep angle, \(\theta_{cmd}\).

Both \textbf{HL} and \textbf{HC} can initiate the desired motion if they are received while the group is holding position. On the other hand, if they are received while a group move is in progress, the new commands get queued into a "via-point" buffer. The queued commands are executed on a FIFO basis when the move already in progress has reached its destination. The group does not come to a stop at the end of last move. Instead, there will be a smooth transition to the new move command, just as if it were one compound move (combination of multiple moves). The next section details the procedure for making contours or "long" moves using "via-point" buffers.

Refer to the description of \textbf{HL} and \textbf{HC} commands in the \textit{commands section} (See Section 3: Remote Mode) for correct syntax, parameter ranges, etc.

**4.1.4 Making Contours**

This subsection discusses the method for making contours. Contouring is the process of making complex trajectories or "long" moves that may involve linear and circular move segments.
These move segments can be sequenced in any order. Arcs can be followed by arcs or lines, and lines by arcs or other lines as shown in the following figures. Since there is no pre-processing of move segments involved in making a contour, the user must ensure that there is no change in tangential velocity at the transition from one move to another. If this constraint is not satisfied, the transition from one move segment to another may cause excessive accelerations and shocks that could damage the stages.

Figure 4.1: A contour with multiple circular moves

Figure 4.2: A contour with multiple linear and circular moves

In order to store the multiple move segment commands needed to make a contour, we make use of a "via point" buffer. This "via point" buffer contains group move commands essential to make a new move segment upon completion of the move segment currently in progress. The new move commands are pulled out of the buffer on a FIFO basis. The "via point" buffer can hold a maximum of 10 group move commands. If more than 10 group move commands are issued by a user, the excess commands are flow-controlled by the firmware.
This mechanism will block the portal through which the commands were issued until all the commands issued have been executed.

It is, therefore, recommended that the user take advantage of ASCII command, HQ which tells the number of commands that can be put in the "via point" buffer at any given time. This allows a user to control the flow of commands manually, while ensuring the availability of that portal for other commands such as HP, TP, etc.

The trajectory generator checks if the "via point" buffer has a new target position (i.e., any new move segments pending?) while the current move is in progress. If "via point" buffer is empty, the group comes to a stop upon completion of current move segment. Otherwise, it begins a new move segment without stopping after completing the current move. The group transitions from current move segment to a new move segment smoothly if the tangential velocity at the transition is ensured to be constant.

The ASCII command HQ is used to query the available "via point" buffer space. The commands HL and HC are used to queue linear move or circular move commands into the "via point" buffer. Refer to the description of these commands in the commands section (See Section 3: Remote Mode) for correct syntax, parameter ranges, etc.

![Figure 4.3: Block Diagram of Via Point Data Handling by Command Processor](image-url)
4.1.5 Miscellaneous Commands

The following commands are available to operate on a group of axes simultaneously:

- **HO** and **HF**: These commands are used to turn ON and turn OFF the power to all axes in a group respectively. The axes assigned to a group can be powered ON or OFF individually using **MO** and **MF** commands also. A group is considered to be ON if all axes assigned to that group are ON.

- **HP**: This command is used to read the actual position of all axes in a group.

- **HS**: This command is used to stop the group motion.

- **HW**: This command is used to wait for the group motion to stop and a user settable delay period thereafter.

- **HX**: This command is used to delete a group.

- **HZ**: This command is used to read the size or the number of axes assigned to group.

4.2 Slaving a Stage to Trackball, Joystick, or a Different Stage

4.2.1 Introduction – Slaving a Stage

ESP series of motion controllers allow three different ways in which a slave axis can respond to a master axis. They are:

1. Slave to master's desired position (trajectory).
2. Slave to master's actual position (feedback).
3. Slave to master's actual velocity for jogging.
The first two ways may be used when absolute or relative move commands can be issued to the master. This is the situation when both master and slave axes are driven by valid motor types. The third way may be used when move commands cannot be issued to the master. This is the situation when the slave axis is driven by a valid motor type, but the master, such as trackball or joystick, is not.

In any case, a series of preliminary commands have to be issued before the desired master-slave response is obtained. These include defining master-slave relationship, appropriate constants and trajectory mode.

The next section outlines the steps to be taken for a slave axis to follow master's position. The subsequent section outlines the steps to be taken for a slave axis to follow master's velocity. The final section outlines the steps to be taken to jog an axis based on inputs from a digital joystick.

### 4.2.2 Slave to a Different Stage

The following steps may be taken for a slave axis to follow master's position. This mode may be chosen exclusively when absolute or relative move commands can be issued to the master.

<table>
<thead>
<tr>
<th>Steps</th>
<th>Move Command</th>
<th>Action by Move Command</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Define master-slave relationship</td>
<td>2SS1</td>
<td>Axis #2 is the slave of axis #1</td>
</tr>
<tr>
<td>2. Defines master-slave reduction ratio</td>
<td>2GR0.5</td>
<td>Master's position is scaled by 0.5 to obtain slave's position</td>
</tr>
<tr>
<td>3. Define slave axis trajectory mode</td>
<td>2TJ4 (or 5)</td>
<td>Set slave axis trajectory mode</td>
</tr>
<tr>
<td>4. Define master axis trajectory mode</td>
<td>1TJ1 (or 2)</td>
<td>Set master axis trajectory mode</td>
</tr>
<tr>
<td>5. Issue move commands to master axis</td>
<td>1PA10, 1PR10</td>
<td>Move master to absolute 10 units. Move master by relative 10 units.</td>
</tr>
</tbody>
</table>

*Table 4.1: Slave to a Different Stage Steps*

### 4.2.3 Slave to a Trackball

The following steps may be taken for a slave axis to follow master's velocity. This mode may be chosen exclusively when absolute or relative move commands cannot be issued to the master. In this case, when the user moves the master, the slave axis responds by jogging in proportion to the master's velocity. The slave axis jog velocity update interval and the scaling coefficients can be defined by the user.
Steps | Move Command | Action by Move Command
--- | --- | ---
1. Define master-slave relationship | 2SS4 | Axis #2 is the slave of axis #4
2. Define slave axis jog. Velocity update interval | 2SI100 | Update slave axis jog velocity every 100 milliseconds
3. Define slave axis scaling coefficients | 2SK0.5, 0 | Specify scaling coefficients
4. Define slave axis trajectory mode | 2TJ6 | Set slave axis trajectory mode
5. Move the master axis physically | | |

Table 4.2: Slave to a Trackball Steps

### 4.2.4 Slave to a Joystick

If the slave axis is required to jog based on a DIO bit status (such as through joystick), follow these steps:

Steps | Move Command | Action by Move Command
--- | --- | ---
1. Assign DIO bits for jogging slave axis | 2BP0, 1 | Jog axis #2 in negative direction if DIO bit #0 is low. Jog axis #2 in positive direction if DIO bit #1 is low.
2. Enable DIO bits for jog mode | 2BQ1 | |
3. Define slave axis jog velocity update interval | 2SI100 | Update slave axis jog velocity every 100 milliseconds
4. Define slave axis scaling coefficients | 2SK0.5, 0 | Specify scaling coefficients
5. Define slave axis trajectory mode | 2TJ6 | Set slave axis trajectory mode
6. Change DIO bit value physically | | |

Table 4.3: Slave to a Joystick Steps

Refer to the description of the ASCII commands in Section 3: Remote Mode, for additional description, correct syntax, parameter ranges, etc.

### 4.3 Closed Loop Stepper Motor Positioning

#### 4.3.1 Introduction – Closed Loop Stepper

Most of the electro-mechanical systems are subjected to phenomena such as backlash and friction.
Due to such physical attributes, a significant position error can be generated when systems are moved from one position to another by stepper motors without any closed loop control mechanism. This error can be further accentuated by micro-stepping and non-collection of encoders (necessary to have closed loop control) and motors. ESP series of motion controller's support closed loop positioning of stepper motors to eliminate such errors.

The next subsection details the implementation of this feature in ESP controllers.

4.3.2 Feature Implementation

While closed loop control of stepper motors can be done during tracking as well as regulation, ESP controllers' closed loop stepping feature is effective only during regulation, i.e., desired motion is completed and the motor is holding position. This was done in order to avoid tuning of control gains such as proportional (Kp), integral (Ki), derivative (Kd) gains, etc. Users need to only enable the feature and define two (2) parameters – desired deadband and closed loop update interval.

The following block diagram illustrates this feature. When the desired motion is completed, the controller calculates position error and evaluates if the error is within the user-specified deadband. If it is, no further corrective actions are commanded. On the other hand, if the error is larger than the desired value, the controller starts the closed loop update interval timer and issues commands to make necessary corrections.

It- then, waits for the timer to reset before checking the position error again. This process is repeated until the position error reduces to the desired value (deadband). The corrective actions taken by the controller to reduce positioning error are dependent upon the way in which the stepper motors are controlled: digital (pulse generation) or analog (sinusoidal commutation).

In case of digitally controlled stepper motors, new corrective move commands are internally issued by the controller. In the case of Commutated stepper motors, the electrical angle is adjusted.
Figure 4.5: Block Diagram of Closed Loop Stepper Motor Positioning

The following steps (See Table 4.4) may be followed to setup the closed loop stepper motor positioning.

<table>
<thead>
<tr>
<th>Steps</th>
<th>ASCII Command</th>
<th>Action by Controller</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Set feedback configuration.</td>
<td>1ZB300</td>
<td>Enable encoder feedback and closed loop positioning of stepper motors for axis #1.</td>
</tr>
<tr>
<td>2. Specify deadband value.</td>
<td>1DB1</td>
<td>Set deadband value for axis 31 to 1 encoder count.</td>
</tr>
<tr>
<td>3. Specify closed loop update</td>
<td>1CL50</td>
<td>Set closed loop update interval for axis #1 to 50 milliseconds.</td>
</tr>
</tbody>
</table>

Table 4.4: An Example of Closed Loop Stepper Motor Positioning Setup

Commands related to closed loop stepper positioning are listed in Table 4.5 (refer to Section 3: Remote Mode, for additional details):
<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZB</td>
<td>Set feedback configuration.</td>
</tr>
<tr>
<td>DB</td>
<td>Specify deadband value.</td>
</tr>
<tr>
<td>CL</td>
<td>Specify closed loop update interval.</td>
</tr>
</tbody>
</table>

Table 4.5: Closed Loop Stepper Positioning Commands

4.4 Synchronize Motion to External and Internal Events

4.4.1 Introduction – Synchronize Motion

Certain applications require the use of inputs from an external source to command the motion controller to perform certain tasks. These tasks can be to either initiate motion of desired axes (written in a user's stored program) or to inhibit motion of desired axes or, more simply, to just monitor the motion status of these axes. ESP series of motion controller's address these issues by taking advantage of the digital I/O interface available on the controller.

The 24 digital I/O bits are divided into three (3) ports: A, B, and C (ESP100 and ESP300 motion controllers have access to only ports A and B). Port A covers DIO bits 0 – 7, port B covers bits 8 – 15 and port C covers bits 16 – 23.

The direction of each port can be setup to be either input or output. If a port is configured to be an input, the DIO bits that belong to that port can only report the state – HIGH or LOW logic level – of the corresponding DIO hardware. On the other hand, if the port is configured to be an output, the DIO bits in that port can be used to either set or clear the state of the corresponding hardware. Each DIO bit has a pull-up resistor to +5V. As a result, all bits will be at HIGH logic if not connected to external circuit and configured as input. Furthermore, the direction of all the ports is set to input by default following a controller reset.

The next section details the way in which these DIO bits can be used to initiate the motion of desired axes through stored programs. The subsequent sections outline the way to inhibit the motion of desired axes and to monitor the motion status of these axes using DIO bits.

4.4.2 Using DIO to Execute Stored Programs

ESP series of motion controllers can synchronize the initiation of any motion profile to external events. In order to accomplish this task, users must write their desired motion profile as a stored program and assign this stored program to a desired DIO bit.
The direction of the DIO port bit belongs to must then be set to "input" in order for the controller to detect the external event. Once these preliminaries are completed, the controller will execute the user specified stored program whenever it detects a change in the state – HIGH to LOW logic level – of the corresponding DIO hardware. Please review the examples below for further clarifications.

**Example 1:**

<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>EP ABS0MM</td>
<td>Define stored program called &quot;Abs0mm&quot;</td>
</tr>
<tr>
<td>1MO; 2MO</td>
<td>Turn axes 1,2 ON</td>
</tr>
<tr>
<td>1TJ1; 2TJ1</td>
<td>Set trajectory mode for axes 1,2 to TRAPEZOID</td>
</tr>
<tr>
<td>1PA0; 2PA0</td>
<td>Move axes 1,2 to absolute 0 units</td>
</tr>
<tr>
<td>1WS100; 2WS100</td>
<td>Wait for axes 1,2 motion to complete</td>
</tr>
<tr>
<td>QP</td>
<td>End of program</td>
</tr>
<tr>
<td>0BG ABS0MM</td>
<td>Assign DIO #0 to run stored program called &quot;Abs0mm&quot;</td>
</tr>
<tr>
<td>BO 04H</td>
<td>04H = (0100) Binary</td>
</tr>
<tr>
<td></td>
<td>Set DIO ports A, B to input and port C to output</td>
</tr>
<tr>
<td></td>
<td>i.e., set bits 0 – 15 to input and 16 – 23 to output</td>
</tr>
</tbody>
</table>

After the above commands are sent to the controller, the controller will execute the stored program called "Abs0mm" when DIO bit #0 changes its state from HIGH to LOW logic level.

