



DOCUMENTATION ISG-kernel

Commissioning manual Commissioning of the kinematic transformation

Short description:
CMS-A2

Preface

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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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Icons used and their meanings

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.



Programming 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.

Contents

Preface.....	2
General and safety instructions	3
1 Machines with kinematic transformation	6
1.1 Commissioning of the transformation.....	6
1.2 General approach for machine commissioning.....	6
1.2.1 Activating transformation	7
1.2.2 Implicit selection/cancellation of kinematic transformation	8
1.2.3 Parameterising the kinematics via the NC program.....	8
1.2.4 Checking the settings in the case of five-axis kinematics.....	9
1.2.4.1 Zero setting the rotatory B axis in the tool	9
1.2.4.2 Setting the zero position of the rotatory C axis in the tool	9
1.2.4.3 Zero setting the rotatory C axis in the workpiece.....	9
2 Examples for machine kinematics	10
2.1 Transformation for 5-axis machine with rotary table	10
2.1.1 Kinematic structure	10
2.1.2 Aligning the axis systems.....	11
2.2 Transformation for Tripod strut kinematic with fixed strut length.....	14
2.2.1 Kinematic structure	14
2.3 Transformation for articulated robot.....	17
2.3.1 Kinematic structure, Axis configuration.....	17
2.3.2 Translatory kinematic offsets	19
2.3.3 Rotary kinematic offsets.....	20
2.3.3.1 Angle offset.....	20
2.3.3.2 Direction of rotation.....	21
2.3.3.3 Flange coordinate system.....	23
2.3.4 Tool offsets	23
2.3.5 Sample parameterisation for a KUKA KR210	23
2.3.5.1 Axis configuration	23
2.3.5.2 Kinematics offsets.....	24
3 Appendix	25
3.1 Suggestions, corrections and the latest documentation.....	25

List of figures

Fig. 1:	Kinematic structure of the single-column bed machine	10
Fig. 2:	Coordinate systems and motion directions.....	11
Fig. 3:	Kinematic offsets	12
Fig. 4:	Tripod kinematics	14
Fig. 5:	Offset dimensions of strut kinematics	15
Fig. 6:	Axis configuration of the kinematic	18
Fig. 7:	Example for param[13]=0 degrees, param[14]=0 degrees	20
Fig. 8:	Example for param[13]=-90 degrees, param[14]=90 degrees.....	21

1 Machines with kinematic transformation

1.1 Commissioning of the transformation

Phases of commissioning

The following phases must be run through when commissioning a kinematic transformation:

1. Identifying the kinematic structure (comparison with structures in [KITRA])
2. Determining kinematic offsets
3. Parameterising the kinematics
4. Verification (checking on the basis of machine axis movements)

1.2 General approach for machine commissioning

Basic steps

1. Unless already done: Commission the axis systems and mechanically align the machine's axes according to the machine structure. In particular, pay attention to the correct motion direction of the machine axes so that the machine behaves during conventional operation (2.5D) in the way the user is accustomed to. (e.g. X100 leads to position 100 in WCS).
2. Select a suitable kinematic transformation according to the kinematic structure of the machine [TRAFO].
3. Check whether the license for transformations is present.
4. In keeping with the description of the kinematic structure (5-axis arrangement X, Y, Z, C, A), the continuous axis configuration of the machine must be created via the channel-specific list.
5. Measure the kinematic offsets and enter them into the assigned transformation parameters (channel parameter list).
6. Define default kinematics (channel parameter list).
7. After RPF→ selection of the kinematic transformation and programming of the orientation (e.g. rotatory axes A30, B45), the tool tip position must remain fixed in space.

1.2.1 Activating transformation

Possibilities of selection

After referencing of the machine (if necessary), the required transformation can be selected and cancelled via the NC program as follows.



Programming Example

Example 1

```
N10 #TRAFO ON  
N20 X100 Y100 A0  
N30 Z10 C0  
N40 #TRAFO OFF
```

If different kinematics are possible for a machine (e.g. tool heads that can be changed in), the kinematic can be selected via the tool selection or can be explicitly programmed in the NC program. In the case of selection via the tool (e.g. D1 T1), the tool must be assigned a kinematics ID != 0 in the tool list.



Programming Example

Example 2

```
N05 #KIN_ID[5]  
N10 #TRAFO ON  
N20 X100 Y100 A0  
N30 Z10 C0  
N40 #TRAFO OFF
```



Programming Example

Example 3:

```
N05 D1 T1  
N10 #TRAFO ON  
N20 X100 Y100 A0  
N30 Z10 C0  
N40 #TRAFO OFF
```

1.2.2 Implicit selection/cancelation of kinematic transformation

Configuring implicit selection/deselection

For some machine types, it makes sense to only program movement in the WCS. Programmed selection/deselection within the NC program can be dropped by means of implicit selection/deselection in the CNC controller. Automatic selection/deselection is achieved via the following channel-specific parameter list entries:

```
auto_enable_kin_trafo    1      ( automatic selection
auto_disable_kin_trafo   0      ( automatic deselection
```

1.2.3 Parameterising the kinematics via the NC program

Change kinematics offsets in the NC program

When transformation is inactive, all kinematics offsets can also be influenced via the NC program. For safety reasons, however, this should be left to well-versed users.



Programming Example

Example 4:

```
N05 #KIN_ID[12]
N10 V.G.KIN[12].PARAM[0]= 500000 (* WZ offset *)
N10 #TRAFO ON
N20 X100 Y100
N30 Z20
N40 #TRAFO OFF
```

1.2.4 Checking the settings in the case of five-axis kinematics

1.2.4.1 Zero setting the rotatory B axis in the tool

1. Clamp long centre point (125mm) into spindle.
2. Allow dial gauge (90 increments offset by z) to touch the tool close to the clamping-in point.
3. Move machine up in positive Z position. When the tool stands straight, there must be no noteworthy deviation recognizable on the dial gauge (a 0.1 degree angular error produces a 0.1745 mm position error in the case of a 100 mm tool length).

1.2.4.2 Setting the zero position of the rotatory C axis in the tool

1. Axis A or B in 90 degrees position.
2. Position dial gauge on tool as mentioned in 1.2.4.1.
3. Depending on the axis, move in the case of B -> Y axis or A ->X axis and check deviations on the dial gauge.

1.2.4.3 Zero setting the rotatory C axis in the workpiece

1. Clamp in a cuboid workpiece with parallel side faces
2. Secure a dial gauge on the tool carrier and lean it against the side face of the workpiece.
3. Move the machine in the X or Y direction and check the deviation on the dial gauge.

