Primeros Pasos
V2.10.0-pre0-5383-gac7e5a07aa

Índice general

El Equipo de LinuxCNC

This handbook is a work in progress. If you are able to help with writing, editing, or graphic preparation please contact any member of the writing team or join and send an email to emc-users@lists.sourceforge

Capítulo 1

About LinuxCNC

1.1. The Software

* LinuxCNC (the Enhanced Machine Control) is a software system for computer control of machine tools such as milling machines and lathes, robots such as puma and scara and other computer controlled machines up to 9 axes. * LinuxCNC es un software gratuito con código fuente abierto. Las versiones actuales de LinuxCNC están completamente licenciadas bajo la Licencia Pública General de GNU (GPL) y Licencia Pública General Reducida (LGPL). * LinuxCNC provides: **easy discovery and testing without installation with the LiveCD,** easy installation from the Live CD, **easy to use graphical configuration wizards to rapidly create a configuration specific to the machine,** directly available as regular packages of recent releases of Debian (since Bookworm) and Ubuntu (since Kinetic Kudu), **a graphical user interface (actually several interfaces to choose from),** a graphical interface creation tool (Glade), **an interpreter for *G-code* (the RS-274 machine tool programming language),** a realtime motion planning system with look-ahead, **operation of low-level machine electronics such as sensors and motor drives,** an easy to use *breadboard* layer for quickly creating a unique configuration for your machine, ** un PLC en software programable con diagramas de escalera. * No proporciona herramientas de dibujo (CAD - Diseño asistido por computadora) ni funciones de generación de código G a partir de dibujos (CAM - Fabricación automatizada por computadora). * Puede mover simultáneamente hasta 9 ejes y admite una variedad de interfaces. * The control can operate true servos (analog or PWM) with the feedback loop closed by the LinuxCNC software at the computer, or open loop with step-servos or stepper motors. * Motion control features include: cutter radius and length compensation, path deviation limited to a specified tolerance, lathe threading, synchronized axis motion, adaptive feedrate, operator feed override, and constant velocity control. * El soporte para sistemas de movimiento no cartesianos se proporciona mediante módulos cinemáticos personalizados. Las arquitecturas disponibles incluyen hexapodos (plataformas Stewart y conceptos similares) y sistemas con articulaciones rotativas para proporcionar movimiento como robots PUMA o SCARA. * LinuxCNC runs on Linux using real time extensions.

1.2. The Operating System

LinuxCNC is available as ready-to-use packages for the Ubuntu and Debian distributions.

1.3. Getting Help

1.3.1. IRC

IRC stands for Internet Relay Chat. It is a live connection to other LinuxCNC users. The LinuxCNC IRC channel is #linuxcnc on libera.chat.

The simplest way to get on the IRC is to use the embedded web client client from libera.

Some IRC etiquette

- Ask specific questions… Avoid questions like "Can someone help me?".
- If you're really new to all this, think a bit about your question before typing it. Make sure you give enough information so someone can answer your question or solve your problem.
- Have some patience when waiting for an answer. Sometimes it takes a while to formulate an answer, or everyone might be busy working or something.
- Set up your IRC account with your unique name so people will know who you are. If you use the java client, use the same name every time you log in. This helps people remember who you are. If you have been on before, many will remember past discussions with you which will save time on both ends.

Sharing Files
The most common way to share files on the IRC is to upload the file to one of the following or a similar service and paste the link:

- *Para texto*: https://pastebin.com/, https://gist.github.com/, https://0bin.net, https://paste.debian.net/-

- *Para imágenes*: https://imagebin.org/, https://imgur.com/, https://bayimg.com/
- *Para archivos*: https://filedropper.com/, http://filefactory.com/, http://1fichier.com/

1.3.2. Mailing List

An Internet Mailing List is a way to put questions out for everyone on that list to see and answer at their convenience. You get better exposure to your questions on a mailing list than on the IRC but answers take longer. In a nutshell you e-mail a message to the list and either get daily digests or individual replies back depending on how you set up your account.

Puede suscribirse a la lista de correo emc-users en: https://lists.sourceforge.net/lists/listinfo/emc-users.

1.3.3. Web Forum

A web forum can be found at https://forum.linuxcnc.org/ or by following the link at the top of the https://linuxcnc.org/ home page.

This is quite active but the demographic is more user-biased than the mailing list. If you want to be sure that your message is seen by the developers then the mailing list is to be preferred.

1.3.4. LinuxCNC Wiki

A Wiki site is a user maintained web site that anyone can add to or edit.

El sitio Wiki LinuxCNC mantenido por usuarios contiene abundante información y consejos en http://wiki.linu
.

1.3.5. Bug Reports

Report bugs to the LinuxCNC github bug tracker.

Capítulo 2

System Requirements

2.1. Minimum Requirements

Los requerimientos mínimos de hardware para ejecutar LinuxCNC en Debian / Ubuntu pueden variar dependiendo del uso que se le dará al sistema. Los sistemas basados en motores a pasos requieren procesadores mas rápidos para generar trenes de pulsos en comparación con los servomecanismos retroalimentados. Usando el Live CD, usted puedes probar el software antes de instalarlo en la computadora. Tenga en cuenta que los resultados del test de latencia son mas importantes que la velocidad del procesador para la generación de pasos por software. Encontrara mas información sobre el test de latencia aqui. Además, LinuxCNC debe ejecutarse en un sistema operativo que utiliza un kernel especialmente modificado, ver Requisitos de versión y kernel.

Additional information is on the LinuxCNC Wiki site: Hardware Requirements

LinuxCNC and Debian Linux should run reasonably well on a computer with the following minimum hardware specification. These numbers are not the absolute minimum but will give reasonable performance for most stepper systems.

- 700 MHz x86 processor (1.2 GHz x86 processor recommended) or Raspberry Pi 4 or better.
- LinuxCNC 2.8 or later from the Live CD expects a 64-bit capable system.
- 512 MB of RAM, 4 GB with GUI to avoid surprises
- No hard disk for Live CD, 8 GB or more for permanent installation
- Graphics card capable of at least 1024x768 resolution, which is not using the NVidia or ATI fglrx proprietary drivers. Modern onboard graphic chipsets seem to generally be OK.
- Internet connection (not strictly needed, but very useful for updates and for communicating with the LinuxCNC community)

Minimum hardware requirements change as Linux distributions evolve so check the Debian web site for details on the Live CD you're using. Older hardware may benefit from selecting an older version of the Live CD when available.

If you plan not to rely on the distribution of readily executable programs ("binaries") and/or aim at contributing to the source tree of LinuxCNC, then there is a good chance you want a second computer to perform the compilation. Even though LinuxCNC and your developments could likely be executed at the same time with respect to disk space, RAM and even CPU speed, a machine that is busy will have worse latencies, so you are unlikely to compile your source tree and produce chips at the same time.

2.2. Kernel and Version requirements

LinuxCNC requiere un kernel modificado para uso con tiempo real para controlar hardware real de máquinas. Sin embargo, puede ejecutarse en un núcleo estándar en modo de simulación para fines tales como verificar el código G, probar archivos de configuración y aprendizaje del sistema. Para trabajar con estas versiones de kernel se distribuyen dos versiones de LinuxCNC. Los nombres de los paquetes son "linuxcnc" y "linuxcnc-uspace".

