

The Instruction Set of the TANGO Controller



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2. Introduction

Communication interface:

All TANGO controllers communicate via a serial COM port interface, independent of the controller type (RS232C, USB, PCI, PCI-E). The default setting is 57600,8,2,N.

Axes:

TANGO controllers are available with up to 4 axes. The axis specifiers used in the TANGO instruction set are the ASCII characters *x*, *y*, *z*, and *a*. Axes can be addressed individually by using the axis specifier or combined if no axis is specified in the instruction.

Instruction syntax:

The instructions and parameters are sent as cleartext ASCII strings with a terminating carriage return [CR], which is 0x0d hex. Characters may be upper-, lower- or camel-case. The parameters are separated by a space character. This provides easy access to all functions by using a simple terminal program such as HyperTerminal. A typical instruction syntax is as follows:

```
[!,?][instruction][SP][optional axis] [parameter1][SP][parameter2] [etc...] [CR]
```

[!,?] Read/write specifier, required by most instructions **:

! (exclamation mark) = to write parameter, execute an instruction etc.

? (question mark) = to read data (returns settings, or status, etc.)

[instruction] Is the instruction word itself.

[SP] Space (ASCII 0x20 hex) as separation.

[optional axis] Axis character *x*, *y*, *z* or *a* if only one axis must be addressed.

[parameter] Usually integer or floating point numbers, floating point uses decimal point, no comma.

[CR] Termination (ASCII 0x0d hex), causes instruction execution.

A read instruction may return more than one parameter. In many cases the number of returned parameters depends on the amount of available axes:

```
[axis X] [if available: axis Y] [if available: axis Z] [if available: axis A]
```

For some instructions that return fractional numbers (e.g. *?pitch*, *?gear*, *?vel*, *?encperiod* and more) the number of returned fractional digits can be specified in order to increase resolution when reading back the value. For *'?pos'* and similar position returning functions (e.g. *'lim'*), the number of fractional digits can be set by the **'resolution'** parameter. Replies are terminated by **[CR]**.

Syntax examples:

```
!vel 10 1.5      set velocities for the first two axes
!cal            perform a calibration move to lower limit with all active axes
!moa y 10.1     move y axis to absolute position 10.1
?pos           returns position of all axes (e.g. 0.0000 0.0000 0.0000)
?vel x         returns velocity setting of X axis only (e.g. 10.000)
```

Moves:

Move instructions are executed as a vector move (except when in scanmode). If several axes are started with one instruction they will reach their destinations at the same time. This means that - depending on velocity, acceleration and travel distance - one leading axis travels at its full velocity while the others follow synchronously. To move axes independently with their individual velocities, they have to be started separately by using single axis instructions. Please refer to the **'move'** instruction descriptions.

Settings:

Most settings can be stored permanently in the TANGO controller, so they are available from power on. When stored once, this reduces initialization overhead of the application software. Refer to the '**save**' instruction for further information. Parameters that are saved can be identified by a 'Y' in the Save column of the **brief instruction set description** later in this document.

Character limits:

To prevent the input buffer from overflow, please do not send more than 255 characters at once.

Such may occur when sending the setup sequence to the TANGO controller. A good practice is to request the '**?err**' state after each setup instruction. This will return the information if the parameters were accepted or not while preventing overflow.

Another solution is to activate the '**!cts**' handshake (available only with Desktop RS232C and some USB versions). This will automatically halt the PC transmission for as long as the input buffer is full. The PC COM port then must be opened with hardware handshake on, as well. Please refer to the '**!cts**' instruction description.

Important: Secure speed limitation

The TANGO controllers have a built in safety function, which reduces the maximum travel velocity to a secure 10mm/s for as long as no initial '**cal**' and '**rm**' moves have been executed. This is to prevent the driven axis from damage that could be caused by moving fast into its end positions. After calibrating the axis into its endswitches (cal and/or rm if switches are mounted and enabled) the travel velocity is no longer limited.

If it is not wanted or impossible to perform calibration and range measure after each power on:

- A) The secure speed limit may be increased to up to 100mm/s at own risk. Please refer to the '**secvel**' instruction for further information.
- B) The **!rm** can be skipped by instead using **!vrm** (please read remarks).
- C) Non existent limit switches can be deactivated (by **swact**) and then do not require a **!rm**. In such case **secvel** will be released after **!cal**.

Important: Measuring units

The measuring unit is set by the '**dim**' instruction, where dim 2 [which is mm] is the default setting.

In all dim settings except of dim 9, the velocity (vel) is in motor revolutions per second. Only dim 9 provides the millimeter unit for most parameters¹, positions and velocities.

Extended mode:

In addition to the improvements when using dim 9 units, there is an option to enable extended mode behavior. It enables more functionality, like separate calibration, rm and joystick velocities, which else are the same as the axis velocity (vel). Please refer to the '**extmode**' instruction for further details.

Remarks:

** [!,?] Read/write specifier:

Even if not required (optional) with some instructions (e.g. moa, mor, m, go, etc.), the response in **autostatus mode 2** depends on the exclamation mark. If this special autostatus mode is required, it must be taken care of whether or not the [!] is used. Refer to **autostatus** for further information.

¹ Only **calbspeed** and **calrefspeed** are always in 1/100 revolutions/sec, even in dim mode 9

3. Remarks concerning the controller initialization

The TANGO controller must be configured to meet the hardware requirements. The configuration can be stored permanently with the **save** instruction. It is recommended to save and reboot the controller after changing the setup parameters (e.g. **!usteps**, **!pitch**, **!gear**) to ensure all changes will be applied.

- The axis units: **!dim**
- The **!extmode** (0 or 1)
- The axis **!pitch** (always in [mm], independent of **dim**)

Dim 9 and Extmode:

Using *dim=9* and *extmode=1* instead of *dim=2* will turn all units (also *vel* and *joyvel*) to [mm] and [mm/s]. *Extmode=1* offers bugfixes, more features (e.g. separate *joyvel*) and flexibility. But it has a slightly different behavior. Please refer to the **Extended Mode** description in this document.



Brief Description of the TANGO Instruction Set

Controller Informations					
Instruction	Example	Save	Example description	Page	
(?)	version	version	-	Read detailed firmware and controller version	18
(?)	det	det	-	Read the controller configuration	19
(?)	detext	detext	-	Read the controller configuration and descriptive text list	19
?	readsn	?readsn	-	Read the controller serial number	20
(?)	ver	ver	-	Read default version number	20
(?)	iver	iver	-	Read further version number information	20
(?)	uptime	uptime	-	Read how long the controller is running	21
(?)	temp	temp	-	Read case temperature (avail. depends on controller type)	21
?	maxaxis	?maxaxis	-	Read number of available axes	21
?	maxcur	?maxcur	-	Show the maximum possible motor currents of all axes	21
?	etspresent	?etspresent	-	Check availability of ETS	22
?	stagesn	?stagesn	-	Read the axis serial numbers from ETS	23
?	maxpos	?maxpos x	-	Read maximum available position range for X axis	23
?	lockpos	?lockpos	-	Read the microscope stage transport lock (screw) position	24

Communication Interface Settings					
Instruction	Example	Save	Example description	Page	
? !	baud	!baud 115200	Y	Set RS232 baud rate (here to 115200Bd, default is 57600)	25
? !	cts	!cts 1	Y	Enable CTS hardware handshake	25

System Instructions					
Instruction	Example	Save	Example description	Page	
(!)	save	save	-	Save parameters to controller nonvolatile memory	26
(!)	restore	restore	-	Reload saved controller parameters from n.v. memory	26
(!)	reset	reset	-	Reset controller (forces restart, similar to cycle power)	27
? !	pa	!pa 1	-	Power amplifiers ON (OFF=0), also refer to 'axis' instr.	28
? !	ipreter	!ipreter 2	Y	Select optional Venus instruction set	29

Operating Modes					
Instruction	Example	Save	Example description	Page	
? !	extmode	!extmode 1	Y	Enable extended controller behavior	30
? !	scanmode	!scanmode 1	Y	Set positioning behavior to scanmode	31
? !	scanvel	!scanvel 0.5	Y	Set scanmode vector velocity to 0.5 mm/s	32
? !	modulomode	!modulomode a 1	Y	Set positioning behavior of A axis to turntable mode 1	33

Controller States and Error Messages					
Instruction	Example	Save	Example description	Page	
? !	autostatus	!autostatus 0	-	Select autostatus response type 0 (=disabled), range: [0-4]	34
(?)	statusaxis	statusaxis	-	Read axis state [@,M,J,C,S,A,D,-]	35
(?)	corrst	corrst x	-	Read state of position correction	35
(?)	status	status	-	Read controller error state	36
(?)	err	err	-	Read error number	36
(?)	help	help	-	Read error number with additional descriptive text	36
(?)	service	service	-	Returns a detailed parameter and state list, for debugging	37
(?)	pci	pci	-	Returns 1 if controller is plugged in a PCI slot (desktop=0)	37
(?)	isvel	?isvel x	-	Read actual velocity of the X axis	37
(?)	iscur	?iscur x	-	Read the momentarily applied motor current of the X axis	38



General Adjustments					
Instruction	Example	Save	Example description	Page	
?!	dim	!dim 1 1 1	Y	Set position measuring units of X Y Z to μm	39
?!	pitch	!pitch 1 1 1	Y	Set spindle pitch of X Y Z to 1 [mm/revolution]	40
?!	gear	!gear 1 1 1	Y	Set gear factor of X Y Z to 1	40
?!	motorsteps	!motorsteps x 200	Y	Set motor step type of X to 200 [steps/rev] for a 1.8° motor	41
?!	accel	!accel 0.1 0.1 0.1	Y	Set acceleration of X Y Z to 0.1m/s ²	42
?!	accelfunc	!accelfunc 1 1 0	Y	Set acceleration function X and Y to s-curve, Z to linear	42
?!	stopaccel	!stopaccel 2 2	Y	Set stop deceleration for X and Y to 2m/s ²	43
?!	vel	!vel 10 10 10	Y	Set axis velocity of X Y Z to 10	44
?!	velfac	!velfac 1 1 1	Y	Set velocity reduction factor for X Y Z to 1 (= no reduction), range is [0.01-1], use not recommended	45
?!	secvel	!secvel x 20	Y	Set secure speed limit X to 20mm/s (unit is always mm/s)	45
?!	cur	!cur 0.5 0.6 1	Y	Set motor current in Ampere: X=0.5 Y=0.6 and Z=1 A	46
?!	reduction	!reduction 0.5 0.5 0.5	Y	Set idle motor current reduction for X Y Z to 50%	47
?!	curdelay	!curdelay 1000 1000	Y	Set idle motor current reduction delay for X,Y to 1000 [ms]	48
?!	ecomove	!ecomove 30 30 0	Y	Set motor move eco-level of X and Y to 30% less current	48
?!	axis	!axis 1 0 -1	Y	Enable X, disable Y and switch off Z axis	49
?!	axisdir	!axisdir 0 1 0	Y	Reverse rotating direction of Y motor (caution!)	49
?!	motortable	!motortable x 2	Y	Select custom motor correction table to type 2 for X axis	50
?!	usteps	!usteps 50000	Y	Set dim 0 microsteps per rev to 50000 (applies to all axes)	50
?!	resolution	!resolution 6	Y	Set ?pos position resolution to 6 fract.digits (0.000001mm)	51
?!	backlash	!backlash 12.3 0 0	Y	Set backlash compensation to 12.3 μm in X and 0 in Y & Z	51
?!	lock	!lock 2 1	Y	Set write protection for parameter 2 (here: motor current)	52
?!	lockaxis	!lockaxis 0 0 0 0	Y	Remove lock protection from all axes (lock has no effect)	52
?	lockstate	?lockstate x	-	Read extended locked parameters, including internal limitations currently applied to X axis	53
?!	stout	!stout 2	Y	Make Status-LED state available at AUX-I/O Pin VR_OUT	53
?!	noled	!noled 1	Y	Switch Status-LED permanently off	54
?!	updelay	!updelay -5000	Y	Wait to a maximum of 5 seconds for valid external power	54

Limit Switch Instructions (Hardware and Software)					
Instruction	Example	Save	Example description	Page	
?!	lim	!lim 0 10 0 10 0 10	-	Set lower position limit to 0 and upper limit to 10 (assume unit is [mm] if dim was set to 2) for X Y Z	55
?!	clim	!clim 50 70 10	-	Set circular limit at center X=50, Y=70 with radius 10	55
?!	limctr	!limctr x 0	-	Disable axis limits for X axis, default = 1	56
?!	nosetlimit	!nosetlimit 1 1 1 1	Y	Disable setting/overwriting of software limits during cal and rm for all axes (here: X Y Z A), default = 0	56
?!	swtyp	!swtyp 1 0 1 !swtyp y 0 0 0	Y	Set limit switch type for all axes to NPN (pull-up resistor) Set limit switch type for Y to PNP (pull-down resistor)	57
?!	swpol	!swpol 1 0 1 !swpol z 1 0 1	Y	Set limit switch polarity E0, EE for all axes (to active high) Set limit switch polarity E0, EE for Z (1=to active high)	58
?!	swact	!swact 1 0 1 !swact y 1 0 0	Y	Enable cal and rm limit switches for all axes Enable cal limit switch for Y, disable ref and rm	59
?!	swdir	!swdir x 1	Y	Swap CAL and RM endswitch assignment of X axis	60
?	readsw	?readsw	-	Read states of all limit switches (1=active and actuated)	61
(?)	swin	swin	-	Read TTL signal level of all limit switch inputs (1=high)	61
(?)	statuslimit	statuslimit	-	Read current limit status „A“ = calibration done „D“ = rm done „L“ = limit switch modified by software „-“ = not yet modified	62

**Calibration and Range Measure Instructions**

Instruction	Example	Save	Example description	Page
(!) cal	cal	-	Perform a calibration move for all enabled axes, see 'axis'	63
(!) rm	rm x	-	Perform a range measure move in X	64
(!) vrm	vrm 75 50	-	Virtual range measure for a 75x50 microscope stage	65
? ! calmode	!calmode 2 2	Y	Set calibration/closed loop behavior X, Y to type 2	66
? ! calrequired	!calrequired z 1	Y	Z axis does not move until !cal is executed	66
? ! caltimeout	!caltimeout 60 60 10	Y	Set calibration timeout for X and Y to 1 minute, Z to 10s	67
? ! caliboffset	!caliboffset 1 1 1	Y	Set the cal zero-point 1mm aside lower limit switch (dim 2)	68
? ! rmooffset	!rmooffset 1 1 1	Y	Set rm end-position 1mm aside upper limit switch (dim 2)	68
? ! caldir	!caldir z 1	Y	Dummy function, please use axisdir instruction	68
? ! calbspeed	!calbspeed 20	Y	Set the speed for move out of 'cal' and 'rm' limit switches for all axes to 0.2 [revolutions/s], range is [1...100]	69
? ! calrefspeed	!calrefspeed 10	Y	Set the speed for calibrating to the encoder reference for all axes to 0.1 [revolutions/s], range is [1...100]	69
? ! encrefvel	!encrefvel 5 5 5	Y	Set the speed for calibrating to the encoder reference for axes X,Y,Z to 5 [rev/s] if dim=2, [mm/s] if dim=9	70
? ! calpos	calpos	-	Read back the encoder position where the calibration switch was released	71
? calzeropos	?calzeropos	-	Read the "zero" position after cal (for calmode 1)	71
? ! refdir	?refdir y	Y	Read the direction for encoder reference search in Y axis	70
? ! calvel	!calvel x 10 0.5	Y	Only if extmode = 1: Set calibration velocities in X	72
? ! rmvel	!rmvel x 10 0.5	Y	Only if extmode = 1: Set range measure velocities in X	73
? ! autopitch	!autopitch x 1	Y	Measure pitch after cal move of X axis	73

Move Instructions

Instruction	Example	Save	Example description	Page
(!) moa	moa 10 10 10 moa y 20	-	Move X Y Z absolute to positions 10 10 10 Move Y axis to position 20 (unit depends on dim setting)	75
(!) mor	mor 4 4 4 mor y -10.5	-	Move X Y Z relative by 4 (unit depends on dim setting) Move Y axis relative 10.5 backwards	75
(!) m	m	-	Move relative again (use same parameters as defined by last '!mor' or '!distance' instruction)	76
? ! distance	!distance 1 1 1	-	Set distance for X Y Z 'm'-move (start with 'm' or '!m')	76
(!) moc	moc x	-	Move X to center position between lower and upper limit switch, or between lower and upper software limits	76
(!) mol	mol	-	Move all axes to their transportlock positions (fix. screw)	77
(!) go	go x 12.5	-	Move X to pos. 12.5, overwriteable, for tracking applications	78
? ! speed	!speed 5 5 5 !speed y 0	-	Let X Y Z axis travel at 5 [revolutions/s] Stop the Y axis speed move	79
(!) a	a	-	Abort move (Stop)	79
? ! delay	!delay 1000	Y	Delay the start of move instructions by 1000 ms	80
? ! pause	!pause 10	Y	Delay "position reached" autostatus response by 10 ms	80
? ! pos	!pos 0 0 1.5 ?pos z	-	Set current X Y positions to 0 and Z position to 1.5 Read current Z position	81
(!) posclr	!posclr x	-	Reset the position offset that was manipulated by !pos	81
(!) zero	!zero z	-	Set Z position and internal counter to 0 (e.g. filter wheel application)	82
(!) clearpos	!clearpos z	-	Set Z position and internal counter to 0 (e.g. filter wheel application), not executable with measuring system	82

HDI Instructions (Joystick, Trackball, ERGODRIVE)

Instruction	Example	Save	Example description	Page
? ! joy	!joy 0 !joy 2	Y	Switch joystick ON=2 or OFF**=0 (**Switching off may cause an autostatus response)	83

**HDI Instructions (Joystick, Trackball, ERGODRIVE)**

Instruction	Example	Save	Example description	Page	
?!	joydir	!joydir 2 -2 0	Y	Set HDI axis mode to X=ON, Y=Reversed, Z=OFF	84
?!	joychangeaxis	!joychangeaxis 1	Y	Change Joystick X and Y axis (X→Y, Y→X)	84
?!	joywindow	!joywindow 14	Y	Set idle window of the joystick center position, where a joystick deflection has no effect [0..100]	84
?!	joyvel	!joyvel z 1.5	Y	Only if extmode = 1: Set joystick velocity for Z to 1.5	85
?(!)	joyspeed	joyspeed 2 25	Y	Set joystick speed for speed button 2 "medium" to 25 rev/s	85
?!	keymode	!keymode 2	Y	Select joystick key mode 2 = high speed preselection	86
?!	keyspeed	!keyspeed x 5 20	Y	Set keymode joystick speed X low=5mm/s, high=20mm/s	87
?(!)	joycurve	!joycurve z 1	Y	Set joystick characteristic for Z ot linear	87
(?)	key	key	-	Read state of all joystick buttons (0=released, 1=pressed)	88
(?)	keyl	keyl	-	Read and clear latched state of all joystick buttons	88
?!	hwfactor	!hwfactor x 1	Y	One coaxial drive knob revolution in X is 1mm axis travel	89
?!	hwfactorb	!hwfactorb x 14	Y	One coaxial drive knob revolution in X is 14mm axis travel	89
?!	hwfilter	!hwfilter 0	Y	Deactivate coaxial drive noise reduction	89
?!	tbfactor	!tbfactor 1 1	Y	Set trackball transmission factor in X and Y to default	90
(?)	zwheel	?zwheel	-	Returns 1 if HDI device has a multi-function wheel	91
?(!)	zwtravel	!zwtravel 1 0.25	Y	Set default multi-function wheel travel to 2.5 mm/rev	91
?!	zwaxis	!zwaxis a	Y	Assign multi-function wheel to A-axis	92
?!	zwfactor	!zwfactor 1	Y	Set multi-function wheel factor to 1:1 (default)	92
(?!)	zwpos	zwpos	-	Read independent multi-function wheel position counter	92
?!	tvrjoy	!tvrjoy z	Y	Assign AUX-IO pulse&direction device to Z axis	93
?!	tvrjoyf	!tvrjoyf 1	Y	Set tvrjoy transmission factor to 1	93
(?)	hdi	hdi	-	Read ID number of the connected HDI device	94
!?	hdimode	!hdimode 0 1	Y	Set hdimode bit 0 to 1 for ERGODRIVE Toggle Mode	95
!?	configaxsel	!configaxsel 1	Y	Toggle joystick Z-axis between axes Z and A by F4 key	96

Digital and Analogue I/O

Instruction	Example	Save	Example description	Page	
(?)	digin	digin digin 8	-	I/O1 Extension module: Read all digital inputs I/O1 Extension module: Read digital input 8	98
?!	digout	!digout 5 1 ?digout	-	I/O1 Extension module: Set digital output 5 to logic level 1 I/O1 Extension module: Read back all digital output levels	98
?!	diginpol	!diginpol 5 1	Y	I/O1 Extension module: Invert input 5 signal	99
?!	digintyp	!digintyp 111111	Y	I/O1 Extension module: Apply pull-up resistor to all inputs	99
?!	digoutpreset	!digoutpreset 3 1	Y	I/O1 Extension module: Preset state of output 3 to high	100
(?)	edigin	edigin edigin 8	-	Multi I/O Extension: Read all digital inputs Multi I/O Extension: Read digital input 8	101
?!	edigout	!edigout 5 1 ?edigout	-	Multi I/O Extension: Set digital output 5 to logic level 1 Multi I/O Extension: Read back all digital output levels	101
?!	ediginpol	!ediginpol 5 1	Y	Multi I/O Extension: Invert input 5 signal	102
?!	edigintyp	!edigintyp 111111	Y	Multi I/O Extension: Apply pull-up resistor to input 0-5	102
?!	edigoutpreset	!edigoutpreset 3 1	Y	Multi I/O Extension: Preset state of output 3 to high	103
(?)	adigin	adigin adigin 2	-	Read all AUX-I/O digital inputs Read logic level of AUX-I/O digital input 2 only	104
?!	adigout	!adigout 3 1 ?adigout	-	Set AUX-I/O digital output 3 to logic level 1 Read back all digital output levels	104
(?)	anain	anain c 2	-	Read input of analogue channel 2	105
?!	anaout	!anaout c 1 17.5	-	Set analogue voltage of channel 1 to 17.5 percent (1.75V)	106
?!	anamode	!anamode 0	N	Set analogue output mode to default behavior	106
?!	stoppol	!stoppol 1	Y	Set AUX-IO stop input to active high	107
!	stop	!stop 0	-	Release stop condition (in latched stoppol modes 4 or 5)	108
?!	shutter	!shutter 1	-	Set AUX-IO shutter out signal to TTL high	108

**Digital and Analogue I/O**

Instruction	Example	Save	Example description	Page
(!) flash	flash 0.1	-	Send a 100µs high pulse to AUX-IO TAKT_OUT (LED)	109
? ! tvr	!tvr z 5	Y	Enable AUX-IO TVR pulse and direction for Z axis	109
? ! brake	!brake 0 0 1	Y	Enable Brake for Z axis on I/O extension output pin 0	110
? ! drop	!drop 5	-	Liquid Dispenser: generate 5 drops or dispense for 5 sec.	111
? ! pump	!pump 1	-	Liquid Dispenser: Switch on air pressure pump manually	112

Encoder Instructions

Instruction	Example	Save	Example description	Page
? ! encmask	!encmask 1 1 0	Y	Enable the activation of X and Y encoders, disable Z	113
? ! enc	!enc 1 0	-	Manually activate X encoder (caution!), set Y to inactive	114
? ! encperiod	!encperiod 0.1	Y	Set signal period of X encoder to 100 µm	114
? ! encctype	!encctype x 1	Y	Set encoder type of X to TTL (no analogue sin/cos signal)	116
? ! encctl	!encctl x 1	Y	Set encoder type of X to TTL (no analogue sin/cos signal)	117
? ! encdir	!encdir y 1	(Y)	Reverse counting direction for Y encoder (caution!)	115
? ! encvel	!encvel x 0.5	Y	Set auto-adjust velocity of X encoder to 0.5mm/s	115
? ! encref	!encref 1 1 0	Y	Enable encoder reference signal for X and Y, disable for Z	117
? ! encnas	!encnas 1 0 0	Y	Enable NAS error signal input encoding for X encoder only	118
(?) encrefstatus	!encrefstatus x	-	Read X encoder reference signal state (1=on reference)	118
(?) encrefstatusl	!encrefstatusl x	-	Read latched X encoder reference signal state	118
(?) encnasstatus	!encnasstatus x	-	Read X encoder NAS signal state (1=NAS error)	119
? ! encerr	!encerr 0	-	Clear encoder error state for X axis (? response is 0 or e)	119
? ! encamp	?encamp x	-	Read X encoder signal amplitude in percent	119
? ! encpos	!encpos 1	-	?pos instruction returns for the encoder positions, if enc=1	120
(?) hwcount	hwcount	-	Read all encoder positions (TTL counter, non interpolated)	120
(!) clearhwcount	clearhwcount x	-	Set hwcount encoder position counter to zero, here: X axis	120

MR Encoder Instructions

Instruction	Example	Save	Example description	Page
? ! mra	?mra x	-	Read amplitude correction factor (sin/cos ratio) of X	121
? ! mro	?mro	-	Read offset correction value for all encoders	121
? ! mrp	!mrp x 0 0 0 0	-	Reset MR-signal peak-to-peak measurement result of X	122
? mrt	?mrt z 2	-	List two measurement results of the Z input signals	122

Closed Loop Instructions

Instruction	Example	Save	Example description	Page
? ! ctr	!ctr 2 2 2	Y	Set closed loop mode of X Y Z to always active (=default)	126
? ! ctrf	!ctrf 2.0	Y	Closed loop factor for X axis is set to 2.0	127
? ! ctrff	!ctrff 2 3.5	Y	Closed loop factors for X axis are set to 2 and 3.5	127
? ! ctrd	!ctrd 100	Y	Closed loop in target window for 100 milliseconds	128
? ! ctrt	!ctrt 200	Y	Closed loop control timeout after 200 milliseconds	128
? ! twi	!twi 0.01 0.01 0.01	Y	Set target window for X Y Z to 10µm (assume dim=2)	129
? ! ctrc	!ctrc 3	Y	Closed loop control is called every 3 millisecond	129
? ! ctrsm	!ctrsm x 1	Y	Set X behavior outside lock-in range to "slow closed loop"	130
? ! ctrs	!ctrs x 0.2	Y	Set lock-in range for X to 0.2mm (assume dim=2)	130
? ctrstatus	?ctrstatus 1	-	Get Closed Loop active state of all axes	131
? ctrdiff	?ctrdiff	-	Get Closed Loop position difference of all axes	132

**Trigger Output Functionality¹**

Instruction	Example	Save	Example description	Page
? ! trig	!trig 1	-	Enable trigger functionality (should be the last instruction)	133
? ! trigm	!trigm 0	Y	Select trigger mode 0	134
? ! triga	!triga x	Y	Trigger function is related to X axis	136
? ! trigo	!trigo 1	Y	Select the default trigger signal output	136
? ! trigs	!trigs 40	Y	Set trigger output signal length to 40 microseconds	137
? ! trigd	!trigd 10	Y	Set trigger distance to 10 (mm if dim=2)	136
? ! trigcomp	!trigcomp 50	Y	Compensate a trigger signal delay of 50µs	138
? ! trigenc	!trigenc 1	Y	Select encoder signal as trigger source (if available)	139
? ! trigf	!trigf 1000	Y	Set periodic trigger pulse frequency to 1kHz	139
? ! trigbdelay	!trigbdelay 15.05	Y	Set Precise secondary trigger out to 15.05µs delayed	140
? ! trigbwidth	!trigbwidth 4.35	Y	Set Precise secondary trigger out signal length to 4.35µs	140
? ! trigbf	!trigbf 66000000	Y	Set Precise secondary trigger out frequency to 66 MHz	140
? ! trigcount	?trigcount	-	Read number of generated trigger events	141
(!) trigger	trigger	-	Manually set trigger output (available in trigm 102, 103)	141
? ! trigr	!trigr 5 10 6	-	Generate 6 trigger signals from 5 to 10→5,6,7,8,9,10 (mm)	142
? ! trigp	!trigp -1 12.5	-	Append a position value to the trigger position list	145
? ! trigc	?trigc	-	Read number of entries in trigp trigger position list	148
? ! trigi	?trigi	-	Read or manipulate the momentary list index of trigp, trigr	148
? ! trigl	!trigl 1	Y	Set trigger signal level for !trigr and !trigp to active high	149

Snapshot - Trigger Input Functionality¹

Instruction	Example	Save	Example description	Page
? ! sns	!sns 1	-	Enable snapshot functionality (always 1 after power up)	156
? ! sns1	!sns1 0	Y	Set snapshot input signal to active low	156
? ! snsf	!snsf 10	Y	Set snapshot signal debounce filter to 10 milliseconds	156
? ! sns1	!sns1 5	-	Set snapshot index to 6 th entry (snsa 6)	160
? ! snsaxis	!snsaxis 1 1 0 0	-	X and Y axis moves wait for snapshot (in sns1 mode 6)	161
? ! snsx	?snsx	-	Read last captured X position	162
? ! snsy	?snzy	-	Read last captured Y position	162
? ! snsz	?snz	-	Read last captured Z position	162
? ! sns1	?sns1	-	Read first position entry of snapshot array (all axes)	162
(!) snse	snse 2	-	Generate SnapShot event F2	163
? ! snsv	?snsv 3	-	Read captured ANIN0 voltage in mV of 3 rd snapshot entry	163
? ! snsj	!snjs 1 0.5 0 0	-	Set snapshot jump distances (snapshot mode sns1 9)	164
? ! prehome	!prehome 10 20 1	-	Set prehome positions X Y Z to 10 20 1 (unit depends on dim setting)	164
? ! home	!home 5 5 0	-	Set home positions X Y Z to 5 5 0 (unit depends on dim setting)	164

¹ Function has to be enabled by factory, it is not available per default.

4. Instruction Syntax Description

Most instructions work in both directions (reading and writing). (?)! means the instruction accepts write and read access. The controller identifies a read instruction by a preceding '?', while '!' indicates writing to a parameter or executing an instruction. More information can be found in the **Introduction** chapter of this document.

Some examples of legal instruction syntax:

```
!Instruction parameter1 parameter2 parameter3 parameter4
!Instruction parameter1 parameter2
!Instruction axis parameter
!Instruction
?Instruction axis parameter
?Instruction
```

5. Error Numbers and their possible Root Cause

```
0    no error
1    no valid axis name
2    no executable instruction
3    too many characters in command line
4    invalid instruction
5    number is not inside allowed range
6    wrong number of parameters
7    either ! or ? is missing
8    no TVR possible, while axis active
9    no ON or OFF of axis possible, while TVR active
10   function not configured
11   no move instruction possible, while joystick enabled
12   limit switch active
13   function not executable, because encoder detected
21   multiple axis moves are forbidden (e.g. during initialization)
22   automatic or manual move is not allowed (e.g. door open or initialization)
27   emergency STOP is active
29   servo amplifiers are disabled (switched OFF)
30   safety circuit out of order

70   wrong CPLD data
71   ETS error
72   parameter is write protected (check lock bits)
73   internal error, e.g. eeprom data corruption
74   closed loop switched off due to parameter change
75   could not enable axis correction, or axis correction was disabled
76   io extension error (output overload on IO1 or Multi-IO connector)
77   io extension internal communication error (internal bus error)
78   HDI input device error
79   xPos module error
```



6. Controller Informations

The firmware version may be read by sending the instruction '**version**' to the controller. The instruction '**det**' gives further details of which options and features are enabled. Each controller has its own unique serial number readable with the instruction '**readsn**'.

6.1. version (Read detailed Version information)

Syntax: ?version or version
Parameter: none or 1

Description: Read the TANGO type and firmware version.

Sending the version instruction with parameter 1 returns the TANGO firmware version number only.

Response syntax: Character string including controller type, firmware version and build date separated by a comma, e.g.
TANGO-DT-S, Version 1.57, Apr 17 2012 , 12:12:02

TANGO-DT	Desktop version, PCI card based
TANGO-DT-S	Desktop version, PCI-S card based
TANGO-DTe	Desktop version, PCI-E card based
TANGO-PCI	PCI card
TANGO-PCI-S	PCI-S card
TANGO-PCIE	PCI-E card (PCI Express)
TANGO-MINI	TANGO mini
TANGO-C	Motorized stage with integrated controller
TANGO-I	TANGO integrale controller
Version 1.57	Firmware version number
Apr 17 2012	Firmware build date
12:12:02	Firmware build time

Example:

```
?version ==> TANGO-DT-S, Version 1.57, Apr 17 2012 , 12:12:02  
?version 1 ==> 1.57
```

6.2. det (Read detailed Configuration)

Syntax: ?det or det
Parameter: none

Description: Read detailed information of the controller configuration.

Response: The response is a decimal integer number. Its bit pattern represents the configuration as described below:

```
0x0 - - - - 1   configured encoder interface = 1Vpp
0x0 - - - - 2   configured encoder interface = MR
0x0 - - - - 4   configured encoder interface = TTL
0x0 - - - - 8   configured encoder interface = Universal 1V+MR
0x0 - - - 3 -   the number of configured axes (e.g. 3)
0x0 - - 1 - -   Display is configured
0x0 - - 2 - -   Speedpoti is configured
0x0 - - 4 - -   Hand wheel is configured
0x0 - - 8 - -   Snapshot (Trigger in) is configured
0x0 - 1 - - -   TVRin is configured
0x0 - 2 - - -   Trigger out is configured
0x0 - 8 - - -   TVRout is configured
0x0 1 - - - -   digital extension: I/O1      (24in+8out)
0x0 2 - - - -   digital extension: Multi I/O (12in+8out)
0x0 4 - - - -   Trackball is configured
0x0 8 - - - -   ETS is connected
0x1 - - - - -   xPos Module (3 axis extension)
```

Individual configured options can be identified by applying a logic AND mask to the returned value.

E.g. (val & 0x0800) to identify if Snapshot instructions are available/configured by factory, (val & 0x02000) for Trigger.

Example: Assume the ?det response is 81697, which is 0x13F21 hex. This number means in detail, that the controller is configured for:

```
1 => Built in digital I/O extension with 24in + 8out
3 => TVRin and Trigger out
F => Display, Speedpoti, Hand wheel and Snapshot
2 => 2 axes
1 => 1Vpp encoder
```

6.3. detext (Read Extended detailed Configuration)

Syntax: ?detext or detext
Parameter: none

Description: Read Detailed information of the controller configuration as multi-line readable text (description strings). Each line is terminated by a [CR].

Response: Multi line reply, containing the configuration number as hex value (bit representation as describet with 'det'), and the meaning of it as multi line text.

Example:

```
detext           =>    02832
                  = MR Encoder
                  = 3 Axes
                  = Snapshot
                  = Trigger out
```

6.4. readsn (Read Serial Number)

Syntax: ?readsn or readsn
Parameter: none

Description: Reads the serial number of the TANGO controller.

Response: The controller returns its unique serial number as ASCII character string. The syntax is YYWWTNXXX.

YY year of manufacturing
WW week of manufacturing
T type identifier
N in hardware available axes (may differ from ?maxaxis)
XXX index number

Example: ?readsn => 083303007

6.5. ver (Read default Version Number)

Syntax: ?ver or ver
Parameter: none

Description: Read the default controller version info. The first digit is the number of configured axes. The second digit is the maximum possible motor current in ampere.
To read the TANGO firmware version, please use '**version**'.

Response syntax: Vers:LSnm.xx.xxx (in some cases "Vers:ESnm.xx.xxx")

"Vers:LS" Fixed character string (also "Vers:ES" possible)
n Number of configured axes: 1, 2, 3, or 4
m Maximum Motor current: 1=1.25A, 2=2.5A, 3=3.75A
x Fixed numbers

Example: ?ver => Vers:LS32.00.038 (=3 axis 2.5 A)

6.6. iver (Read internal Version Number)

Syntax: ?iver or iver
Parameter: none

Description: Read the internal version information string. Mostly unused.
To read the TANGO firmware version, please use '**version**'.

Response syntax: 14 characters, e.g. T[DD].[WW].[YY]-[NNNN]
[DD] = Day of Week
[WW] = Week
[YY] = Year
[NNNN] = Number

Example: ?iver => T04.35.02-0004

6.7. uptime (Read Controller Up Time)

Syntax: ?uptime or uptime
Parameter: none

Description: This instruction returns the power-on time of the controller since it was switched on or resetted.

Response: Time in seconds.