2 Examples for machine kinematics

2.1 Transformation for 5-axis machine with rotary table

2.1.1 Kinematic structure

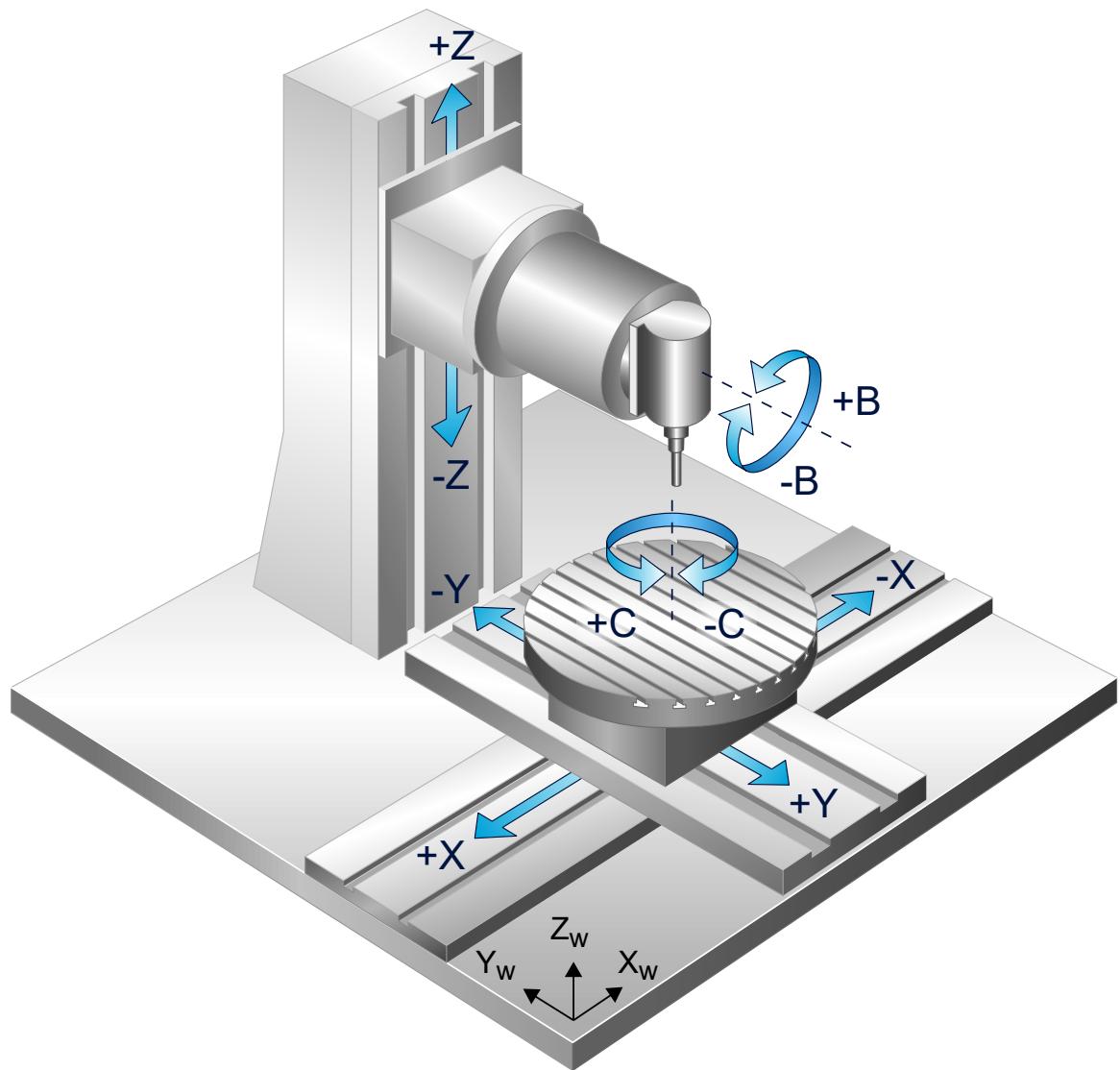


Fig. 1: Kinematic structure of the single-column bed machine

Machine type: 5-axis machine (5 axes + spindle)

Axis identifiers as per the machine labelling

Axes in the tool: Z, B, (spindle S)

Axes in the workpiece X, Y, C

Axis configuration in the sda_mds.lis: X, Y, Z, B, C

2.1.2 Aligning the axis systems

- Clamp centre point into spindle chuck.
- B axis zero point: Use a protractor or a try-square to align the rotatory axis B in the tool so that the centre point is oriented perpendicular to the turntable face of C.
- Zero point of X and Y axes: Position X and Y so that the centre point (clamped into the spindle) is flush with the rotary axis of C.
- Z axis zero point: The zero point of the Z axis cannot be approached. This transpires whenever the rotary axis of the B axis lies on the C axis. Place the centre point on the turntable via positioning of Z. Determine the offset from the turntable surface C up to the centre or the B axis. Subtract this offset from the current position → results in the zero position in the current coordinate system.
- C axis zero point: This can be selected freely depending on the later turntable support with workpiece fastening (see turntable coordinate system). The easiest thing is to position fastening holes in the C axis to a flush position with the direction of the X or Y machine axes.
- Figure 2 shows the resulting positive motion direction of the translatory machine axes and the rotation direction of the rotatory machine axes. Note that the machine can also be moved correctly in the conventional 2.5 D mode. For example, the turntable with the workpiece moves to the left when X100 is programmed!