The realtime kernel options are preempt-rt, RTAI and Xenomai.

Puede descubrir la versión del kernel de su sistema con el comando:

```
uname -a
```

Si ve (como arriba) `-rt-` en el nombre del kernel, entonces está ejecutando el preempt-rt kernel y debería instalar la versión "uspace" de LinuxCNC. También debe instalar uspace para configuraciones "sim" en kernels que no son en tiempo real.

If you see `-rtai-` in the kernel name then you are running RTAI realtime. See below for the LinuxCNC version to install.

2.2.1. Preempt-RT with *linuxcnc-uspace* package

Preempt-RT is the newest of the realtime systems, and is also the version that is closest to a mainline kernel. Preempt-RT kernels are available as precompiled packages from the main repositories. The search term "PREEMPT_RT" will find them, and one can be downloaded and installed just like any other package. Preempt-RT will generally have the best driver support and is the only option for systems using the Mesa ethernet-connected hardware driver cards. In general preempt-rt has the worst latency of the available systems, but there are exceptions.

2.2.2. RTAI with *linuxcnc* package

RTAI ha sido el pilar de las distribuciones LinuxCNC durante muchos años. Generalmente dará el mejor rendimiento en tiempo real, en términos de baja latencia, pero podría tener un soporte de periféricos pobre y no tantas resoluciones de pantallas. Un Kernel RTAI está disponible desde el repositorio de paquetes de LinuxCNC. Si instaló desde la imagen Live/Install, el cambio de núcleo y sabor de LinuxCNC se describe en [Installing-RTAI].

2.2.3. Xenomai with *linuxcnc-uspace* package

Xenomai is also supported, but you will have to find or build the kernel and compile LinuxCNC from source to utilise it.

2.2.4. RTAI with *linuxcnc-uspace* package

It is also possible to run LinuxCNC with RTAI in user-space mode. As with Xenomai you will need to compile from source to do this.

2.3. Problematic Hardware

2.3.1. Laptops

Laptops are not generally suited to real time software step generation. Again a Latency Test run for an extended time will give you the info you need to determine suitability.

2.3.2. Video Cards

If your installation pops up with 800 x 600 screen resolution then most likely Debian does not recognize your video card or monitor. This can sometimes be worked-around by installing drivers or creating / editing Xorg.conf files.

Capítulo 3

Getting LinuxCNC

This section describes the recommended way to download and make a fresh install of LinuxCNC. There are also Alternate Install Methods for the adventurous. If you have an existing install that you want to upgrade, go to the Updating LinuxCNC section instead.

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To operate machinery LinuxCNC requires a special kernel with real-time extensions. There are three possibilities here: preempt-rt, RTAI or Xenomai. In addition there are two versions of LinuxCNC which work with these kernels. See the table below for details. However for code testing and simulation it is possible to run the `linuxcnc-uspace` application on a stock kernel of the distribution.

Fresh installs of LinuxCNC are most easily created using the Live/Install Image. This is a hybrid ISO filesystem image that can be written to a USB storage device or a DVD and used to boot a computer. At boot time you will be given a choice of booting the "Live" system (to run LinuxCNC without making any permanent changes to your computer) or booting the Installer (to install LinuxCNC and its operating system onto your computer's hard drive).

The outline of the process looks like this:

1. Download the Live/Install Image.

2. Write the image to a USB storage device or DVD.

3. Boot the Live system to test out LinuxCNC.

4. Boot the Installer to install LinuxCNC.

3.1. Download the image

This section describes some methods for downloading the Live/Install image.

3.1.1. Normal Download

Software for LinuxCNC to download is presented on the project's Downloads page. Most users will aim for the disk image for Intel/AMD PCs, the URL will resemble https://www.linuxcnc.org/iso/linuxcnc_2.9.7-amd64.hybrid.iso.

For the Raspberry Pi, multiple images are provided to address differences between the RPi4 and RPi5.

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Do not use the regular Raspbian distribution for LinuxCNC that may have shipped with your RPi starter kit - that will not have the real-time kernel and you cannot migrate from Raspbian to Debian's kernel image.

3.1.2. Download using zsync

zsync is a download application that efficiently resumes interrupted downloads and efficiently transfers large files with small modifications (if you have an older local copy). Please note, it needs to use the http protocol, not https. Use zsync if your download of the image using the Normal Download method is frequently interrupted.

zsync in Linux

1. Install zsync using Synaptic or, by running the following in a terminal

   ```
   sudo apt-get install zsync
   ```

2. Then run this command to download the iso to your computer

   ```
   zsync http://www.linuxcnc.org/iso/linuxcnc_2.9.4-amd64.hybrid.iso
   ```

Please remember to confirm the checksum of the downloaded iso as described below, since the authenticity of the server is not guaranteed with the http protocol.

zsync in Windows Hay una versión Windows de zsync. Funciona como una aplicación de consola y puede ser descargado desde https://www.assembla.com/spaces/zsync-windows/documents .

3.1.3. Verify the image

(This step is unnecessary if you used zsync)

1. After downloading, verify the checksum of the image to ensure integrity.

```
md5sum linuxcnc-2.9.7-amd64.iso
```

ó

```
sha256sum linuxcnc-2.9.7-amd64.iso
```

1. Then compare to these checksums

```
amd64 (PC)
md5sum: 1815aceaac0e7861747aa34d61846e79
sha256sum: 08b3f59233e47c91cf1c9a85c41df48542c97b134efefa7446d3060c9a3e644b
arm64 (Pi)
md5sum: 4547e8a72433efb033f0a5cf166a5cd2
sha256sum: ff3ba9b8dfb93baf1e2232746655f8521a606bc0fab91bffc04ba74cc3be6bf0
```

Verify md5sum on Windows or Mac Windows and Mac OS X do not come with an md5sum program, but there are alternatives. More information can be found at: How To MD5SUM

3.2. Write the image to a bootable device

The LinuxCNC Live/Install ISO Image is a hybrid ISO image which can be written directly to a USB storage device (flash drive) or a DVD and used to boot a computer. The image is too large to fit on a CD.

3.2.1. Raspberry Pi Image

La imagen Raspberry Pi es una imagen de tarjeta SD completa y debería escribirse en una tarjeta SD con la aplicación Raspberry Pi Imager.

3.2.2. AMD-64 (x86-64, PC) Image using GUI tools

Download and install Balena Etcher from https://etcher.balena.io/#download-etcher (Linux, Windows, Mac) and write the downloaded image to a USB drive.

If your image fails to boot then please also try Rufus. It looks more complicated but seems to be more compatible with various BIOSes.

3.2.3. Command line - Linux

1. Connect a USB storage device (for example a flash drive or thumb drive type device).

2. Determine the device file corresponding to the USB flash drive. This information can be found in the output of `sudo dmesg` after connecting the device. `cat /proc/partitions` may also be helpful.