Example: uptime => 8731

6.8. temp (Read Case Temperature)

Syntax: ?temp or temp
Parameter: none

Description: Read the ambient temperature inside the controller.
Remarks: Not all TANGO controllers provide a temperature sensor.

Response: Temperature in [°C] with one decimal place.

Example: temp => 28.9

6.9. maxaxis (Read number of available Axes)

Syntax: ?maxaxis
Parameter: none

Description: Read the number of available (factory configured) axes.
1, 2, 3 or 4.

Response: Number of available axes.

Example: ?maxaxis => 3

6.10. maxcur (Read Maximum Motor Current)

Syntax: ?maxcur
Parameter: x, y, z, a or none
Optional parameter 1

Description: Read the maximum possible motor current which can be set by !cur.

A) Maxcur called without parameter:
Maximum motor current which the power amplifier can deliver.

B) Maxcur called with parameter "1":
Motor current limitation, set by the connected axis (via ETS).

Response: maximum motor current in Ampere [A] (e.g. "1.25" or "1.00")

Examples:

?maxcur y read maximum adjustable motorcurrent of Y axis only
?maxcur read maximum adjustable motorcurrent of all available axes
(e.g. returns 1.25 1.25 1.25 1.00)

?maxcur y 1 read motor current limitation of Y axis only (e.g. set by ETS)
?maxcur 1 read motor current limitation of all axes (e.g. set by ETS)

6.11. etspresent (Read ETS Detect State)

Syntax: ?etspresent
Parameter: none

Description: Check if an ETS was detected by the TANGO (during power-up).

0 = No ETS found at the corresponding address
1 = ETS was found at the corresponding address (is available)

Remarks: If more than one ETS is found, the first one (lowest address) is treated as the 'main' ETS, the ETS with higher address only for the there defined axis specific parameters (e.g. axis 3).

Response: ASCII string of 4 characters, 0 or 1
 [ETS ADR0][ETS ADR1][ETS ADR2][ETS ADR3]

Example: ?etspresent => 0000 (no ETS connected)
 ?etspresent => 1000 (ETS found at address 0, usual case)
 ?etspresent => 1010 (ETS found at address 0 and 2)

6.12. stagesn (Read Connected Devices Serial Number)

Syntax: ?stagesn
Parameter: none or -1,0,1,2,3

Description: Read the device serial number from the ETS.
If the motor axis provides the ETS identification circuit, the serial number of the axis or connected unit (e.g. a microscope stage) is returned.

Call parameter options:

- None: 4 serial numbers are returned, one for each possible ETS address (0,1,2,3)
- -1 : 1 Serial number is returned, of the main ETS (usually also the only connected ETS, recommend instruction)
- 0-3 : Addresses an individual ETS, usually only ETS#0 is Available (which then also responds with -1 param.)

Response: ASCII string(s) of 8 or 9 characters.
The syntax is YYMMDDXXX or "-----" if no ETS available.

YY year of manufacturing
MM month of manufacturing
DD day of manufacturing
XX(X) index number

Example: ?stagesn => 120328015 -----
?stagesn -1 => 120328015
?stagesn 0 => 120328015
?stagesn 1 => -----

?stagesn -1 => 07090305

?stagesn => ----- 120328015 -----
?stagesn -1 => 120328015
?stagesn 0 => -----
?stagesn 1 => 120328015

6.13. maxpos (Maximum Position)

Syntax: ?maxpos
Parameter: x, y, z, a or none

Description: Read the maximum position value which the controller can accept due to internal limitations. It depends on e.g. the selected pitch, gear or motorsteps.

Response: Maximum position value of the axes
(unit depends on 'dim' setting)

Example: ?maxpos => 2600.0000 2600.0000 2600.0000
?maxpos x => 2600.0000 (X axis accepts positions from -2600mm to +2600mm)

6.14. lockpos (TransportLock Position)

Syntax: ?lockpos

Parameter: x, y, z, a or none

Description: Read the factory set transportlock position, where the axis must be positioned to for the fixation screw/transportation. A value of zero indicates the position is not available.

Remarks: Refer to the **!mol** instruction

Response: Transportlock position

Example:

```
?lockpos               => 50.3815 38.0018 0.0000
```

```
?lockpos y             => 38.0018 (Y axis transportlock position)
```

```
?lockpos z             => 0.0000 (Z axis provides no transportlock position)
```


7. Communication Interface Settings

7.1. baud (Baud Rate)

Syntax: !baud or ?baud
Parameter: 1200, 2400, 4800, 9600, 19200, 38400, **57600** or 115200

Description: Set or read the baudrate of the serial COM Port interface.

It applies to devices with a true RS232 serial connection, as available with TANGO-DT, TANGO mini (RS232 and USB versions), TANGO integrale and the USB Pilot stage.

Remarks: For PCI/PCI-E card versions or TANGO-DT with USB interface this instruction has no effect, as communication is managed by the driver at a very high, internally fixed baudrate. In this case it does not matter which baudrate the virtual COM port is opened with, it has no effect on performance.

After sending this instruction the PC has to re-open the COM Port with the new baudrate, else no communication is possible. Then a **!'save'** instruction may be sent to permanently store the new baudrate in the controller.

The default baudrate to connect a TANGO is 57600.

Response: Current baud rate of the controller

Examples:
!baud 57600 Set the baud rate to 57600 [Bd]
?baud Read currently set baud rate

7.2. cts (Enable/Disable RS232 Hardware Handshake)

Syntax: ?cts or !cts
Parameter: 0 or 1

Description: Enable or disable RTS/CTS hardware handshake of the RS232 and USB Virtual COM Port interfaces. For PCI bus communication this instruction has no effect.

Remarks: The COM port of the PC has to be opened in the same hardware handshake mode.

0 : no handshake (default)
1 : RTS/CTS handshake

Response: Currently selected cts mode

Examples:
?cts read current handshake mode
!cts 0 disable RTS/CTS handshake (default, recommended)
!cts 1 enable RTS/CTS handshake

8. System Instructions

8.1. save (Save Parameters)

Syntax: !save or save
Parameter: none

Description: The save instruction permanently stores the parameter settings (e.g. spindle pitch, motor current) to the TANGO controller. These parameters will be applied as default values after each consecutive power-on or reset. Executing a save comand always returns the "OK..." string when writing to the internal memory has completed successfully.

Response: ASCII string "OK... " or "ERR"

Example: save
 ==> OK... (The currently used controller parameters are saved
 and from now on used as defaults)

8.2. restore (Restore Saved Parameters)

Syntax: !restore, restore or ?restore
Parameter: none or -1

Description: Reload or reset the saved parameters.

When called without parameter (restore, !restore, ?restore)

The controller reloads the parameter settings from its nonvolatile memory, like performed at power-on or reset. But restore does not affect or restart the entire hardware.

?restore returns "OK..." or "ERR" (like the save instruction), In the other cases there is no reply. ?err might be sent once after the restore instruction and will reply after restore has completed.

When called with parameter "-1" (restore -1, !restore -1)

The saved parameters (nonvolatile memory) will be deleted and set to the firmware defaults. The parameters then have to be checked and set to the hardware requirements by the user. Else it may cause damage (due to overcurrent, wrong pitch, limit switch types etc). Software reset is performed automatically.

There is no reply to the restore -1 instruction, ?err polling may be required as described with the software '**reset**'.

Response: none, or "OK..." or "ERR" when using ?restore

Example: restore (reload the saved parameter set)
 ?restore (like restore, but with OK/ERR reply)
 restore -1 (reset the saved parameters to default)



8.3. reset (Force a Software Reset)

Syntax: !reset or reset
Parameter: none

Description: The controller is forced to perform a software reset. It is a restart similar to power on. Rebooting from reset will take more than 1 second, where the controller is not responding. There is no reply to a software reset.

Remarks: Wait for reboot after Reset:
 For knowing if the controller has rebooted and is ready, data may be polled until it responds again. E.g. send '**?err**' until the controller responds:
 Send ?err [wait 0.5s for response]
 Send ?err [wait 0.5s for response]
 ...
 Send ?err [wait 0.5s for response]
 Send ?err => 0 [Response, controller is ready]

Response: none

Example: reset

8.4. pa (Enable or Disable the Power Amplifiers)

Syntax: !pa or !poweramplifier
 ?pa or ?poweramplifier

Parameter: 0, 1, 2 or none

Description: Switch all motor amplifiers on/off or read amplifier state.

If switched off, no motor current is flowing (high impedance).
To switch off individual axes, use the '**axis -1**' instructions.

Amplifier switch off can also be caused by a short circuit,
the PSE pin functionality or loss of motor supply voltage.
Then an internal error (error 29) is generated and the status
LED flashes. ?pa will return 0. After removing the switch-off
cause, the amplifiers can be switched on again by !pa 1.

SET INSTRUCTION PARAMETER:

2 = Special Closed Loop switch on instruction, see remarks
1 = Amplifiers on
0 = Amplifiers off

READ INSTRUCTION PARAMETER:

none = read amplifier state, 1 = ok, 0 = error / off
-1 = read all amplifiers, 1 = on, 0 = off

Remarks: If the amplifiers switched off due to any condition or by the
 !*pa 0* instruction, and the axes were in active closed loop
 state before, it is possible to switch them on again and
 reactivate the closed loop at the current axis positions by
 sending !*pa 2*. A **cal** or **rm** sequence is not required and the
 momentary (measuring system) positions of the axes are applied.
 For axes without encoders, !*pa 2* will behave like !*pa 1*.

When using !*pa 1* (or using !*pa 2* without active closed loop),
the **cal** and **rm** sequence must be executed again.

Response: amplifier state 0 = Amplifiers are off or at least one
 amplifier switched off (due to an error)
 1 = Amplifiers are on

Example: !*pa 1* Switch on all amplifiers

 ?*pa* Read amplifier state (e.g. returns 1)
 ?*pa -1* Read amplifier on states (e.g. returns 1 1 1)

 !*pa 2* Switch on all amplifiers and if axes were in
 closed loop before they switched off, the axes
 continue at their momentary position.

Sequence example: !*pa 0*
 ?*pa* => 0
 ?*err* => 0

External event: PSE, short circuit or no motor voltage applied
?*pa* => 0
?*err* => 29

8.5. ipreter (Select Instruction Set)

Syntax: !ipreter or ?ipreter
Parameter: 1, 2, 3 or 4

Description: Instruction set of the TANGO controller.
The TANGO controller provides 4 different instruction sets, also called "interpreter".
It is recommended to use the default interpreter 1, as it is the native language and supports the most complex instruction set available.
Other instruction sets may be used for compatibility to existing applications. They are described in separate manuals.

INTERPRETER NR.

```
-----  
0   Not supported! (old register instruction set)  
  
1   TANGO instruction set (default),  
    as described in this manual  
  
2   VENUS-1 and VENUS-2  
  
3   LUDL MAC5000  
  
4   ASI MS-2000 (Available with Firmware >= 1.46)  
-----
```

To return from the VENUS instruction set (2), please enter the string "1 setipreter" and press enter (or send an ASCII [CR]). For other instruction sets please refer to the corresponding instruction set description.

Response: 1, 2, 3 or 4

Example:
!ipreter 2 => Switch the interpreter to the VENUS instruction set
?ipreter => Responds the currently selected interpreter

9. Operating Modes

9.1. Extended Mode

Activating Extended Mode will change the controller's behavior. Also there are new instructions available for setting calibrate and range measure velocities.

Note: When initializing the controller, the desired Extended Mode should be set directly after setting **dim** and before setting gear, pitch, vel etc.

Calibration in extmode = 0:

!vel --> The velocity for moving towards a limit switch has to be set everytime before starting a **cal** / **rm** move.
!calbspeed --> There is only one velocity for all axes to travel out of the Limit switch. The unit is 1/100 rev/s.

Calibration in extmode = 1:

!vel has no influence to the **!cal** and **!rm** move, **calbspeed** is no longer used. Now the calibrate (**cal**) and range measure (**rm**) velocities can be assigned once and will be used as speed especially for this instructions.

!calvel --> Set velocities for moving towards and out of the cal switch (E0)

!rmvel --> Set velocities for moving towards and out of the rm switch (EE)

Additional differences when in extmode = 1:

If the pitch or gear parameter is changed, all parameters which are in revolutions/s (e.g. vel) are recalculated internally. So the axis velocities will remain the same.

joyvel --> The joystick velocity can (and has to be) set independently from **vel** by the **joyvel** instruction.

The **?lim** instruction, when requested without an axis specifier, now returns all limits in a correctly formatted way.

9.1.1 extmode (Switch to Extended Mode)

Syntax: `!extmode` or `?extmode`

Parameter: 0 or 1

Description: This instruction switches the TANGO controller into extended mode. This mode offers improved behavior and more instructions than the standard interpreter. For further information please refer to the **Extended Mode** Chapter 9.1.

0 = default, compatible interpreter mode

1 = extended interpreter mode

Response: currently used extmode, 0 or 1

Examples:

`!extmode 1` Set controller behavior to extended mode

`?extmode` Read extended mode setting

9.2. Scan Mode

In Scan Mode the controller executes move instructions with a vector velocity.

9.2.1 scanmode (Switch to Scan Mode)

Syntax: !scanmode or ?scanmode
Parameter: 0, 1, 2 or 3

Description: This instruction switches the TANGO controller into scan mode, which may be used for continuous path control. This mode applies a constant vector velocity for automatic moves (moa, mor) which is set by '**scanvel**'.

0 = normal operation (default, no scan mode)
1 = scan mode 1
2 = scan mode 2
3 = no vector moves (else similar to mode 0)

Scan mode 1:

- The resulting travel velocity of automatic moves is **scanvel**.
- The individual '**vel**' settings are ignored.
- Applies to single axis and vector moves,
e.g. "!moa x 10"→scanvel, "!mor 20 20"→x=y=scanvel/sqrt(2)

Scan mode 2:

- Similar to scanmode 1, but individually started axes now travel at their original '**vel**' settings. May be useful e.g. when the Z-axis controls the focus.
- The resulting travel velocity of a vector move is **scanvel**.
- The individual '**vel**' settings are used for single axis move.
e.g. "!moa z -10"
- Applies to vector moves of 2 or more axes only,
e.g. "!moa 10 20"

Scan mode 3:

Similar to mode 0 (normal operation, no scan mode like 1 or 2) But when using vector moves (combined move of more than 1 axis), each axis travels at its own velocity and acceleration. The axes arrive at the specified target position at different times.

Response: Scanmode (automatic move mode) as integer

Examples:

!scanmode 1 Set controller into scanmode 1 (always traveling at scanvel)
?scanmode Read controller scanmode

!vel 20 20 10 (example: vel x,y = 20, vel z = 10)

!scanvel 0.1

!scanmode 2

!moa 50 100 → vector move with scanvel (vector velocity is now 0.1mm/s)

!mor z 1.5 → single axis move executed with vel z (this example 10mm/s)

!scanmode 0 Disable scanmode (=default, normal operation)

!scanmode 3 No scanvel, vector moves now make each axis travel at its own vel x,y,z,a setting towards the target
e.g. !mor 10 10 5 starts each axis at its own vel setting



9.2.2 scanvel (Vector Velocity for Scanmode and Dissection)

Syntax: !scanvel or ?scanvel
Parameter: 0.000001 to 1000 [mm/s]

Description: This instruction sets or reads the '**scanmode**' vector velocity in millimeters per second. It is also used for the snapshot dissection mode (**sns** 3) continuous path velocity. There is only one parameter.

Remarks: The **secvel** velocity restrictions will be applied to the individual axes as long as they are not calibrated and range measured (**cal**, **rm**).

Response: Currently selected scanmode velocity in [mm/s]

Examples:
!scanvel 10 Set scanmode vector velocity to 10 mm/s
?scanvel Read scanmode velocity

9.3. ModuloMode

Modulo Mode can be used for turntable- and for endless rotating applications.

9.3.1 modulomode (Define Linear or Turntable Modes)

Syntax: !modulomode or ?modulomode

Parameter: x, y, z, a or none
0, 1, 2, 3 or 4

Description: This instruction sets or reads the axis modulo mode. Modulo mode switches the specified axes from linear into a turntable mode that remains within $[0...360[^\circ$ or $[0...1[$ depending on '**dim**'. 1 linear and 4 turntable modes are available:

- 0 : Modulo Mode off (default mode, e.g. for linear axes)
- 1 : Travel shortest distance to target position
(*automatically decides to travel forward or back*)
- 2 : Only travel in positive direction
(*may result in traveling up to one additional revolution*)
- 3 : Only travel in negative direction
(*may result in traveling up to one additional revolution*)
- 4 : Do not travel over Zero
e.g. for swiveling axes $<360^\circ$ with limited operation range or as cable tear-off protection

Modes 1,2 and 3 ignore the upper and lower limits of the axis. While mode 4 uses the limits (**cal,rm,lim**) in order to narrow the possible operating range.

Remarks: Modulo Mode 1, in conjunction with the !speed instruction, can be used to achieve an endless rotating mode (pump, fan, etc).

Response: Currently selected modulo mode

Examples:

```
!modulomode 0 0 1 (set Z axis to modulo mode 1, X and Y to standard linear mode)
!modulomode a 4 (set A axis to modulo mode 4)
?modulomode => 0 0 0 (returns modulo mode of all axes, e.g. 0s)
?modulomode x => 1 (returns modulo mode of X axis, e.g. 1)
```

10. Controller States and Error Messages

10.1. autostatus (Set Autostatus Behavior)

Syntax: !autostatus or ?autostatus

Parameter: 0, 1, 2, 3 or 4

Description: Select auto response behavior for completion of move and calibration instructions. The power-on default is mode 1. Autostatus mode cannot be saved by the '**save**' instruction.

0 : Disable automatic status replies
(Except '**!save**' instructions will still return either "OK..." or "ERR")

1 : **Default state at power on. Recommended.**
Position reached response after each automatic move (moa, mor, cal, rm) (a 5 character string with e.g. '@' for each configured axis is returned by the controller. Please also refer to '**statusaxis**' for further information. Autostatus 1 is the default configuration after power-on.

2 : The controller responds to SET instructions (leading "!") immediately with the **status message** "OK..." or "ERR". Move and Cal/Rm instructions will respond additionally like in autostatus 1 (e.g. "@@@" response).

3 : Similar to the default mode 1, but a simple <CR> (0x0d hex) is returned to indicate that the move is completed. It can be used to improve performance for higher vector throughput, but contains less information e.g. concerning possible errors.

4 : Echoes the instruction that was sent, in case of set or move instruction.

```
Example: !autostatus 0    disable autostatus ("statusaxis" has to be polled
                        to identify if the axis is traveling or stopped)
          !autostatus 1    set autostatus to the default behavior
          ?autostatus      read the currently selected autostatus
```

--- autostatus 0 ---

```
!moa,!mor,m,a,cal,rm ==> [returns nothing, statusaxis (sa) must be polled]
```

--- autostatus 1 --- **default**

```
!moa,!mor,m,a        ==> [returns completion, 5 ASCII character string @@@-.]
!cal,!rm              ==> [returns completion, 5 ASCII character string AD@-.]
```

--- autostatus 2 ---

```
!vel 10              ==> [returns "OK..."]
!vel -10             ==> [returns "ERR 5"]
vel 10               ==> [returns nothing (is executed but no "!" reply)]
```

--- autostatus 3 ---

```
!moa,!mor,m,a,cal,rm ==> [returns completion, 0 ASCIIIs only <CR> termination]
```

--- autostatus 4 ---

```
!moa 10 5 0         ==> [returns !moa 10 5 0]
```

10.2. statusaxis (Read State of Axis)

Syntax: ?statusaxis or statusaxis or sa
Parameter: x, y, z, a or none

Description: Statusaxis responds the state of each axis.
 Similar to the '**autostatus 1**' response for move instructions,
 but with an additional '-' after the dot.
 It can be used for polling move states when in 'autostatus 0'
 mode, where no automatic response is generated.
 Every response except of 'M' means the axis has stopped for
 some reason and may be ready for a new move instruction.
 It is recommended to check the returned ASCII character for
 != 'M' (not equal to 'M', 0x4D hex).

Response: 6 ASCII characters: [STATUS X][STATUS Y][STATUS Z][STATUS A].-

@ => Axis is not moving and ready
M => Axis is moving
J => Axis is ready and may also be controlled manually (by joystick)
S => Limit switches are actuated and prevent further automatic move
A => ok response after cal instruction
D => ok response after rm instruction
E => error response, move aborted or not executed
 (e.g. **cal**, **rm** limit switch error or stop input active)
T => Timeout occurred (refer to '**caltimeout**' instruction)
- => Axis is not enabled, not available in hardware

Example: Assume ?statusaxis returns @@@-.-
 This means three axes are enabled and ready to move.

?statusaxis (JM--.- = 2 axis controller, X is ready, Y is moving)
sa (e.g. may return A@@-.- after calibrating the X-Axis)
sa x (e.g. may return M if axis is moving)

10.3. corrst (Read Position Correction State)

Syntax: ?corrst or corrst
Parameter: x, y, z, a or none

Description: Read the state of position correction
 Bit 0 (1) = correction data available
 Bit 1 (2) = correction requested (by '!corr 1')
 Bit 2 (4) = correction active

Response: Bit coded integer number

Example: corrst => 7 3 0
 Corrst x => 7 (Bit 0,1,2 are 1 = correction active)

10.4. status (Read the Controller Error State)

Syntax: ?status or status
Parameter: none

Description: The ?status instruction responds with the current state of the controller. Which is either 'OK...' or an 'ERR' with the error number. The error number description can be found in chapter **Error Numbers**. Also refer to '**err**' and '**help**' instructions.

Response: OK... or ERR with error number

Example: ?status => ERR 4
 ?status => OK...

10.5. err (Read Error Number)

Syntax: ?err or err, !err
Parameter: none

Description: The instructions err or ?err return the controller error state or 0, if no error occurred. The error state will be updated or re-set by the next instruction. If not a permanent error (like e.g. 29) the error state may be cleared to zero by sending !err.

Response: Error number as decimal value
 (refer to Chapter 5: **Error Numbers**)

Example: err (may return a 0)
 ?err (same as err)
 !err (clears error state if no permanent error)

10.6. help (Read Error Number with Description String)

Syntax: ?help or help
Parameter: none or requested error number

Description: The instruction 'help' returns a text string. It contains the error state with appended error description. The error state is not cleared to zero. Please also refer to the '**err**' instruction.

Called without a parameter:

It returns the controller's error state with description

Called with a parameter (error number):

It returns this error number with the corresponding comment

Response: Error number as decimal value, error description as ASCII text

Example: help => ERROR 0,no error (assuming there is no error)
 help => ERROR 5,number outside range
 help 29 => ERROR 29,servo amplifier off

10.7. service (Print Service Information to Terminal)

Syntax: ?service or service
Parameter: none

Description: Returns a multi-line parameter and state list of the TANGO Controller. It may be used for debugging or in case of service requests. Either a terminal program or SwitchBoard version 1.19 and above can be used.

Response: Many lines of text including e.g. serial number, parameters, states etc. Each line terminated by a [CR]. From TANGO firmware 1.60C/1.61 (September 02, 2015) and later, the last line sends the string "END_SERVICE_PRINT." indicating the end.

Example: service

10.8. pci (Is PCI Bus)

Syntax: ?pci or pci
Parameter: none

Description: Check if the TANGO controller is used as PCI/PCI-E card (plugged into a PC slot).

0 = Controller is a desktop version
1 = Controller is a PCI or PCI-E card, plugged in the PCI(-E) slot of a computer (here: no RS232 or USB communication)

Response: 0 or 1

Example: pci => 0 (e.g. a TANGO Desktop)

10.9. isvel (Read Actual Velocities)

Syntax: ?isvel or isvel
Parameter: x, y, z, a or none

Description: Read the actual velocity(s) at which the axis is currently traveling. Unlike '**vel**' or '**speed**' this instruction returns the currently traveled (true) speed of the axes, even when controlled by a HDI device.

Optional read-resolution: As an option to read the value with higher precision, the number of required decimal places can be specified with the query "?isvel [0...16 decimal places]". If no precision is defined, the default resolution is 3 decimal places.

Response: Actual axis velocity in [mm/s]

Example:

```
?isvel           => Read actual velocity of all axes
?isvel y       => Read actual velocity of the Y axis (e.g returns 10.000)
?isvel 4       => Read actual velocity of all axes with 4 decimal places (0.0000)
?isvel y 6     => Read actual velocity of the Y axis with 6 decimal places
isvel           => Same as ?isvel
```



10.10. iscur (Read Actual Motor Current)

Syntax: ?iscur or iscur

Parameter: x, y, z, a or none

Description: Read the momentarily applied motor current, which includes current reduction or switched off states (by **axis**).

Remarks: It is not a measured value.

Response: Applied motor current in [A]

Example:

?iscur => Read applied motor current of all axes

?iscur y => Read applied motor current of the Y axis (e.g returns 1.00)

iscur => Same as ?iscur

11. General Adjustments

With the following instructions the parameters of the controller are widely scalable to the given mechanic construction and to customer requirements. The controller is adaptable to the requested requirements.

11.1. dim (Unit for Positions and Velocities)

Syntax: !dim or ?dim
Parameter: x, y, z, a or none
 0 to 9

Description: The dim instruction sets the unit (here "dimension") of the input and output parameters related to length, e.g. position or move instructions. Dim 9 also sets the velocity parameters to mm/s (e.g. '**vel**', '**speed**'), which else remain in motor revolutions per second.

```
0   = Micro steps
1   = µm
2   = mm      (the default: velocities in motor revolutions/s)
3   = 360°
4   = revolutions
5   = cm
6   = m
7   = inch
8   = mil     (1/1000 inch)
9   = mm      (difference to mode 2: all velocity units in mm/s)
```

Remarks: For dim 3 (=360°) and 4 (=revolutions) it is recommended to set the **spindle pitch** to 1mm.
 In dim mode 0 the Microstep resolution can be specified by the '**usteps**' instruction, in order to match the required amount of steps per revolution (e.g. 40000, 54000, 360).
 For positioning instructions as **!moa**, **!mor**, fractional values can also be used as the internal resolution (typ. 819200/rev) might be higher than the user set microsteps.

Response: Current dim settings

Examples:

```
!dim 4 1   set dim unit for X to [revolutions] and for Y to [µm]
!dim z 9   set dim unit for Z to [mm and mm/s]
!dim 2 2 2 set dim unit for axes X, Y and Z to [mm]
?dim      read dim unit for all axes
?dim a    read dim unit of A-axis only
```

11.2. pitch (Spindle Pitch)

Syntax: !pitch or ?pitch
Parameter: x, y, z, a or none
 0.0001 to 72 [mm/rev]

Description: This instruction sets or reads the spindle pitch which defines the axis travel distance in millimeter per motor (or gear) revolution.

Optional read-resolution: As an option to read the parameter with higher precision, the number of required decimal places can be specified with the query "?pitch [0...16 decimal places]". If no precision is defined, the default resolution is 4 decimal places.

Remarks: If the required pitch value is an infinite number due to a 1/x function, the '**gear**' parameter can be used instead or in combination.

Response: currently used spindle pitch in [mm per motor revolution]

Examples:
!pitch 4 1 set spindle pitch X=4[mm] and Y=1[mm]
!pitch z 28.895 set spindle pitch Z=28.895[mm]
?pitch read spindle pitch of all axes (e.g. returns 1.0000 1.0000)
?pitch a read spindle pitch of A-axis only
?pitch 9 read spindle pitch of all axes with 9 decimal places
?pitch y 6 read spindle pitch of Y-axis with 6 decimal places (1.000000)

11.3. gear (Gear Ratio)

Syntax: !gear or ?gear
Parameter: x, y, z, a or none
 0.001 to 1000

Description: This instruction sets or reads the axis gear ratio. If there is no gearbox mounted to the axis, this parameter should be left at its default value of 1.

Optional read-resolution: As an option to read the parameter with higher precision, the number of required decimal places can be specified with the query "?gear [0...16 decimal places]". If no precision is defined, the default resolution is 3 decimal places. Please also refer to the examples below.

Remarks: If the required pitch value is an infinite number due to a 1/x function, the '**pitch**' parameter can be used instead or in combination.

Response: currently used gear ratio

Examples:
!gear 10 set gear ratio X=1:10
!gear 4 1 set gear ratio X=1:4 and Y=1:1
!gear z 12.5 set gear ratio Z=1:12.5
?gear read gear ratio of all axes
?gear a read gear ratio of A-axis only (e.g. returns 1.000)
?gear 9 read gear ratio of all axes with 9 decimal places
?gear z 10 read gear ratio of Z-axis only with 10 decimal places



11.4. motorsteps (Motor Steps Per Revolution)

Syntax: !motorsteps or ?motorsteps
Parameter: x, y, z, a or none
4 to 65532 as multiples of 4

Description: This instruction sets the steps per revolution of the motor, which can be found in the datasheet. Common motors have 200 steps per revolution (1.8° full step). This is the TANGO default value. Other motors may have e.g. 400, 500 or 24 steps per revolution. It is essential for operation to have this parameter set according to the datasheet. The motor steps parameter must be a multiple of 4 in the range of 4 to 65532.

Response: Selected motorsteps of the stepper motor(s)

Examples:

```
!motorsteps 200 200 400      set motor steps for X and Y to 200 and Z to 400
!motorsteps x 500           set motor steps for X to 500
?motorsteps                 read motorsteps of all axes
?motorsteps a              read motorsteps of A-axis only
```

11.5. accel (Acceleration)

Syntax: !accel or ?accel
Parameter: x, y, z, a or none
0.0001 to 20 [m/s²]

Description: This instruction sets or reads the acceleration which is used for all moves, the speed instruction and manual control by HDI devices.

Optional read-resolution: As an option to read the parameter with higher precision, the number of required decimal places can be specified with the query "?accel [0...10 decimal places]". If no precision is defined, the default resolution is 2 decimal places.

Remarks: In case of a stop event, '**stopaccel**' is used instead.

Response: Currently used acceleration in m/s²

Examples:

```
!accel 0.5      set acceleration X=0.5[m/s2]. Other axes are not affected
!accel 1 0.55   set acceleration X=1.0[m/s2] and Y=0.55[m/s2]
!accel z 0.2    set acceleration Z=0.2[m/s2]. Other axes are not affected
?accel         read all axes for their current acceleration
?accel z       read Z axis for its acceleration
?accel 6       => 0.500000 0.123456 0.200000
?accel y 4     => 0.1235
```

11.6. accelfunc (Acceleration Ramp Function)

Syntax: !accelfunc or ?accelfunc
Parameter: x, y, z, a or none
0, 1 or 2

Description: Select the acceleration ramp type for automatic moves (e.g. m, moa, mor, moc, cal, rm).

0 = Linear acceleration and deceleration ramp
1 = s-curve acceleration and deceleration ramp
2 = reserved, currently behaves as 1 (s-curve)

Remarks: The acceleration ramp for '**go**' and '**speed**' instructions and manual control (HDI) always remains linear accelerated.

Response: Currently used acceleration type

Examples:

```
!accelfunc 1   set accel function X to s-curve, other axes are not affected
!accelfunc x 1 set accel function X to s-curve, other axes are not affected
!accelfunc 1 1 0 set accel function in X and Y to s-curve, Z to linear accel.
?accelfunc     read acceleration ramp function of all axes
?accelfunc z   read acceleration ramp function of Z axis only
```

11.7. stopaccel (Emergency Stop Deceleration)

Syntax: !stopaccel or ?stopaccel

Parameter: x, y , z, a or none
0.001 to 200 m/s²

Description: This instruction sets the deceleration for emergency stop conditions. It will be used by:

- abort instructions
- active stop input
- a '**cal**' or '**rm**' move (at the limit switch)
- when detecting an unexpected limit switch

Optional read-resolution: As an option to read the parameter with higher precision, the number of required decimal places can be specified with the query "?stopaccel [0...10 decimal places]". If no precision is defined, the default resolution is 2 decimal places.

Response: Deceleration for stop conditions

Examples:

```
!stopaccel 1 1 2 Set the stop deceleration for X and Y to 1 and Z to 2 [m/s2]  
!stopaccel x 1.5 Set the X stop deceleration to 1.5[m/s2]  
?stopaccel Returns the stop deceleration of all axes  
?stopaccel z Returns the stop deceleration of Z axis only (e.g. 1.50)  
?stopaccel 6 Returns stop deceleration of all axes with 6 fractional digits  
?stopaccel z 9 Returns stop deceleration of Z axis with 9 fractional digits
```

11.8. vel (Velocity)

Syntax: !vel or ?vel
Parameter: x, y , z, a or none
 0.000001 to 200 [rev/s] (or up to 3000 [mm/s] if dim = 9)

Description: Velocity for automatic moves, cal**, rm** and HDI**

Except of dim=9, the velocity unit is always motor revolutions per second. Only in dim=9 the unit is [mm/s].

Optional read-resolution: As an option to read the parameter with higher precision, the number of required decimal places can be specified with the query "?vel [0...16 decimal places] ". If no precision is defined, the default resolution is 3 decimal places.

Remarks: ** If **extmode**=0 (default), vel is also used for

- the HDI (joystick) velocity
- the cal and rm instructions

extmode=1 provides separate parameters (**joyvel, calvel, rmvel**).

Vel can be used to change the travel velocity during a **go** instruction. In such case, setting vel to zero will also end a running go instruction (e.g. !vel z 0, !vel 0 0 0, etc.)

The **velfac** instruction can be used in addition to vel, but is not necessary or recommended.

Response: Currently selected velocity

Examples:

```
!vel 1.0 15        set velocity X=1[revolution/s] and Y=15[revolution/s]
!vel z 0.1        set velocity Z=0.1[revolution/s]
?vel              read velocity of all axes
?vel x            read velocity of X axis only
?vel 6            => 20.000000 0.123456 5.000000
?vel y 4          => 0.1235
```

11.9. velfac (Velocity Factor)

Syntax: !velfac or ?velfac
Parameter: x, y , z, a or none
 0.01 to 1.00

Description: This instruction sets or reads the velocity factor, which is used for all consecutive automatic moves. It is internally multiplied to the velocity (**vel**) and affects the positioning instructions *moa*, *mor*, *moc*, *m*, *cal*, *rm*. It does not affect instructions like *go* or *speed*.

Response: Currently used velocity factor [0.01 to 1.00]

Remarks: Velfac is just for backward compatibility and not required anymore, as the **vel** resolution is high enough to achieve the full spectrum of velocities.

Examples:
?velfac read velocity factor of all axes
?velfac z read velocity factor of Z axis only
!velfac x 0.1 set velocity factor of X axis to 1/10 of specified velocity
!velfac 1 1 1 set velocity factor of X,Y,Z to specified velocity (default)

11.10. secvel (Secure Velocity)

Syntax: !secvel or ?secvel
Parameter: x, y , z, a or none
 0.000001 to 100 [mm/s]

Description: The security speed limitation is used as long as the axis is not calibrated and range measured ('**cal**', '**rm**'). The unit is always mm/s and does not depend on the '**dim**' setting. It is intended to prevent mechanical damage as long as the controller does not know the mechanical limits of the axis. (The breaking distance behind the hardware limit switches often is not sufficient to stop the axis under all velocities).

Setting this parameter to higher values may also be used as a workaround at own risk, if executing a *cal/rm* is not wanted. Axes which only have one (E0/*cal*) or do not provide any limit switch (refer to '**swact**' settings) disable the security speed limit after a *cal* or do not even apply the limit.

Optional read-resolution: As an option to read the parameter with higher precision, the number of required decimal places can be specified with the query "?secvel [0..16 decimal places]". If no precision is defined, the default resolution is 2 decimal places.

Response: Currently used secure velocity in [mm/s]

Examples:
!secvel 100 100 100 => Set maximum possible velocity of X Y Z
!secvel y 14.5 => Set maximum possible velocity of Y to 14.5 mm/s

11.11. cur (Motor Current)

Syntax: !cur or ?cur
Parameter: x, y, z, a or none
0.03 to [maximum current]

Description: This instruction sets or reads the motor current. The maximum current is limited by hardware or additionally by factory settings (ETS) and may be checked using '**maxcur**' instruction.

Remarks: Please check the motor datasheet first in order not to destroy the motor by overcurrent/overtemperature. Also, if the motor current set too low it can cause the axis to move incorrectly and lead to mechanical damage. At least for open loop systems (without encoder feedback) it is required to ensure the axis can travel under all required velocities and load situations.

If current reduction is active, the momentarily applied motor currents can be checked any time via the **iscur** instruction.

