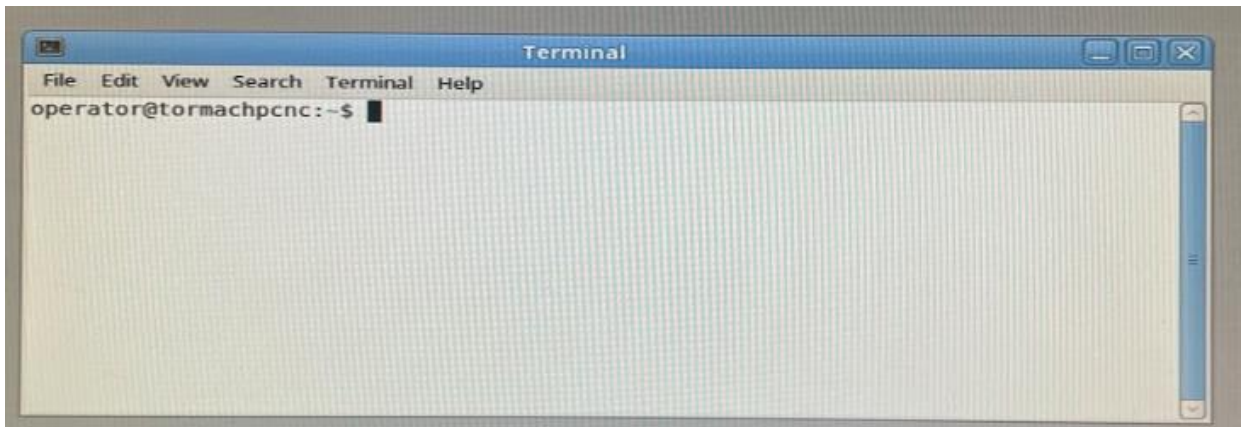


## P1A-S pendant PathPilot Installation

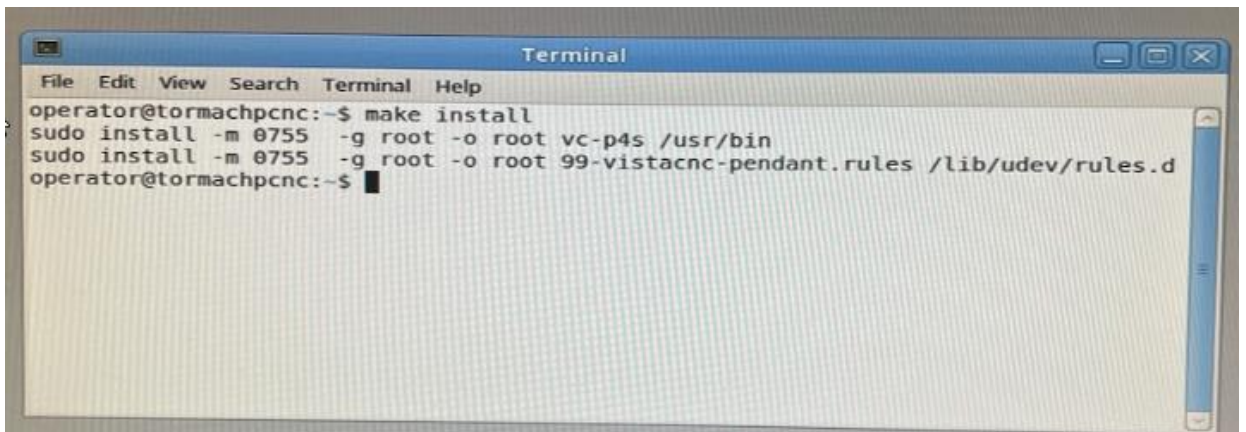
1. Refer to “iMach3 Pendant FW update procedure” to upgrade the pendant firmware (FW) to LinuxCNC if the pendant was used with another CNC application. The upgrade application needs to run on a Windows PC.
2. Reboot the PathPilot PC, and when you see the "TORMACH" splash screen, hold down the left SHIFT and ALT keys to boot into desktop.
3. Copy and move the following files to the PathPilot PC under /home/operator. “vc-p1as” is in folder “vc-p1as 64bit”.

```
Makefile  
vc-p1as  
vc-p1as-pp.hal  
99-vistacnc-pendant.rules
```

