

Backlash Comp parameters in SINUMERIK Operate

Parameter	Value	Unit	Display
38118(0) SMA_CTRLOUT_MODULE_NR	1		po
38128(0) SMA_CTRLOUT_NR	1		po
38138(0) SMA_CTRLOUT_TYPE	8		po
38132(0) SMA_IS_VIRTUAL_AX	0		po
38134(0) SMA_IS_UNIPOLAR_OUTPUT	0		po
38200 SMA_NUM_ENCS	1		po
38228(0) SMA_ENC_MODULE_NR	1		po
38228(1) SMA_ENC_MODULE_NR	1		po
38238(0) SMA_ENC_INPUT_NR	1		po
38238(1) SMA_ENC_INPUT_NR	2		po
38248(0) SMA_ENC_TYPE	8		po
38248(1) SMA_ENC_TYPE	8		po
38242(0) SMA_ENC_IS_INDEPENDENT	0		cf
38242(1) SMA_ENC_IS_INDEPENDENT	0		cf
38244(0) SMA_ENC_MEAS_TYPE	1		po
38244(1) SMA_ENC_MEAS_TYPE	1		po
38258(0) SMA_ACT_POS_ABS	0		po
38258(1) SMA_ACT_POS_ABS	0		po

MD30200 sets the number of measuring systems applied to the axis. If this is set to 1, there is only one encoder. The maximum is two per axis.

Axis+ and **Axis-** toggle between the axes to be edited. The current edited axis is displayed in the top-right corner of the screen on the blue bar.

Parameter	Value	Unit	Display
32438(2) SMA_AX_JERK_VEL1	236.228472448...	inch/min	cf
32438(3) SMA_AX_JERK_VEL1	236.228472448...	inch/min	cf
32438(4) SMA_AX_JERK_VEL1	236.228472448...	inch/min	cf
32438(0) SMA_MAX_AX_JERK_FACTOR	1		cf
32438(1) SMA_MAX_AX_JERK_FACTOR	1		cf
32438(2) SMA_MAX_AX_JERK_FACTOR	1		cf
32438(3) SMA_MAX_AX_JERK_FACTOR	1		cf
32438(4) SMA_MAX_AX_JERK_FACTOR	1		cf
32448 SMA_LOOKAH_FREQUENCY	10 Hz		cf
32458(0) SMA_BACKLASH	8	inch	cf
32458(1) SMA_BACKLASH	8	inch	cf
32452(0) SMA_BACKLASH_FACTOR	1		cf
32452(1) SMA_BACKLASH_FACTOR	1		cf
32452(2) SMA_BACKLASH_FACTOR	1		cf
32452(3) SMA_BACKLASH_FACTOR	1		cf
32452(4) SMA_BACKLASH_FACTOR	1		cf
32452(5) SMA_BACKLASH_FACTOR	1		cf
32458(0) SMA_BACKLASH_DYN	8	inch	cf

MD32450 (Backlash Comp) There are two indexes for this machine data—index (0) and (1). If **MD30200** is set to a (1), use index (0) in **MD32450**. If **MD30200** is set to a (2), **MD32450 (1)** is the position feedback axis.

Index (0) is for axis with indirect feedback and index (1) is for an axis with direct feedback.

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