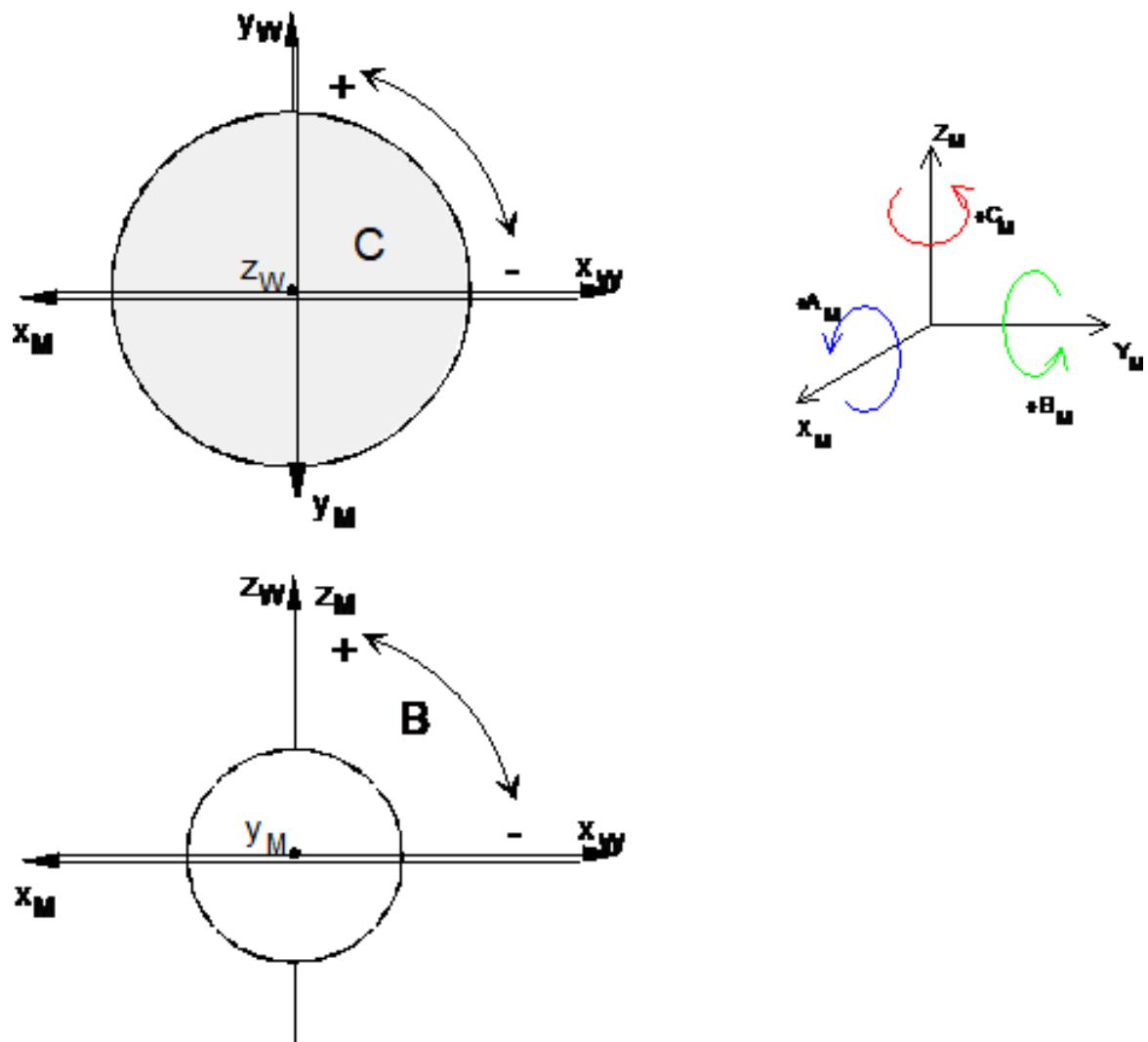


Fig. 2: Coordinate systems and motion directions

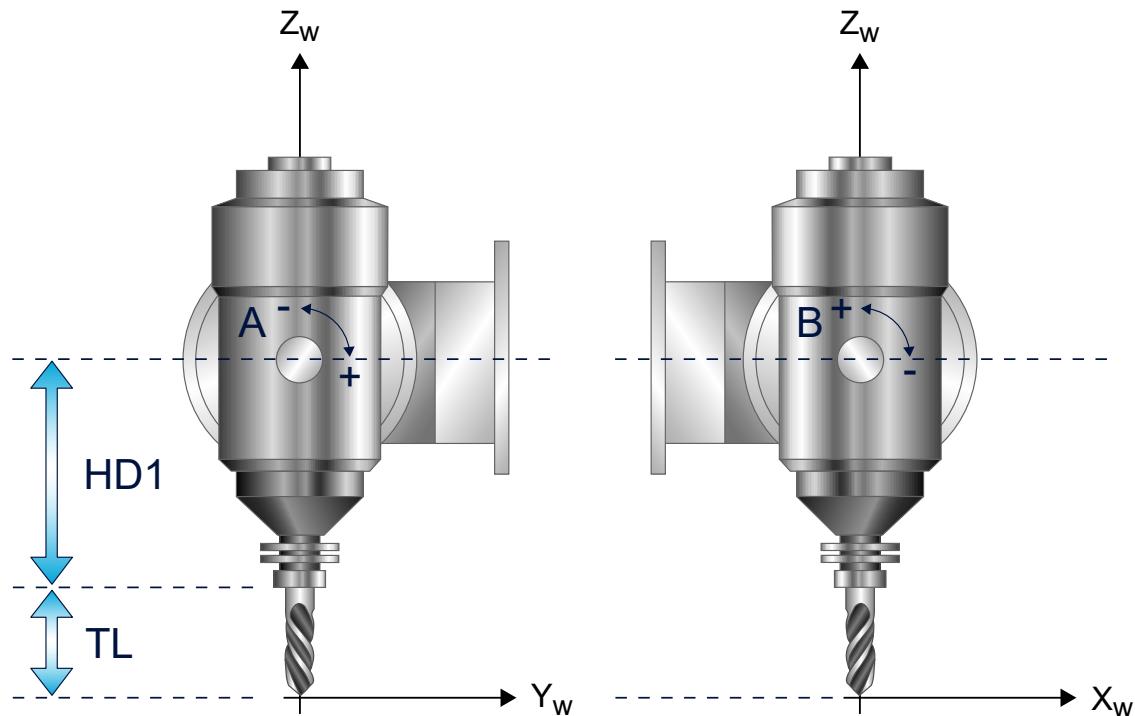


Fig. 3: Kinematic offsets

Kinematic ID		
1		
Offset parameters	List parameters	Meaning
HD1	kinematik[1].param[0]	z axis offset zero point until rotation point B axis

Axis configuration and kinematic offsets

Excerpt from the channel parameter list:

```
# Define axis configuration
# =====

gruppe[0].achse[0].log_achs_nr 1
gruppe[0].achse[0].bezeichnung X
#
gruppe[0].achse[1].log_achs_nr 2
gruppe[0].achse[1].bezeichnung Y
#
gruppe[0].achse[2].log_achs_nr 3
gruppe[0].achse[2].bezeichnung Z
#
gruppe[0].achse[3].log_achs_nr 4
gruppe[0].achse[3].bezeichnung B
#
gruppe[0].achse[4].log_achs_nr 5
gruppe[0].achse[4].bezeichnung C
```

```
#  
  
# Define kinematic parameters  
# =====  
kinematik_id      1      ( Define the default ID  
  
# Offsets in 0.1 µm  
trafo[0].id        1      ( Type 1 for 5-axis kinematic P-CHAN-00262  
trafo[0].param[0]  1450000 (Tool clamping point offset up to rotation  
point B axis  
trafo[0].param[1]  0  
trafo[0].param[2]  0  
trafo[0].param[3]  0  
trafo[0].param[4]  0  
trafo[0].param[5]  0  
trafo[0].param[6]  0  
...  
...
```

**Notice**

It is essential to specify the value of P-CHAN-00262.