Response: Motor current in Ampere (e.g. 1.00)

Examples:
!cur 1.1 set X motor current to 1.1[A]
!cur 1 2 set motor current for X=1[A] and Y=2[A]
!cur z 0.3 set Z motor current to 0.3[A]
?cur read motor current of all axes
?cur x read motor current of X axis only



11.12. reduction (Motor Current Reduction Factor)

Syntax: !reduction or ?reduction

Parameter: x, y, z, a or none
0 to 1.00

Description: Motor current reduction factor when idle, used to reduce the dissipated heat from the motor.
When the axis is idle (stopped), the motor current (**cur**) is reduced by this factor.
Floating point numbers from 0 to 1.00 represent 0 to 100% of the motor current. Reduction is disabled when set to 1 (default).

Remarks: The current reduction can be delayed by the '**curdelay**' instruction.
Without adding a delay, reduction might have an impact on vector throughput, as it takes some extra time to increase the current ahead of each move instruction or joystick deflection. The decrease and increase rate is 1% (0.01) per 160µs. When reduction is active and a move instruction or joystick deflection is executed, the axis current is first ramped up to 100%. This causes a response delay of e.g. 30%-->100% = 70*160µs = 11.2ms.

While reducing, the axis might also show slight waggle, depending on mechanical load.

In systems with encoders: Reducing the current to less than 0.3 (30%) will disable the permanent **closed loop** while reduction is active (axis stopped and **curdelay** expired).

If current reduction is active, the momentarily applied motor currents can be checked any time via the **iscur** instruction.

Response: Reduction factor(s) [0.00 to 1.00]

Examples:

```
!reduction .3 .7 Set idle current reduction X=0.3*cur[A] and Y=0.7*cur[A]
!reduction 1 1 1 Disable reduction for axes X,Y,Z
!reduction z 0.5 Set Z idle current reduction factor to 0.5*cur[A]
?reduction Read idle current reduction factor of all axes
?reduction x Read idle current reduction factor of X axis only (e.g. 1.00)
```

11.13. curdelay (Delay for Current Reduction)

Syntax: !curdelay or ?curdelay

Parameter: x, y, z, a or none
0 to 65000 [ms]

Description: At the end of each move, the axis enters idle state. If the motor current **reduction factor** is set to a value less than 1, this reduction will take effect after the curdelay time.

Remarks: A delay might be necessary in cases of
- long time exposure (to avoid waggle)
- high vector throughput (to avoid reduction between the move)
- heat reduction when not operating (long, like a screensaver)

Response: Selected delay time for the current reduction in [ms]

Examples:

```
!curdelay 100 450 Set delay for motor current reduction X=100[ms] and Y=450[ms]
!curdelay z 15000 Set delay for motor current reduction Z=15 seconds
!curdelay 0 0 Set immediate reduction for X and Y axis
?curdelay Read motor current reduction delay of all axes
?curdelay x Read motor current reduction delay of X axis only
```

11.14. ecomove (EcoMove Current Level)

Syntax: !ecomove or ?ecomove

Parameter: x, y, z, a or none
0 to 70

Description: EcoMove reduces the motor current while the axis travels at constant velocity. Like '**reduction**' it can be used to greatly reduce the dissipated heat of the motor. But the EcoMove parameter works in a different way: Greater values = greater power saving, which means a eco level value of 0 is 100% current and a eco level of 30 is 70% current.

0 = Full motor current (default)

70 = Maximum power saving level (low motor heating and force)

Response: EcoMove level

```
Examples: !ecomove 0 0 0 0 (disable ecomove for all axes / 0%)
!ecomove x 25 (reduce X current by 25% when moving)
?ecomove (return all ecomove levels)
```


11.15. axis (Enable, Disable, Switch Off Axis)

Syntax: !axis or ?axis
Parameter: x, y, z, a or none
-1, 0, 1

Description: This instruction enables, disables and switches off axes. The currently selected state can also be read.
A disabled axis still powers the motor with its current, while a switched off axis loses its torque.

1 = enabled
0 = disabled
-1 = axis power stage off

Response: Axis enable state

Examples:
!axis 1 1 1 1 enable all axes
!axis 1 0 1 0 disable Y and A axis, enable X and Z
!axis y -1 switch off Y axis: power stage Y off
?axis x read axis state of X axis only
?axis read axis state of all axes

11.16. axisdir (Axis Direction)

Syntax: !axisdir or ?axisdir
Parameter: x, y, z, a or none
0 or 1

Description: Travel direction of the axes.

0 = Normal axis direrction
1 = Reversed axis direrction

Remarks: Changing the axis direction should only be used once as a general setup of the hardware direction, and not be used during normal operation. It's recommended to **save** and restart.

The hardware limit switches CAL and RM will automatically be reassigned when switching the axis direction. Also swact, swpol, swtyp, readsw etc. Exception: The **swin** function is not affected.

Closed loop will be deactivated when changing the direction and has to be reenabled by cal or reset/power-on.

If the axis is position corrected by factory (mapped), the axis direction is an essential part of the mapping process and must not be changed by the customer. If the direction of a position corrected axis is changed by the customer, the axis will no longer meet their specifications (position accuracy).

Response: Axis direction

Examples:
!axisdir 0 1 0 1 Reverse travel directions of Y and A axis
!axisdir z 1 Set reverse travel direction for Z axis
?axisdir Read axis direction of all axes
?axisdir x Read axis direction of X axis only

11.17. motortable (Motor Correction Table)

Syntax: !motortable or ?motortable
Parameter: x, y, z, a or none
0 or number specified by factory

Description: This instruction adds a motor correction, which can be used to reduce resonances and vibration. The motor has to be measured for the specific application by factory. Then a table number will be assigned and the customer may activate it by setting the corresponding motortable number. Using a wrong motortable will lead to increased noise and position error.

0 = No correction

Response: Currently used motortable(s)

Examples:
!motortable 1 1 2 0 Select motortable 1 for X and Y, 2 for Z and no for A
!motortable x 0 Disable correction for x
?motortable Read the currently used tables for all axes

11.18. usteps (Microstep Resolution)

Syntax: !usteps or ?usteps
Parameter: 360 ... 1638400

Description: This instruction sets the microsteps for one motor revolution, used in axis unit "**dim 0**" (Microsteps). It offers compatibility to application software that is written for e.g. 40000 or 54000 microsteps. One value applies to all axes that have **dim 0** selected.

Remarks: For positioning (moa, mor etc.) in microsteps dim mode 0, the microstep position can also be specified with fractional digits (e.g. !mor 40000 4500 0.5).

Response: Currently used **dim 0** microstepping resolution in [steps/rev]

Examples:
!usteps 40000 Set microstep resolution to 40000/revolution (for dim=0)
?usteps Read the microstep resolution

11.19. resolution (Position Number Format)

Syntax: !resolution or ?resolution
Parameter: 0, 1, ... 6

Description: This instruction sets the resolution of "**?pos**" and similar position returning instructions for **dim 1, 2 and 9**. It affects the amount of returned fractional digits, as listed below. One value applies to all axes, default = 4 (100nm resolution).

Value	Resolution dim 2,9	Resolution dim 1
0	= 1mm	0.1 μ m
1	= 0.1mm	0.1 μ m
2	= 0.01mm	0.1 μ m
3	= 0.001mm	0.1 μ m
4 (default)	= 0.0001mm	0.1 μ m
5	= 0.00001mm	0.01 μ m
6	= 0.000001mm	0.001 μ m

Affected instructions are: ?pos, ?lim, ?maxpos, ?posclr, ?distance, ?twi, ?ctrs, ?ctrdiff, ?caliboffset, ?rmoffset, ?calpos, ?calzeropos, ?trigd, ?snsa, ?snsp.

Response: Responded fractional digits of the '**pos**' and other position returning instructions.

Examples:

```
!resolution 5      Set position read resolution to 10 nm (5 decimal places if mm)
                   e.g. "?pos x" returns 0.00000 in dim 2 and 9, 0.00 in dim 1.
?resolution        Read the fractional digits resolution
```

11.20. backlash (Mechanical Backlash Compensation)

Syntax: !backlash or ?backlash
Parameter: x, y, z, a or none
-100.0 ... 100.0 [μ m]

Description: Compensates mechanical backlash of the individual axes. Unit is always micrometer [μ m], independent from dim.

0 = Backlash compensation off

Remarks: Backlash compensation is not applied in **closed loop mode**. Backlash compensation does not affect the axis performance. Backlash compensation is also applied in HDI mode, e.g. when using the joystick. Due to compensation the manual control is greatly improved when using high magnifications.

Backlash Info: Mechanical backlash becomes visible when traveling to the same position from both directions, forward and backward. The backlash value is half the amount of this deviation.

Response: Axis backlash in micrometer [μ m]

Examples:

```
!backlash 12.7 21.3 0  Set backlash for X to 12.7 $\mu$ m, Y=21.3 $\mu$ m and Z=none
!backlash x 0         Disable backlash compensation for X
!backlash x 5         Compensate a backlash of 5 $\mu$ m in X
?backlash             Read the backlash compensation value of all axes
?backlash z          Read the backlash compensation value of Z axis only
```

11.21. lock (Select Parameters to Lock)

Syntax: ?lock or !lock
Parameter: 0 to 15, 0 or 1

Description: Select write protection for TANGO parameters (lock state).
Either bitwise: !lock [bit number] [0 or 1]
or multi bits : !lock [bit field of 0s and 1s]
After selecting the parameters to lock, these have to be applied to the desired axes by '**lockaxis**'.

Response: Specified lock bit state or entire lock bit field, LSB first.
The bit positions represent the following parameters:

Bit Nr.	Parameter
0:	Pitch
1:	Gear
2:	Cur
3:	MotorSteps
4:	SwPol
5:	SwTyp
6:	SwDir
7:	EncTTL,EncType
8:	EncPeriod
9:	AxisDir
10:	MotorTable
11:	BackLash
12:	Anglecorr
13:	CalLrnPos
14:	CalibOffset
15:	RmOffset

Example: !lock 111 => Set lock bits 0 1 and 2, leave others unaffected
!lock 2 0 => Clear lock condition for parameter 2 (=current)
!lock 0 1 => Set lock bit for parameter 0 (pitch)
?lock => Read lock bit field (e.g. "0000000000000000")
?lock 5 => Read lock bit #5 state

11.22. lockaxis (Apply the Parameter Lock to Axes)

Syntax: ?lockaxis or !lockaxis
Parameter: x, y , z, a or none

Description: Apply the parameter lock, selected by the '**lock**' instruction, to the specified axes. If the lockbits or lockaxis are zero nothing will be locked.

Response: Axes to which the lock bits are currently applied.

Example: !lockaxis y 1 => Apply lock bits to Y axis
!lockaxis 1 1 => Apply lock bits to X and Y axis
?lockaxis x => Read if lock bits are applied to the X axis
?lockaxis => Read all axes (returns e.g. "1 1 0 0")

11.23. lockstate (Read all internal Lock States)

Syntax: ?lockstate
Parameter: x, y, z, a or none

Description: Set/read the internal parameter write protection (lock) state caused by the ETS (factory) and user lock/lockaxis settings. The bit positions represent the following parameters:

Bit Nr.	Parameter
0:	Pitch
1:	Gear
2:	Cur
3:	MotorSteps
4:	SwPol
5:	SwTyp
6:	SwDir
7:	EncTTL, EncType
8:	EncPeriod
9:	AxisDir
10:	MotorTable
11:	BackLash
12:	Anglecorr
13:	CalLrnPos
14:	CalibOffset
15:	RmOffset

Response: Lock state as 16 bits ASCII string(s), 0s and 1s, LSB first

Example: ?lockstate => Read lock state of all axes
?lockstate x => Lock state of X axis e.g. "1100000000000000"

11.24. stout (Select Status Signal Output)

Syntax: !stout or ?stout
Parameter: 0,1,2,3,4

Description: Makes the state of the TANGO Status LED available to the optional AUX-I/O connector:

0 = Just Status LED, no AUX-I/O used (default)
~~1 = AUX-I/O Pin 5 (TAKT_OUT) not supported~~
2 = AUX-I/O Pin 6 (VR_OUT)
3 = AUX-I/O Pin 7 (SHÜTTER_OUT)
4 = AUX-I/O Pin 8 (TRIGGER_OUT)

Remarks: To turn off the Status LED, instruction '**noled**' may be used.

Response: Selected status output mode

Example: !stout 0 => Only use TANGO Status LED (default)
?stout => Read status output mode (returns 0,1,2,3 or 4)

11.25. noled (Select Status Signal Output)

Syntax: !noled or ?noled
Parameter: 0 or 1

Description: Permanently force off the TANGO Status LED.
Forcing the LED off may be necessary in low light applications where no external light source is wanted.

0 Normal operation, Status-LED on (default)
1 Status-LED permanently off

Response: Status LED mode

Example: !noled 1 => Force Status-LED permanently off
!noled 0 => Status-LED normal operation (default)
?noled => Read status output mode (returns 0 or 1)

11.26. updelay (Power Up Delay)

Syntax: !updelay or ? updelay
Parameter: -5000 to 5000

Description: Delay time of the TANGO controller on power up in [ms].

This parameter is ment for fixing problems of TANGO PCI/PCI-E card versions with external power supply or long PCI reset times of the computer mainboard.

Applications:

Use negative values to wait for valid motor voltage (e.g. when using master-slave power switches for the external power supply).

Use positive values to wait a fixed time (e.g. when the mainboard generates a too long reset signal, it causes the PCI/PCI-E card to start as a Desktop version. So the virtual PCI COM port is not accessible.)

Positive values: The controller waits for the specified time.

Negative values: The controller waits for valid motor voltage for a maximum of this time or shorter.

Response: Power up delay time in [ms]

Example: !updelay -2000 => Wait max. 2s for valid motor voltage level
!updelay 2500 => Wait 2.5s extra on power up
?updelay => Read the power up delay

12. Limit Switch Instructions (Hardware and Software)

12.1. lim (Software Limits)

Syntax: `!lim or ?lim`
Parameter: `x, y, z, a or none`
`+-maximum position range (unit depends on 'dim')`

Description: This instruction sets or reads the movement range limitations. The upper and lower software limits must be send together in a single "`!lim`" instruction. The unit depends on '`dim`' setting.

Remarks: In **Extended Mode** (`extmode = 1`) the '`?lim`' instruction returns the limits as a correctly formatted string, as shown in the example below.

Response: `Currently used software limits [lower] [upper]`

Examples:

```
!lim -1000 1000 -2000 2000    set the software limits for X and Y
!lim z -500 1700              set the software limits for Z
!lim z -45.37                 set the lower software limit of Z
?lim y                        read software limits of Y-axis only
?lim                          read software limits of all axes
                              only recommended in extmode=1, as shown below:
```

`?lim` response example for 3 axes in

```
--> extmode=0: -1000 1000, [CR]-1000 1000, -1000 100[CR]
--> extmode=1: -1000 1000 -1000 1000 -1000 100[CR]
```

12.2. clim (Circular Software Limit)

Syntax: `!clim or ?clim`
Parameter: `center position x,y and radius`
`or only radius`
`(units depend on 'dim')`

Description: This instruction provides circular movement range limitations. The limit can be specified either with XY center position or just with the radius. Then the current XY axis positions will be used as center. The units depend on '`dim`', x and y must have same dim.

```
!clim 0 disables circular limits
?clim 1 queries the state (active=1, inactive=0)
```

`!clim [centerPosX] [CenterPosY] [Radius] or`
`!clim [Radius] set the circular limit.`

Response: `Circular limits [X] [Y] [radius] or active state [0,1]`

Examples:

```
!clim 50 70 10    Set clircular limit of radius 10 at center position X=50,Y=70
!clim 9.5         Set clircular limit of radius 9.5 around the current position
!clim 0          Disable circular limits
?clim            Read circular limit positions and radius (cenx ceny radius)
?clim 1         Query if circular limits are enabled (1) or disabled (0)
```

12.3. limctr (Enable or Disable Limit Control)

Syntax: !limctr or ?limctr
Parameter: x, y, z, a or none
 0 or 1

Description: This instruction enables or disables the limit control or returns the current state of it.

0 = disabled
1 = enabled (default from power on)

Attention: Setting limctr to 0 can cause mechanical damage to the axis!
If limit controls are disabled, the controller ignores any limits set by **cal**, **rm** or **lim**.
Actuating the limit switches is still recognized (as long as they are not deactivated by the **swact** instruction).

Remarks: Limit control is enabled by default from power on each time and cannot be stored permanently.

Response: Limit control state

Example:
!limctr z 0 disable Z limit control, Z axis limits are ignored
!limctr 1 1 1 enable X, Y and Z limit control
?limctr a read limit control state of A axis only
?limctr read limit control state of all axes

12.4. nosetlimit (Do not set Limits by Cal/Rm)

Syntax: !nosetlimit or ?nosetlimit
Parameter: x, y, z, a or none
 0 or 1

Description: Enables or disables setting of software limits by the calibration (**cal**) and range measure (**rm**) functions.
The default is nosetlimit=0 which means that the software limits are set by the cal/rm moves to these min/max positions.

Response: 0 = set software limits to !cal and !rm positions (default)
 1 = do not change software limits after !cal or !rm

Examples:
!nosetlimit 1 1 X and Y axis do not take software limits after !cal and !rm
!nosetlimit y 1 Y axis is does not set software limits of !cal and !rm move
?nosetlimit read nosetlimit state of all axes
?nosetlimit a read nosetlimit state of A axis only

12.5. swtyp (Type of Limit Switch)

Syntax: !swtyp or ?swtyp

Parameter: x, y, z or a (specifying an axis is recommended)
0 or 1, 0 or 1, 0 or 1

Description: Set or read the limit switch type, per axis only.
Assigns a pull-up or pull-down resistor to the switch input.
The sequence is always:

```
!swtyp [SWITCH_E0] [SWITCH_REF**] [SWITCH_EE]
```

0 = PNP: applies a pull-down resistor to the switch input

1 = NPN: applies a pull-up resistor (default)

Remarks: ** The REF switch is not used by the TANGO controller.

It is recommended to set each axis individually by using the axis parameter x, y, z or a.

Using no axis parameter will apply the the values to all axes!

Please note that the E0 and EE switches are reassigned by a change of the **axisdir** instruction.

Response: Currently selected limit switch type

Examples:

```
!swtyp z 0 0 1 set Z axis limit switches E0=PNP, REF(don't care), EE=NPN
```

```
?swtyp y read E0, EE switch types of Y axis (returns e.g. 1 0 1)
```

```
?swtyp
```

not recommended,

in extmode=0 returns e.g. 1 1 11 1 11 1 1

in extmode=1 returns e.g. 1 1 1 1 1 1 1 1 1

```
!swtyp 1 0 1
```

set limit switches to NPN type for all axes at once
(not recommended)

12.6. swpol (Polarity of Limit Switch)

Syntax: !swpol or ?swpol

Parameter: x, y, z or a (specifying an axis is recommended)
0 or 1, 0 or 1, 0 or 1

Description: Set or read the active polarity of the limit switches, per axis only. The sequence is always:

```
!swpol [SWITCH_E0] [SWITCH_REF**] [SWITCH_EE]
```

0 = switch has active low signal

1 = switch has active high signal

Remarks: ** The REF switch is not used by the TANGO controller.

It is recommended to set each axis individually by using the axis parameter x, y, z or a.

Using no axis parameter will apply the the values to all axes!

Please note that the E0 and EE switches are reassigned by a change of the **axisdir** instruction.

The **swin** instruction is not affected by the polarity setting, as it returns the TTL logic level and not the actuation state.

Response: Polarity of the limit switches

Examples:

```
!swpol y 1 1 1 set polarity of Y limit switches (E0 REF EE) to active high
```

```
!swpol z 0 0 0 set polarity of Y limit switches (E0 REF EE) to active low
```

```
?swpol x read limit switch polarity of the X axis (returns e.g. 0 0 0)
```

```
!swpol 1 0 1 set polarity of limit switches for all axes at once  
(not recommended)
```

12.7. swact (Enable or Disable Limit Switches)

Syntax: !swact or ?swact

Parameter: x, y, z or a (specifying an axis is recommended)
0 or 1, 0 or 1, 0 or 1

Description: Enable or disable the limit switches, per axis only.
The sequence is always:

```
!swact [SWITCH_E0] [SWITCH_REF**] [SWITCH_EE]
```

0 = switch is disabled (actuation state is ignored)
1 = switch is enabled

Remarks: ** The REF switch is not used by the TANGO controller.

It is recommended to set each axis individually by using the axis parameter x, y, z or a.
Using no axis parameter will apply the the values to all axes!

Please note that the E0 and EE switches are reassigned by a change of the **axisdir** instruction.

The **swin** instruction is not affected and can still be used to read the TTL logic level of the inputs.

Secvel velocity: If all switches of an axis are set to inactive, **secvel** will not be applied (no velocity limitation at all). If EE (rm) switch is set to inactive, the secvel limitation will be released after the cal. If both switches E0+EE are activated, cal+rm must be executed in order to release the secure velocity.

Response: Limit switch enable states [E0] [REF] [EE] (e.g. 1 0 1)

Examples:

```
!swact z 1 0 1 set Z limit switches E0=enabled REF=disabled EE=enabled
```

```
?swact a read limit switches enable state of A axis only (e.g. 1 0 1)
```

```
!swact 1 0 1 enable cal and rm limit switches for all axes at once  
(not recommended)
```

12.8. swdir (Swap Assignment of Cal and Rm Switch)

Syntax: !swdir or ?swdir
Parameter: x, y, z, a or none
 0 or 1

Description: Swap the cal(E0) and rm(EE) switch assignment.

0 = switches are not swapped (default)
1 = switches are swapped

In opposite to the axisdir instruction, which swaps motor direction and limit switch assignment, swdir only swaps the limit switches E0<->EE without changing the axis direction. This may become necessary due to wiring of the axis and depends on the axis hardware. It is independent of axisdir, which works with and without a swapped swdir.

Attention: swdir should only be used to compensate different wiring of the stage limit switches. **Swapping the switches to the wrong assignment may result in mechanical damage!**

Response: Current state of endswith assignment(s)

Examples:

```
!swdir 1 1 0       Swap E0<->EE switch assignment in X and Y, not in Z
!swdir x 1        Swap E0<->EE switch assignment in X (E0 switch is now EE etc.)
?swdir            Read switch assignment of all axes
?swdir z          Read switch assignment of Z axis only
```

12.9. readsw (Read Status of Limit Switches)

Syntax: ?readsw or readsw
Parameter: none

Description: Readsw returns the actuation state of the limit switch (while swin returns the signal level). Also readsw exchanges the E0 and EE switch assignment (cal direction is always E0) depending on '**axisdir**'. Disabled switches (swact) are read as 0.

0 = limit switch is currently not actuated or disabled
1 = limit switch is currently actuated (axis is in switch)

Please note that the switch state is only valid when the swtyp, swpol parameters are set correctly and the switch is activated by swact.

Sequence of the 12 characters is:

Axis: X Y Z A X Y Z A X Y Z A
Switch: [E0][E0][E0][E0][Ref][Ref][Ref][Ref][EE][EE][EE][EE]

E0 = lower limit switch (!cal instruction)
Ref = Reference switch (not available with TANGO)
EE = upper limit switch (!rm instruction)

Response: Actuation state of limit switches as 12 character ASCII string

Examples: readsw => 000000001000
 (read all limit switch actuation states, EE of X is actuated)

12.10. swin (Read Limit Switch Input Level)

Syntax: ?swin or swin
Parameter: none or 0...7

Description: This instruction reads the limit switch signal directly. The response is a string of 8 characters, either 0 or 1.

0 = limit switch input signal is TTL low
1 = limit switch input signal is TTL high

In opposite to the '**readsw**' instruction, swin reflects the TTL input levels. Even disabled switches are represented with their current TTL input signal level. Swin is not affected by axisdir setting (does not exchange E0 and EE switches). The [Ref] signals are not used.

Sequence of the 8 characters is:

Axis: X Y Z A
Switch: [E0][EE][E0][EE][E0][EE][E0][EE]
Index : 0 1 2 3 4 5 6 7

E0 = lower limit switch (!cal)
EE = upper limit switch (!rm)

Response: Limit switch input TTL level as 1 or 8 ASCII characters

Examples: swin => 11111111 (read all 8 limit switch signal levels)
 swin 1 => 1 (read EE of X Axis signal level)

12.11. statuslimit (Cal / Rm / Lim Status)

Syntax: ?statuslimit or statuslimit
Parameter: none

Description: Read the status of the soft- and hardware limits concerning the **cal**, **rm** and **lim** instructions. It can be used to check if the axes were already calibrated (cal) or range measured (rm) and if a software limit was set.

The status information is arranged in 4 groups.
The ASCII character string positions are:

```
0 ... 3: Group 1 => cal state of axis 0-3 (x,y,z,a) '-' or 'A'  
4 ... 7: Group 2 => rm state of axis 0-3 (x,y,z,a) '-' or 'A'  
8 ... 11: Group 3 => lower soft limit state of axis 0-3 (x,y,z,a) -,L  
12 ... 15: Group 4 => upper soft limit state of axis 0-3 (x,y,z,a) -,L
```

The characters represent the state with 4 possible characters:
- => cal or rm not performed, limit not set/modified since power on
A => axis is calibrated (!cal)
D => axis is range measured (!rm)
L => software limit has been modified by (!lim)

```
STRING: "-----" up to max. "AAAADDDLLLLLLLLL"  
AXIS : xyzaxyzaxyzaxyza  
LIMIT : CAL RM LIM-LIM+
```

Response: ASCII string of 16 characters

Example: Assume '?statuslimit' returns the string "AA-A---D-LL-L--L"

This means in detail:

```
[ 0] A -> X-axis is calibrated  
[ 1] A -> Y-axis is calibrated  
[ 2] - -> Z-axis is not calibrated  
[ 3] A -> A-axis is calibrated  
[ 4] - -> X-axis is not range measured  
[ 5] - -> Y-axis is not range measured  
[ 6] - -> Z-axis is not range measured  
[ 7] D -> A-axis is range measured  
[ 8] - -> X-axis lower software limit is not modified  
[ 9] L -> Y-axis lower software limit is modified  
[10] L -> Z-axis lower software limit is modified  
[11] - -> A-axis lower software limit is not modified  
[12] L -> X-axis upper software limit is modified  
[13] - -> Y-axis upper software limit is not modified  
[14] - -> Z-axis upper software limit is not modified  
[15] L -> A-axis upper software limit is modified
```

13. Calibration and Range Measure Instructions

After power on or **!reset** of the controller, a calibration (instruction **!cal**) followed by a range measure (instruction **!rm**) should be executed in order to set the axis origin and hardware position limits.

From then on the controller will stop the axes automatically at the end of the available positioning range. It also disables the secure travel speed limitation of **'secvel'**, which else is applied to protect the axes from possible damage.

The **cal/rm** instructions set the limits close to the limit switch positions. An additional position offset for the these limits can be specified with the instructions **!caliboffset** and **!rmoffset**.

Long axes and/or slow velocities may exceed the default calibration timeout of 40 seconds. Therefore the timeout can be set to the desired value by **caltimeout**. Please also refer to the optional **extmode** enhancements and **calmode** options for calibration. If a **!cal** or **!rm** was performed can be checked by **?statuslimit**.

13.1. cal (Perform Calibration to lower Limit Switch)

Syntax: `!cal or cal`
Parameter: `x, y, z, a or none`

Description: This instruction moves either the specified or all axes towards lower positions until the limit switch E0 is detected. If the corresponding switch is disabled (swact), cal will not be performed.
The behavior of CAL depends on the setting of **'extmode'**.

Extmode=0 (mostly the default setting):

- CAL travels towards switch with the axis velocity **'vel'**
- CAL travels out of switch with **'calbspeed'**

Extmode=1:

- CAL travels towards switch with **'calvel'** parameter 1
- CAL travels out of switch with **'calvel'** parameter 2

The movement stops slightly after traveling out of the switch. If required, this travel distance can be increased by specifying a **'caliboffset'**.

Depending on the **'calmode'** setting this position is used as origin (position 0) and if **'nosetlimit'** is set to 0 (default) also as the new lower software limit.

Remarks: The calibration status can be read by checking **'statuslimit'**. Cal can use an encoder reference mark to set a precise zero position. Therefore, **'encref'** must be set to 1.

Response: **Autostatus** dependent, similar to **!moa**, **!mor** etc. but instead of an '@', the returned status string contains a 'A' after a successful calibration or 'E' if an error occurred (cal was unsuccessful) 'T' if a timeout occurred (cal was unsuccessful) '-' the axis is not present

Examples:

```
!cal          execute a calibration for all enabled axes => "AAA-."
cal y        execute a calibration for Y axis           => "@A@-."
```

```
This sequence calibrates the X and Z axis => "A@A-."
"!axis 1 0 1"
"!cal"
"!axis 1 1 1"
```

13.2. rm (Perform Range Measure to upper Limit Switch)

Syntax: !rm or rm

Parameter: x, y, z, a or none

Description: This instruction moves either the specified or all axes towards higher positions until the limitswitch EE is detected. If the corresponding switch is disabled (swact), rm will not be performed.
The behavior of RM depends on the setting of '**extmode**'.

Extmode=0 (mostly the default setting):

- RM travels towards switch with the axis velocity '**vel**'
- RM travels out of switch with '**calbspeed**'

Extmode=1:

- RM travels towards switch with '**rmvel**' parameter 1
- RM travels out of switch with '**rmvel**' parameter 2

The movement stops slightly after traveling out of the switch. If required, this travel distance can be increased by specifying a '**rmoffset**'.

if '**nosetlimit**' is set to 0 (default), rm also sets the rm-position as the new upper software limit.

Remarks: The rangemeasure status can be read by checking 'statuslimit'.

Response: **Autostatus** dependent, similar to !moa, !mor etc. but instead of an '@', the returned status string contains a 'D' after a successful rangemeasure or 'E' if an error occurred (cal was unsuccessful) 'T' if a timeout occurred (cal was unsuccessful) '-' the axis is not present

Examples:

```
!rm          execute a range measure for all enabled axes => "DDD-."
rm y        execute a range measure for Y axis           => "@D@-."
```

Or the sequence

```
"!axis 1 0 1"
```

```
"!rm"
```

```
"!axis 1 1 1"
```

```
range measure the X and Z axis, while Y is not used => "D@D-."
```


13.3. vrm (Virtual Range Measure)

Syntax: !vrm or vrm

Parameter: x, y, z, a or none
Axis length(s) in user **dim**

Description: Can replace the need of an **rm** move, by just defining the axis length without axis travel (time saving).

Same as with the **rm** instruction the

- SecVel is released
- corresponding statuslimit 'E' entry is set
- hardware limit is set

Vrm requires that **!cal** was performed on the axis.
Vrm does not return any autostatus reply (like the @@@-).

Warning: Specifying a wrong axis length can cause mechanical damage.

Remarks: Check **?err** response or **statuslimit** for 'E' entries to make sure the parameters were accepted.

If axes are not **calibrated** the vrm function causes error 2.

Axes with MR encoders (nanoScale) should always perform a true Rm for high accuracy measurement.

Vrm can also be used before executing an **rm** move in order to travel fast (without **secvel** limitation) near the **rm** limit switch → then **rm** can be executed (caution: velocity might be high now) to get the real maximum hardware travel range and/or to allow the above mentioned encoder autoadjust which is performed during **rm**. [Example #3]

Response: None

Examples:
vrm 75 50 virtual range measure (define axis lengths of X=75, Y=50)
vrm y 150 virtual range measure for Y axis (define Y=150)

Sequence example1:
cal x
cal y
cal z
?statuslimit => "AAA-----"
vrm 300 300 20
?statuslimit => "AAA-DDD-----"

Sequence example2:
cal x
cal y
!moa 10 10
!pos 0 0 (the lower limit is now at position -10 -10)
vrm 300 300 (the upper limit is set to 290 290)

Sequence example3:
cal x (calibrate the X axis)
!vel 40 (set X velocity to e.g. 40mm/s)
vrm 300 (virtually set X rm for e.g. a 300mm axis)
!moa 300 (move to end of X travel range without secvel)
!vel 10 (slow down for executing rm)
!rm x (perform true hardware rm from here=time saving)

13.4. calmode (Closed Loop/Calibration Behavior)

Syntax: !calmode or ?calmode

Parameter: x, y, z, a or none
0, 1 or 2

Description: This instruction reads or sets the closed loop behavior on power-up and also affects the calibration behavior:

0 = Cal instruction sets the zero position (default setting)
Closed loop enabled after cal move

1 = the power-up position remains the zero position even after calibration
Closed loop is enabled from power-up

2 = Cal instruction sets the zero position
Closed loop is enabled from power-up

Remarks: For activating the closed loop, the '**encmask**' of the corresponding axes must be set to one. If encmask is not set or no encoder is present, the calmode only affects the axis zero position behavior.
In calmode 1 the zero position of the CAL instruction can be read out by using '**?calzeropos**'.

Response: Calmode of the axes

Examples:

```
!calmode 0 0 0 Calmode behavior of axes X,Y,Z set to default operation
!calmode z 2 Set Z axis to enter closed loop instantly after power-up
?calmode Read calmode of all axes
?calmode y Read calmode of Y axis only
```

13.5. calrequired (Calibration Required)

Syntax: !calrequired or ?calrequired

Parameter: x, y, z, a or none
0 or 1

Description: The calibration required mode offers a mechanism to prevent axis travel until the **!cal** instruction is executed. It can be used to e.g. prevent collisions until the axis is in a known position.

0 = The axis can travel even without !cal (default)

1 = The axis is halted until a !cal is executed

Response: Calrequired setting of the axes

Examples:

```
!calrequired 0 0 0 No cal required to enable X,Y,Z axis move (default)
!calrequired z 1 Cal required to enable axis move in Z
?calrequired Read calrequired mode of all axes
?calrequired y Read calrequired mode of Y axis only
```

13.6. caltimeout (Calibration Timeout)

Syntax: !caltimeout or ?caltimeout
Parameter: x, y, z, a or none
1 to 120 (seconds, as integer)

Description: This instruction specifies the timeout for calibration (**cal**) and range measure (**rm**) instructions. It can be set for each axis individually, depending on axis length and velocities. The default value is 40 or 60 seconds.

Remarks: For long axes (over 350mm) the default timeout of 40...60s becomes insufficient and must be increased, as the typical cal, rm travel velocity is 10mm/s and the cal, rm routines require some additional time around the limit switch.

Response: Calibration+RangeMeasure timeout in seconds

Examples:

```
!caltimeout 60 60 60    set the cal/rm timeout for X,Y,Z to 60 seconds
!caltimeout x 40       set the cal/rm timeout for X to 40 seconds
?caltimeout            read timeout of all axes
?caltimeout z         read timeout of Z axis only
```

13.7. caliboffset (Calibration Offset)

Syntax: !caliboffset or ?caliboffset

Parameter: x, y, z, a or none
Position (0.0 ... 100mm, unit depends on 'dim')

Description: This instruction specifies a calibration position offset. When executing a 'cal' instruction, the axis travels this extra distance away from the limit switch E0 and sets the origin (axis zero position) there. The unit depends on the current 'dim' settings. Valid position range is "0.0 to 100mm equivalent". The default value is 0.

Response: Calibration Cal switch position offset

Examples:

```
!caliboffset 10 5.5 0.1 set the calibration offset for X, Y and Z axis
!caliboffset x 0.05    set the calibration offset for X axis to 0.05
?caliboffset          read the calibration offset of all axes
?caliboffset y        read the calibration offset of Y axis only
```

13.8. roffset (Range Measure Position Offset)

Syntax: !roffset or ?roffset

Parameter: x, y, z, a or none
Position (0.0 ... 100mm, unit depends on 'dim')

Description: Similar to caliboffset, this instruction specifies an extra position offset for the 'rm' instruction. The axis travels this extra distance away from the upper limit switch EE and sets upper limit position there. The unit depends on the current 'dim' settings. Valid position range is "0.0 to 100mm equivalent". The default value is 0.

Response: Range Measure RM switch position offset

Examples:

```
!roffset 1 1 1    set the range measure offset to 1 (mm at dim 2) for X, Y and Z
!roffset z 0.1    set the range measure offset to 0.1 (mm at dim 2) for Z only
?roffset          read range measure position offset of all axes
?roffset z        read range measure position offset of Z axis only
```

13.9. caldir (Calibration Direction)

Syntax: !caldir or ?caldir

Parameter: x, y, z, a or none
0 or 1

Description: Dummy instruction, has no function. 'axisdir' may be used to change the axis direction.

Response: 0 or 1

Examples:

```
?caldir          read caldir of all axes
?caldir x        read caldir of X axis only
!caldir y 1      set Y caldir to positive direction
!caldir 0 0 1    set Z caldir to positive direction, X and Y to negative
```

13.10. calbspeed (Calibration Speed for Retraction)

Syntax: !calbspeed or ?calbspeed

Parameter: x, y, z, a or -1
0.1 to 8000 [*0.01 revolutions/s]

Description: **(Available in EXTMODE=0 only, else use calvel/rmvel)**
Set or read the cal/rm calibration speed which is used for traveling out of the limit switches E0 and EE.