3. Use the `dd` command to write the image to your USB storage device. For example, if your storage device showed up as `/dev/sde`, then use this command:

   ```
   dd if=linuxcnc_2.9.7-amd64.hybrid.iso of=/dev/sde bs=4k status=progress
   ```

3.2.4. Command line - MacOS

1. Abra una ventana de terminal teclee

   ```
   diskutil list
   ```

2. Inserte el USB y anote el nombre del nuevo disco que aparece, p. Ej. /dev/disk5.

3. Desmonte el USB. El número encontrado arriba debe ser sustituido en lugar de la N.

   ```
   diskutil unmountDisk /dev/diskN
   ```

4. Transfiera los datos con dd, como en Linux. Tenga en cuenta que el nombre del disco tiene una "r" agregada al principio.

   ```
   sudo dd if=linuxcnc_2.9.7-amd64.hybrid.iso of=/dev/rdiskN bs=1m
   ```

5. Note that this may take a long time to complete and there will be no feedback during the process.

Writing the image to a DVD in Linux

1. Insert a blank DVD into your burner. A *CD/DVD Creator* or *Choose Disc Type* window will pop up. Close this, as we will not be using it.

2. Browse to the downloaded image in the file browser.

3. Right click on the ISO image file and choose Write to Disc.

4. Select the write speed. It is recommended that you write at the lowest possible speed.

5. Start the burning process.

6. If a *choose a file name for the disc image* window pops up, just pick OK.

Writing the image to a DVD in Windows

1. Descargue e instale Infra Recorder, un programa de grabación de imagen gratuito de codigo abierto: https://infrarecorder.org/ .

2. Insert a blank CD in the drive and select Do nothing or Cancel if an auto-run dialog pops up.

3. Open Infra Recorder, and select the *Actions* menu, then *Burn image*.

Writing the image to a DVD in Mac OSX

1. Download the .iso file

2. Right-click on the file in the Finder window and select "Burn to disc". (The option to burn to disc will only appear if the machine has an optical drive fitted or connected.)

3.3.   Testing LinuxCNC

With the USB storage device plugged in or the DVD in the DVD drive, shut down the computer then turn the computer back on. This will boot the computer from the Live/Install Image and choose the Live boot option.

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nota
If the system does not boot from the DVD or USB stick, it may be necessary to change the boot order in the PC BIOS.

Una vez que el ordenador se haya iniciado, puede probar LinuxCNC sin instalarlo. No puede crear configuraciones personalizadas o modificar la mayoría de ajustes del sistema en una sesión en vivo, pero puede (y debe) correr el test de latencia.

Para probar LinuxCNC: desde el menú Aplicaciones/CNC, seleccione LinuxCNC. Se abrirá un cuadro de diálogo desde el cual puede elegir una de entre muchas configuraciones de muestra. En este punto, solo tiene sentido elegir una configuración "sim". Algunas de las configuraciones de muestra incluyen en pantalla máquinas simuladas en 3D, busque "Vismach" para verlas.

To see if your computer is suitable for software step pulse generation run the Latency Test as shown here.

At the time of writing the Live Image is only available with the preempt-rt kernel and a matching LinuxCNC. On some hardware this might not offer good enough latency. There is an experimental version available using the RTAI realtime kernel which will often give better latency.

3.4. Installing LinuxCNC

To install LinuxCNC from the Live CD select *Install (Graphical)* at bootup.

3.5. Updates to LinuxCNC

With the normal install the Update Manager will notify you of updates to LinuxCNC when you go on line and allow you to easily upgrade with no Linux knowledge needed. It is OK to upgrade everything except the operating system when asked to.

> ⚠ **aviso**
> Do not upgrade the operating system to a new version if prompted to do so. You should accept OS *updates* however, especially security updates.

3.6. Install Problems

In rare cases you might have to reset the BIOS to default settings if during the Live CD install it cannot recognize the hard drive during the boot up.

3.7. Alternate Install Methods

The easiest, preferred way to install LinuxCNC is to use the Live/Install Image as described above. That method is as simple and reliable as we can make it, and is suitable for novice users and experienced users alike. However, this will typically replace any existing operating system. If you have files on the target PC that you want to keep, then use one of the methods described in this section.

In addition, for experienced users who are familiar with Debian system administration (finding install images, manipulating apt sources, changing kernel flavors, etc), new installs are supported on following platforms: ("amd64" means "64-bit", and is not specific to AMD processors, it will run on any 64-bit x86 system)

Distribution	Architecture	Kernel	Package name	Typical use
Debian Bookworm	amd64 & arm64	preempt-rt	linuxcnc-uspace	machine control & simulation
Debian Bookworm	amd64	RTAI	linuxcnc	machine control
Debian Bullseye	amd64	preempt-rt	linuxcnc-uspace	machine control & simulation
Debian Buster	amd64 & arm64	preempt-rt	linuxcnc-uspace	machine control & simulation
Debian Buster	amd64	RTAI	linuxcnc	machine control
Any	Any	Stock	linuxcnc-uspace	simulation ONLY

> **nota**
> LinuxCNC v2.9 no es compatible con Debian 9 o versiones anteriores.

Preempt-RT kernels The Preempt-rt kernels are available for Debian from the regular debian.org archive. The package is called `linux-image-rt-*`. Simply install the package in the same way as any other package from the Synaptic Package manager or with apt-get at the command-line.

RTAI Kernels The RTAI kernels are available for download from the linuxcnc.org debian archive. The apt source is:

- Debian Bookworm: `deb https://linuxcnc.org bookworm base`

- Debian Bullseye: `deb https://linuxcnc.org bullseye base`

- Debian Buster: `deb https://linuxcnc.org buster base`

LinuxCNC and the RTAI kernel are now only available for 64-bit OSes but there are very few surviving systems that can not run a 64-bit OS.

3.7.1. Installing on Debian Bookworm (with Preempt-RT kernel)

1. Install Debian Bookworm (Debian 12), amd64 version. You can download the installer here: https://www.debian.org/distrib/

2. After burning the iso and booting up if you don't want Gnome desktop select *Advanced Options > Alternative desktop environments* and pick the one you like. Then select *Install* or *Graphical Install*.

   ⚠️ **aviso**
   Do not enter a root password, if you do sudo is disabled and you won't be able to complete the following steps.

   ---

3. Run the following in a terminal to bring the machine up to date with the latest packages.

   ```
   sudo apt-get update
   sudo apt-get dist-upgrade
   ```

   ---

   nota
   It is possible to download a version of LinuxCNC directly from Debian but this will install an old pre-release version, and is not recommended at this time.

   ---

4. Install the Preempt-RT kernel and modules

   ```
   sudo apt-get install linux-image-rt-amd64
   ```

5. Re-boot, and select the Linux 6.1.0-10-rt-amd64 kernel. The exact kernel version might be different, look for the "-rt" suffix. This might be hidden in the "Advanced options for Debian Bookworm" sub-menu in Grub. When you log in, verify that `PREEMPT RT` is reported by the following command.

