IsoUs – Ultimate Step
Plugin – Work Origins

www.promax.it

PROMAX Motion & Control

2

1 Work Origins

Work Origins allows manual managing of the **WORK ORIGINS**.

1.1 PlugIn Using

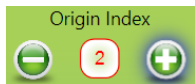The **WORK ORIGINS**, are very important in the Gcode file execution.

These allow to work the Gcode file in different positions on the **WORK PLANE**.

IsoUs can use up to **256 DIFFERENT ORIGINS** which can be called by Gcode with function **G54**, or this PlugIn.

The **ORIGINS VALUES**, are saved automatically in the *"ZERI.VAL"*, therefore is sufficient to copy this file in a new IsoUs installation, to get all origins. Work Origins allows to activate new **ORIGINS** manually, but these will be **SAVED** in the file *"ZERI.VAL"* only if is inserted the **PASSWORD LEVEL 2**

1.1.1 Activate an Origin by Index

Can be used up to **256 DIFFERENT ORIGINS**. These are activated by **BUTTONS**:

Choose the desired **ORIGIN INDEX** and confirm by **BUTTON OK**:

The selected origin will be activated and confirmed in the following field:

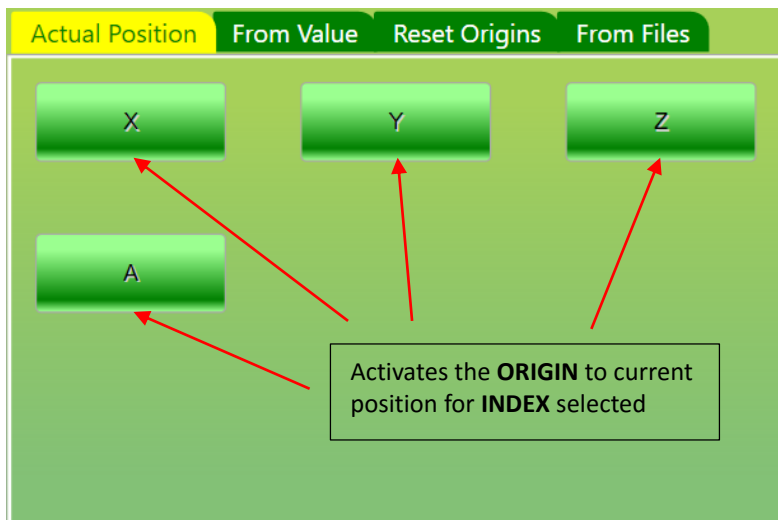The **ORIGINS VALUES** are showed in the fields:

Origin Value	
X	1000
Y	2000
Z	3000
A	4000

1.1.2 Set an Origin from Current Axes Position

In some situations, is necessary set the **ORIGIN** from **CURRENT AXES POSITIONS**.

Therefore select the **TAB** *"Actual Position"*

The new **ORIGINS**, will be saved in the file *"ZERI.VAL"* only with if inserted the **PASSWORD LEVEL 2**

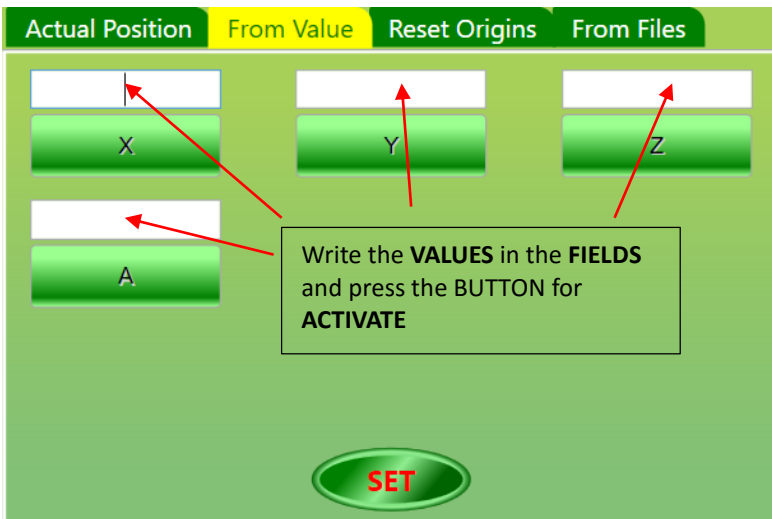Activates the **ORIGIN** to current position for **INDEX** selected