Remarks: RESTRICTIONS APPLY DUE TO BACKWARDCOMPATIBILITY. See examples. Setting the calbspeed without specifying an axis will set all axes to this one value. It is recommended to access axes individually. Refer to examples below. Calbspeed is only available in **extmode=0**. For improved behavior and flexibility please refer to the **calvel**, **rmvel** instructions, which become available with **extmode=1** and replace the calbspeed and vel.

Response: Currently used calibration back speed [in 1/100 motor rev/s]

Examples:

```
!calbspeed 50 50  ILLEGAL INSTRUCTION!  
!calbspeed 15    COMPATIBILITY RESTRICTIONS! 0.15 [revolutions/s] for all axes!  
?calbspeed      COMPATIBILITY RESTRICTIONS! returns one parameter!
```

```
?calbspeed -1    read the the limit switch retraction speed of all axes  
!calbspeed z 20  set the limit switch retraction speed for Z only (recommended)  
?calbspeed x     read the limit switch retraction speed for X (recommended)
```

13.11. calrefspeed (Reference Signal Calibration Speed)

Syntax: !calrefspeed or ?calrefspeed

Parameter: x, y, z, a or -1
0.1 to 8000 [*0.01 revolution/s]

Description: Reference mark calibration speed. This speed is used when searching the encoder reference mark. The default value is 32 (0.32 rev/s). There is only one value for all axes.

Remarks: RESTRICTIONS APPLY DUE TO BACKWARDCOMPATIBILITY. See examples. **It is recommended to use the new instruction 'encrefvel'.**

Response: Currently used calrefspeed [in 1/100 motor rev/s]

Examples:

```
!calrefspeed 5 5  ILLEGAL INSTRUCTION!  
!calrefspeed 15  COMPATIBILITY RESTRICTIONS! 0.15 [revolutions/s] for all axes!  
?calrefspeed     COMPATIBILITY RESTRICTIONS! returns one parameter!
```

```
?calrefspeed -1  read the the referencing speed of all axes  
!calrefspeed z 20 set the referencing speed for Z only (recommended)  
?calrefspeed x   read the referencing speed for X (recommended)
```

13.12. encrefvel (Encoder Ref Signal Calibration Velocity)

Syntax: !encrefvel or ?encrefvel

Parameter: x, y, z, a or none
0.000001 to 3000 [rev/s] (or [mm/s] if dim=9)

Description: Replaces the !calrefspeed instruction.
Set or read the velocity, at which the reference mark search is performed (during **!cal**, after releasing the limit switch).

Response: Currently used encrefvel in [rev/s] or [mm/s] when dim=9

Examples:

```
!encrefvel 5 5 5 Set encoder reference mark search velocity to 5 (mm/s @ dim=9)
!encrefvel z 0.5 Set encoder reference mark search velocity for Z axis to 0.5
?encrefvel Read velocities of all axes
?encrefvel y Read velocities of Y axis only
```

13.13. refdir (Direction for Searching Reference Signal)

Syntax: !refdir or ?refdir

Parameter: x, y, z, a or none
0 or 1

Description: DUMMY INSTRUCTION.
Specifies or reads the direction in which to search the reference switch [REF]. This switch is not available with TANGO controllers.

Response: 0 = search in negative direction (default)
1 = search in positive direction

Examples:

```
!refdir y 1 set the Y-axis reference search to positive direction
!refdir 1 1 0 set the reference search direction of X, Y and Z axis
?refdir read reference search directions of all axes
?refdir x read reference search direction of X axis only
```

13.14. calpos (Calibration Position)

Syntax: !calpos or ?calpos
Parameter: x, y, z, a or none
position value (unit depends on 'dim')

Description: Used in combination with an encoder to measure calibration position accuracy (repeatability of the origin). During calibration the encoder signal period, where the limit switch E0 was released and the origin (pos=0) was set, is stored. This position value within an encoder period can be read with ?calpos.
The position may also be set to another value. The unit depends on the setting of 'dim'. Valid range is 0 to 100mm equivalent.

Remarks: This instruction is used for systems with encoders only.

Response: A position within the range of one encoder signal period

Examples:
?calpos y read calibration position of Y axis (e.g. returns 0.0000)
?calpos read calibration position of all axes
!calpos 0 0 0 set calibration positions to zero (X, Y and Z)
!calpos y 0 set calibration position of Y axis to zero

13.15. calzeropos (Position at CAL)

Syntax: ?calzeropos
Parameter: x, y, z, a or none

Description: In **calmode 1**, the axis position is not set to zero by the **cal** instruction. In order to determine the "zero" position after **cal**, calzeropos can be read.

Remarks: CalModes other than 1 (0,2) set the position to zero after executing cal. So the returned position is zero in this cases.

Response: Postion at which the **cal** instruction completed.

Examples:

Assuming calmode set to "!calmode 2 1 0 0" and cal already executed on all axes:

```
?calzeropos y -153.1433
?calzeropos 0.0000 -153.1433 0.0000 0.0000
?calzeropos x 0.0000
```

Assuming all axes traveled +10 mm after the cal instruction:

```
?calzeropos y -153.1433 (this axis is in calmode 1)
?pos y -143.1433 => -143.1433 - (-153.1433) = 10.0000

?calzeropos x 0.0000 (this axis is in calmode 2)
?pos x 10.0000 => 10.0000 - 0.0000 = 10.0000

?calzeropos z 0.0000 (this axis is in calmode 0)
?pos z 10.0000 => 10.0000 - 0.0000 = 10.0000
```

13.16. calvel (Calibration Velocities for CAL Instruction)

Syntax: !calvel or ?calvel
Parameter: x, y, z, a or none
one or two velocities (depending on dim)

Description: **This instruction is accessible in EXTMODE=1 only.**
If **extmode** is set to 1, this instruction replaces the **calbspeed** and **vel** parameters for the calibration (!cal) instruction:

Parameter 1 : speed towards cal limit switch (find)
Parameter 2 : speed out of cal limit switch (slow release)

Velocity unit: [motor rev/s] for dim = 0 ... 8
[mm/s] for dim = 9

The travel speed towards the limit switch should not be faster than 10mm/s to prevent mechanical damage (axis must be able to stop within a short distance after a limit switch event).
The travel speed out of the limit switch should be low for achieving high position accuracy, e.g. 0.5mm/s

Remarks: calvel can be set per axis only, with x,y,z,a specified

Response: Two velocities (towards and out of limit switch) per axis

Examples:
!calvel x 10 0.5 !cal in X travels towards rm limit switch at a velocity of 10
and out of the limit switch at a velocity of 0.5
!calvel x 10 set the velocity towards the switch only
?calvel read cal velocities of all axes (xvel1 xvel2 yvel1 yvel2 etc.)
?calvel y read cal velocities of Y axis only (e.g. returns 10.000 0.500)
!calvel 10 0.5 not supported, set instruction is per axis only

13.17. **rmvel (Range Measure Velocities for RM Instruction)**

Syntax: `!rmvel` or `?rmvel`
Parameter: `x, y, z, a` or none
one or two velocities (depending on dim)

Description: **This instruction is accessible in EXTMODE=1 only.**
If `extmode` is set to 1, this instruction replaces the `calbspeed` and `vel` parameters for the range measure (`!rm`) instruction:

Parameter 1 : speed towards rm limit switch (find)
Parameter 2 : speed out of rm limit switch (slow release)

Velocity unit: [motor rev/s] for dim = 0 ... 8
[mm/s] for dim = 9

The travel speed towards the limit switch should not be faster than 10mm/s to prevent mechanical damage (axis must be able to stop within a short distance after a limit switch event).
The travel speed out of the limit switch should be low for achieving high position accuracy, e.g. 0.5mm/s

Remarks: `rmvel` can be set per axis only, with `x,y,z,a` specified

Response: Two velocities (towards and out of limit switch) per axis

Examples:
`!rmvel x 10 0.5` `!rm` in X travels towards rm limit switch at a velocity of 10
and out of the limit switch at a velocity of 0.5
`!rmvel x 10` set the velocity towards the switch only
`?rmvel` read cal velocities of all axes (`xvel1 xvel2 yvel1 yvel2` etc.)
`?rmvel y` read cal velocities of Y axis only (e.g. returns 10.000 0.500)
`!rmvel 10 0.5` not supported, set instruction is per axis only

13.18. **autopitch (Measure Pitch after CAL Instruction)**

Syntax: `!autopitch` or `?autopitch`
Parameter: `x, y, z, a` or none
0 or 1

Description: Measures and sets the spindle pitch each time when executing a cal instruction.

Remarks: Only works if encoders are present.
Not recommended for spindles and precision drives.

Response: Autopitch enabled (1) or disabled (0, default)

Examples:
`!autopitch 1 1 0` Measure and readjust pitch after each cal instruction X and Y
`!autopitch y 1` Measure and readjust pitch after each cal instruction in Y
`?autopitch` read autopitch setting of all axes
`?autopitch x` read autopitch setting of X axis

Pitch measuring sequence example: `"!autopitch x 1"`
`"!cal x"`
[wait for reply]
`"!autopitch x 0"`
`"?pitch x"`
`"!save"`

14. Move Instructions

Move instructions cause the TANGO to move axes to certain positions or to travel at a constant, specified velocity. Positioning can be executed for individual axes or combined as a vector move.

Positioning (moa, mor, m, moc) is based on the velocity (vel) and acceleration (accel, accelfunc) settings. If executed as a vector of 2 or more axes, the TANGO automatically selects the leading axis and adjusts the other axes in a way that none of their velocity and acceleration parameters is exceeded.

Moa and mor are similar instructions. Moa travels based on absolute coordinates, defined by the axis origin or the overwritten **pos**, while **mor** travels relative to the current position.

The '**m**' instruction can be used to achieve high vector throughput with little communication overhead (often combined with autostatus=3). The relative distances have to be preset - either the last **mor** or a **distance** instruction.

A special case of positioning is available with the **!go** instruction. It does not move as a vector, here each axis travels at its own velocity and accel settings. Also it only provides linear acceleration (accelfunc does not apply). The advantage of the **!go** instruction is that it can be overwritten at any time with no need to abort the currently executed move. It will smoothly change directions. Target applications are e.g. focusing via a slider or tracking a mouse cursor position.

The third option for axis travel is speed move. Here not positions but velocities are specified. The addressed axes travel at this velocities until stopped, aborted or reaching a position limit. Like **!go**, the speed instruction is also not executed as a vector and does not use the accelfunc. Speed requires the joystick to be enabled (**joy** and **joydir**).

Remarks on relative positioning:

Due to internal resolution a sequence of many consecutive relative moves may lead to (minor) absolute position deviation. Executing an absolute move at times is recommended.

Also, if HDI is enabled, minor changes in position may occur due to the connected device (Joystick, ERGODRIVE). Which can also accumulate position error when only using relative moves. It is recommended to deactivate the HDI when using relative moves (by instructions **joy** or **joydir**).

14.1. moa (Move Absolute)

Syntax: !moa or moa
Parameter: x, y, z, a or none
position values within \pm maxpos

Description: This instruction commands one or more axes to the specified position(s). The position unit depends on **dim** settings.

Response: Depends on **autostatus** settings, which per default is set to 1. Each commanded (and enabled) axis responses either '@' after successfully completing the move, or 'E' if an error occurred. For further information on response options, please refer to **autostatus** and **statusaxis**.

Examples:
moa 10 0 20 axes X,Y,Z travel to the specified positions (vector move)
moa 10 0.5 axes X and Y travel to the specified positions (vector move)
moa x 10.2 X-axis travels to position (e.g. 10.2mm if dim=2)
moa 10.2 same as "moa x 10.2"
moa y 34.5 Y-axis travels to position (e.g. 34.5mm if dim=2)

14.2. mor (Move Relative)

Syntax: !mor or mor
Parameter: x, y, z, a or none
distance values within \pm maxpos

Description: This instruction commands one or more axes relative to the current position. The position unit depends on **dim** settings.

Response: Depends on **autostatus** settings, which per default is set to 1. Each commanded (and enabled) axis responses either '@' after successfully completing the move, or 'E' if an error occurred. For further information on response options, please refer to **autostatus** and **statusaxis**.

Examples:
mor 10 0 -20 axes X,Y,Z travel the specified distances (vector move)
mor 10 0.5 axes X and Y travel the specified distances (vector move)
mor x 10.2 X-axis travels the specified distance (e.g. 10.2mm if dim=2)
mor 10.2 same as "mor x 10.2"
mor y -34.5 Y-axis travels e.g. (if dim=2) 34.5mm backwards

14.3. m (Move Relative Shortcut)

Syntax: !m or m
Parameter: none

Description: The instruction is a shortcut (abbreviation) of mor. It is useful to speed up communication especially for consecutive identical vectors. The vector is taken from the preceeding !mor or !distance instruction. The instruction will move all enabled axes if their distance is not zero.

Response: Depends on state of autostatus, recommended is mode 3.

Example: Positioning sequence involving moa,mor,m

!moa 1 2 3 4	will move to 1 2 3 4	
!mor 1 1 1 1	will move to 2 3 4 5	(mor sets distance)
m	will move to 3 4 5 6	
!distance 0 2 0 0		(specify distance)
m	will move to 3 6 5 6	
m	will move to 3 8 5 6	

14.4. distance (Distance for m)

Syntax: !distance or ?distance
Parameter: x, y, z, a or none
Distance (within ±maxpos)

Description: This instruction sets the travel distance for !m instructions. The unit depends on the '**dim**' settings.

Remarks: The distance value is also set by each '!mor' instruction. Distances must be defined for all axes, axes that shall not move have to be set to distance = 0.

Response: Currently used value for distance (unit depends on '**dim**')

Examples:

?distance	read distance values of all axes
?distance z	read distance value of Z axis only
!distance 10 20 0	set X and Y distance
!distance 1 2 0.5	set X, Y and Z distance
!distance y 20.2	set Y distance only, other axes keep their distance values

14.5. moc (Move to Center)

Syntax: !moc or moc
Parameter: x, y, z, a or none

Description: The specified or all enabled axes travel to the center position between their lower and upper software limit. It is recommended to first execute the !cal and !rm instructions.

Response: Depending on the **autostatus** setting, each successful centered axis responds with "@".

Examples:

moc	all axes travel to their center position
moc y	Y-axis travels to the center position

14.6. mol (Move to LockPos)

Syntax: !mol or mol

Parameter: x, y, z, a or none

Description: The specified or all enabled axes travel to the transportlock position. This special move instruction may be used to position the microscope stage or axes to their transport position, where the fixation screw is inserted.

Requirements: 1) The axes must be calibrated (by **!cal**)
2) The lock position must be stored in the ETS or virtual ETS

Remarks: The factory defined lock positions can be read by **lockpos**.
If the position value is greater 0, a lock position is available.

Response: Depending on the **autostatus** setting,
each axis responds with "@".

Examples:

mol all axes travel to their transportlock position (if available)
mol y Y-axis travels to to the transportlock position (if available)

14.7. go (Go To Position)

Syntax: !go or go
Parameter: x, y, z, a or none
 position values within \pm maxpos

Description: Used for position tracking applications.
 Similar to the 'moa' instruction, 'go' executes a move
 of one or more axes to an absolute position.

The differences to absolute move instructions are:

- Go can be overwritten anytime, also when moving, by another go position (without the need to abort or to stop it first)
- The velocity can be changed while traveling (**vel**)
- The move can be ended (at the normal acceleration) by sending a go instruction without position value, or by setting vel=0 ("go" stops all axes, "go y" only the Y axis etc.)
- Go is no vector move, each axis moves at its own velocity (**vel**) and acceleration (**accel**)
- It supports only linear acceleration (no s-curve)
- No autostatus reply on completion (polling of **statusaxis** \neq 'M' required)

The unit of the position values depends on **dim**.

Remarks: In order to check for a completed go move, please poll the
 '**statusaxis**' state, which should not be 'M' then.

Snapshot Mode **snsn** 6 is ignored by the go instruction.

Response: None.

Examples:
go 10.7 14 axes X and Y travel to the specified positions (no vector)
go x 10.2 the X-axis travels to position 10.2 ([mm] assume dim=2)
go 10.2 same as "go x 10.2"
go 10.1 -0.5 0 axes X, Y, Z travel to the specified positions (no vector)
go (or !speed 0 0 0) stops the go instruction for X, Y and Z axis (using **accel**)
go z (or !speed z 0) stops the go instruction for Z axis only

go 10 100
go 2 11.5 => change in direction while axis already traveling

Sequence examples (extended functionality, TANGO Firmware 1.60C and higher):

!vel z 10
go z 100 => starts an absolute move in Z at a velocity of 10
!vel z 1 => changes the velocity of Z to 1 while still traveling
!vel z 0.1 => changes the velocity of Z to 1 while still traveling

go 0.5 5.2 100.15 => start absolute move for X, Y and Z axis
!vel y 40 => changes the velocity of Y to 40 while still traveling
!vel 20 15 40 => changes velocities of X, Y and Z while still traveling

go 10 100 => starts an absolute move in two axes (X, Y), now...
"go x" or "!vel x 0" or "!vel 0" will end the X move at the default acceleration
"go y" or "!vel y 0" will end the Y move at the default acceleration
"go" or "!vel 0 0" will end the two axis move

14.8. speed (Speed Move)

Syntax:	!speed or ?speed
Parameter:	x, y, z, a or none +-100.0 [rev/s] or [mm/s] in dim=9 only
Description:	Axes start traveling at the specified velocities. It can be stopped by setting the speed to zero, by abort (a) and by reaching a soft- or hardware limit. Speed uses the acceleration set by accel and only provides linear acceleration.
Remarks:	Joydir must be enabled in to execute speed instructions. For endless rotation please refer to modulomode=1 or !zero . Setting speed to zero also stops the go instruction. Joydir enables/disables individual axes for the speed instruction.
Response:	Currently executed speed in [rev/s], or [mm/s] if dim=9 There is no autostatus reply.
Examples:	<pre>!speed 33 0.01 start speed move for X= 33[rev/s] and Y= 0.01[rev/s] !speed 10 start speed move for X-axis to 10[revolutions/s] !speed y 0.001 start speed move for Y-axis !speed 0 0 0 0 stop speed move for all axes !speed 0 stop speed move for X-axis !speed z 0 stop speed move for Z-axis ?speed read the currently executed speed of all axes ?speed z read the currently executed speed of Z-axis only ?speed 5 read the currently executed speeds with 5 fractional digits ?speed z 6 read the currently executed Z speed with 6 fractional digits</pre>

14.9. a (Abort the Current Move)

Syntax:	!a or a or [hex 0x03]
Parameter:	x, y, z, a, -1 or none
Description:	This instruction stops either all axes or the specified axis and sets them into position reached state. Stop is performed with high acceleration set by stopaccel . PCI-E and DT-E controllers from Firmware 1.66 support the option (-1), where the axis stops at regular accel acceleration (**). Most TANGO controllers also provide the "Ctrl+C" (hex 0x03) special character stop, which bypasses the parser (faster response, independent of running instructions) to stop all axes and clear the input buffer.
Remarks:	Abort might fail in special cases of closed loop errors. In such case closed loop has to be deactivated as well.
Response:	Depends on the instruction being executed (moa, speed, go etc.) and autostatus . If a move was aborted in autostatus=1 (default) and all axes stopped, each axis responds an '@'.
Example:	<pre>a (abort move of all axes , with stopaccel) a y (abort move of Y axis only, with stopaccel) a -1 (abort move of all axes , with accel) ** a z -1 (abort move of Z axis only, with accel) **</pre>

14.10. delay (Set the Delay Time for Consecutive Moves)

Syntax: ?delay or !delay

Parameter: 0 to 10000 [ms]

Description: This instruction will insert a delay time before executing a move (delayed start). There is only one value for all axes.
Applies to: moa,mor,moc,m

Response: Delay time in [ms]

Examples:

!delay 500 Delay the start of a move instruction by 0.5 seconds

?delay Read the delay time

14.11. pause (Set the Pause after Position Reached)

Syntax: ?pause or !pause

Parameter: 0 to 10000 [ms]

Description: Complementary to **delay**, this instruction adds a pause time after the axes have reached their target positions. In autostatus=1 mode the "@@@" response is delayed by this time. It may be used to insert an automatic settling time after moa,mor,moc or m. There is only one value for all axes.

Response: Pause time in [ms]

Examples:

!pause 10 Delay the autostatus response of a move by 10 milliseconds

?pause Read the pause time

14.12. pos (Read or Set Position)

Syntax: !pos or ?pos
Parameter: x, y, z, a or none
 Position (within \pm maxpos)

Description: This instruction either reads or sets the axis position.
 If set, this defines a new absolute position of the axis.
 The unit depends on the selected dimension (**dim**).

Remarks: Even axes with encoders return the motor position by default.
 Returning the encoder position can be achieved by setting the
 corresponding '**encpos**' to 1.

 The effect of manipulating positions with '!pos' can be
 removed by the instruction '**posclr**'. Also the difference
 (offset) from the original zero position can be read by it.

Response: Axis position(s) (depends on **dim**, also **enc** and **encpos** state)

Examples: ?pos Read all axis positions
 ?pos z Read Z axis position only
 !pos 100 200 Set the current X and Y axis positions
 !pos x 0 Set the current X position to zero
 !pos -0.1 Set the current X position to -0.1 (unit depends on dim)
 !pos y 2000 Set the current Y position to 2000 (unit depends on dim)

14.13. posclr (Clear Position Offset)

Syntax: !posclr or ?posclr
Parameter: x, y, z, a or none

Description: Reset or read the position offset to the axis origin, which
 was added by a '**!pos**' instruction.

 The absolute position can be redefined by '!pos'. In order to
 return to the original absolute position, clearpos offers
 reading or clearing of the changes made by '!pos'.

Response: Position offsets (depending on **dim**)

Examples: !posclr x (reset X to original position)
 !posclr (reset all positions to original position)
 ?posclr (read position offset of all axes)

 ?pos => 1.0000 **2.0000** 3.0000
 !pos y 8 *(here a position offset of 8-2=6 is added to Y)*
 ?pos => 1.0000 **8.0000** 3.0000
 ?posclr => 0.0000 **6.0000** 0.0000
 !posclr *(here the !pos set position offsets are removed)*
 ?pos => 1.0000 **2.0000** 0.0000

14.14. zero (Set Internal Position to Zero)

Syntax: !zero or zero

Parameter: x, y, z, a or none

Description: Unlike "**!pos 0**", the "**!zero**" instruction also resets the internal position counter to zero. It can be used in applications where axes exceed the position limits, e.g. filter wheels (in such case a "**!pos 0**" instruction is not sufficient, as internal limits will apply). In order to ensure the reference point remains at the same position, the zero instruction should be executed after completing one or several complete revolutions.

Remarks: For rotational axes '**modulomode**' can be used. In these modes, setting the axes to zero is not required.

Response: none.

Examples:

!zero Set all internal positions to zero

!zero z Set Z axis position to zero

14.15. clearpos (Set Internal Position to Zero)

Syntax: !clearpos or clearpos

Parameter: x, y, z, a or none

Description: For compatibility with LStep controllers. Functionality is almost the same as with the '**zero**' instruction. The only difference is that the clearpos instruction is not executed when in closed loop.

Response: none.

Examples:

!clearpos Set all internal positions to zero

!clearpos x Set X axis position to zero

15. HDI Instructions (Joystick, Trackball, ERGODRIVE)

The HDI (human device interface) provides manual control of the axes and also supports special functions.

The HDI interface accepts hot plugging of the devices. It is possible to unplug, plug in, or exchange the input devices during operation of the TANGO controller.

The HDI velocities are limited to the **sevel** velocity as long as no **cal** and **rm** sequence has been executed. The axis travel will stop at either the hardware limit switches or the software limits (defined by **lim** instruction).

The Joystick velocities are either taken from the current axis velocity **vel** or, if **extmode** is enabled, as an independent **joyvel**.

The **keymode** functionality enables selection of different **keyspeed** or **zwtravel** wheel velocities by pressing the function keys F1-F4 of the joystick. Please refer to **keymode** for further information.

The optional **multi-function wheel**, found on several HDI devices, can be assigned to any axis (instruction **zaxis**) and the LED100 brightness (via **hdimode**).

15.1. joy (Generally Enable/Disable HDI)

Syntax: !joy or ?joy
Parameter: 0, 1, 2, 3, 4 or 5

Description: Generally enable or disable the connected HDI device (joystick, trackball, ERGODRIVE etc.)
It is recommended to only use the values 0 or 2. For compatibility, a value of 1 has the same effect as 2.

0 = OFF : disable HDI device
2 = ON : enable HDI device (default setting)

If joy is switched from an ON state to OFF (0), an automatic status message like "@@@" is generated. If this is not wanted a workaround is using **joydir** to disable the HDI or temporarily disabling autostatus.

Response: HDI enable state

Examples:

!joy 0 disable the HDI device (e.g. joystick) and speed instruction
!joy 2 enable the HDI device (default) and speed instruction
?joy read HDI enable state

Behavior examples / sequences:

```
-----  
?joy     ==> 2        (HDI is enabled)  
!joy 0   ==> @@@- .  (response when switched to disable, default autostatus on)  
!joy 0               (no response when joy already is disabled)  
!joy 2               (no response when joy is enabled)  
-----
```


```
!autostatus 0        (workaround #1 to avoid response when disabling)  
!joy 0  
!autostatus 1  
-----
```

```
!joydir 0 0 0 0      (workaround #2 is to use 'joydir' instead)  
!joydir 2 2 2 2      (make sure the direction is correct, 2 or -2)  
-----
```

15.2. joydir (Joystick Direction or Assign Joystick per axis)

Syntax: !joydir or ?joydir
Parameter: x, y, z, a or none
 and 0, 1, 2, -1, -2

Description: In addition to the '**joy**' instruction, joydir can be used to enable/disable individual HDI axes and set their directions. It is recommended to use the values 2, 0 or -2. The options are:

0 = Disable HDI axis (e.g. joystick deflection is ignored)
 = Enable HDI axis, no motor current reduction)
= Enable HDI axis, current reduction supported (default)
(-1 = Same as 1, direction reversed)
-2 = Same as 2, direction reversed

Remarks: Please also make sure that the joystick function is globally enabled by the '**joy**' instruction.

When using a 4 axis controller with a 3 axis HDI device, the 3rd axis must be assigned to axis 3 (=default setting), 4 or both (3 and 4) by enabling/disabling their joydir!

This instruction also enables or disables (0) the '**speed**' move for the corresponding axes, but does not affect the speed move directions (set to 2 or -2 only works as enable).

Response: HDI directions of the axes or specified axis

Examples:
!joydir -2 enable HDI X-axis in reversed direction
!joydir z 0 disable HDI Z-axis
!joydir 2 2 0 2 set positive direction, allow current reduction, assign the joysticks 3rd axis to the controller A axis instead of Z
?joydir read HDI enable/direction setting of all axes
?joydir y read HDI enable/direction setting of Y axis only

15.3. joychangeaxis (Change Joystick X and Y Axis)

Syntax: !joychangeaxis or ?joychangeaxis
Parameter: 0 or 1

Description: Change the assignment of the Joystick X and Y axes.

0 = no change (default)
1 = Joystick X and Y axes changed (X=Y, Y=X)

Remarks: Only for Joystick devices.

Response: Joystick X-Y axis change state

Examples:
!joychangeaxis 1 change X and Y axis of the Joystick
?joychangeaxis read Joystick X,Y change state

15.4. joywindow (Joystick Window)

Syntax: !joywindow or ?joywindow
Parameter: 0 to 100

Description: This instruction sets the center position threshold of the Joystick in digits. A deflection, as long as it is in this window, has no effect. There is only one value for all axes. The default value of ± 14 should not be reduced, as this may result in slow unwanted creeping of axes even when the joystick is apparently not deflected. Increasing the value will reduce the velocity resolution (available steps).

Response: joywindow [in digits]

Examples:
?joywindow read joystick window
!joywindow 14 set joystick window to ± 14

15.5. joyvel (Joystick Velocity)

Syntax: !joyvel or ?joyvel
Parameter: x, y, z, a or none
0.000001 to 200 [revolutions/s] or equiv. [mm/s] if dim=9

Description: **This instruction is accessible in extmode 1 only!**
In extmode=1 this instruction must be used to set the joystick velocities. As the vel instruction then has no influence to the joystick velocity. In normal mode (extmode=0) the joystick velocities are derived from the axis vel settings.

Response: Currently used joystick velocities

Examples:
!joyvel 12.5 20 0.4 Set joystick velocities for 3 axes
!joyspeed z 1 Set joystick velocities for z to 1 [rev/s], (e.g. dim=2)
or [mm/s] if dim=9
?joyvel x Read joystick velocity of X-axis

15.6. joyspeed (Joystick Speed Presets for BPZ Device)

Syntax: !joyspeed or ?joyspeed
Parameter: 1, 2 or 3 and
0.000001 to 200 [revolutions/s]

Description: **Only used by a customer designed HDI device** (called BPZ), this instruction sets the joystick speeds for the three speed buttons (Slow, Medium, Fast). Unit is in motor revolutions per second (like 'vel' instruction). While the velocity applies to all axes, each speed button has to be set individually:
1 = Slow Button speed, one parameter for all axes
2 = Medium Button speed, one parameter for all axes
3 = Fast Button speed, one parameter for all axes

Response: Speed currently assigned to the specified button in [rev/s]

Examples:
?joyspeed 1 Read "Slow" joystick button speed
!joyspeed 3 30 Set "fast" joystick button speed to 30 [revolutions/s]

15.7. keymode (Joystick Key Mode)

Syntax: !keymode or ?keymode

Parameter: 0, 1 or 2

Description: Assign keyspeed values to the Joystick buttons. The Joystick can be used with two different velocity settings defined by the keyspeed instruction. The default keyspeed 1 is set to 1mm/s (slow) and keyspeed 2 to 10mm/s (fast). In keymodes 1,2 'vel' or 'joyvel' instructions have no effect. In such case refer to '**keyspeed**', which will be used then. Please note that other special functions which require Joystick buttons (e.g. **snapshot modes**) should not be used at the same time as keymode.

A) If Joystick toggle mode ('**hdimode**') is selected:

--> F1 toggles XY between the keyspeed values 1 and 2
--> F4 toggles Z keyspeeds (available from firmware 1.56)

B) If '**hdimode**' is not set to toggle mode, the behavior is:

Pressing F1 selects keyspeed2 values of X and Y axis,
while F4 selects keyspeed1 values of X and Y axis.

Pressing F2 selects keyspeed2 value of the Z axis,
while F3 selects keyspeed1 value of the Z axis.

In case of joysticks with the optional multi-function wheel, the wheel velocities can be selected by pressing F1, F4, or no key. Please refer to the '**zwtravel**' description.

Recommended Joystick settings are:

2&3 axis Joystick: hdimode 0 or 1 to either toggle velocities by pressing F2/F3, F1/F4 (0) or to toggle by pressing F1 (1).

Joystick with wheel: hdimode 0 to toggle XY by F2,F3 and the wheel by pressing none/F1/F2.

Parameter description:

0 = Normal key functions
1 = X/Y and Z Joystick velocity, preset **keyspeed** 1 [F4,F3]
2 = X/Y and Z Joystick velocity, preset **keyspeed** 2 [F2,F1]

Response: keymode as decimal number

Examples:

!keymode 1 slow preset keymode
?keymode => 0 (in case keymode is disabled)

15.8. keyspeed (Joystick Key Speed Presets)

Syntax: !keyspeed or ?keyspeed
Parameter: x, y, z, a or none
 0.000001 to 3000 [mm/s]

Description: Two Joystick velocities can be set for each axis individually. The first parameter is called the slow value and the second parameter is fast. Unit is always mm/s, independent from **dim**.

Remarks: In keymode 1 or 2 the X and Y values (slow/fast) are assigned to F4 and F1, while the Z values are assigned to F3/F2. Please also refer to **keymode**. Toggle mode can be used as well. Please refer to **hdimode** (bit 1) for further information

Response: Two floating point values per axis (slow fast)
 single axis : => [keyspeed1/slow] [keyspeed 2/fast]
 multiple axes: => [slow_x] [fast_x] [slow_y] [fast_y] ...

Examples:
?keyspeed x => 1.00 10.00 (Read X Joystick button velocity)
?keyspeed => 1.00 10.00 1.00 10.00 0.10 1.00 (Reply of 3 ax. controller)
!keyspeed z 0.1 1 (Set Joystick keyspeed1 to 0.1 and keyspeed2 to 1 [mm/s])
!keyspeed 5 20 2 10 0.2 2 (Set 3 axes at once)

15.9. joycurve (Joystick Characteristic)

Syntax: !joycurve or ?joycurve
Parameter: x, y, z, a or none
 0, 1, 2

Description: The speed characteristic of Joystick deflection can be defined for each axis individually.

 0 = Logarithmic (default)
 1 = Linear
 2 = Quadratic

Response: Currently used characteristic

Examples: !joycurve 0 0 0 => set X,Y,Z axes to logarithmic
 !joycurve z 1 => set Z axis to linear
 ?joycurve => read characteristic of all axes

15.10. key (Read HDI Device Key State)

Syntax: ?key or key

Parameter: none or key number 1, 2, 3, 4

Description: This instruction reads the state of all 4 or the specified HDI device key(s).

0 = key is currently released or not available

1 = key is currently pressed

Response: 1 or 4 Key states, each either 0 or 1

Examples: key => query all keys, returns 4 numbers, e.g. 0 0 0 0

key 1 => query only key 1 (e.g. F1 Joystick button)

key 3 => query only key 3 (e.g. F3 Joystick button)

15.11. keyl (Read HDI Device Latched Key State)

Syntax: keyl, ?keyl or !keyl

Parameter: none or key number 1, 2, 3, 4

Description: The ?keyl or keyl instruction reads the latched state of the specified or all 4 HDI device keys. The latched state of the requested key(s) is cleared after reading.

The instruction !keyl clears the latched state of the specified or all keys to zero (0) without reading.

0 = key is/was released since last keyl or ?keyl instruction

1 = key is/was pressed since last keyl or ?keyl instruction

Response: 1 or 4 Latched key states, each either 0 or 1

Examples: keyl => read+clear all 4 keys, returns e.g. 0 1 0 0

keyl 1 => read+clear only key 1 (e.g. F1 Joystick button)

?keyl 1 => same as "keyl 1"

!keyl 2 => clear latch state of key 2 only (to zero)

!keyl => clear latch state of all 4 keys (to zero)

15.12. hwfactor (Coaxial-/ERGODRIVE Transmission Factor)

Syntax: !hwfactor or ?hwfactor

Parameter: x, y, z, a or none
and -200.0 to 200.0

Description: Aaxis travel distance in millimeter per coaxial drive revolution. Negative factors reverse the travel direction. (The hardware provides about 100000 steps per revolution.)

Remarks: Some HDIs provide a switch to change between two different factors. Please refer to '**hwfactorb**'.

Response: Currently used factor(s)
As floating point number(s) between -200.0 and +200.0

Examples:

```
!hwfactor 14 14 => One knob revolution in X or Y results in 14mm axis travel
!hwfactor x 100 => One knob revolution in X results in 100mm travel
?hwfactor       => Read transmission factor of all axes
```

15.13. hwfactorb (Alternate Coaxial-/ERGODRIVE Factor)

Syntax: !hwfactorb or ?hwfactorb

Parameter: x, y, z, a or none
and -200.0 to 200.0

Description: Alternate (second) parameter for travel distance per coaxial drive revolution '**hwfactor**'. Available with e.g. ERGODRIVE and Pilot stage. Negative factors reverse the travel direction.

Response: Currently used alternate coaxial drive factor(s)
As floating point number(s) between -200.0 and +200.0

Examples:

```
!hwfactorb 26.6 26.6 => One knob revolution in X or Y results in 26.6mm travel
?hwfactorb y        => Read alternate transmission factor of Y axis only
```

15.14. hwfilter (Coaxial-/ERGODRIVE Noise Filter)

Syntax: !hwfilter or ?hwfilter

Parameter: 0 or 1

Description: Coaxial drive noise filter.

1 = Noise filter is active (recommended, default)
0 = Noise filter is deactivated (finer step resolution)**

The filter is activated/deactivated for X and Y axes at once.
** Disabling the filter can result in a finer resolution, but it also causes position inaccuracy e.g. between automatic moves or when the axis is not moving: Its signal noise will cause a permanent slight position jitter.