**Example 2:**

<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>EP CYC2MM</td>
<td>Define stored program called &quot;Cyc2mm&quot;</td>
</tr>
<tr>
<td>1MO; 2MO</td>
<td>Turn axes 1,2 ON</td>
</tr>
<tr>
<td>1TJ1; 2TJ1</td>
<td>Set trajectory mode for axes 1,2 to TRAPEZOID</td>
</tr>
<tr>
<td>1PA0; 2PA0</td>
<td>Move axes 1,2 to absolute 0 units</td>
</tr>
<tr>
<td>1WS100; 2WS100</td>
<td>Wait for axes 1,2 motion to complete</td>
</tr>
<tr>
<td>DL LOOP</td>
<td>Define a label called &quot;LOOP&quot;</td>
</tr>
<tr>
<td>1PR2; 2PR2</td>
<td>Move axes 1,2 by relative 2 units</td>
</tr>
<tr>
<td>1WS100; 2WS100</td>
<td>Wait for axes 1,2 motion to complete</td>
</tr>
<tr>
<td>1PR-2; 2PR-2</td>
<td>Move axes 1,2 by relative –2 units</td>
</tr>
<tr>
<td>1WS100; 2WS100</td>
<td>Wait for axes 1,2 motion to complete</td>
</tr>
<tr>
<td>JL LOOP,10</td>
<td>Jump to label called &quot;LOOP&quot; 10 times</td>
</tr>
<tr>
<td>QP</td>
<td>End of program</td>
</tr>
<tr>
<td>1BGCYC2MM</td>
<td>Assign DIO #1 to run stored program called &quot;Cyc2mm&quot;</td>
</tr>
<tr>
<td>BO 04H</td>
<td>04H = (0100) Binary</td>
</tr>
<tr>
<td></td>
<td>Set DIO ports A, B to input and port C to output</td>
</tr>
<tr>
<td></td>
<td>i.e., set bits 0 – 15 to input and 16 – 23 to output</td>
</tr>
</tbody>
</table>

After the above commands are sent to the controller, the controller will execute "Cyc2mm" stored program when DIO bit #1 changes its state from HIGH to LOW logic level.
4.4.3 Using DIO to Inhibit Motion

ESP series of motion controllers can inhibit the motion of any axis in response to external events. In order to accomplish this task, users must define the DIO bit to be employed to inhibit the motion of a desired axis and the logic state in which that bit should be in order to inhibit motion. Once this done, the feature has to be enabled. Furthermore, the direction of the DIO port this DIO bit belongs to must be set to "input" in order for the controller to detect the external event.

At this point, if the selected axis is already in motion, and DIO bit is asserted, E-stop is executed per E-stop configuration (Refer "ZE" command for further details). If the axis is not moving, any new move commands are refused as long as the DIO bit is asserted. In either case, "AXIS-XX DIGITAL I/O INTERLOCK DETECTED" error is generated, where XX is the axis whose motion is inhibited through DIO. Please review the example below for further clarifications.

Example 3:

2BK1,1 | Use DIO bit #1 to inhibit motion of axis #2. This DIO bit should be HIGH when axis #2 motion is inhibited
2BL1 | Enable inhibition of motion using DIO bits for axis #2
BO 04H | 04H = (0100)Binary
        | Set DIO ports A,B to input and port C to output
        | i.e., set bits 0 – 15 to input and 16 – 23 to output

After the above commands are sent to the controller, the controller will inhibit the motion of axis #2 when DIO bit is at a HIGH logical level, and generate appropriate error message.

4.4.4 Using DIO to Monitor Motion Status

User's applications can monitor motion status – desired axis is in motion or standstill – through ESP motion controller's DIO. This status bit can in turn be used to drive external processes such as turning on/off a mechanical brake, for instance. In order to accomplish this task, users must define the DIO bit to be employed to monitor the motion status of a desired axis and the logic state in which that bit should be in when the axis is not in motion. Once this is done, the feature has to be enabled. Furthermore, the direction of the DIO port this DIO bit belongs to must be set to "output" in order for the controller to report the motion status.

At this point, if the selected axis is not in motion, the DIO bit changes its state to the level specified as described earlier. Please review the example below for further clarifications.
Example 3:

2BM9,1 | Use DIO bit #9 to indicate motion status of axis #2. This DIO bit will be set to HIGH when axis #2 is not in motion

2BN1 | Enable notification of motion status using DIO for axis #2

BO 06H | 06H = (0110) Binary
       | Set DIO port A, to input and ports B, C to output
       | i.e., set bits 0 – 7 to input and 8 – 23 to output

After the above commands are sent to the controller, the controller will set DIO bit #9 to a HIGH logical level when axis #2 is not in motion.

Commands related to utilizing DIO for initiating/inhibiting motion of desired axis and notifying motion status of these axes are listed in the table below (refer to Section 3: Remote Mode, for additional details):

<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>BG</td>
<td>Assign DIO bits to execute stored programs</td>
</tr>
<tr>
<td>BK</td>
<td>Assign DIO bits to inhibit motion</td>
</tr>
<tr>
<td>BL</td>
<td>Enable DIO bits to inhibit motion</td>
</tr>
<tr>
<td>BM</td>
<td>Assign DIO bits to notify motion status</td>
</tr>
<tr>
<td>BN</td>
<td>Enable DIO bits to notify motion status</td>
</tr>
<tr>
<td>BO</td>
<td>Set DIO port A, B, C direction</td>
</tr>
</tbody>
</table>

*Table 4.6: Commands to Synchronize Motion to External Events*
5.1 Motion Systems

A schematic of a typical motion control system is shown in Figure 5.1.

*Figure 5.1: Typical Motion Control Systems*

Its major components are:

**Controller**
An electronic device that receives motion commands from an operator directly or via a computer, verifies the real motion device position and generates the necessary control signals.
**Driver**

An electronic device that converts the control signals to the correct format and power needed to drive the motors.

**Motion Device**

An electro-mechanical device that can move a load with the necessary specifications.

**Cables**

Needed to interconnect the other motion control components.

If the user is like most motion control users, they started by selecting a motion device that matches certain specifications needed for an application. Next, the user should choose a controller that can satisfy the motion characteristics required. The changes are that the user is less interested in how the components look or what their individual specs are, but want to be sure that together they perform reliably according to their needs.

We mentioned this to make a point. A component is only as good as the system lets (or helps) it to be.

For this reason, when discussing a particular system performance specification, we will also mention which components affect performance the most and, if appropriate, which components improve it.

## 5.2 Specification Definitions

People mean different things when referring to the same parameter name. To establish some common ground for motion control terminology, here are some general guidelines for the interpretation of motion control terms and specifications.

- As mentioned earlier, most motion control performance specifications should be considered system specifications.
- When not otherwise specified, all error-related specifications refer to the position error.
- The servo loop feedback is position-based. All other velocity, acceleration, error, etc. parameters are derived from the position feedback and the internal clock.
- To measure the absolute position, we need a reference, a measuring device, that is significantly more accurate than the device tested. In our case, dealing with fractions of microns (0.1 µm and less), even a standard laser interferometer becomes unsatisfactory.
For this reason, all factory measurements are made using a number of high precision interferometers, most of them connected to a computerized test station.

- To avoid unnecessary confusion and to more easily understand and troubleshoot a problem, special attention must be paid to avoid bundling discrete errors in one general term. Depending on the application, some discrete errors are not significant. Grouping them in one general parameter will only complicate the understanding of the system performance in certain applications.

### 5.2.1 Following Error

The Following Error is not a specifications parameter but, because it is at the heart of the servo algorithm calculations and of other parameter definitions, it deserves our attention.

As will be described later in Section 5.3: Control Loops, a major part of the servo controller's task is to make sure that the actual motion device follows as close as possible an ideal trajectory in time. The user can imagine having an imaginary (ideal) motion device that executes exactly the motion profile they are requesting. In reality, the real motion device will find itself deviating from this ideal trajectory. Since most of the time the real motion device is trailing the ideal one, the instantaneous error is called Following Error.

To summarize, the Following Error is the instantaneous difference between the actual position as reported by the position feedback device and the ideal position, as seen by the controller. A negative following error means that the load is trailing the ideal motion device.

### 5.2.2 Error

Error has the same definition as the Following Error with the exception that the ideal trajectory is not compared to the position feedback device (encoder) but to an external precision-measuring device.

In other words, the Following Error is the instantaneous error perceived by the controller while the Error is the one perceived by the user.

### 5.2.3 Accuracy

The accuracy of a system is probably the most common parameter users want to know. Unfortunately, due to its perceived simplicity, it is also the easiest to misinterpret.
The Accuracy is a static measure of a point-to-point positioning error. Starting from a reference point, the user should command the controller to move a certain distance. When the motion is completed, the user should measure the actual distance traveled with an external precision-measuring device. The difference (the Error) represents the positioning Accuracy for that particular motion.

Because every application is different, the user needs to know the errors for all possible motions. Since this is practically impossible, an acceptable compromise is to perform the following test. Starting from one end of travel, the user can make small incremental moves and at every stop, the user should record the position Error. The user performs this operation for the entire nominal travel range. When finished, the Error data is plotted on a graph similar to Figure 5.2.

![Figure 5.2: Position Error Test](image)

The difference between the highest and the lowest points on the graph is the maximum possible Error that the motion device can have. This worst-case number is reported as the positioning Accuracy. It guaranties the user that for any application, the positioning error will not be greater than this value.

### 5.2.4 Local Accuracy

For some applications, it is important to know not just the positioning Accuracy over the entire travel but also over a small distance. To illustrate this case, Figure 5.3a and Figure 5.3b shows two extreme cases.
Both error plots from Figure 5.3a and Figure 5.3b have a similar maximum Error. But, if the user compares the maximum Error for small distances, the system in Figure 5.3b shows significantly larger values.

For applications requiring high accuracy for small motions, the system in Figure 5.3a is definitely preferred.

"Local Error" is a relative term that depends on the application; usually no Local Error value is given with the system specifications. The user should study the error plot supplied with the motion device and determine the approximate maximum Local Error for the specific application.
5.2.5 Resolution
Resolution is the smallest motion that the controller attempts to make. For all DC motor and most all standard stepper motor driven stages supported by the ESP3000, this is also the resolution of the encoder. Keeping in mind that the servo loop is a digital loop, the Resolution can be also viewed as the smallest position increment that the controller can handle.

5.2.6 Minimum Incremental Motion
The Minimum Incremental Motion is the smallest motion that a device can reliably make, measured with an external precision-measuring device. The controller can, for instance, execute a motion equal to the Resolution (one encoder count) but in reality, the load may not move at all. The cause for this is in the mechanics.

Figure 5.4: Effect of Stiction and Elasticity on Small Motions

Figure 5.4 shows how excessive stiction and elasticity between the encoder and the load can cause the motion device to deviate from ideal motion when executing small motions.

The effect of these two factors has a random nature. Sometimes, for a small motion step of the motor, the load may not move at all. Other times, the accumulated energy in the spring will cause the load to jump a larger distance. The error plot will be similar to Figure 5.5.

Figure 5.5: Error Plot

Once the Maximum Incremental Motion is defined, the next task is to quantify it. This more difficult for two reasons: one is its random nature and the other is in defining what a completed motion represents.
Assume that the user has a motion device with a 1 µm resolution. If every time the user commands a 1 µm motion the measured error is never greater than 2%, the user will probably be very satisfied and declare that the Minimum Incremental Motion is better than 1 µm.

If, on the other hand, the measured motion is sometimes as small as 0.1 µm (a 90% error), the user could not say that 1 µm is a reliable motion step. The difficulty is in drawing the line between acceptable and unacceptable errors when performing a small motion step. The most common value for the maximum acceptable error for small motions is 20%, but each application ultimately has its own standards.

One way to solve the problem is to take a large number of measurements (a few hundred at minimum) for each motion step size and present them in a format that an operator can use to determine the Minimum Incremental Motion by its own standards.

![Figure 5.6: Error vs. Motion Step Size](image-url)

Figure 5.6 shows an example of such a plot. The graph represents the maximum relative error for different motion step sizes. In this example, the Minimum Incremental Motion that can be reliably performed with a maximum of 20% error is one equivalent to 4 resolution (encoder) increments.

5.2.7 **Repeatability**

Repeatability is the positioning variation when executing the same motion profile. Assuming that the user has a motion sequence that stops at a number of different locations, the Repeatability is the maximum position variation of all targets when the same motion sequence is repeated a large number of times. It is a relative, not absolute, error between identical motions.
5.2.8 **Backlash and Hysteresis**

Hysteresis and Backlash contribute to error caused by approaching a point from a different direction.

**Backlash**

The maximum magnitude of an input that produces no measurable output upon reversing direction. It can be a result of insufficient axial preloads or poor meshing between drivetrain components, i.e., gear teeth in a gear-coupled drivetrain. Backlash is relatively repeatable and can be compensated for by capable controllers.

**Hysteresis**

The difference in the absolute position of an object for a given commanded input when approached from opposite directions (Figure 2). It is due to elastic forces accumulated in various drivetrain components (leadscrew wind-up, for instance). This is often confused with backlash which can be characterized and compensated for by capable controllers.

All parameters discussed up to now that involve the positioning Error assumed that all motions were performed in the same direction. If the user tries to measure the positioning error of a certain target (destination), approaching the destination from different directions could make a significant difference.

In generating the plot in **Figure 5.2** we said that the motion device will make a large number of incremental moves, from one end of travel to the other. If the user commands the motion device to move back and stop at the same locations to take a position error measurement, the user would expect to get an identical plot, superimposed on the first one. In reality, the result could be similar to **Figure 5.7**.

![Figure 5.7: Hysteresis Plot](image)

The error plot in reverse direction is identical with the first one but seems to be shifted down by a constant error. This constant error is the Hysteresis of the system.
To justify a little more why we call this Hysteresis, let's do the same graph in a different format (Figure 5.8). Plotting the real versus the ideal position will give the user a familiar hysteresis shape.

5.2.9 Pitch, Roll and Yaw

These are the most common angular error parameters for linear translation stages. They are pure mechanical errors and represent the rotational error of a stage carriage around the three axes. A perfect stage should not rotate around any of the axes, thus the Pitch, Roll and Yaw should be zero.

The commonly used representation of the three errors is shown in Figure 5.9. Pitch is rotation around the Y axis, Roll is rotation around the X axis, and Yaw is rotation around the Z axis.

The problem with this definition is that, through correct, it is difficult to remember. A more graphical representation is presented in Figure 5.10. Imagine a tiny carriage driven by a giant lead screw. When the carriage rolls sideways on the lead screw pitch, we call that Pitch. And, when the carriage deviates left or right from the straight direction (on an imaginary Y trajectory), we call it Yaw.
5.2.10 Wobble

This parameter applies only to rotary stages. It represents the deviation of the axis of rotation during motion. A simple form of Wobble is a constant one, where the rotating axis generates a circle (Figure 5.11).

