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Software Manual for the Coil Winding Arm Controller MKII Software.

Version 1.1

31st October 2020.

This documentation applies for use of the software on the following machines:

- CNC 200mm Coil Winder MK4 fitted with ARM Controller MKII
- CNC 200mm Coil Winder MK5 fitted with ARM Controller MKII
- Mini Coil Winder MK4 fitted with ARM Controller MKII
- Quad Winder MK1 fitted with ARM Controller MKII
- Custom Coil Winders fitted with ARM Controller MKII

<http://www.ukcnc.net>

Running more than one machine

This feature has been Implemented in **CNC ARM Controller MKII Software Version 2.4 and above.**

Over the years we have been asked if it is possible to run more than one Coil Winding Machine on a single computer.

The answer has always been NO, but after a bit of playing around we have released a new Test version for anyone that has more than one machine and would like to try.

As stated this is a TEST and we do not guarantee performance like you would get with a dedicated computer for each machine.

The Coil Winding Machines we supply all have the same USB VID/PID identification and this will need to be changed on the extra machines that you want to run. This can be done by programming up a different version of the firmware for each machine and also installing a version of the software that will launch multiple sessions.

Here is a list showing which machine should have which firmware programmed into it.

Machine 1

ARM-CW-Firmware-MKII-2-0-M1.hex

Machine 2

ARM-CW-Firmware-MKII-2-0-M2.hex

Machine 3

ARM-CW-Firmware-MKII-2-0-M3.hex

You will need to use the JTAG programmer that was supplied with the machine to update your Coil Winding machines and the instructions can be download below

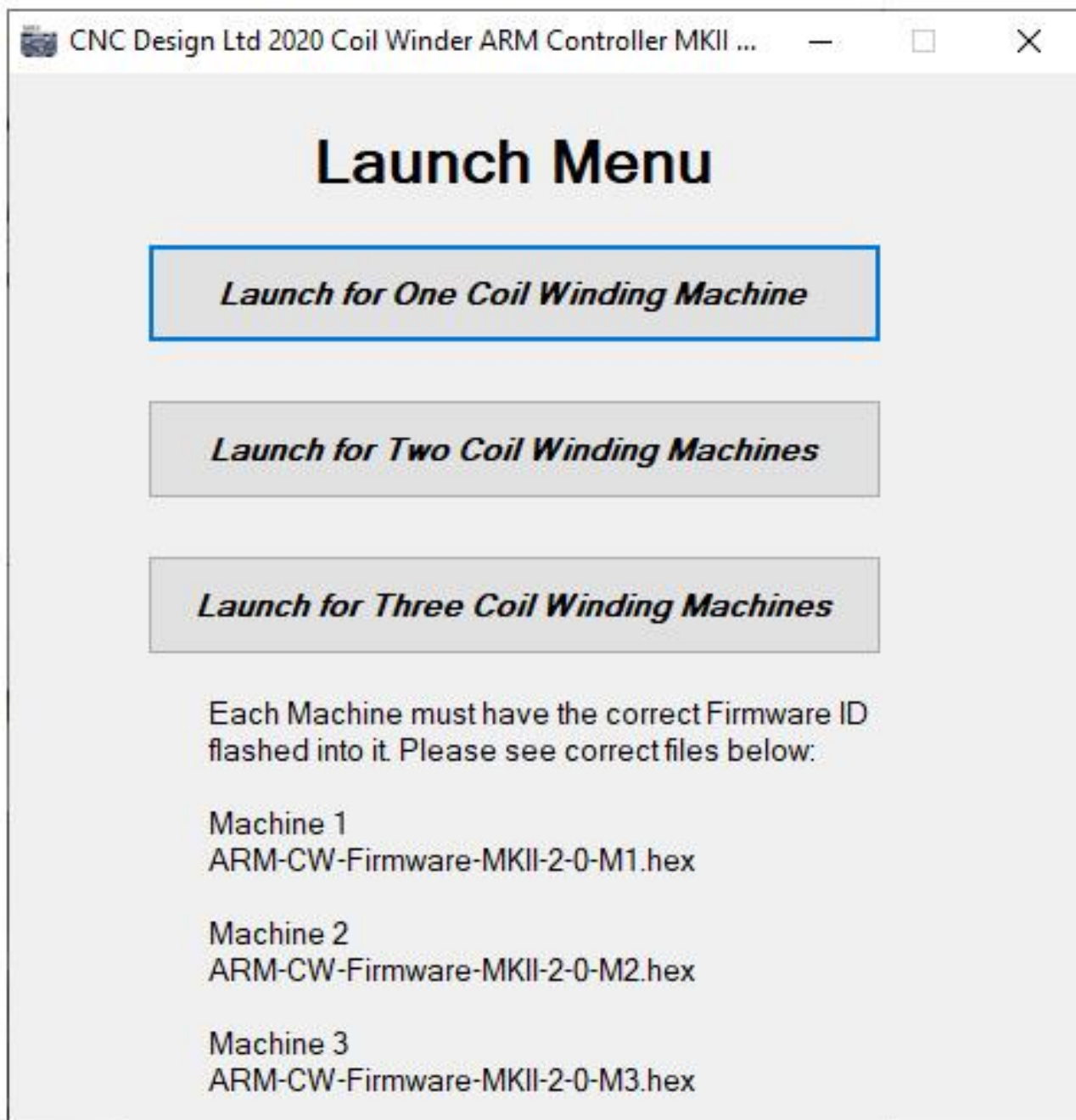
Mini Coil Winder instructions:

<http://www.ukcnc.net/CNC-mini-coil-winder-upgrade-firmwareV1-0.pdf>

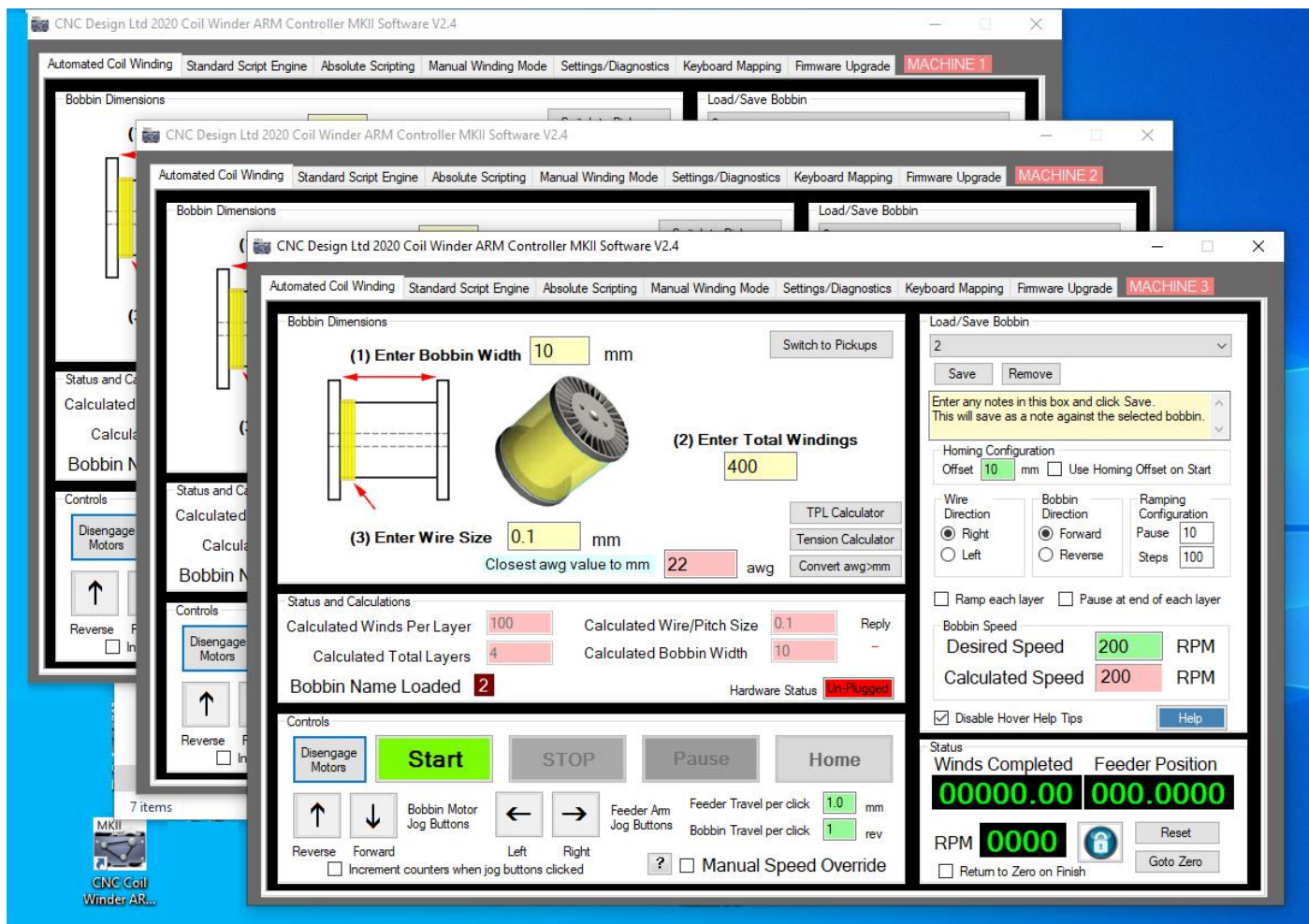
200mm Coil Winder instructions:

<http://www.ukcnc.net/CNC-200mm-coil-winder-upgrade-firmwareV1-0.pdf>

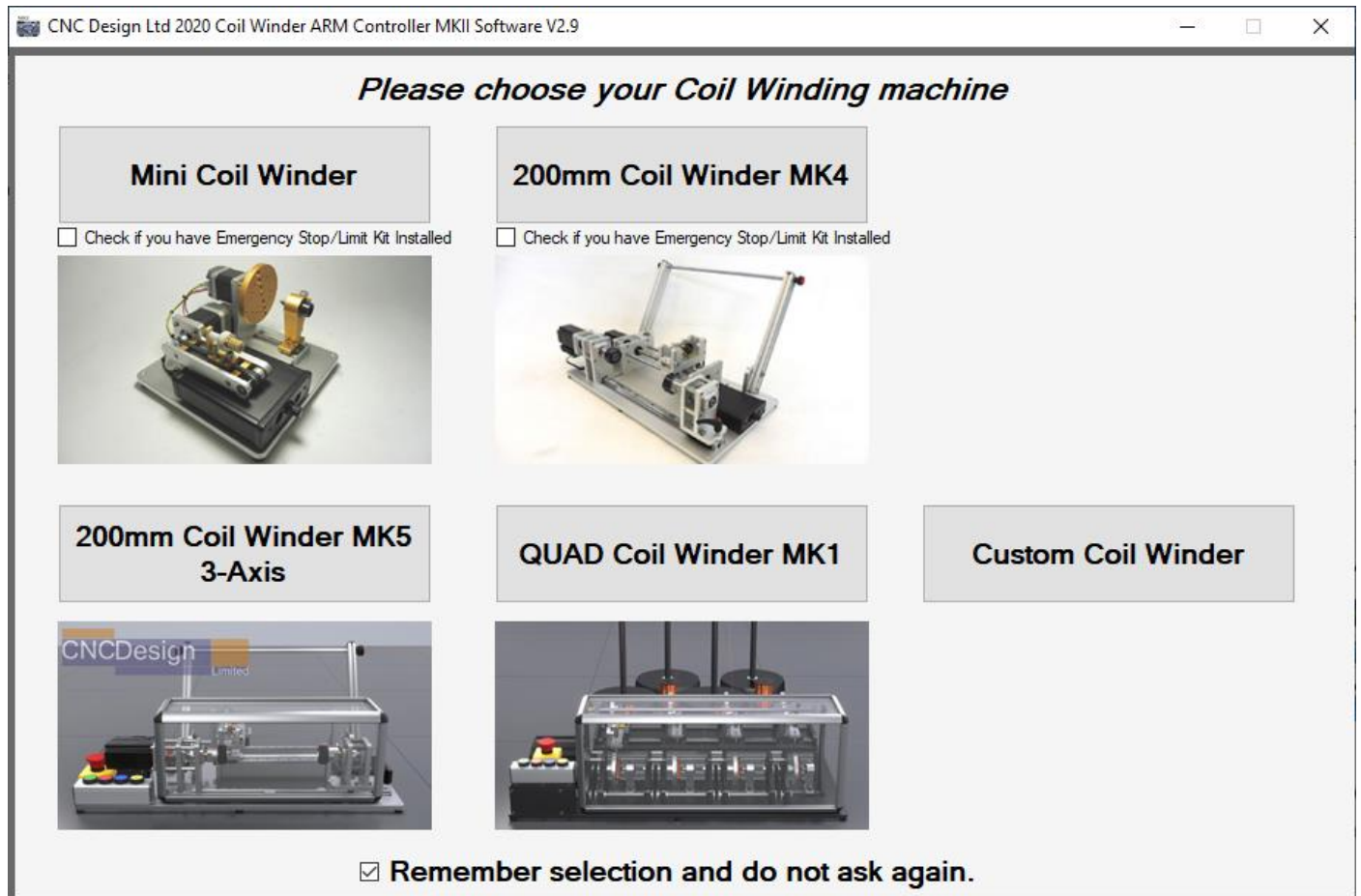
When the software is first launched it will come up with the menu below:



So if we chose to launch three machines then it would launch 3 instances of the software and show on each screen which machine it is connected to.



Another change we have made is to disable the auto detect of the machine when it is first plugged in and now you will be presented with another menu asking what machine you are using:



If you have fitted a limit switch on the Mini Coil Winder or the 200mm Coil Winder MK4 then you can tick the checkbox for this option, rather than using the Custom Coil Winder configuration.

If you select the Remember selection checkbox then this menu will not be shown again on startup, but can be accessed within the software under the Settings/Diagnostics tab.

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Automated Coil Winding - Tab.

This tab shows a simple wizard which only needs a few basic settings to be made and you will be up and winding your coil in the quickest time.

CNC Design Ltd 2020 Coil Winder ARM Controller MKII Software V3.0

Automated Coil Winding | Standard Script Engine | Absolute Scripting | Manual Winding Mode | Settings/Diagnostics | Keyboard Mapping | MACHINE 1

Bobbin Dimensions

(1) Enter Bobbin Width mm

(2) Enter Total Windings

(3) Enter Wire Size mm

Closest awg value to mm awg

Switch to Pickups

TPL Calculator

Tension Calculator

Convert awg>mm

Status and Calculations

Calculated Winds Per Layer Calculated Wire/Pitch Size Reply

Calculated Total Layers Calculated Bobbin Width -

Bobbin Name Loaded Hardware Status

Controls

Disengage Motors

Start STOP Pause Home Feeder

Bobbin Motor Jog Feeder Arm Jog Wire Guide Jog Feeder Homing Offset mm

Reverse Forward Left Right Back Forward Home Wire Guide

Travel per click revolutions Travel per click millimeters Travel per click millimeters Guide Homing Offset mm

Load/Save Bobbin

Load/Save Bobbin

Save Remove

Enter any notes in this box and click Save. This will save as a note against the selected bobbin.

Wire Direction: ☒ Right ☐ Left

Bobbin Direction: ☒ Forward ☐ Reverse

Ramping Configuration: Pause Steps

☐ Ramp each layer ☐ Pause at end of each layer

☐ Return to Zero on Finish ☐ Manual Speed ?

Bobbin Speed: Desired Speed RPM Calculated Speed RPM

☒ Disable Hover Help Tips Help

Status

Winds Completed Feeder Position

RPM Guide Position

Goto Zero Reset

☐ Move Wire Guide Back Each Layer

☒ Increment counters when jog buttons clicked

For a quick start you only have to set four parameters in the **Automated Coil Winding** tab to wind a coil.

Set the **Bobbin Width**, Set the **Total Windings**, Set the **Wire Size** and Set the **Desired Speed**. Then simply click the Start Button.

The software will then Wind the coil back and forth until the coil is complete.

Below we will go through each option panel and detail what they are.

Bobbin Dimensions

(1) Enter Bobbin Width mm

(2) Enter Total Windings

(3) Enter Wire Size mm

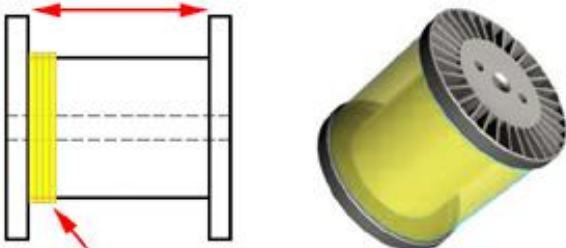
Closest awg value to mm awg

Switch to Pickups

TPL Calculator

Tension Calculator

Convert awg>mm



The **Convert awg>mm** will take the value entered in the box and convert from awg to millimetres. This is a handy tool for people used to dealing with awg wire sizes.

In the example above it has converted 22awg, which calculates to be 0.6438mm.

The **Switch to Pickups** button changes the screen from normal bobbins to the Guitar Pickup screen. This will be covered later on in the manual.

The **TPL Calculator** button will bring up a calculator panel on the screen. This will be covered later on in the manual.

The **Tension Calculator** button will bring up a calculator panel on the screen. This will be covered later on in the manual.

Next, with three simple steps you can setup the software to wind your desired coil.