   ```
   uname -v
   ```

6. Open Applications Menu > System > Synaptic Package Manager search for *linux-image* and right click on the original non-rt and select *Mark for Complete Removal*. Reboot. This is to force the system to boot from the RT kernel. If you prefer to retain both kernels then the other kernels need not be deleted, but grub boot configuration changes will be needed beyond the scope of this document.

7. Add the LinuxCNC Archive Signing Key to your apt keyring by downloading [the LinuxCNC installer script](https://www.linuxcnc.org/linuxcnc-install.sh). You will need to make the script executable to run it:

```
chmod +x linuxcnc-install.sh
```

Then you can run the installer:

```
sudo ./linuxcnc-install.sh
```

3.7.2. Installing on Debian Bookworm (with experimental RTAI kernel)

1. Esta versión del kernel y LinuxCNC se puede instalar encima de una instalación Live DVD o, alternativamente, en una nueva instalación de Debian Bookworm de 64 bits como se describió anteriormente.

2. You can add the LinuxCNC archive signing key and repository information by downloading and running the installer script as described above. If an RTAI kernel is detected it will stop before installing any packages.

3. Actualice la lista de paquetes desde linuxcnc.org

```
sudo apt-get update
```

4. Remove the existing uspace version of LinuxCNC and install the new realtime kernel, RTAI and the RTAI-version of LinuxCNC.

```
sudo apt-get purge linuxcnc-uspace
sudo apt-get purge linuxcnc-doc*
sudo apt-get install linuxcnc
```

Reboot the machine, ensuring that the system boots from the new 5.4.258-rtai kernel.

3.7.3. Installing on Raspbian 12

Don't do that. The latencies are too bad with the default kernel and the PREEMPT_RT (the RT is important) kernel of Debian does not boot on the Pi (as of 1/2024). Please refer to the .iso images provided online on the regular LinuCNC download page. You can create them yourself following the scripts provided online.

Capítulo 4

Running LinuxCNC

4.1. Invoking LinuxCNC

After installation, LinuxCNC starts just like any other Linux program: run it from the terminal by issuing the command *linuxcnc*, or select it in the *Applications -> CNC* menu.

4.2. Configuration Launcher

When starting LinuxCNC (from the CNC menu or from the command line without specifying an INI file) the Configuration Selector dialog starts.

The Configuration Selector dialog allows the user to pick one of their existing configurations (My Configurations) or select a new one (from the Sample Configurations) to be copied to their home directory. Copied configurations will appear under My Configurations on the next invocation of the Configuration Selector.

The Configuration Selector offers a selection of configurations organized:

- *Mis configuraciones* - Configuraciones de usuario ubicadas en linuxcnc/configs en tu directorio home.

- *Configuraciones de ejemplo* - Estas configuraciones, cuando se seleccionan, se copian en linuxcnc/configs. Una vez que copie una configuración a su directorio local, el lanzador lo ofrecerá como *Mis configuraciones*. Los nombres bajo los cuales se presentan dichas configuraciones locales corresponden al de los directorios dentro del directorio configs/:

  - *sim* - Configurations that include simulated hardware. These can be used for testing or learning how LinuxCNC works.
  - *by_interface* - Configurations organized by GUI.
  - *by_machine* - Configurations organized by machine.
  - *apps* - Applications that do not require starting linuxcnc but may be useful for testing or trying applications like PyVCP or GladeVCP.
  - *attic* - Obsolete or historical configurations.

The sim configurations are often the most useful starting point for new users and are organized around supported GUIs:

- *axis* - Keyboard and Mouse GUI

- *craftsman* - Touch Screen GUI (no longer maintained ???)
- *gmoccapy* - Touch Screen GUI
- *gscreen* - Touch Screen GUI
- *pyvcp_demo* - Panel de control virtual Python
- *qtaxis* - Touch Screen GUI, axis lookalike
- *qtdragon* - Touch Screen GUI
- *qtdragon_hd* - Touch Screen GUI, high definition
- *qtplasmac* - Touch Screen GUI, for plasma tables
- *qttouchy* - Touch Screen GUI
- *tklinuxcnc* - Keyboard and Mouse GUI (no longer maintained)
- *touchy* - Touch Screen GUI
- *woodpecker* - Touch Screen GUI

A GUI configuration directory may contain subdirectories with configurations that illustrate special situations or the embedding of other applications.

The *by_interface* configurations are organized around common, supported interfaces like:

- general mechatronics
- mesa
- parport
- pico
- pluto
- servotogo
- vigilant
- vitalsystems

Related hardware may be required to use these configurations as starting points for a system.

The *by_machine* configurations are organized around complete, known systems like:

- boss
- cooltool
- scortbot erIII
- sherline
- smithy
- tormach

A complete system may be required to use these configurations.

The *apps items* are typically either:

1. utilities that don't require starting linuxcnc

2. demonstrations of applications that can be used with linuxcnc

   ▪ info - crea un archivo con información del sistema que puede ser útil para diagnóstico de problemas.
   ▪ gladevcp - Example GladeVCP applications.
   ▪ halrun - Starts halrun in an terminal.
   ▪ latency - Applications to investigate latency
     • latency-histogram-1 - histogram for single servo thread
     • latency-histogram - histogram
     • latency-test - standard test
     • latency-plot - stripchart
   ▪ parport - Applications to test parport.
   ▪ pyvcp - Example pyvcp applications.
   ▪ xhc-hb04 - Applications to test an xhc-hb04 USB wireless MPG

