



DOCUMENTATION ISG-kernel

Functional description Oscillating axis

Short Description:
FCT-A8

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ISG Industrielle Steuerungstechnik GmbH
STEP, Gropiusplatz 10
D-70563 Stuttgart
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www.isg-stuttgart.de
support@isg-stuttgart.de

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Preface

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This description is solely intended for skilled technicians who were trained in control, automation and drive systems and who are familiar with the applicable standards, the relevant documentation and the machining application.

It is absolutely vital to refer to this documentation, the instructions below and the explanations to carry out installation and commissioning work. Skilled technicians are under the obligation to use the documentation duly published for every installation and commissioning operation.

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Further information

Links below (DE)

<https://www.isg-stuttgart.de/produkte/softwareprodukte/isg-kernel/dokumente-und-downloads>

or (EN)

<https://www.isg-stuttgart.de/en/products/softwareproducts/isg-kernel/documents-and-downloads>

contains further information on messages generated in the NC kernel, online help, PLC libraries, tools, etc. in addition to the current documentation.

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This documentation uses the following icons next to the safety instruction and the associated text. Please read the (safety) instructions carefully and comply with them at all times.

Icons in explanatory text

➤ Indicates an action.

⇒ Indicates an action statement.



⚠ DANGER

Acute danger to life!

If you fail to comply with the safety instruction next to this icon, there is immediate danger to human life and health.



⚠ CAUTION

Personal injury and damage to machines!

If you fail to comply with the safety instruction next to this icon, it may result in personal injury or damage to machines.



Attention

Restriction or error

This icon describes restrictions or warns of errors.



Notice

Tips and other notes

This icon indicates information to assist in general understanding or to provide additional information.



Example

General example

Example that clarifies the text.



Programing Example

NC programming example

Programming example (complete NC program or program sequence) of the described function or NC command.



Release Note

Specific version information

Optional or restricted function. The availability of this function depends on the configuration and the scope of the version.

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1 Overview

Task

Oscillating axis motions (oscillation) are used for the grinding machining process, for example. As a result of the oscillating motion, a tool (grinding disc) moves in the reverse direction across the workpiece in order to reach the final dimension with high precision and surface quality.

Characteristics

The essential characteristics of the oscillating motion result from the oscillating motion between two absolute positions as well as the feed rate.

Parametrisation

Settings are required in the channel and axis parameter lists to parameterise an oscillating motion. The section Parameter [▶ 14] contains a detailed description of the commands.

Programming

An oscillating motion is defined in the NC program by the axis-specific command X[OSC...] (see Chapter Programming [▶ 10]).

Mandatory note on references to other documents

For the sake of clarity, links to other documents and parameters are abbreviated, e.g. [PROG] for the Programming Manual or P-AXIS-00001 for an axis parameter.

For technical reasons, these links only function in the Online Help (HTML5, CHM) but not in pdf files since pdfs do not support cross-linking.

2 Description

An oscillating axis motion is required in certain machining technologies, e.g. grinding, and this is executed mainly independently of a path motion.

This motion referred to below as an "oscillating motion" is executed by the tool with periodic reversal across the workpiece.

In the strict physical sense of the word, a typical oscillating motion is sinusoidal. It must be borne in mind that, when the term "oscillating motion" is used for the periodic reversal motion described in this section, the timing of the motion is not generally sinusoidal.

This is also not intended since in typical grinding work, the relative velocity between the disc and the workpiece should be constant, at least during tool engagement.

An oscillating axis during grinding is presented in the figure below as an example. The workpiece is machined by superimposing the oscillating X motion on positioning motions in the Y and Z axes.