- 1.) **Enter the width of your bobbin** is the actual length of the bobbin you wish to wind wire across.
- 2.) **Enter Total Windings** for the coil you wish to make.
- 3.) **Enter the wire Size** you wish to wind but also allow for the coating. Typically, this can be 10%-15% of the size of the wire.

After you have set these parameters, then the software will auto calculate the nearest settings that are suitable for the machine you have connected and will display them in the **Status and Calculations** panel.

Status and Calculations			
Calculated Winds Per Layer	16	Calculated Wire/Pitch Size	0.645
Calculated Total Layers	31.25	Calculated Bobbin Width	10.32
Bobbin Name Loaded	1	Hardware Status	Un-Plugged

Based on the parameters entered in the **Bobbin Dimensions** panel, the actual working values that get sent to the Coil Winding Machine are displayed in the **Status and Calculations** panel. These calculations take into consideration the machine that is connected to your computer and also the resolution settings applied.

In the example above, it has taken the parameters and calculated that the 16 winds will be wound each layer and based on the width of wire, this would make the actual winding area of wire cover 10.32mm and not the 10mm specified.

On the back of these calculations, it has also calculated that 31.25 layers will be wound onto the bobbin. This is 16 winds to the right for the first layer and then 16 winds to the left for the second layer and so on until the total windings are complete.

Now if your bobbin width is 10mm maximum then you will need to reduce the bobbin size to reduce the windings per layer. The simple fact is that 10mm will not divide by the width of your wire $10\text{mm}/0.6438=15.53$ unless you are going to chop your wire in half at the end of each layer, which is not possible!

In the screenshot below, you can see by reducing the Bobbin Width to 9.99mm it has reduced the layers to 15 and also the bobbin width to 9.675mm. Not ideal as you may get spacing created between each winding, which leads to uneven windings as your layers build up.

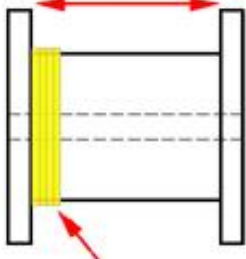
The ideal bobbin would be the correct width to allow the exact number of windings you require using the wire you need to use. But this is not always possible.

Bobbin Dimensions

(1) Enter Bobbin Width

9.99

mm



(2) Enter Total Windings

500

(3) Enter Wire Size

0.6438

mm

Closest awg value to mm

22

awg

Switch to Pickups

TPL Calculator

Tension Calculator

Convert awg>mm

Status and Calculations

Calculated Winds Per Layer

15

Calculated Wire/Pitch Size

0.645

Reply

Calculated Total Layers

33.33333

Calculated Bobbin Width

9.675

Bobbin Name Loaded

1

Hardware Status

Un-Plugged

We also have some status display objects in this panel.

Reply is the answer coming back from the Coil Winding Machine after each command is sent.

Hardware Status shows if the Coil Winding Machine is connected or not connected to the computer.

Bobbin Name Loaded is the name of the bobbin that has been chosen from the drop-down box in the Load/Save Bobbin panel below.

As you can see all of the objects in this panel are for information purposes only and cannot be set by the person using the software.

Load/Save Bobbin

1

Save Remove

Enter any notes in this box and click Save.
This will save as a note against the selected bobbin.

Wire Direction
☒ Right
☐ Left

Bobbin Direction
☒ Forward
☐ Reverse

Ramping Configuration
 Pause 10
 Steps 100

☐ Ramp each layer ☐ Pause at end of each layer
☐ Return to Zero on Finish ☐ Manual Speed ?

Bobbin Speed
 Desired Speed 200 RPM
 Calculated Speed 200 RPM

☒ Disable Hover Help Tips Help

The **Load/Save Bobbin** panel not only allows you to save and remove bobbin parameters, but also lets you set other parameters that will affect the coil you are winding. These settings, along with other settings from other panels get saved to the computer's registry, which can be backed up and reloaded in the future. This is usually due to either moving the software to a new machine and wanting to bring your saved bobbins across to it, or in case of a failure.

Starting from the top of the panel and working downwards we first have the drop-down box. This will allow you to choose previously saved bobbin configurations.

When clicking the **Save** button it will ask for a name that you wish to call the bobbin and save all the parameters set for that bobbin to the registry. If you wish to remove the saved bobbin from the registry, then click the **Remove** button and it will delete that bobbin.

The yellow box below the drop-down box is for any notes you wish to save against that bobbin. These notes will be saved along with other parameters and recalled when a bobbin is selected.

Wire Direction group box.

Sets the direction for the feeder arm when winding starts.

Bobbin Direction group box.

Sets the direction for the bobbin when winding starts.

Ramping Configuration group box.

We use stepper motors on our machines then to get them to higher speeds we need to ramp up the motor speed gradually.

You have two variables you can set to get the desired curve as such.

The Steps variable is the divider of the target frequency that we want the bobbin motor to run at. So, if the software calculated that the bobbin motor should run at 1000kHz and the steps box is set to 100 then we can see that the steps would be $1000/100 = 10$ Hz increments.

The Pause variable is the time between each increment.

Ramping each layer checkbox.

If this box is left unchecked then the machine will ramp up at the beginning of the winding routine and at the end only. When the feeder gets to the end of the layer it will simply change direction. If the box is checked then the bobbin motor and feeder motor will ramp up at the start of each layer and ramp down at the end of each layer.

Pause at the end each Layer checkbox.

Checking this box will pause the machine after each layer has been wound. This option can only be used if **Ramping each layer** is also checked.

Manual Speed Override checkbox.

If checked then when the **Start** button is clicked the software will pass control over to the manual speed controller on your controller box.

The manual controller dial needs to be fully turned to the left before it will start to wind and the speed of the bobbin motor and feeder arm will increase or decrease depending on the position of the dial.

Bobbin Speed group box.

Desired speed is the variable that will tell the machine what speed you want the bobbin motor to run at.

As the bobbin motor and feeder motor are interpolated, then most of the time the speed of the bobbin motor will be divided down to set the speed of the feeder arm motor to suit and keep that interpolation correct. But if you require the wire size or movement pitch to be a

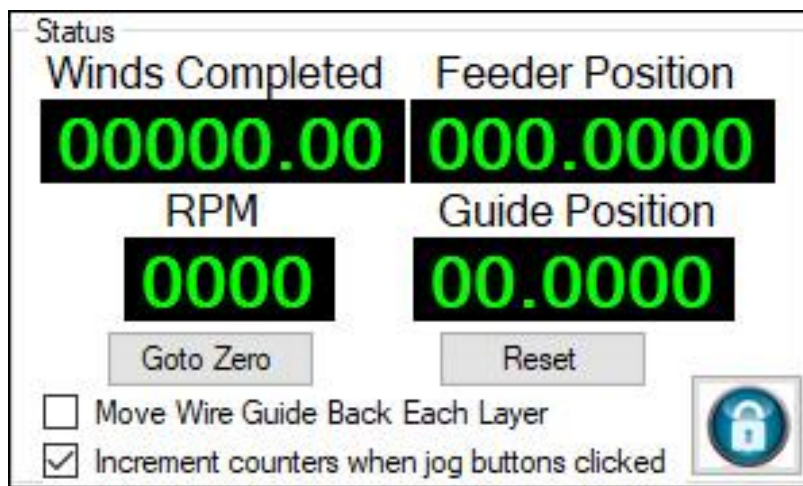
large number that requires the feeder arm motor to run faster than the bobbin motor, then the bobbin motor will automatically drop and the calculated speed will be displayed below.

Disable Hover Help Tips checkbox.

You can move the mouse over any object within the software and if left over that object for a certain amount of time a Hover Tip will appear giving you information on that object. By checking this box then it will stop these hover tips appearing.

Return to Zero checkbox.

If this is checked then when the machine has finished its winding routine the feeder arm will automatically move back to the zero position.



The **Status** panel has the following objects.

Padlock Icon

Clicking on this will ask you for a password and is used by the developers for diagnostics and troubleshooting if needed. You should never have to go into this area.

Winds Completed display.

Displays the amount of winding that have been wound.

Feeder Position display.

Displays the position of the feeder arm on the machine.

RPM display.

Displays the speed that the bobbin motor is running at.

Guide Position display.

Displays the position of the Wire Guide on 3-Axis the machines only.

Reset button.

Pressing this button will reset the feeder position to zero.

Goto Zero button.

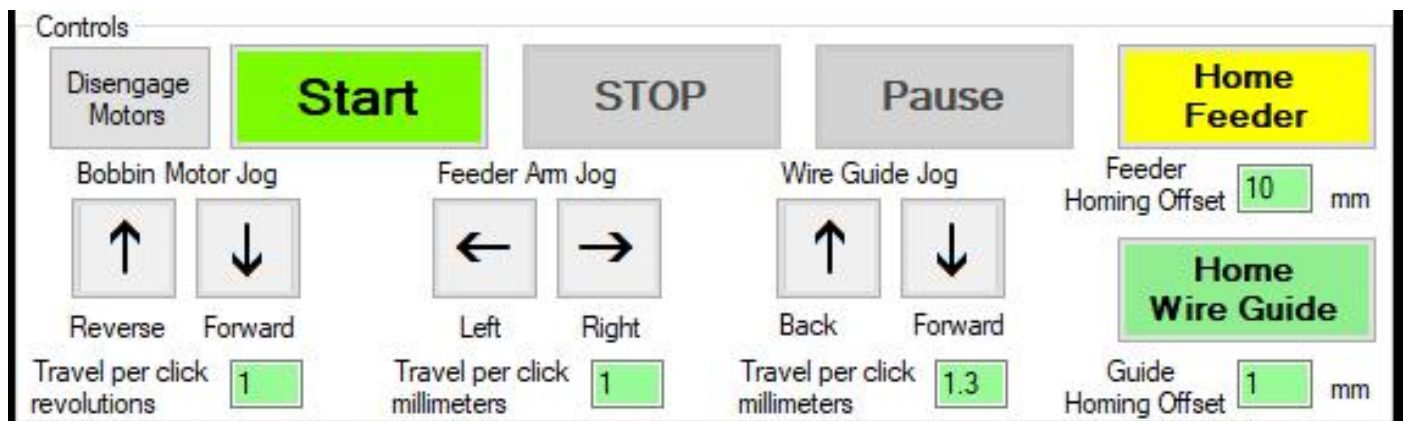
Pressing this button will tell the feeder arm to return to its zero position.

Move Wire Guide Back Each Layer checkbox.

For machines with a 3rd-Axis and when checked this will move the Wire Guide away from the bobbin each layer. The distance is the wire size and rounded up to suit the resolution of the Wire Guide motor.

Increment Counter When Jog Buttons Clicked Checkbox.

When checked this will update the counters when the jog buttons are clicked.



The **Controls** panel has the following objects.

Disengage Motors button.

When clicked this will disengage the motors so they can be turned by hand.

The motors will automatically re-engage when start or jog buttons are clicked.

You will not be able to disengage the motors when paused, but if you need to move the motors at this point, then simply turn the power off to the motors via the switch. Do the adjustments and then turn the power back on before pressing resume in the software.

Start button.

Clicking this button starts the winding routine.

Stop button.

Clicking this button stops the winding routine.

Pause/Resume button.

While winding is in progress and you wanted to pause the machine, then click this button. It will then turn to a flashing Resume status and clicking it again will allow the machine to carry on from where it was paused.

While paused you can cancel the winding routine by pressing the stop button.

Also while paused the Left and Right button can be used to jog the feeder arm to a new position. This will not increment the feeder position and can be used for adjustments needed without having to restart the whole winding routine from the beginning.

Home Feeder button.

This can only be used if there are limit/homing switches installed on the machine. Based on the variable set in the ***Feeder Homing Offset*** will determine the distance that the feeder arm will travel away from the limit switch once it has been triggered.

Feeder Homing Offset.

Sets the offset distance that the feeder arm will move away from the limit switch when the ***Home Feeder*** button is clicked.

For example, if it is set to 10mm then when the ***Home Feeder*** button is clicked the feeder arm will move to the left until it gets to the limit switch on the machine. It will then move to the right 10mm.

This option is only available for machines with the homing/limit switches installed.

Reverse button.

This is a manual jog for the bobbin motor and when clicked the bobbin motor will move in the reverse direction.

Forward button.

This is a manual jog for the bobbin motor and when clicked the bobbin motor will move in the forward direction.

Left button.

This is a manual jog for the feeder arm and when clicked the feeder arm will move to the left.

Right button.

This is a manual jog for the feeder arm and when clicked the feeder arm will move to the right.

Back button.

This is a manual jog for the Wire Guide and when clicked the wire guide will move to the Back. Only available on 3-Axis machines.

Forward button.

This is a manual jog for the Wire Guide and when clicked the wire guide will move to the Back. Only available on 3-Axis machines.

Feeder Travel per click variable.

Sets the travel in millimetres that the feeder arm will move if either the **Left** or **Right** buttons are clicked.

Bobbin Travel per click variable.

Sets the amount of revolutions that the bobbin motor will move if either the **Forward** or **Reverse** buttons are clicked.

Wire Guide Travel per click variable.

Sets the travel in millimetres that the wire guide will move if either the **Back** or **Forward** buttons are clicked. Only available on 3-Axis machines.

Home Wire Guide button.

This can only be used if there is a 3rd-Axis installed on the machine. Based on the variable set in the **Guide Homing Offset** will determine the distance that the wire guide will travel away from the limit switch once it has been triggered.

Wire Guide Homing Offset.

Sets the offset distance that the feeder arm will move away from the limit switch when the **Home Wire Guide** button is clicked.

For example, if it is set to 1mm then when the **Home Wire Guide** button is clicked the Wire Guide will move to the back until it gets to the limit switch on the machine. It will then move forward 1mm.

This option is only available for 3-Axis Machines.

Bobbin Dimensions

(1) Enter Bobbin Width mm

(2) Enter Total Windings

(3) Enter Wire Size mm

Closest awg value to mm awg

Switch to Pickups

TPL Calculator

Tension Calculator

Convert awg>mm

On the **Bobbin Dimensions** panel we have a **TPL Calculator** button.
When clicked this switches the appearance of the panel as can be seen below

TPL Calculator

Enter Required TPL:

Enter Bobbin Width:

Feeder Resolution:

Enter Total Layers:

Calculated Bobbin Width:

Calculated Wire Size:

Calculated Windings:

Enter your Required Turns Per Layer (TPL)
Then Click Calculate to get the result of what
the wire size should be.
Adjust the TPL till you get as close to the bobbin
width/height you require.

Calculate Populate Results Close

This will allow you to calculate the Turns Per Layer by simply entering the turns required for each layer, the bobbin width and the number of layers you wish to wind.

Close button.

Closes the TPL panel.

Calculate button.

This will populate the result green boxes with the values that have been calculated, based on what you entered in the top boxes.

Populate Results button.

This will take the values that have just been calculated and populate the main bobbin dimensions screen.

CNC Design Ltd 2020 Coil Winder ARM Controller MKII Software V2.9

Automated Coil Winding | Standard Script Engine | Absolute Scripting | Manual Winding Mode | Settings/Diagnostics | Keyboard Mapping | **MACHINE 1**

Bobbin Dimensions

(1) Enter Bobbin Width mm

(2) Enter Total Windings

(3) Enter Wire Size mm

Closest awg value to mm awg

Switch to Pickups

TPL Calculator

Enter Required TPL:

Enter Bobbin Width:

Feeder Resolution:

Enter Total Layers:

Calculated Bobbin Width:

Calculated Wire Size:

Calculated Windings:

Enter your Required Turns Per Layer (TPL) Then Click Calculate to get the result of what the wire size should be. Adjust the TPL till you get as close to the bobbin width/height you require.

Calculate | **Populate Results** | Close

Status and Calculations

Calculated Winds Per Layer | Calculated Wire/Pitch Size | Reply

Calculated Total Layers | Calculated Bobbin Width | -

Bobbin Name Loaded | Hardware Status

Controls

Disengage Motors | **Start** | STOP | Pause | Home Feeder

Bobbin Motor Jog | Feeder Arm Jog | Wire Guide Jog | Feeder Homing Offset mm

Reverse | Forward | Left | Right | Back | Forward

Travel per click revolutions | Travel per click millimeters | Travel per click millimeters | Home Wire Guide

Guide Homing Offset mm

Status

Winds Completed | Feeder Position

RPM | Guide Position

Goto Zero | Reset

☐ Increment counters when jog buttons clicked

Above after clicking the Populate Results button.

Bobbin Dimensions

(1) Enter Bobbin Width mm

(2) Enter Total Windings

(3) Enter Wire Size mm

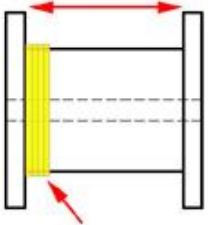

Closest awg value to mm awg

Switch to Pickups

TPL Calculator

Tension Calculator

Convert awg>mm

On the **Bobbin Dimensions** panel, we have a **Tension Calculator** button.
When clicked this switches the appearance of the panel as can be seen below

Wire Tension Calculator

Enter Wire Diameter
(Without Insulation) mm

Calculated Tension grams

Calculated Tension Kg

Calculated Tension Lbs

Calculated Tension Ounces

Enter your wire diameter.
Then Click Calculate to get the result of what
tension should be set.

Please note this is just a guideline and you
may have to adjust the tension up or down
a little to suit your bobbin type.

Calculate

Close

Close button.

Closes the Tensioner panel.

Calculate button.

This will take the wire size entered in the top box and give the results in the green boxes.