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nota
Under the Apps directory, only applications that are usefully modified by the user are offered for copying to the user's directory.
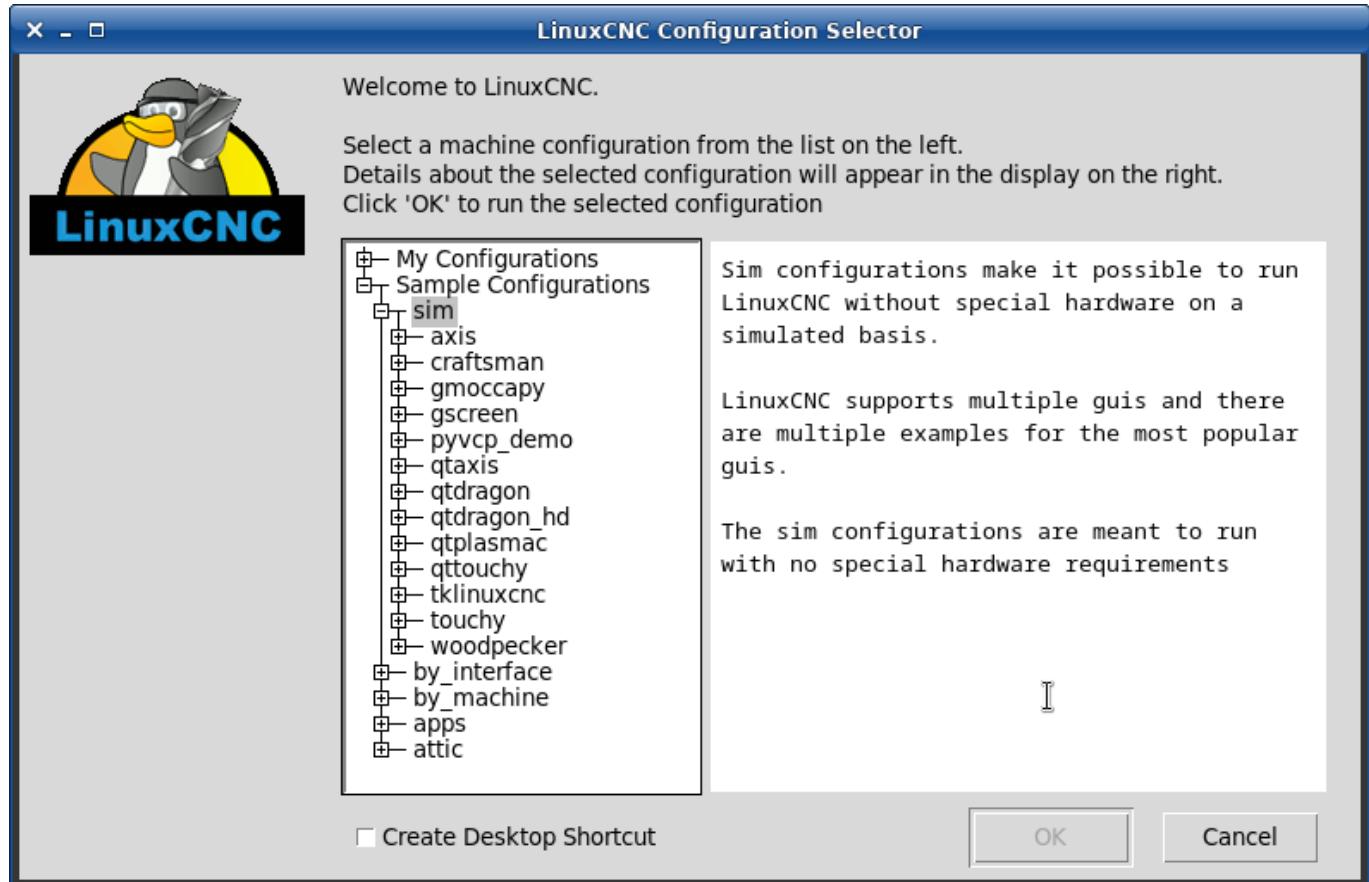

Figura 4.1: Selector de Configuración de LinuxCNC

Click any of the listed configurations to display specific information about it. Double-click a configuration or click OK to start the configuration.

Select *Create Desktop Shortcut* and then click *OK* to add an icon on the Ubuntu desktop to directly launch this configuration without showing the Configuration Selector screen.

When you select a configuration from the Sample Configurations section, it will automatically place a copy of that config in the ~/linuxcnc/configs directory.

4.3. Next steps in configuration

After finding the sample configuration that uses the same interface hardware as your machine (or a simulator configuration), and saving a copy to your home directory, you can customize it according to the details of your machine. Refer to the Integrator Manual for topics on configuration.

4.4. Simulator Configurations

All configurations listed under Sample Configurations/sim are intended to run on any computer. No specific hardware is required and real-time support is not needed.

These configurations are useful for studying individual capabilities or options. The sim configurations are organized according to the graphical user interface used in the demonstration. The directory for axis contains the most choices and subdirectories because it is the most tested GUI. The capabilities demonstrated with any specific GUI may be available in other GUIs as well.

4.5. Configuration Resources

The Configuration Selector copies all files needed for a configuration to a new subdirectory of ~/linuxcnc/configs (equivalently: /home/username/linuxcnc/configs). Each created directory will include at least one INI file (iniflename.ini) that is used to describe a specific configuration.

File resources within the copied directory will typically include one or more INI file (filename.ini) for related configurations and a tool table file (toolfilename.tbl). Additionally, resources may include HAL files (filename.hal, filename.tcl), a README file for describing the directory, and configuration specific information in a text file named after a specific configuration (inifilename.txt). That latter two files are displayed when using the Configuration Selector.

The supplied sample configurations may specify the parameter HALFILE (filename.hal) in the configuration INI file that are not present in the copied directory because they are found in the system HAL file library. These files can be copied to the user configuration directory and altered as required by the user for modification or test. Since the user configuration directory is searched first when finding HAL files, local modifications will then prevail.

The Configuration selector makes a symbolic link in the user configuration directory (named hallib) that points to the system HAL file library. This link simplifies copying a library file. For example, to copy the library core_sim.hal file in order to make local modifications:

```
cd ~/linuxcnc/configs/name_of_configuration
cp hallib/core_sim.hal core_sim.hal
```

Capítulo 5

Updating LinuxCNC

Actualizar LinuxCNCa una nueva versión menor (es decir, a una nueva versión en la misma serie estable, por ejemplo de 2.9.1 a 2.9.2) es un proceso automático si su PC esta conectada a internet . Verá un mensaje de actualización después del lanzamiento de una version menor nueva, junto con otras actualizaciones de software. Si no tiene internet en su PC vea Actualizando sin red.

5.1.   Upgrade to the new version

This section describes how to upgrade LinuxCNC from version 2.8.x to a 2.9.y version. It assumes that you have an existing 2.8 install that you want to update.

To upgrade LinuxCNC from a version older than 2.8, you have to first upgrade your old install to 2.8, then follow these instructions to upgrade to the new version.

If you do not have an old version of LinuxCNC to upgrade, then you're best off making a fresh install of the new version as described in the section Getting LinuxCNC.

Mas aún, si ejecuta Ubuntu Precise o Debian Wheezy vale la pena considerar hacer un respaldo del directorio "linuxcnc" en un medio extraible y realizar una instalación limpia de una versión mas reciente de SO y LinuxCNC ya que esas versiones terminaron su ciclo de vida en 2017 y 2018 respectivamente. Si esta ejecutando en Ubuntu Lucid entonces tendrá que hacer esto, ya que Lucid ya no es soportada por LinuxCNC (su ciclo de vida terminó en 2013).

To upgrade major versions like 2.8 to 2.9 when you have a network connection at the machine you need to disable the old linuxcnc.org apt sources in the file /etc/apt/sources.list and add a new linuxcnc.org apt source for 2.9, then upgrade LinuxCNC.

The details will depend on which platform you're running on. Open a terminal then type `lsb_release -ic` to find this information out:

```
lsb_release -ic
Distributor ID: Debian
Codename:       Buster
```

You should be running on Debian Buster, Bullseye or Bookworm or Ubuntu 20.04 "Focal Fossa" or newer. LinuxCNC 2.9.y will not run on older distributions than these.

You will also need to check which realtime kernel is being used:

```
uname -r
6.1.0-10-rt-amd64
```

Si ve (como arriba) `-rt-` en el nombre del kernel, entonces está ejecutando el preempt-rt kernel y debería instalar la versión "uspace" de LinuxCNC. También debe instalar uspace para configuraciones "sim" en kernels que no son en tiempo real.

If you see `-rtai-` in the kernel name then you are running RTAI realtime. See below for the LinuxCNC version to install. RTAI packages are available for Bookworm and Buster but not currently for Bullseye.

