



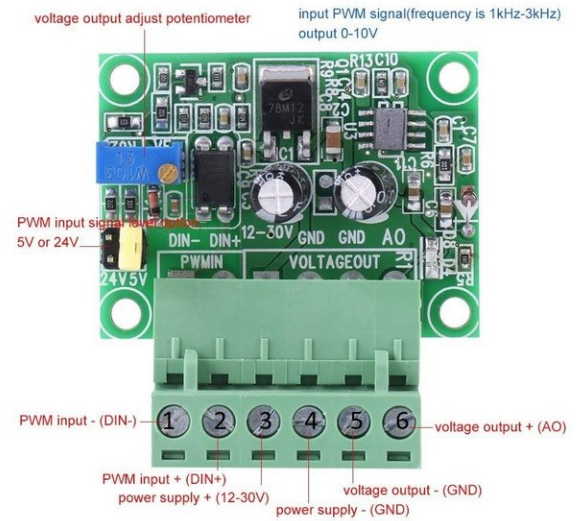
Connect a AMB Kress or Mafell spindle with digital control

Adding a spindle to the duet board that is able to run/stop/pause via gcode. AMB kress Mafell
Digital control

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Step 1 — Needed parts



- AMB Kress or Mafell spindle with digital control
- PWM to voltage 0-10V converter (see links)
- Small wiring cables suitable for 24V

voltage output adjust potentiometer

input PWM signal(frequency is 1kHz-3kHz)
output 0-10V

PWM input signal potentiometer
5V or 24V

24V 5V

12-30V

DIN- DIN+ GND GND AO

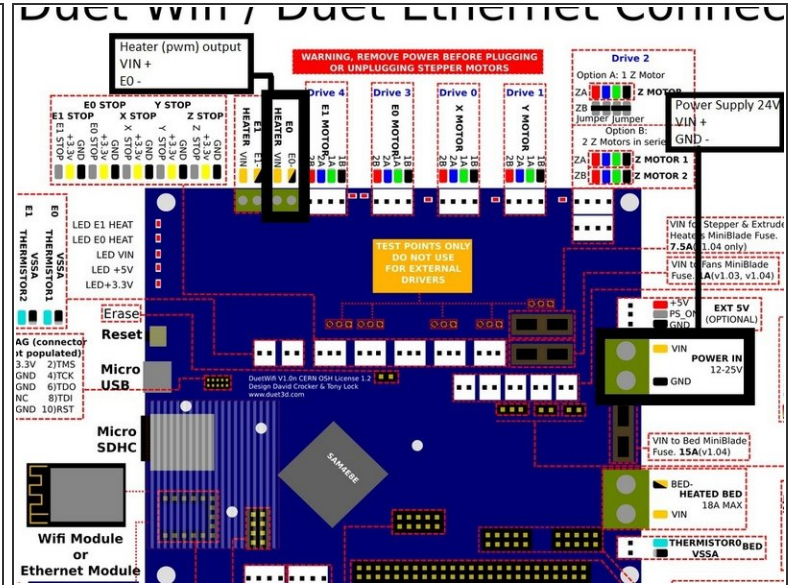
PWMIN VOLTAGEOUT

PWM input - (DIN-) 1 2 3 4 5 6 voltage output + (AO)

PWM input + (DIN+)
power supply + (12-30V)

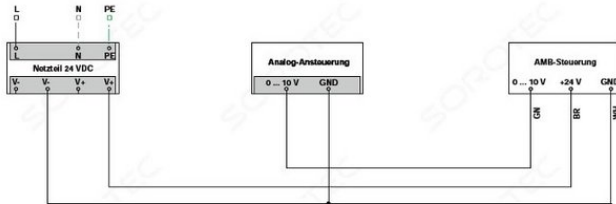
power supply - (GND)

voltage output - (GND)