Bobbin Dimensions

(1) Enter Bobbin Width mm

(2) Enter Total Windings

(3) Enter Wire Size mm

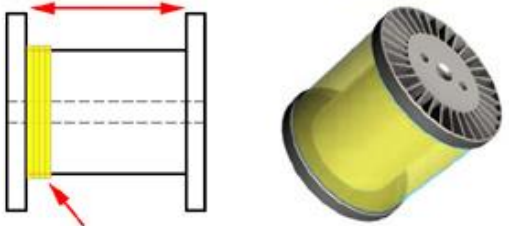
Closest awg value to mm awg

Switch to Pickups

TPL Calculator

Tension Calculator

Convert awg>mm



On the **Bobbin Dimensions** panel we have a **Switch to Pickups** button. When clicked this switches the appearance of the panel as can be seen below

CNC Design Ltd 2020 Coil Winder ARM Controller MKII Software V2.9

Automated Coil Winding | Standard Script Engine | Absolute Scripting | Manual Winding Mode | Settings/Diagnostics | Keyboard Mapping | MACHINE 1

Bobbin Dimensions

Interpretation of Guitar Bobbin Dimensions.

Length mm

Width mm

Height mm

Total Windings

Wire Size mm

Resistance Closest awg value to mm awg

Mixed TPL Mode

Switch to Bobbins

Save/Edit Mixed TPL

TPL Calculator

Tension Calculator

Convert awg>mm

Notice we use Height instead of width that we use on normal bobbin.

Status and Calculations

Calculated Winds Per Layer Calculated Wire/Pitch Size Reply

Calculated Total Layers Calculated Pickup Height

Bobbin Name Loaded Hardware Status

Controls

Disengage Motors

Start

STOP

Pause

Home Feeder

Bobbin Motor Jog

Feeder Arm Jog

Wire Guide Jog

Feeder Homing Offset mm

Home Wire Guide

Guide Homing Offset mm

Reverse Forward

Left Right

Back Forward

Travel per click revolutions

Travel per click millimeters

Travel per click millimeters

Load/Save Pickup

1960 Strat

Save Remove Populate Default Pickups

Wire Direction ☒ Right ☐ Left

Bobbin Direction ☒ Forward ☐ Reverse

Ramping Configuration

Pause Steps

☐ Ramp each layer ☐ Pause at end of each layer

☐ Return to Zero on Finish ☐ Manual Speed ?

Bobbin Speed

Desired Speed RPM

Calculated Speed RPM

☒ Disable Hover Help Tips Help

Status

Winds Completed

Feeder Position

RPM

Guide Position

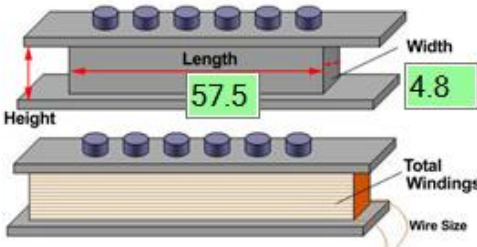
Goto Zero Reset

☐ Increment counters when jog buttons clicked

We now have a guitar pickup picture displayed and also a few more options.

Bobbin Dimensions

Interpretation of Guitar Bobbin Dimensions.



Mixed TPL Mode Switch to Bobbins

(1) Enter Pickup Height
10.8 mm

(2) Enter Total Windings
8293

(3) Enter Wire Size
0.0635 mm

Resistance 6.33K Closest awg value to mm 22 awg

Save Mixed TPL
TPL Calculator
Tension Calculator
Convert awg>mm

The main thing that has changed is that we now have extra variables that can be set and saved against the bobbin.

These are shown in green and are for information only. They do not affect the way the pickup is wound.

Load/Save Pickup

Nothing Saved Yet

Save Remove Populate Default Pickups

Enter any notes in this box and click Save.
This will save as a note against the selected bobbin.

Homing Configuration
Offset 10 mm ☐ Use Homing Offset on Start

Also, you will notice that we now have a **Populate Default Pickups** button.

When you first run the software you will see that nothing has been saved yet.

But by click the **Populate Default Pickups** button it will populate the database with a set of common guitar pickups.

Any of these once loaded can be changed and saved back to suit your custom needs.

Load/Save Pickup

1950-1951 Tele Bridge

1950-1951 Tele Bridge
1950-1960 Tele Neck
1951-1964 Tele Bridge
1954 Strat
1955 Strat
1956 Strat
1957 Strat
1958 Strat

A new feature is the Mixed TPL Mode button.

The screenshot shows the 'Bobbin Dimensions' software interface. On the left, there are two diagrams of guitar bobbins. The top diagram is labeled 'Interpretation of Guitar Bobbin Dimensions.' and shows a bobbin with dimensions: Length 57.5, Width 4.8, and Height 10.8. The bottom diagram shows a bobbin with dimensions: Total Windings 8293 and Wire Size 0.0635. Below the diagrams, it says 'Notice we use Height instead of width that we use on normal bobbin.' and 'Resistance 6.33K'. On the right, there are input fields for 'Mixed TPL Mode' (highlighted with a red circle), 'Switch to Bobbins', '(1) Enter Pickup Height' (10.8 mm), '(2) Enter Total Windings' (8293), '(3) Enter Wire Size' (0.0635 mm), and 'Closest awg value to mm' (22 awg). There are also buttons for 'Save Mixed TPL', 'TPL Calculator', 'Tension Calculator', and 'Convert awg>mm'.

A lot of our customers that are winding Guitar Pickups are now using the Scripting Engine for creating some Mixed Turns Per Layer(TPL) to build up their coil shapes into various shapes and also to try and get close to a Scatter Wind effect.

We do have a Beta Scatter Winding tab in the software, but it is based on a different position per revolution, rather than allowing for mixed TPL setups, that can then be merged together.

A quick couple of paragraphs on Scatter Winding first.

What is scatter winding?

When wire is wound into coils on a pickup, the most basic definition of scatter-wound means “non-uniform.”

Imagine a spool of thread that doesn’t have thread on it yet that you’re going to wrap thread around.

If you were to wrap that thread in a uniform way, you would start the wrap on one side, with each consecutive wrap following the other until you reach the other side, then start wrapping in the other direction and crisscross until you were finished.

If you were to wrap the same thread in a non-uniform way where you wrap a few times on one side, then go straight to the other side and get a few wraps there, then to the middle and “fill” the spool in a non-uniform way, that’s a scatter-wind.

Does scatter winding have a “standard?”

No. Scatter-winding is particular to manufacturer. Seymour Duncan will scatter-wind differently than Lindy Fralin and differently than other pickup makers and so on. In addition, there are also pickup makers who scatter-wind by hand, and still others who will use a machine. There is no single “right way” to scatter-wind.

What pickup makers do is experiment with different scatter-wind techniques until they find one they think works well, and go with that.

One of the down sides of using the scripting is that for higher speeds, each command will need to be ramped up and ramped down. If not then the motors will just stall. Just like any CNC machine out there, that is using Stepper motors, they need to be ramped.

Now the big question or observation I get is that in the Automated Tab, you can setup all the parameters of the pickup you wish to wind, click on the start button and away the machine will go, without it having to ramp up and down each layer.

The main reason we can do this is because the feeder (with small wire) is never running faster than the bobbin motor and the speed it is running at 99% of the time means we can change direction of the feeder without ramping.

So we calculate total windings, along with the turns per layer and send this as one command to the firmware. You will still get a ramp at the beginning and also a ramp at the end of the winding. But no ramping in-between layers as the firmware simply changes direction of the feeder when it hits it desired TPL.

With the scripting we send one command for each layer.

So now to try and make winding a little bit smoother, we have added a new button on the Automated tab Pickup Screen. This is called Mixed TPL mode and allows you to save different combinations of winding sets and to execute them one after the other.

You will still need to ramp up and down for each set, but depending on how many windings are in a set and how many total winds you need to do, it will reduce the ramping per layer a lot.

Main rules to stick to are to make sure each winding set you create has at least two layers and that total layers are a whole number (Integer).

The reason for this is so you do not lose your zero point in-between the winding sets. If you try to send say 10 windings at a 1.0mm pitch for the first layer and then send 5 windings at

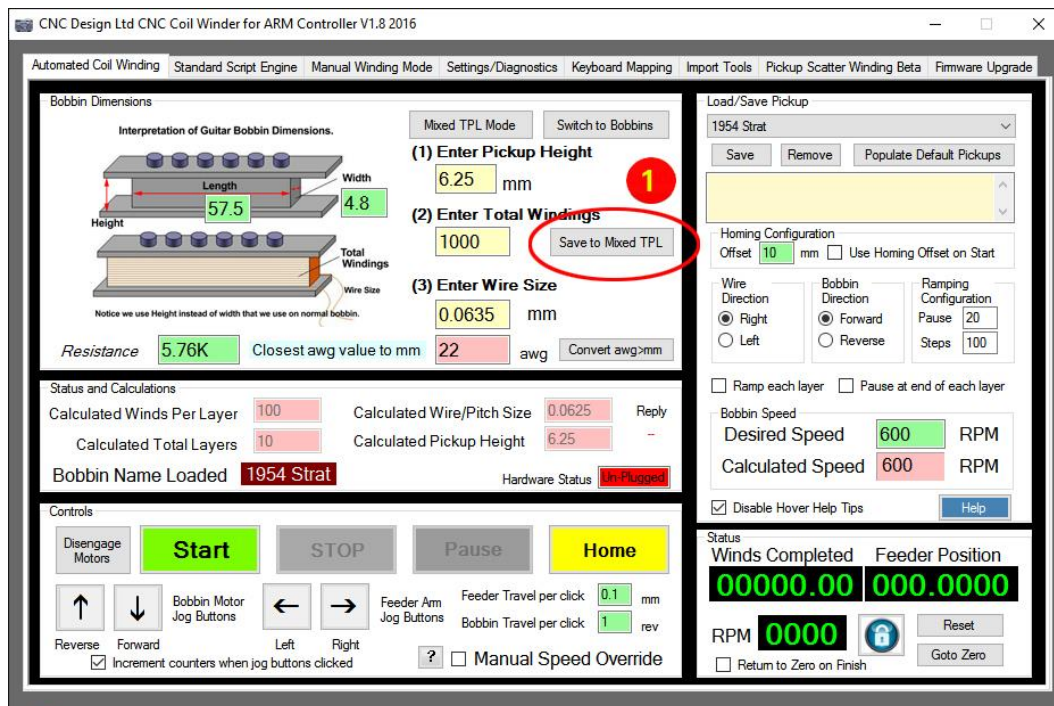
1.0mm for the next layer, then obviously the starting point for the next command is not at zero point and it would actually be 5.0mm.

In the scripting engine you could send a movement command to bring it back to zero, but for this feature under the Mixed TPL Mode, that will not be possible.

So a little bit of a trade off, but it should suit most people's needs.

Here are some screenshots with instructions on how it works.

GUI layout may look a little different as screenshots are from V1.8 software.



1 Set the Pickup Height, Windings and wire size, then click Save to Mixed TPL.

CNC Design Ltd CNC Coil Winder for ARM Controller V1.8 2016

Automated Coil Winding | Standard Script Engine | Manual Winding Mode | Settings/Diagnostics | Keyboard Mapping | Import Tools | Pickup Scatter Winding Beta | Firmware Upgrade

Bobbin Dimensions

Interpretation of Guitar Bobbin Dimensions.

Length: 57.5 mm
Width: 4.8 mm
Height: 57.5 mm
Total Windings: 1000
Wire Size: 0.0635 mm

Resistance: 5.76K Closest awg value to mm 22 awg Convert awg>mm

Mixed TPL Mode Switch to Bobbins

(1) Enter Pickup Height 6.25 mm

(2) Enter Total Windings 1000 Save to Mixed TPL

(3) Enter Wire Size 0.0635 mm

Status and Calculations

Calculated Winds Per Layer 100 Calculated Wire/Pitch Size 0.0625 mm Reply

Calculated Total Layers 10 Calculated Pickup Height 6.25 mm

Bobbin Name Loaded 1954 Strat Hardware Status Un-Plugged

Controls

Disengage Motors Start STOP Pause Home

Reverse Forward Bobbin Motor Jog Buttons Left Right Feeder Arm Jog Buttons Feeder Travel per click 0.1 mm Bobbin Travel per click 1 rev

☒ Increment counters when jog buttons clicked ☐ Manual Speed Override

Save To Mixed TPL List

Saved Mixed TPL combinations

Nothing Saved Yet

Save Remove

Please Enter a name for this entry

MTPL1

Please enter a name and click the Save button to add it to the drop down list.

This will allow you to save the settings of the pickup as a Mixed TPL combination..

Saved Mixed TPL combinations can only be used in the Mixed TPL Mode.

Click Close to return.

Calculated Total Layers must always be an even integer number.

Close

Status

Winds Completed 00000.00 Feeder Position 000.0000

RPM 0000

☐ Return to Zero on Finish

Reset Goto Zero

- 1 Check the Total Layers and make sure this is greater than 1 and also an even number.
- 2 Here is where you can specify a name for your winding setup before saving it to the Combination List.

CNC Design Ltd CNC Coil Winder for ARM Controller V1.8 2016

Automated Coil Winding | Standard Script Engine | Manual Winding Mode | Settings/Diagnostics | Keyboard Mapping | Import Tools | Pickup Scatter Winding Beta | Firmware Upgrade

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Total Windings: 1000
Wire Size: 0.0635 mm

Resistance: 5.76K Closest awg value to mm 22 awg Convert awg>mm

Mixed TPL Mode Switch to Bobbins

(1) Enter Pickup Height 6.25 mm

(2) Enter Total Windings 1000 Save to Mixed TPL

(3) Enter Wire Size 0.0635 mm

Status and Calculations

Calculated Winds Per Layer 100 Calculated Wire/Pitch Size 0.0625 mm Reply

Calculated Total Layers 10 Calculated Pickup Height 6.25 mm

Bobbin Name Loaded 1954 Strat Hardware Status Un-Plugged

Controls

Disengage Motors Start STOP Pause Home

Reverse Forward Bobbin Motor Jog Buttons Left Right Feeder Arm Jog Buttons Feeder Travel per click 0.1 mm Bobbin Travel per click 1 rev

☒ Increment counters when jog buttons clicked ☐ Manual Speed Override

Save To Mixed TPL List

Saved Mixed TPL combinations

Nothing Saved Yet

Save

Please Enter a name for this entry

1000 Winds 100TPL

Please enter a name and click the Save button to add it to the drop down list.

This will allow you to save the settings of the pickup as a Mixed TPL combination..

Saved Mixed TPL combinations can only be used in the Mixed TPL Mode.

Click Close to return.

Calculated Total Layers must always be an even integer number.

Close

Status

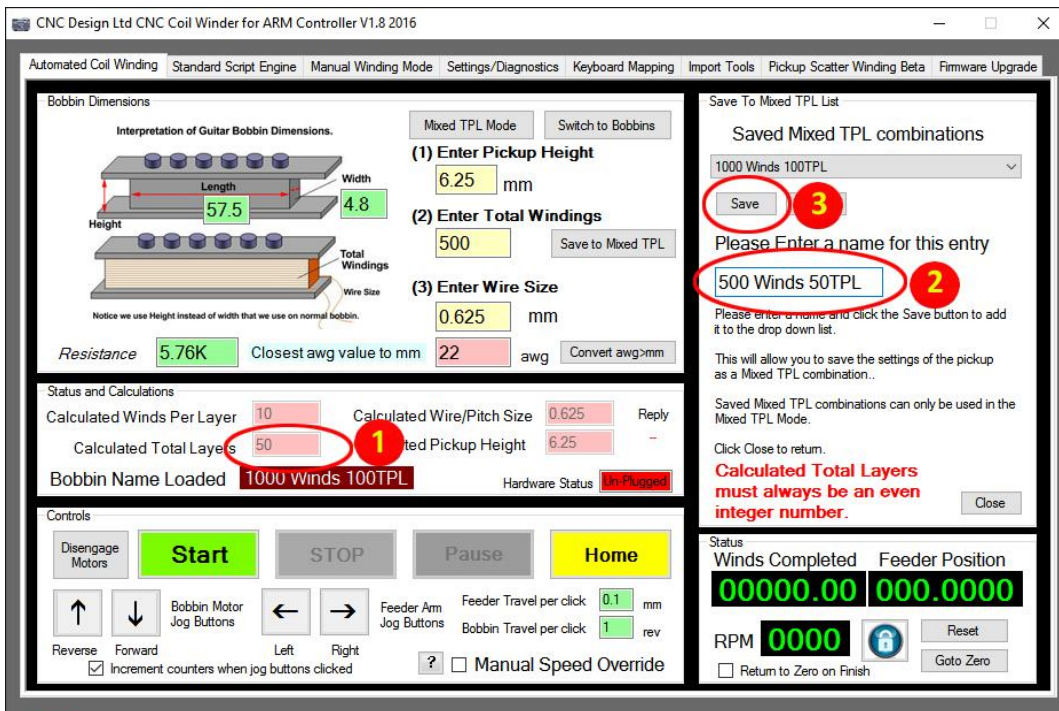
Winds Completed 00000.00 Feeder Position 000.0000