If this parameter is not set, when the transformation is selected with #TRAFO ON, error ID 21630 is output.

2.2 Transformation for Tripod strut kinematic with fixed strut length

2.2.1 Kinematic structure

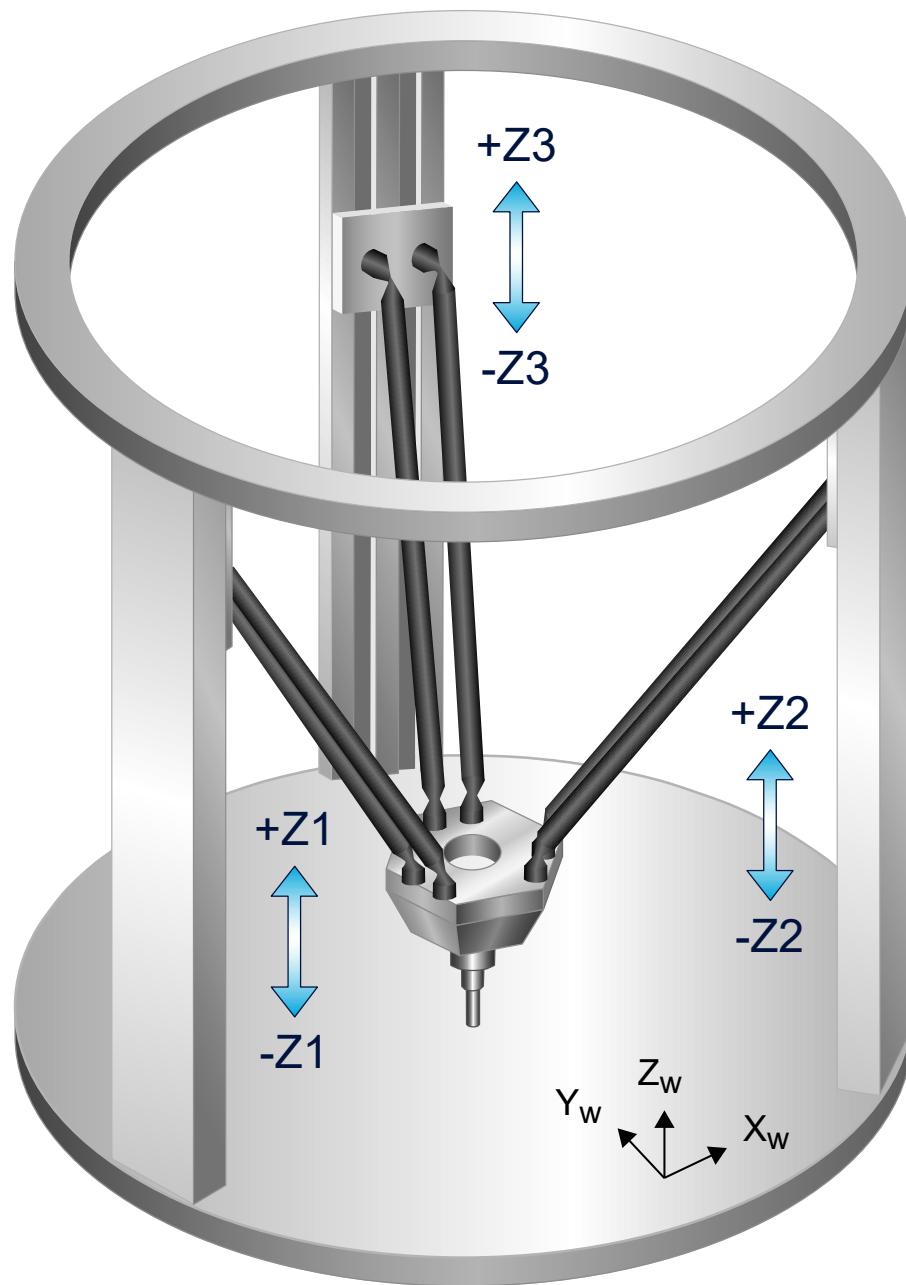


Fig. 4: Tripod kinematics

Machine type: 3-axis machine (3 axes + spindle)

Axis identifiers as per the machine labelling

Axes in the tool: Z1, Z2, Z3,(Spindle B)