- PWM converter has 4 inputs (2 power + 2 pwm input signals) and 2 outputs (0-10V voltage). Make sure the yellow jumper is on the 24V pins as we are using the duet pwm signal output which is 12/24V.
- Power wiring to the PWM converter
 - Connect the “VIN” power pin on the duet board (see image) to port 3 on the pwm converter “power supply + (12-30V)”
 - Connect the “GND” power pin on the duet board to port 4 on the pwm converter “power supply – (GND)”
- Pwm signal wiring to the pwm converter using HEATER E0 of the duet board
 - Connect “VIN” from heater E0 to port 2 “PWM input + (din+)” on the pwm converter
 - Connect “E0-” from heater E0 to port 1 “PWM input – (DIN-)” on the pwm converter

Step 3 — Installation diagram




- Other than the power supply cable 110V/220V, the spindle has 3 small cables:
- BROWN 10-26V DC (for power supply)
- GREEN 0-10V DC (for speed control)
- WHITE 0 V (for ground/GND)

Step 4 — Wiring the spindle



- **Brown** to “VIN” connector of the duet power supply pin
- **Green** to port 6 “voltage output + (AO)” of the pwm converter
- **White** to port 5 “voltage output – (GND)” of the pwm converter
- Connect port 5 “voltage output – (GND)” of the pwm converter to the “GND” pin of the power supply on the duet board

 **THE LAST STEP (port 5 to GND pin duet) IS REALLY IMPORTANT! You create a**

common ground between the spindle and pwm converter/power supply

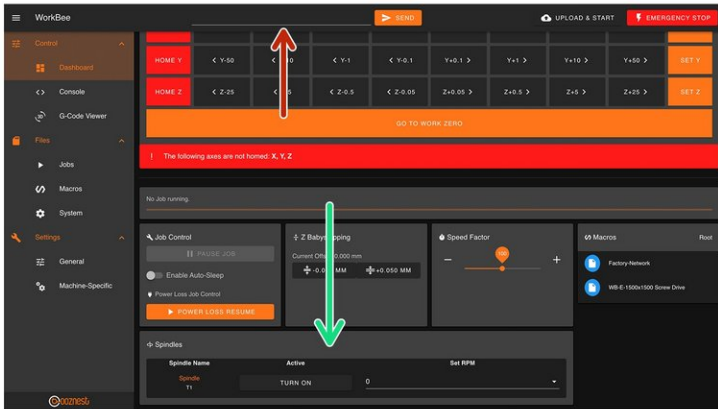
Step 5 — Programming



```
0:/sys/config-spindle.g
1 ; Laser configuration executed by config.g
2
3 M950 R0 C"e0heat" L0:25000 Q100
4 M563 P1 S"Spindle" R0
5
```

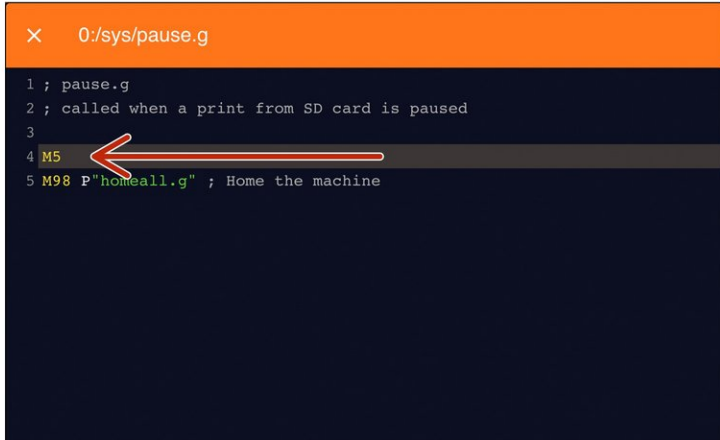
- Under File Management > System click on 'config-spindle.g'. Then add the following lines
 - M950 R0 C"e0heat" L0:25000 Q100
 - ❖ L is the minimum and maximum RPM of your Spindle. Adjust accordingly.
 - ❖ Q is the frequency. If your spindle keeps fluctuating at lower rpms, change the frequency to 300. If it still keeps fluctuating, change it to 320 or 350 and so on.
 - M563 P1 S"Spindle" R0
- ⚠ Press the software emergency stop in the top right corner to restart the controller.