RPM 0000

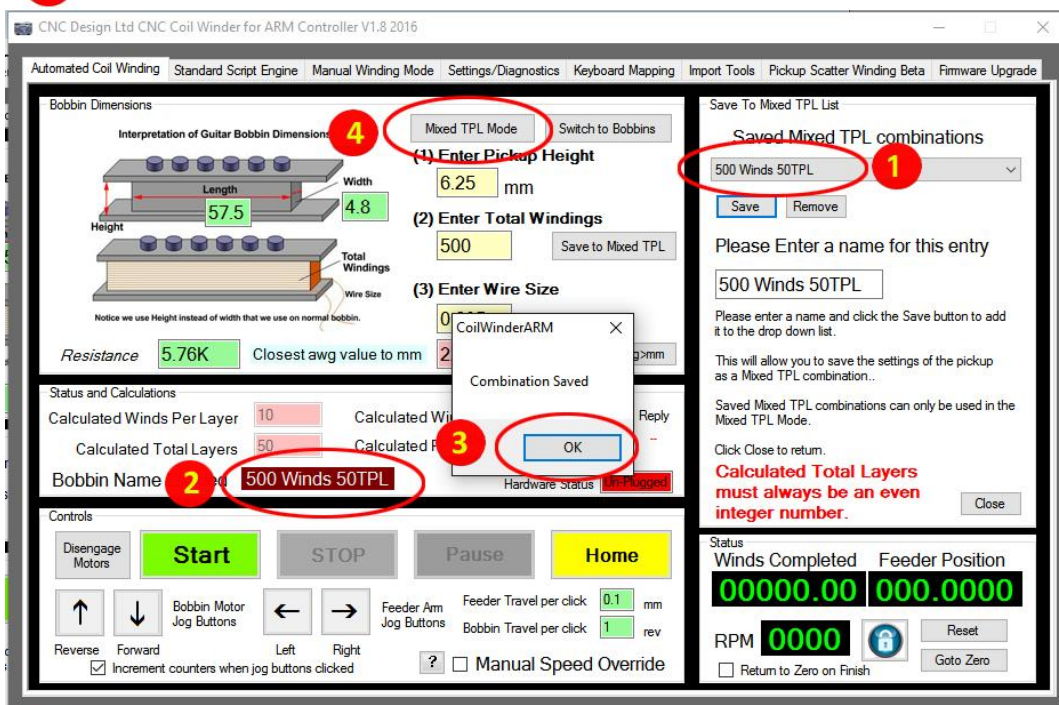
☐ Return to Zero on Finish

Reset Goto Zero

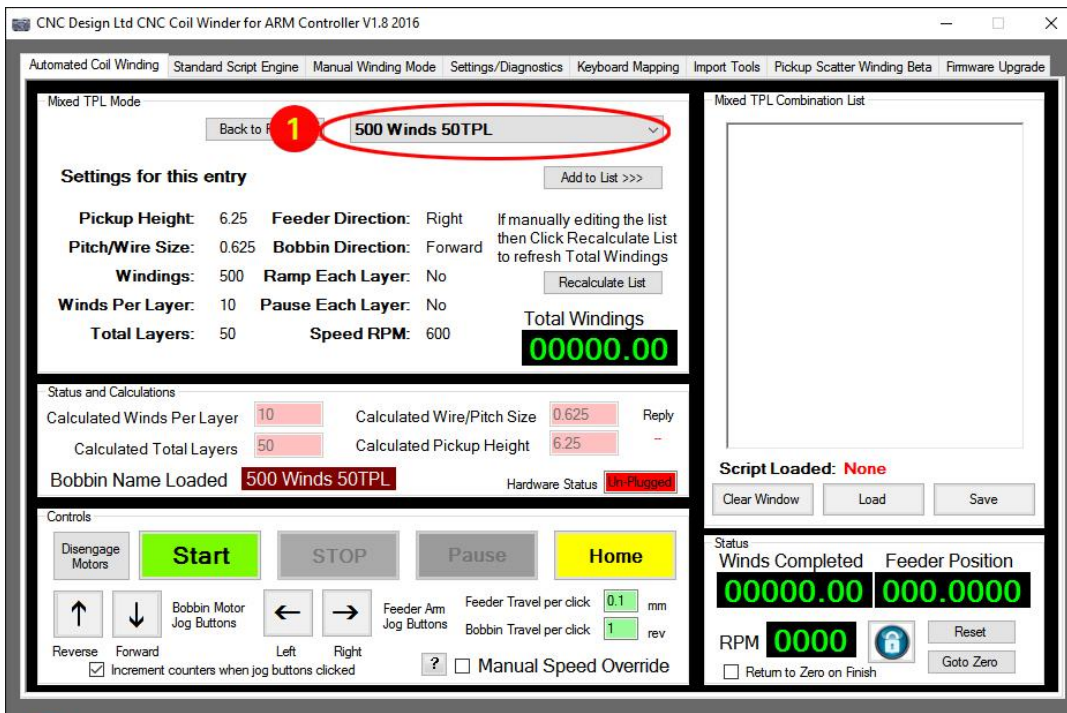
- 1 So to save this, enter a Name
- 2 Click the Save button



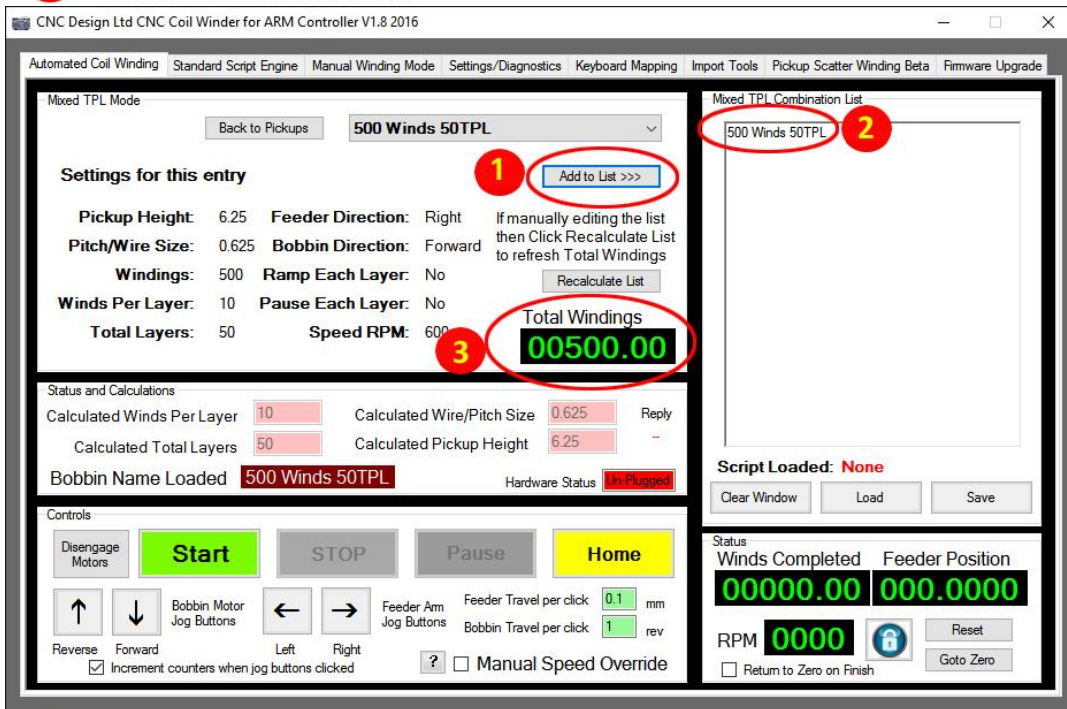
- 1 Next we setup another winding setup and check the Total Layers is an even number.
- 2 Choose a name
- 3 Click the Save button



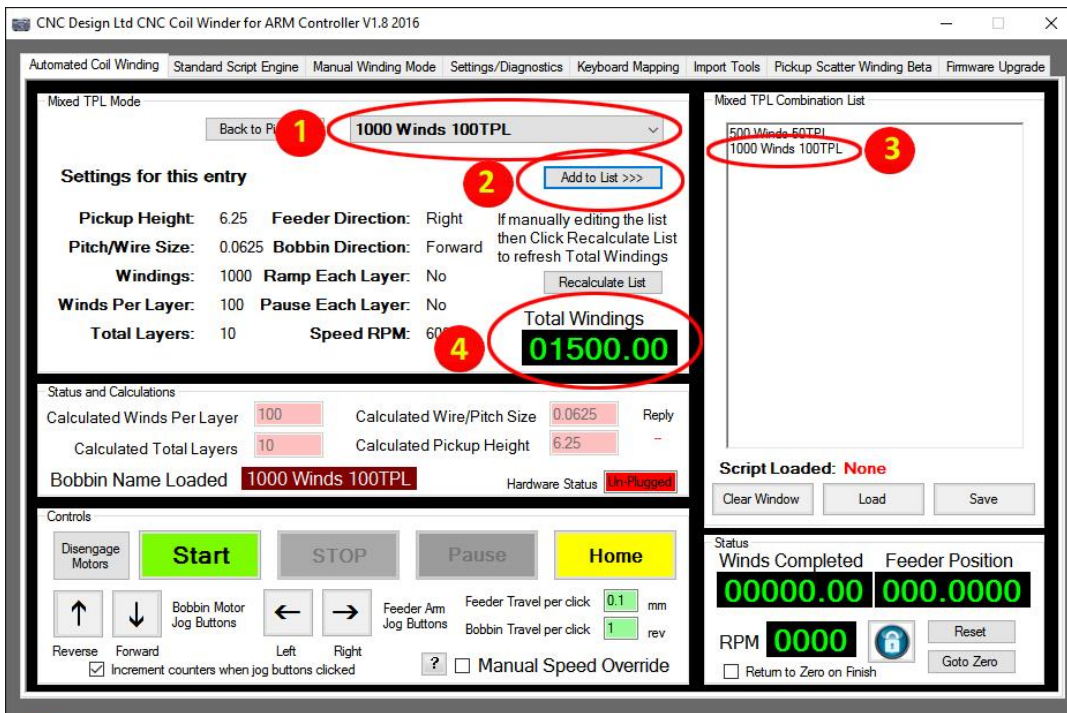
- 1 Once saved the winding setup should be now listed in the drop down box.
- 2 Also the Bobbin Name should update.
- 3 Click the OK button
- 4 Next to use the TPL combinations we have saved, we click the Mixed TPL Mode button.



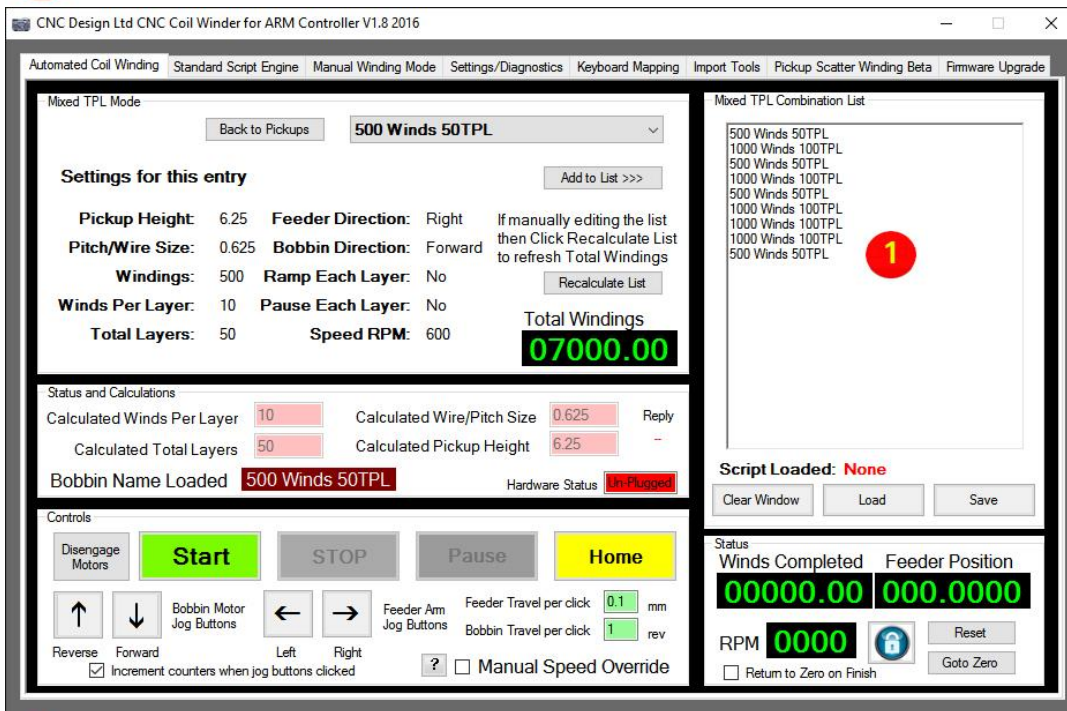
- 1 We can see our saved items are available from the drop down list. When selected all the various settings will be shown in the relevant boxes.



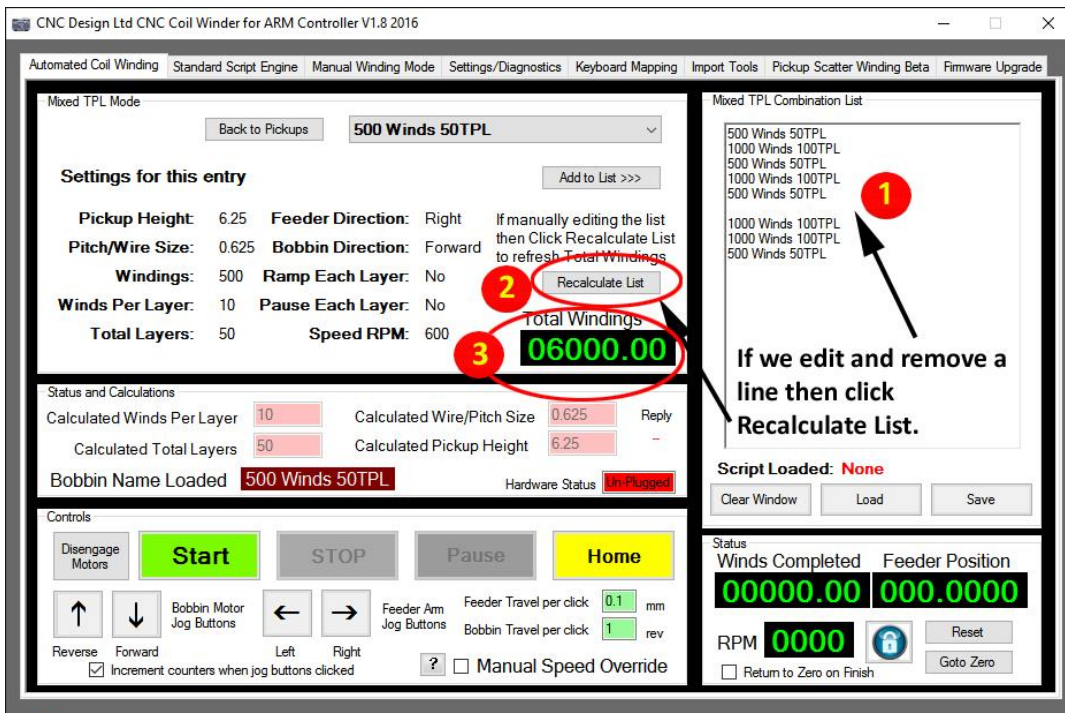
- 1 Click Add to List button
- 2 The item shown in the drop down box will now be added to the list on the right hand side.
- 3 The total Windings counter will be updated.



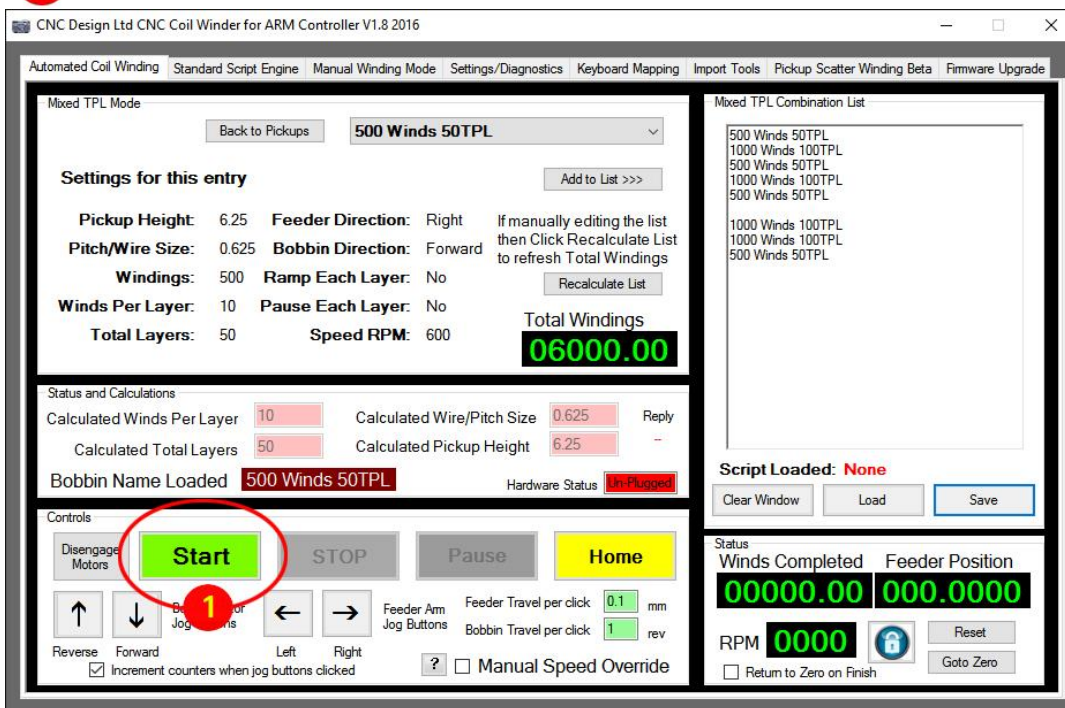
- 1** We now choose another item from the drop down list.
- 2** Click the Add to List button
- 3** The TPL Combination List should now be updated with the new item.
- 4** The total Windings counter will be updated adding the windings from each entry on the list.