![Wobble Generates a Circle]

A real rotary stage may have a more complex Wobble, where the axis of rotation follows a complicated trajectory. This type of error is caused by the imperfections of the stage machining and/or ball bearings.

5.2.11 Load Capacity

There are two types of loads that are of interest for motion control applications: static and dynamic loads.

The static Load Capacity represents the amount of load that can be placed on a stage without damaging or excessively deforming it. Determining the Load Capacity of a stage for a particular application is more complicated than it may first appear. The stage orientation and the distance from the load to the carriage play a significant role. For a detailed description on how to calculate the static Load Capacity, please consult the motion control catalog tutorial section.

The dynamic Load Capacity refers to the motor's effort to move the load. The first parameter to determine is how much load the stage can push or pull. In some cases the two values could be different due to internal mechanical construction.

The second type of dynamic Load Capacity refers to the maximum load that the stage could move with the nominal acceleration. This parameter is more difficult to specify because it involves defining an acceptable following error during acceleration.
5.2.12 **Maximum Velocity**

The Maximum Velocity that could be used in a motion control system is determined by both motion device and driver. Usually it represents a lower value than the motor or driver is capable of. In most cases, including the ESP300, the default Maximum Velocity should be increased. The hardware and firmware are tuned for a particular maximum velocity that cannot be exceeded.

5.2.13 **Minimum Velocity**

The Minimum Velocity usable with a motion device depends on the motion control system but also on the acceptable velocity regulation. First, the controller sets the slowest rate of motion increments it can make. The encoder resolution determines the motion increment size and then, the application sets a limit on the velocity ripple.

To illustrate this, take the example of a linear stage with a resolution of 0.1 µm. If the user sets the velocity to 0.5 µm/sec, the stage will move 5 encoder counts on one second.

But, a properly tuned servo loop could move the stage 0.1 µm in about 20 ms. The position and velocity plots are illustrated in **Figure 5.12**.

![Figure 5.12: Position, Velocity and Average Velocity](image)

The average velocity is low but the velocity ripple is very high. Depending on the application, this may be acceptable or not. With increasing velocity, the ripple decreases and the velocity becomes smoother.

This example is even more true in the case of a stepper motor driven stage. the typical noise comes from a very fast transition from one step position to another. The velocity ripple in that case is significantly higher.
In the case of a DC motor, adjusting the PID parameters to get a softer response will reduce the velocity ripple but care must be taken not to negatively affect other desirable motion characteristics.

5.2.14 Velocity Regulation

In some applications, for example scanning, it is important for the velocity to be very constant. In reality, there are a number of factors besides the controller that affect the velocity.

As described in the Minimum Velocity definition, the speed plays a significant role in the amount of ripple generated, especially at low values. Even if the controller does a perfect job by running with zero following error, imperfections in the mechanics (friction, variation, transmission ripple, etc.) will generate some velocity ripple that can be translated to Velocity Regulation problems.

Depending on the specific application, one motor technology can be preferred over the other.

As far as the controller is concerned, the stepper motor version is the ideal case for a good average Velocity Regulation because the motor inherently follows precisely the desired trajectory. The only problem is the ripple caused by the actual stepping process.

The best a DC motor controller can do is to approach the stepper motor's performance in average Velocity regulation, but it has the advantage of significantly reduced velocity ripple, inherently and through PID tuning. If the DC motor implements a velocity closed loop through the use of a tachometer, the overall servo performance increases and one of the biggest beneficiary is the Velocity Regulation.

5.2.15 Maximum Acceleration

The maximum Acceleration is a complex parameter that depends as much on the motion control system as it does on application requirements. For stepper motors, the main concern is not to loose steps (or synchronization) during the acceleration. Besides the motor and driver performance, the load inertia plays a significant role.

For DC motor systems the situation is different. If the size of the following error is of no concern during the acceleration, high Maximum Acceleration values can be entered. The motion device will move with the highest natural acceleration it can (determined by the motor, driver, load inertia, etc) and the errors will consist of just a temporary larger following error and a velocity overshoot.

In any case, special consideration should be given when setting the acceleration. Through in most cases no harm will be done in setting a high acceleration value, avoid doing so if the application does not
require it. The driver, motor, motion device and load undergo maximum stress during high acceleration.

### 5.2.16 Combined Parameters

Very often a user looks at an application and concludes that they need a certain overall accuracy. This usually means that the user is combining a number of individual terms (error parameters) into a single one. Some of this combined parameters even have their own name, even though not all people mean the same thing by them: Absolute Accuracy, Bi-directional Repeatability, etc. The problem with these generalizations is that, unless the term is well defined and the testing closely simulates the application, the numbers could be of little value.

The best approach is to carefully study the application, extract from the specification sheet the applicable discrete error parameters and combine them (usually add them) to get the worst-case general error applicable to the specific case. This method not only offers a more accurate value but also gives a better understanding of the motion control system performance and helps pinpoint problems.

Also, due to integrated nature of the ESP300 system, many basic errors can be significantly corrected by another component of the loop. Backlash, Accuracy and Velocity Regulation are just a few examples where the controller can improve motion device performance.

### 5.3 Control Loops

When talking about motion control systems, one of the most important questions is the type of servo loop implemented. The first major distinction is between open and closed loops. Of course, this is of particular interest when driving stepper motors. As far as the DC servo loops, the PID type is by far the most widely used.

The ESP300 implements a PID servo loop with velocity and acceleration feed-forward.

The basic diagram of a servo loop is shown in (Figure 5.13). Besides the command interpreter, the main two parts of a motion controller are the trajectory generator and the servo controller. The first generates the desired trajectory and the second one controls the motor to follow it as closely as possible.
5.3.1 PID Servo Loops

The PID term comes from the proportional, integral and derivative gain factors that are at the basis of the control loop calculation. The common equation given for it is:

\[ K_p \cdot e + K_i \int e \, dt + K_d \cdot \frac{de}{dt} \]

where:
- \( K_p \) = Proportional gain factor
- \( K_i \) = integral gain factor
- \( K_d \) = derivative gain factor
- \( e \) = instantaneous following factor

The program for most users is to get a feeling for this formula, especially when trying to tune the PID loop. Tuning the PID means changing its three gain factors to obtain a certain system response, task quite difficult to achieve without some understanding of its behavior of servo loops.

The following paragraphs explain the PID components and their operation.

**P Loop**

Lets start with the simplest type of closed loop, the P (proportional) loop. The diagram in (Figure 5.14) shows its configuration.

Every servo cycle, the actual position, as reported by the encoder, is compared to the desired position generated by the trajectory generator. The difference \( e \) is the positioning error (the following error). Amplifying it (multiplying it by \( K_p \)) generates a control signal that, converted to an analog signal, is sent to the motor driver.

There are a few conclusions that could be drawn from studying this circuit:
- The motor control signal, thus the motor voltage, is proportional to the following error.
- There must be a following error in order to drive the motor.
• Higher velocities need higher motor voltages and thus higher following errors.
• At stop, small errors cannot be corrected if they don't generate enough voltage for the motor to overcome friction and stiction.
• Increasing the $K_p$ gain reduces the necessary following error but too much of it will generate instabilities and oscillations.

**Figure 5.14: P Loop**

**PI Loop**

To eliminate the error at stop and during long constant velocity motions (usually called steady-state error), an integral term can be added to the loop. This term integrates (adds) the error every servo cycle and the value, multiplied by the $K_i$ gain factor, is added to the control signal (**Figure 5.15**).

![Diagram of PI Loop](image)

**Figure 5.15: PI Loop**

The result is that the integral term will increase until it drives the motor by itself, reducing the following error to zero. At stop, this has the very desirable effect of driving the positioning error to zero. During a long constant velocity motion it also brings the following error to zero, an important feature for some applications.

Unfortunately, the integral term also has a negative side, a severe destabilizing effect on the servo loop. In the real world, a simple PI Loop is usually undesirable.
**PID Loop**

The third term of the PID Loop is the derivative term. It is defined as the difference between the following error of the current servo cycle and of the previous one. If the following error does not change, the derivative term is zero.

(Figure 5.16) shows the PID servo loop diagram. The derivative term is added to the proportional and integral one. All three process the following error in their own way and, added together, form the control signal.

The derivative term adds a damping effect that prevents oscillations and position overshoot.

![PID Loop Diagram](image)

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**5.3.2 Feed-Forward Loops**

As described in the previous paragraph, the main driving force in a PID loop is the proportional term. The other two correct static and dynamic errors associated with the closed loop.

Taking a closer look at the desired and actual motion parameters and at the characteristics of the DC motors, some interesting observations can be made. For a constant load, the velocity of a DC motor is approximately proportional with the voltage. This means that for a trapezoidal velocity profile, for instance, the motor voltage will have also a trapezoidal shape (Figure 5.17).

The second observation is that the desired velocity is calculated by the trajectory generator and is known ahead of time. The obvious conclusion is that we could take this velocity information, scale it by $K_{vff}$ factor and feed it to the motor driver. If the scaling is done properly, the right amount of voltage is sent to the motor to get the desired velocities, without the need for a closed loop.
Because the signal is derived from the velocity profile and it is being sent directly to motor driver, the procedure is called velocity feed-forward.

Of course, this looks like an open loop, and it is (Figure 5.18). But, adding this signal to the closed loop has the effect of significantly reducing the "work" the PID has to do, thus reducing the overall following error. The PID now has to correct only for the residual error left over by the feed-forward signal.

There is another special note that has to be made about the feed-forward method. The velocity is approximately proportional to the voltage and only for constant loads, but this true only if the driver is a simple voltage amplifier or current (torque) driver. A special case is when the driver has its own velocity feedback loop from a tachometer (Figure 5.19).

The tachometer is a device that outputs a voltage proportional with the velocity. Using its signal, the driver can maintain the velocity to be proportional to the control signal.
If such a driver is used with a velocity feed-forward algorithm, by properly tuning the $K_{vff}$ parameter, the feed-forward signal could perform an excellent job, leaving very little for the PID loop to do.

![Tachometer-Driven PIDF Loop](image)

**Figure 5.19: Tachometer-Driven PIDF Loop**

## 5.4 Motion Profiles

When talking about motion commands we refer to certain strings sent to a motion controller that will initiate a certain action, usually a motion. There are a number of common motion commands that are identified by name. The following paragraphs describe a few of them.

### 5.4.1 Move

A move is a point-to-point motion. On execution of a move motion command, the motion device moves from the current position to a desired destination. The destination can be specified either as an absolute position or as a relative distance from the current position.

When executing a move command, the motion device will accelerate until the velocity reaches a pre-defined value. Then at the proper time, it will start decelerating so that when the motor stops, the device is at the correct position. The velocity plot of this type of motion will have a trapezoidal shape (**Figure 5.20**). For this reason, this type of motion is called a trapezoidal motion.
The position and acceleration profiles relative to the velocity are shown in (Figure 5.21).

Besides the destination, the acceleration and the velocity of the motion (the constant portion of it) can be set by the user before every move command. Advanced controllers like the ESP300 allow the user to change them even during the motion.

### 5.4.2 Jog

When setting up an application, it is often necessary to move stages manually while observing motion. The easy way to do this without resorting to specialized input devices such as joysticks or track-wheels is to use simple push-button switches. This type of motion is called a jog. When a jog button is pressed the selected axis starts moving with a pre-defined velocity. The motion continues only while the button is pressed and stops immediately after its release.

The ESP300 offers two jog speeds. Both high speed and low speed are user programmable. The jog acceleration is also ten times smaller than the programmed maximum acceleration values.
5.4.3 Home Search

Home search is a specific motion routine that is useful for most types of applications. Its goal is to find a specific point in travel relative to the mounting base of the motion device very accurately and repeatable. The need for this absolute reference point is twofold. First, in many applications it is important to know the exact position in space, even after a power-off cycle. Secondly, to protect the motion device from hitting a travel obstruction set by the application (or its own travel limits), the controller uses programmable software limits. To be efficient though, the software limits must be placed accurately in space before running the application.

To achieve this precise position referencing, the ESP300 motion control system executes a unique sequence of moves.

First, let's look at the hardware required to determine the position of a motion device. The most common (and the one supported by the ESP300) are incremental encoders. By definition, these are encoders that can tell only relative moves, not absolute position. The controller keeps track of position by incrementing or decrementing a dedicated counter according to the information received from the encoder. Since there is no absolute position information, position "zero" is where the controller was powered on (and the position counter reset).

To determine an absolute position, the controller must find a "switch" that is unique to the entire travel, called a home switch or origin switch. An important requisition is that this switch must be located with the same accuracy as the encoder pulses.

If the motion device is using a linear scale as position encoder, the home switch is usually placed on the same scale and read with the same accuracy.

If, on the other hand, a rotary encoder is used, the problem becomes more complicated. To have the same accuracy, a mark on the encoder disk could be used (called index pulse) but because it repeats itself every revolution, it does not define a unique point over the entire travel.

An origin switch, on the other hand, placed in the travel of the motion device is unique but not accurate (repeatable) enough. The solution is to use both, following a search algorithm.

A home switch (Figure 5.22) separates the entire travel in two areas: one for which it has a high level and one for which is low. The most important part of it is the transition between the two areas. Also, looking at the origin switch level, the controller knows on which side of the transition it currently is and which way to move to find it.
The task of the home search routine is to identify one unique index pulse as the absolute position reference. This is done by the first finding the home switch transition and then the very first index pulse (Figure 5.23).

So far, we can label the two motion segments D and E. During D the controller is looking for the origin switch transition and during E for the index pulse. To guarantee the best accuracy possible, both D and E segments are performed at a very low speed and without a stop in-between. Also, during E the display update is suppressed to eliminate any unnecessary overhead.

The routine described above could work but has one problem. Using the low speeds, it could take a very long time if the motion device happens to start from the opposite end of travel. To speed things up, we can have the motion device move fast in the vicinity of the home switch and then perform the two slow motions, D and E. The new sequence is shown in (Figure 5.24).
Motion segment B is performed at high speed, with the pre-programmed home search speed. When the home switch transition is encountered, the motion device stops (with an overshoot), reverses direction and looks for it again, this time with half the velocity (segment C).

Once found, it stops again with an overshoot, reverses direction and executes D and E with one tenth of the programmed home search speed.