Axes in the workpiece -

Axis configuration in the sda_mds.lis: X, Y, Z

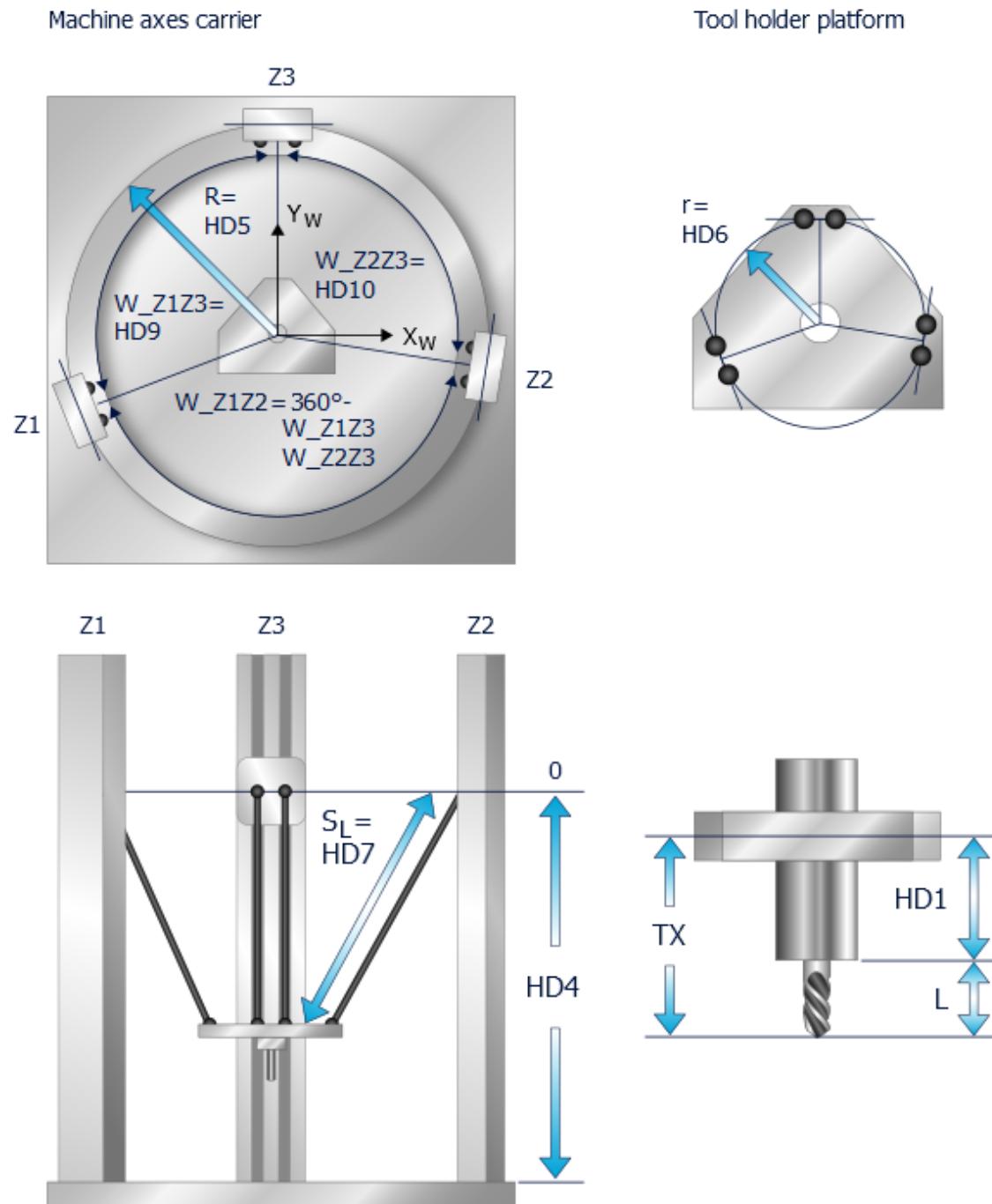


Fig. 5: Offset dimensions of strut kinematics

Kinematic ID	Axis sequence	
12	X, Y, Z (Z1, Z2, Z3)	
Parameter		
Offset	list	Meaning
HD1	trafo[1].param[0]	Tool offset Z
HD2	trafo[1].param[1]	Tool offset X
HD3	trafo[1].param[2]	Tool offset Y
HD4	trafo[1].param[3]	Z offset machine axis zero origin.
HD5	trafo[1].param[4]	Radius to connecting line of the joint centre points on the drive columns (large circle)
HD6	trafo[1].param[5]	Radius to connecting line of the joint centre points on the holder platform (small circle)
HD7	trafo[1].param[6]	Strut length to each joint centre point
HD8	trafo[1].param[7]	Switch for switching to non-ideal tripod (enable HD9 / HD 10)
HD9	trafo[1].param[8]	Angle column / joint 3 to column / joint 1
HD10	trafo[1].param[9]	Angle column / joint 3 to column / joint 2

Axis configuration and kinematic offsets

Excerpt from the channel parameter list:

```

# Define axis configuration
# =====
gruppe[0].achse[0].log_achs_nr 1
gruppe[0].achse[0].bezeichnung x
#
gruppe[0].achse[1].log_achs_nr 2
gruppe[0].achse[1].bezeichnung y
#
gruppe[0].achse[2].log_achs_nr 3
gruppe[0].achse[2].bezeichnung z
#
# Define kinematic parameters
# =====
# Offsets in 0.1 µm
#
# Parameterising the tripod
trafo[1].id      12 ( Tripod P-CHAN-00262
trafo[1].param[0] 500000
trafo[1].param[1] 0
trafo[1].param[2] 0
trafo[1].param[3] 9100000
trafo[1].param[4] 4585000
trafo[1].param[5] 725900
trafo[1].param[6] 7020000

```

**Notice**

It is essential to specify the value of P-CHAN-00262.

If this parameter is not set, when the transformation is selected with #TRAFO ON, error ID 21630 is output.

2.3 Transformation for articulated robot

List parameters	Meaning
trafo[1].id	Defining the ID for this kinematic

```
trafo[1].id 45 ( Define the kinematic type 45 P-CHAN-00262
#
# If only the ID is specified, the type of the transformation P-
CHAN-00829 is automatically assigned the value of the ID
```

or

```
trafo[1].id 4711
trafo[1].type 45
```

In this variant, the NC command (#KIN ID[4711] or the default setting must be used to assign this ID (P-CHAN-00032).

Advantage of this variant:

Multiple identical kinematic types can be created in one configuration file.

**Notice**

It is essential to specify the value of P-CHAN-00262.

If this parameter is not set, when the transformation is selected with #TRAFO ON, error ID 21630 is output.