4

1.1.3 Set an Origin from Value

The **ORIGINS** can be set by **DIRECT VALUE**, without move the axes in the origin position.
Therefore select the **TAB** *"From Value"*
The new **ORIGINS**, will be saved in the file *"ZERI.VAL"* only with if inserted the **PASSWORD LEVEL 2**

For this operation there are **2 MODE** for **ORIGIN VALUE:**

 Push for toggle

"SET" , the Axis will get the **ORIGIN FROM VALUE WRITTEN IN THE RELATIVE FIELD.**
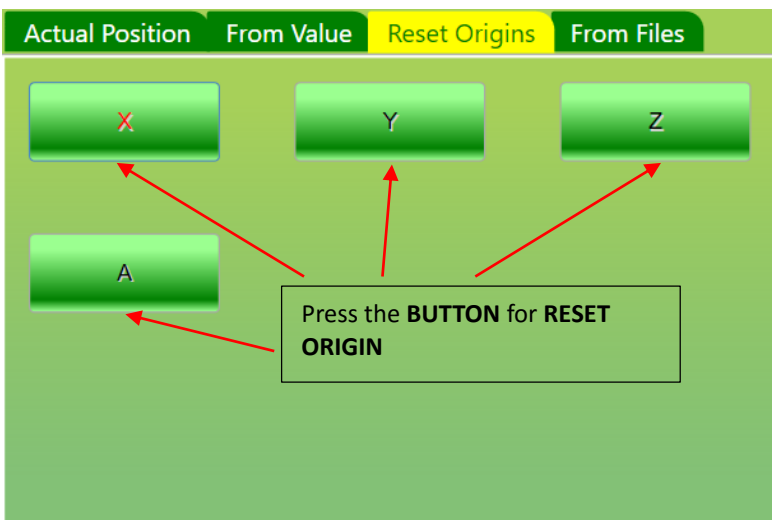
 Push for toggle

"PRESET", The Axis **WILL TAKE THE CURRENT POSITION EQUAL TO VALUE WRITTEN IN THE RELATIVE FIELD.**
The **ORIGIN** will not be set to value written in the field, but to a **DIFFERENT VALUE** so that the Axis will get the
CURRENT POSITION equal to value written.

1.1.4 Origin Reset

This operation **RESET** the **WORK ORIGIN**.
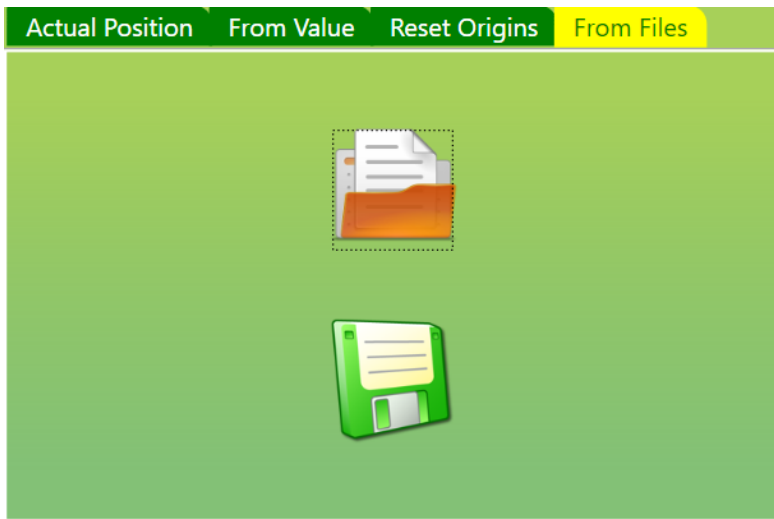Therefore select the **TAB** *"Reset Origins"*

1.1.5   Manage Origins File

Can be saved the many **ORIGINS FILE** .
For use this function, must be inserted the **PASSWORD LEVEL 2**
Therefore select the **TAB** *"From Files"*

Load an **ORIGIN FILE**

Save the current **ORIGIN** in a **FILE**

Index