In the case when the motion device starts from the other side of the home switch transition, the routine will look like (Figure 5.25).

The ESP300 moves at high speed up to the home switch transition (segment A) and then executes B, C, D and E.

All home search routines are run so that the last segment, E, is performed in the position direction of travel.

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**CAUTION**

The home search routine is very important for the positioning accuracy of the entire system and it requires full attention from the controller. Do not interrupt or send other commands during its execution, unless it is for emergency purposes.

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**5.5 Encoder**

PID closed-loop motion control requires a position sensor. The most widely used technology by far are incremental encoders.

The main characteristic of an incremental encoder is that it has a 2-bit gray code output, more commonly known as quadrature output (Figure 5.26).
The output has two signals, commonly known as channel A and channel B. Some encoders have analog outputs (sine – cosine signals) but the digital type are more widely used. Both channels have a 50% duty cycle and are out of phase by 90°. Using both phases and an appropriate decoder, a motion controller can identify four different areas within one encoder cycle. This type of decoding is called X4 (or quadrature decoding), meaning that the encoder resolution is multiplied by 4. For example, an encoder with 10 µm phase period can offer a 2.5 µm resolution when used with a X4 type decoder.

Physically, an encoder has two parts: a scale and a read head. The scale is an array of precision placed marks that are read by the head. The most commonly used encoders, optical encoders, have a scale made out of a series of transparent and opaque lines placed on a glass substrate or etched in a thin metal sheet (Figure 5.27).
The encoder read head has three major components: a light source, a mask and a detector (Figure 5.28). The mask is a small scale-like piece, having identically spaced transparent and opaque lines.

Combining the scale with the read head, when one moves relative to another, the light will pass through where the transparent areas line up or blocked when they do not line up (Figure 5.29).

The detector signal is similar to a sine wave. Converting it to a digital waveform, the user will get the desired encoder signal. But, this is only one phase, only half of the signal needed to get position information. The second channel is obtained the same way but from a mask that is placed 90% out of phase relative to the first one (Figure 5.30).
There are two basic types of encoders: linear and rotary. The linear encoders, also called linear scales, are used to measure linear motion directly. This means that the physical resolution of the scale will be the actual positioning resolution. This is their main drawback since technological limitations prevent them from having better resolutions than a few microns. To get higher resolutions in linear scales, a special delicate circuitry must be added, called scale interpolator. Other technologies like interferometry or halography can be used but they are significantly more expensive and need more space.

The most popular encoders are rotary. Using gear reduction between the encoder and the load, significant resolution increases can be obtained at low cost. But the price paid for this added resolution is higher backlash.

In some cases, rotary encoders offer high resolution without the backlash penalty. For instance, a linear translation stage with a rotary encoder on the lead screw can easily achieve 1 µm resolution with negligible backlash.

**NOTE**

For rotary stages, a rotary encoder measures the output angle directly. In this case, the encoder placed on the rotating platform has the same advantages and disadvantages of the linear scales.
There are many different types of electrical motors, each one being best suitable for certain kind of applications. The ESP300 supports two of the most popular types: *stepper motors* and *DC motors*.

Other technologies like interferometry or halography can be used but they are significantly more expansive and need more space.

Another way to characterize motors is by the type of motion they provide. The most common ones are rotary but in some applications, linear motors are preferred.

### 5.6.1 Stepper Motors

The main characteristic of a stepper motor is that each motion cycle has a number of stable position. This means that, if current is applied to one of its windings (called phases), the rotor will try to find one of these stable points and stay there. In order to make a motion, another phase must be energized which, in turn, will find a new stable point, thus making a small incremental move – a step.

(Figure 5.31) shows the basics of a stepper motor. When the winding is energized, the magnetic flux will turn the rotor until the rotor and stator teeth line up. This true of the rotor core is made out of soft iron. Regardless of the current polarity, the stator will try to pull-in the closest rotor tooth.

![Figure 5.31: Stepper Motor Operation](image)

But, if the rotor is a permanent magnet, depending on the current polarity, the stator will pull or push the rotor tooth. This is a major distinction between two different stepper motor technologies: variable reluctance and permanent magnet motors. The variable reluctance motors are usually small, low cost, large step angle stepper motors. The permanent magnet technology is used for larger, high precision motors.
The stepper motor advantages to a new stable position by means of several stator phases that have the teeth slightly offset from each other. To illustrate this, (Figure 5.32) shows a stepper motor with four phases and, to make it easier to follow, it is drawn in a linear fashion (as a linear stepper motor).

![Figure 5.32: Four-Phase Stepper Motor](image)

The four phases, from A to D, are energized one at a time (phase A is shown twice). The rotor teeth line up with the first energized phase, A. If the current to phase A is turned off and B is energized next, the closest rotor tooth to phase B will be pulled in and the more moves one step forward.

If, on the other hand, the next energized phase is D, the closest rotor tooth is in the opposite direction, thus making the motor to move in reverse.

Phase C cannot be energized immediately after A because it is exactly between two teeth, so the direction of movement is indeterminate.

To move in one direction, the current in the four phases must have the following timing diagram (Figure 5.33).

![Figure 5.33: Phase Timing Diagram](image)

One phase is energized after another, in a sequence. To advance one full rotor tooth the user needs to make a complete cycle of four steps. To make a full revolution, the user needs a number of steps four times the number of rotor teeth. These steps are called full steps. They are the largest motion increment the stepper motor can make. Running the motor in this mode is called full-stepping.

What happens if the user energizes two neighboring phases simultaneously (Figure 5.34).
Both phases will pull equally on the motor will move the rotor only half of the full step. If the phases are always energized two at a time, the motor still makes full steps. But, if the user alternates one and two phases being activated simultaneously, the result is that the motor will move only half a step at a time. This method of driving a stepper motor is called half-stepping. The advantage is that we can get double the resolution from the same motor with very little effect on the driver’s side. The timing diagram for half-stepping is shown in (Figure 5.35).

Now, what happens if we energize the same two phases simultaneously but with different currents? For example, lets say that phase A has the full current and phase B only half. This means that phase A will pull the rotor tooth twice as strongly as B does. The rotor tooth will stop closer to A, somewhere between the full step and the half step positions (Figure 5.36).
The conclusion is that, varying the ratio between the currents of the two phases, the user can position the rotor anywhere between the two full step locations. To do so, the user needs to drive the motor with analog signals, similar to (Figure 5.37).

![Figure 5.37: Timing Diagram, Continuous Motion (Ideal)](image)

But a stepper motor should be stepping. The controller needs to move it in certain known increments. The solution is to take the half-sine waves and digitize them so that for every step command, the currents change to some new pre-defined levels, causing the motor to advance one small step (Figure 5.38).

![Figure 5.38: Timing Diagram, Mini-Stepping](image)

This driving method is called mini-stepping or micro-stepping. For each step command, the motor will move only a fraction of the full-step. Motion steps are smaller so the motion resolution is increased and the motion ripple (noise) is decreased.

However, mini-stepping comes at a price. First, the driver electronics are significantly more complicated. Secondly, the holding torque or one step is reduced by the mini-stepping factor. In other words, for a x10 mini-stepping, it takes only 1/10 of the full-step holding torque to cause the motor to have a positioning error equivalent to one step (a mini-step).

To clarify a little what this means, let's take a look at the torque produced by a stepper motor. For simplicity, let's consider the case of a single phase being energized (Figure 5.39).

Once the closest rotor tooth has been pulled in, assuming that the user doesn't have any external load, the motor does not develop any torque. This is a stable point.
If external forces try to move the rotor (Figure 5.40), the magnetic flux will fight back. The more teeth misalignment exists, the larger the generated torque.

![Figure 5.39: Single Phase Energization](image)

If the misalignment keeps increasing, at some point, the torque peaks and then starts diminishing again such that, when the stator is exactly between the rotor teeth, the torque becomes zero again (Figure 5.41).

This is an unstable point and any misalignment or external force will cause the motor to move one way or another. Jumping from one stable point to another is called missing steps, one of the most critiqued characteristics of stepper motors.

The torque diagram versus teeth misalignment is shown in (Figure 5.42). The maximum torque is obtained at one quarter of the tooth spacing, which is equivalent to one full step.

![Figure 5.41: Unstable Point](image)

![Figure 5.42: Torque and Tooth Alignment](image)
This torque diagram is accurate even when the motor is driven with half-, mini-, or micro-steps. The maximum torque is still one full step away from the stable (desired) position.

5.6.1.1 Stepper Motor Types

To simplify the explanation, the examples above are based on a variable reluctance stepper motor. The main characteristic of these motors is that their rotors have no permanent magnets. The variable reluctance motors are easy and inexpensive to make but suffer from higher inefficiency and require a unipolar driver. They are used in low cost, low power applications.

Permanent magnet motors have each "tooth" made out of a permanent magnet, each one having alternate polarity. They are more efficient but the step size is very large due to the physical size of the pole "teeth". They are also being used in low cost and, in particular, miniature applications.

The most common type of stepper motor is the Hybrid stepper motor. It is the fine "teeth" and stepping angle of a variable reluctance motor and the efficiency of the permanent magnet motor. The rotor is made out of one or more stacks that consist of a pair of magnetically opposite polarized sections. These motors offer the best combination of efficiency and fine stepping angles and can be driven by both unipolar and bipolar drivers.

Advantages

Stepper motors are primarily intended to be used for low cost microprocessor controlled positioning applications. Due to some of their inherent characteristics, they are preferred in many industrial and laboratory applications. Some of their main advantages are:

- Low cost full-step, open loop implementation
- No servo tuning required
- Good position lock-in
- No encoder necessary
- Easy velocity control
- Retains some holding torque even with power off
- No wearing or arcing commutators
- Preferred for vacuum and explosive environments.

Disadvantages

Some of the main disadvantages of the stepper motors are:

- Could loose steps (synchronization) in open loop operation
- Requires current (dissipates energy) even at stop
- Generates higher heat levels than other types of motors
- Moves from one step to another are made with sudden motions
• Large velocity ripples, especially at low speeds, causing noise and possible resonances
• Load torque must be significantly lower than the motor holding torque to prevent stalling and missing steps
• Limited high speed

5.6.2 DC Motors
A DC motor is similar to a permanent magnet stepper motor with an added internal phase commutator (Figure 5.43).

Applying current to phase B pulls in the rotor pole. If, as soon as the pole gets there, the current is switched to the next phase C, the rotor will not stop but continue moving to the next target.

Repeating the current switching process will keep the motor moving continuously. The only way to stop a DC motor is not to apply any current to its windings. Due to the permanent magnets, reversing the current polarity will cause the motor to move in the opposite direction.

Of course, there is a lot more to the DC motor theory but this description gives the user a general idea on how they work.

A few other characteristics to keep in mind are:
• For a constant load, the velocity is approximately proportional to the voltage applied to the motor
• For accurate positioning, DC motors need a position feedback device.
• Constant current generates approximately constant torque
• If DC motors are tuned externally (manually, etc.) they act as generators.

Advantages
DC motors are preferred in many applications for the following reasons:
• Smooth, ripple-free motion at any speed
• High torque per volume
• No risk of losing position (in a closed loop)
• Higher power efficiency than stepper motors
• No current requirement at stop
• Higher speeds can be obtained than with other types of motors.
Disadvantages

Some of the DC motor's disadvantages are:
- Requires a position feedback encoder and servo loop controller
- Requires servo loop tuning
- Commutator may wear out in time
- Not suitable for high vacuum application due to the commutator arcing
- Hardware and setup are more costly than for an open loop stepper motor (full stepping)

5.7 Drivers

Motor divers must not be overlooked when judging a motion control system. They represent an important part of the loop that in many cases could increase or reduce the overall performance.

The ESP300 is an integrated controller and driver. The controller part is common for any configuration but the driver section must have the correct hardware for each motor driven. The driver hardware is one driver card per axis that installs easily in the rear of the controller. Each card has an end-plate with the 25 pin D-Sub motor connector and an identifying label. Always make sure that the motor specified on the driver card label matches the label on the motion device.

There are important advantages to having an integrated controller/driver. Besides reducing space and cost, integration also offers tighter coordination between the two units so that the controller can more easily monitor and control the driver's operation.

Driver types and techniques vary widely. In the following paragraphs, we will discuss only those implemented in the ESP300.

5.7.1 Stepper Motor Drivers

Driving a stepper motor may look simple at first place. For a motor with four phases, the most widely used type, the user will need only four switches (transistors) controlled directly by a CPU (Figure 5.44).

This driver works fine for simple, low performance applications. But, if high speeds are required, having to switch the current fast in inductive loads becomes a problem. When voltage is applied to a winding, the current (and thus the torque) approaches its normal value exponentially (Figure 5.45).
When the pulse rate is flat, the current does not have time to reach the desired value before it is turned off and the total torque generated is only a fraction of the nominal one (Figure 5.46).

How fast the current reaches its nominal value depends on three factors: the winding's inductance, resistance and the voltage applied to it.

The inductance cannot be reduced. But the voltage can be temporarily increased to bring the current to its desired level faster. The most widely used technique is a high voltage chopper.

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If, for instance, a stepper motor requiring only 3V to reach the nominal current is connected momentarily to 30V, it will reach the same current on only 1/10 of the time (Figure 5.47).

Once the desired current value is reached, a chopper circuit activates to keep the current close to the nominal value.

### 5.7.2 Unipolar – Bipolar Drivers

In the examples described in Section 5.7.1: Stepper Motor Drivers, each phase has its own commutator (transistor) to control the current that flows through it. Having one end permanently connected to the power source, the current will flow through each phase always in the same direction. For this reason, these types of drivers are called **Unipolar**.

On the other hand, Figure 5.48 shows a **Bipolar** Driver built in a dual H-bridge configuration. The name "H-Bridge" comes from the topology of the transistors controlling one load (coil). In this case, by turning on diagonally transistors (1-4 or 2-3), the current could be made to flow either way through the coil. This means that the driver can control not just the intensity of the magnetic field generated by the stator, but also its polarity. Implicitly, the only stepper motors that can be used with such a driver are the ones with polarized rotors, the Permanent Magnet, and the Hybrid types.

The question that arises from the driver configuration is how to connect a Four Phase stepper motor to a driver that drives only two coils. This could be accomplished in three different ways, each one with its own advantages and disadvantages:

1. Use only two adjacent phases (e.g., phase #1 and #2).
   - **Advantage** – simplicity
- **Disadvantage** – lower efficiency since only half the windings are being used.