Response: State of the coaxial drive noise filter

Examples:

```
!hwfilter 0 => Disable noise filter
?hwfilter   => Read hwfilter state
```



15.15. **tbfactor (Trackball Factor)**

Syntax: `!tbfactor` or `?tbfactor`

Parameter: `x, y, z, a` or none
and `-200.0` to `200.0`

Description: Set or read the trackball sensitivity (transmission factor), which is a floating point number between `-200.0` and `+200.0`. A negative value can be used to change direction (similar to 'joydir'). The default factor is 1.

Response: Currently used trackball factor(s)

Examples:

```
!tbfactor x 100 => X axis is 100 times more sensitive than the default setting  
!tbfactor y 12.5 => X axis is 12.5 times more sensitive than the default  
!tbfactor 0.5 0.5 => X and Y axis set to half the default sensitivity  
?tbfactor => Read sensitivity factor of all axes
```

15.16. zwheel (Is Multi-function Wheel Available)

Syntax: ?zwheel or zwheel
Parameter: none

Description: Identify if the connected HDI device provides a Wheel.

 0 = HDI device has no multi-function wheel
 1 = HDI device has a multi-function wheel

Remarks: To identify the HDI device, use '**hdi**' instruction

Response: 0 or 1

Example: ?zwheel => 0

15.17. zwtravel (Multi-function Wheel Travel per Revolution)

Syntax: !zwtravel or ?zwtravel
Parameter: 1, 2 or 3 and
 -50.0 to 50.0 [mm/revolution]

Description: Set or read the travel distances for one revolution of the multi-function wheel, available with several HDI devices, e.g. ERGODRIVE and Joystick.

 1 = Default (used when no HDI function key is pressed)
 2 = Used while Joystick F4 button is pressed (preset to slow)
 3 = Used while Joystick F1 button is pressed (preset to fast)

 Presets for travel distance are
 1: 0.1 mm/rev (default factor)
 2: 0.01 mm/rev (alternate factor, factory preset to slow)
 3: 1.0 mm/rev (alternate factor, factory preset to fast)

Remarks: ERGODRIVE and Pilot stage only offer switching between two travel distances. In this case distance parameter 1 remains the default, parameter 3 is used as alternate second factor.

 '**secvel**' and '**vel**' (or '**joyvel**' in **extmode** 1) may prevent faster traveling when turning the wheel.

 For safety reasons, the default travel can be set to zero (0). So the axis will move only when a key is pressed (F1, F4).

 It is possible to set negative values and by this offering direction change via HDI key.

 The multi-function wheel can also be assigned to other axes with the '**zaxis**' instruction. By default it is set to Z.

Response: Travel distance(s) of the multi-function wheel

Examples:

```
?zwtravel            Read all 3 travel distances: [1:default] [2:slow] [3:fast]
?zwtravel 1         Read    "default" travel distance
?zwtravel 2         Read    "slow"  travel distance
!zwtravel 3 2.5     Set     "fast"   travel distance to 2.5 [mm/revolution]
!zwtravel 1 0       Set     "default" parameter to zero (inactive without keypress)
```

15.18. zwaxis (Multi-function Wheel Axis)

Syntax: !zwaxis or ?zwaxis
Parameter: x, y, z or a

Description: Assign multi-function wheel to an axis (default: z)

Response: x, y, z or a

Example: !zwaxis a (assign wheel to axis 4)
 !zwaxis x (assign wheel to axis 1)
 ?zwaxis => z (wheel is currently assigned to axis 3)

15.19. zwfactor (Multi-function Wheel Factor)

Syntax: !zwfactor or ?zwfactor
Parameter: 0, 1, 2 ... to 20

Description: For custom designed applications only.
 Increase Wheel transmission multiplier, default=1.

 0 = Wheel has no effect
 1 = Wheel default (1:1)
 .
 .
 .
 20 = Wheel travels 20 times more distance

Remarks: Useful in custom designs where the application requires a different rotary encoder to provide the wheel functionality. If the chosen encoder type provides less resolution than the Joystick multi-function wheel, zwfactor can be used to adapt the behavior (here: to achieve correct **zwtravel** distances). The multi-function wheel has a resolution of 480 counts/rev. In example if the encoder has 128 counts/rev, zwfactor can be set to 4.

Response: Multiplier

Example: !zwfactor 1 (set default multiplier, as for TANGO HDIs)
 !zwfactor 5 (set multiplier for lower res. Encoder wheel)
 ?zwfactor (read the currently used multiplier)

15.20. zwpos (Multi-function Wheel Position Counter)

Syntax: !zwpos, zwpos or ?zwpos
Parameter: none

Description: Read or set the independent position counter of the Multi-function Wheel.

Remarks: The wheel resolution is 480 counts/rev, counts always, **zwfactor** settings have no influence.

Response: Counter value as 32 Bit signed integer

Example: !zwpos 0 (set position counter to zero)
 !zwpos 2000 (set position counter to 2000)
 zwpos (read the position counter, same as ?zwpos)

15.21. tvrjoy (Pulse and Direction Joystick Functionality)

Syntax: !tvrjoy or ?tvrjoy
Parameter: 0, z, a

Description: Enables and assigns the AUX-IO pulse&direction inputs TAKT_IN, V/R_IN to an axis, providing a pulse and direction interface. The behavior is similar to the trackball, which is available as HDI device.

Remarks: The function does not provide absolute positioning accuracy. It can be compared to a HDI device behavior.

This function is also available without connecting a HDI device, by entering tvr mode 5 for the corresponding axis

0 = Disabled (default)
z = Assigned to Z-axis
a = Assigned to A-axis

Response: Currently assigned axis

Examples:
!tvrjoy 0 Disable AUX-IO tvr joystick function
!tvrjoy z Assign AUX-IO tvr joystick function to Z-axis
?tvrjoy Query assigned axis

15.22. tvrjoyf (Pulse and Direction Joystick Factor)

Syntax: !tvrjoyf or ?tvrjoyf
Parameter: -200.0 to +200.0

Description: Set or read the AUX-IO tvrjoy transmission factor as floating point number between -200.0 and +200.0. A sign change can be used to change direction. The default setting is 1.

Response: Currently used tvr factor

Examples:
!tvrjoyf 10 Axis is 10 times more sensitive than the default setting
?tvrjoyf Read tvrjoy transmission factor



15.23. hdi (Read HDI ID)

Syntax: ?hdi or hdi
Parameter: none

Description: Read the ID number of the connected hdi device.
The second value shows how good the hardware ID code matches the theoretical ID value [in %]. This value should be more than 30 [%] for secure device identification.

ID numbers: 0, 1, 2, ... 15, 16 (16=no device connected)
ID match : 0 (poor) ... 100 (good)

ID	DEVICE
---	-----
0	(Reserved for special devices)
1	Coaxial drive
2	Custom designed console
3	ERGODRIVE
4	SmartMove
5	Custom device
6	Custom device
7	Stand alone Jogwheel
8	-
9	-
10	2x 2-Axis Joystick or 4-Axis jogbox
11	Trackball with 2-Axis Joystick
12	Joystick 2-Axis
13	Trackball with 3-Axis Joystick
14	Trackball
15	Joystick 3-Axes
16	No device connected
17	(Device identification in progress)
18	(Device initialization in progress)
-1	No device connected (Digital HDIs)
---	-----

Remarks: The instruction may be used to identify the connected HDI device. Additionally '**zwheel**' can be used to identify if the device provides an additional multi-function wheel.

Response: HDI ID number, and the hardware coded ID match in percent.

Example: ?hdi => 12 97 (HDI ID = device nr. 12, 97% match)
 ?hdi => 16 99 (ID ≥16 = no hdi connected)



15.24. hdimode (HDI Mode Options)

Syntax: ?hdimode or !hdimode
 Parameter: Set LSB or more bits at once: string of 0s and 1s,
 or single bit with two numbers: 0 to 15 and 0 or 1

Description: Select extended HDI device options.
 Options may either be set by a string of bits (0s and 1s)
 or by specifying bit number and logic state (on/off = 1/0).
 The string is LSB first (bit 0 is the first and leftmost).
 Setting the corresponding bit to 1 enables the functionality,
 0 disables it.

<u>Bit</u>	<u>Function</u>
0:	Toggle Mode for ERGODRIVE XY and Z Keys (0=off, 1=on)
1:	Toggle Mode for Joystick (in KeyMode 1 or 2) 0=select KeySpeed velocity XY with F1+F4, Z with F2+F3 1=toggle KeySpeed velocity XY by just pressing F1 F4 is used to toggle Z (firmware 1.56 and higher)
2:	LED100 brightness control via Joystick or ERGODRIVE (1=enabled). The AUX-I/O TAKT_OUT pin is controlled automatically then (LED digitally switched of at 0%) Remarks: If enabled, it can interfere with the 2nd Trigger Output respectively adigout 0 .
3:	LED100 fine manual brightness control, 16x finer with Multifunction Wheel 4x finer when controlled via Joystick Y deflection (1=fine mode enabled, only in conjunction with Bit 2)
4:	LED100 set as main function of the Multifunction Wheel pressing function keys, or the function key usually assigned to control the LED, can now be used to drive the assigned axis.
5:	- reserved -
6:	Joystick Z knob (3 rd axis) drives the A (4 th) axis
7:	Diagonal mode (HDI X applied to X and Y simultaneously)
8:	Trackball Y axis drives the Z axis (X then is disabled)
9:	- reserved -
10:	- reserved -
11:	- reserved -
12:	- reserved -
13:	- reserved -
14:	- reserved -
15:	- reserved -

Response: Single mode bit or all 16 mode bits as ASCII string

Examples:

```
!hdimode 100010   Set mode bits 0 and 4 to "on", bits 1,2,3,5 to "off". Bits
                  6...15 are left unchanged.
!hdimode 0 1      Set mode bit 0 to 1 (on) = ERGODRIVE Toggle Mode selected
!hdimode 2 1      Set mode bit 2 to 1 (on)
!hdimode 3 0      Set mode bit 3 to 0 (off)
?hdimode          Read the state of all mode bits (returns 16 digits)
?hdimode 0        Read the state of mode bit 0 (ERGODRIVE toggle mode)
```



15.25. configaxsel (Joystick Axis Select Option)

1 Syntax: !configaxsel or ?configaxsel
Parameter: 0 or 1

Description: Used in TANGO 4 axes systems.
Enable the axis select functionality when the joystick Z-axis should drive both, the controller Z and A axes.
If the A axis joystick is enabled (by joydir a/see remarks), the Z knob of the joystick either drives Z (F4 key released) or A (F4 key pressed).

1 = axis select enabled (pressing F4 key → A-axis used)
0 = axis select disabled (default: joystick Z always Z-axis)

Remarks: Please make sure that the joystick function for A axis is enabled ('**joydir a**' instruction)

Response: Axis select configuration

Examples:

!configaxsel 1 Axis select enabled (F4 applies Z→A with 3 axes joystick)
!configaxsel 0 Axis select disabled (default)
?configaxsel Read the axis select configuration (returns 0 or 1)

16. Joystick Function Key Assignments

The Joystick provides 4 function keys, F1-F4. The key states can be read by the **key** and **key1** instructions. Several operating modes of the TANGO controller also assign special functions to the F-keys. The chart shows the key assignments for the different modes:

Mode / Key		F1	F2	F3	F4
SnapShot Mode	0	-	set new point	-	-
	1	-	next point	-	-
	2	previous point	next point	prehome & first point	prehome & home point
	3	-	start dissection	-	-
	7	Move sequence prehome & home	autoinc from 1st point	pause/continue	pause & previous point
	9	Relative Jump back	Relative Jump forward	-	-
Axis Select Mode ²⁾		-	-	-	Joystick Z-Axis controls A-Axis ¹⁾
KeyMode		Select X,Y KeySpeed2	Select Z KeySpeed2	Select Z KeySpeed1	Select X,Y KeySpeed1
KeyMode+Toggle		Toggle X,Y KeySpeed	Toggle Z KeySpeed	-	-
Joystick has wheel		zwtravel3 (fast) ₁₎	-	Wheel "Joystick" ¹⁾	zwtravel2 (slow) ₁₎
LED Mode no wheel		-	-	Y-axis controls LED brightness ¹⁾	-
				F3+F4: Store LED brightness	
LED Mode w. wheel		zwtravel3 (fast) ₁₎	Wheel controls LED brightness ¹⁾	Wheel "Joystick" ¹⁾	zwtravel2 (slow) ₁₎
				F3+F4: Store LED brightness	

1) Function selected only as long as key pressed.
In all other cases the function is selected or executed by pressing the key.

2) F4 can be configured as Axis Select (Z<->A). Please refer to '**configaxsel**'.

Remarks: When selecting more than one mode, function keys may become assigned to several functions at once.

Joysticks with multi-function wheel behave different in case of LED control than josticks without a wheel (refer to chart above).

17. Digital and Analogue I/O

TANGO Desktop and TANGO PCI/PCI-S/PCI-E controllers provide several I/O options which become available with the optional auxiliary I/O port:

Digital I/O, two analogue outputs (channel 0 and 1) and one analogue input. (Furthermore the HDI Interface analogue inputs can be read via '**anain**', which offers additional analog 0-5V inputs if no HDI device is connected.)

TANGO PCI-E based controllers with optional I/O1 or Multi I/O port module provide additional 24 or 12 digital inputs and 8 digital outputs via **digin**, **digout** etc. The presence of these modules can be checked by the **det** instruction.

17.1. digin (I/O1 Digital Inputs)

Syntax: ?digin or digin
Parameter: none or 0 to 23

Remarks: Only available with TANGO PCI-E/DT-E extension module I/O1.

Description: This instruction reads the logic state of one or all digital inputs of the optional digital I/O1 extension. If called without parameter, all inputs are returned as a string of 24 characters. If called with parameter (input number), only the state of the specified input is returned.

Response: logic state of digital input(s)
 ASCII string 0 or 1, LSB (IN0) is the first/leftmost character
 0 = low, 1 = high (depends on the polarity setting **diginpol**)

Examples:
?digin read all 24 digital inputs (e.g. 000000000000000000000000)
?digin 8 read logic level of input 8 (response e.g. 1)

17.2. digout (I/O1 Digital Outputs)

Syntax: !digout or ?digout
Parameter: string of up to 8 characters 0 and 1,
 or single bit with two numbers 0 to 7 and 0 or 1

Remarks: Only available with TANGO PCI-E/DT-E extension module I/O1.

Description: This instruction sets or reads back the logic level of one or all digital outputs of the optional digital I/O1 extension. Outputs may be set either by a string of levels (up to eight 0s and 1s) or by output number and signal level. The string is LSB first (output 0 is the leftmost).

Response: current output state(s)

Examples:
!digout 11110000 The digital outputs 0,1,2,3 are set to logic '1' and the outputs 4,5,6,7 are set to logic '0'.
!digout 100 The digital output 0 is set to logic '1' and the outputs 1 and 2 are set to logic '0'. Outputs 3 to 7 are left unchanged.
!digout 5 1 set digital output 5 to logic 1 (high)
!digout 7 0 set output 7 to 0 (low)
?digout read the state of all outputs
?digout 5 read the state of output 5

17.3. diginpol (I/O1 Digital Input Polarity)

Syntax: !diginpol or ?diginpol
Parameter: string of up to 24 characters 0 and 1,
or single bit with two numbers 0 to 23 and 0 or 1

Remarks: Only available with TANGO PCI-E/DT-E extension module I/O1.

Description: This instruction sets or reads back if the I/O1 input signal inverters are activated or not. Each of the 24 inputs can be inverted individually.
The inverter may be set either by a string of levels (up to 24 0s and 1s) or by specifying the input number and inverter state. The string is LSB first (input 0 is the leftmost).

Response: current inverter setting(s)

Examples:
!diginpol 010000000000000000000000 Set all inverter states (IN1 to inverted)
!diginpol 11000 The digital inputs IN0 and IN1 are set inverted, IN2, 3 and 4 are set to non inverted, input IN5 to IN23 settings are left unchanged
!diginpol 5 1 activate inverter of digital input IN5 only
!diginpol 17 0 disable inverter of digital input IN17 only
?diginpol read the inverter setting of all 24 inputs
?diginpol 5 read the inverter setting of input 5 only

17.4. digintyp (I/O1 Digital Input Type)

Syntax: !digintyp or ?digintyp
Parameter: string of up to 6 characters 0 and 1,
or single bit with two numbers: Block 0 to 5 and level 0 or 1

Remarks: Only available with TANGO PCI-E/DT-E extension module I/O1.

Description: This instruction sets or reads back if the I/O1 pull-up / pull-down resistor settings for the 24 inputs.
The resistors are arranged in 6 blocks. Therefore inputs can only be accessed blocks of 4: IN0-3, IN4-7, ... IN20-IN23

0 = pull down
1 = pull up

The pull up/down may be set either by a string of levels (up to 6 0s and 1s) or by specifying the block number and level. The string is LSB first (block 0 is the leftmost).

Response: current pull up/down setting(s)

Examples:
!digintyp 110000 Set all pull up/downs (IN0-IN7 to pull up, rest to pull down)
!digintyp 001 Set pull up/down of IN0-IN7 to pull down, IN8-IN11 to pull up the settings for IN12 to IN23 are left unchanged
!digintyp 4 1 set block 4 (IN16-IN19) to pull up
!digintyp 2 0 set block 2 (IN8-IN11) to pull down
?diginpol read the pull up/down setting of all 6 blocks
?diginpol 5 read the pull up/down setting of input 5 only

17.5. digoutpreset (I/O1 Digital Output Presets)

Syntax: !digoutpreset or ?digoutpreset
Parameter: string of up to 8 characters 0 and 1,
 or single bit with two numbers: Output 0 to 7 and level 0 or 1

Remarks: Only available with TANGO PCI-E/DT-E extension module I/O1.

Description: This instruction sets or reads back the logic levels of one or all digital outputs of the optional digital I/O1 extension, which are applied after power up of the TANGO. Output preset levels may be set either by a string of levels (up to eight 0s and 1s) or by output number and signal level. The string is LSB first (output 0 is the leftmost).

Response: output preset value(s)

Examples:

```
!digoutpreset 11110000  After power on, the digital outputs 0,1,2,3 are set to
                        logic '1' and the outputs 4,5,6,7 are set to logic '0'
!digoutpreset 100      After power on, the digital output 0 is set to logic '1' and
                        the outputs 1 and 2 are set to logic '0'. Outputs 3 to 7 are
                        left unchanged.
!digoutpreset 5 1      set preset value of output 5 to logic 1 (high)
!digoutpreset 7 0      set preset value of output 7 to 0 (low)
?digoutpreset          read the state of all outputs
?digoutpreset 5        read the state of output 5
```

17.6. edigin (Multi I/O Digital Inputs)

Syntax: ?edigin or edigin
Parameter: none or 0 to 11

Remarks: Only available with the Multi I/O port of TANGO PCI-E/DT-E.

Description: This instruction reads the logic state of one or all digital inputs of the optional Multi I/O digital extension port. If called without parameter, all inputs are returned as a string of 12 characters. If called with parameter (input number), only the state of the specified input is returned.

Response: logic state of digital input(s)
 ASCII string 0 or 1, LSB (IN0) is the first/leftmost character
 0 = low, 1 = high (depends on the polarity setting **ediginpol**)

Examples:
?edigin read all 12 digital inputs (e.g. 000000000000)
?edigin 8 read logic level of input 8 (response e.g. 1)

17.7. edigout (Multi I/O Digital Outputs)

Syntax: !edigout or ?edigout
Parameter: string of up to 8 characters 0 and 1,
 or single bit with two numbers 0 to 7 and 0 or 1

Remarks: Only available with the Multi I/O port of TANGO PCI-E/DT-E.

Description: This instruction sets or reads back the logic level of one or all digital outputs of the optional Multi I/O extension port. Outputs may be set either by a string of levels (up to eight 0s and 1s) or by output number and signal level. The string is LSB first (output 0 is the leftmost).

Response: current output state(s)

Examples:
!edigout 11110000 The digital outputs 0,1,2,3 are set to logic '1' and the
 outputs 4,5,6,7 are set to logic '0'.
!edigout 100 The digital output 0 is set to logic '1' and the outputs 1 and
 2 are set to logic '0'. Outputs 3 to 7 are left unchanged.
!edigout 5 1 set digital output 5 to logic 1 (high)
!edigout 7 0 set output 7 to 0 (low)
?edigout read the state of all outputs
?edigout 5 read the state of output 5

17.8. ediginpol (Multi I/O Digital Input Polarity)

Syntax: !ediginpol or ?ediginpol
Parameter: string of up to 12 characters 0 and 1,
or single bit with two numbers 0 to 11 and 0 or 1

Remarks: Only available with the Multi I/O port of TANGO PCI-E/DT-E.

Description: This instruction sets or reads back if the Multi I/O input signal inverters are activated or not. Each of the 12 inputs can be inverted individually. The inverter may be set either by a string of levels (up to 12 0s and 1s) or by specifying the input number and inverter state. The string is LSB first (input 0 is the leftmost).

Response: current inverter setting(s)

Examples:

```
!diginpol 010000000000 Set all inverter states (IN1 to inverted)
!diginpol 11000 The digital inputs IN0 and IN1 are set inverted, IN2, 3 and 4
are set to non inverted, input IN5 to IN11 settings are left
unchanged
!diginpol 5 1 activate inverter of digital input IN5 only
!diginpol 7 0 disable inverter of digital input IN7 only
?diginpol read the inverter setting of all 12 inputs
?diginpol 5 read the inverter setting of input 5 only
```

17.9. edigintyp (Multi I/O Digital Input Type)

Syntax: !edigintyp or ?edigintyp
Parameter: string of up to 12 characters 0 and 1,
or single bit with two numbers 0 to 11 and 0 or 1

Remarks: Only available with the Multi I/O port of TANGO PCI-E/DT-E.

Description: This instruction sets or reads back if the Multi I/O pull-up / pull-down resistor settings for the 12 inputs. Each of the 12 resistors can be set individually.

0 = pull down
1 = pull up

The pull up/down may be set either by a string of levels (up to 12 0s and 1s) or by specifying the input number and level. The string is LSB first (input 0 is the leftmost).

Response: current pull up/down setting(s)

Examples:

```
!edigintyp 110000000000 Set all pull up/downs (IN0,IN1 to pull up, rest down)
!edigintyp 001 Set IN0+IN1 to pull down, IN1 to pull up, rest left unchanged
!edigintyp 4 1 set IN4 to pull up
!edigintyp 2 0 set IN2 to pull down
?ediginpol read the pull up/down settings of all 12 inputs
?ediginpol 5 read the pull up/down setting of input 5 only
```



17.10. edigoutpreset (Multi I/O Digital Output Presets)

Syntax: !edigoutpreset or ?edigoutpreset
Parameter: string of up to 8 characters 0 and 1,
or single bit with two numbers: Output 0 to 7 and level 0 or 1

Remarks: Only available with the Multi I/O port of TANGO PCI-E/DT-E.

Description: This instruction sets or reads back the logic levels of one or all digital outputs of the optional Multi I/O extension port, which are applied after power up of the TANGO. Output preset levels may be set either by a string of levels (up to eight 0s and 1s) or by output number and signal level. The string is LSB first (output 0 is the leftmost).

Response: output preset value(s)

Examples:

```
!digoutpreset 11110000 After power on, the digital outputs 0,1,2,3 are set to
                        logic '1' and the outputs 4,5,6,7 are set to logic '0'
!digoutpreset 100 After power on, the digital output 0 is set to logic '1' and
                  the outputs 1 and 2 are set to logic '0'. Outputs 3 to 7 are
                  left unchanged.
!digoutpreset 5 1 set preset value of output 5 to logic 1 (high)
!digoutpreset 7 0 set preset value of output 7 to 0 (low)
?digoutpreset read the state of all outputs
?digoutpreset 5 read the state of output 5
```

17.11. adigin (AUX-I/O Digital Input)

Syntax: ?adigin or adigin
Parameter: none or 0 to 3

Description: Available with the AUX-I/O connector.
This instruction returns the logic state of one or all digital inputs on the optional AUX-I/O connector. If no parameter is used all inputs are returned as a string of 4 characters, ASCII 0 or 1, LSB first:

0 = Bit 0 = AUX-I/O Pin 1 (Takt In) **
1 = Bit 1 = AUX-I/O Pin 2 (V/R In)
2 = Bit 2 = AUX-I/O Pin 3 (Stop)
3 = Bit 3 = AUX-I/O Pin 4 (SnapShot2)

Response: Logic state of digital inputs

Remarks **: Bit 0 (Takt In) is only available with TANGO PCI-E and DT-E controllers.

Examples:
?adigin read all four AUX-I/O digital inputs (response e.g. 1111)
?adigin 3 read AUX-I/O digital input 3 ("SnapShot2", response e.g. 1)

17.12. adigout (AUX-I/O Digital Output)

Syntax: !adigout or ?adigout
Parameter: Set LSB or more bits at once: string of 0s and 1s,
 or single bit with two numbers: 0 to 3 and 0 or 1

Description: Available with the AUX-I/O connector, this instruction sets or reads back the logic level of the AUX-I/O digital outputs. Outputs may be set either by a string of levels (0s and 1s) or by individual bit number and signal level:

0 = BIT0 = AUX-I/O Pin 5 (TAKT_OUT, default LED100 on/off pin)
1 = BIT1 = AUX-I/O Pin 6 (VR_OUT)
2 = BIT2 = AUX-I/O Pin 7 (SHUTTER_OUT)
3 = BIT3 = AUX-I/O Pin 8 (TRIGGER_OUT)

The string is LSB first (channel 0 is the leftmost).

Remarks: Some outputs might be occupied when the **trigger** is activated. Shutter out can be controlled by the **shutter** instruction also. In manual LED control mode (**hdimode** bit 2), TAKT_OUT will be set high/low automatically depending on brightness (0%=high).

Response: Output state(s), 0 or 1

Examples:
!adigout 1011 digital outputs 0,2,3 are set to high, output 1 is set to low
!adigout 10 digital outputs 0 and 1 are set to logic 1 (BIT0) and 0 (BIT1),
 outputs 2 and 3 are left unchanged
!adigout 0 set digital output 0 to logic 0 (e.g. LED100 on)
!adigout 1 set digital output 0 to logic 1 (e.g. LED100 off)
!adigout 1 0 set digital output 1 to logic 0
!adigout 2 1 set digital output 2 to logic 1
?adigout read the level of all outputs (e.g. returns 0000)
?adigout 3 read the level of output 3 (e.g. returns 0)

17.13. anain (Analogue Input)

Syntax: ?anain

Parameter: c (c = channel) or v (higher precision with PCI-E controllers)
0 to 15 (channel number)

Description: This instruction reads the current value of the analogue inputs. The range is decimal from 0 (=0V) to 1023 (=5V).

Channel No	Connector	Pin	Signal Name
0	HDI	1	Joystick X
1	HDI	2	Joystick Y
2	HDI	3	Joystick Z
3	HDI	4	Joystick A
4	HDI	5	Speedpoti
5	HDI	6	IN1B
6	HDI	7	IN2B
7	HDI	8	IN3B
8	HDI	9	IN4B
9	HDI	10	(HDI-ID)
10	AUX-IO	9	ANAINO
11	internal	-	(PSE)
12	internal	-	V-MOT
13	EXT	20	X-ID0
14	EXT	18	X-ID1 / Temp
15	internal	-	REF (2.5V)

To calculate the internal motor voltage:

$$U_{\text{mot}}[\text{V}] = (5 / 1023) * [\text{anain } c \ 12] * (55.7/4.7)$$

More accurate:

$$U_{\text{mot}}[\text{V}] = (2.5 / [\text{anain } c \ 15]) * [\text{anain } c \ 12] * (55.7/4.7)$$

To calculate the internal PSE voltage:

$$U_{\text{pse}}[\text{V}] = (5 / 1023) * [\text{anain } c \ 11] * (14.7/4.7)$$

More accurate:

$$U_{\text{pse}}[\text{V}] = (2.5 / [\text{anain } c \ 15]) * [\text{anain } c \ 11] * (14.7/4.7)$$

To calculate the case temperature (available for TANGO DT/DT-S controllers with encoder interface):

$$T[^\circ\text{C}] = (250 / [\text{anain } c \ 11]) * [\text{anain } c \ 14]$$

It is recommended to use the '**temp**' instruction instead.

Example:

?anain c 10 Read value of channel 10 (analogue input of AUX-IO connector)
==> 510

?anain v 10 Read value of channel 10 (analogue input of AUX-IO connector)
==> 509.75 (response of TANGO PCI-E based TANGO controllers)
==> 510 (response of other TANGO controllers: same as 'c'
for compatibility)

17.14. anaout (Analogue Output)

Syntax: !anaout or ?anaout
Parameter: 0 to 100 in percent (100% = 10V) for anaout0 and anaout1
c (c = single channel keyword)
0, 1 or 2 (single channel number)

Description: Sets or read back the AUX-IO analog output signal levels in percent. It can be accessed in two ways, either direct or a single channel with the 'c' keyword (refer to examples below). The signal resolution is 14 bit with PCI-E and PCI-S based TANGO controllers.
Power-on presets can be specified to provide a required output voltage after switching on the controller. The functionality can be accessed by the 'p' keyword.

Fractional numbers can be used, 100% corresponds to 10 Volts.

Channel No.	Connector	Pin	Signal Name
0	AUX-IO	10	ANOUT0
1	AUX-IO	11	ANOUT1
2	reserved	-	-

```
!anaout [level of anaout0] [optional also level of anaout1]
!anaout c [channel no.] [level of specified anaout channel]
!anaout p [channel no.] [preset value of specified channel]
```

Remarks: Channel 0 is used for brightness control of the LED100 illumination. In order to entirely switch off the LED, use '**adigout**'. Also refer to manual LED control via **hdimode**.

Response: Analogue output signal level in percent

Examples:
!anaout 100 50.1 Set channel 0 = 100% (10V) and channel 1 = 50.1% (5.01V)
!anaout 75 Set channel 0 = 75% (7.5V)
!anaout c 1 25.3 Set channel 1 to 25.3% (2.53V)
!anaout p 0 10 Set power-on preset value of anaout channel 0 to 10% (1 Volt)
?anaout Read output level of all channels (e.g. 0.00 0.00 0.00)
?anaout c 0 Read output level of channel 0 only (e.g. returns 100.00)

17.15. anamode (Analogue Output Mode)

Syntax: !anamode or ?anamode
Parameter: 0,1,2,3,4

Description: Defines the behavior of the optional analog output, available with the Aux I/O connector. The mode cannot be stored.

```
0 : default mode - output controlled by '!anaout'
    or by HDI devices in LED100 mode
1 : ANOUT0 controled by anain (0~5Vin --> 0~10Vout)
2 : ANOUT1 controled by anain (0~5Vin --> 0~10Vout)
3 : ANOUT1 controled by Z-axis position (65535 µSteps = 10V)
4 : ANOUT1 controled by A-axis position (65535 µSteps = 10V)
```

Response: Selected mode as integer

Examples: !anamode 3 (set mode 3 to drive analog piezo stage with Z)
?anamode ==> 0

17.16. stoppol (Mode and Polarity of Stop Input Signal)

Syntax: !stoppol or ?stoppol
Parameter: 0 to 5 and 8 to 13

Description: Operating mode of the AUX-I/O "Stop" input.
The modes offer selection of high and low polarities as well as different behaviors: stop while signal active, latched stop, HDI remaining enabled or becoming disabled, immediately abort a running move or complete move first then stop.

0,1 Stop only as long as stop signal is applied

HDI (joystick) remains active!

0 : active low
1 : active high

2,3 Stop only as long as stop signal is applied

HDI (joystick) is also disabled

2 : active low
3 : active high

4,5 Stop signal is latched (sticky), must be released by sending a "!stop 0" instruction

HDI (joystick) is also disabled

4 : active low
5 : active high

6,7 Not available

8,9 Same as 0,1 but a running move will be completed first *

10,11 Same as 2,3 but a running move will be completed first *

12,13 Same as 4,5 but a running move will be completed first *

Requirements: A stop signal must be applied for at least 50µs.

***) Stoppol modes 8-13:**

In order to stop, the stop signal must remain active until all axes have finished traveling. If the stop signal is removed while an axis is still traveling, no stop will be performed.

Remarks: Usually the stop input has an internal pull-up resistor to +5V, please refer to the corresponding TANGO operating manual.

If closed loop '**ctrsm**' error condition behavior is set to 4 (latched stop condition), the TANGO controller will set stoppol to a latched mode automatically if this error condition occurs.

Response: Operating mode of AUX-I/O stop signal input as integer

Example:
!stoppol 5 Set the function of the AUX-I/O stop input to latched stop active high.

17.17. stop (Release, Force or Check Stop Condition)

Syntax: !stop or ?stop

Parameter: 0, 1

Description: Release or force a stop condition in latched '**stoppol**' modes 4, 5, 12 and 13. Or read if stop condition is active.

0 = Release stop condition (in stoppol modes 4,5,12,13)

1 = Force stop condition (in stoppol modes 4,5,12,13 only)

Remarks: in stoppol modes 12 and 13, a forced stop by sending "!stop 1" stops the axes immediately (same as in stoppol modes 4,5).

Response: Internal stop state of the controller (0, 1)

Example: !stop 0 release a latched stop
!stop 1 force a stop (in latched stoppol modes only)
?stop read if stop is currently active (=1)

17.18. shutter (Shutter Out Signal of AUX-IO)

Syntax: !shutter or ?shutter

Parameter: 0, 1

Description: Set the AUX-IO shutter out signal to the desired TTL level:

0 = signal low

1 = signal high

Response: Output level of shutter signal

Example: !shutter 1 Set the shutter out signal to TTL high state

17.19. flash (Defined Pulse at AUX-IO Takt Out)

Syntax: !flash or ?flash
Parameter: +-0.00001 ... 32500 [ms]

Description: Sends a pulse of defined length to the AUX-IO TAKT_OUT pin.
Used e.g. for LED strobes.

Floatingpoint numbers in [ms].
Range 0.00001 (10ns) to 32500 (32.5s).
Resolution is 1/132µs.

Pulse Polarity depends on sign:

- Positive numbers generate an active high pulse
- negative numbers generate an active low pulse

For safe operation it is recommended to once send one dummy pulse when initializing in order have the correct polarity.

Remarks: **Only available with PCI/PCI-E based controllers and TANGO DT.**
Might interfere with secondary trigger output.

Response: None

Example:
!flash 0.001 (high pulse with duration of 1µs)
!flash -0.01 (low pulse with duration of 10µs)

17.20. tvr (Pulse and Direction Input Function)

Syntax: !tvr or ?tvr
Parameter: x, y, z, a or none
0, 5

Description: Set the TVR Mode, used to drive an axis through an externally applied pulse and direction signal.

Mode

- 0 = disabled
- (1) = ~~enabled without tvrf factor~~
- (2) = ~~enabled with tvrf factor~~
- (3) = ~~enabled without tvrf factor, requires ext. start/stop~~
- (4) = ~~enabled with tvrf factor, requires ext. start/stop~~
- 5 = enabled with tvrjoyf factor

Remarks: Only available with TANGO PCI-E and DT-E controllers.

Response: Currently selected tvr mode(s)

Example:
!tvr 0 0 0 0 (disable tvr on all 4 axes)
!tvr z 5 (enable tvr mode 5 for Z axis)
?tvr z (read tvr mode of Z axis)
?tvr (read tvr mode of all axes)

Example for TVR via AUX-IO standalone operation:

```
!tvrjoyf 1.0
!tvr z 5
!tvrjoy z
```

17.21. brake (Axis Brake Function)

Syntax: !brake or ?brake
Parameter: x, y, z, a or none
 0,1...8 or -255...0

Description: Function for electrically released brakes, intended to hold axes if their motor is turned off due to switched off axes, amplifiers, undervoltage or PSE by using outputs of the optional IO extension. Individual and/or combined IO outputs can be selected individually for each axis.

Each axis can be applied to an output by integer values 1~8. Negative values can be used to apply several output pins or combine / share same additional pins. They represent a bit mask of 8 bit (0x00~0xFF) as integer values 0 to -255.

I/O:	[OUT7]	[OUT6]	[OUT5]	[OUT4]	[OUT3]	[OUT2]	[OUT1]	[OUT0]
PIN:	8	7	6	5	4	3	2	1
BIT:	-128	-64	-32	-16	-8	-4	-2	-1

0 = brake function disabled
1 = apply brake to 1st IO pin (OUT0)
2 = apply brake to 2nd IO pin (OUT1)
3,4,5,6,7 ...
8 = apply brake to 8th IO pin (OUT7)

-1 = apply brake to 1st IO pin (OUT0)
-2 = apply brake to 2nd IO pin (OUT1)
etc. ...
-17 = apply brake to 1st and 5th pin (OUT0 + OUT4)

Behavior: Motor amplifier is on : Output = high (to release brake)
 Motor amplifier is off: Output = low (0V)

The brake function doesn't recognize the current reduction or a motor current set to 0 Ampere.