- 1** Now we can add various combinations that we require to the List to build up our total windings.



- 1 You can manually edit the items in the list and remove as shown above.
- 2 After any manual editing make sure you click on the Recalculate List button
- 3 The total Windings counter will be updated.



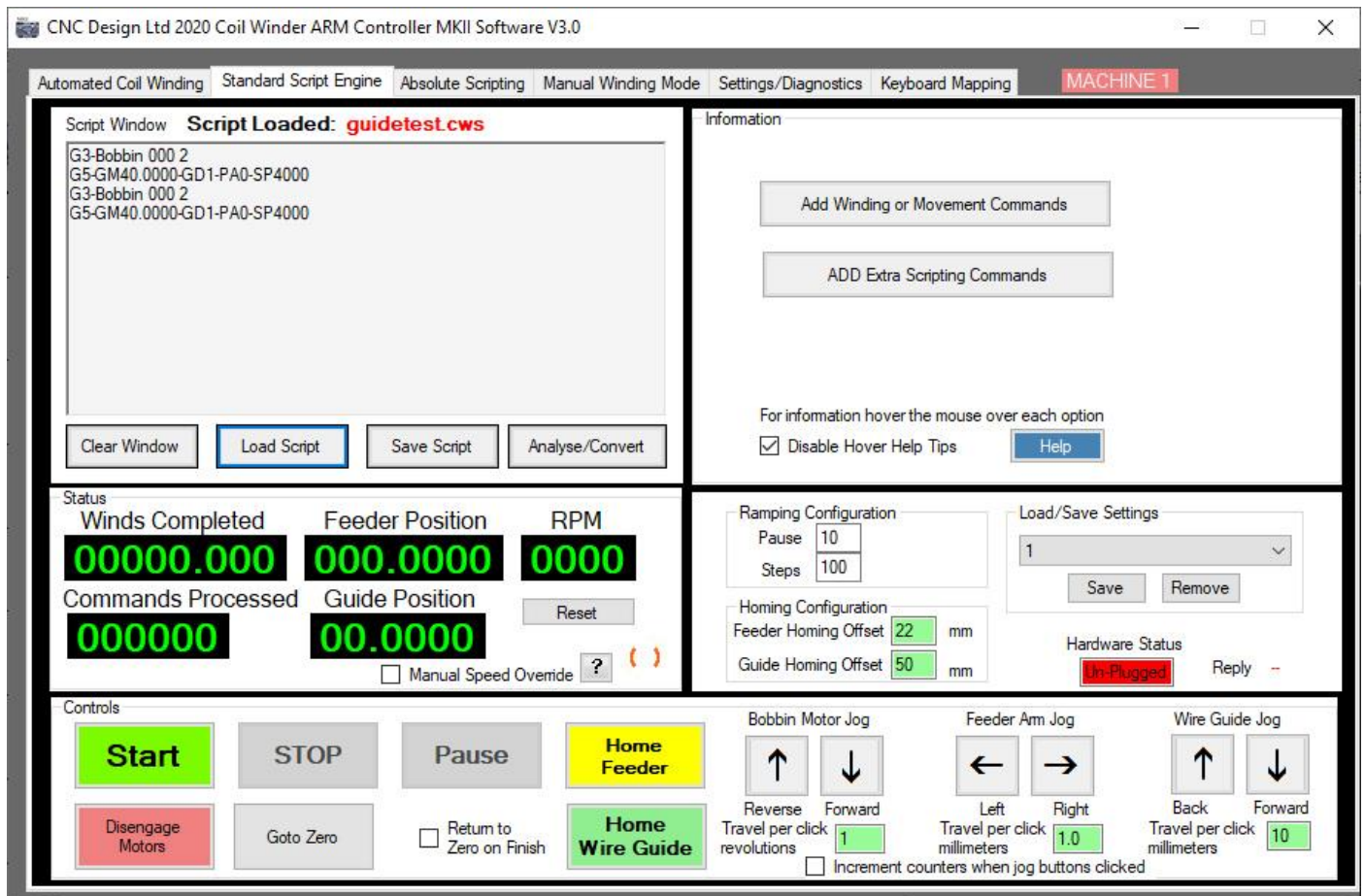
- 1 Make sure your machine is plugged in and then hit start!
It should now go through each entry in the list and execute the command.

Standard Script Engine – Tab

This tab allows us to have more control over the coil winding process by allowing us to create a series of commands to control bobbin windings and feeder movement.

These commands can be built up and saved as a script for later use.

Creating the commands is very simple by using the GUI interface to choose the options you want for each new command and press the **Add Command** button.



Below we will go through each option panel and detail what they are.

The screenshot displays a software interface with four main sections:

- Ramping Configuration:** Contains two input fields: 'Pause' set to 10 and 'Steps' set to 100.
- Homing Configuration:** Contains two input fields: 'Feeder Homing Offset' set to 1 mm and 'Guide Homing Offset' set to 2 mm.
- Load/Save Settings:** Features a dropdown menu currently showing '1', with 'Save' and 'Remove' buttons below it.
- Hardware Status:** Shows a red 'Un-Plugged' status indicator and a 'Reply --' button.

The objects for the other options on the panel are as follows:

Ramping Configuration group box.

We use stepper motors on our machines then to get them to higher speeds we need to ramp up the motor speed gradually.

You have two variables you can set to get the desired curve as such.

The Steps variable is the divider of the target frequency that we want the bobbin motor to run at. So if the software calculated that the bobbin motor should run at 1000kHz and the steps box is set to 100 then we can see that the steps would be $1000/100 = 10$ Hz increments.

The Pause variable is the time between each increment.

Homing Configuration group box.

Feeder Homing Offset.

Sets the offset distance that the feeder arm will move away from the limit switch when the **Home Feeder** button is clicked.

For example, if it is set to 10mm then when the **Home Feeder** button is clicked the feeder arm will move to the left until it gets to the limit switch on the machine. It will then move to the right 10mm.

This option is only available for machines with the homing/limit switches installed.

Wire Guide Homing Offset.

Sets the offset distance that the feeder arm will move away from the limit switch when the **Home Wire Guide** button is clicked.

For example, if it is set to 1mm then when the **Home Wire Guide** button is clicked the Wire Guide will move to the back until it gets to the limit switch on the machine. It will then move forward 1mm.

This option is only available for 3-Axis Machines.

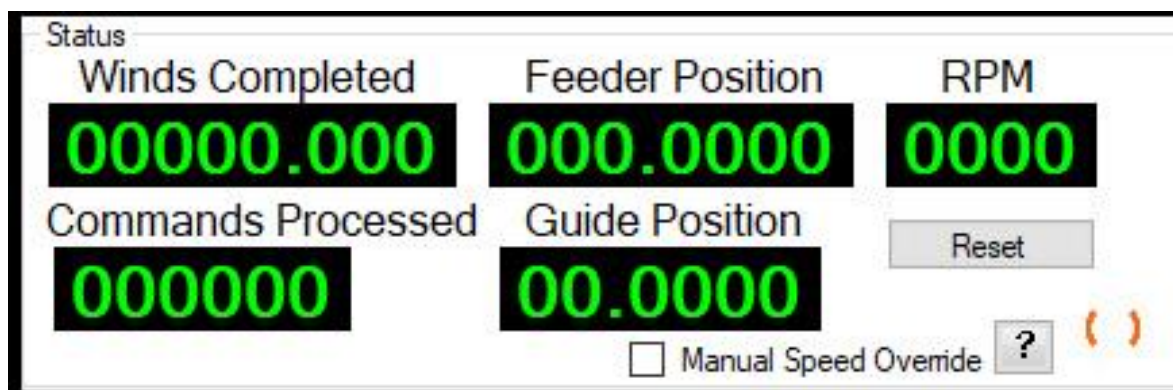
Reply is the answer coming back from the Coil Winding Machine after each command is sent.

Hardware Status shows if the Coil Winding Machine is connected or not connected to the computer.

The **Load/Save Settings** group box.

Allows you to save and remove scripting parameters.

When clicking the **Save** button it will ask for a name that you wish to call the set and save all the parameters to the registry. If you wish to remove the saved set from the registry, then click the **Remove** button and it will delete it.



The **Status** panel has the following objects

Winds Completed display.

Displays the amount of winding that have been wound.

Feeder Position display.

Displays the position of the feeder arm on the machine.

RPM display.

Displays the speed that the bobbin motor is running at.

Commands Processed display.

Displays the amount of commands that have been processed.

Guide Position display.

Displays the position of the wire guide on the machine. Only for 3-Axis machines.

Reset button.

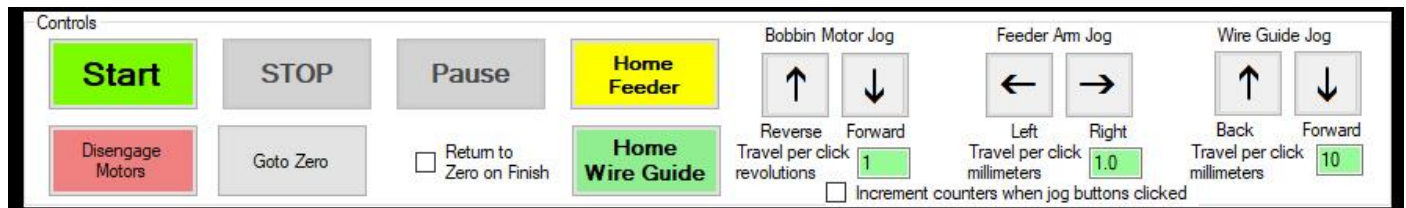
Pressing this button will reset the feeder position to zero.

Manual Speed Override checkbox.

If checked then when the **Start** button is clicked the software will pass control over to the manual speed controller on the controller box.

The manual controller dial needs to be fully turned to the left before it will start to wind and the speed of the bobbin motor and feeder arm will increase or decrease depending on the position of the dial.

Ramping will be disabled for this mode as not needed and it will be down to control of the user to make sure the speed is controlled so no jamming of the motors will occur.



The **Controls** panel has the following objects

Start button.

Clicking this button starts the winding routine starting with the first command in the script window.

Stop button.

Clicking this button stops the winding routine.

Pause/Resume button.

While winding is in progress and you wanted to pause the machine then click this button. It will then turn to a flashing Resume status and clicking it again will allow the machine to carry on from where it was paused.

While pause you can cancel the winding routine by pressing the stop button.

Also while paused the Left and Right button can be used to jog the feeder arm to a new position. This will not increment the feeder position and can be used for adjustments needed without having to restart the whole winding routine from the beginning.

Home Feeder button.

This can only be used if there are limit/homing switches installed on the machine. Based on the variable set in the **Feeder Homing Offset** will determine the distance that the feeder arm will travel away from the limit switch once it has been triggered.

Disengage Motors button.

When clicked this will disengage the motors so they can be turned by hand.

The motors will automatically re-engage when start or jog buttons are clicked.

You will not be able to disengage the motors when paused, but if you need to move the motors at this point, then simply turn the power off to the motors via the switch. Do the adjustments and then turn the power back on before pressing resume in the software.

Goto Zero button.

Pressing this button will tell the feeder arm to return to its zero position.

Return to Zero checkbox.

If this is checked then when the machine has finished its winding routine the feeder arm will automatically move back to the zero position.

Home Wire Guide button.

This can only be used if there is a 3rd-Axis installed on the machine. Based on the variable set in the **Guide Homing Offset** will determine the distance that the wire guide will travel away from the limit switch once it has been triggered.

Reverse button.

This is a manual jog for the bobbin motor and when clicked the bobbin motor will move in the reverse direction.

Forward button.

This is a manual jog for the bobbin motor and when clicked the bobbin motor will move in the forward direction.

Left button.

This is a manual jog for the feeder arm and when clicked the feeder arm will move to the left.

Right button.

This is a manual jog for the feeder arm and when clicked the feeder arm will move to the right.

Back button.

This is a manual jog for the Wire Guide and when clicked the wire guide will move to the Back. Only available on 3-Axis machines.

Forward button.

This is a manual jog for the Wire Guide and when clicked the wire guide will move to the Back. Only available on 3-Axis machines.

Feeder Travel per click variable.

Sets the travel in millimetres that the feeder arm will move if either the **Left** or **Right** buttons are clicked.

Bobbin Travel per click variable.

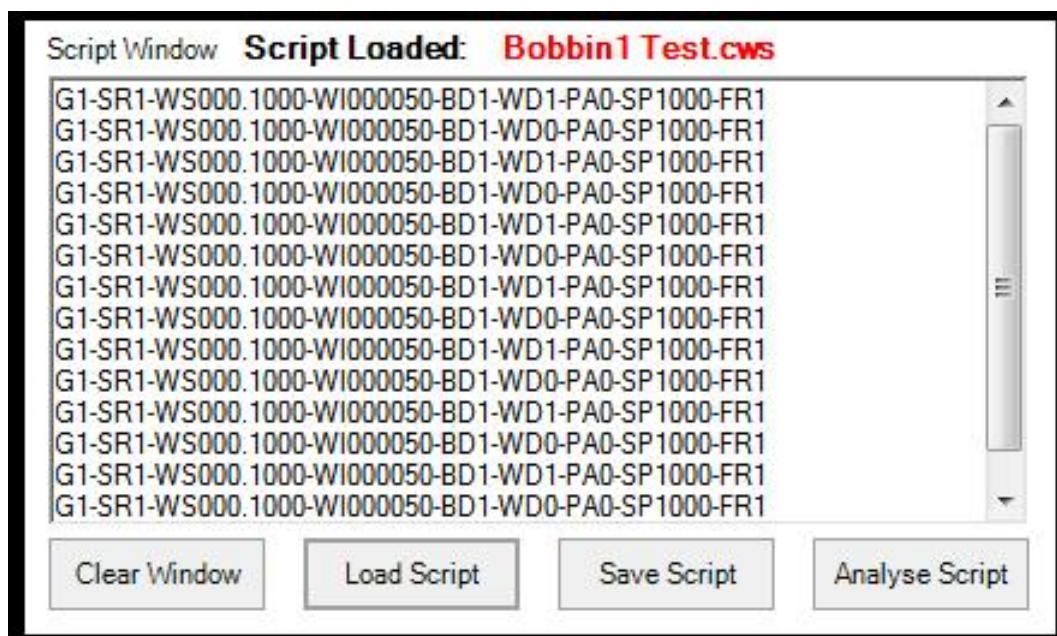
Sets the amount of revolutions that the bobbin motor will move if either the **Forward** or **Reverse** buttons are clicked.

Wire Guide Travel per click variable.

Sets the travel in millimetres that the wire guide will move if either the **Back** or **Forward** buttons are clicked. Only available on 3-Axis machines.

Increment Counter When Jog Buttons Clicked Checkbox.

When checked this will update the counters when the jog buttons are clicked.



The **Script Window** panel has the following objects

The Script window itself is where each command is appended to and built up.

The command structure is very simple to understand and a quick breakdown is.

G1 – This lets the software know it is a Standard command.

SR1 – Sets the Start Ramp to on.

WS000.1000 – Sets the Wire Size or pitch to 0.1mm to move per wind.

WI000050 – Sets the amount of winds to be completed.

BD1 - Sets the Bobbin Direction to forward

WD1 – Sets the Wire Direction to move to the right.

PA0 – Tells the software not to pause for each layer.

SP1000 – Sets the speed to 1000 RPM

FR1 – Sets the Finish Ramp to on.

This will again interpolate the bobbin and feeder motors so that they start and stop at the exact time across each wind.

If you just wanted the feeder arm to move and not the bobbin motor then simply set the windings to zero (**WI000000**). When this command is then executed it would move the feeder arm 0.1mm.

The same if you just wanted the bobbin motor to do 50 turns without the feeder moving. Set the wire size to zero (**WS000.0000**).

There are also another set of commands that can be added to your script.

***comment** - Anything with a * in front of it will be treated as a comment.

M1-message -Pauses the script and allows a message to be displayed.

M2-Start Loop10 – Start of loop command. Any commands inserted between the M2 and M3 commands will be repeated. In this example 10 times.

M3-End Loop – End of loop command.

M4-Zero Windings Counter – Zero the Total Windings counter

M5-Zero Feeder Position – Zero the Feeder Position.

M6-Pause100 – Pause between commands

M7-Move Feeder To Zero – Move Feeder to zero position.

Rather than manually adding commands, we would recommend using the GUI Add Command buttons to build the script as each command has to be in this exact format as shown above.

Clear Window button.

Clears the current window and deletes your script. If it has not been saved beforehand then you will not be able to recover it.

Load Script button.