2. Connect the two opposing phases (1-3 and 2-4) in series.
   - **Advantage** – the motor does not require more than the nominal current.
   - **Disadvantage** – the driver will see twice the nominal motor inductance that will reduce the motor's torque performance at higher speeds.

3. Connect the two opposing phases (1-3 and 2-4) in parallel.
   - **Advantage** – the motor inductance does not increase, allowing it to perform well at higher speeds.
   - **Disadvantage** – requires the driver to supply twice the motor's nominal current.

![Dual H-Bridge Driver](image)

**Figure 5.48: Dual H-Bridge Driver**

### 5.7.3 DC Motor Drivers

There are three major categories of DC motor drivers. The simplest one is a voltage amplifier (**Figure 5.49**).

![DC Motor Voltage Amplifier](image)

**Figure 5.49: DC Motor Voltage Amplifier**

The driver amplifies the standard $\pm 10$ V control signal to cover the motor's nominal voltage range while also supplying the motor's nominal current.
This type of driver is used mostly in low cost applications where following error is not a great concern. The controller does all the work in trying to minimize the following error but load variations make this task very difficult.

The second type of DC motor driver is the current driver, also called a torque driver (Figure 5.50).

In this case, the control signal voltage defines the motor current. The driver constantly measures the motor current and always keeps it proportional to the input voltage. This type of driver is usually preferred over the previous one in digital control loops, offering a stiffer response and thus reduces the dynamic following error.

Figure 5.50: DC Motor Current Driver

But, when the highest possible performance is required, the best choice is always the velocity feedback driver. This type of driver requires a tachometer, an expensive and sometimes difficult to add device (Figure 5.51).

Figure 5.51: DC Motor Velocity Feedback Driver

The tachometer, connected to the motor's rotor, outputs a voltage directly proportional with the motor velocity. The circuit compares this voltage with the control signal and drives the motor so that the two are always equal. This creates a second closed loop, a velocity loop. Motions performed with such a driver are very smooth at high and low speeds and has a similar dynamic following error.
General purpose velocity feedback drivers have usually two adjustments: tachometer gain and compensation (Figure 5.52).

The tachometer gain is used to set the ratio between the control voltage and the velocity. The compensation adjustment reduces the bandwidth of the amplifier to avoid oscillations of the closed loop.

5.7.3.1 PWM Drivers

Even though linear amplifiers are simpler and cleaner (do not generate noise), their low efficiency makes them impractical to be used with medium and larger motors. The most common types of DC drivers use some kind of PWM (Pulse-Width Modulation) techniques to control the current and/or voltage applied to the motor. This allows for a more efficient and compact driver design.
Section 6 – Servo Tuning

6.1 Tuning Principles

The ESP300 controller uses a PID servo loop with feed-forward. Servo tuning sets the $K_p$, $K_i$, and $K_d$, and feed-forward parameters of the digital PID algorithm, also called the PID filter.

Tuning PID parameters requires a reasonable amount of closed-loop system understanding. First review the Control Loops paragraph in the Motion Control Tutorial Section. If needed, consult additional servo control theory books.

Start the tuning process using the default values supplied with the stage. These values are usually very conservative, favoring safe and oscillation-free operation. To achieve the best dynamic performance possible, the system must be tuned for the specific application. Load, acceleration, stage orientation, and performance requirements all affect how the servo loop should be tuned.

6.2 Tuning Procedures

Servo tuning is usually performed to achieve better motion performance (such as reducing the following error statically and/or dynamically) or because the system is malfunctioning (oscillating and/or shutting off due to excessive following error).

Acceleration plays a significant role in the magnitudes of the following error and overshoot, especially at start and stop. Rapid velocity changes represent very high acceleration, causing large following errors and overshoot. Use the smallest acceleration the application can tolerate to reduce overshoot and make tuning the PID filter easier.
In the following descriptions, it is assumed that a software utility is being used to capture the response of the servo loop during a motion step command, and to visualize the results.

### 6.2.1 Hardware and Software Requirements

#### Hardware Requirements

Tuning is best accomplished when the system response can be measured. This can be done with external monitoring devices but can introduce errors.

The ESP300 controller avoids this problem by providing an internal `tune` capability. When `tune` mode is activated, the controller records a number of different parameters. The parameters can include real instantaneous position, desired position, desired velocity, desired acceleration, DAC output value, etc.

The sample interval can be set to one servo cycle or any multiple of it and the total number of samples can be up to 1000 points.

This is a powerful feature that the user can take advantage of to get maximum performance out of the motion system.

#### Software Requirements

Users can write their own application(s) or use the ESP-tune-exe Windows utility.

Please refer to the description of ASCII command, "DC", to setup data acquisition.

### 6.2.2 Correcting Axis Oscillation

There are three parameters that can cause oscillation. The most likely to induce oscillation is \( K_i \), followed by \( K_p \) and \( K_d \). Start by setting \( K_i \) to zero and reducing \( K_p \) and \( K_d \) by 50%.

If oscillation does not stop, reduce \( K_p \) again.

When the axis stops oscillating, system response is probably very soft. The following error may be quite large during motion and non-zero at stop. Continue tuning the PID with the procedures described in the next paragraph.

### 6.2.3 Correcting Following Error

If the system is stable and the user wants to improve performance, start with the current PID parameters. The goal is to reduce following error during motion and to eliminate it at stop.
Guidelines for further tuning (based on performance starting point and desired outcome) are provided in the following paragraphs.

**Following Error Too Large**

This is the case of a soft PID loop caused by low values for $K_p$ and $K_d$. It is especially common after performing the procedures described in paragraph 6.2.2.

First increase $K_p$ by a factor of 1.5 to 2. Repeat this operation while monitoring the following error until it starts to exhibit excessive ringing characteristics (more than 3 cycles after stop). To reduce ringing, add some damping by increasing the $K_d$ parameter.

Increase it by a factor of 2 while monitoring the following error. As $K_d$ is increased, overshoot and ringing will decrease almost to zero.

**NOTE**

Remember that if acceleration is set too high, overshoot cannot be completely eliminated with $K_d$.

If $K_d$ is further increased, at some point oscillation will reappear, usually at a higher frequency. Avoid this by keeping $K_d$ at a high enough value, but not so high as to re-introduce oscillation.

Increase $K_p$ successively by approximately 20% until signs of excessive ringing appear again.

Alternately increase $K_d$ and $K_p$ until $K_d$ cannot eliminate overshoot and ringing at stop. This indicates $K_p$ is larger than its optional value and should be reduced. At this point, the PID loop is very tight.

Ultimately, optimal values for $K_p$ and $K_d$ depend on the stiffness of the loop and how much ringing the application can tolerate.

**NOTE**

The tighter the loop, the greater the risk of instability and oscillation when load conditions change.
Errors At Stop (Not In Position)

If you are satisfied with the dynamic response of the PID loop but the stage does not always stop accurately, modify the integral gain factor $Ki$. As described in the Motion Control Tutorial section, the $Ki$ factor of the PID works to reduce following error to near zero. Unfortunately it can also contribute to oscillation and overshoot. Change this parameter carefully, and if possible, in conjunction with $Kd$.

Start with the integral limit ($IL$) set to a high value and $Ki$ value at least two orders of magnitude smaller than $Kp$. Increase its value by 50% at a time and monitor overshoot and final position at stop.

If intolerable overshoot develops, increase the $Kd$ factor. Continue increasing $Ki$, $IL$ and $Kd$ alternatively until an acceptable loop response is obtained. If oscillation develops, immediately reduce $Ki$ and $IL$.

Remember that any finite value for $Ki$ will eventually reduce the error at stop. It is simply a matter of how much time is acceptable for the application. In most cases it is preferable to wait a few extra milliseconds to get to the stop in position rather than have overshoot or run the risk of oscillations.

Following Error During Motion

This is caused by a $Ki$, and $IL$ value that is too low. Follow the procedures in the previous paragraph, keeping in mind that it is desirable to increase the integral gain factor as little as possible.

6.2.4 Points To Remember

- Use the Windows-based "ESP_tune.exe" utility to change PID parameters and to visualize the effect. Compare the results and parameters used with the previous iteration.
- The ESP300 controller uses a servo loop based on the PID with velocity and acceleration feed-forward algorithm.
- Use the lowest acceleration the application can tolerate. Lower acceleration generates less overshoot.
- Use the default values provided with the system for all standard motion devices as a starting point.
- Use the minimum value for $Ki$, and $IL$ that gives acceptable performance. The integral gain factor can cause overshoot and oscillations.

A summary of servo parameter functions is listed in Table 6.2.1.
<table>
<thead>
<tr>
<th>Parameter</th>
<th>Function</th>
<th>Value Set Too Low</th>
<th>Value Set Too High</th>
</tr>
</thead>
<tbody>
<tr>
<td>Kp</td>
<td>Determines stiffness of servo loop</td>
<td>Servo loop too soft with high following errors</td>
<td>Servo loop too tight and/or causing oscillation</td>
</tr>
<tr>
<td>Kd</td>
<td>Main damping factor, used to eliminate oscillation</td>
<td>Uncompensated oscillation caused by other parameters being high</td>
<td>Higher-frequency oscillation and/or audible noise in the motor caused by large ripple in the motor voltage</td>
</tr>
<tr>
<td>Ki</td>
<td>Reduces following error during long motions and at stop</td>
<td>Stage does not reach or stay at the desired stop position</td>
<td>Oscillations at lower frequency and higher amplitude</td>
</tr>
<tr>
<td>Vff</td>
<td>Reduces following error during the constant velocity phase of a motion</td>
<td>Negative following error during the constant velocity phase of a motion. Stage lags the desired trajectory</td>
<td>Positive following error during the constant velocity phase of a motion. Stage is ahead of the desired trajectory</td>
</tr>
<tr>
<td>Aff</td>
<td>Reduces following error during the acceleration and deceleration phases of a motion</td>
<td>Negative following error during the acceleration phase of a motion. Stage lags the desired trajectory</td>
<td>Position following error during the acceleration phase of a motion. Stage is ahead of the desired trajectory</td>
</tr>
</tbody>
</table>

*Table 6.1: Servo Parameter Functions*
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Section 7 – Optional Equipment

7.1 Hand-held Keypad

An optional alphanumeric keypad (see Figure 7.1 below) allows the user to access the full command set of the ESP300 without the use of a host computer. The keypad features a backlit LCD display that echoes each character typed on the keypad. Additionally, status messages are echoed to the display in certain cases (e.g., error codes).

Four macro keys on the top row of the keypad permit execution of previously stored programs on the push of one button (see EP, EX commands in Section 3, Remote Mode, for details).

Figure 7.1: Alphanumeric Hand-held Keypad
7.1.1 Description of Keys (see Figure 7.1)

STOP ALL

When this button is activated, all motion is aborted. All axes are affected. The function of STOP ALL on the keypad is equivalent to STOP ALL on the ESP300 front panel.

MACRO#

Activating either MACRO # button results in execution of a previously stored program.

- MACRO 1 runs PROGRAM 1
- MACRO 2 runs PROGRAM 2
- MACRO 3 runs PROGRAM 3
- MACRO 4 runs PROGRAM 4

See EP command in Section 3, Remote Mode, for details on creating programs.

SHIFT ↑

Pressing this key in connection with a double function key selects the upper symbol, e.g. /F (this symbol is selected).

ENTER

When this key is pressed, all previously typed characters are sent to the ESP300.

SPACE BKSP

Pressing this key deletes a preceding character. Pressing it in connection with the SHIFT key inserts a space in a given line.

7.1.2 Activating the Keypad

Plug one end of the cable that was supplied with the keypad into the receptacle on the bottom side of the keypad and the other end into the receptacle on the lower right corner of the ESP300 front panel. The ESP300 will detect the presence of the keypad. No user settings are required.

Now, the keypad is ready for use. An easy way to verify proper operation of the keypad is by sending the VE command (type: VE and hit ENTER). The ESP300 should respond with the current version.
Appendix A – Error Messages

The ESP300 controller has an elaborate command interpreter and system monitor. Every command is analyzed for syntax and correct format after it is received. The result of the analysis is stored in an output buffer in plain English. During moves and while, idle system inputs are monitored and any change is reported to the user via the output buffer. To read the contents of the output buffer, send the command TB (tell buffer).

For more compact error messages, use the TE command. The ESP300 controller response to this command is a one byte; binary coded error number, e.g., 33.

For the sake of convenience, error messages are divided into two categories – non-axis specific error messages and axis specific error messages. Below is a list of all possible ESP300 controller error messages that are not axis specific:

0  NO ERROR DETECTED
No errors exist in the output buffer.

1  PCI COMMUNICATION TIME-OUT
A communication transfer was initiated through PCI bus interface and was never completed.

2  Reserved for future use

3  Reserved for future use

4  EMERGENCY SOP ACTIVATED
An emergency stop was executed because the motion controller received a '#' character or "STOP ALL AXES" button was pressed.

5  Reserved for future use

6  COMMAND DOES NOT EXIST
The issued command does not exist. Check the Command Syntax.

7  PARAMETER OUT OF RANGE
The specified parameter is out of range. Refer to the description of issued command for valid parameter range.
8 CABLE INTERLOCK ERROR
The 100-pin cable between motion controller board and driver is disconnected.

9 AXIS NUMBER OUT OF RANGE
The specified axis number is out of range. Refer to the description of issued command for valid axis number range.

10 Reserved for future use
11 Reserved for future use
12 Reserved for future use

13 GROUP NUMBER MISSING
Group number is not specified. The issued command requires a valid group number. Refer to the description of issued command for valid group number range.

14 GROUP NUMBER OUT OF RANGE
The specified group number is out of range. Refer to the description of issued command for valid group number range.

15 GROUP NUMBER NOT ASSIGNED
The specified group has not been assigned. Refer to the description of HN command to create a new group with this group number.

16 GROUP NUMBER ALREADY ASSIGNED
The specified group number has already been assigned. Refer to the description of HB command to query the list of group numbers already assigned.

17 GROUP AXIS OUT OF RANGE
At least one of the axis numbers specified to be a member of this group is out of range. Refer to the description of HN command for valid range of axis numbers that can be assigned to a group.