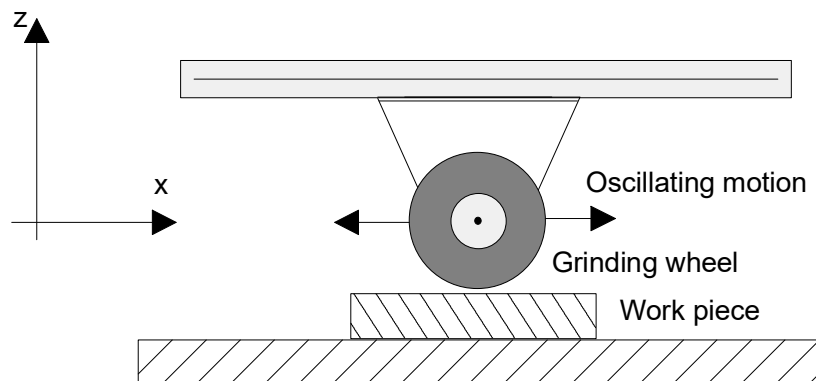


Fig. 1: Grinding with an oscillating axis

Description of parameters

An oscillating motion can be described by the following parameters in addition to the profile type which defines the velocity curve in the dynamic phase.

- v_{osc} : Oscillation feed rate
- T_{osc} : Oscillation period
- f_{osc} : Oscillation frequency ($1/T_{osc}$)
- $p1$: Oscillation reversal position 1
- $p2$: Oscillation reversal position 2
- t_{d1} : Waiting/deceleration time at oscillation reversal position 1
- t_{d2} : Waiting/deceleration time at oscillation reversal position 2
- s_{exc} : Oscillation excursion

The time and path diagrams below explain the parameters:

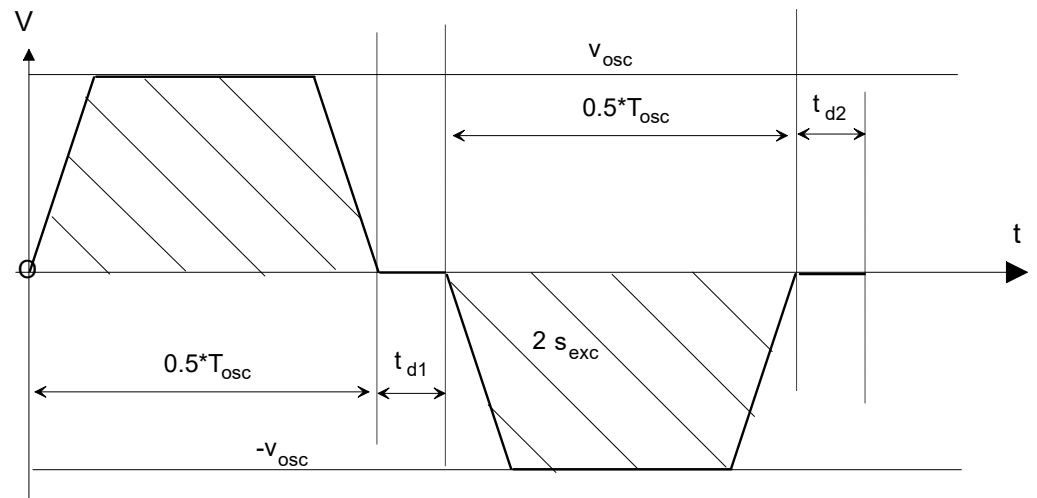


Fig. 2: Oscillating motion in the time range with linear slope profile

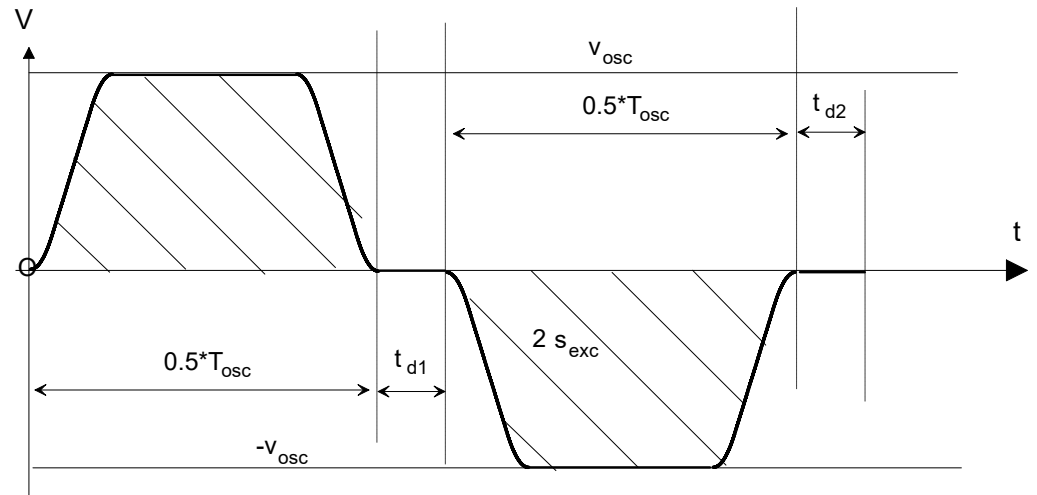


Fig. 3: Oscillating motion in the time range with non-linear slope profile

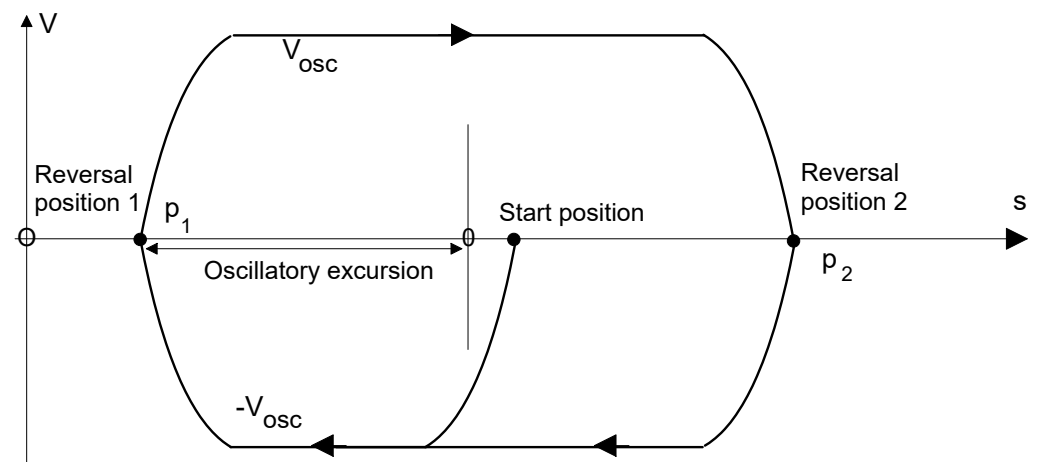


Fig. 4: Positioning procedure with pendulum movement

Characteristics

- The essential characteristics of the oscillating motion result from the oscillating motion between two absolute positions as well as the feedrate.
- Any definition of the oscillating axis within the configured axes
- Asynchronous oscillating motion
- Alternative programming of the oscillating axis in the path compound
- The oscillating motion is started, stopped and parameterised via the NC program
- Slope type depending on the channel parameter settings
- Programmable waiting times at the reversal points of the oscillating motion
- Using G01 acceleration in the dynamic phases of the motion
- Interrupting the path motion if oscillating motion is commanded
- Implicit deactivation of oscillating motion when:
 - transiting from programmed oscillating axis to path motion
 - Issuing new command without previous deselection
 - requesting axis positions to synchronise decoding and interpolation
 - Program end



Notice

After an oscillating motion is deactivated, the motion is always stopped at **oscillating position 2**.

3 Programming

The programming syntax is based on the axis-specific programming of independent axes [PROG].

After the axis identifier, the parameters of the oscillating motion are defined by keywords and, if applicable, an associated value:

X[<keyword> <(value1)>, [<keyword2> <(value2)> ,...]

The characteristic of the oscillating motion is determined by the locations of the reversal positions and the axis feedrate. The reversal positions can be either specified directly or alternatively they are determined automatically via the zero position and the excursion.

Alternatively, the oscillating velocity can be defined by:

- Feedrate
- Frequency
- Period

If no restriction occurs due to the dynamic axis characteristics, the frequency and the period are maintained exactly when the linear slope is used and maintained approximately when the non-linear slope is used.

```
<axis_name> [ OSC ON | OFF FEED<expr> | FREQ<expr> | TIME<expr>
[1ST_POS<expr> 2ND_POS<expr>] | [ ZERO_POS<expr> EXCUR<expr>]
[1ST_DELT<expr> 2ND_DELT<expr>] [NBR_OSC<expr>] { \ } ]
```

