

P1A-S pendant LinuxCNC driver Installation

1. Copy and move following files to LinuxCNC PC

Makefile

vc-plas

vc-plas.hal

vc-plas-postgui.hal

99-vistacnc-pendant.rules

2. Put **Makefile**, **vc-plas** and **99-vistacnc-pendant.rules** to "src" under home directory `~/src$`. If there is a **Makefile** in that directory, name that make file to different name, like **Makefile_old**.
3. Open a terminal window, and at your home directory, type **make install**, this will install

vc-plas to `/usr/bin`

99-vistacnc-pendant.rules to `/lib/udev/rules.d`

4. Put **vc-plas.hal** and **vc-plas-postgui.hal** to the directory in which the `.ini` file is located, normally it is under "your home directory"/`linuxcnc/configs`
5. Open and add following lines (**in bold font**) to `.ini` file:

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

```
[HALUI]
MDI_COMMAND=...
MDI_COMMAND=...
MDI_COMMAND=...
MDI_COMMAND=...
MDI_COMMAND=...
MDI_COMMAND=G10 L20 P1 X0
MDI_COMMAND=G10 L20 P1 Y0
```

```
MDI_COMMAND=G10 L20 P1 Z0
MDI_COMMAND=G0 X0 Y0 Z0
MDI_COMMAND=G10 L20 P1 A0
```

6. The number of decimal digit to display and step size selections are defined in `vc-plas.hal`:

```
.
.
#PlA-S pendant settings
#number of decimal digit to display on axis DRO,
#settable number:2,3,4
setp vc-plas.decimal 3

#step size, set 0 to skip.
setp vc-plas.stepsize-1 0.0001
setp vc-plas.stepsize-2 0.001
setp vc-plas.stepsize-3 0.01
setp vc-plas.stepsize-4 0.1
setp vc-plas.stepsize-5 1
setp vc-plas.stepsize-6 10
setp vc-plas.stepsize-7 0
setp vc-plas.stepsize-8 0
setp vc-plas.stepsize-9 0
```