2.3.1 Kinematic structure, Axis configuration

Kinematic ID	45
--------------	----

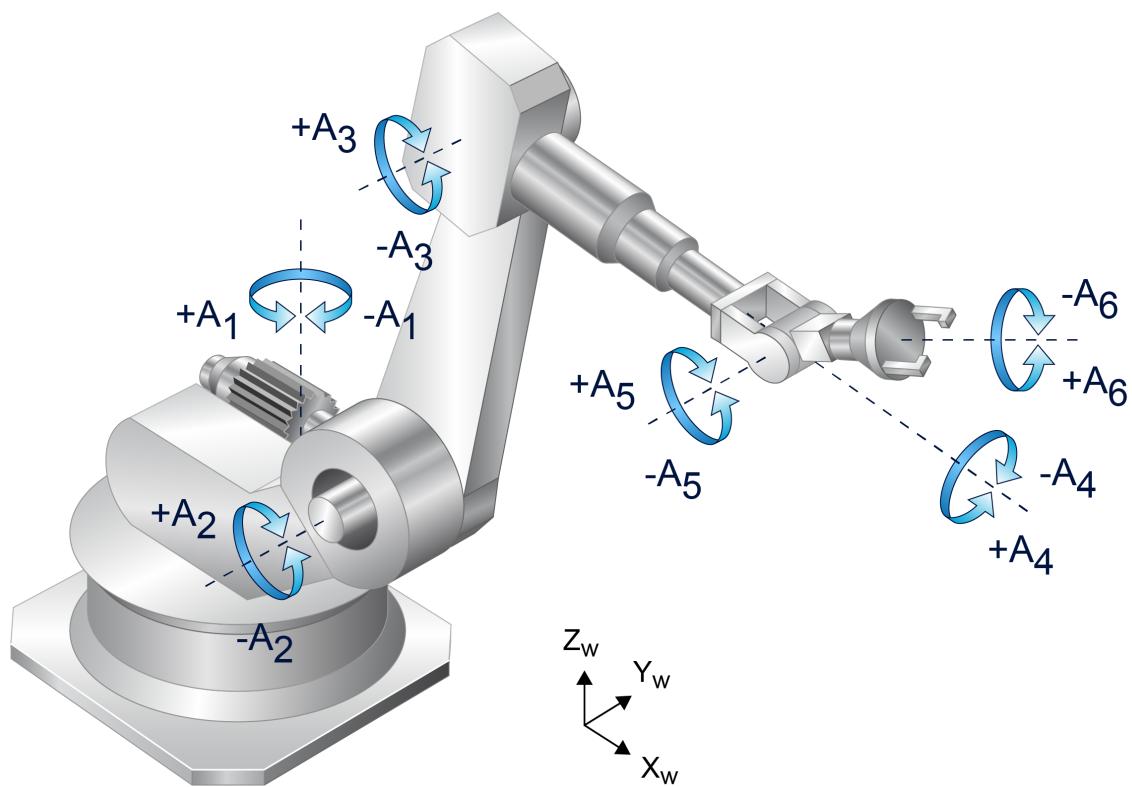


Fig. 6: Axis configuration of the kinematic

Axis configuration in the NC channel		
Axis identifier	X, Y, Z, A, B, C (G1, G2, G3, G4, G5, G6)	
Axis index	0, 1, 2, 3, 4.5	
Kinematic structure		
	Tool axes	Workpiece axes
NC axes	X, Y, Z, A, B, C	-

Peculiarities

The articulated axes are numbered consecutively from 1 to 6 (starting with the first axis which rotates about the z axis of the Cartesian space coordinate system). The robot is in the zero position of the articulated axes.

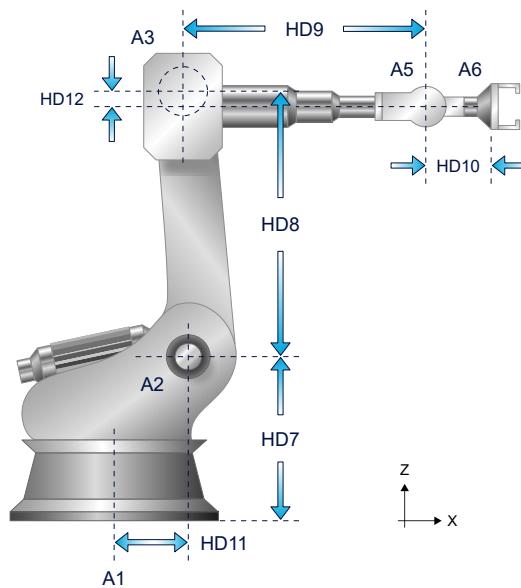
Establish a continuous axis configuration with 6 axes X, Y, Z, A, B, C. corresponding to the axis sequence specified. Establish the correct mathematically positive rotation direction of the articulated axes according to the space coordinate system.

All articulated axes of the robot except for the hand axes A4 and A6 are linear axes. The axes G4 and G6 are modulo axes with ranges of 0 to 180, 0 to -180 degrees. If no trailing cables have to be taken into account, articulated axis G1 can also be set as a modulo axis.

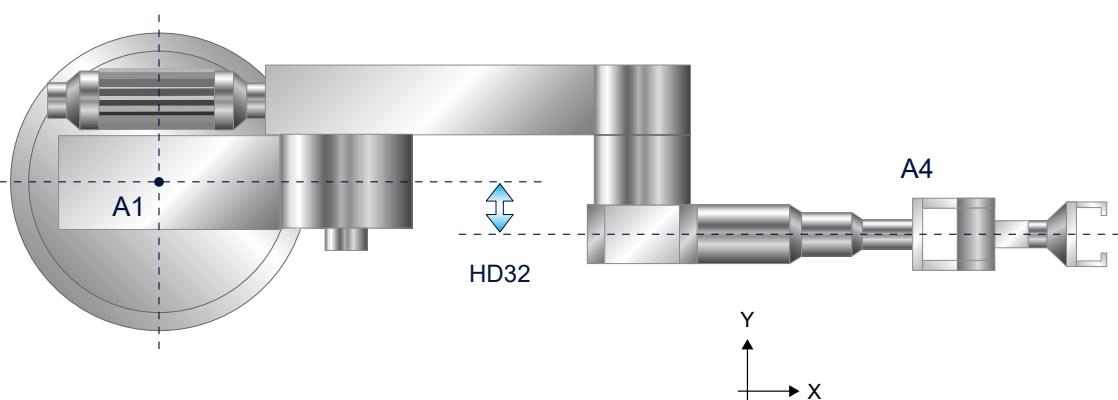
Check whether the hand axes G4 to G6 are coupled mechanically via gearing. If this is the case, electronic gear compensation is necessary in the CNC!

2.3.2

Translatory kinematic offsets



List parameters	Meaning
trafo[1].param[10]	X offset of origin of Cartesian space KS to rotation point articulated axis 2
trafo[1].param[6]	Z offset of origin of Cartesian space KS to rotation point articulated axis 2
trafo[1].param[31]	Y offset between rotary axis 4 and rotary axis 1
trafo[1].param[7]	Z offset from rotary axis joint 2 to rotary axis joint 3
trafo[1].param[11]	Z offset from rotary axis joint 3 to rotary axis joint 5
trafo[1].param[8]	X offset from rotary axis joint 3 to rotary axis joint 5
trafo[1].param[9]	X offset from manual axis joint 5 to flange surface on joint 6



2.3.3 Rotary kinematic offsets

2.3.3.1 Angle offset

These are required to match the zero position of the internal robot model in the kinematic transformation to the physical zero position of the actual robot. In the examples given below, the articulated axis positions are 0 in each case.