<axis_name>	Name of the oscillating axis
OSC	Identifier for "Oscillating" function. Must always be programmed as the <u>first</u> keyword.
ON	Oscillation on. The motion is stopped at block end when a path motion is active and the oscillating motion is then commanded.
OFF	Oscillation off. The oscillating axis can then move again in the coordinated motion. If the oscillating motion is stopped implicitly if it is not previously deselected when a new axis motion is programmed.
FEED<expr>	Feedrate of the oscillating motion in [mm/min, m/min, inch/min]
FREQ<expr>	Frequency of the oscillating motion in [Hz]
TIME<expr>	Period of the oscillating motion in in [s]
1ST_POS<expr>	First reversal position in [mm, inch]
2ND_POS<expr>	Second reversal position in [mm, inch]
ZERO_POS<expr>	Zero point or zero crossing of the oscillating motion in [mm, inch]
EXCUR<expr>	Excursion in [mm, inch]
1ST_DELT<expr>	Wait time at first reversal position in [s]
2ND_DELT<expr>	Wait time at second reversal position in [s]
NBR_OSC<expr>	Number of oscillations
\	Separator ("backslash") for clear programming of the command over multiple lines.



Programming Example

Programming the oscillating axis

The equals signs between the keyword and the value are optional.

Specifying the oscillating motion path via reversal positions:

```
N10 X[OSC ON 1ST_POS=-100 2ND_POS=100 FEED=1000]
```

Specifying the oscillating motion path via the zero position and the excursion:

```
N20 X[OSC ON ZERO_POS=0 EXCUR=100 FEED=1000]
```

Specifying oscillation frequency 1 Hertz, 10 oscillations:

```
N30 X[OSC ON ZERO_POS=0 EXCUR=100 FREQ=1 NBR_OSC=10]
```

Specifying a 4s oscillating period:

```
N40 X[OSC ON ZERO_POS=0 EXCUR=100 TIME=4]
```

Oscillating motion with feed motion of a path axis:

```
N50 X[OSC ON 1ST_POS=111 2ND_POS=222 FREQ=1]
N60 G01 G90 Y500 F200
```

Oscillate with wait times of 0.5 s each at reversal positions

```
N70 X[OSC ON 1ST_POS=-100 1ST_DELT=0.5 2ND_POS=200
      2ND_DELT=0.5 FEED=1000]
```

Deselecting oscillation:

Oscillation is stopped when reversal position 2 is reached:

```
N80 X[OSC OFF]
```

Fast oscillation stop:

If a feedrate is programmed with FEED in combination with OFF, the oscillating motion is stopped immediately (feedhold of oscillating axis) and the reversal position 2 is directly approached at the new feed rate.

```
N90 X[OSC OFF FEED=5000]
```



Notice

Restrictions of kinematic transformations

When kinematic transformation (#TRAFO ON) is active, an oscillating motion is only permitted if the kinematics have a basic Cartesian structure and the oscillation direction vector lies in the z axis direction of the machine.

4 Oscillating motion dynamics

Depending on the profile type, limiting effects occur at relatively high frequency or short period or short oscillation path. This is caused by the limited axis velocities and accelerations.

In this case, the real oscillation frequency or period deviates from the required programmed frequency or period.

The examples listed below show the limits of motion dynamics. In general these motion profiles should be avoided since the motion velocity and therefore the machining velocity during the oscillating motion are not constant or tend to deviate lower.

4.1 Example of limitation by acceleration



Programing Example

Limitation by acceleration

Dynamic characteristics used:

a_max: 1000 mm/s²

v_max: 5000000 μ m/s

```
%L sub_mv
N1000 G01 G90 Y100 F500
N2000 Y-100
M29

%osc_7
N10 X[OSC ON 1ST_POS=-120 2ND_POS=120 FREQ=0.6]
N20 LL sub_mv
N30 X[OSC OFF]
N180 M30
```