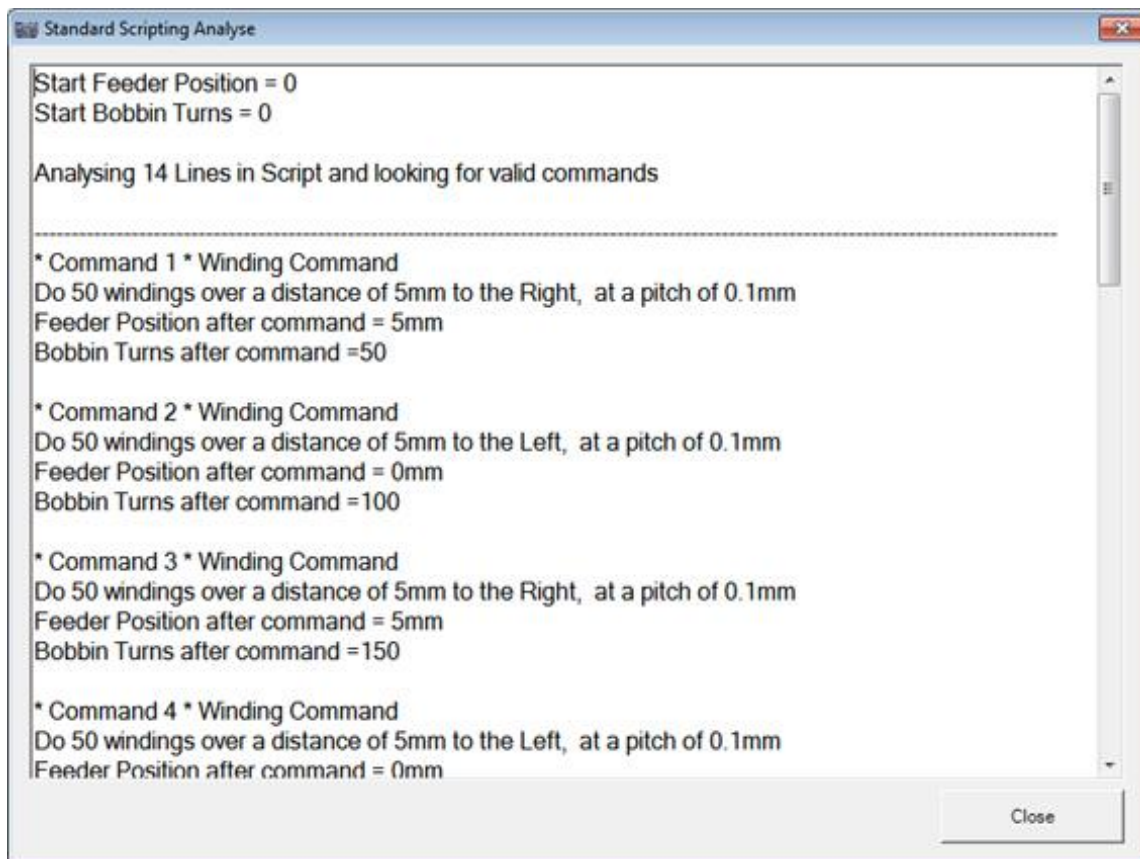
Loads a script from the computers file system into the script window.

Save Script button.

Saves the script in the Script Windows to the computers file system and allows you to choose where to save it and what filename to call it.

Analyse Script button.

This runs through your script and then opens up a separate window with the result of your script.

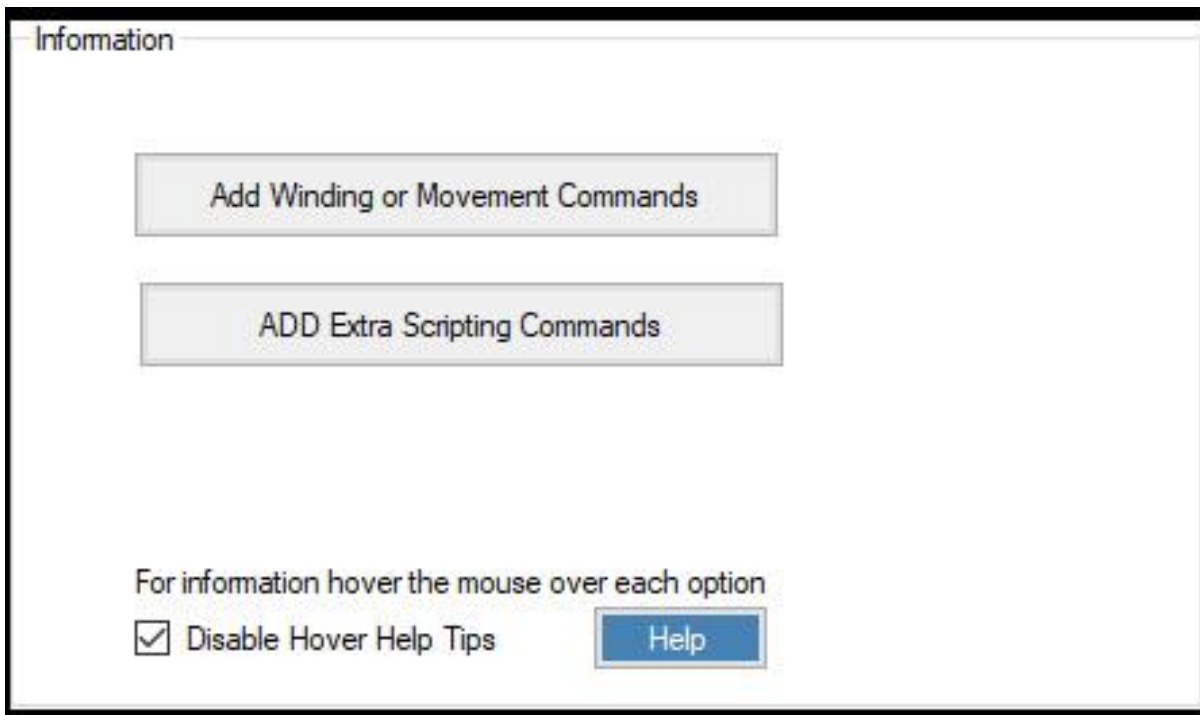


As you can see, our command1 of:

G1-SR1-WS000.1000-WI000050-BD1-WD1-PA0-SP1000-FR1

Instructs the machine to do 50 windings, with the feeder moving 0.1mm per wind.

Below we will look at the GUI interface for adding these commands.



The **Information** panel has the following objects

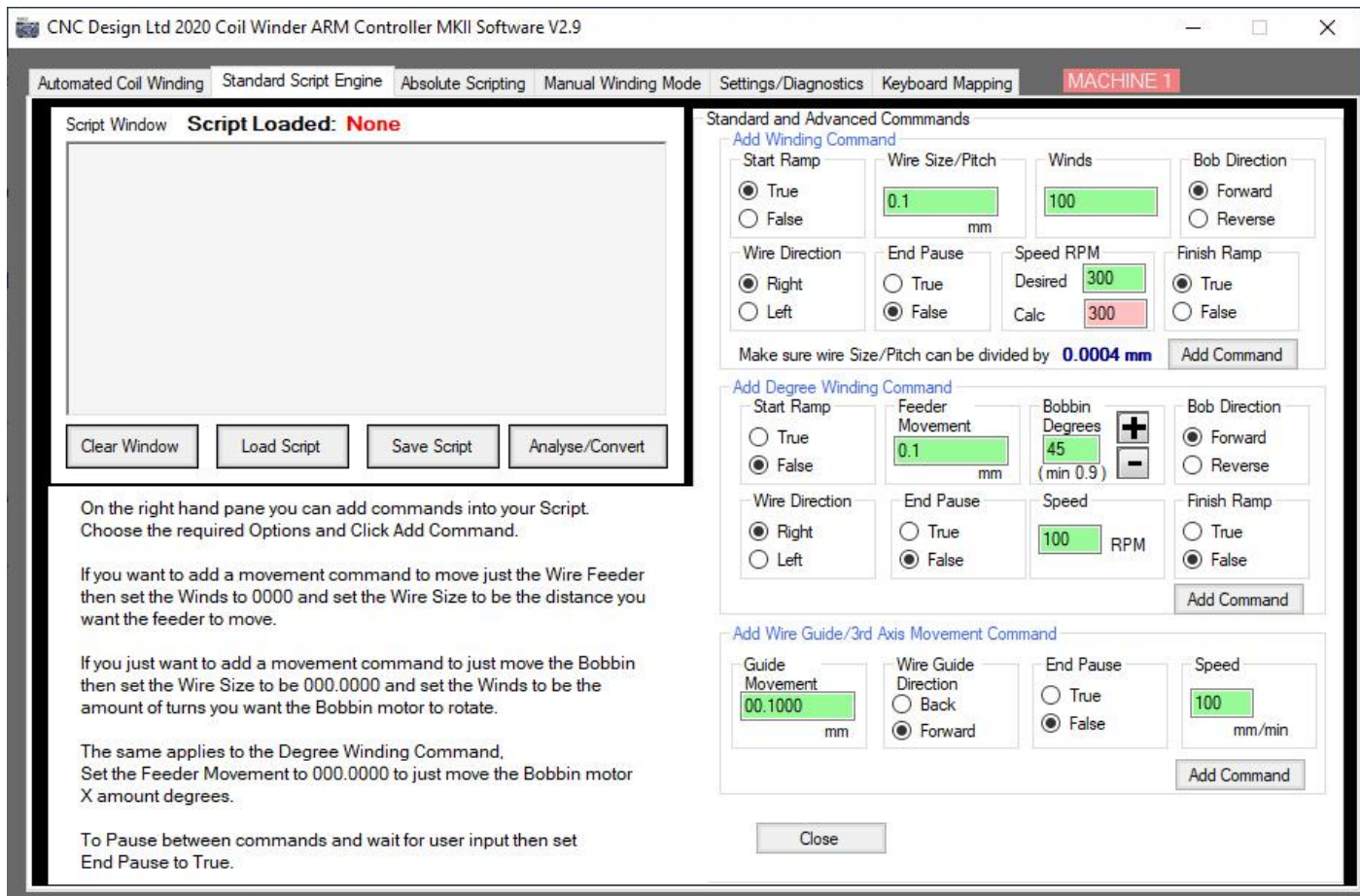
Disable Hover Help Tips checkbox.

You can move the mouse over any object within the software and if left over that object for a certain amount of time a Hover Tip will appear giving you information on that object. By checking this box then it will stop these hover tips appearing.

On the Information group you have two options that will open up different windows.

Add Winding or Movement Commands button.

Clicking on this option brings up the panel below:



Standard and Advanced Commands

Add Winding Command

Start Ramp: ☒ True ☐ False

Wire Size/Pitch: 0.1 mm

Winds: 100

Bob Direction: ☒ Forward ☐ Reverse

Wire Direction: ☒ Right ☐ Left

End Pause: ☐ True ☒ False

Speed RPM: Desired 300, Calc 300

Finish Ramp: ☒ True ☐ False

Make sure wire Size/Pitch can be divided by 0.0004 mm

Add Command

Add Degree Winding Command

Start Ramp: ☐ True ☒ False

Feeder Movement: 0.1 mm

Bobbin Degrees: 45 (min 0.9)

Bob Direction: ☒ Forward ☐ Reverse

Wire Direction: ☒ Right ☐ Left

End Pause: ☐ True ☒ False

Speed: 100 RPM

Finish Ramp: ☐ True ☒ False

Add Command

Add Wire Guide/3rd Axis Movement Command

Guide Movement: 00.1000 mm

Wire Guide Direction: ☐ Back ☒ Forward

End Pause: ☐ True ☒ False

Speed: 100 mm/min

Add Command

The **Standard and Advanced Commands** panel is shown above.

Add Winding Command

Standard and Advanced Commands

Add Winding Command

Start Ramp <input checked="" type="radio"/> True <input type="radio"/> False	Wire Size/Pitch <input type="text" value="0.1"/> mm	Winds <input type="text" value="100"/>	Bob Direction <input checked="" type="radio"/> Forward <input type="radio"/> Reverse
Wire Direction <input checked="" type="radio"/> Right <input type="radio"/> Left	End Pause <input type="radio"/> True <input checked="" type="radio"/> False	Speed RPM Desired <input type="text" value="300"/> Calc <input type="text" value="300"/>	Finish Ramp <input checked="" type="radio"/> True <input type="radio"/> False

Make sure wire Size/Pitch can be divided by **0.0004 mm**

Add Command

The objects for the standard command are as follows:

Start Ramp group box.

Sets whether the bobbin and feeder motors should ramp up on the beginning of the command.

Usually you would always set this to **True** unless using the servo motor option.

If setting it as **False** with stepper motors on the machine and running at speeds over 100RPM then you are going to jam the motor. So please be aware of this.

Wire Size group box.

This can be set for just moving the feeder arm or moving it per winding revolution.

If the **Winds** variable is set to greater than zero then the feeder arm will move the distance of the **Wire Size** variable each turn of the bobbin motor.

If the **Winds** variable is set to zero then the feeder arm will move the total distance of the millimetres set in the **Wire Size** variable.

Winds group box.

Sets the total winds for this command.

Bobbin Direction group box.

Sets the direction of the bobbin motor for this command.

Wire Direction group box.

Sets the direction of the feeder motor for this command.

End Pause group box.

Tells the software to pause after the command has completed.

The Pause button will change to Resume and will need to be clicked before the next command is executed.

Speed RPM group box.

Desired speed is the variable that will tell the machine what speed you want the bobbin motor to run at.

As the bobbin motor and feeder motor are interpolated, then most of the time the speed of the bobbin motor will be divided down to set the speed of the feeder arm motor to suit and keep that interpolation correct. But if you require the wire size or movement pitch to be a large number that requires the feeder arm motor to run faster than the bobbin motor, then the bobbin motor will automatically drop and the calculated speed will be displayed below.

Finish Ramp group box.

Sets whether the bobbin and feeder motors should ramp down at the end of the command. Usually you would always set this to **True** unless using the servo motor option.

Add Command button.

After setting all the other options above this button, you simply click this button to add the command to the script window.

Add Degree Winding Command

Add Degree Winding Command

Start Ramp <input type="radio"/> True <input checked="" type="radio"/> False	Feeder Movement 0.1 mm	Bobbin Degrees 45 (min 0.9) + -	Bob Direction <input checked="" type="radio"/> Forward <input type="radio"/> Reverse
Wire Direction <input checked="" type="radio"/> Right <input type="radio"/> Left	End Pause <input type="radio"/> True <input checked="" type="radio"/> False	Speed 100 RPM	Finish Ramp <input type="radio"/> True <input checked="" type="radio"/> False
Add Command			

The objects for the advanced command are as follows:

Start Ramp group box.

Sets whether the bobbin and feeder motors should ramp up on the beginning of the command.

Wire Size group box.

This is the distance that the feeder arm will move per degree movement of the bobbin motor.

Bobbin Degrees group box.

Sets the movement in degrees of the bobbin motor for this command.

Bobbin Direction group box.

Sets the direction of the bobbin motor for this command.

Wire Direction group box.

Sets the direction of the feeder motor for this command.

End Pause group box.

Tells the software to pause after the command has completed.

The Pause button will change to Resume and will need to be clicked before the next command is executed.

Speed group box.

This variable that will tell the machine what speed you want the bobbin motor to run at.

Finish Ramp group box.

Sets whether the bobbin and feeder motors should ramp down at the end of the command.

Add Command button.

After setting all the other options above this button, you simply click this button to add the command to the script window.

Add Wire Guide Movement Command

The dialog box is titled "Add Wire Guide/3rd Axis Movement Command". It contains the following controls:

- Guide Movement:** A text input field containing "00.1000" with "mm" as a unit label below it.
- Wire Guide Direction:** Two radio buttons labeled "Back" and "Forward". The "Forward" radio button is selected.
- End Pause:** Two radio buttons labeled "True" and "False". The "False" radio button is selected.
- Speed:** A text input field containing "100" with "mm/min" as a unit label below it.
- Add Command:** A button located at the bottom right of the dialog.

Guide Movement group box.

This is the distance that the wire guide will move.

Wire Guide Direction group box.

Sets the direction of the Wire Guide for this command.

End Pause group box.

Tells the software to pause after the command has completed.

The Pause button will change to Resume and will need to be clicked before the next command is executed.

Speed group box.