5.1.1. Apt Sources Configuration

- Open the `Software Sources` window. The process for doing this differs slightly on the three supported platforms:

  - Debian:
    - Haga clic en `Menú de aplicaciones`, luego en `Sistema`, luego en `Administrador de paquetes Synaptic`.
    - In Synaptic, click on the `Settings` menu, then click `Repositories` to open the `Software Sources` window.

  - Ubuntu Precise:
    - Click on the `Dash Home` icon in the top left.
    - In the `Search` field, type "software", then click on the `Ubuntu Software Center` icon.
    - In the Ubuntu Software Center window, click on the `Edit` menu, then click on `Software Sources...` to open the `Software Sources` window.

  - Ubuntu Lucid:
    - Click the `System` menu, then `Administration`, then `Synaptic Package Manager`.
    - In Synaptic, click on the `Settings` menu, then click on `Repositories` to open the `Software Sources` window.

- In the `Software Sources` window, select the `Other Software` tab.

- Delete or un-check all the old linuxcnc.org entries (leave all non-linuxcnc.org lines as they are).

- Click the `Add` button and add a new apt line. The line will be slightly different on the different platforms:

Cuadro 5.1: Tabular overview on variants of the Operating System and the corresponding configuration of the repository. The configuration can be performed in the GUI of the package manager or in the file /etc/apt/sources.list.

OS / Realtime Version	Repository
Debian Buster - preempt	deb https://linuxcnc.org buster base 2.9-uspace
Debian Buster - RTAI	deb https://linuxcnc.org buster base 2.9-rt
Debian Bullseye - preempt	deb https://linuxcnc.org bullseye base 2.9-uspace
Debian Bookworm - preempt	deb https://linuxcnc.org bookworm base 2.9-uspace
Debian Bookworm - RTAI	deb https://linuxcnc.org bookworm base 2.9-rt
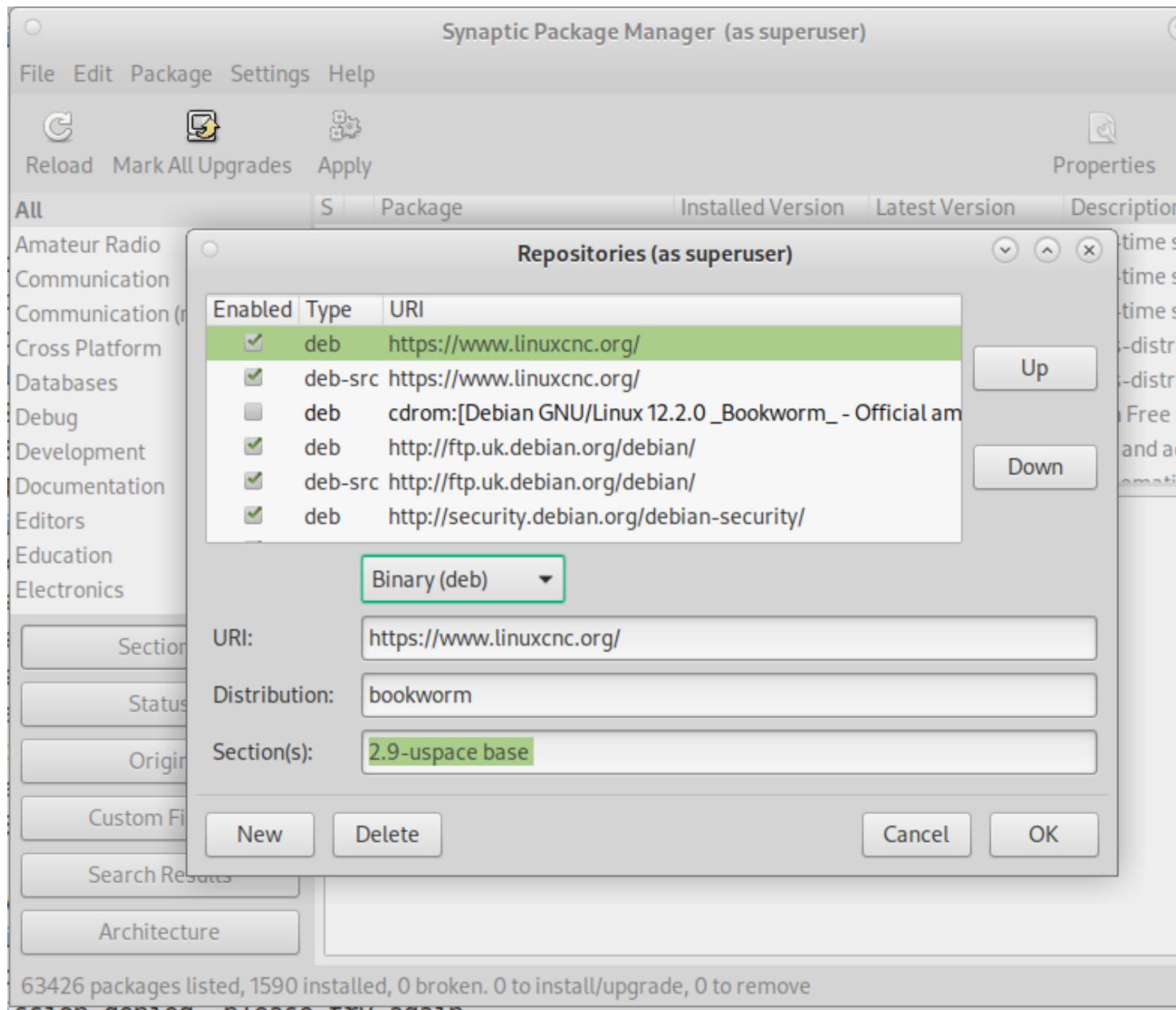
Figura 5.1: Figure with a screenshot of the repository configuration of the synaptic package manager.

- Click `Add Source`, then `Close` in the Software Sources window. If it pops up a window informing you that the information about available software is out-of-date, click the `Reload` button.

5.1.2. Upgrading to the new version

Ahora su computadora sabe dónde obtener la nueva versión del software. A continuación tenemos que instalarlo.

The process again differs depending on your platform.

5.1.2.1. Debian Buster, Bullseye and Bookworm

Debian uses the Synaptic Package Manager.

- Open Synaptic using the instructions in Setting apt sources above.

- Click the `Reload` button.

- Use the Search function to search for `linuxcnc`.

- The package is called "linuxcnc" for RTAI kernels and "linuxcnc-uspace" for preempt-rt.

- Click the check box to mark the new linuxcnc and linuxcnc-doc-* packages for upgrade. The package manager may select a number of additional packages to be installed, to satisfy dependencies that the new linuxcnc package has.

- Click the `Apply` button, and let your computer install the new package. The old linuxcnc package will be automatically upgraded to the new one.

5.1.3. Ubuntu

- Click on the `Dash Home` icon in the top left.

- In the `Search` field, type "update", then click on the `Update Manager` icon.

- Click the `Check` button to fetch the list of packages available.

- Click the `Install Updates` button to install the new versions of all packages.