As output "low" is the safe brake state, when sharing outputs with several axes the output state zero is dominant. If the TANGO provides both, IO1 and Multi-IO (IO2) extension, the Multi-IO (IO2) is used for the brake functionality.

Remarks: Only available for TANGO PCI-E and DT-E controllers in conjunction with an I/O extension, such as IO1 or Multi-IO.

The assigned pins cannot be changed by the IO instructions **!digout**, **!edigout**. Reading the digital output state with **?digout**, **?edigout** also returns the momentary state of the brake outputs.

Response: Integer value, -255 to 8

Examples:

!brake 1 3 8 0	=> Enable brakes for XYZ axes on different pins, disable A
!brake 4	=> Enable brake for X axis on 4th pin (OUT3)
!brake z 7	=> Enable brake for Z axis on 7th pin (OUT6)
!brake -17 -18 -20	=> Enable brake for XYZ on pins 123, create XYZ common pin 5
?brake	=> Read brake setting for all axes (e.g. returns 0 0 0)
?brake z	=> Read brake setting for Z axis only (e.g. returns 0)

17.22. drop (Liquid Dispenser – Generate Drops)

Syntax: !drop or ?drop
Parameter: 0, 1, ...6000

Description: Used with the Märzhäuser Liquid Dispenser.
Generates drops or reads back the amount of generated drops.

The instruction supports both variations of the dispenser:

1) For upright microscopes

Drops are generated and counted.

2) For inverted microscopes

Liquid is dispensed for the specified amount of seconds or 1/10 seconds (depends on dispenser setup). Time is counted.

!drop 0 resets the counter to zero

!drop N generates *N* drops/seconds etc. (*N*=1...6000)

?drop 0 reads amount of drops still to be generated by the recent !drop instruction, this countdown can be used to identify the drop instruction has finished (=0). Here it's not required to reset the counter.

?drop reads amount of drops/time since counter was resetted

Remarks: **Only available with PCI-E based controllers and TANGO DT-E.**
Might interfere with trigger and snapshot functionality.

Response: Amount of counted drops or time, depending on the device.
The drop counter counts to a maximum of 65535 then rolls over.

Example:
!drop 10 generate 10 drops, or dispense liquid for 10 seconds,
 (depends on hardware)

?drop 0 => 7 (still 7 drops or seconds to generate, not finished yet)
?drop 0 => 0 (all drops have been generated, ready)

!drop 0 reset the drop counter for ?drop
?drop read the drop counter (counting since it has been resetted)

17.23. pump (Liquid Dispenser – Manually add Air Pressure)

Syntax: !pump or ?pump
Parameter: 0, 1

Description: Used with the Märzhäuser Liquid Dispenser. Manually overwrites the air pressure pump. Can be used to ensure sufficient pressure before dispensing liquids in inverted applications (time interval). The dispenser switches the pump on and off automatically, but in case of the time interval dispenser it might be safer to ensure sufficient pressure before dispensing by this instruction. For generating drops it might not be required to ensure pressure because they are counted. It then just may take longer.

1 = Air pressure pump on
0 = Air pressure pump off

It is ensured by design that the maximum pressure won't be exceeded.

Remarks: **Only available with PCI-E based controllers and TANGO DT-E.** Might interfere with trigger and snapshot functionality.

Response: 0 (pump is off), 1 (pump is on)

Example:
!pump 1 switch pump on
!pump 0 switch pump off

?pump => 0 (pump is off)

18. Encoder Instructions

The encoder interface supports incremental encoders with or without a reference mark. The type of encoder (analog 1Vpp, analog MR or RS422/TTL) should be configured by factory, as it might require a different hardware.

For TANGO Desktop and PCI/PCI-E it is always possible to switch from an analog (1Vpp or MR) interface to a digital RS422 interface by setting the **encttl** parameter to 1.

Newer TANGO Controllers running Firmware 1.60 and higher often provide a Universal Encoder Interface, where the individual encoder type can be selected by software at any time. The **enctype** instruction then replaces the older **encttl** instruction which should not be used anymore.

To enable encoder functionality, first the **encoder mask** has to be set for the corresponding axes. After that, depending on **calmode**, the encoders (**enc=1**) or also the closed loop will either be activated by calibration of the axis or by power-on.

Manually setting the encoders '**enc**' state to 1 is not recommended, as it possibly causes unpredictable behavior in closed loop mode. Also, in case of analog MR encoders, the signal correction will not be preformed, which leads to positioning errors.

18.1. encmask (Encoder Mask)

Syntax: !encmask or ?encmask
Parameter: x, y, z, a or none
 0 or 1

Description: The instruction reads or sets the encoder globally enable mask, which is required to activate the encoders.
 The encoders then will be detected and activated after a successful calibration instruction '**cal**' or in automatic Closed Loop activation modes (**calmode**) after power up.

0 = clear enable mask (encoder will not be checked/activated)
1 = set enable mask

Response: Encoder enable mask

Example:
!encmask 1 1 0 Globally enable encoders for X, Y and disable Z-axis
!encmask z 0 Globally disable encoder for Z-axis
?encmask Read encoder mask state of all axes

18.2. enc (Encoder Active)

Syntax: ?enc (or !enc)
Parameter: x, y, z, a or none
 0 or 1

Description: This instruction may be used to query if the encoders are active (e.g. successfully activated by a 'cal' instruction). It is not recommended to manually activate the encoders by sending any of the "!enc 1" instructions. For error free Closed Loop behavior and best measuring accuracy, encoders must be activated by the TANGO controller. This depends on 'calmode', 'cal' and 'encmask'. For further details please refer to the above mentioned instruction descriptions.

0 = Encoder is inactive (not used)
1 = Encoder is active (used)

Response: Encoder active state

Example:
?enc Read encoder active state of all axes
?enc y Read encoder active state of Y-axis
!enc z 0 Disable encoder of Z-axis
!enc 1 1 0 Manually activate encoders of X, Y and disable Z-axis
!enc x 1 Manually activate (not recommended!) the X-axis encoder

18.3. encperiod (Encoder Signal Period)

Syntax: !encperiod or ?encperiod
Parameter: x, y, z, a or none
 0.000002 to 4.0 [mm]

Description: This instruction reads or sets the encoder signal period. The unit is always [mm].

Optional read-resolution: As an option to read the parameter with higher precision, the number of required decimal places can be specified with the query "?encperiod [0...16 decimal places]". If no precision is defined, the default resolution is 4 decimal places.

Response: Encoder signal period(s)

Example:
!encperiod 0.5 0.5 0.001 Set encoder period for X and Y to 500µm, Z to 1µm
!encperiod z 0.02 Set encoder period of Z-axis to 20µm
!encperiod 0.00001960784 Set encoder period of X-axis
?encperiod Read encoder period of all axes
?encperiod z Read encoder period of Z-axis
?encperiod 12 Read period of all axes with 12 fractional digits
?encperiod z 9 Read period of Z-axis with 9 fractional digits

18.4. encdir (Encoder Counting Direction)

Syntax: !encdir or ?encdir
Parameter: x, y, z, a or none
 0 or 1

Remarks: Setting the encoder direction is not required and should never be changed by this instruction, as the TANGO identifies the correct counting direction itself. The only exception might be if the connected encoder is used as a truly independent measuring system, and never by the TANGO for closed loop operation.

Description: Set or read the encoder counting direction.
Do not set this parameter when the TANGO is in closed loop!
The encoder direction is set by the TANGO automatically (e.g. after calibration **cal** or instant closed loop during power-on).

0 = Encoder counting direction default
1 = Encoder counting direction reversed

Response: Encoder counting direction

Example:
!encdir 1 1 1 Reverse encoder counting direction for all axes
!encdir x 1 Reverse encoder counting direction for X-axis only
?encdir Read encoder counting direction of all axes
?encdir y Read encoder counting direction of Y-axis only

18.5. encvel (Encoder Auto-Ajust Velocity)

Syntax: !encvel or ?encvel
Parameter: x, y, z, a or none
 0.01 ... 20.0 [mm/s]

Description: The velocity for encoder auto-calibration can be set or read by this instruction. It is recommended to keep the default setting. The unit is always [mm/s].

Response: Velocity used for Encoder detection and calibration in [mm/s]

Example:
!encvel 0.5 0.5 0.5 Set encoder auto-adjust velocity for all axes
!encvel 0.5 Set encoder auto-adjust velocity for X-axis only
!encvel z 0.5 Set encoder auto-adjust velocity for Z-axis only
?encvel Read encoder auto-adjust velocity of all axes
?encvel y Read encoder auto-adjust velocity of Y-axis only

18.6. `enctype` (Encoder Type Configuration)

Syntax: `!enctype` or `?enctype`

Parameter: `x, y, z, a` or none
`0, 1` or `2`

Remarks: Newer versions of the TANGO Controller, running Firmware 1.60 or higher, provide a Universal Encoder Interface. This new interface can be configured by software to support 5Vpp MR, 1Vpp or digital RS422 encoders. In order to support the new features, the `encttl` instruction was replaced by `enctype` (`encttl` then should not be used).

Description: This instruction reads or sets the encoder signal type.

0 = MR 5Vpp analog sin/cos interpolation
1 = TTL RS422 A/B digital incremental signal
2 = 1Vpp analog sin/cos interpolation

The read instruction provides two options:
By using an additional parameter "1" with the read instruction, the effectively by hardware applied encoder type is returned. Without the parameter the instruction returns the selected encoder type.

Remarks: If digital encoders (A/B-TTL, RS422) are used and the interface by mistake is programmed to an analog signal mode, this can cause a sporadic malfunction (encoders become deactivated) due to analog signal monitoring.

Response: -1 = not available, invalid configuration
0 = MR 5Vpp analog sin/cos interpolation
1 = TTL RS422 A/B digital incremental signal
2 = 1Vpp analog sin/cos interpolation

Example:

```
!enctype 1 0 2 Set X encoder to A/B-TTL, Y to MR and Z to 1Vpp
!enctype 1 1 Set X and Y encoder to A/B-TTL
?enctype Read the demanded encoder type of all axes
?enctype x Read the demanded encoder type of X axis
?enctype 1 Read the in fact applied encoder type of all axes
?enctype y 1 Read the in fact applied encoder type of Y axis
?enctype a => 0
?enctype a 1 => -1
?enctype => 0 0 2
?enctype 1 => 0 0 2
```

18.7. encctl (Encoder Configured for TTL Signal)

Syntax: !encctl or ?encctl
Parameter: x, y, z, a or none
0 or 1

Remarks: In newer versions of the TANGO Controller - with Universal Encoder Interface and Firmware 1.60 or higher - this instruction is replaced by '**enctype**' and therefore encctl should no longer be used, except for compatibility.

Description: This instruction reads or sets the type of encoder signal. If digital encoders (A/B-TTL,RS422) are used with an analog encoder interface (configured for 1Vpp or 5Vpp MR), the corresponding encoder has to be set to TTL mode. Else the TTL signal will be found as invalid (due to signal level) and not be used or deactivated during operation (sporadic malfunction).

0 = Analog sin/cos encoder (1Vpp or MR is defined by hardware)
1 = Digital quadrature A/B encoder (e.g. RS422)

Response: Currently selected encoder signal type(s)

Example:
!encctl 0 0 1 Set X and Y axis encoders to analog, Z to digital A/B-TTL
!encctl z 1 Set Z encoder type to digital
?encctl Read encoder signal type of all axes
?encctl x Read encoder signal type of X-axis

18.8. encref (Use Encoder Reference Signal)

Syntax: !encref or ?encref
Parameter: x, y, z, a or none
0 or 1

Description: Enable or disable the use of encoder reference marks. If enabled, the '**cal**' instruction will - after reaching the lower limit switch - travel to the reference mark and set the axis position to zero.

0 = Encoder reference signal not used
1 = Encoder reference signal used for calibration

Remarks: The velocity towards the reference mark is set by **encrefvel**.

Response: Encoder reference signal used, not used

Example:
!encref 1 1 0 Use encoder reference signal as origin for X and Y-axis
!encref y 1 Use encoder reference signal as origin for Y-axis
?encref Read Encoder reference signal usage of all axes
?encref z Read Encoder reference signal usage of Z-axis

18.9. encnas (Use Encoder NAS Error Signal)

Syntax: !encnas or ?encnas
Parameter: x, y, z, a or none
0 or 1

Description: Before enabling this functionality, please make sure that the connected encoder provides a NAS error signal. If enabled, an encoder NAS error also generates an internal '**encerr**' error state. The NAS input is active low.

0 = NAS encoder input state is ignored (default)
1 = NAS encoder input signal is used for error detection

Remarks: The NAS signal state can be read by '**encnasstatus**'.

Response: Encoder NAS signal used / not used for error detection

Example:
!encnas 1 1 0 Use encoder NAS signal for X and Y-axis, ignore for Z
!encnas x 1 Use encoder NAS signal for Y-axis
?encnas Read encoder NAS signal use state of all axes
?encnas x Read encoder NAS signal use state of X-axis

18.10. encrefstatus (Encoder REF Signal State)

Syntax: ?encrefstatus or encrefstatus
Parameter: x, y, z, a or none

Description: Returns the REF signal input state.

0 = REF signal is inactive
1 = REF signal is active (encoder is on a reference mark)

Response: Encoder reference signal state

Example:
encrefstatus Read REF signal state of all axes
encrefstatus x Read REF signal state of X-axis only

18.11. encrefstatusl (Latched Encoder REF Signal State)

Syntax: ?encrefstatusl or encrefstatusl
Parameter: x, y, z, a or none

Description: Returns the latched REF signal input state. If the REF signal was active since last reading of encrefstatusl, a 1 is returned. The corresponding latch state(s) are cleared after reading.

0 = REF signal is/was inactive
1 = REF signal is/was active (encoder is/was on a reference mark)

Response: Latched encoder reference signal state

Example:
encrefstatusl Read+clear latched REF signal state of all axes
encrefstatusl x Read+clear latched REF signal state of X-axis only

18.12. encnasstatus (Encoder NAS Error Signal State)

Syntax: ?encnasstatus or encnasstatus
Parameter: x, y, z, a or none

Description: Returns the NAS error signal input state.
This signal is usually ignored, but can be enabled by **encnas**.

0 = NAS signal is inactive (the encoder reports no error)
1 = NAS signal is active (the encoder reports an error)

Response: Encoder NAS error signal state

Example:

encnasstatus Read NAS signal (error) state of all axes
encnasstatus x Read NAS signal (error) state of X-axis only

18.13. encerr (Encoder Error State)

Syntax: !encerr or ?encerr
Parameter: x, y, z, a or none
0

Description: This instruction reads or resets the encoder error state.
On error, e.g. a low **encamp** signal amplitude or active NAS error signal from the encoder '**encnas**+'**encnasstatus**', the encoder signal is invalid and the closed loop for the corresponding axis is switched off.

0 = No error, normal function
e = Encoder error

Response: Encoder error state, 0 or e

Example:

!encerr 0 Reset encoder error
?encerr Read encoder error states of all axes, e.g. "0 0 e" for 3 axes
?encerr x Read encoder error state of X-axis only

18.14. encamp (Encoder Signal Amplitude)

Syntax: ?encamp or encamp
Parameter: x, y, z, a or none
Optional parameter 1

Description: Read the encoder signal amplitude.
100 (percent) represents the maximum undistorted signal amplitude.

Remarks: In case of single ended TTL encoders the amplitude might be returned as 0.

Response: Encoder signal amplitude in percent as integer

Example:

?encamp Read all encoder signal amplitudes (returns e.g. 57 74 0)
?encamp x Read X encoder signal amplitude
?encamp 1 Read all amplitudes with 1 fractional digit (57.3 73.8 0.5)
?encamp x 1 Read X encoder signal amplitude with 1 fractional digit (57.3)

18.15. encpos (Encoder Position)

Syntax: !encpos or ?encpos
Parameter: x, y, z, a or none
0 or 1

Description: Set or read the position source for a **?pos** instruction. If set to 1 and the encoder is active (corresponding **'enc'=1**), **?pos** returns the encoder position, else the motor position. Refer to the **'pos'** and **'enc'** instructions for further information. The setting cannot be stored by **'save'**.

Remarks: For compatibility, sending a 0 or 1 without specifying an axis applies the setting to all axes.

Response: Position output source
0 = pos instruction returns motor position (default)
1 = pos instruction returns encoder position (if enc. active)

Example:
!encpos 1 from now on a '?pos' instruction returns the encoder position for all axes (if the corresponding encoders are activated)
~~!encpos 1 1 0~~ invalid! (individual x,y,z instructions must be used for it)
!encpos x 1 from now on a 'pos' instruction returns the encoder position for the X -axis (if the encoder is activated)
?encpos Use of ?encpos is not recommended: Just for compatibility, this instruction reads the "ored" position source of all axes (returns just one 0 or 1)
?encpos x Read position output source of X-axis

18.16. hwcount (Hardware Counter)

Syntax: ?hwcount or hwcount
Parameter: x, y, z, a or none

Description: Returns the positions of the independent quadrature encoder counter. It counts the signal edges without further signal interpolation, meaning one signal period corresponds to a counter increment of 4, half a period to 2 etc.

Remarks: Refer to **'clearhwcount'** for setting the counter(s) to zero.

Response: Encoder hardware position-counter

Example:
hwcount Returns the position counter of all axes
hwcount x Returns the position counter of X-axis only

18.17. clearhwcount (Clear Hardware Counter)

Syntax: !clearhwcount or clearhwcount
Parameter: x, y, z, a or none

Description: Set the encoder quadrature hardware-counter positions to zero.
Remarks: Affects the position returned by **?hwcount** only.

Response: none.

Example:
clearhwcount Reset hwcount position of all axes to zero
clearhwcount x Reset hwcount position of X-axis to zero

19. MR Encoder Instructions

19.1. mra (MR Amplitude Correction Factor)

Syntax: !mra or ?mra
Parameter: x, y, z, a or none
0.8 to 1.2

Description: This instruction reads or sets the cosine amplification correction factor of the analogue encoder signal (here: sin/cos amplitude ratio). This factor is calculated automatically on each calibration move '**cal**' and should not be changed. If the axis is manually controlled and only used for relative measurement, so that no '**cal**' is possible, the user may determine the ratio itself and then write it into mra for more accurate results. Please also refer to the '**mro**' instruction.

Response: Currently used correction factor(s)

Example:
?mra Read MR signal correction factor of all axes
?mra x Read MR signal correction factor of X-axis only
!mra x 1.0095 Amplify the X cosine signal by *1.0095 compared to the sine

19.2. mro (MR Offset Correction Value)

Syntax: !mro or ?mro
Parameter: x, y, z, a or none
-2048 to +2048

Description: This instruction reads or sets the sine and/or cosine offset compensation value as 16bit signed digits. This factor is calculated automatically on each calibration move '**cal**' and should not be changed. If the axis is manually controlled and only used for relative measurement, so that no '**cal**' is possible, the user may determine the offset itself and then write it into mro for more accurate results. Please also refer to the '**mra**' instruction.

Response: Currently used correction values

Example:
?mro Read MR signal offset value sine and cosine for all axes
?mro x Read MR signal offset value sine and cosine for X-axis only
!mro 48 -100 0 0 0 0 0 Set X offset to sin=48digit, cos=-100digit, Y, Z = 0
!mro y 16 -28 Set Y offset to sin=16digit, cos=-28digit
!mro y 16 Set only sine offset of Y encoder

19.3. mrp (MR Signal Peak-To-Peak Measuring Result)

Syntax: !mrp or ?mrp
Parameter: x, y, z, a or none
-2048 to +2048

Description: This instruction reads or sets the sine and/or cosine peak values, measured since they were reset the last time. It is just a measurement and has no effect to the signal processing itself. The returned values are signed 16bit digits.

Response: [sine max] [sine min] [cosine max] [cosine min] result(s)

Example:
?mrp x Returns [x_sin max] [x_sin min] [x_cos max] [x_cos min]
?mrp Returns the above, but for all axes (up to 16 values)
!mrp x 0 0 0 0 Reset the peak-to-peak measurement for x
!mrp x 0 0 Reset only the X sine min, max values
!mrp 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 Reset measurement for all 4 axes

19.4. mrt (MR Signal Level)

Syntax: ?mrt
Parameter: x, y, z, a or none
1 to 32767 and -1 to -32767

Description: This instruction reads the corrected sine and cosine A/D converter results of the analog encoder interface as signed 16 bit integer.

in case of MR encoders, specifying a negative number returns the corrected analog value (offset, amplitude).

The number of data samples (lines) to read should be specified, e.g. '?mrt 1' for returning one sample. If there is no number specified, the instruction returns 10 sampling results per default.

Response: [sine] [cosine] results as signed 16 bit values
or [x_s] [x_c] [y_s] [y_c] [z_s] [z_c] for all
Each data line is terminated by a [CR].

Example:
?mrt Returns 10 lines with all axes (up to 6 values per line)
?mrt 1 Returns one line with all axes (up to 6 values)

?mrt x Returns 10 lines with [x_sin] [x_cos] signal digits
?mrt x 1 Returns one line with [x_sin] [x_cos] signal digits
?mrt y 2 Returns two lines with [y_sin] [y_cos] signal digits
?mrt y 1000 Returns 1000 lines with [y_sin] [y_cos] signal digits

?mrt -1 Returns one line, all axes with MR correction applied
?mrt x -10 Returns 10 lines, X axis with MR correction applied

20. Closed Loop Instructions

The closed loop control pulls the axis towards the measuring system position, compensating the inaccuracies of the drive train.

The closed loop mode is set by the **ctr** instruction. It also requires setting **encmask** for the individual axes (**encmask** requests enabling of the encoders, which is a precondition for enabling closed loop). Closed loop is finally activated by either executing a calibration (**cal**) or after power-up by selecting the power-up modes (**calmode** 1 or 2).

The **ctrstatus** instructions may be used to check if the closed loop is activated.

Remarks:

Activating closed loop fails if the **pitch**, **gear** or **encperiod** settings are incorrect. The error tolerance of these parameters is about a factor of 2.

The closed loop target window (**twi**, in combination with **ctrd**, **ctrtrt**) is the condition to identify if the axis has reached its target position. In the default closed loop mode (**ctr** = 2) the axis will (continue to) travel precisely to the target position, even if the target window is already reached.

When the optional motor current **reduction** is set below 0.3 (30%), closed loop will be disabled during reduction (axis has stopped and **curdelay** has expired).

The closed loop behavior can be set to different behaviors for reliability or safety, when exceeding a specified deviation. The instructions **ctrsm** and **ctrs** may be used.

20.1. Setting Up the Closed Loop

The closed loop circuit provides several instructions to adjust, optimize and customize its behavior:

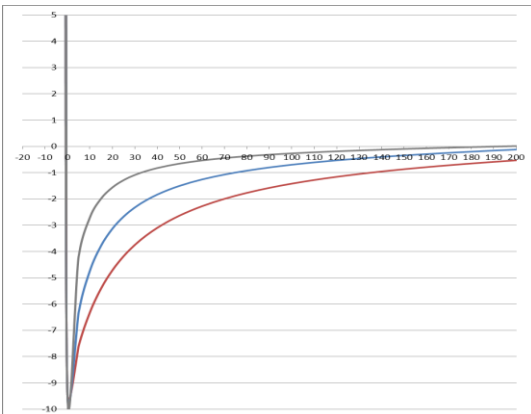
- **Ctr** - the closed loop mode
- **Ctrff** - the closed loop amplification multipliers
- **Tw** - the "position reached" deviation criteria
- **Ctrd** - the "position reached" time criteria
- **Ctrt** - the maximum waiting time for the criteria (timeout)
- **Ctrsm** - the behavior at greater deviation
- **Ctrs** - the definition of greater deviation

Positioning with Closed Loop - twi and ctrd

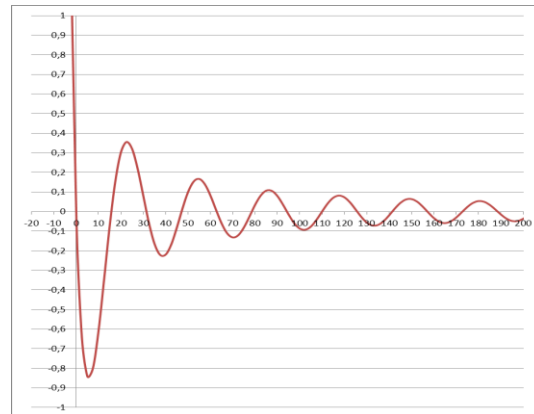
In closed loop mode the position reached reply is delayed until the specified criteria are fulfilled. The criteria consist of a deviation limit and a time, during which the deviation limit must be kept.

The **twi** and **ctrd** instructions define a window with the height of $\pm twi$ and the width of **ctrd**. If the deviation exceeds $\pm twi$, the delay time begins again. So the $(\pm twi * ctrd)$ window travels along, until the criteria are fulfilled or until the timeout (**ctr**) is reached. In such case the position reached reply will be sent even without fulfilling the criteria.

The window definition is required, as position deviation of the axis isn't just constantly decreasing, there is also oscillation of the axis position:



P1 Deviation at the end of a move compensated by the closed loop



P2 Oscillation at the end of a move (sinusoidal decay)

So without defining a **ctrd** delay time criterion, the position reached reply would be sent as soon as the deviation once went below the **twi** value. But as **P2** shows, this might be just temporary and the deviation will build up again (oscillation). To be safe, **ctrd** time must be at least the oscillation period, which makes sure both, minima and maxima of the deviation are checked within the criteria window.

Example: **twi** is $\pm 0.2\mu m$ and **ctrd** is 30ms. In **P2** the **twi** limit is exceeded at 1ms, so **ctrd** begins again for 30ms. At 18ms the **twi** limit is exceeded once more and **ctrd** begins again for 30ms. Afterwards the deviation remains within $\pm twi$, so **ctrd** counts down its 30ms and finally sends the position reached event $18+30 = 48ms$ after the original move has completed.



Closed Loop Setup

The closed loop factor **ctrff** can be used in order to reach the twi and ctrd criteria more quickly.

In general, its default values of 2 and 2 provide a good base to start from. Ctrff has two parameters per axis. The first one is the factor applied when the axis is traveling, the second is applied when the axis stopped traveling and is idle. Picture *P1* shows how increasing the second factor influences compensation of position error at the end of a move. Greater values cause the axis to compensate faster, but from a certain point might begin to be unstable.

Closed Loop behavior

Ctr sets the general behavior of the closed loop, which might be off, always on or on until position is reached.

In addition, a behavior can be set when the position deviation exceeds a certain limit. Please refer to the **ctrsm** and **ctrs** instructions.

Examples

1: enable closed loop for X and Y axes only

```
!ctr 2 2 0
!encmask 1 1 0
!cal
```

2: enable closed loop individually for Z axis

```
!ctr z 2
!encmask z 1
!cal z
```

3: enable closed loop for X and Y from power-on

```
!ctr 2 2
!encmask 1 1
!calmode 2 2
save
(then cycle power or send reset instruction)
```

20.2. ctr (Control Enable)

Syntax: !ctr or ?ctr
Parameter: x, y, z, a or none
0,1,2,3,4

Description: Sets, reads or changes the closed loop mode.

0 = Closed Loop OFF
1 = Closed Loop Auto OFF when position is reached
2 = Closed Loop always ON (default, recommended)
3 = (not supported, behaves like mode 1)
4 = (not supported, behaves like mode 2)

Closed loop mode is activated by either executing **cal** or after power up (refer to **calmode**).

Preconditions for successfully entering closed loop are having **ctr** and **encmask** set.

Pros and Cons: Mode 1: (+) Axis is stopped after reaching the target window
(-) Position is scattered within $\pm twi$ range
(-) Position deviation may occur due to external influence (drive concept, gravity, etc.)
(-) Is only active when moving
(-) Can cause a position jump at the beginning of a move, if a deviation exists (see above)

Mode 2: (+) Always stays closest possible to target position
(+) Compensates external influences (required with several dirve concepts or with Z axes)
(-) Might still travel after the position reached "@@@" reply of the target window, as it always travels towards zero deviation
(-) Might not absolutely stand still after reaching a position. Depending on drive concept, slip stick effects can cause the axis to slightly bounce between positions within e.g. ± 50 nanometers. similar might happen with TTL encoders of coarse resolution. Then mode 1 might be preferred.

Remarks: Using closed loop mode 2 is recommended for most applications.

Mode 1 is recommended only if the application does not stand sufficiently still in the end position (e.g. long exposures). In this case, the HDI - especially an ERGODRIVE - should be disabled, too.

Response: Closed loop mode(s)

Examples:
!ctr 0 0 0 0 Closed loop off for all axes
!ctr 2 2 Closed loop for X- and Y-axis permanently on
!ctr z 1 Closed loop for Z-axis switches off after position reached
?ctr Read closed loop states of all axes
?ctr x Read closed loop state of X axis

20.3. ctrf (Control Factor)

Syntax: !ctrf or ?ctrf
Parameter: x, y, z, a or none
0.0 to 25.0

Description: CTRF IS FOR COMPATIBILITY ONLY - PLEASE USE **CTRFF**.
This instruction reads or sets the closed loop factor.
Higher values result in more stiffness and faster settling.
Above a critical value this may lead to oscillation.
The default factor of 2.0 mostly results in a good behavior.
Hint: Using the ctrff instruction instead offers more options.

Remarks: Even if setting the parameter supports floating point, the return value is integer (for compatibility).
It is recommended to use ctrff instead of ctrf.

Response: Closed loop factors as integers (rounded)

Examples:
!ctrf 2 2 2 Set closed loop factor to 2 for all axes
!ctrf x 3 Set closed loop factor for X axis to 3
?ctrf Read closed loop factors of all axes (as integer)
?ctrf y Read closed loop factor of Y axis (as integer)

20.4. ctrff (Extended Control Factor)

Syntax: !ctrff or ?ctrff
Parameter: x, y, z or a
0.0 to 25.0
0.0 to 25.0

Description: This instruction reads or sets 2 closed loop factors per axis.
Higher values result in more stiffness and faster settling.
Above a critical value this may lead to oscillation.
The default factor of 2.0 mostly results in a good behavior.
Important: Can only be set per axis (with x,y,z,a specified)

Parameter1: Is used while axis is traveling
Parameter2: Is used when axis is idle or while trying
to settle within the target window (**twi**)

Parameter 2 can be set to higher values than Parameter1
to achieve smoother axis travel while still having the
stiffness and faster settling times at the end of a move.
(E.g.: "!ctrff x 2 4".)

Response: Closed loop factors (2 per axis)

Examples:
~~!ctrff 2 2 2 2~~ Not supported!
!ctrff x 2 4 Set closed loop factors for X axis 2(moving) and 4(reached)
!ctrff x 0.5 1 Set closed loop factors for X axis 0.5(moving) and 1(reached)
!ctrff x 0 0 Disable closed loop regulation in X, while loop still active
?ctrff Read closed loop factors of all axes (2 parameters per axis)
?ctrff y Read closed loop factors of Y axis only (2 parameters)
?ctrff 2.0 2.0 2.0 2.0 2.0 2.0 (response of a 3 axis TANGO)
?ctrff y => 2.0 2.0

20.5. ctrd (Control Target Window Delay)

Syntax: !ctrd or ?ctrd
Parameter: 0 to 1000 [ms]
 optional axis x,y,z,a

Description: This instruction reads or sets the control delay, which is used as a position reached criteria when in closed loop mode. The closed loop has to remain inside the target window (**twi**) for this time, until the position reached state is set. If the target window is left before the delay time is over, the delay starts counting again. Please also refer to the **ctrt** timeout, which aborts the waiting for twi+ctrd after a certain amount of time. The unit is milliseconds.

Setting the delay time to zero forces the axis to immediately reply without waiting for the axis to match the target window.

In all other cases, ctrd delay times must be set higher than the **ctrc** interval (>5ms).

Either one delay for all axes can be set or axes can be set individually.

Remarks: While the default target delay of 100ms works with most drive concepts, it may be optimized for performance individually. In order to find the optimal setting, the sinusoidal decay of the axis must be measured. The minimum delay time is the signal period of the mechanical oscillation.

Response: Closed loop control delay in milliseconds.

Examples:
~~!ctrd 50 50 50~~ Not supported!
!ctrd 100 Closed loop target window delay to 100 ms for ALL AXES
!ctrd x 100 Closed loop target window delay to 100 ms for X axis
?ctrd Read closed loop target window delay (for compatibility)
?ctrd y Read closed loop target window delay of Y axis

20.6. crtt (Control Timeout)

Syntax: !crtt or ?crtt
Parameter: 0 to 10000 [ms]

Description: This instruction reads or sets the control timeout. It specifies the maximum time the closed loop tries to reach the desired encoder position. If the ctrd+twi condition could not be fulfilled within this crtt time, it will be aborted. The crtt timeout should be set to a value higher than **ctrd**, usually to the default of 1 second. The unit is milliseconds. Only one parameter for all axes.

Setting the timeout to zero forces all axes to immediately reply without waiting to match the target windows.

Response: Closed loop control timeout in milliseconds.

Examples:
!crtt 1000 Closed loop tries to reach the end position for 1 second
?crtt Read closed loop timeout

20.7. twi (Target Window)

Syntax:	!twi or ?twi
Parameter:	x, y, z, a or none ±window size, unit depends on dim , range = 0.00001 to 1 mm
Description:	This instruction reads or sets the closed loop control target window width (+-). While increasing this value leads to position variance, setting a too narrow window may result in closed loop timeouts (higher ctrd, ctrt values required). The unit depends on dim .
Remarks:	The target windows minimum size shouldn't be set smaller than the encoder resolution and noise. Please make sure the measuring system is able to deliver the required signal quality. For analog encoders the limit might be between 1/1000 to 1/5000 of the signal period, which in case of MR encoders about 0.5µm and for a 4µm optical scale 4nm.
Response:	Closed loop target window. The unit depends on dim .
Examples:	
!twi 0.001 0.001	Closed loop target window ±1µm (if dim=2) for X and Y-axis
!twi y 0.005	Closed loop target window ±5µm (if dim=2) for Y-axis
?twi	Read target window of all axes
?twi z	Read target window of Z-axis only

20.8. ctrc (Control Call)

Syntax:	!ctrc or ?ctrc
Parameter:	1 to 100 [ms] DO NOT CHANGE!
Description:	This instruction reads or sets the controller call interval. It specifies the time interval in which the closed loop circuit checks the position deviation. The unit is milliseconds. There is only one parameter which applies to all axes. THE DEFAULT FACTORY SETTING (3 or 5 ms) depends on the TANGO controller and SHOULD NOT BE CHANGED. Values of less than 3 [ms] are not recommended.
Response:	Closed loop control call interval in milliseconds.
Examples:	
!ctrc 5	Closed loop control is executed every 5 milliseconds
?ctrc	Read closed loop call intervall

20.9. ctrsm (Control behavior outside Lock-in Range)

Syntax: !ctrsm or ?ctrsm

Parameter: x, y, z or none

Description: Behavior of the closed loop circuit when outside the lock-in range (**ctrs**). When outside the ctrs lock-in range, which is regarded to be an error, the TANGO controller can treat this condition as follows:

- 0 = Continue as usual, motor might possibly stall (default)
- 1 = Limit the closed loop velocity (avoid stalling the motor)
- 2 = Disable closed loop until returning to lock-in range
- 3 = Disable closed loop permanently
- 4 = Axis is set to latched stop condition (read remarks)**
- 5 = Switch off all power stages (like !pa 0)

Remarks: ** **stoppol** is manipulated by this function in order to achieve a latched stop (stoppol value is or'ed by 4).
The stop condition must be released by sending "**!stop 0**"

ctrsm 1 assures to return from large deviations without stalling the motor. If outside the **ctrs** lock-in range, a slow return velocity is applied. Inmost cases it is the better alternate to ctrsm 0.

ctrsm modes 3 to 5 may be used for safety.

Response: Selected Behavior of the axes (as integer value)

Examples:

```
!ctrsm z 1      Select slow mode in Z (to avoid stalling of the motor)
!ctrsm 5 5 5    Select switch off mode for safety (e.g. collision detection)
?ctrsm         Read all behaviors
?ctrsm y       Read behavior of Y-axis only
```

20.10. ctrs (Control Lock-in Range)

Syntax: !ctrs or ?ctrs

Parameter: x, y, z or none
0.01 [mm] to [maxpos]

Description: Lock-in range of the closed loop circuit.
When the closed loop position difference exceeds this limit, the behavior defined with **ctrsm** is applied to the axis/axes.
The unit depends on **dim**.