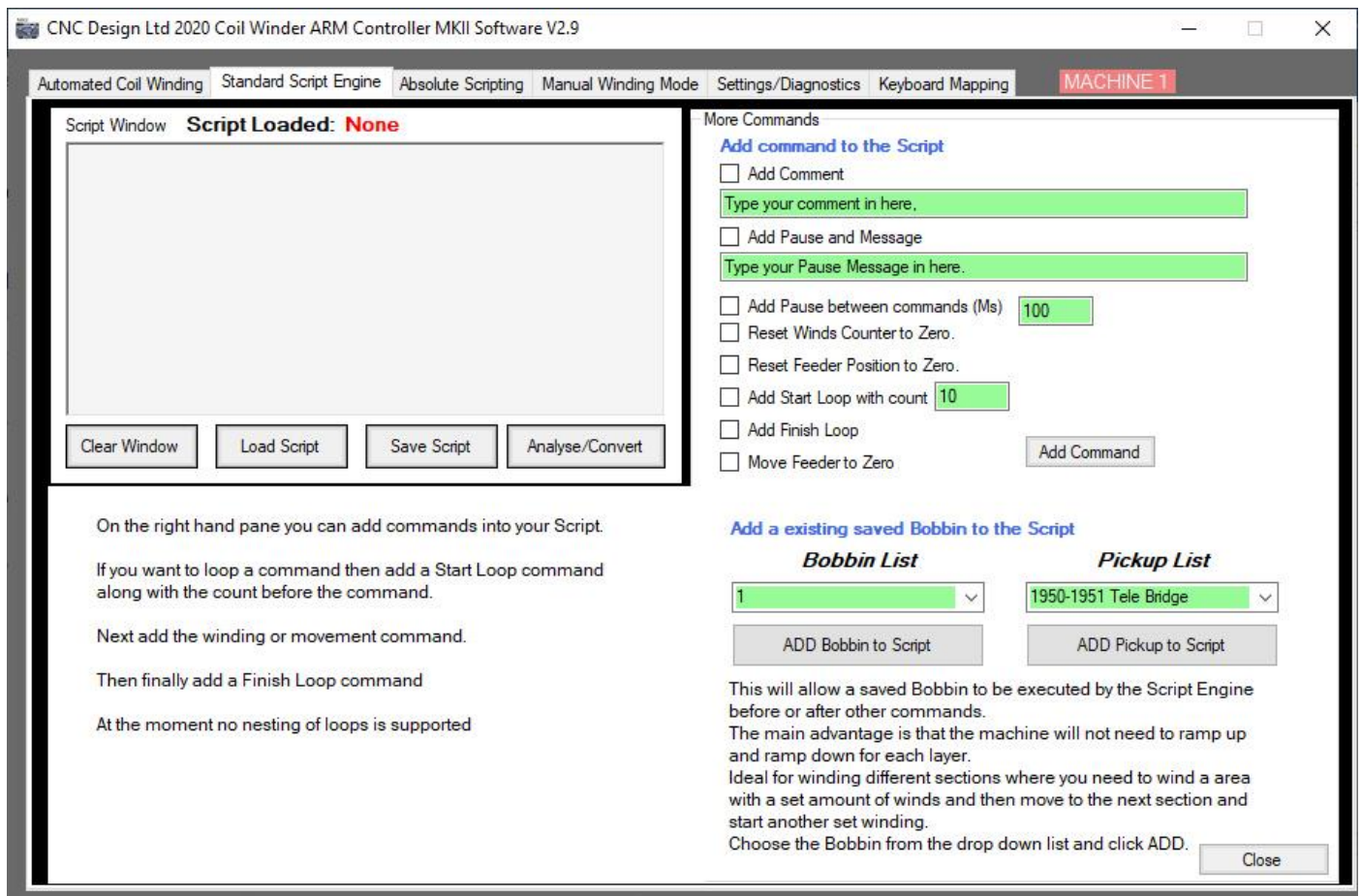
This variable that will tell the machine what speed you want the wire guide motor to run at.

Add Command button.

After setting all the other options above this button, you simply click this button to add the command to the script window.

Add Winding or Movement Commands button.

Clicking on this option brings up the panel below:



More Commands

Add command to the Script

☐ Add Comment

Type your comment in here.

☐ Add Pause and Message

Type your Pause Message in here.

☐ Add Pause between commands (Ms) 100

☐ Reset Winds Counter to Zero.

☐ Reset Feeder Position to Zero.

☐ Add Start Loop with count 10

☐ Add Finish Loop

☐ Move Feeder to Zero

Add Command

***comment** - Anything with a * in front of it will be treated as a comment.

M1-message -Pauses the script and allows a message to be displayed.

M2-Start Loop with Count – Start of loop command. Any commands inserted between the M2 and M3 commands will be repeated. In this example 10 times.

M3-Finish Loop – End of loop command.

M4-Zero Windings Counter – Zero the Total Windings counter

M5-Zero Feeder Position – Zero the Feeder Position.

M6-Pause100 – Pause between commands

M7-Move Feeder To Zero – Move Feeder to zero position.

Add Command button.

After setting all the other options above this button, you simply click this button to add the command/commands to the script window.

Add a existing saved Bobbin to the Script

<i>Bobbin List</i>	<i>Pickup List</i>
<div>1 ▾</div>	<div>1950-1951 Tele Bridge ▾</div>
<div>ADD Bobbin to Script</div>	<div>ADD Pickup to Script</div>

This will allow a saved Bobbin to be executed by the Script Engine before or after other commands.
The main advantage is that the machine will not need to ramp up and ramp down for each layer.
Ideal for winding different sections where you need to wind a area with a set amount of winds and then move to the next section and start another set winding.
Choose the Bobbin from the drop down list and click ADD.

Close

The Standard Scripting engine also allows saved bobbins from the Automated Tab section to be added as a Scripting command.

This is mainly for customers using the Scripting engine of the 200mm coil winder that need to place movement command when winding sections over the length of the coil.

They could have done this before, but using the Scripting Winding commands meant that they had to ramp up and ramp down for each layer.

So now they can wind a section of their coil with a saved bobbin and then move to the next section and wind that area with the same bobbin or a different one and no ramping between layers.

This also may be useful for people with the Mini Coil Winder that are using the Mixed TPL mode.

Instead of using Mixed TPL mode they could use the Scripting Engine and not have to worry about their layers being an integer as it has a Move Feeder to Zero option or if you know your finish position then you could enter a movement command to move the feeder to the next start position.

Ideal for winding different sections where you need to wind a area

with a set amount of winds and then move to the next section and start another set winding.

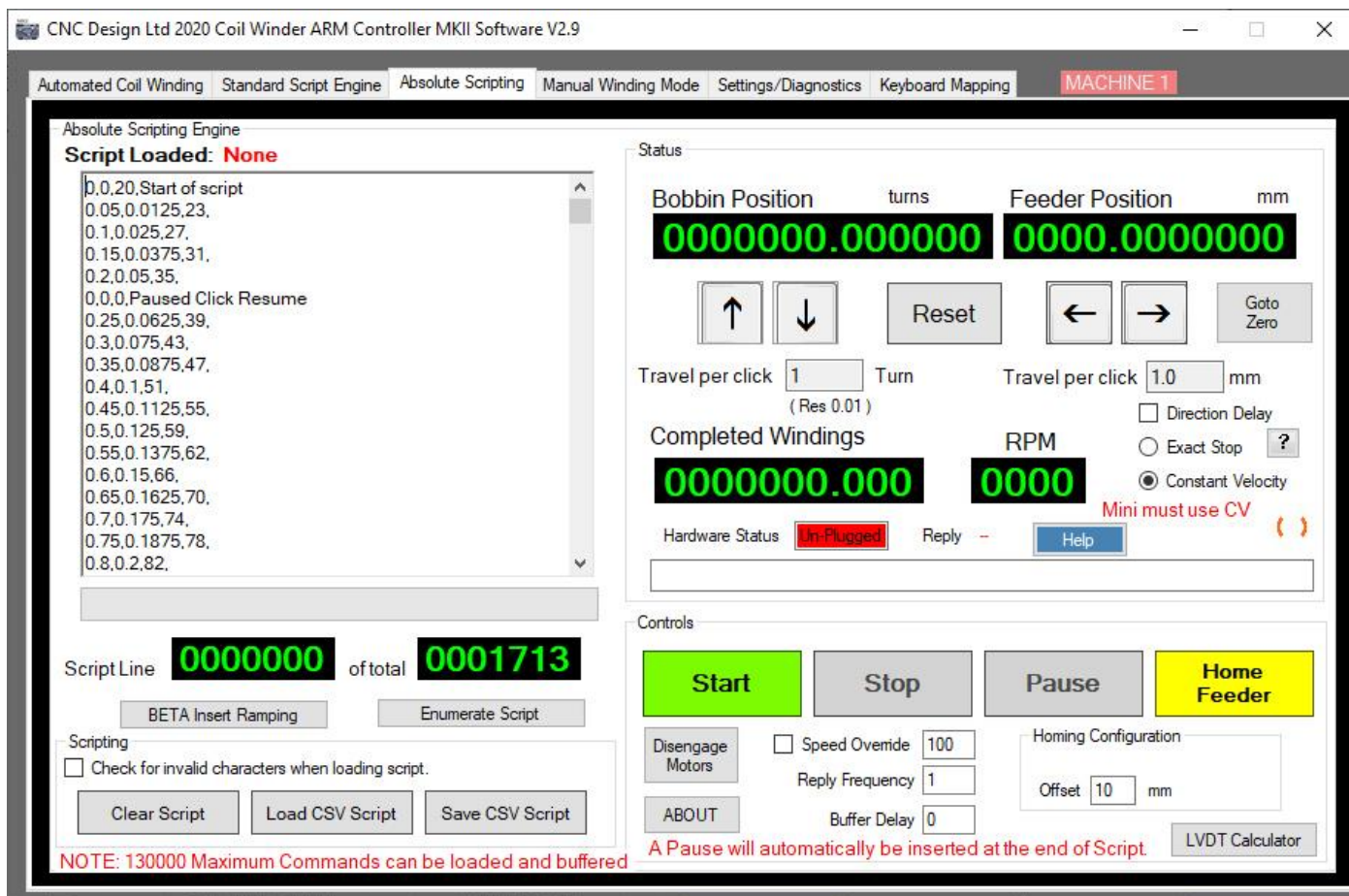
Choose the Bobbin from the drop-down list and click **ADD**.

Absolute Scripting Mode – Tab

With the new ARM Controller MKII, we have now on-board Flash memory that can be used for buffering loads of small commands. This removes any small delays that can be caused by the USB communications latency.

Unlike the Standard Scripting Engine which is Incremental positioning for each command, this is absolute positioning on each command.

For example if you set the bobbin position to be 10.00 and feeder position to be 5.00 in a command (10.00,5.00,100,) then it will rotate the bobbin 10 times and move the feeder by 5mm. If you then send a command (11.00,6.00,100,) it will move the bobbin by 1 turn and the feeder by 1mm, at a speed of 100 RPM.

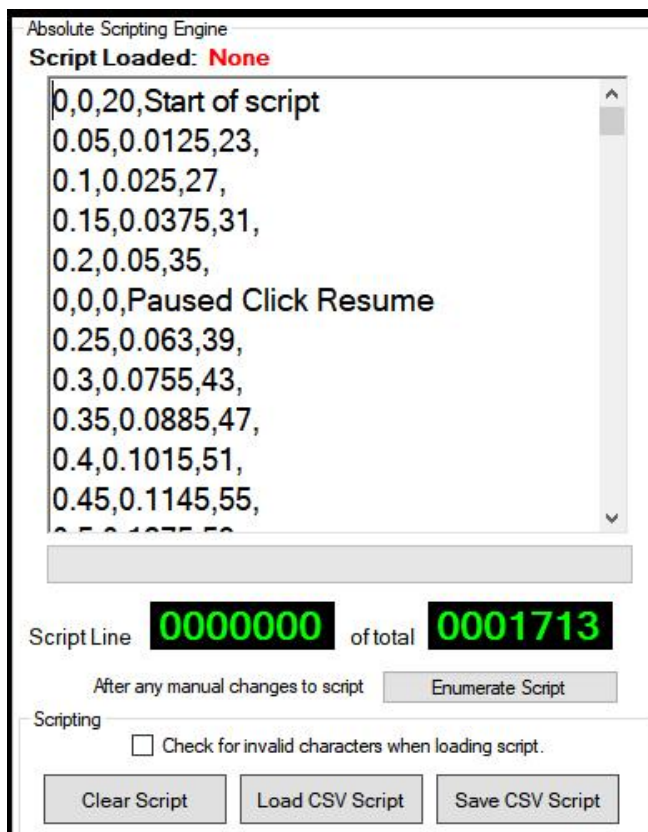


The scripts can be created in Excel spreadsheet and saved as a CSV file. This can then be loaded into the script window. The format for each command is:

Bobbin position, Feeder position, Speed, Comment

If the bobbin, feeder and speed are set to zero (0,0,0,Paused) then the script will pause and display the comment.

You will need to create your own ramping if required as shown in the example.



The **Absolute Scripting** panel has the following objects.

Script Line display.

Displays which line of the script is being executed out of the total number of lines loaded.

Clear Script button.

Clears the current window and deletes your script. If it has not been saved beforehand then you will not be able to recover it.

Load Script button.

Loads a CSV script from the computers file system into the script window.

Save Script button.

Saves the script in the Script Windows to the computers file system and allows you to choose where to save it and what filename to call it.

Enumerate Script button.

After manually editing the script in the window, you will need to enumerate it by clicking this button.

The check for invalid characters should not now be needed and was there while we were testing. But handy to check if your script file has any hidden characters in there.

Status

Bobbin Position	turns	Feeder Position	mm
0000000.000000		0000.0000000	

↑

↓

Reset

←

→

Goto Zero

Travel per click	<input type="text" value="1"/>	Turn	Travel per click	<input type="text" value="1.0"/>	mm
	(Res 0.01)				

Completed Windings

0000000.000

RPM

0000

☐ Direction Delay
☐ Exact Stop ?
☒ Constant Velocity

Mini must use CV ()

Hardware Status Un-Plugged

Reply --

Help

The **Status** panel has the following objects.

Bobbin Position display.

Displays the position of the bobbin on the machine.

Feeder Position display.

Displays the position of the feeder arm on the machine.

Completed Windings display.

Displays the amount of winding that have been wound.

RPM display.

Displays the speed that the bobbin motor is running at.

Reset button.

Pressing this button will reset the bobbin and feeder position to zero.

Reverse button.

This is a manual jog for the bobbin motor and when clicked the bobbin motor will move in the reverse direction.

Forward button.

This is a manual jog for the bobbin motor and when clicked the bobbin motor will move in the forward direction.

Left button.

This is a manual jog for the feeder arm and when clicked the feeder arm will move to the left.

Right button.

This is a manual jog for the feeder arm and when clicked the feeder arm will move to the right.

Feeder Travel per click variable.

Sets the travel in millimetres that the feeder arm will move if either the **Left** or **Right** buttons are clicked.

Bobbin Travel per click variable.

Sets the amount of revolutions that the bobbin motor will move if either the **Forward** or **Reverse** buttons are clicked.

Controls

Start	Stop	Pause	Home Feeder
Disengage Motors	<input type="checkbox"/> Speed Override	100	Homing Configuration Offset <input type="text" value="10"/> mm
ABOUT	Reply Frequency	1	
	Buffer Delay	0	
A Pause will automatically be inserted at the end of Script.			
			LVDT Calculator

The **Control** panel has the following objects

Start button.

Clicking this button starts the buffering routine first and once all the commands are buffered to the controller, then it will start winding.

Stop button.

Clicking this button stops the winding routine.

Pause/Resume button.

While winding is in progress and you wanted to pause the machine then click this button. It will then turn to a flashing Resume status and clicking it again will allow the machine to carry on from where it was paused.

Because of the nature of the absolute scripting, it is not possible to use ramping. So again this should only be used at low speeds.

Home button.

This can only be used if there are limit/homing switches installed on the machine. Based on the variable set in the **Homing Configuration** will determine the distance that the feeder arm will travel away from the limit switch once it has been triggered.

Speed Override checkbox.

If checked then the speed is ignored in the script and it will use the value set. You have no ramping when this is selected, so only suitable for low speeds.

Reply Frequency box.

Due to the speed and small movements, it can sometimes not be possible to receive replies back from the controller as quick as they are being executed and you could get some stalling or lockups. We recommend keeping this set to 2 or above.

Buffer Delay box.

It seems that Microsoft changed it's USB routines/drivers since releasing Windows 10 build 1803 and this has caused some issues with Absolute Scripting and the buffering routine when writing commands to the Flash Memory of the ARM Controller.

If you find you have issues with the buffering or any weird outcome from your script then change this buffer delay value to 20 or above.

Homing Configuration group box.

Sets the offset distance that the feeder arm will move away from the limit switch when the **Home** button is clicked.

For example, if it is set to 10mm then when the **Home** button is clicked the feeder arm will move to the left until it gets to the limit switch on the machine. It will then move to the right 10mm.

By ticking the **Use Homing Offset on Start** option will cause the machine to home when the Start button has been clicked. The machine will then home before the winding starts.

This option is only available for machines with the homing/limit switches installed.

Disengage Motors button.

When click this will disengage the motors so they can be turned by hand.

The motors will automatically re-engage when start or jog buttons are clicked.

You will not be able to disengage the motors when paused, but if you need to move the motors at this point, then simply turn the power off to the motors via the switch. Do the adjustments and then turn the power back on before pressing resume in the software.

ABOUT button.

This will display a short description of the commands, but also allow you to load a sample script when the button is clicked.

Absolute Scripting Format

CLOSE

With this scripting engine you can load up a CSV file which has the format of Bobbin Position, Feeder Position, Speed, Comment

Example
100.00,50.000,100,Comment
102.00,55.000,100,Comment

Load Sample Script

Move bobbin 100 turns(100 winds), move feeder to 50mm(50mm move)
At a speed of 100RPM
Move bobbin 102 turns(2 winds), move feeder to 55mm(5mm move)
At a speed of 100RPM

This absolute position for each command.
Setting Speed to 0 will pause and ignore that command.

