

Open Series Osai Controller

How to Adjust Soft Limits on HDS, HDS-F, Venture, and Venture + Models:



Step 1 – From the HDS interface, click on the ODM button as displayed in the figure 1.

Step 2 – Once the ODM screen is opened click the + symbol on IP 192.168.0.1, + AMP, + AMP3 (Or whatever amp has a blue clock next to it), + Process







Step 3 – Once you have the 'Process' tab opened, you can then click on the x, y, and z axes. In each of

these menus you will be able to change the coordinate value for the soft limits under the tab labeled

'Dynamic Characters'.

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Hardware	Percentage of VFF	100	[%]	
	Maximum Feed	1650.0	[inch / min]	
E III Process	Rapid Traverse Feed	1650.0	[inch / min]	
(1) Axis X	Rapid Acceleration	80.0	[inch / s * s]	
	Rapid Deceleration	80.0	[inch / s * s]	
🖉 [04] Secondary Gantry Axis y	Rapid Acceleration Jerk	1100.0	[inch / s * s * s]	
	Rapid Deceleration Jerk	1100.0	[inch / s * s * s]	
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AMP OPENControl	Working Deceleration Ramp Time	0.0	[ms]	
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Step 4 – Once you have made the desired changes to your soft limits, you must always click 'save'

located at the bottom of the window, then 'compile amp' located on the tool bar at the top of the screen.



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Step 5 – Once the controller has finished compiling the new settings you have edited, you must then restart the controller. There are two ways this can be done. First, you can shut down the computer and the machine like you would at the end of the work day. Second, which is the slightly more efficient way; you can navigate to the Boot Control Screen and click the tab at the top of the screen that looks like a rocket ship. Once you do, a screen will pop up asking you if you would like to restart the boot control. By clicking 'ok' you will prompt a reboot of the Osai Controller. Once the controller is reset, the new soft limits will be adjusted and used during operations.

Techno CNC Systems

## support.technocnc.com

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17/09/2014 16:11:45.342 - Log:	31/12 - Broadcasting definition			
17/09/2014 16:11:45.342 - Log:	31/2 - Boot Services			
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17/09/2014 16:11:49.360 - Log:	31/3 - Boot PLC			
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17/09/2014 16:11:49.364 - Log:	31/6 - Boot Motion			
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