

# Adapt axis settings

For the commissioning of a real machine, some important information is still missing in the data layer of the ctrlX. As a workaround, this data is saved in the PLC and can be edited in the WebIQ HMI. See **Commissioning> Axis**.

When the PLC program is started, the saved setting is compared with the existing axes to determine changes. If a deviation is detected, an administrator must adapt the configuration.

## Axis settings

Label	Meaning
Axis PROJECT	Name of all axes defined in project
Axis CFG	Name of all axes stored in config file
	Displaying both axis name enables you to detect differences between project and stored configuration.  If the configuration does not match the project: - Revise settings - Copy axis names with button "Copy name" - Save changes
Jog. Rel.	Enables relative Jog in widget cx-jog
Ref. Abs.	Enables setting of absolute reference in widget cx-jog
Ref. Drive	Enables drive-based referencing in widget cx-jog
Ref. Drive Pos.	Show position input field for drive-based referencing. While all parameters for drive-based homing are stored in the drive, sending the position to the drive must be implemented in <b>FB_Machine_Customer.mSetDriveHomingParams()</b>
Mode in Auto	OP mode, which is set, when axis does not belong to a kinematic
Kin. axis?	Checked if axis is part of any kinematic

Mold	Ejector	Core pullers	Inputs/Outputs	System Information	System Status	Jog	Axis	Kinematics				
Save		⚙										
⚙	⚙	⚙	⚙	⚙	⚙	⚙	⚙	⚙	⚙	⚙	⚙	⚙
Axis #	Axis PROJECT	Axis ==	Axis CFG	Axis \$[axisType]	Axis max. Jog Vel.	Axis Unit	Axis Jog Rel.	Axis Ref. Abs.	Axis Ref. Drive	Axis Ref. Drive Pos.	Axis Mode in AUTO	Axis Kin. axis?
1	X	==	X	virtual	100.0	mm/s	✓	✓		✓	ModeAH	✓
2	Y	==	Y	virtual	100.0	mm/s	✓	✓		✓	ModeAH	✓
3	Z	==	Z	virtual	100.0	mm/s	✓	✓		✓	ModeAH	✓
4	X1	==	X1	virtual	900.0	mm/s	✓	✓		✓	ModeAH	✓
5	Y1	==	Y1	virtual	900.0	mm/s	✓	✓		✓	ModeAH	✓
6	Z1	==	Z1	virtual	900.0	mm/s	✓	✓		✓	ModeAH	✓
7	LinAbs	==	LinAbs	virtual	900.0	mm/min	✓	✓		✓	ModeAH	✓
8	LinMod	==	LinMod	virtual	600.0	mm/min	✓	✓		✓	ModeStop	
9	RotAbs	==	RotAbs	virtual	600.0	rpm	✓	✓			ModeStop	
10	RotMod	==	RotMod	virtual	600.0	rpm	✓	✓			ModeStop	
11		==		virtual	0.0						ModeStop	
12		==		virtual	0.0						ModeAB	
13		==		virtual	0.0						ModeAB	
14		==		virtual	0.0						ModeAB	
15		==		virtual	0.0						ModeAB	
16		==		virtual	0.0						ModeAB	
17		==		virtual	0.0						ModeAB	
18		==		virtual	0.0						ModeAB	
19		==		virtual	0.0						ModeAB	

Copy

Paste

▲

▼

Copy name

To set other application specific settings, see **FB\_Machine\_Customer/00\_Init/mUserCfg**.