Buffer Mode Can only be used with MKII ARM Controller

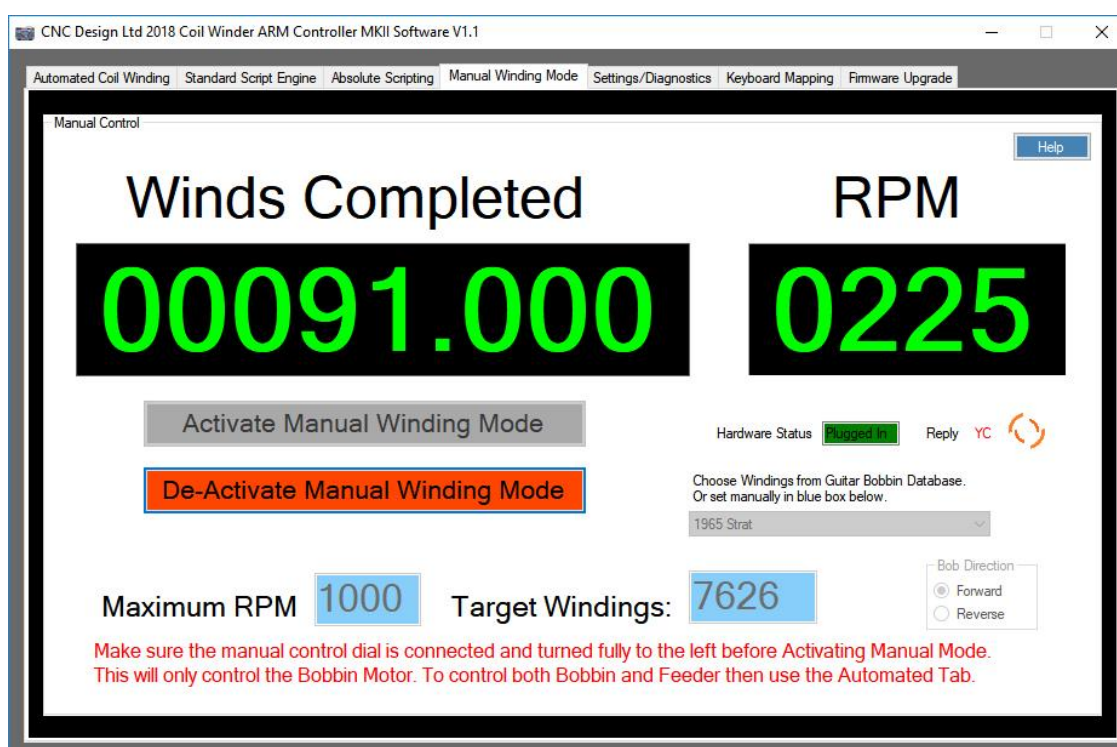
Manual Winding Mode – Tab

This mode is for people wishing to use their machine for semi-automatic winding of guitar pickups.

This will only turn the bobbin motor and control will be handed over to the manual controller, which must be connected to the controller box.

The manual controller dial needs to be fully turned to the left before it will start to wind and the speed of the bobbin motor and feeder arm will increase or decrease depending on the position of the dial.

Ramping will be disabled for this mode as not needed and it will be down to control of the user to make sure the speed is controlled so no jamming of the motors will occur.



Activate Manual Winding Mode button

This will start the winding routine.

DeActivate Manual Winding Mode button

This will stop the winding routine.

Target Windings variable.

This is the amount of windings you wish the machine to do.

It can be set manually by clicking on the blue input box and entering a number or using the drop down box and choosing from a previously saved pickup bobbin.

Bobbin Direction group box.

Sets the direction of the bobbin motor for this command.

Winds Completed display.

Displays the amount of winding that have been wound.

RPM display.

Displays the speed that the bobbin motor is running at.

Reply is the answer coming back from the Coil Winding Machine after each command is sent.

Hardware Status shows if the Coil Winding Machine is connected or not connected to the computer.

Settings/Diagnostics – Tab

CNC Design Ltd 2020 Coil Winder ARM Controller MKII Software V2.9

Automated Coil Winding Standard Script Engine Absolute Scripting Manual Winding Mode Settings/Diagnostics Keyboard Mapping MACHINE 1

Please do not touch these settings unless you know what you are doing.

Settings

Wire Guide Motor

PPmm Resolution Current Config: **200mm Coil Winder MK5**

Bobbin Motor

Frequency SPBR Wire Guide Jog Speed mm/min Pause Boundary mm

Feeder Motor

Frequency Resolution SPFR BSP

☐ Enable Timeout Alert Timeout seconds ☒ Enable Command Pause Pause Mseconds

☒ Limit Switches Installed ☒ Emergency Stop Installed ☐ Reverse Bobbin Motor ☐ Reverse Feeder Motor ☒ Safety Hood Installed ☒ 3rd Axis Installed

Automated Coil Winding Standard Bobbins

Feed Settings

Bobbin Jog Speed RPM Hz

Feeder Jog Speed RPM Hz

Homing Seek Feed RPM Hz

Homing Seek Offset mm

Limit Trigger travel mm

Diagnostics - This has been included for support reasons

DB Out	Bobbin Motor Freq	FBD	Feeder Motor Freq	FFD
<input type="text" value="01100011"/>	<input type="text" value="3333.333332"/>	<input type="text" value="33.33333332"/>	<input type="text" value="833.333333"/>	<input type="text" value="8.33333333"/>
DD Out	BFQ Raw LSB	BDFQ Raw LSB	FFQ Raw LSB	FDFQ Raw LSB
<input type="text" value="99"/>	<input type="text" value="894784"/>	<input type="text" value="8947.84852975415"/>	<input type="text" value="223696"/>	<input type="text" value="2236.96213243851"/>
Raw RPM Feedback	BCP	Base Speed	FCP	Calculated RPM
<input type="text" value=""/>	<input type="text" value="400000"/>	<input type="text" value="3333.333332"/>	<input type="text" value="100000"/>	<input type="text" value=""/>
Fram Buffer count	Fram sector	Buffer Counter	Reset Flash	Switch Out
<input type="text" value=""/>	<input type="text" value=""/>	<input type="text" value="0"/>	<input type="button" value="Reset Flash"/>	<input type="text" value="255"/>

Firmware

Change Colours

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This tab has a mixture of settings and also diagnostics displays.

The diagnostic displays you do not have to really worry about and more there for trouble shooting if needed.

Below we will go through the settings that can be changed to suit your machine and any add-ons you use.

Settings

Wire Guide Motor

PPmm Resolution Current Config: **200mm Coil Winder MK5**

Bobbin Motor

Frequency SPBR Wire Guide Jog Speed mm/min Pause Boundary mm

Feeder Motor

Frequency Resolution SPFR BSP

☐ Enable Timeout Alert Timeout seconds ☒ Enable Command Pause Pause Mseconds

☒ Limit Switches Installed ☒ Emergency Stop Installed ☐ Reverse Bobbin Motor ☐ Reverse Feeder Motor ☒ Safety Hood Installed ☒ 3rd Axis Installed

Automated Coil Winding Standard Bobbins

Wire Guide PPmm variable.

For machines with a 3rd Axis installed, this will be the Pulses Per 1mm of movement.

Wire Guide Resolution display.

Displays the resolution of the Wire Guide.

Wire Guide Jog Speed variable.

Sets the movement speed of the Wire Guide.

Current Config display.

This displays what configuration has been detected when the machine is plugged into your computer or displays what has been manually set.

Choose Machine button.

This will launch the startup screen and allow you to change machine type.

Backup button.

This backs up all the bobbins and all the settings for all tabs within the software and allows you to save as a .REG file.

If you move the software onto a new machine then make sure you use this button to back up the settings and then copy the .REG file over to your new computer.

Next just double click the .REG file and follow the instructions on the screen.

When you launch the software on the new machine it should pick up all the settings.

Bobbin Motor Frequency display.

This value is automatically calculated on the value of the SPBR variable.

Bobbin Motor SPBR variable.

This variable sets the Steps Per Bobbin Revolution needed to suit the Coil Winding Machine attached to your computer.

Feeder Resolution display.

Displays the resolution of the feeder arm.

This value is automatically calculated on the value of the SPFR variable and BSP variable.

SPBR variable.

This variable sets the Steps Per Feeder Revolution needed to suit the Coil Winding Machine attached to your computer.

BSP variable.

This variable sets the Ballscrew Set Pitch needed to suit the Coil Winding Machine attached to your computer.

Pause Boundary variable

If the pause button is used near the start of each layer and at the end of each layer then it can throw either the position read off or not complete the pause.

This is because when the Pause key is clicked when winding and there is not enough travel left in the winding for a ramp down and then a ramp up after pause.

By the default the Pause boundary is 1.0mm into the wind and the width of bobbin minus 1.0mm.

Set Default Startup variable

Sets which tab should display on start-up of the software.

Enable Timeout Alert checkbox

Enables the command timeout value for communications. If no reply has come back to the software from the controller in the value entered, then it will cause an alert box to be displayed. Used for de-bugging any issues and usually left unchecked.

Enable Command Pause checkbox

Enables the pause between commands sent from the Standard Scripting Engine. This is useful if small commands are sent and you need to slow it down to avoid communication conflicts.

Limit Switches installed checkbox

If you have installed the limit/homing and emergency stop kit onto your Coil Winder then you need to check this option to let the software know. It will then enable the homing features of the software.

Emergency Stop installed checkbox

If you have installed the limit/homing and emergency stop kit onto your Coil Winder then you need to check this option to let the software know. It will then enable the extra features of the software.

Reverse Bobbin Motor checkbox

Will reverse the direction of the bobbin motor to suit motor attached to your machine.

Reverse Feeder Motor checkbox

Will reverse the direction of the feeder motor to suit motor attached to your machine.

Safety Hood checkbox.

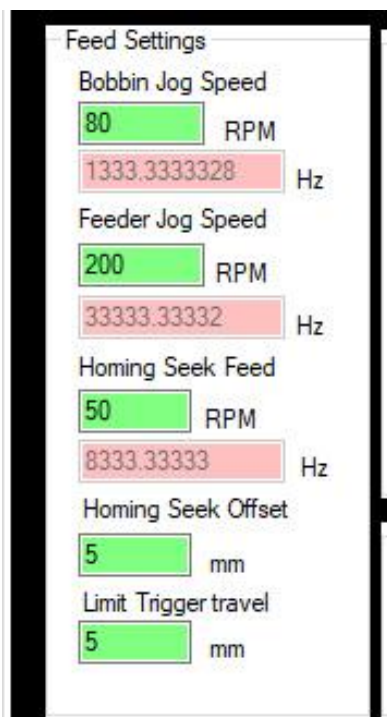
For use on machines that have a hood fitted.

3rd Axis Installed checkbox.

For machines that have a 3rd Axis installed such as the wire guid eon the 200mm MK5 machine.

Save button.

Saves the settings that have been set in all the variables above if using a Custom Configuration.



The screenshot shows a 'Feed Settings' window with several input fields. Each field has a green box for the value and a red box for the unit. The settings are as follows:

Variable	Value	Unit
Bobbin Jog Speed	80	RPM
	1333.333328	Hz
Feeder Jog Speed	200	RPM
	33333.33332	Hz
Homing Seek Feed	50	RPM
	8333.33333	Hz
Homing Seek Offset	5	mm
Limit Trigger travel	5	mm

Bobbin Jog Speed variable.

Sets the speed of the bobbin motor when using the Jog buttons. This is set in RPM.

Feeder Jog Speed variable.

Sets the speed of the feeder arm motor when using the Jog buttons. This is set in frequency, rather than RPM.

Homing Seek Feed variable.

Sets the speed of the Feeder motor when homing is at the seek stage. This is set in RPM.

When the Homing button is clicked in the software, the feeder will move to the limit switch and when triggered it will move away from the limit switch and then back again for another trigger. This is known as the seek stage and is used so that the feeder always ends up in the same position even though the initial homing speed can vary.

Homing Seek Offset variable.


Sets the offset distance that the feeder will travel away from the limit switch when in seek stage.

Limit Trigger Travel variable.

If you accidentally trigger a limit switch then the controller will alert the software and move the feeder away from the limit switch. This is the travel distance that the feeder would move once triggered.

Diagnostics - This has been included for support reasons and generally you do not have to worry or even need to know the outputs being displayed.

DB Out 11111111	Bobbin Motor Freq 0	FBD 79.999999968	Feeder Motor Freq 0	FFD 79.999999968
DD Out 255	BFQ Raw LSB 0	BDFQ Raw LSB 21474.836471410	FFQ Raw LSB 0	FDFQ Raw LSB 21474.836471410
Raw RPM Feedback	BCP 0	Base Speed 7999.9999968	FCP 0	Calculated RPM
Fram Buffer count	Fram sector	Buffer Counter 0	Reset Flash	Switch Out 255



The only control on the middle section is the **Reset Flash** button.

This is only to be used when installing a new Flash Chip on the controller board. It then resets the counters on the controller and initialises the new memory installed.

The other display boxes are for information when diagnosing any issues.

Firmware Firmware CNC Design Ltd Coil Winder ARM Controller MKII V1.1	Change Colours Background Foreground Border Reset to Default	Info http://www.ukcnc.net CNCDesign Limited Copyright 2018
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At the bottom of the tab we also have some other settings.

Firmware button.

When clicked it displays the current Firmware of the connected Coil Winding Machine.

Under the **Change Colours** group box we have:

Background button.

Changes the background colour of each tab.

Foreground button.

Changes the foreground colour of each tab.

Border button.

Changes the border colour of each tab.

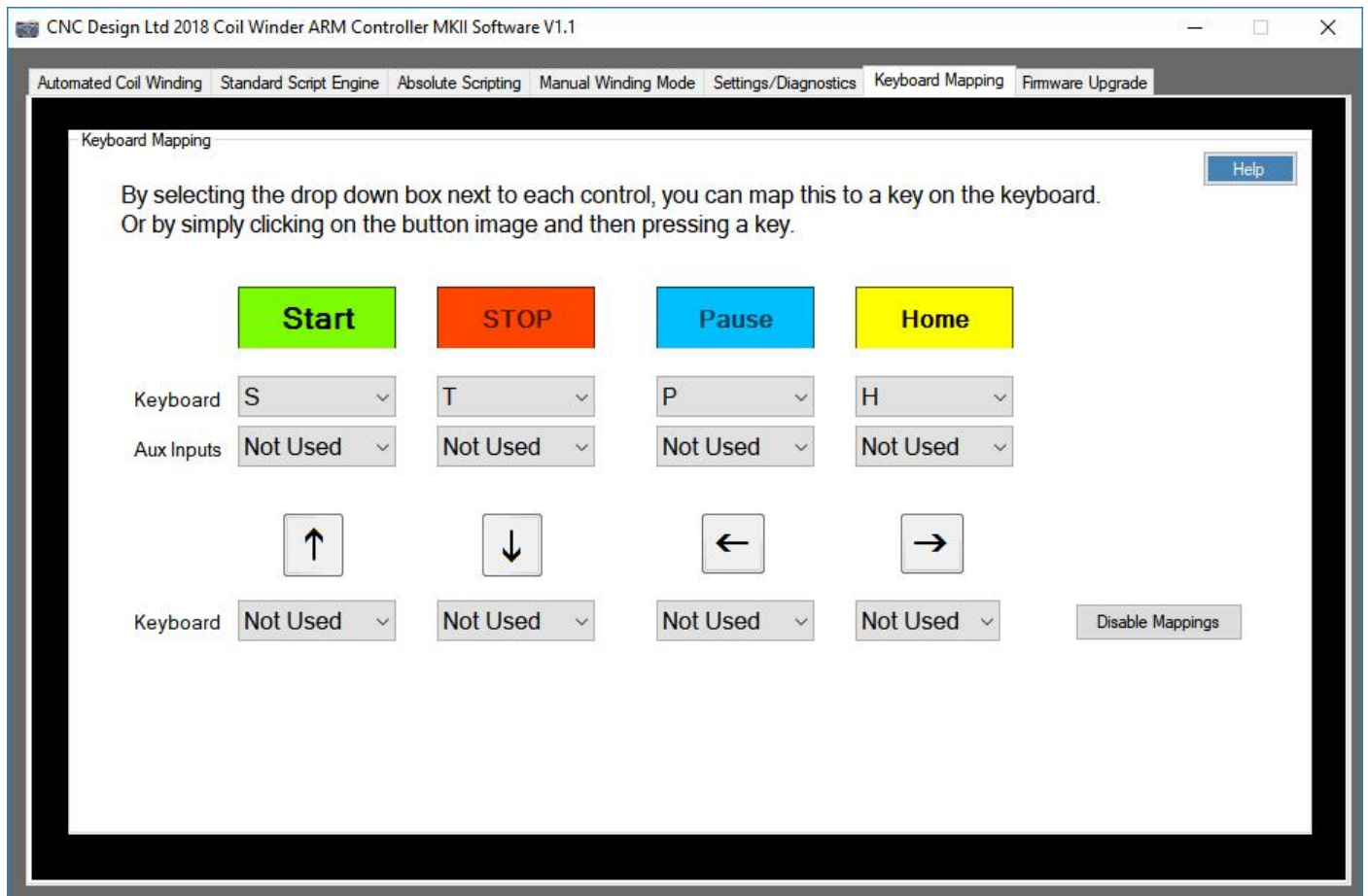
Reset to Default button.

Sets all colours back to the original style.

Info box.

Clicking on URL will take you to product web page.

Keyboard Mapping – Tab



This tab lets you map keyboard keys to the buttons within the software.

By selecting the drop-down box next to each control, you can map this to a key on the keyboard. Or by simply clicking on the button image and then pressing a key.

Also these keys can be mapped to inputs on the controller board that have switches attached.

Upgrading the Firmware.

With the new ARM Controller MKII you can no longer upgrade the firmware via the software and will need to use a JTAG programmer that is supplied with the machine.

Please check the download area of our website for the full instructions, depending on what machine you have.

<http://www.ukcnc.net/index.php/downloads/>