Response: Closed loop lock-in range.

Examples:

```
!ctrs 0.5 0.5 0.2 Set lock-in range of X=0.5mm, Y=0.5mm, Z=0.2mm (if dim=2 or 9)
!ctrs z 0.1       Set lock-in range of Z=0.1mm (if dim= 2 or 9)
?ctrs            Read lock-in range of all axes
?ctrs z         Read lock-in range of Z-axis only
```

20.11. ctrstatus (Control Status)

Syntax: ?ctrstatus or ctrstatus

Parameter: x, y, z, a or none
optional parameter: 1, 2 or 3

Description: Read the internal closed loop states of the specified or all axes. Options and responses are:

A) Called without parameter:

Returns the internally applied **ctr** state which is set when the closed loop gets enabled by the controller (!cal or calmode=1,2).

- 0 Closed loop permanently off
- 1 Closed loop only active while moving
- 2 Closed loop always on (default closed loop operation)
- (3 Closed loop only active while moving)
- (4 Closed loop always on)

B) Called with parameter "1":

Check if the closed loop is currently active.

- 0 = Closed loop not active
(e.g. ctr=0, !cal running, encerr, limit swich, etc.)
- 1 = Closed loop active

C) Called with parameter "2":

Check if closed loop is in target window.

- 0 = Position outside target window
- 1 = Position in target window

D) Called with parameter "3":

Check if closed loop is in lock-in range.

- 0 = Position outside lock-in range
- 1 = Position in lock-in range

E) Called with parameter "0": (All in one request)

Returns the internally applied **ctr** state, like **A)** does
And a second hex parameter representing all state bits of the calling parameter 1,2,3:

- Bit 0 (0x1): Closed Loop Active
- Bit 1 (0x2): Closed Loop in Target Window
- Bit 2 (0x4): Closed Loop in Lock-In Range

Response: Closed loop state.

Examples:

```
?ctrstatus Returns the internally running ctr mode of all axes
?ctrstatus y Returns the internally running ctr mode of the Y-axis

?ctrstatus 1 Returns the Closed Loop active state of all axes, e.g. "1 1 0"
?ctrstatus x 1 Returns the Closed Loop active state of the X-axis, e.g. "1"

?ctrstatus 2 Returns if Closed Loop is in target window, e.g. "1 1 0"
?ctrstatus z 2 Returns if Closed Loop of the Z-axis is in target window

?ctrstatus 3 Returns if Closed Loop is in lock-in range, e.g. "1 1 0"
?ctrstatus z 3 Returns if Closed Loop of the Z-axis is in lock-in range

ctrstatus x 0 ==> 2 7 (ctr mode 2 is applied, is active/in window/in range)
ctrstatus 0 ==> 2 7 2 7 0 0
```

20.12. ctrdiff (Control Position Difference)

Syntax: ?ctrdiff

Parameter: x, y, z, a or none

Description: This instruction returns the momentary measured closed loop position difference between the motor and encoder position (mot.pos - enc.pos).
The unit depends on **dim** settings.

Remarks: Only available with active closed loop.
Closed Loop factor(s) ctrfff can be set to 0 in order to suppress regulation.

Response: Momentary position difference.

Examples:

?ctrdiff Returns the position difference of all axes

?ctrdiff y Returns the position difference of the Y-axis e.g. "0.0015"

21. Trigger Output Functionality (option)

Trigger functionality must be configured by factory.

To identify if the Trigger functionality is configured, use `'?det'` or `'detext'`.

The trigger output generates TTL signals dependent either on axis positions or as a constant frequency. It can be used to synchronize external devices like e.g. a camera. TANGO Desktop and PCI/PCI-E controllers provide up to 2 trigger outputs via the optional AUX-I/O connector. See **mode** and **output description**.

A special trigger mode - ideal for on the fly scanning applications - is provided by the `!trigr` instruction. This mode achieves the highest accuracy. A more sophisticated mode is provided by `!trigp`, an individual position list.

The trigger can be based on the motor position or on the more accurate encoder position, if the axis provides position encoders.

Axis positions and analog inputs can be captured on trigger by **Snapshot Mode 8**.

The LED100 illumination is active low and typically wired to OUT2 (TAKT_OUT). Remarks: If **hdimode** controls the LED 100, it can interfere with TAKT_OUT.

The trigger signals are processed in a 40 microsecond interval.

Before enabling the trigger function by `!trig 1`, please ensure that all trigger settings have been made.

```
Example1:  !trig 0[CR]           Disable trigger globally
           !trigm 0[CR]        Select trigger mode 0
           !triga x[CR]        Set X axis as trigger source
           !trigd 0.100[CR]     Set trigger distance to 100µm (if dim = 2)
           !trigs 400[CR]       Set trigger pulse width to 0.4ms
           !trig 1[CR]         Enable trigger and set start position
```

```
Example2:  !trig 0[CR]           Disable trigger globally
           !trigs 120[CR]        Set trigger pulse width to 120µs
           !trigf 2500[CR]       Set pulse frequency to 2.5kHz
           !trigm 100[CR]        Select trigger mode 100 (periodic signal)
           !trig 1[CR]           Enable trigger
```

Optional: `!trigcount 0` instruction may be executed to reset the event counter.

21.1. trig (Trigger)

Syntax: !`trig` or `?trig`
Parameter: 0 or 1

Description: This instruction enables or disables the trigger circuit. The position at which `!trig 1` is executed also sets the start position for all trigger modes (except modes 20 and 21).

0 = Trigger function globally disabled
1 = Trigger function globally enabled

Response: 0 or 1

Examples:
`!trig 1` Enable trigger circuit (also defines the start position =here)
`?trig` Read enable state of trigger circuit

21.2. trigm (Trigger Mode)

Syntax: !trigm or ?trigm
 Parameter: 0 to 11, 100 to 105

Description: This instruction selects the required trigger mode.

Trigger Mode	Trigger Generation	Trigger Signal	Remarks
0		High active	First pulse when move starts <i>Direction forward</i>
1		High active	First pulse when move starts <i>Bidirectional</i>
2		High active	First pulse when move starts <i>Direction backward</i>
3	-- See Mode 0 --	Low active	Same as 0, signal inverted
4	-- See Mode 1 --	Low active	Same as 1, signal inverted
5	-- See Mode 2 --	Low active	Same as 2, signal inverted
6		High active	Triggers shifted by $\text{trigd}/2$ <i>Direction forward</i>
7		High active	Triggers shifted by $\text{trigd}/2$ <i>Bidirectional</i>
8		High active	Triggers shifted by $\text{trigd}/2$ <i>Direction backward</i>
9	-- See Mode 6 --	Low active	Same as 6, signal inverted
10	-- See Mode 7 --	Low active	Same as 7, signal inverted
11	-- See Mode 8 --	Low active	Same as 8, signal inverted
100	Periodic trigger signal the frequency can be set by "trigf" instruction	High active	Does not depend on position
101		Low active	
102	Manually forced trigger signals by the "trigger" instruction which releases one or several pulses	High active	Does not depend on position or time
103		Low active	
104	Position reached trigger signal if all moves including the specified axis "triga" have completed	High active	Comes with the "@@-." autostatus response
105		Low active	



Remarks: The start position is defined by the position where the trigger was globally enabled ("**!trig 1**" instruction).

 Trigger modes 20 and 21 are used internally by the **trigr** and **trigg** instructions.

Response: Trigger mode as integer: 0 to 11, (20,21), 100 to 105

Examples: !trigm 0 Set trigger mode 0
 ?trigm Read current trigger mode

21.3. triga (Trigger Axis)

Syntax: !triga or ?triga
 Parameter: x, y, z or a

Description: This instruction selects the axis on which to trigger.

Response: x, y, z or a

Examples:
 !triga y Select Y-axis as trigger source
 ?triga Read current trigger axis

21.4. trigo (Trigger Output)

Syntax: !trigo or ?trigo
 Parameter: 0 to 15

Description: This instruction selects the trigger outputs.

The secondary output TAKT_OUT provides extended functionality:
 2, 3: 1:1 mode, generating the same signal as output 1
 6, 7: precise width
 10 11: high precision delay
 14,15: precise (and optionally even higher) frequency

TAKT_OUT is also the default output to control the LED100.

Output / Mode	STANDARD	PREC.WIDTH2	PREC.DELAY2	PREC.FREQUENCY2
No output No signal out	0	(4)	(8 PCI-E)	(12)
Primary TRIGGER OUT	1	(5)	(9 PCI-E)	(13)
Secondary ** TAKT OUT	2	6	10 (PCI-E)	14
Both, P&S ** TRIGGER+TAKT	3	7	11 (PCI-E)	15

A combined delay and width of 40µs resolution is available in standard modes 1,2,3 by the **trigs** instruction.

****** For further information on the second trigger output, please refer to **trigs**, **trigwidth**, **trigdelay**, **trigbf** and the description of the **second trigger signal output**.

Remarks: Options depend on hardware: TANGO PCI-E / DT-E based controllers with AUX-IO connector offer all features. PCI-S based controllers do not provide the precision delay function and TANGO mini or integrale provide none or one trigger output.

Response: Selected trigger outputs

Examples:
 !trigo 0 No output signal
 !trigo 1 Default trigger output (TRIGGER_OUT)
 !trigo 2 Secondary trigger output (AUX-IO TAKT_OUT, LED100)
 !trigo 3 Both trigger outputs 1:1 (TRIGGER_OUT and TAKT_OUT)
 ?trigo Read back the selected trigger output mode

21.5. trigs (Trigger Signal Length)

Syntax: !trigs or ?trigs
Parameter: 0 to 2500000 [μ s]
or optional 3x 0 to 2500000 with secondary trigger option

Description: This instruction sets the trigger pulse width in the range of 40 microseconds to 2.5 seconds in increments of 40. (0 = shortest trigger signal width, narrow pulse)
If the parameter is not a multiple of 40 it will be rounded to the nearest multiple: e.g. 90 --> 80, 100 --> 120.
When read back, the corrected (nearest) value is returned.

Remarks: **Secondary Trigger Option:** TANGO controllers with a secondary trigger output (AUX I/O) offer a **1:1 mode**. When !trigs is called with 3 parameters, OUT2 provides the option of a delay and individual width. Both parameters must be specified and may be set from 0 to 2500000 (μ s) in increments of 40 (μ s), as mentioned above.

The 2nd trigger signal must be active within the range of the 1st signal. At the end of signal 1, signal 2 is set back to inactive, too. For further information, refer to the trigger description of the **Standard 1:1** output mode.

Example: !trigs 120 40 80

Generates 120 μ s on OUT1 and a 40 μ s delayed 80 μ s long pulse on OUT2. The 2nd and 3rd parameter cannot be read back by ?trigs, it only returns the signal length of output OUT1.

Response: 0 to 2500000 (μ s) trigger signal length

Examples:

!trigs 40 Set Trigger pulse width to 40 μ s
!trigs 2500000 Set Trigger pulse width to 2.5 s
?trigs Read current trigger pulse width

!trigs 200 40 80 Set Trigger output 1 pulse width, delay, output 2 pulse width
The two additional parameters cannot be read back with ?trigs

21.6. trigd (Trigger Distance)

Syntax: !trigd or ?trigd
Parameter: >0.0 to 5000000 (unit depends on **dim** of the selected axis)

Description: This instruction sets or reads the trigger distance.
Equidistant trigger signals are generated in this position interval.

Remarks: The trigger axis (**triga**) should be defined before setting trigd.

Response: Trigger distance (the unit is defined by **dim**)

Examples:

!trigd 3.01 Set trigger distance to 3.01mm (if dim of selected axis is 2)
?trigd Read the trigger distance

21.7. trigcomp (Trigger Compensation)

Syntax: `!trigcomp` or `?trigcomp`
Parameter: `-10000 ... +10000 [μs]` (smallest step is 10μs)

Description: Time delay compensation for position trigger (look ahead). It releases the trigger at an earlier (+) or later (-) time in order to be executed at the required position.

It can be used to compensate time delays in the signal chain or to center a trigger pulse around the target position.

Application 1:

To avoid stitching mismatch with bidirectional scans (and so increase performance by not requiring unidirectional)

At high velocity on the fly scans, the delay of the trigger signal chain has an effect on where the sample is taken. When scanning in both directions, this effect becomes visible typically by a comb-like appearance of the stitched image. This can be greatly improved or entirely removed by the trigcomp delay compensation. The default setting is 0.

Example: If a camera has a shutter release delay of 100μs and the axis travels at 10mm/s, an uncompensated bidirectional scan will cause a 1μm shift in each direction, causing a 2μm shift between forward and backward direction. When this delay is compensated by "`!trigcomp 100`", the trigger is released at an 100μm earlier position (which the TANGO calculates internally, based on the current velocity) and the camera now will take the picture without any position shift.

Remarks:

The described comb effect can also be caused by a mechanical backlash of the scan axis. On open loop axes without encoder feedback, the effect can possibly be minimized by using the **backlash** compensation.

Application 2:

To generate a symmetrical trigger pulse, which is active for a certain time before and after the trigger position.

Example: The pulse is 200μs long and should be active 100μs before and after the trigger position
--> `trigs 200, trigcomp 100`

Response: Compensated delay in [μs]

Examples:

`!trigcomp 130` Compensate trigger signal chain delay of 130μs
`?trigcomp` Read the compensation delay (e.g. returns 0)

21.8. trigenc (Trigger on Encoder)

Syntax: !trigenc or ?trigenc
Parameter: 0 or 1

Description: Trigger position source select, encoder or motor position.

0 = Trigger position from motor position (default)
1 = Trigger position from encoder (true position)

Remarks: Triggering on encoder signals is designed for analogue
1Vpp or MR encoders.
When using A/B-TTL encoders, the available position range
might be extremely limited due to the low encoder period.
The valid trigger position range is ± 32000 encoder periods
Examples:

- MR @ 500 μ m * ± 32000 = ± 16000 mm
- 1Vpp @ 20 μ m * ± 32000 = ± 640 mm
- TTL @ 1 μ m * ± 32000 = ± 32 mm

In order to use trigenc=1, the encoder must be activated.
Without active encoder (?enc = 0), the motor position is used.

Response: Currently selected trigger position source

Examples:
!trigenc 1 Trigger based on the encoder signal, if available
?trigenc Read the trigger position source, e.g. 0

21.9. trigf (Trigger Frequency)

Syntax: !trigf or ?trigf
Parameter: 0.01 to 25000

Description: This instruction sets the frequency for periodic trigger
output mode (**trigm** 100 and 101).
The frequency resolution is 1/40 μ s.

Response: Trigger frequency

Remarks: From TANGO firmware 1.60C / 1.61 it is also possible to
send a fixed number of trigger pulses at the specified
trigf by using the manual trigger modes 102, 103 and
calling the manual **!trigger** instruction with the number
of pulses as parameter. Refer to **trigger** description.

Examples:
!trigf 2500 Periodic trigger pulses at 2.5kHz (signal every 0.4ms)
?trigf Read trigger frequency

21.10. trigbdelay (Precise Trigger Delay for second output)

Syntax: !trigbdelay or ?trigbdelay
Parameter: 0.00 to 32500000 [µs]

Description: Precise delay for secondary trigger output signal (TAKT_OUT). Applies to trigger output settings !trigo 10 and 11. Unit in microseconds [µs], resolution is 1/132µs.

Remarks: Secondary trigger can either have precise width or delay. **Only available with TANGO PCI-E based controllers.**

Response: Delay time in µs

Examples:

```
!trigbdelay 0.35 Delay the secondary trigger signal by 350ns (to TRIGGER_OUT)
?trigbdelay      Read the secondary trigger delay (e.g. returns 0.00)
```

21.11. trigbwidth (Precise Signal Width for second output)

Syntax: !trigbwidth or ?trigbwidth
Parameter: 0.00 to 32500000 [µs]

Description: Precise width for secondary trigger output signal (TAKT_OUT). Applies to trigger output settings !trigo 6 and 7. Unit in microseconds [µs], resolution is 1/132µs.

Remarks: Secondary trigger can either have precise width or delay. **Only available with TANGO PCI-S/PCI-E based controllers.**

Response: Signal width in µs

Examples:

```
!trigbwidth 5.01 Set secondary trigger signal width to 5.01µs
?trigbwidth      Read the secondary trigger signal length (e.g. returns 40.00)
```

21.12. trigbf (Precise Trigger Frequency for second output)

Syntax: !trigbf or ?trigbf
Parameter: 0.010 ... 66000000 [Hz]

Description: Precise frequency for secondary trigger output (TAKT_OUT). Applies to trigger output settings !trigo 14 and 15. Unit is microseconds [µs], resolution is 1/132µs.

Remarks: **Only available with TANGO PCI/PCI-E based controllers.** Trigcount does not count the precise trigger events.

Response: Output frequency [Hz] for precise frequency output mode.

Examples:

```
!trigbf 0.01      Set secondary trigger frequency to 0.01Hz
!trigbf 50000005 Set secondary trigger frequency to 50.000005 MHz
?trigbf          Read the secondary trigger frequency (e.g. returns 1000.000)
```

21.13. trigcount (Trigger Counter)

Syntax: !trigcount or ?trigcount
Parameter: 0 to 2147483647

Description: Read or set the trigger event counter.
 Trigcount increments on every executed trigger pulse.

Response: Number of executed triggers

Examples:
?trigcount Read trigger counter
!trigcount 0 Clear trigger counter
!trigcount 110 Set trigger counter to 110 counted events

21.14. trigger (Force Trigger Signal)

Syntax: !trigger or trigger
Parameter: None or 0 to 127

Description: This instruction generates one trigger output pulse or
 a fixed amount of pulses, refer to description below.
 Manual trigger is available in manual **trigger modes** 102
 and 103 only. The pulse width depends on **trigs** setting.

From TANGO firmware 1.60C / 1.61 it is also possible to manually generate a fixed number of 1 to 127 trigger signals by calling the instruction with an additional count parameter.

Remarks: When executing multiple triggers (trigger was called with
 parameter), the function does not return until all trigger
 pulses are executed (the command interpreter is blocked).
 To identify if the instruction completed - and that the TANGO
 controller is able to receive new instructions - it is
 recommended to send an ?err request and wait for it to return.
 --> Refer to Example 2(b).

Response: None

Example1: trigger (Force one trigger pulse now)

Example2: (Minimum requirement is TANGO firmware 1.60C / 1.61)

```
!trig 0            (Disable trigger)  
!trigf 1000       (Set frequency of trigger signal in Hz)  
!trigs 400        (Set duration of trigger pulse in µs)  
!trigm 102        (Set trigger mode to manual trigger 102 or 103)  
!trig 1           (Enable trigger)
```

```
trigger 5           (Manually force 5 trigger pulses at 1000 Hz)
```

Example2 (b) : err (Optional wait for trigger function to complete
 by waiting for err response, e.g. zero)

```
--> 0
```

21.15. trigr (Set Trigger Range)

Syntax: !trigr or ?trigr

Parameter: x, y, z, a or none
start position
end position
number of equidistant trigger signals within a position range

Description: Provides the *range trigger mode*, which
- begins and ends at defined positions
- generates a defined number of equidistant, unidirectional trigger signals (10000 max.)

Setting a trigger mode is not required, !trigr sets it to mode 20 (up) or 21 (down) automatically.

If no axis is specified, the trigger axis is used (?triga).
If an axis is specified (x,y,z,a) the trigger axis is set to this axis and remains set until changed.

Trigger signals are generated within a position range.
The scan direction is set by the start,end positions:
- start < end = trigger in positive travel direction
- start > end = trigger in negative travel direction

Start and end position units are defined by **dim**, e.g. mm.

The number of trigger signals defines their distance:
The first trigger is generated at the start position and the last trigger is generated at the end position (n+1).
e.g. to achieve 1mm distance from 0 to 10 mm = 11 signals.

If only one trigger position is specified (start = end), the trigger direction is determined from the current position:
- If the trigger position is greater than the axis position, the trigger direction is set to positive (up, forward).
- If the trigger position is lower than the axis position, the trigger direction is set to negative (down).

Once set, the trigger range remains and is reactivated automatically when the axis travels back behind the start position. If required, !trigr can set new parameters ahead of every move instruction.

For bidirectional scans, !trigr must be set to the required travel direction before each move (from pos -> to pos).
The move must start from below the start position and travel past the end position.

Remarks: The signal polarity for this special trigger mode can be set by the **!trigl** instruction.
In order to apply the signal polarity immediately, the trigger mode can be set to **!trigm** = 20 or 21 before setting **trigl**.

The trigr instruction clears and overwrites possibly existing **trigp** position lists of the specified axis and vice versa.
(!trigr internally writes its positions to the trigp list.)

Response: Currently applied values: [startpos] [endpos] [num of trigger]



Examples for trigr:

--- Preparation ---

- Globally disable the trigger:

```
!trig 0
```

- Select trigger polarity:

```
!trigm 20      (mode 20 or 21 to apply trigl immediately)
!trigl 1       (set trigger signal level to active high)
```

- Specify the axis:

```
( !trigenc 1 ) (optional if the axis provides an encoder)
!triga x       (can also be specified or changed by !trigr)
```

--- Trigger ---

- A) Trigger in positive direction:

```
!moa 9         (move X to position below the trigger range)
!trigr 10 20 11 (one trigger every mm, 10,11,12,...20)
!trig 1        (globally enable the trigger**)
!moa 21        (move X to position past the trigger range)
```

- B) Trigger in negative direction:

```
!moa 21        (move X to position below the trigger range)
!trigr 20 10 11 (one trigger every mm, 20,19,18,...10)
!trig 1        (globally enable the trigger**)
!moa 9         (move X to position past the trigger range)
```

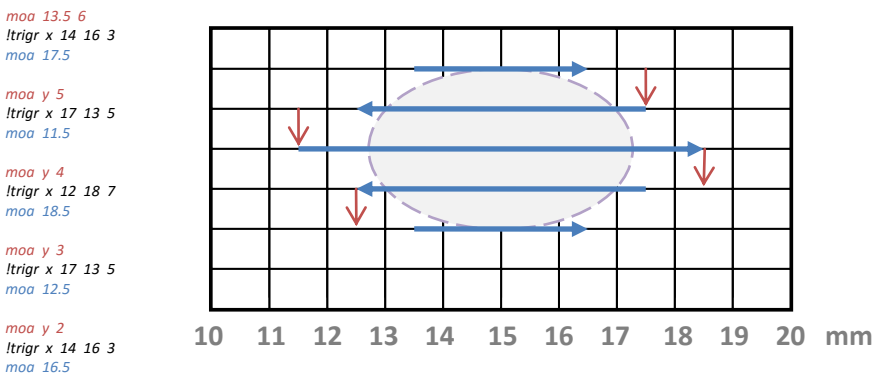
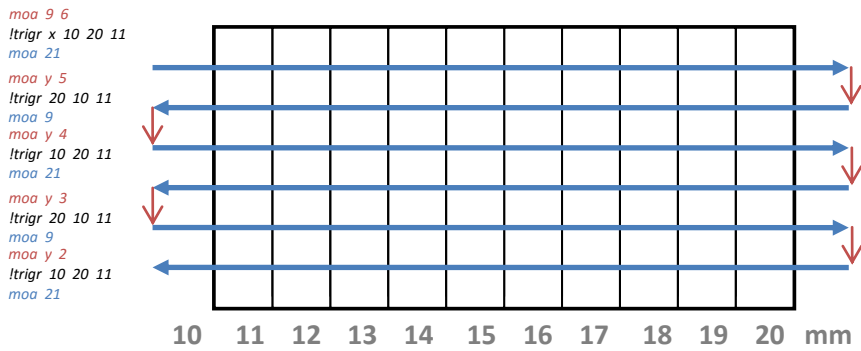
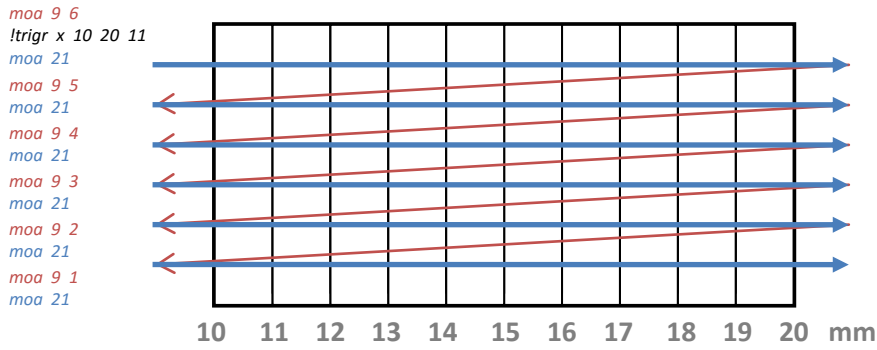
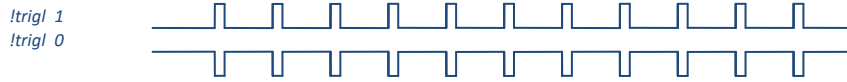
- C) Single trigger position:

```
!moa 19        (move X to position below the trigger range)
!trigr 20 20 1 (one trigger at 20mm)
!trig 1        (globally enable the trigger**)
!moa 21        (move X to position past the trigger range)
```

```
!trigr y 11.5 16 10 (select y axis for trigger from 11.5 to 16)
!trigr 11.5 16 10   (use recently set axis for trigger)
?trigr ==> 11.5000 16.5000 11 (read trigger settings)
?triga ==> y
```

** Trigger should be globally disabled for the initial configuration and may remain enabled afterwards, even if the !trigr parameters are modified.

Trigger Range Functionality (!trigr)



21.16. **trigp (Trigger Position List Entry)**

Syntax: !trigp or ?trigp
Parameter: none or x, y, z, a
 List index and position value

Description: Provides a list of individual, unidirectional trigger positions. The position unit depends on **dim** (mm, μ m, ...). Up to 10000 list entries are possible.

Setting a trigger mode is not required. !trigp sets trigm to mode 20 (up) or 21 (down) automatically.

The entries are only valid for the specified axis. If the axis has to be changed, all entries must be rewritten to the list.

If no axis is specified, the trigger axis is used (**triga**). If an axis is specified (x,y,z,a) with the first entry or when clearing the list, the trigger axis is set to this axis and remains set until changed. Later attempts of change are ignored and an error will be returned.

Trigger signals are generated at the specified position(s). The entries must be either of increasing or decreasing value, as the scan direction is identified by the first two entries. In case of only one list entry, the direction is determined from the current axis position here or when '!trig 1' is set:

- If the trigger position is greater than the axis position, the trigger direction is set to positive (up, forward).
- If the trigger position is lower than the axis position, the trigger direction is set to negative (down).

Once set, the position list remains and is reactivated automatically when the axis travels back behind the first position. If required, !trigp can set new parameters ahead of every move instruction.

For bidirectional scans, !trigp must be set to the required travel direction before each move (from pos -> to pos). The move must start from before the first trigger position.

```
!trigp 0            Discard the entire position list
!trigp x 0          Sets !triga to X axis and discards the X list
!trigp -1 10        Append a position to the list (here: e.g. 10 mm)
!trigp x -1 9       Only possible if the list is empty (trigc=0):
                    Set the first position and select trigger axis
!trigp 1 10         Set or modify the first list entry
!trigp 5 10         If entries >= 5: Replace the 5th list entry
                    If entries = 4: Append entry (like -1 does)
?trigp -1           Read back the last entry on the list
?trigp 7            Read back the 7th list entry
```

Remarks: The signal polarity for this special trigger mode can be set by the '**!trigl**' instruction.

The number of entries can be read by the '**trigc**' instruction.

In order to apply the signal polarity immediately, the trigger mode can be set to !trigm = 20 or 21 before setting **trigl**.

Response: Requested trigger position list entry in the current **dim**

Examples for trigp:

--- Preparation ---

- Globally disable the trigger:

```
!trig 0
```

- Select trigger polarity:

```
!trigm 20 (mode 20 or 21 to apply trigl immediately)
!trigl 1 (set trigger signal level to active high)
```

- Specify the axis:

```
( !trigenc 1 ) (optional if the axis provides an encoder)
!triga x (can also be specified or changed by !trigp)
```

- Empty the position list

```
!trigp 0 (if required, appending is also possible)
(remove all existing entries from the list)
```

--- Trigger ---

- A) Trigger in positive direction:

```
!moa 105 (move X to position below the trigger range)
!trigp -1 110.5 (append a position value, here: first entry)
!trigp -1 125.7 (append a position value)
!trigp -1 200.3 (append a position value)
!trig 1 (globally enable the trigger**)
!moa 205 (here: move X past the last entry)
```

- B) Trigger in negative direction:

```
!moa 205 (move X to position above the 1st entry pos)
!trigp -1 200.3 (append a position value, here: first entry)
!trigp -1 125.7 (append a position value)
!trigp -1 110.5 (append a position value)
!trig 1 (globally enable the trigger**)
!moa 105 (here: move X past the last entry)
```

- C) Single trigger position:

```
!moa 105 (move X before the position)
!trigp -1 110.5 (set only one trigger position)
!trig 1 (globally enable the trigger**)
!moa 115 (move X to position past the trigger range)
```

```
!trigp y 11.5 (set y as trigger axis, overwrites !triga)
!trigp -1 11.5 (use recently set axis for trigger)
?trigc (read the number of list entries)
?trigp 1 (read the first trigger position entry)
?triga y (read the trigger axis)
```

** The trigger should be globally disabled for the initial configuration and while filling or modifying the trigger position list.

During a scan it is not necessary to disable/enable the trigger, as the trigger re-enables itself when the axis moves before the first position.



More examples for trigp:

```
!trig 0
!trigm 20
!trigl 1
!trigenc 1

moa 5
```

Globally disable the trigger
mode 20 or 21 to apply trigl immediately
set trigger signal level to active high
optional, set the encoder as trigger source

position the x axis below the 1st triggerpos

EXAMPLE1 (strict)

EXAMPLE2 (favor)

```
!triga x
!trigg 0

!trigg 1 10
!trigg 2 10.5
!trigg 3 11
!trigg 4 11.5
!trigg 5 12

!trigg 6 20
!trigg 7 20.5
!trigg 8 20.5
!trigg 9 21.5
!trigg 10 22

!trigg 11 30
!trigg 12 30.5
!trigg 13 31
!trigg 14 31.5
!trigg 15 32
```

```
!trigg x 0

!trigg -1 10
!trigg -1 10.5
!trigg -1 11
!trigg -1 11.5
!trigg -1 12

!trigg -1 20
!trigg -1 20.5
!trigg -1 20.5
!trigg -1 21.5
!trigg -1 22

!trigg -1 30
!trigg -1 30.5
!trigg -1 31
!trigg -1 31.5
!trigg -1 32
```

Select trigger axis and erase position list

Insert 1st trigger position

...

...

Insert last trigger position

The following instructions would now deliver:

```
?trigc => 15
?trigi => 1
?trigg 3 => 11.0000
?trigg x 3 => 11.0000
?trigg -1 => 32.0000
```

read the amount of entries
read the list index (here: at 1st entry)
read 3rd entry of trigger axis (here: X)
read 3rd entry of X (redundant information)
read last list position

It is possible to overwrite entries, e.g. !trigg 11 30.25

It is possible to shorten the list, e.g. !trigc 10 (=positions 30..32 mm deleted)

It is possible to append positions, e.g. !trigg -1 40.225

Which is the same as ?trigc → 15 !trigg 16 40.225

```
!trig 1

moa 37
```

Globally enable the trigger

Travel x past the last trigger position

Now 15 triggers are generated (examples here: 3 regions of interest with individual gaps inbetween).

Important note: Sending a !trigg list to the TANGO cannot be done in one block. As with all instruction sequences, it must be ensured that the 256 byte input buffer does not run over. Good practice might be to read back "err" or ?trigc after each !trigg position, at least every few !trigg positions. This will ensure no data gets lost during transmission.

21.17. **trigc (Number of Trigger Position List Entries)**

Syntax: !trigc or ?trigc
Parameter: none or [0 to trigc]

Description: Read the number of position list entries, which are made by **!trigp** or **!trigr**.
Or reduce the position list size by specifying a lower amount of entries.

Remarks: Only for special trigger functionality of **!trigp** and **!trigr**.

Response: Amount of trigger position list entries.

Examples: ?trigc (read the amount of trigger position list entries)
 !trigc 0 (clear the trigp position list)
 !trigc 5 (reduce the entries to 5, only possible if greater)

21.18. **trigi (Trigger Position List Index)**

Syntax: !trigi or ?trigi
Parameter: none or 1 to 10000 (less or equal to the current **trigc** count)

Description: This instruction reads or sets the trigger position list pointer of the selected trigger axis (**triga**).
The behavior is similar to **snsi** of the snapshot array, except the index here is consistent from 1 to N (**snsi** is 0...N-1).

In trigger modes 20 and 21 this pointer access can be used to read back where in the position list the trigger unit currently is. Or it can be used to manipulate the list index (position pointer) of the entries made by **trigp** or **trigr**.

The value must not exceed the amount of **trigc** list entries.

Response: Current trigger position list pointer

Example:
?trigi Read the current trigger position list pointer (e.g returns 1)
!trigi 1 Set position list pointer to the first element
!trigi Same as !trigi 1
!trigi 21 Set position list pointer to the 21st element

21.19. **trigl (Trigger Level)**

Syntax: `!trigl` or `?trigl`

Parameter: 0 or 1

Description: Select the trigger signal polarity for trigger modes 20 and 21 (**!trigr**, **!trigp** functionality).

0 = Trigger signal is active low
1 = Trigger signal is active high

Remarks: Only for special trigger functionality of **!trigp** and **!trigr**. For all other cases, the polarity is defined by their **trigger mode**.

Response: Trigger signal polarity for trigger modes 20 and 21.

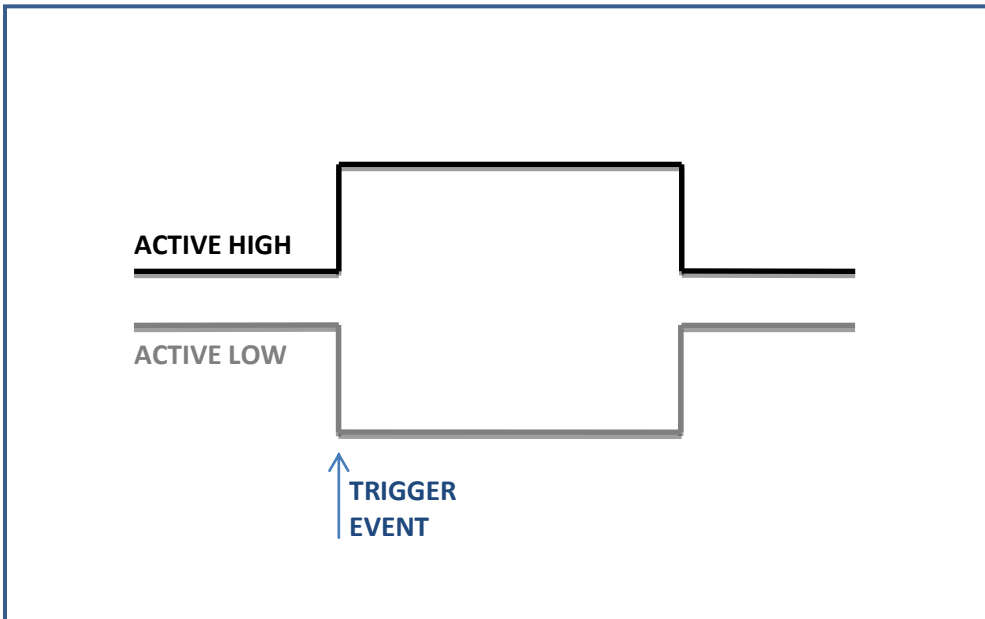
Examples: `!trigl 0` (set to active low)
`!trigl 1` (set to active high)
`?trigl` (read trigger level, e.g. returns 1 = active high)

22. The Second Trigger Signal Output

22.1. Introduction

PCI/PCI-S/PCI-E and Desktop TANGOs provide two trigger output signals. Only PCI-E based controllers support all functionality described in this chapter.

Depending on the trigger mode, the output signals are active high or active low. This description shows the trigger signals in active high mode.



Up to two output signals are available and can be selected with the '**trigo**' instruction:

- TRIGGER_OUT (here called OUT1)
- TAKT_OUT (here called OUT2)

OUT2 is provided by PCI and Desktop TANGOs only.

Both outputs share the same polarity setting and trigger source.