4. Open a terminal Window: (Following pictures show P4-S pendant installation)



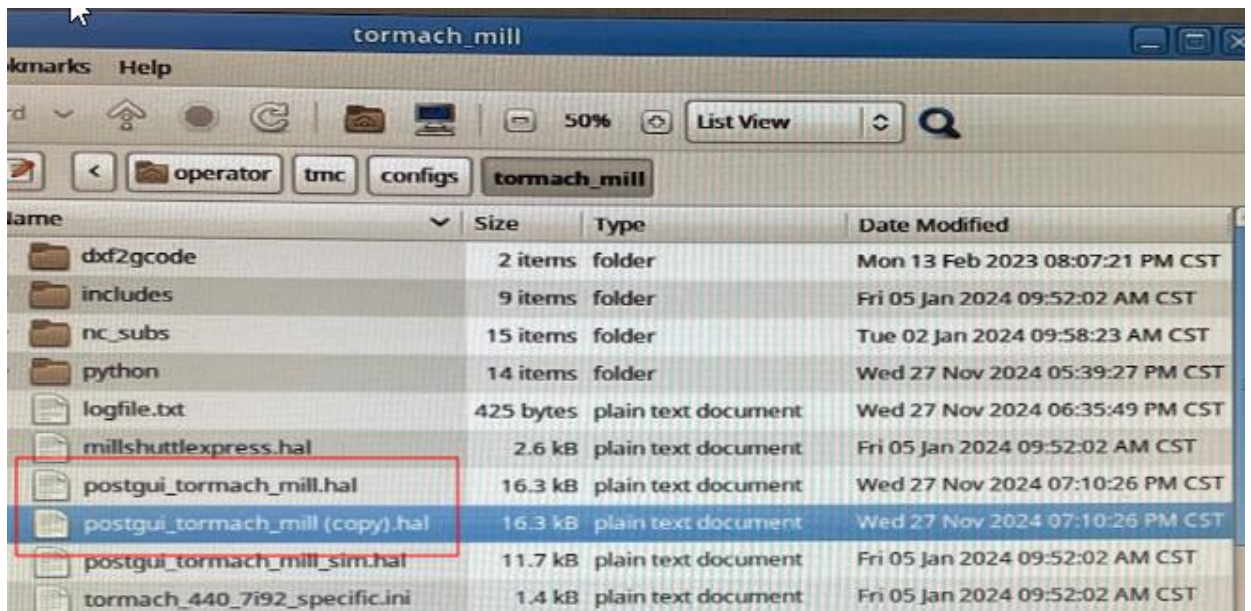
5. Type “make install” followed by Enter.



This moves: **vc-plas** to **/usr/bin**  
**99-vistacnc-pendant.rules** to **/lib/udev/rules.d**