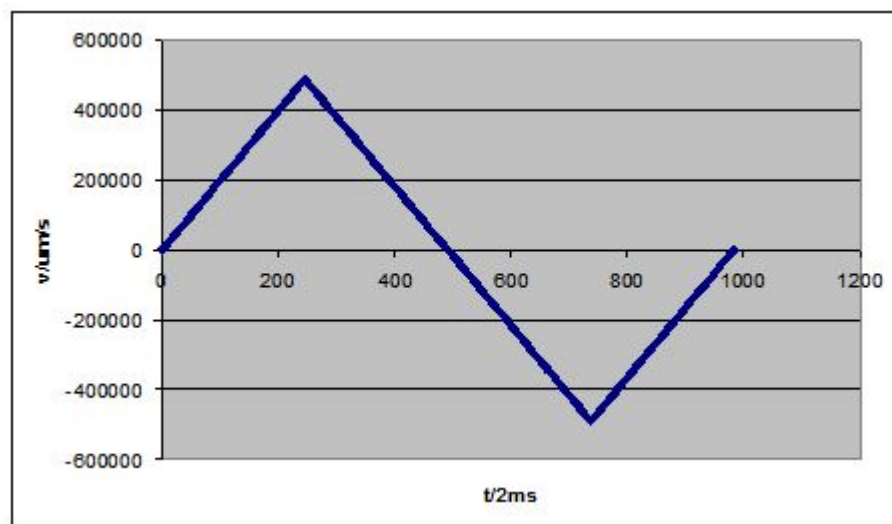


Fig. 5: Limited oscillating frequency due to axis acceleration

A full oscillation requires 1.964 s. The required 1.666 s (approx. 833 cycles) are therefore not possible with the dynamic characteristics listed above due to the oscillating frequency of 0.6 Hz.

4.2 Example of limitation by velocity



Programing Example

Limitation by velocity

Dynamic characteristics used:

a_max: 1000 mm/s²

v_max: 500000 μm/s

```

%L sub_mv
N1000 G01 G90 Y100 F500
N2000 Y-100
M29

%osc_7
N10 X[OSC ON 1ST_POS=-520 2ND_POS=520 FREQ=0.2]
N20 LL sub_mv
N30 X[OSC OFF]
N180 M30
    
```

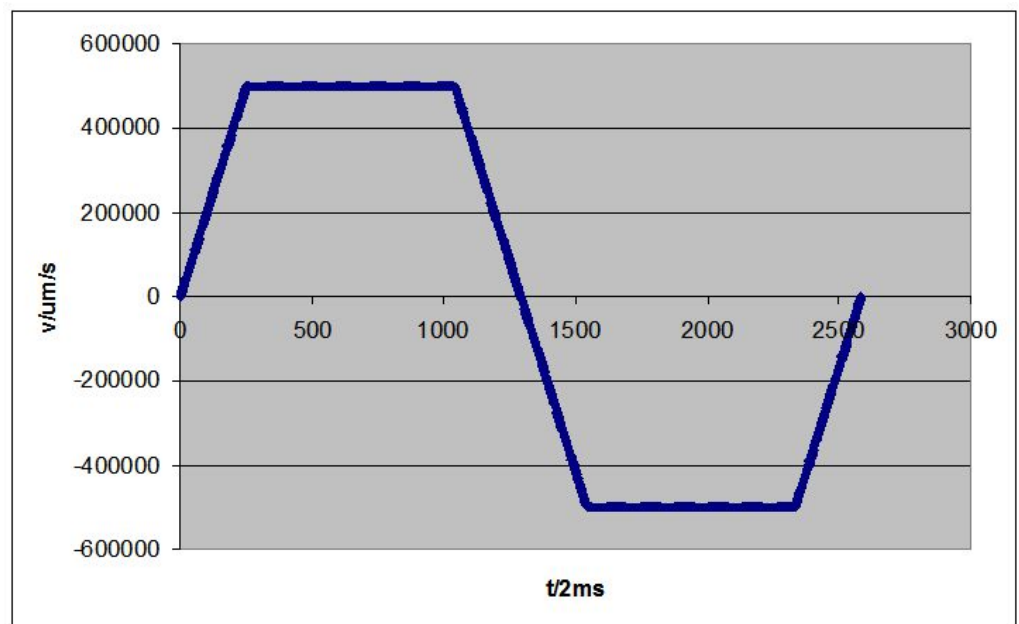


Fig. 6: Limited oscillating frequency due to axis acceleration

A full oscillation requires 5.164 s. The required 5 s (approx. 2500 cycles) are therefore not possible with the dynamic characteristics listed above due to the oscillating frequency of 0.2 Hz.