18 GROUP AXIS ALREADY ASSIGNED
At least one of the axis numbers specified to be a member of this group is already a member of a different group.

19 GROUP AXIS DUPLICATED
At least one of the axis numbers is specified to be a member of this group more than once.

20 DATA ACQUISITION IS BUSY
Data acquisition is not yet complete.
21  **DATA ACQUISITION SETUP ERROR**
An error occurred during data acquisition setup. Ensure that data acquisition is disabled and all parameters are within valid range before issuing the command. Refer to the command description for valid range of parameters.

22  **DATA ACQUISITION NOT ENABLED**
Data acquisition is not yet enabled.

23  **SERVO CYCLE TICK FAILURE**
There was a failure to increment the servo tick in the Interrupt Service Routine (ISR) that manages motion control.

24  *Reserved for future use*

25  **DOWNLOAD IN PROGRESS**
Firmware download is in progress.

26  **STORED PROGRAM NOT STARTED**
An attempt was made to execute a stored program and the program could not be started.

27  **COMMAND NOT ALLOWED**
The issued command is not valid in the context in which it was issued.

28  **STORED PROGRAM FLASH AREA FULL**
The flash area reserved for stored programs is full.

29  **GROUP PARAMETER MISSING**
At least one parameter is missing. Refer to the description of issued command for valid number of parameters.

30  **GROUP PARAMETER OUT OF RANGE**
The specified group parameters is out of range. Refer to the description of issued command for valid range of parameter.

31  **GROUP MAXIMUM VELOCITY EXCEEDED**
The specified group velocity exceeds the minimum of the maximum velocities of members of this group. Refer to the description of HV command for more details.

32  **GROUP MAXIMUM ACCELERATION EXCEEDED**
The specified group acceleration exceeds the minimum of the maximum acceleration of members of this group. Refer to the description of HA command for more details.
33  **GROUP MAXIMUM DECELERATION EXCEEDED**
The specified group deceleration exceeds the minimum of the maximum decelerations of members of this group. Refer to the description of HD command for more details.

34  **GROUP MOVE NOT ALLOWED DURING MOTION**
Cannot make a coordinated move when one of the members of the group is being "homed".

35  **PROGRAM NOT FOUND**
The issued command could not be executed because the stored program requested is not available.

36  **Reserved for future use**

37  **AXIS NUMBER MISSING**
Axis number not specified. The issued command requires a valid axis number. Refer to the description of issued command for valid axis number range.

38  **COMMAND PARAMETER MISSING**
At least one parameter associated with this command is missing. Refer to the description of issued command for valid number of parameters.

39  **PROGRAM LABEL NOT FOUND**
The issued command could not be executed because the requested label within a stored program is not available.

40  **LAST COMMAND CANNOT BE REPEATED**
An attempt was made to repeat the last (previous) commanded by just sending a carriage return. This feature is not allowed for commands that carry strings in addition to the two-letter ASCII mnemonic. Issue the last command again.

41  **MAX NUMBER OF LABELS PER PROGRAM EXCEEDED**
The number of labels used in the stored program exceeds the allowed value.

*Below is a list of all possible error messages that are axis specific. Here, "x" represents the axis number.*

**x00  MOTOR TYPE NOT DEFINED**
A valid motor type was not defined for the requested axis. Refer to the description of QM command to define a motor type.
**x01  PARAMETER OUT OF RANGE**  
The specified parameter is out of range. Refer to the description of issued command for valid parameter range.

**x02  AMPLIFIER FAULT DETECTED**  
There was an amplifier fault condition.

**x03  FOLLOWING ERROR THRESHOLD EXCEEDED**  
The real position of specified axis was lagging the desired position by more encoder counts than specified with the FE command. Refer to the description of ZF command to configure the motion controller tasks upon encountering a following error.

**x04  POSITIVE HARDWARE LIMIT DETECTED**  
The motion controller sensed a high level at its positive travel limit input. Refer to the description of ZH command to configure the motion controller tasks upon encountering a hardware limit.

**x05  NEGATIVE HARDWARE LIMIT DETECTED**  
The motion controller sensed a high level at its negative travel limit input. Refer to the description of ZH command to configure the motion controller tasks upon encountering a hardware limit.

**x06  POSITIVE SOFTWARE LIMIT DETECTED**  
The motion controller sensed that the axis has reached positive software travel limit. Refer to the description of SR command to specify the desired positive software travel limit. Also, refer to the description of ZS command to configure the motion controller tasks upon encountering a software limit.

**x07  NEGATIVE SOFTWARE LIMIT DETECTED**  
The motion controller sensed that the axis has reached negative software travel limit. Refer to the description of SL command to specify the desired negative software travel limit. Also, refer to the description of ZS command to configure the motion controller tasks upon encountering a software limit.

**x08  MOTOR / STAGE NOT CONNECTED**  
The specified axis is not connected to the driver.

**x09  FEEDBACK SIGNAL FAULT DETECTED**  
There was a feedback signal fault condition. Ensure that the encoder feedback is relatively noise free.
x10  **MAXIMUM VELOCITY EXCEEDED**  
The specified axis velocity exceeds maximum velocity allowed for the axis. Refer to the description of VU command or set maximum velocity for the axis.

x11  **MAXIMUM ACCELERATION EXCEEDED**  
The specified axis acceleration exceeds maximum acceleration allowed for the axis. Refer to the description of AU command to query or set maximum acceleration or deceleration for the axis.

x12  **Reserved for future use**

x13  **MOTOR NOT ENABLED**  
A command was issued to move an axis that was not powered ON. Refer to the description of MO and MF commands to turn the power to an axis ON or OFF respectively.

x14  **Reserved for future use**

x15  **MAXIMUM JERK EXCEEDED**  
The specified axis jerk exceeds maximum jerk allowed for the axis. Refer to the description of JK command for valid jerk range.

x16  **MAXIMUM DAC OFFSET EXCEEDED**  
The specified axis DAC offset exceeds maximum value allowed for the axis. Refer to the description of issued command for valid range.

x17  **ESP CRITICAL SETTINGS ARE PROTECTED**  
An attempt was made to modify parameters that are specific to smart stages or "Unidriver".

x18  **ESP STAGE DEVICE ERROR**  
An error occurred while reading a smart stage.

x19  **ESP STAGE DATA INVALID**  
Smart stage data is invalid.

x20  **HOMING ABORTED**  
Axis home search was aborted. This message is obtained when home search was not completed either due to an axis not being enabled or due to the occurrence of a fault condition. Refer to the description of OR command for information related to locating the home position of an axis.
x21  **MOTOR CURRENT NOT DEFINED**  
Maximum current for the motor is not specified. Refer to the description of QI command to query or set the maximum motor current for an axis.

x22  **UNIDRIVE COMMUNICATIONS ERROR**  
There was no communication between motion controller and the Unidriver.

x23  **UNIDRIVE NOT DETECTED**  
Unidrive could not be detected by the motion controller.

x24  **SPEED OUT OF RANGE**  
The specified home search speed is out of range. Refer to the description of OH command for valid home search speed range.

x25  **INVALID TRAJECTORY MASTER AXIS**  
The specified trajectory mode in not valid for a master axis. Refer to the description if TJ command to specify a valid trajectory mode for a master axis.

x26  **PARAMETER CHARGE NOT ALLOWED**  
The specified parameter cannot be changed while the axis is in motion. Wait until the axis motion is complete, and issue this command again. Refer to the description of MD command to determine if motion is done.

x27  **INVALID TRAJECTORY MODE FOR HOMING**  
The specified trajectory mode is not valid for locating the home position of the axis. Refer to the description of TJ command to specify a valid trajectory mode for locating the home position of this axis.

x28  **INVALID ENCODER STEP RATIO**  
The specified full step resolution is invalid. Refer to the description of FR command for valid range of full step resolution.

x29  **DIGITAL I/O INTERLOCK DETECTED**  
A DIO interlock was asserted.

x30  **COMMAND NOT ALLOWED DURING HOMING**  
The command issued was not executed because locating the home position of this axis is in progress. Refer to the description of the issued command for further details.
x31 COMMAND NOT ALLOWED DUE TO GROUP ASSIGNMENT
The specified command was not executed because this axis is member of a group. Refer to the description of issued command for further details.

x32 INVALID TRAJECTORY MODE FOR MOVING
The specified trajectory mode is invalid to make absolute or relative moves. Refer to the description of PA and PR commands for valid trajectory modes to initiate motion.
Appendix B – Trouble-Shooting / Maintenance

There are no user-serviceable parts or user adjustments to be made to the ESP300 controller/driver.

**WARNING**

Procedures are to be performed only by qualified service personnel. Qualified service personnel should be aware of the shock hazards involved when instrument covers are removed and should observe the following precautions before proceeding.

- Turn off power switch and unplug the unit from its power source
- Disconnect cables if their function is not understood
- Remove jewelry from hands and wrist
- Expect hazardous voltages to be present in any unknown circuits.

**CAUTION**

Verify proper alignment before inserting connectors.

Refer to Appendix G, Factory Service, for information about repair or other hardware corrective action.
Most of the time a blown fuse is the result of a more serious problem. Fixing the problem should include not only correcting the effect (blown fuse) but also the cause of the failure. Analyze the problem carefully to avoid repeating it in the future.

A list of the most common problems and their corrective actions is provided in Table B.1. Use it as a reference but remember that a perceived error is open to an operator error or has some other simple solution.

<table>
<thead>
<tr>
<th>PROBLEM</th>
<th>CAUSE</th>
<th>CORRECTIVE ACTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>Display does not come on.</td>
<td>Power switch is turned off.</td>
<td>Turn on the main power switch located on the front panel.</td>
</tr>
<tr>
<td></td>
<td>No electrical power</td>
<td>Verify with an adequate tester or another electrical device (lamp, etc.) that power is present in the outlet. If not, contact an electrician to correct the problem.</td>
</tr>
<tr>
<td></td>
<td>Power cord not plugged in.</td>
<td>Plug the power cord in the appropriate outlet. Observe all caution notes and procedures described in the System Setup section.</td>
</tr>
<tr>
<td></td>
<td>Blown fuse</td>
<td>Replace the line fuse as described in the System Setup section. Beware that the fuse blows only when a serious problem arises. If the fuse blows again, contact Newport for service.</td>
</tr>
<tr>
<td>Error message or physically present stage is declared unconnected.</td>
<td>Bad connection.</td>
<td>Turn power off and verify the motion device connection.</td>
</tr>
<tr>
<td></td>
<td>Bad component/ step/ cable</td>
<td>Turn power off and swap the motor cable with another axis (if cables are identical) to locate the problem. Contact Newport for cable replacement or motion device service.</td>
</tr>
<tr>
<td>Red LED above STOP ALL button remains on.</td>
<td>Safety control connector on the rear of the ESP300 is missing.</td>
<td>Plug connector in. If the connector was lost, you can either build one as shown in System Setup in Appendix C.1.8, or call Newport for a replacement.</td>
</tr>
<tr>
<td>Motor can not be turned on.</td>
<td>Power button on the display does not appear when motor power button is pressed.</td>
<td>Verify that the motion device is connected.</td>
</tr>
</tbody>
</table>

Table B.1: Trouble-Shooting Guide Descriptions
<table>
<thead>
<tr>
<th>PROBLEM</th>
<th>CAUSE</th>
<th>CORRECTIVE ACTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>Excessive following error.</td>
<td>Wrong setup, load specification exceeded.</td>
<td>Verify that all setup parameters correspond to the actual motion device installed.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Verify that the load specifications for the motion device are not being exceeded.</td>
</tr>
<tr>
<td>Axis does not move.</td>
<td>Incorrect connection.</td>
<td>Verify that the motion device is connected to the correct driver card, as specified by the labels.</td>
</tr>
<tr>
<td></td>
<td>Incorrect parameters.</td>
<td>Verify that the motion device is connected to the correct driver card, as specified by the labels.</td>
</tr>
<tr>
<td>System performance below</td>
<td>Incorrect connection.</td>
<td>Verify that the motion device is connected to the correct driver card, as specified by the labels.</td>
</tr>
<tr>
<td></td>
<td>Incorrect parameters.</td>
<td>Verify that all relevant parameters (PID, velocity, etc.) are set properly.</td>
</tr>
<tr>
<td>Move command not executed.</td>
<td>Software travel limit</td>
<td>The software limit (See SL command) if the specified direction was reached. If limits are set correctly, do not try to move past them.</td>
</tr>
<tr>
<td></td>
<td>Incorrect parameters</td>
<td>Verify that all relevant parameters (PID, velocity, etc.) are set properly.</td>
</tr>
<tr>
<td>Home search not completed.</td>
<td>Faulty origin or index signals.</td>
<td>Carefully observe and record the motion sequence by watching manual knob rotation, if available. With the information collected, call Newport for assistance.</td>
</tr>
<tr>
<td></td>
<td>Wrong line terminator.</td>
<td>Make sure that the computer and the controller use the same line terminator.</td>
</tr>
<tr>
<td></td>
<td>No remote communication, wrong communication port.</td>
<td>Verify that the controller is set to communicate on the right port, RS-232 or IEEE488.</td>
</tr>
<tr>
<td></td>
<td>Wrong communication parameters.</td>
<td>Verify that all communication parameters match between the computer and the controller.</td>
</tr>
</tbody>
</table>

*Table B.1: Trouble-Shooting Guide Descriptions (Continued)*

**NOTE**

Many problems are detected by the controller and reported on the display and/or in the error register. Consult Appendix A, Error Messages, for a complete list and description.
B.2 Fuse Replacement

B.2.1 Replacing Fuses on the ESP300 Rear Power Line Panel

WARNING

Power-down equipment and unplug AC power cord before replacing fuses.

At the rear of the ESP300, depress the fuse holder tabs with a small, thin-bladed screwdriver (see Figure B2.1) and ease the fuse holder out of the AC plug receptacle.

Remove and inspect the fuses. Replace as needed with appropriate fuse: 4A, T, 250V fuse for ESP300-xxxxx1 models and 6.3A, T, 250V fuse for ESP300-xxxxx2 models.

Re-insert into the AC plug receptacle by pushing in the fuse holder until the tabs snap in place.