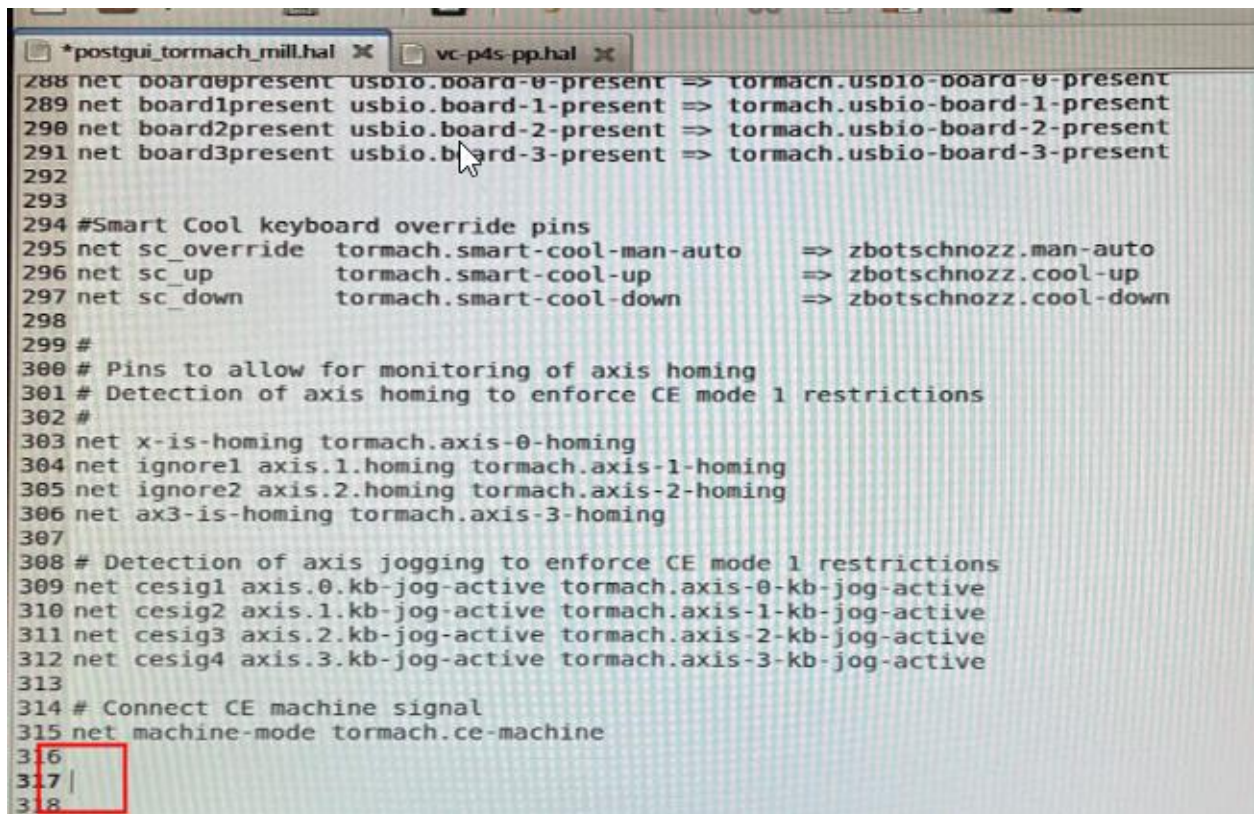
6. Copy and move **vc-plas-pp.hal** to  
`/home/operator/tmc/configs/tormach_mill` directory
7. Go to `/home/operator/tmc/configs/tormach_mill` directory, make a backup file of  
"postgui\_tormach\_mill.hal" :

Select "postgui\_tormach\_mill.hal", do a **Ctrl + C**, then **Ctrl + V**. It creates file  
"postgui\_tormach\_mill(copy).hal"



8. Open "**vc-plas-pp.hal**" and "postgui\_tormach\_mill.hal".
9. Copy and paste the whole content of "**vc-plas-pp.hal**" to the end of  
"postgui\_tormach\_mill.hal" :

on **vc-plas-pp.hal**, do **Ctrl + A** then **Ctrl + C**; then on "postgui\_tormach\_mill.hal",  
move the cursor to the end of the file, do **Ctrl + V**.



```
*postgui_tormach_mill.hal
vc-p4s-pp.hal

288 net board0present usbio.board-0-present => tormach.usbio-board-0-present
289 net board1present usbio.board-1-present => tormach.usbio-board-1-present
290 net board2present usbio.board-2-present => tormach.usbio-board-2-present
291 net board3present usbio.board-3-present => tormach.usbio-board-3-present
292
293
294 #Smart Cool keyboard override pins
295 net sc_override tormach.smart-cool-man-auto => zbotschnozz.man-auto
296 net sc_up tormach.smart-cool-up => zbotschnozz.cool-up
297 net sc_down tormach.smart-cool-down => zbotschnozz.cool-down
298
299 #
300 # Pins to allow for monitoring of axis homing
301 # Detection of axis homing to enforce CE mode 1 restrictions
302 #
303 net x-is-homing tormach.axis-0-homing
304 net ignore1 axis.1.homing tormach.axis-1-homing
305 net ignore2 axis.2.homing tormach.axis-2-homing
306 net ax3-is-homing tormach.axis-3-homing
307
308 # Detection of axis jogging to enforce CE mode 1 restrictions
309 net cesig1 axis.0.kb-jog-active tormach.axis-0-kb-jog-active
310 net cesig2 axis.1.kb-jog-active tormach.axis-1-kb-jog-active
311 net cesig3 axis.2.kb-jog-active tormach.axis-2-kb-jog-active
312 net cesig4 axis.3.kb-jog-active tormach.axis-3-kb-jog-active
313
314 # Connect CE machine signal
315 net machine-mode tormach.ce-machine
316
317 |
318
```

10.

Following P1a-S features are not compatible with v1.x and v2.x

Feedrate F% mode, Spindle S% mode.