Step 6 — Speed Control

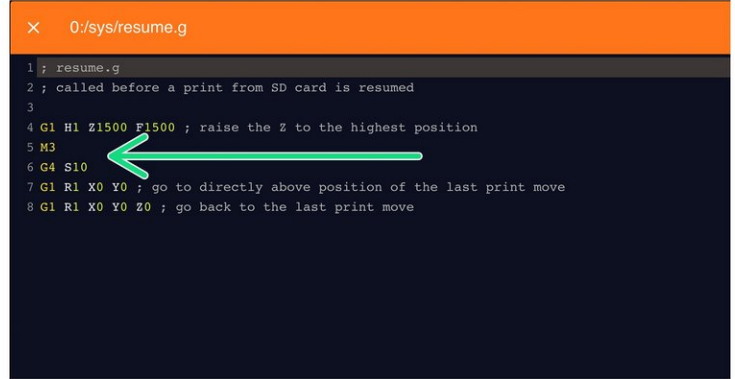


- You can control the spindle manually using G-Code.
 - ① For example M3 S25000, turns the spindle on clockwise and sets the spindle speed at 25000rpm
 - ① M5 Stops the Spindle.
- You can also control it in the 'Spindles' panel.
 - Press 'Turn On' will turn the spindle on clockwise at the RPM set.
 - You can change the preset RPMs under Settings > Machine Specific > Spindle RPM Presets.
- If you have a multimeter, try to read the output voltage of the pwm converter (port 5 and 6). If it says 10V, you are on the maximum spindle speed.
- You can also add a digital led voltmeter on port 5 and 6 of the pwm controller (see image 2)

Step 7 — Stop the spindle when pausing a job



```
0:/sys/pause.g
1 ; pause.g
2 ; called when a print from SD card is paused
3
4 M5
5 M98 P"homecall.g" ; Home the machine
```



```
0:/sys/resume.g
1 ; resume.g
2 ; called before a print from SD card is resumed
3
4 G1 H1 Z1500 F1500 ; raise the Z to the highest position
5 M3
6 G4 S10
7 G1 R1 X0 Y0 ; go to directly above position of the last print move
8 G1 R1 X0 Y0 Z0 ; go back to the last print move
```

- Under File Management > System click on 'pause.g'.
- Add the command **M5** in the header, so the spindle stops when you pause a job while running
- Open the resume.g file and add the following lines
 - M3
 - ⓘ The Spindle RPM is not needed. It will go back to the RPM when the M5 command was sent.
 - G4 S10
 - ⓘ Dwell for 10 seconds to let the Spindle get up to speed.

Step 8 — Modify post processor in Vectric



- Modify the vectric's post processor to automatically use spindle speed.
- Go to the installation directory of the Vectric software, search for "grbl_mm.pp" and make a copy in the same directory and open the copy
- Change the POST_NAME to something else, I did "GRBL (mm) (SPEED)"
- In the header, change "M3" to "M3[S]" to add speed to the M3 command
- After your "M3[S]" line, add a new line "G4S15". This code tells the machine to wait 15 seconds to achieve full spindle speed before starting a job
- ① Save your file in the post processor directory, make sure it ends with .pp or Vectric does not recognise it!
- ① Next time you open the Vectric software, your new post processor will be added to the PP list

Step 9 — Links and references



- Many many thanks to user “Tubal” from the Openbuilds forum, who describes part of the process [Openbuilds forum link](#)
- PWM converter [Amazon link](#)
- Power wiring diagram [Duet power wiring](#)
- AMB Kress wiring diagram from SOROTEC [PDF wiring diagram](#)
- Duet 2 G codes overview [Reprap Gcode overview](#)

Thanks for following the guide. Any issues, please contact us!