

P4-S pendant PathPilot driver Installation

1. Reboot the PathPilot PC and when you see the "TORMACH" splash screen, hold down the left SHIFT and ALT keys to boot into desktop.

2. Copy and move following files to the PathPilot PC under `/home/operator`

```
Makefile  
vc-p4s  
vc-p4s-pp.hal  
99-vistacnc-pendant.rules
```

3. Double click **Makefile**, select **Run**. This will install

```
vc-p4s to /usr/bin  
99-vistacnc-pendant.rules to /lib/udev/rules.d
```

4. Copy and move **vc-p4s-pp.hal** to `/home/operator/tmc/configs/tormach_mill` directory

5. Open and add following lines (**in bold font**) to **tormach_1100-3.ini** files (in `/home/operator/tmc/configs/tormach_mill` directory):

```
[HAL]  
HALFILE = my-mill.hal  
HALFILE = custom.hal  
HALFILE = vc-p4s-pp.hal  
POSTGUI_HALFILE = custom_postgui.hal  
HALUI = halui
```

6. Step size selection is defined in `vc-p4s.hal`. To change or add stepsize, open and edit the numbers (**in bold font**) in `vc-p4s.hal` file.

```
#P4-S pendant settings  
#STEP SIZE, SET 0 TO SKIP.  
setp stepsize-1 0.0001  
setp stepsize-2 0.001  
setp stepsize-3 0.01  
setp stepsize-4 0.1  
setp stepsize-5 0  
setp stepsize-6 0  
setp stepsize-7 0  
setp stepsize-8 0  
setp stepsize-9 0
```

7. Limitations

Following P4-S features are not compatible with v1.9

Feedrate F% mode, Spindle S% mode, Program Start/Hold, Program Stop, Spindle on/off, E-stop.