List parameters	Meaning
trafo[1].param[13]	Rotary offset for zero position of robot joint axis 2
trafo[1].param[14]	Rotary offset for zero position of robot joint axis 3

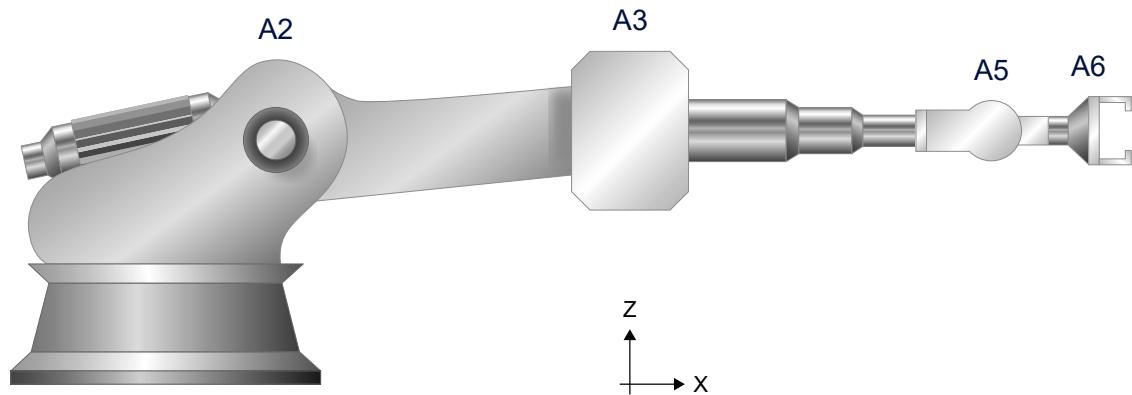


Fig. 7: Example for param[13]=0 degrees, param[14]=0 degrees

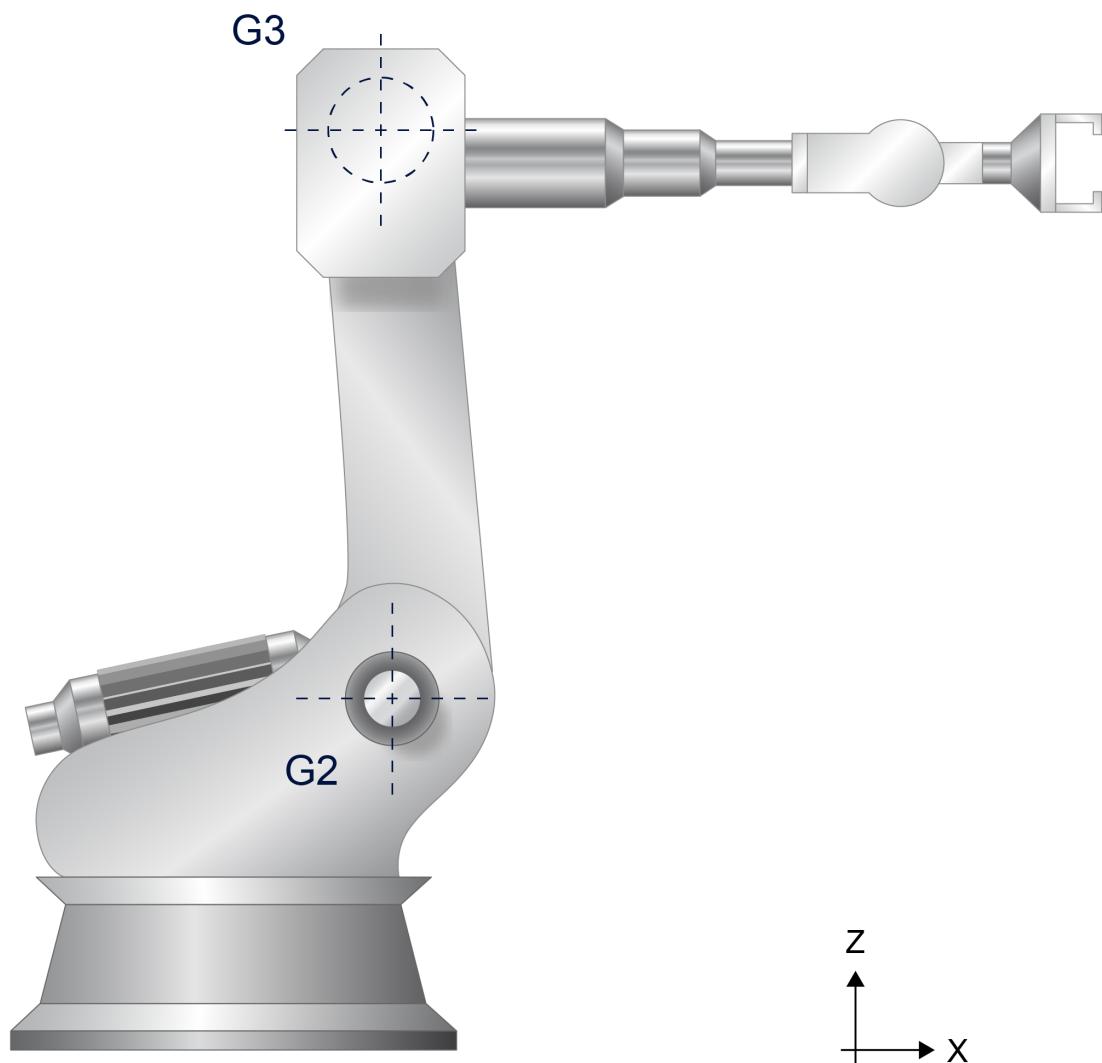


Fig. 8: Example for param[13]=-90 degrees, param[14]=90 degrees

2.3.3.2 Direction of rotation

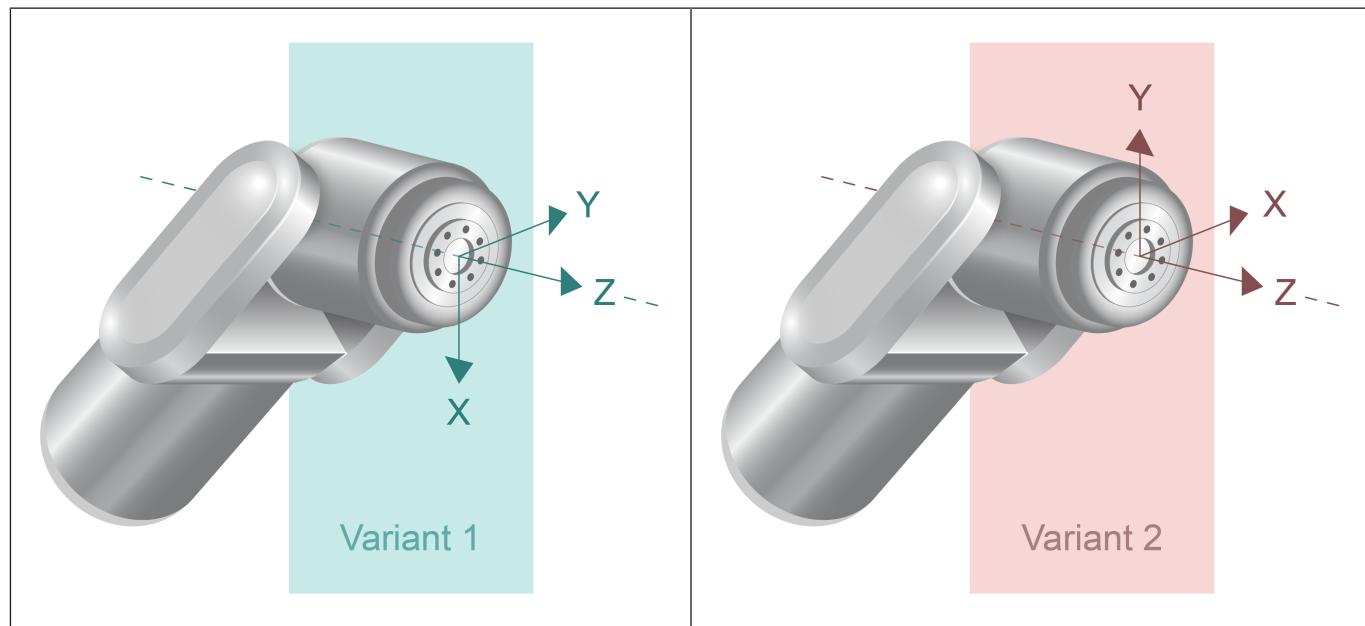
These were used for matching the rotation directions of the internal robot model in the kinematic transformation to the physical rotation directions of the actual robot. In default position, all the articulated axes in zero position of the robot rotate about the Cartesian Y axis in a mathematically positive direction.

List parameters	Meaning
trafo[1].param[20]	Rotation direction of C axis 1, 0: positive, 1: negative
trafo[1].param[21]	Rotation direction of C axis 2, 0: positive, 1: negative
trafo[1].param[22]	Rotation direction of C axis 3, 0: positive, 1: negative
trafo[1].param[23]	Rotation direction of C axis 4, 0: positive, 1: negative
trafo[1].param[24]	Rotation direction of C axis 5, 0: positive, 1: negative
trafo[1].param[25]	Rotation direction of C axis 6, 0: positive, 1: negative

2.3.3.3 Flange coordinate system

For compatibility reasons, the orientation of the flange coordinate system can be changed back from variant 1 (standard) to variant 2.

List parameters	Meaning
kinematik[45].param[30]	0: Variant 1, default (KUKA, Stäubli) 1: Variant 2



2.3.4 Tool offsets

The following parameters are available for a tool flanged to robot axis 6.

List parameters	Meaning
trafo[1].param[0]	Tool offset in Z direction of effector
trafo[1].param[1]	Tool offset in X direction of effector
trafo[1].param[2]	Tool offset in Y direction of effector
trafo[1].param[3]	Tool rotation about the X'' axis
trafo[1].param[4]	Tool rotation about the Y' axis
trafo[1].param[5]	Tool rotation about the Z axis

2.3.5 Sample parameterisation for a KUKA KR210

2.3.5.1 Axis configuration

```
gruppe[0].bezeichnung IPO_1
```

```
gruppe[0].achs_anzahl 6