Attention

When the dynamic limits are reached, an error message is output.

5 Parameter

The actual oscillating motion is completely parameterised via the NC program except for the profile type.

5.1 Overview

5.1.1 Channel parameters

The parameter below defines the profile type for the oscillating motion:

ID	Parameter	Description
P-CHAN-00071	profile	Default acceleration profile

5.1.2 Axis parameters

The parameters below are the limiting characteristics for oscillating dynamics.

Linear slope parameters

ID	Parameter	Description
P-AXIS-00011	a_stufe_1	Acceleration in Step 1
P-AXIS-00012	a_stufe_2	Acceleration in Step 2
P-AXIS-00221	vb_stufe_1_2	Changeover velocity between acceleration steps

Non-linear slope parameters

ID	Parameter	Description
P-AXIS-00001	a_beschl	Acceleration at machining feed rate
P-AXIS-00002	a_brems	Deceleration at machining feed rate
P-AXIS-00195	tr_beschl_ab	Ramp time for acceleration down-gradation
P-AXIS-00196	tr_beschl_zu	Ramp time for acceleration up-gradation
P-AXIS-00197	tr_brems_ab	Ramp time for deceleration down-gradation
P-AXIS-00198	tr_brems_zu	Ramp time for deceleration up-gradation

5.2 Description

5.2.1 Channel parameters

P-CHAN-00071	Default acceleration profile at program start
Description	Default value for the selected acceleration profile type with path movements and oscillating axis movements.
Parameter	prog_start.slope.profile
Data type	SGN16
Data range	0: Step-shaped acceleration profile (default) 1: Trapezoidal acceleration profile 2: Sine-square acceleration profile 3: Trapezoidal HSC acceleration profile (across blocks)
Dimension	----
Default value	0
Remarks	<p>The acceleration profile and the associated acceleration and ramp time weighting can be programmed in the NC program with the #SLOPE [TYPE..] command [PROG].</p> <p>The maximum of the weighted ramp times P-AXIS-00195.. P-AXIS-00198 is always effective with the trapezoidal HSC acceleration profile.</p> <p>For every independent axis, the acceleration profile can also be programmed specifically in the NC command with the key word SLOPE_TYPE [PROG].</p>

5.2.2 Axis parameters

5.2.2.1 Linear slope

P-AXIS-00011	Acceleration of step 1 (linear slope)	
Description	The parameter only becomes active during the deceleration phases. It defines the acceleration in step 1.	
Parameter	getriebe[i].lslope_profil.a_stufe_1	
Data type	UNS32	
Data range	$1 \leq a_stufe_1 \leq P\text{-}AXIS\text{-}00008$	
Axis types	T, R, S	
Dimension	T: mm/s ²	R,S: °/s ²
Default value	1000	
Drive types	----	
Remarks	The acceleration ramps can be changed in the NC program. The appropriate NC commands are described in detail in [PROG//G130, G131] in greater detail.	

P-AXIS-00012	Acceleration of step 2 (linear slope)	
Description	The parameter only becomes active during the deceleration phases. It defines the acceleration in step 2.	
Parameter	getriebe[i].lslope_profil.a_stufe_2	
Data type	UNS32	
Data range	$1 \leq a_stufe_2 \leq P\text{-}AXIS\text{-}00008$	
Axis types	T, R, S	
Dimension	T: mm/s ²	R,S: °/s ²
Default value	1000	
Drive types	----	
Remarks	The acceleration ramps can be changed in the NC program. The appropriate NC commands are described in detail in [PROG//G130, G131] in greater detail.	

