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From: Greg Sorvari  
Date: 1/3/95  
Subject: PCM-23 Revision A3

PART NUMBER: 400291-01  
REV: A1

## **Cam Start Options**

The PCM-23 now has added options in the Cam Start Mode. If the Start Mode selected is Point Start, the user has 4 options to select from.

The Point Start Select options are:

- 1) Match Follower to Master
- 2) Index to Match Master
- 3) Index to Table
- 4) Follower Wait for Master

If options 2 and 3 are selected, the user has an option as to what type of index is used -- this is the new feature. Note that 2 and 3 are the only options that initiate with an index. The index type selection is done through the "FF" command with bit 6 and bit 7 (bit 0 LSB, bit 7 MSB).

In order to change index types, first select the correct profile in the Cam Start Mode screen (This can also be changed and/or verified through the "CY" command). The following steps must be done in terminal mode. To change index types you must read the current value of the "FF" command. The value returned is in hexadecimal. To change the index type you must "OR" in one of the four index choices and enter it as a 2 digit hexadecimal number.

The 4 options for index choices are:

- 1) Within range - follower flags (FF command) - 00XXXXXX binary
- 2) Shortest Path - follower flags (FF command) - 01XXXXXX binary
- 3) CW only - follower flags (FF command) - 10XXXXXX binary
- 4) CCW only - follower flags (FF command) - 11XXXXXX binary

Example:

Say you want to set the index type of profile 2 to Shortest path. Select profile 2 in the Cam Start Mode screen. Go in to terminal mode by typing "Alt-d" then type "FF?" -- the system may return a "2". If you "OR" in the bit 6 you would get 42 hex. You then type FF = 42. You can confirm entry by typing "CY?" (this should return a "CY = 2"), and then by typing "FF?" (this should return a "FF = 42").

## **Cam Start Velocity Change**

One other change in revision A3 for the PCM-23 is the Index speed that may be used for Cam Start Mode. It will now have the correct velocity based on the velocity entered in the Cam Start Mode screen.

\*\* This is 10x faster than the previous versions of firmware \*\*