gruppe[0].achse[0].log_achs_nr 1
gruppe[0].achse[0].bezeichnung X
gruppe[0].achse[1].log_achs_nr 2
gruppe[0].achse[1].bezeichnung Y
gruppe[0].achse[2].log_achs_nr 3
gruppe[0].achse[2].bezeichnung Z
gruppe[0].achse[3].log_achs_nr 4
gruppe[0].achse[3].bezeichnung A
gruppe[0].achse[4].log_achs_nr 5
gruppe[0].achse[4].bezeichnung B
gruppe[0].achse[5].log_achs_nr 6
gruppe[0].achse[5].bezeichnung C
```

2.3.5.2

Kinematics offsets

```
# Robot: 6-axis articulated robot based on the example of KR210 R2700-2
# -----
# Offset from G3 to rotation sym. axis in beam arm -115 mm
# X offset from the origin to the rotation point G2 330 mm
# Z offset from the origin to the rotation point G2 645 mm
# Top arm length 2 1150 mm
# Bottom arm length G3 to G5 1120 mm
# Distance G5 to G6 215 mm
#
trafo[1].id      45          ( Kinematic ID P-CHAN-00262
trafo[1].param[0] 500000    ( Effector offset: Z
trafo[1].param[1] 2500000   ( X
trafo[1].param[2] 0           ( Y
trafo[1].param[3] 0           ( Effector rotation: X ''
trafo[1].param[4] 900000    (Y'
trafo[1].param[5] 0           (Z
trafo[1].param[6] 6450000   (Z offset from G1 to G2
trafo[1].param[7] 11500000  (Z offset from G2 to G3
trafo[1].param[8] 12200000  (X offset from G3 to G5
trafo[1].param[9] 2150000   (X offset from G5 to G6
trafo[1].param[10] 3300000  (X offset from G1 to G2
trafo[1].param[11] -1150000 (Z offset from G3 to G5

trafo[1].param[13] 0         (Angle offset zero position G2
trafo[1].param[14] 0         (Angle offset zero position G3

trafo[1].param[20] 1         (Rotation direction G1 negative
trafo[1].param[21] 0         (Rotation direction G2 negative
trafo[1].param[22] 0         (Rotation direction G3 negative
trafo[1].param[23] 1         (Rotation direction G4 negative
trafo[1].param[24] 0         (Rotation direction G5 negative
trafo[1].param[25] 1         (Rotation direction G6 negative

trafo[1].param[30] 0         (Old orient. of flange coordinate system
trafo[1].param[31] 0         (Y offset from G4 to G1
```

3 Appendix

3.1 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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