The optional LED100 illumination uses OUT2.

If the OUT1 signal width is set to zero a short spike still is generated, allowing the edge to trigger events of up to 25 kHz. The minimum OUT1 width of 40µs results in 12.5 kHz max. signal frequency.

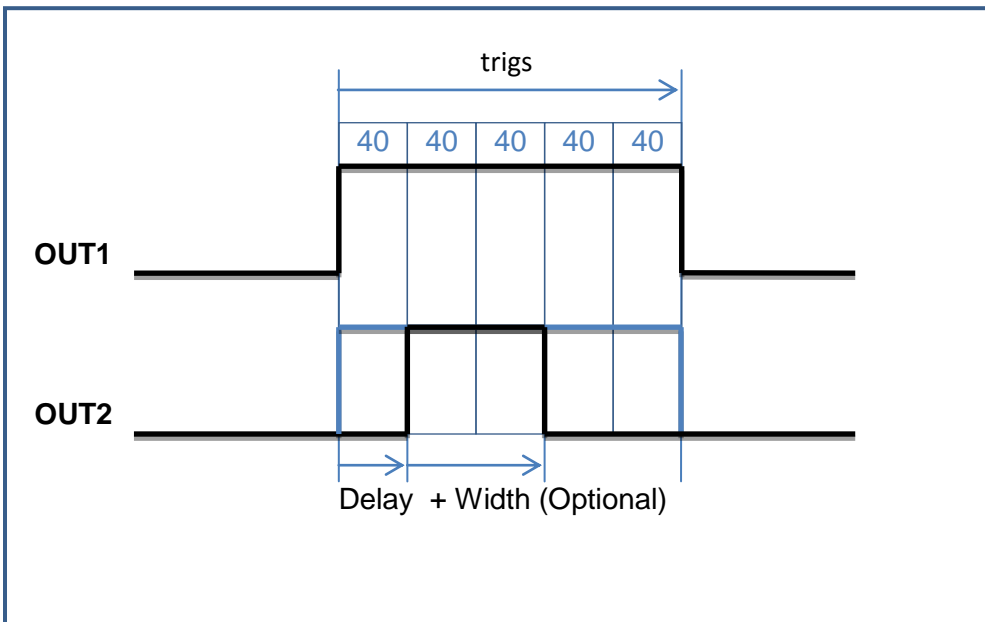
22.2. Standard 1:1

Signal: OUT2 provides the same signal as OUT1 (refer to OUT1 options)

Options: When the signal width (**trigs**) instruction is sent with 3 parameters, OUT2 provides the option of a delay and individual width. OUT2 becomes inactive latest when OUT1 returns to its inactive state. (OUT2 must be within the active range of OUT1.)

Remarks: Can be used with any trigger mode of OUT1.
Parameter in increments of 40µs (0; 40; 80; ... 2,500,000)
Possible jitter up to a few microseconds

Application: Commonly used with camera and shutter/LED applications



OPTIONS

`!trigo 1` → OUT1 only, OUT2 set to inactive level
`!trigo 2` → OUT2 only, OUT1 set to inactive level
`!trigo 3` → OUT1 and OUT2

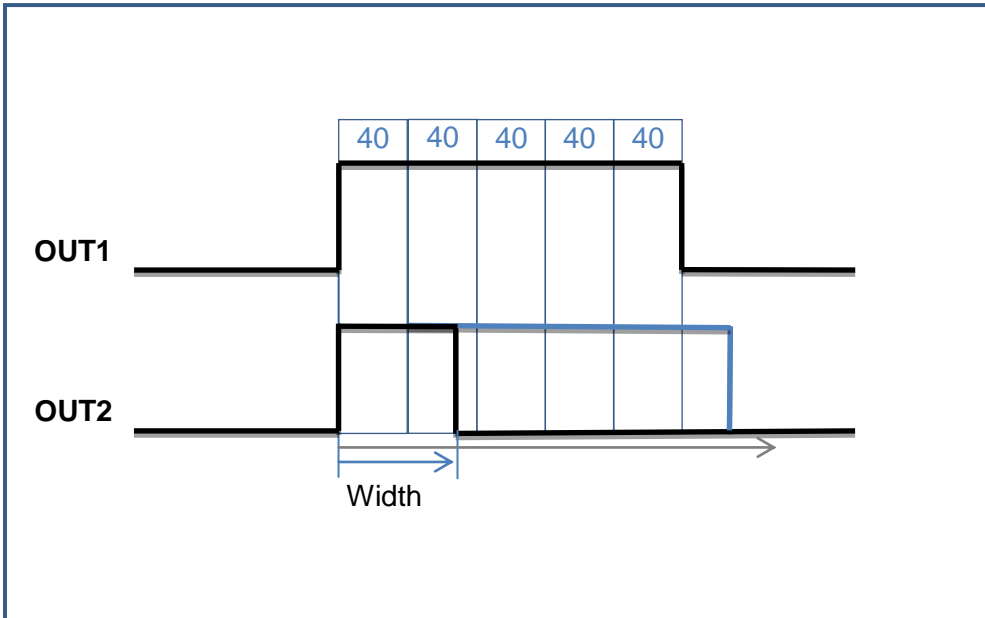
EXAMPLE

`!trigo 3`
`!trigs 200 40 80` → Set OUT1 signal width & maximum duration (200µs), Delay (40µs) and Width (80µs) for OUT2
 or `!trigs 200` → Set OUT1 and OUT2 signal width to 200µs

22.3. Precise Width

Signal: OUT2 starts with OUT1 but has individual, high resolution width.

Remarks: Can be used with any trigger mode of OUT1.
OUT2 resolution is in 7.6ns steps, up to 32.5 seconds.
OUT2 width can be longer than OUT1.



OPTIONS

`!trigo 5` → OUT1 only, OUT2 set to inactive level
`!trigo 6` → OUT2 only, OUT1 set to inactive level
`!trigo 7` → OUT1 and OUT2

EXAMPLE

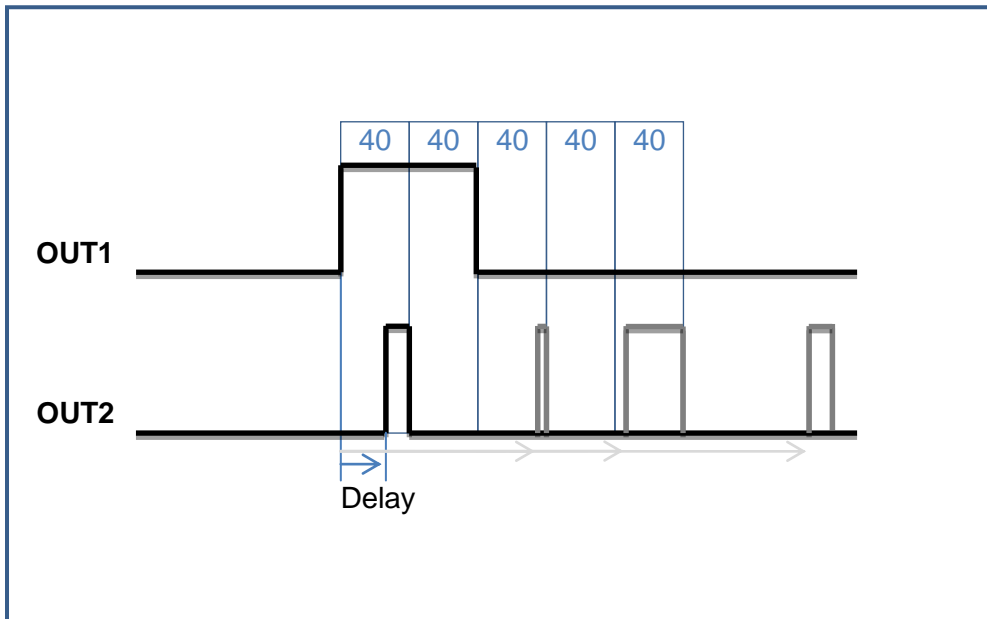
`!trigo 7`
`!trigs 200`
`!trigbwidth 65.4` or `!trigbwidth 230`

22.4. Precise Delay

Signal: OUT2 provides a precise edge delay to OUT1.

Remarks: Can be used with any trigger mode of OUT1.
OUT2 resolution is in 7.6ns steps, up to 32.5 seconds.
OUT2 delay can be later as the OUT1 signal width.
Very low jitter between the two edges OUT1 - OUT2 (<10ns).
The OUT2 pulse width can't be specified, it is resetted in 40µs intervals. Pulses of 100ns up to 39µs may occur.

Application: Precise trigger of transducer and receiver



OPTIONS

`!trigo 9` → OUT1 only, OUT2 set to inactive level
`!trigo 10` → OUT2 only, OUT1 set to inactive level
`!trigo 11` → OUT1 and OUT2

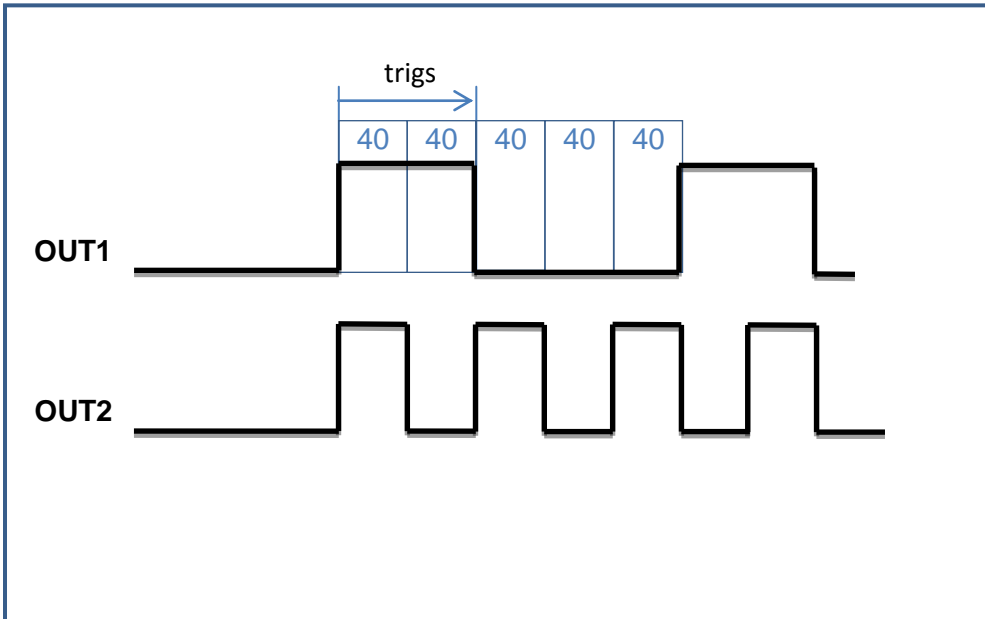
EXAMPLE

`!trigo 11`
`!trigs 80`
`!trigbdelay 25.5` or `!trigbdelay 112.03` or `!trigbdelay 165`

22.5. Precise Frequency

Signal: OUT1 and OUT2 provide individual output frequencies.

Remarks: OUT1 can run in an individual trigger mode (position dependent, etc.)
 OUT1 width can be specified by '**trigs**'
 OUT1 frequency is limited to 0.01 to 25000 Hz and 1/40µs resolution
 OUT2 provides 0.010...66,000,000 Hz high resolution and low jitter
 OUT2 has fixed width of 50%
 OUT1 and OUT2 are in phase if the frequencies match (multiples)



OPTIONS

`!trigo 13` → OUT1 only, OUT2 set to inactive level
`!trigo 14` → OUT2 only, OUT1 set to inactive level
`!trigo 15` → OUT1 and OUT2
!trigm can be set to an independent behavior, must not be frequency output

EXAMPLE

```
!trigo 15
!trigs 80
!trigf 5000
!trigbf 12500
!trigm 100
```


23.1. sns (Snapshot enable/disable)

Syntax: !sns or ?sns
Parameter: 0 or 1

Description: This instruction globally enables or disables the snapshot functionality. Snapshot is globally enabled by default (power-on) in order to support stand-alone applications. Latched key pressed events or the **snsm=6** waiting state of a move is cleared when enabling/disabling the Snapshot (sns0,1).

0 = disabled
1 = enabled (default)

Response: Snapshot state

Examples:
!sns 0 Disable snapshot
?sns Read snapshot enable state

23.2. sns1 (Snapshot Level / Polarity)

Syntax: !sns1 or ?sns1
Parameter: 0 or 1

Description: This instruction sets the snapshot input signal polarity.
0 = active low (falling edge)
1 = active high (rising edge)

Response: Currently used snapshot polarity

Examples:
!sns1 0 Set snapshot input to active low
!sns1 1 Set snapshot input to active high
?sns1 Read current snapshot input polarity

23.3. snsf (Snapshot Filter)

Syntax: !snsf or ?snsf
Parameter: 0 to 255 [ms]

Description: Reads or set the snapshot filter time in ms, which is used to debounce the snapshot input signals (either HDI button or digital signal via snapshot input). Default is 10ms. The filter doesn't delay the reaction to the signal.

Requirements: The minimum high and low times of the input signal must be greater or equal to 200µs each in order to be recognized.

Remarks: Debouncing is recommended for push-buttons, switches, light barriers etc. For digitally generated signals, the filter time can be set to 0.

Response: Snapshot filter time

Examples:
!snsf 0 Disable input filter
!snsf 10 Set snapshot filter time to 10 ms
?snsf Read snapshot filter time

23.4. snsrm (Snapshot Mode)

Syntax: !snsrm or ?snsrm
Parameter: 0, 1, ... 11

Description: This instruction reads or sets the snapshot mode (default=0).

- 0 = Capture positions to list with Joystick key F2
- 1 = Move forward through position list with Joystick key F2
 (wraps around at the last element)
- 2 = Extended move with Joystick keys:
 - F1: Move backward through position list (wraps around)
 - F2: Move forward through position list (wraps around)
 - F3: Move to '**prehome**' then start of list (first element)
 - F4: Move to '**prehome**' with 'vel' then '**home**' with 'sevel'
- 3 = Simple continuous path control in conjunction with
 pre-loaded **snsa/snse** positions (dissection mode).
 The path travel velocity is set by '**scanvel**'.
 Start with Joystick key F2 or corresponding 'snse 2'.
 HDI must be enabled by **joy** and **joydir** = 2.
- 4 = Like mode 0, but snapshot I/O input is used instead of F2
- 5 = Like mode 1, but snapshot I/O input is used instead of F2
- 6 = Triggered start: Move and Speed instructions will wait
 for the I/O connector snapshot event to start moving.
 Axes must be assigned by the '**snsaxis**' instruction.
- 7 = Custom HDI mode with Prehome, Home and auto increment
 in a time interval set by the '**delay**' instruction
- 8 = A Trigger-OUT event (not a snapshot event) captures axis
 positions and the ANIN0 analogue signal (of the optional
 AUX-I/O connector, available with DT and PCI/PCI-E TANGOs)
- 9 = Move relative '**snsj**' Jump distances with Joystick keys
 F2 = jump, F1 = jump in reversed direction (back)
- 10= Like mode 9, but snapshot I/O input is used instead of F2
- 11= Z axis follows an X-Z position list (e.g. focus for scan)

Remarks: F1-F4 key events can also be generated by '**snse**' 1 to 4.

Position capture modes (0,4,8) also capture the analog voltage
at the AUX-I/O ANIN0 input pin. It can be read by '**?snsv**'.

A snapshot is always executed on all active axes. Capture and
move. For snapshot move the position list must be filled with
valid positions for all axes.

When setting snsrm Snapshot mode, latched key events (**key1**)
or a pending snapshot mode 6 waiting state is cleared.

Response: Currently selected snapshot mode

Examples:

```
!snsrm 0           Set snapshot mode to capture (with joystick key F2)
!snsrm 1           Set snapshot mode to move (with joystick key F2)
!snsrm 2           Set snapshot mode to extended move
!snsrm 8           Set snapshot mode to capture at trigger out events
?snsrm            Read current snapshot mode
```

23.5. Snapshot Mode Description and Examples

Snapshot Mode 1,2,3,7,9 move functions, accessible via Joystick F1-F4 keys or !snse 1-4 instruction:

Key	Mode function				
	1	2	3 (DISSECTION)	7 ***	9
F1 =	-	previous point**	-	prehome* & home	jump back
F2 =	next point	next point**	start dissection	auto inc from 1st point	jump fwd
F3 =	-	prehome*& first point	-	pause/continue	-
F4 =	-	prehome*& home	-	pause & previous point	-

* Remarks: A move to the "prehome" positions always travels at **secvel**.

Prehome & home means that the axes move to prehome and from there to home. This is used to avoid possible collisions on the way to the home position.
Prehome & first point means that the axes move to prehome and after reaching directly to the first position in the position list. This sequence is also for collision prevention.

If prehome is not required, it can be set to the same position as home.
 For graphical explanation of home & prehome positions, refer to Figure 1 below.

** SnapShot mode 2:

F3 function must be executed in order to enable the F1 and F2 functionality
 F4 disables the F1 and F2 functionality, so pressing F3 is required again

Instruction sequence example for snsm 2:

```
!cal
!rm
!sns 0
!prehome [Xpos] [Ypos] [Zpos] [Apos] (specify a redirection to avoid obstacles)
!home [Xpos] [Ypos] [Zpos] [Apos] (specify home, e.g. load, unload position)
!snsa 0 (clear the snapshot array / position list)
!snsa 1 [Xpos] [Ypos] [Zpos] [Apos] (load position list, at least one entry)
!snsa 2 ... (load position list) ...
... !snsa N ...
!snsm 2 (enter snapshot mode 2 for F1-F4 functionality)
!sns 1 (activate snapshot function globally)
```

*** SnapShot Mode 7:

1. Execute a !cal and !rm instruction to define the repeatable, absolute position (origin).
2. Define the !prehome and the !home positions.
3. Define a position list of points using the !snsa instruction.
4. Specify a user delay between the positions by using the !delay instruction.
5. Enter snapshot mode 7 by sending the !snsm 7 instruction.

All information is lost when the TANGO controller is switched off or reset.
 The delay also applies to all move instructions. So when leaving the snapshot mode 7 it is recommended to reset the delay value back to zero (!delay 0).
 Snapshot mode 7 uses the joystick keys F1 to F4 according this specification:

F1 = Go to load/unload position (as defined with the !home and !prehome instructions)
 F2 = Start Auto Movement from Point 1 (through position list, defined by the !snsa instruction and using a delay as defined by the !delay instruction)
 F3 = Pause/Continue from current position (halt the automatic move)
 F4 = Move back one position in the list (when in pause, else it is paused after reaching the next position and then it moves back.)

Instruction sequence example for snsm 7:

```
!cal
!rm
!sns 0
!delay 3000 (delay between moves, e.g. 3 seconds)
!prehome [Xpos] [Ypos] [Zpos] [Apos] (specify a redirection to avoid obstacles)
!home [Xpos] [Ypos] [Zpos] [Apos] (specify home, e.g. load, unload position)
!snsa 0 (clear the snapshot array / position list)
!snsa 1 [Xpos] [Ypos] [Zpos] [Apos] (load position list)
!snsa 2 ... (load position list) ...
... !snsa N ...
!snsm 7 (enter snapshot mode 7 for F1-F4 functionality)
!sns 1 (activate snapshot function globally)
```

Autoincrement can be aborted by the **abort (a)** instruction.

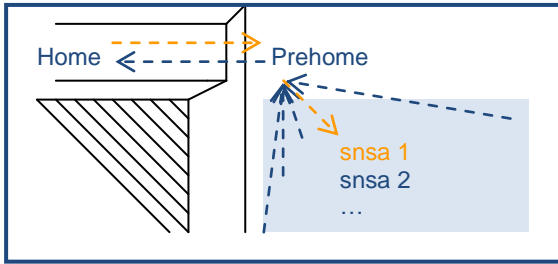


Figure 1: home & prehome (in modes 2 and 7)

SnapShot Mode 3 (dissection, simple continuous path functionality):

Typical applications are laser dissection or evaporation, or adhesive dosers/dispensers.

Remarks: All axes must be idle and all axis positions must be loaded with valid entries.

Joy and joydir must be enabled (e.g. set to 2) for all required axes (as with !speed).

The continuous path functionality has a continuous increase in position deviation which will build up during the sequence. The interpreter is blocked during execution.

```

!scanvel [mm/s]           (set the path/vector velocity)
!sns 0
!snsa 0                   (clear the snapshot array / position list)
!snsa 1 [Xpos] [Ypos] [Zpos] [Apos] (load position list)
!snsa 2 ...               (load position list) ...
... !snsa N ...           ...
!snsm 3                   (enter snapshot dissection mode 3)
!sns 1                   (activate snapshot function globally)
!snse 2                   (start the dissection sequence, or press F2 key)
?err                      (send a request and wait for reply --> completed)

```

SnapShot Mode 11 (X-Z focus list):

In snapshot mode 11, Z follows a position list dependent on the X axis position.

Typically used for focus applications under high magnification.

Best performance with piezo Z-stages, which are able to follow more precisely and at higher velocities.

The snapshot array can be loaded with X-Z position pairs of increasing X value. The X distances can be random, no equal distance or match with e.g. trigger distances required. When snsm 11 is activated, Z travels at interpolated positions between the X points. X positions below the first snapshot array entry will cause Z to remain at the first Z position. X positions higher than the last entry will cause Z to remain at the last Z position. The Z positioning will begin as soon as the snapshot mode is activated. Z then is controlled by the snapshot array position list. The snapshot array positions of Y and A axes are ignored in snsm 11.

```

!sns 0
!snsa 0                   (clear the snapshot array / position list)
!snsa 1 [Xpos] [don't care] [Zpos] (load X-Z position list first entry)
!snsa 2 ...               (load X-Z position list) ...
... !snsa N ...           ...
!snsm 11                  (enter X-Z focus mode)
!sns 1                   (activate snapshot function globally)
?err                      (send a request and wait for reply --> completed)

```

```

Example: !snsa 1 5.1 0 2.33
         !snsa 2 7.1 0 5
         !snsa 3 11.7 0 1.65

```

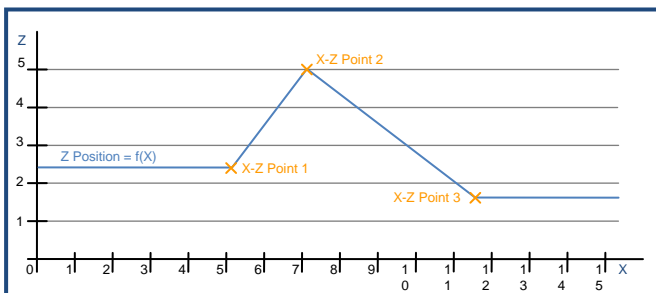


Figure 2: X-Z focus application (snapshot mode 11)

23.6. snsc (Snapshot Counter)

Syntax: !snsc or ?snsc
Parameter: none, 0 or 1 to 1024 (not greater than the current snsc count)

Description: This instruction reads or sets the snapshot counter, which shows the snapshot array entries (counted snapshot events). This instruction may also be used to reset the counter to zero or reduce the size of an existing array.

Response: Current snapshot array entries (number of snapshot events)

Example:
?snsc Read the number array entries (e.g. captured snapshots)
!snsc Clear snapshot counter to zero elements
!snsc 0 Clear snapshot counter (same as !snsc without parameter)
!snsc 50 Reduce snapshot array entries to 50 (only if the current snsc value is equal or higher than the new value)

23.7. snsi (Snapshot Index)

Syntax: !snsi or ?snsi
Parameter: none or 0 to 1023 (less than the current snsc count)

Description: This instruction reads or sets the snapshot array pointer.

In snapshot modes 1 and 5 this pointer access can be used to manipulate the array index where move target positions are read from.

Opposed to other snapshot instructions the index range here is [0...N-1] instead of [1...N]. The value must be less than the amount of **snsc** array entries.

Remarks: The pointer is only used for the snapshot move. It does not define the array index where positions are written to. Captured positions are always appended as the last element of the array. For array manipulations by software please refer to '**snsa**' and '**snsr**'.

Response: Current snapshot array pointer

Example:
?snsi Read the current array pointer position
!snsi 0 Set array pointer to the first element
!snsi Same as !snsi 0
!snsi 20 Set array pointer to the 21st element

23.8. snsaxis (Snapshot Axis)

Syntax: !snsaxis or ?snsaxis
Parameter: x, y, z, a or none
 0 or 1

Description: Defines which axes should wait in Snapshot mode 6.
 Please refer to '**snsm**' for further information.
 When sending a moa, mor or speed instruction with sns 6,
 axes can be specified that should not execute the move until
 triggered by a snapshot-in event. This can be used in cases
 where precise start timing has to be controlled by an external
 signal (maybe also set the '**trigf**' value to zero then).

1 = move or speed of this axis will wait for snapshot signal
0 = axis does not wait for snapshot signal (default operation)

Remarks: If not all axes are set to waiting mode, a vector move may
 start some of the axes while the others are waiting.
 Such problem does not exist when using single axis move/speed
 instructions.

Response: Wait mode setting of the axes

Example:

```
!snsaxis 1 0 1    Set axis X, Z to waiting mode, Y does not have to wait
!snsaxis y 1     Set axis Y to waiting mode
?snsaxis         Read waiting mode of all available axes (e.g. returns "0 0 0")
?snsaxis z       Read waiting mode of Z axis only (e.g. returns "1")
```

23.9. snsp (Snapshot Position)

Syntax:	!snsp or ?snsp
Parameter:	x, y, z, a or none Positions (unit depends on ' dim ')
Description:	This instruction reads the most recently captured Snapshot Position. It can also be used to append new positions to the Snapshot position array. The snapshot counter ' snc ' will be incremented automatically. Please also refer to ' snsa '.
Remarks:	The unit of the position data depends on selected ' dim ' value. Only motor positions can be read. In order to read captured encoder positions, please refer to ' ?snsa '.
Response:	Last captured Snapshot position of the specified axis or of all available axes
Examples:	
?snsp	Read last captured snapshot position of all axes
?snsp z	Read last captured snapshot position of Z axis only
!snsp 10 20 30	Append new motor position entry for X, Y and Z axis
!snsp y 2000	Append new position entry with Y-axis only (not recommended)

23.10. snsas (Snapshot Array)

Syntax:	!snsas or ?snsas
Parameter:	x, y, z, a or none -1, 0 or 1 to 1024
Description:	Read, fill, modify or clear the snapshot position array, which may contain up to 1024 elements. For reading a valid element, the index must have a value between 1 and the maximum of the snapshot counter value. Please also refer to ' ?snc '. To append new position data to the array, an index of [snc+1] or index=-1 may be used. The Snapshot counter then will be incremented by 1 automatically. Parameter: -1 = last/append, 0 = clear, 1...1024 = r/w access.
Remarks:	The unit of the position data depends on selected ' dim ' value. The read position values are either motor positions or encoder positions, depending on active encoders and ' encpos ' settings. Encoder position is only available with captured positions, not when the position entry was written by software (!snsp or !snsas). In this case the encoder position is read as 0 and ' encpos ' should be set to 0 for reading this position.
Response:	Snapshot array position(s) in ' dim ' units.
Examples:	
?snsas 1	Read all axis positions of the first snapshot entry
?snsas 33	Read all axis positions of the 33rd snapshot entry
?snsas z 99	Read the Z-axis position of the 99th snapshot entry
?snsas y -1	Read the Y-axis position of the last snapshot entry
?snsas -1	Read all axis positions of the last snapshot entry
!snsas 0	Clear the entire snapshot array
!snsas x 1 20.5	Set X position of first element to 20.5 (e.g. mm if dim=2)
!snsas 2 10 10 10 10	Set all axis positions of the second array entry to 10
!snsas -1 10 10 10 10	Append a new entry to the position array (snc is incremented)

23.11. snse (Snapshot Event)

Syntax: !snse or snse
Parameter: 1, 2, 3 or 4

Description: Executes the F-key Snapshot functions via the communication interface. Instead of pressing a Joystick button or using the AUX-I/O signal, the functions can be triggered by software:

1 = Function normally executed by pressing Joystick F1 key
2 = Function normally executed by pressing Joystick F2 key
or using the AUX-I/O SnapShot input
3 = Function normally executed by pressing Joystick F3 key
4 = Function normally executed by pressing Joystick F4 key

Remark: Behavior is the same as with the function keys. It depends on the snapshot mode settings and only works when Snapshot is enabled. Does not work with Snapshot Mode 8, as this mode requires trigger out signals being generated by the TANGO.

Response: -

Example:
snse 2 Execute F2 Snapshot event (e.g. capture current position to the snapshot position array)

23.12. snsV (Snapshot Voltage)

Syntax: !snsv or ?snsv
Parameter: 1 to 1024 or -1 to -1024

Description: Read the AUX-I/O ANIN0 input voltage (0...5V), captured at the specified position array index. The value can also be written to (i.e. as temporary data storage)
Index > 0: read Voltage in [mV]
Index < 0: read raw ADC data

Remarks: The specified index must be in the range of ±1 to ±?snsc. The [mV] values are always calculated with the internal voltage reference, while the raw data is the direct ADC sampling result which may be less accurate (only PCI-E based TANGOs have an accurate ADC sampling result). The raw data range is always 12bit, but with PCI-S based controllers the 2 LSBs are always zero (10bit resolution).

Response: Voltage in [mV] or in [12bit ADC raw data]

Example:
?snsv 2 Read captured Voltage [mV] of 2nd snapshot array entry
?snsv -2 Read captured Voltage [raw] of 2nd snapshot array entry
!snsv 5 1234 Store the value 1234 in 5th snapshot array voltage element

23.13. snsj (Snapshot Jump)

Syntax: !snsj or ?snsj
Parameter: x, y, z, a or none
 Positions (unit depends on '**dim**')

Description: This instruction sets the jump distance, used for relative moves via HDI key F2 and F1 = jump with reversed direction. The unit of the position depends on the setting of '**dim**'.

Remarks: Used in snapshot mode (**sns**m) 9.

Response: Position value(s)

Examples:

```
!snsj z 1.5            Set the jump distance for Z axis to 1.5 (mm if dim= 2 or 9)
!snsj 1 -10 0 0.2     Set the jump distance for all axes (here Z doesn't move)
?snsj y                Read the jump distance of Y axis
?snsj                  Read the jump distance of all axes
```

23.14. prehome (Snapshot PreHome Position)

Syntax: !prehome or ?prehome
Parameter: x, y, z, a or none

Description: This instruction sets the prehome position used by the snapshot extended move. The unit of the position depends on the setting of '**dim**'.

Remarks: Used in snapshot modes (**sns**m) 2 and 7.

Response: Position value(s)

Examples:

```
!prehome y 10.2       Set prehome position Y-value to 10.2 (e.g. [mm] when dim=2)
!prehome 10 0 20      Set prehome position X,Y,Z
?prehome x            Read currently used prehome position of X axis only
?prehome              Read currently used prehome positions of all axes
```

23.15. home (Snapshot Home Position)

Syntax: !home or ?home
Parameter: x, y, z, a or none

Description: This instruction sets the home position used by the snapshot extended move. The unit of the position depends on the setting of '**dim**'.

Remarks: Used in snapshot modes (**sns**m) 2 and 7.

Response: Position value(s)

Examples:

```
!home y 10.2           Set home position Y-value to 10.2 (e.g. [mm] when dim=2)
!home 10 0 20          Set home position X,Y,Z
?home x                Read currently used home position of X axis only
?home                  Read currently used home positions of all axes
```

24. Glossary

AUX I/O	Optional extension connector for PCI-S and PCI-E based TANGOS / TANGO Desktop. Provides analog and digital I/O, safety and trigger functionality.
Cal	Causes axes to travel towards the lower limit switch. Usually the zero position is also set by this instruction.
Closed Loop	The axis position is controlled according to a measuring system.
HDI	Human Device Interface, manual control of the axes, e.g. Joystick.
I/O1	Optional extension module for digital I/O 24xIN + 8xOUT
LED100	Optional LED illumination unit for microscopes
Multi I/O	Optional I/O extension for digital 12xIN + 8xOUT (24, 12 or 5Volts)
PCI-E	TANGO controller type for PCI-E slots. Offers greater functionality compared to the PCI-S. Used in TANGO Desktop named DT-E.
PCI-S	TANGO controller type for PCI slots. Also used in TANGO Desktop.
Rm	Causes axes to travel towards the upper limit switch. Usually executed directly after cal, then it also disables the secvel velocity limitation.
Secvel	Secure velocity which limits the axis travel velocity as long as no cal and rm has been executed. Ment to protect the axes from damage when traveling too fast into the axis hardware limits.
Snapshot	Trigger input functionality, also available with joystick key F2.
TANGO	Motion controller for stepper motors, also called controller.



25. Document Revision History

No.	Revision	Date	Changes	Remarks
01	A	27. March 2012	Newly revised and extended document version	Based on TANGO firmware revision 1.57
02	B	16. April 2012	Added instructions: Ecomove, noled, calrequired, joychangeaxis, ctrsm, ctrs, trigo, trigcomp, trigenc, snsi, snsaxis, sns, zwfactor, detext, posclr, maxaxis, trigbwidth, trigbdelay, trigbf, encrefvel, vrm, flash, etspresent, stagesn Added stop and stoppol modes !joy instruction autostatus behavior	Based on TANGO firmware revision 1.57
03	C	03. May 2012	caldir marked as dummy, naming conventions, version instruction	
04	D	18. July 2012	Remarks concerning closed loop behavior and (current) reduction	
05	-	30. July 2012	digin, digout, diginpol, digintyp, digoutpreset	Based on TANGO firmware revision 1.57
06	Prelim E	06. Sept. 2012	Added: Glossary of common terms, Joystick Key Assignment chart Second Trigger Output description Multi I/O instructions edigin, edigout, ediginpol, edigintyp, edigoutpreset Adapted to naming conventions Improved description of HDI	Based on TANGO firmware revision 1.58
07	E	18. Feb. 2013	Added: anamode, trigr, corrst	Based on TANGO firmware revision 1.60
08	F	25. June 2013	Added I/O communication error 77 ?ver instruction "Ver:" to "Vers:" Improved vrm description	
09	G	23. Aug. 2013	Improved go, speed, vel description	Final documentation of firmware 1.60
10	Prelim H	23. Aug. 2013	Extended functionality of "go" and "vel" instructions	Based on TANGO firmware revision 1.60C
11	H	04. Sept. 2013	Added "!mol" and "lockpos"	Based on TANGO firmware revision 1.60C
12	I	16. Oct. 2013	Added "!pa 2"	Based on TANGO firmware revision 1.58
13	Prelim J	02. Dec. 2013	Added multiple manual trigger pulses description	Based on TANGO firmware revision 1.60C
14	Prelim J	06. Dec. 2013	Added scanmode 3	Based on TANGO firmware revision 1.63
15	J	20. Oct. 2014	Corrected "limctr" description Added new ctrstatus option, Added hdimode options for LED100 Added "zwpos", "enctype", "brake", "trigl" instructions Improved descriptions Added snapshot mode "snsm 9" (jump mode) and "snsj" Added calvel, rmvel with one parameter Mentioned "trigenc" encoder trigger position limitations Added sns10 Extended description of "trigs" Revised closed loop descriptions Added "calzeropos" and "tvr" instructions	Final documentation of firmware 1.65



No.	Revision	Date	Changes	Remarks
16	Prelim K	02. April 2015	Corrected snsm 10 description, added liquid dispenser instructions "drop" and "pump", extended "a" description, added LED100 example for adigout	Based on TANGO firmware revision 1.66
17	Prelim K	21. Sept. 2015	Added "clim" instruction, added hdimode bit 8	Based on TANGO firmware revision 1.66
18	Prelim K	21. Oct. 2015	Extended trigr description	Based on firmware 1.66 and 1.60H/1.60S
19	Prelim K	30. Oct. 2015	Extended speed and velfac description	
20	K	10. Nov. 2015	Document released for TANGO Firmware 1.66	Based on TANGO firmware revision 1.66
21	-	01. Dec. 2015	Corrected trigenc description for TTL Added lock and lockstate bits 14, 15	
22	L	22. Dec 2015	Revised release for TANGO Firmware 1.66	Based on TANGO firmware revision 1.66
23	M	13. Jan. 2016	Improved trigger, "trigs" and 1:1 trigger output mode description	
24		20. Jan. 2016	Improved descriptions of LED100	
25		27. Jan. 2016	Improved and corrected encoder descriptions (encerr = e) etc.	
26	N	16. Feb 2016	Added "trigp", "trigc", "trigi", "iscur", "snsm 11", Improved trigger description, Improved and extended snapshot mode "snsm" description	Final documentation of firmware 1.67