Re-connect and power-up the system to verify that the problem has been corrected.
B.3 Cleaning

Clean the exterior metallic surfaces of the ESP300 with water damp but not wet lint-free cloth. Clean external cable surfaces with alcohol, using a clean, lint-free cloth.

---

**WARNING**

*Power-down all equipment before cleaning.*

---

**CAUTION**

*Do not expose connectors, fans, LEDs, or switches to alcohol or water.*
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Appendix C – Connector Pin Assignments

C.1 ESP300 Rear Panel

C.1.1 GPIO Connector (37-Pin D-Sub)
This connector is dedicated to the digital I/O ports. All I/O are pulled up to +5V DC with 4.7KΩ resistors. Maximum sink or source current is 32 mA. Connector pin-outs are listed in Table C.1, and functionally described in the following paragraphs.

C.1.2 Signal Descriptions (Digital I/O, 37-Pin, JP4 Connector)
+5V, 100mA (maximum)
+5V supply
+15V, 25mA (maximum)
+15V supply

Digital I/O
The digital I/O can be programmed to be either input or output (in 8-bit blocks) via software.

DGND
Digital Ground used for all digital signals.

<table>
<thead>
<tr>
<th>Pin #</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>+15V, 25mA</td>
</tr>
<tr>
<td>2</td>
<td>+15V, 25mA</td>
</tr>
<tr>
<td>3</td>
<td>+5V, 100mA</td>
</tr>
<tr>
<td>4</td>
<td>Digital Input/Output 1</td>
</tr>
<tr>
<td>5</td>
<td>Digital Input/Output 2</td>
</tr>
<tr>
<td>6</td>
<td>Digital Input/Output 3</td>
</tr>
<tr>
<td>7</td>
<td>Digital Input/Output 4</td>
</tr>
<tr>
<td>8</td>
<td>Digital Input/Output 5</td>
</tr>
<tr>
<td>9</td>
<td>Digital Input/Output 6</td>
</tr>
<tr>
<td>10</td>
<td>Digital Input/Output 7</td>
</tr>
<tr>
<td>11</td>
<td>Digital Input/Output 8</td>
</tr>
<tr>
<td>12</td>
<td>Digital Input/Output 9</td>
</tr>
<tr>
<td>13</td>
<td>Digital Input/Output 10</td>
</tr>
<tr>
<td>14</td>
<td>Digital Input/Output 11</td>
</tr>
<tr>
<td>15</td>
<td>Digital Input/Output 12</td>
</tr>
</tbody>
</table>

Table C.1: Digital Connector Pin-Outs
### Table C.1: Digital Connector Pin-Outs (Continued)

<table>
<thead>
<tr>
<th>Pin #</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>16</td>
<td>Digital Input/Output 13</td>
</tr>
<tr>
<td>17</td>
<td>Digital Input/Output 14</td>
</tr>
<tr>
<td>18</td>
<td>Digital Input/Output 15</td>
</tr>
<tr>
<td>19</td>
<td>Digital Input/Output 16</td>
</tr>
<tr>
<td>20</td>
<td>DGND</td>
</tr>
<tr>
<td>21</td>
<td>DGND</td>
</tr>
<tr>
<td>22</td>
<td>DGND</td>
</tr>
<tr>
<td>23</td>
<td>DGND</td>
</tr>
<tr>
<td>24</td>
<td>DGND</td>
</tr>
<tr>
<td>25</td>
<td>DGND</td>
</tr>
<tr>
<td>26</td>
<td>DGND</td>
</tr>
<tr>
<td>27</td>
<td>DGND</td>
</tr>
<tr>
<td>28</td>
<td>DGND</td>
</tr>
<tr>
<td>29</td>
<td>DGND</td>
</tr>
<tr>
<td>30</td>
<td>DGND</td>
</tr>
<tr>
<td>31</td>
<td>DGND</td>
</tr>
<tr>
<td>32</td>
<td>DGND</td>
</tr>
<tr>
<td>33</td>
<td>DGND</td>
</tr>
<tr>
<td>34</td>
<td>DGND</td>
</tr>
<tr>
<td>35</td>
<td>DGND</td>
</tr>
<tr>
<td>36</td>
<td>DGND</td>
</tr>
<tr>
<td>37</td>
<td>DGND</td>
</tr>
</tbody>
</table>

#### C.1.3 Motor Driver Card (25-Pin) I/O Connector

This connector interfaces an ESP300 driver card to motorized stages. Cabling to the connector is provided with the applicable stage. Connector pin-outs are listed in **Table C.2**.

<table>
<thead>
<tr>
<th>Pins</th>
<th>2 Phase Stepper Motor</th>
<th>DC Motor</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Stepper Phase 1</td>
<td>N/C</td>
</tr>
<tr>
<td>2</td>
<td>Stepper Phase 1</td>
<td>N/C</td>
</tr>
<tr>
<td>3</td>
<td>Stepper Phase 2</td>
<td>N/C</td>
</tr>
<tr>
<td>4</td>
<td>Stepper Phase 2</td>
<td>N/C</td>
</tr>
<tr>
<td>5</td>
<td>Stepper Phase 3</td>
<td>N/C</td>
</tr>
<tr>
<td>6</td>
<td>Stepper Phase 3</td>
<td>N/C</td>
</tr>
<tr>
<td>7</td>
<td>Stepper Phase 4</td>
<td>N/C</td>
</tr>
<tr>
<td>8</td>
<td>Stepper Phase 4</td>
<td>N/C</td>
</tr>
<tr>
<td>9</td>
<td>Common Phase 3,4</td>
<td>N/C</td>
</tr>
<tr>
<td>10</td>
<td>N/C</td>
<td>N/C</td>
</tr>
<tr>
<td>11</td>
<td>Common Phase 1,2</td>
<td>N/C</td>
</tr>
<tr>
<td>12</td>
<td>N/C</td>
<td>N/C</td>
</tr>
<tr>
<td>13</td>
<td>Home Signal</td>
<td>Home Signal</td>
</tr>
<tr>
<td>14</td>
<td>Shield Ground</td>
<td>Shield Ground</td>
</tr>
<tr>
<td>15</td>
<td>Encoder Index (+)</td>
<td>Encoder Index (+)</td>
</tr>
<tr>
<td>16</td>
<td>Limit Ground</td>
<td>Limit Ground</td>
</tr>
<tr>
<td>17</td>
<td>Travel Limit (+) Input</td>
<td>Travel Limit (+) Input</td>
</tr>
<tr>
<td>18</td>
<td>Travel Limit (-) Input</td>
<td>Travel Limit (-) Input</td>
</tr>
<tr>
<td>19</td>
<td>Encoder Channel A (+)</td>
<td>Encoder Channel A (+)</td>
</tr>
</tbody>
</table>

*Table C.2: Driver Card Connector Pin-Outs*
<table>
<thead>
<tr>
<th>Pins</th>
<th>2 Phase Stepper Motor</th>
<th>DC Motor</th>
</tr>
</thead>
<tbody>
<tr>
<td>20</td>
<td>Encoder Channel B (+)</td>
<td>Encoder Channel B (+)</td>
</tr>
<tr>
<td>21</td>
<td>Encoder Supply: +5V</td>
<td>Encoder Supply: +5V</td>
</tr>
<tr>
<td>22</td>
<td>Encoder Ground</td>
<td>Encoder Ground</td>
</tr>
<tr>
<td>23</td>
<td>Encoder Channel A (-)</td>
<td>Encoder Channel A (-)</td>
</tr>
<tr>
<td>24</td>
<td>Encoder Channel B (-)</td>
<td>Encoder Channel B (-)</td>
</tr>
<tr>
<td>25</td>
<td>Encoder Index (-)</td>
<td>Encoder Index (-)</td>
</tr>
</tbody>
</table>

*Table C.2: Driver Card Connector Pin-Outs (Continued)*

### C.1.4 Signal Descriptions (Motor Driver Card, 25-Pin I/O Connector)

**DC Motor Phase(+) Output**

This output must be connected to the positive lead of the DC motor. The voltage seen at this pin is pulse-width modulated with a maximum amplitude of 48V DC.

**DC Motor Phase(-) Output**

This output must be connected to the negative lead of the DC motor. The voltage seen at this pin is pulse-width modulated with a maximum amplitude of 48V DC.

**Stepper Motor Phase 1 Output**

This output must be connected to Winding A+ lead of a two-phase stepper motor. The voltage seen at this pin is pulse-width modulated with a maximum amplitude of 48V DC.

**Stepper Motor Phase 2 Output**

This output must be connected to Winding A- lead of a two-phase stepper motor. The voltage seen at this pin is pulse-width modulated with a maximum amplitude of 48V DC.

**Stepper Motor Phase 3 Output**

This output must be connected to Winding B+ lead of a two-phase stepper motor. The voltage seen at this pin is pulse-width modulated with a maximum amplitude of 48V DC.

**Stepper Motor Phase 4 Output**

This output must be connected to Winding B- lead of a two-phase stepper motor. The voltage seen at this pin is pulse-width modulated with a maximum amplitude of 48V DC.

**Common Phase 3,4**

This output can be connected to the center tab of Winding A of a two-phase stepper motor. The voltage seen at this pin is pulse-width modulated with maximum amplitude of 48V DC.
**Common Phase 1,2**

This output can be connected to the center tab of Winding B of a two-phase stepper motor. The voltage seen at this pin is pulse-width modulated with a maximum amplitude of 48V DC.

**Travel Limit(+) Input**

This input is pulled-up to +5V with a 4.7KΩ resistor by the controller and represents the stage negative direction hardware travel limit. The active true state is user-configurable. (default is active HIGH).

**Travel Limit(-) Input**

This input is pulled-up to +5V with a 4.7KΩ resistor by the controller and represents the stage negative direction hardware travel limit. The active true state is user-configurable (default is active HIGH).

**Encoder A(+) Input**

The A(+) input is pulled-up to +5V with a 1KΩ resistor. The signal is buffered with a 26LS32 differential receiver. The A(+) encoder encoded signal originates from the stage position feedback circuitry and is used for position tracking.

**Encoder A(-) Input**

The A(-) input is pulled-up to +5V and pulled down to ground with 1KΩ resistors. This facilitates both single- and double-ended signal handling into a 26LS32 differential receiver. The A(-) encoder encoded signal originates from the stage position feedback circuitry and is used for position tracking.

**Encoder B(+) Input**

The B(+) input is pulled-up to +5V with a 1KΩ resistor. The signal is buffered with a 26LS32 differential receiver. The B(+) encoder encoded signal originates from the stage position feedback circuitry and is used for position tracking.

**Encoder B(-) Input**

The B(-) input is pulled-up to +5V and pulled down to ground with 1KΩ resistors. This facilitates both single- and double-ended signal handling into a 26LS32 differential receiver. The B(-) encoder encoded signal originates from the stage position feedback circuitry and is used for position tracking.

**Encoder Ground**

Ground reference for encoder feedback.
Home Input
This input is pulled-up to +5V with a 1KΩ resistor by the controller. The Home signal originates from the stage and is used for homing the stage to a repeatable location.

Index(+) Input
The (+) Index input is pulled-up to +5V with a 1KΩ resistor by the controller and is buffered with a 26LS32 differential receiver. The (+) Index signal originates from the stage and is used for homing the stage to a repeatable location.

Index(-) Input
The (-) Index input is pulled-up to +5V and pulled down to ground with 1KΩ resistors by the controller. This facilitates both single- and double-ended signal handling into a 26LS32 differential receiver. The (-) Index signal originates from the stage and is used for homing the stage to a repeatable location.

Encoder Supply: +5V, 250mA (Maximum)
A +5V DC supply is available from the ESP300. This supply is provided for stage home, index, travel limit, and encoder feedback circuitry.

Limit Ground
Ground for stage travel limit signals. Limit ground is combined with digital ground at the controller side.

Shield Ground
Motor cable shield ground.

C.1.5 Auxiliary Encoder Inputs
This 25 pin D-Sub connector provides input for 3 auxiliary encoder channels (axis 4, 5, 6). For signal description, see Section C.1.4. These channels can be used for master-slaving (see Section 4.2), trackball and other applications. Additionally, 4 digital I/O pins are provided (See Section C.1.2).
### Table C.3: Auxiliary Encoder Connector Pin-Outs

<table>
<thead>
<tr>
<th>Pin #</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Encoder Channel A (+), Axis 4</td>
</tr>
<tr>
<td>2</td>
<td>Encoder Channel A (-), Axis 4</td>
</tr>
<tr>
<td>3</td>
<td>Encoder Channel B (+), Axis 4</td>
</tr>
<tr>
<td>4</td>
<td>Encoder Channel B (-), Axis 4</td>
</tr>
<tr>
<td>5</td>
<td>Encoder Channel A (+), Axis 5</td>
</tr>
<tr>
<td>6</td>
<td>Encoder Channel A (-), Axis 5</td>
</tr>
<tr>
<td>7</td>
<td>Encoder Channel B (+), Axis 5</td>
</tr>
<tr>
<td>8</td>
<td>Encoder Channel B (-), Axis 5</td>
</tr>
<tr>
<td>9</td>
<td>Encoder Channel A (+), Axis 6</td>
</tr>
<tr>
<td>10</td>
<td>Encoder Channel A (-), Axis 6</td>
</tr>
<tr>
<td>11</td>
<td>N/C</td>
</tr>
<tr>
<td>12</td>
<td>N/C</td>
</tr>
<tr>
<td>13</td>
<td>N/C</td>
</tr>
<tr>
<td>14</td>
<td>Encoder Channel B (+), Axis 6</td>
</tr>
<tr>
<td>15</td>
<td>Encoder Channel B (-), Axis 6</td>
</tr>
<tr>
<td>16</td>
<td>Digital Input/Output 0</td>
</tr>
<tr>
<td>17</td>
<td>Digital Input/Output 1</td>
</tr>
<tr>
<td>18</td>
<td>Digital Input/Output 2</td>
</tr>
<tr>
<td>19</td>
<td>Digital Input/Output 3</td>
</tr>
<tr>
<td>20</td>
<td>+5V (500 mA max)</td>
</tr>
<tr>
<td>21</td>
<td>+5V (500 mA max)</td>
</tr>
<tr>
<td>22</td>
<td>DGND</td>
</tr>
<tr>
<td>23</td>
<td>DGND</td>
</tr>
<tr>
<td>24</td>
<td>N/C</td>
</tr>
<tr>
<td>25</td>
<td>N/C</td>
</tr>
</tbody>
</table>

#### C.1.6 IEEE-488 Interface Connector (24 Pin)

The IEEE488 Interface Connector has a standard configuration, as shown in Table C.4.