P-AXIS-00221	Changeover speed (linear slope)	
Description	The parameter becomes active during the acceleration and deceleration phases. It defines the changeover speed between step 1 and step 2 (P-AXIS-00011 and P-AXIS-00012 or P-AXIS-00283 and P-AXIS-00282).	
Parameter	getriebe[i].lslope_profil.vb_stufe_1_2	
Data type	UNS32	
Data range	$1 \leq vb_stufe_1_2 \leq P\text{-}AXIS\text{-}00212$	
Axis types	T, R, S	
Dimension	T: µm/s	R,S: 0.001°/s
Default value	100000	
Drive types	----	
Remarks		

5.2.2.2 Non-linear slope

P-AXIS-00001	Acceleration at machining feed (non-linear slope)	
Description	The parameter represents the axis acceleration with increasing velocity.	
Parameter	getriebe[i].slope_profil.a_beschl	
Data type	UNS32	
Data range	$1 \leq a_beschl \leq P\text{-}AXIS\text{-}00008$	
Axis types	T, R	
Dimension	T: mm/s ²	R,S: °/s ²
Default value	1000	
Drive types	----	
Remarks	The acceleration ramps can be changed in the NC program. The appropriate NC commands are described in [PROG//G130/G131] in greater detail.	

P-AXIS-00002	Deceleration at machining feed (non-linear slope)	
Description	The parameter represents the axis deceleration with decreasing velocity.	
Parameter	getriebe[i].slope_profil.a_brems	
Data type	UNS32	
Data range	$1 \leq a_brems \leq P\text{-}AXIS\text{-}00008$	
Axis types	T, R, S	
Dimension	T: mm/s ²	R,S: °/s ²
Default value	1000	
Drive types	----	
Remarks	The acceleration ramps can be changed in the NC program. The appropriate NC commands are described in [PROG//G130/G131] in greater detail.	

P-AXIS-00195	Ramp time for acceleration down-gradation (non-linear slope)	
Description	The parameter defines the acceleration ramp time for the down-gradation of the acceleration P-AXIS-00001.	
Parameter	getriebe[i].slope_profil.tr_beschl_ab	
Data type	UNS32	
Data range	P-AXIS-00201 ≤ tr_beschl_ab ≤ MAX(UNS32)	
Axis types	T, R, S	
Dimension	T: μs	R,S: μs
Default value	50000	
Drive types	----	
Remarks	The ramp time can be changed in the NC program. The appropriate NC commands are described in [PROG//G132, G133] in greater detail.	

P-AXIS-00196	Ramp time for acceleration up-gradation (non-linear slope)	
Description	The parameter defines the acceleration ramp time for the up-gradation of the acceleration P-AXIS-00001.	
Parameter	getriebe[i].slope_profil.tr_beschl_zu	
Data type	UNS32	
Data range	P-AXIS-00201 ≤ tr_beschl_zu ≤ MAX(UNS32)	
Axis types	T, R, S	
Dimension	T: μs	R,S: μs
Default value	50000	
Drive types	----	
Remarks	The ramp time can be changed in the NC program. The appropriate NC commands are described in [PROG//G132, G133] in greater detail.	

P-AXIS-00197	Ramp time for deceleration down-gradation (non-linear slope)	
Description	The parameter defines the acceleration ramp time for the down-gradation of deceleration P-AXIS-00002.	
Parameter	getriebe[i].slope_profil.tr_brems_ab	
Data type	UNS32	
Data range	$P\text{-}AXIS\text{-}00201 \leq tr_brems_ab \leq MAX(UNS32)$	
Axis types	T, R, S	
Dimension	T: μs	R,S: μs
Default value	50000	
Drive types	----	
Remarks	The ramp time can be changed in the NC program. The appropriate NC commands are described in [PROG//G132, G133] in greater detail.	

P-AXIS-00198	Ramp time for deceleration up-gradation (non-linear slope)	
Description	The parameter defines the acceleration ramp time for the up-gradation of deceleration P-AXIS-00002.	
Parameter	getriebe[i].slope_profil.tr_brems_zu	
Data type	UNS32	
Data range	$P\text{-}AXIS\text{-}00201 \leq tr_brems_zu \leq MAX(UNS32)$	
Axis types	T, R, S	
Dimension	T: μs	R,S: μs
Default value	50000	
Drive types	----	
Remarks	The ramp time can be changed in the NC program. The appropriate NC commands are described in [PROG//G132, G133] in greater detail.	

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6 Appendix

6.1 Suggestions, corrections and the latest documentation

Did you find any errors? Do you have any suggestions or constructive criticism? Then please contact us at documentation@isg-stuttgart.de. The latest documentation is posted in our Online Help (DE/EN):



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The link above forwards you to:

<https://www.isg-stuttgart.de/fileadmin/kernel/kernel-html/index.html>



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