5.2. Updating without Network

Para actualizar sin una conexión de red, necesita descargar un paquete .deb y luego instalarlo con dpkg. Los .deb se pueden encontrar en https://linuxcnc.org/dists/ .

Tiene que profundizar en el enlace anterior para encontrar el deb correcto para su instalación. Abra una terminal y escriba *lsb_release -ic* para encontrar el nombre de su sistema operativo.

```
> lsb_release -ic
Distributor ID: Debian
Codename:       bullseye
```

Pick the OS from the list then pick the major version you want like 2.9-rt for RTAI or 2.9-rtpreempt or 2.9-uspace for preempt-rt.

Next pick the type of computer you have: binary-amd64 for any 64-bit x86, binary-i386 for 32 bit, binary-armhf (32bit) or binary-arm64 (64bit) for Raspberry Pi.

A continuación, elija la versión que desee de la parte inferior de la lista como *linuxcnc-uspace_2.8.0_amd64.d* (elija la más reciente por su fecha). Descargue el deb y cópielo a su directorio de usuario. Puede cambiar el nombre del archivo a algo un poco más corto con el administrador de archivos, como *linuxcnc_2.8.0.deb*. Luego abra una terminal e instálelo con el gestor de paquetes con este comando:

```
sudo dpkg -i linuxcnc_2.9.2.deb
```

5.3. Updating Configuration Files for 2.9

5.3.1. Stricter handling of pluggable interpreters

If you just run regular G-code and you don't know what a pluggable interpreter is, then this section does not affect you.

A seldom-used feature of LinuxCNC is support for pluggable interpreters, controlled by the undocumented [TASK]INTERPRETER INI setting.

Versions of LinuxCNC before 2.9.0 used to handle an incorrect [TASK]INTERPRETER setting by automatically falling back to using the default G-code interpreter.

Since 2.9.0, an incorrect [TASK]INTERPRETER value will cause LinuxCNC to refuse to start up. Fix this condition by deleting the [TASK]INTERPRETER setting from your INI file, so that LinuxCNC will use the default G-code interpreter.

5.3.2. Canterp

If you just run regular G-code and you don't use the `canterp` pluggable interpreter, then this section does not affect you.

In the extremely unlikely event that you are using `canterp`, know that the module has moved from `/usr/lib/libcanterp.so` to `/usr/lib/linuxcnc/canterp.so`, and the [TASK]INTERPRETER setting correspondingly needs to change from `libcanterp.so` to `canterp.so`.

5.4. Updating Configuration Files (for 2.10.y)

Touchy: the Touchy MACRO entries should now be placed in a [MACROS] section of the INI rather than in the [TOUCHY] section. This is part of a process of commonising the INI setting between GUIs.

Capítulo 6

Glossary

A listing of terms and what they mean. Some terms have a general meaning and several additional meanings for users, installers, and developers.

Acme Screw
A type of lead-screw that uses an Acme thread form. Acme threads have somewhat lower friction and wear than simple triangular threads, but ball-screws are lower yet. Most manual machine tools use acme lead-screws.

Axis
One of the computer controlled movable parts of the machine. For a typical vertical mill, the table is the X axis, the saddle is the Y axis, and the quill or knee is the Z axis. Angular axes like rotary tables are referred to as A, B, and C. Additional linear axes relative to the tool are called U, V, and W respectively.

AXIS(GUI)
One of the Graphical User Interfaces available to users of LinuxCNC. It features the modern use of menus and mouse buttons while automating and hiding some of the more traditional LinuxCNC controls. It is the only open-source interface that displays the entire tool path as soon as a file is opened.

GMOCCAPY (GUI)
A Graphical User Interfaces available to users of LinuxCNC. It features the use and feel of an industrial control and can be used with touch screen, mouse and keyboard. It support embedded tabs and hal driven user messages, it offers a lot of hal beens to be controlled with hardware. GMOCCAPY is highly customizable.

Backlash
The amount of "play" or lost motion that occurs when direction is reversed in a lead screw. or other mechanical motion driving system. It can result from nuts that are loose on leadscrews, slippage in belts, cable slack, "wind-up" in rotary couplings, and other places where the mechanical system is not "tight". Backlash will result in inaccurate motion, or in the case of motion caused by external forces (think cutting tool pulling on the work piece) the result can be broken cutting tools. This can happen because of the sudden increase in chip load on the cutter as the work piece is pulled across the backlash distance by the cutting tool.

Backlash Compensation
Any technique that attempts to reduce the effect of backlash without actually removing it from the mechanical system. This is typically done in software in the controller. This can correct the final resting place of the part in motion but fails to solve problems related to direction changes while in motion (think circular interpolation) and motion that is caused when external forces (think cutting tool pulling on the work piece) are the source of the motion.

Ball Screw
A type of lead-screw that uses small hardened steel balls between the nut and screw to reduce friction. Ball-screws have very low friction and backlash, but are usually quite expensive.

Ball Nut
A special nut designed for use with a ball-screw. It contains an internal passage to re-circulate the balls from one end of the screw to the other.

CNC
Computer Numerical Control. The general term used to refer to computer control of machinery. Instead of a human operator turning cranks to move a cutting tool, CNC uses a computer and motors to move the tool, based on a part program.

Halcompile
A tool used to build, compile and install LinuxCNC HAL components.

Configuration(n)
A directory containing a set of configuration files. Custom configurations are normally saved in the users home/linuxcnc/configs directory. These files include LinuxCNC's traditional INI file and HAL files. A configuration may also contain several general files that describe tools, parameters, and NML connections.

Configuration(v)
The task of setting up LinuxCNC so that it matches the hardware on a machine tool.

Coordinate Measuring Machine
A Coordinate Measuring Machine is used to make many accurate measurements on parts. These machines can be used to create CAD data for parts where no drawings can be found, when a hand-made prototype needs to be digitized for moldmaking, or to check the accuracy of machined or molded parts.

Display units
The linear and angular units used for onscreen display.

DRO
A Digital Read Out is a system of position-measuring devices attached to the slides of a machine tool, which are connected to a numeric display showing the current location of the tool with respect to some reference position. DROs are very popular on hand-operated machine tools because they measure the true tool position without backlash, even if the machine has very loose Acme screws. Some DROs use linear quadrature encoders to pick up position information from the machine, and some use methods similar to a resolver which keeps rolling over.

EDM
EDM is a method of removing metal in hard or difficult to machine or tough metals, or where rotating tools would not be able to produce the desired shape in a cost-effective manner. An excellent example is rectangular punch dies, where sharp internal corners are desired. Milling operations can not give sharp internal corners with finite diameter tools. A *wire* EDM machine can make internal corners with a radius only slightly larger than the wire's radius. A *sinker* EDM can make internal corners with a radius only slightly larger than the radius on the corner of the sinking electrode.

EMC
The Enhanced Machine Controller. Initially a NIST project. Renamed to LinuxCNC in 2012.

EMCIO
The module within LinuxCNC that handles general purpose I/O, unrelated to the actual motion of the axes.

EMCMOT
The module within LinuxCNC that handles the actual motion of the cutting tool. It runs as a real-time program and directly controls the motors.