<table>
<thead>
<tr>
<th>Description</th>
<th>Pin #</th>
<th>Pin #</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>DIO1</td>
<td>1</td>
<td>13</td>
<td>DIO5</td>
</tr>
<tr>
<td>DIO2</td>
<td>2</td>
<td>14</td>
<td>DIO6</td>
</tr>
<tr>
<td>DIO3</td>
<td>3</td>
<td>15</td>
<td>DIO7</td>
</tr>
<tr>
<td>DIO4</td>
<td>4</td>
<td>16</td>
<td>DIO8</td>
</tr>
<tr>
<td>EOI</td>
<td>5</td>
<td>17</td>
<td>REN</td>
</tr>
<tr>
<td>DAV</td>
<td>6</td>
<td>18</td>
<td>GND</td>
</tr>
<tr>
<td>NRFD</td>
<td>7</td>
<td>19</td>
<td>GND</td>
</tr>
<tr>
<td>NDAC</td>
<td>8</td>
<td>20</td>
<td>GND</td>
</tr>
<tr>
<td>IFC</td>
<td>9</td>
<td>21</td>
<td>GND</td>
</tr>
<tr>
<td>SRQ</td>
<td>10</td>
<td>22</td>
<td>GND</td>
</tr>
<tr>
<td>ATN</td>
<td>11</td>
<td>23</td>
<td>GND</td>
</tr>
<tr>
<td>SIELD</td>
<td>12</td>
<td>24</td>
<td>SIGNAL GND</td>
</tr>
</tbody>
</table>

#### Table C.4: IEEE488 Interface Connector

#### C.1.7 RS-232C Interface Connector (9-Pin D-Sub)

The RS-232C interface uses a 9-pin sub-F connector. The back panel connector pin-out is shown in (Figure C.1).
Pin No.    Description
1  -15V
2  TXD
3  RXD
4  DTR
5  N/C
6  -15V
7  CTS
8  RTS
9  N/C

Figure C.1: RS-232C Connector Pin-Out

C.1.8 RS-232C Interface Cable

Figure C.2 shows a simple straight through, pin-to-pin cable with 9 conductors that can be used to connect to a standard 9 pin RS232 host.

Pin No.    Pin No.
1  1
2  2
3  3
4  4
5  5
6  6
7  7
8  8
9  9

9-Pin D-Sub
Male Connector
on Controller Side

9-Pin D-Sub
Female Connector
on Computer Side

Figure C.2: Conductor, pin-to-pin RS-232C interface cable

C.1.9 Motor Interlock Connector (BNC)

This connector is provided for the wiring of one or more remote Emergency Stop switches. They will have the same effect as the front panel STOP ALL button.

The switch has to be normally closed for operation. If more than one switch is installed, they should be connected in series. The minimum rating for the switches should be 50 mA at 5V.

The ESP300 is supplied with a dust cap that automatically provides the proper connection for operation if no switch is connected (See Figure C.3).
<table>
<thead>
<tr>
<th>Pin #</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Center Pin</td>
<td>Input Emergency Stop must always be connected to the shell (GND) during normal controller operation. An open circuit is equivalent to pressing STOP ALL on the front panel.</td>
</tr>
<tr>
<td>Connector Shield</td>
<td>Provides GND for switch</td>
</tr>
</tbody>
</table>

*Figure C.3: Motor Interlock Connector (BNC) with dust cap*
Some of the status reporting commands return an ASCII character that must be converted to binary. To aid with the conversion process, the following table converts all character used and some other common ASCII symbols to decimal and binary. To also help in working with the I/O port related commands, the table is extended to a full byte, all 256 values.

<table>
<thead>
<tr>
<th>Number (decimal)</th>
<th>ASCII Code</th>
<th>Binary Code</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>Null</td>
<td>00000000</td>
</tr>
<tr>
<td>1</td>
<td>Soh</td>
<td>00000001</td>
</tr>
<tr>
<td>2</td>
<td>Stx</td>
<td>00000010</td>
</tr>
<tr>
<td>3</td>
<td>Etx</td>
<td>00000011</td>
</tr>
<tr>
<td>4</td>
<td>Eot</td>
<td>00000100</td>
</tr>
<tr>
<td>5</td>
<td>Enq</td>
<td>00000101</td>
</tr>
<tr>
<td>6</td>
<td>Ack</td>
<td>00000110</td>
</tr>
<tr>
<td>7</td>
<td>Bel</td>
<td>00000111</td>
</tr>
<tr>
<td>8</td>
<td>Bs</td>
<td>00001000</td>
</tr>
<tr>
<td>9</td>
<td>Tab</td>
<td>00001001</td>
</tr>
<tr>
<td>10</td>
<td>Lf</td>
<td>00001010</td>
</tr>
<tr>
<td>11</td>
<td>Vi</td>
<td>00001011</td>
</tr>
<tr>
<td>12</td>
<td>Ff</td>
<td>00001100</td>
</tr>
<tr>
<td>13</td>
<td>Cr</td>
<td>00001101</td>
</tr>
<tr>
<td>14</td>
<td>So</td>
<td>00001110</td>
</tr>
<tr>
<td>15</td>
<td>Si</td>
<td>00001111</td>
</tr>
<tr>
<td>16</td>
<td>Dle</td>
<td>00010000</td>
</tr>
<tr>
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*Table D.1: Binary Conversion Table (using decimal and ASCII codes) (Continued)*
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Table D.1: Binary Conversion Table (using decimal and ASCII codes) (Continued)
The modular design of the ESP300 makes it easy for qualified individuals to upgrade the unit in the field. Upgrade kits to add more axis, IEEE488 or display option are available upon request. Call Newport for details.

This section describes how to upgrade an ESP300 from 2 to 3 axes. Other axes upgrades can be performed accordingly.

---

**WARNING**

Opening or removing covers will expose you to hazardous voltages.

Refer all servicing internal to this controller enclosure to qualified service personnel who should observe the following precautions before proceeding:

- Turn power OFF and unplug the unit from its power source
- Disconnect all cables
- Remove any jewelry from hands and wrists
- Use only insulated hand tools
- Maintain grounding by wearing a wrist strap attached to instrument chassis.

---

**CAUTION**

The ESP contains static sensitive devices. Exercise appropriate caution when handling ESP300 boards, cables and other internal components.
CAUTION

Do not install anything into your ESP300 except items provided by Newport specifically for installation into the ESP300.

E.1 Adding Axes

1. Turn the power off and unplug the power cord from the controller. Disconnect all cables from the controller.

2. Remove the 3 screws, two as shown and one is on the Rear Panel which is labeled “Cover Tab with Screw. See (Figure E.1), which shows how to remove the cover.

3. Carefully remove the top cover.
4. Insert the driver module for the respective axis. The connector of the driver module is keyed to prevent insertion with improper polarity. Make sure the keys line up properly before you try to insert the module (See Figure E.2).

5. Attach the driver panel to the rear panel of the unit with the two supplied screws.

6. Re-install the top cover.

The unit is now ready for use.

---

E.2 Adding IEEE488

1. Follow steps 1 – 3 adding axes.

2. Insert the IEEE-488 driver module in the connector. The connector of the module is keyed to prevent insertion with improper polarity. Make sure the keys line up properly before you try to insert the module.

3. Attach the IEEE-488 panel to the rear panel of the unit with the two supplied screws.

4. Re-install the top cover.

The unit is now ready for use.
1. Follow steps 1-3 of adding axis (See Section E.1).
2. Disconnect the 40 pin ribbon connector on the display side.
3. Remove the two screws as shown (See Figure E.3).

Remove the 2 screws, as shown. Remove 6 screws on the bottom of unit that attach Front Panel to Chassis.

Figure E.3: How to remove screws inside the unit for the Front Panel

4. Remove the 6 screws on the bottom of the unit that attach the Front Panel to the unit chassis.
5. Attach the new front panel option by installing the 6 screws on the bottom and the two screws inside the unit.
6. Connect the front panel with the 40 pin ribbon connector.
7. Re-install the top cover.

The unit is now ready for use.
Appendix F – ESP Configuration Logic

Each time a stage or stages are disconnected/re-connected, or a system is powered down and then back up, the ESP300 controller card verifies the type of stage(s) present and re-configures its own flash memory if necessary (i.e., new stage). The controller card in the ESP300 system configuration, the stage motor and the current type are defined, the controller card will configure the specific axis. Specific ESP logic is shown in (Figure F.1).
Is An ESP Stage Present?

Was An ESP Stage Present?

Was Same

Yes

No

Copy ESP Stage Data To Controller Flash Memory

Is Drive Axis Present?

Yes

Is Motor Current Defined?

Yes

Configure Stage Axis

No

No

Erase Controller Flash Memory And Load Default Parameters

Figure F.1: Configuration Logic
Newport positioners, or stages, with integrated configuration memory devices are said to be "ESP Compatible". It is not necessary to manually enter individual stage parameters (e.g., motor current, maximum velocity, etc.) with an ESP compatible stage. All necessary configuration settings will be automatically loaded after system reset with ESP compatible positioners.

When a positioner is said to be ESP incompatible, all that really means is that it does not have the integrated memory device that allows for automatic configuration. Therefore, it will have to be configured manually – as is customary with all non-ESP controllers.

There are two (2) basic levels of positioner configuration. The first level assumes that the stage is Newport controller compatible. That is to say that hardware travel limits, encoder feedback counting, etc… are designed to operate with Newport controllers. In this case only a certain amount of commands are necessary to setup the axis before moving the stage. The second level is when a stage is not a standard Newport stage and various compatibility issues need to be addressed. This scenario requires additional command configurations.

The following are examples of how to configure an ESP controller axis for a standard Newport stage that is not equipped with the "ESP Compatible" memory device (i.e., level 1):

Example #1: DC Servo on axis 1

1qm1 // set motor type to DC servo
1qi0.15 // set motor maximum current to 0.15 amps
1qv30 // set motor voltage to 30 volts
1sn7 // set user units to degrees
1su0.005 // set resolution to 0.005 degrees
1vu15 // set maximum velocity to 15 deg/sec
1va7 // set working velocity to 7 deg/sec
1oh7 // set homing speed to 7 deg/sec
1jh7 // set jog high speed to 7 deg/sec
1jw1 // set jog low speed to 1 deg/sec
1au40 // set maximum acceleration to 40 deg/sec²
1ac20  //set working acceleration to 20 deg/sec^2
1ag25  //set deceleration to 25 deg/sec^2
1fe0.5  //set following error threshold to 0.5 deg
1kp600  //set PID proportional gain to 600
1kd600  //set PID derivative gain to 600
1ki350  //set PID integral gain to 350
1ks300  //set PID integral saturation gain to 300
1tj1  //set trajectory mode to trapezoidal
1qd  //update motor driver configuration
sm  //save configuration to non-volatile memory

Example #2: Stepper stage on axis 1

1qm3  //set motor type to commutated stepper
       (ESP300 only)
1qi 1  //set motor maximum current to 1 amp
1qv30  //set motor voltage to 30 volts
1sn2  //set user units to millimeters
1su0.001  //set resolution to 1 micron
1fr0.01  //set stepper motor full step resolution to 10 micron
1qs100  //set micro-stepping resolution to 100x
1vu20  //set maximum velocity to 20 mm/sec
1va10  //set working velocity to 10 mm/sec
1jh10  //set jog high velocity to 10 mm/sec
1jl1  //set jog low velocity to 1 mm/sec
1oh10  //set Homing velocity to 10 mm/sec
1au50  //set maximum acceleration to 50 mm/sec^2
1ac 50  //set acceleration to 30 mm/sec^2
1ag30  //set deceleration to 30 mm/sec^2
1fe1  //set following error threshold to 1 mm
1tj1  //set trajectory mode to trapezoidal
1qd  //update motor driver configuration
sm  //save configuration to non-volatile memory

The following commands should be reviewed for proper axis compatibility when connecting to a non-Newport stage – assuming that it is electrically compatible with the controller (i.e., level 2):

ZA  //set amplifier configuration
ZB  //set feedback configuration
ZH  //set hardware limit configuration
Appendix H – Factory Service

This section contains information regarding factory service for the ESP300 System. The user should not attempt any maintenance or service of the system or optional equipment beyond the procedures outlined in the Trouble-Shooting appendix of this manual. Any problem that cannot be resolved should be referred to Newport Corporation. Technical Customer Support contact information is listed in Table H-1.

<table>
<thead>
<tr>
<th>Contact</th>
<th>Information</th>
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<tbody>
<tr>
<td>Telephone</td>
<td>1-800-222-6440 ext. 31694</td>
</tr>
<tr>
<td>Fax</td>
<td>1-949-253-1479</td>
</tr>
<tr>
<td>Email</td>
<td><a href="mailto:istd.service@newport.com">istd.service@newport.com</a></td>
</tr>
</tbody>
</table>

Table H-1: Technical Customer Support Contacts

Contact Newport to obtain information about factory service. Telephone contact number(s) are provided on the Service Form (see next page). Please have the following information available:

- Equipment model number (ESP300)
- Equipment serial number (for the ESP300)
- Distribution revision number from a floppy disk
- Problem description (document using the Service Form, following pages)

If the instrument is to be returned for repair, you will be given a Return Authorization Number that should be referenced in your shipping documentation. Complete a copy of the Service Form on the next page and include it with your shipment.
H.1 Service Form

Newport Corporation
U.S.A. Office: 800-222-6440
FAX: 949/253-1479

Name ___________________________________ RETURN AUTHORIZATION # _______________________
(Please obtain prior to return of item)

Company __________________________________________________________________________________

Address _______________________________________________ Date ________________________

Country ________________________________________ Phone Number _______________________

P.O. Number ____________________________________ FAX Number ________________________

Item(s) Being Returned:

Model # __________________________________ Serial # ________________________________

Description: __________________________________________________________________________

Reason for return of goods (please list any specific problems) ______________________________________

____________________________________________________________________________________

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