Encoder
A device to measure position. Usually a mechanical-optical device, which outputs a quadrature signal. The signal can be counted by special hardware, or directly by the parport with LinuxCNC.

Feed
Relatively slow, controlled motion of the tool used when making a cut.

Feed rate
The speed at which a cutting motion occurs. In auto or MDI mode, feed rate is commanded using an F word. F10 would mean ten machine units per minute.

Feedback
A method (e.g., quadrature encoder signals) by which LinuxCNC receives information about the position of motors.

Feedrate Override
A manual, operator controlled change in the rate at which the tool moves while cutting. Often used to allow the operator to adjust for tools that are a little dull, or anything else that requires the feed rate to be "tweaked".

Floating Point Number
A number that has a decimal point. (12.300) In HAL it is known as float.

Códigos G
The generic term used to refer to the most common part programming language. There are several dialects of G-code, LinuxCNC uses RS274/NGC.

GUI
Interfaz gráfica de usuario.

General
A type of interface that allows communications between a computer and a human (in most cases) via the manipulation of icons and other elements (widgets) on a computer screen.

LinuxCNC
An application that presents a graphical screen to the machine operator allowing manipulation of the machine and the corresponding controlling program.

HAL
Hardware Abstraction Layer. At the highest level, it is simply a way to allow a number of building blocks to be loaded and interconnected to assemble a complex system. Many of the building blocks are drivers for hardware devices. However, HAL can do more than just configure hardware drivers.

Home
A specific location in the machine's work envelope that is used to make sure the computer and the actual machine both agree on the tool position.

INI file
A text file that contains most of the information that configures LinuxCNC for a particular machine.

Instance
One can have an instance of a class or a particular object. The instance is the actual object created at runtime. In programmer jargon, the "Lassie" object is an instance of the "Dog" class.

Joint Coordinates
These specify the angles between the individual joints of the machine. See also Kinematics

Jog
Manually moving an axis of a machine. Jogging either moves the axis a fixed amount for each key-press, or moves the axis at a constant speed as long as you hold down the key. In manual mode, jog speed can be set from the graphical interface.

kernel-space
Code running inside the kernel, as opposed to code running in userspace. Some realtime systems (like RTAI) run realtime code in the kernel and non-realtime code in userspace, while other realtime systems (like Preempt-RT) run both realtime and non-realtime code in userspace.

Kinematics
The position relationship between world coordinates and joint coordinates of a machine. There are two types of kinematics. Forward kinematics is used to calculate world coordinates from joint coordinates. Inverse kinematics is used for exactly the opposite purpose. Note that kinematics does not take into account, the forces, moments etc. on the machine. It is for positioning only.

Lead-screw
An screw that is rotated by a motor to move a table or other part of a machine. Lead-screws are usually either ball-screws or acme screws, although conventional triangular threaded screws may be used where accuracy and long life are not as important as low cost.

Machine units
The linear and angular units used for machine configuration. These units are specified and used in the INI file. HAL pins and parameters are also generally in machine units.

MDI
Manual Data Input. This is a mode of operation where the controller executes single lines of G-code as they are typed by the operator.

NIST
National Institute of Standards and Technology. An agency of the Department of Commerce in the United States.

NML
Neutral Message Language provides a mechanism for handling multiple types of messages in the same buffer as well as simplifying the interface for encoding and decoding buffers in neutral format and the configuration mechanism.

Offsets
An arbitrary amount, added to the value of something to make it equal to some desired value. For example, G-code programs are often written around some convenient point, such as X0, Y0. Fixture offsets can be used to shift the actual execution point of that G-code program to properly fit the true location of the vice and jaws. Tool offsets can be used to shift the "uncorrected" length of a tool to equal that tool's actual length.

Part Program
A description of a part, in a language that the controller can understand. For LinuxCNC, that language is RS-274/NGC, commonly known as G-code.

Program Units
The linear and angular units used in a part program. The linear program units do not have to be the same as the linear machine units. See G20 and G21 for more information. The angular program units are always measured in degrees.

Python
General-purpose, very high-level programming language. Used in LinuxCNC for the Axis GUI, the StepConf configuration tool, and several G-code programming scripts.

Rapid
Fast, possibly less precise motion of the tool, commonly used to move between cuts. If the tool meets the workpiece or the fixturing during a rapid, it is probably a bad thing!

Rapid rate
The speed at which a rapid motion occurs. In auto or MDI mode, rapid rate is usually the maximum speed of the machine. It is often desirable to limit the rapid rate when testing a G-code program for the first time.

Real-time
Software that is intended to meet very strict timing deadlines. On Linux, in order to meet these requirements it is necessary to install a realtime kernel such as RTAI or Preempt-RT, and build the LinuxCNC software to run in the special real-time environment. Realtime software can run in the kernel or in userspace, depending on the facilities offered by the system.

RTAI
Real Time Application Interface, see https://www.rtai.org/, the real-time extensions for Linux that LinuxCNC can use to achieve real-time performance.

RTLINUX
See https://en.wikipedia.org/wiki/RTLinux, an older real-time extension for Linux that LinuxCNC used to use to achieve real-time performance. Obsolete, replaced by RTAI.

RTAPI
A portable interface to real-time operating systems including RTAI and POSIX pthreads with realtime extensions.

RS-274/NGC
The formal name for the language used by LinuxCNC part programs.

Servo Motor
Generally, any motor that is used with error-sensing feedback to correct the position of an actuator. Also, a motor which is specially-designed to provide improved performance in such applications.

Servo Loop
A control loop used to control position or velocity of an motor equipped with a feedback device.

Signed Integer
A whole number that can have a positive or negative sign. In HAL it is usually a s32, but could be also a s64.

Husillo
The part of a machine tool that spins to do the cutting. On a mill or drill, the spindle holds the cutting tool. On a lathe, the spindle holds the workpiece.

Spindle Speed Override
A manual, operator controlled change in the rate at which the tool rotates while cutting. Often used to allow the operator to adjust for chatter caused by the cutter's teeth. Spindle Speed Override assumes that the LinuxCNC software has been configured to control spindle speed.

StepConf
An LinuxCNC configuration wizard. It is able to handle many step-and-direction motion command based machines. It writes a full configuration after the user answers a few questions about the computer and machine that LinuxCNC is to run on.

Stepper Motor
A type of motor that turns in fixed steps. By counting steps, it is possible to determine how far the motor has turned. If the load exceeds the torque capability of the motor, it will skip one or more steps, causing position errors.

TASK
The module within LinuxCNC that coordinates the overall execution and interprets the part program.

Tcl/Tk
A scripting language and graphical widget toolkit with which several of LinuxCNCs GUIs and selection wizards were written.

Traverse Move
Un movimiento en línea recta desde el punto inicial hasta el punto final.

Unidades

See "Machine Units", "Display Units", or "Program Units".

Unsigned Integer

A whole number that has no sign. In HAL it is usually a u32 but could be also a u64.

World Coordinates

This is the absolute frame of reference. It gives coordinates in terms of a fixed reference frame that is attached to some point (generally the base) of the machine tool.

Capítulo 7

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