

The right choice for the ultimate yield!

LS ELECTRIC strives to maximize your profits in gratitude for choosing us as your partner.

## Programmable Logic Control

# Motion Control Module

**XGT Series**

**User Manual**

**XGF-M32E**



### Safety Instructions

- Read this manual carefully before installing, wiring, operating, servicing or inspecting this equipment.
- Keep this manual within easy reach for quick reference.

**LS**ELECTRIC

### Before using the product ...

For your safety and effective operation, please read the safety instructions thoroughly before using the product.

- ▶ Safety Instructions should always be observed in order to prevent accident or risk with the safe and proper use the product.
- ▶ Instructions are divided into “Warning” and “Caution”, and the meaning of the terms is as follows.



#### **Warning**

This symbol indicates the possibility of serious injury or death if some applicable instruction is violated.



#### **Caution**

This symbol indicates the possibility of severe or slight injury, and property damages if some applicable instruction is violated.

Moreover, even classified events under its caution category may develop into serious accidents relying on situations. Therefore we strongly advise users to observe all precautions properly just like warnings.

- ▶ The marks displayed on the product and in the user’s manual have the following meanings.



Be careful! Danger may be expected.



Be careful! Electric shock may occur.

- ▶ The user’s manual even after read shall be kept available and accessible to any user of the product.

## Safety Instructions for Design Process

### **Caution**

- ▶ **Design the analog input / output signal or pulse input / output line at least 100mm away from high voltage line or power line so that it is not affected by noise or magnetic field change.** It may cause malfunction due to noise.
- ▶ **If there is a lot of vibration in the installation environment, take measures to prevent direct vibration from being applied to the PLC.** It may cause electric shock, fire or malfunction.
- ▶ **If metallic dust is present in the installation environment, take measures to prevent metallic dust from entering the product.** It may cause electric shock, fire or malfunction.

## Safety Instructions on Installation Process

### **Caution**

- ▶ **Use PLC only in the environment specified in PLC manual or general standard of datasheet.**  
If not, electric shock, fire, abnormal operation of the product may be caused.
- ▶ **Before install or remove the module, be sure PLC power is off.** If not, electric shock or damage on the product may be caused.
- ▶ **Be sure that every module is securely attached after adding a module or an extension connector.** If the product is installed loosely or incorrectly, abnormal operation, error or dropping may be caused. In addition, contact failures under poor cable installation will be causing malfunctions as well.
- ▶ **Make sure that the I / O connector is securely fastened.** It may cause wrong input or output.

## Safety Instructions for Wiring Process

### Warning

- ▶ **Prior to wiring works, make sure that every power is turned off.** If not, electric shock or damage on the product may be caused.

### Caution

- ▶ **Check rated voltages and terminal arrangements in each product prior to its wiring process.** Applying incorrect voltages other than rated voltages and misarrangement among terminals may cause fire or malfunctions.
- ▶ **Secure terminal screws tightly applying with specified torque.** If the screws get loose, short circuit, fire or abnormal operation may be caused. Securing screws too tightly will cause damages to the module or malfunctions, short circuit, and dropping.
- ▶ **Be sure to earth to the ground using Class 3 wires for PE terminals which is exclusively used for PLC.** If the terminals not grounded correctly, abnormal operation or electric shock may be caused.
- ▶ **Don't let any foreign materials such as wiring waste inside the module while wiring,** which may cause fire, damage on the product or abnormal operation.

## Safety Instructions for Test-Operation and Maintenance

### **Warning**

- ▶ **Don't touch the terminal when powered.** Electric shock or abnormal operation may occur.
- ▶ **Prior to cleaning or tightening the terminal screws, let all the external power off including PLC power.** If not, electric shock or abnormal operation may occur.

### **Caution**

- ▶ **Do not make modifications or disassemble each module.**  
Fire, electric shock or abnormal operation may occur.
- ▶ **Prior to installing or disassembling the module, let all the external power off including PLC power.** If not, electric shock or abnormal operation may occur.
- ▶ **Keep any wireless equipment such as walkie-talkie or cell phones at least 30cm away from PLC.** If not, abnormal operation may be caused.

## Safety Instructions for Waste Disposal

### **Caution**

- ▶ **Product or battery waste shall be processed as industrial waste.** The waste may discharge toxic materials or explode itself.

# Revision History

Version	Date	Remark	Revised position
V 1.0	2013.9	1. First Edition	-
V1.1	2015.7	1. Domain address and CI changed 2. General specifications changed by reason of changed IEC specifications.	- 2-1
V1.2	2016.9	1. Chapter 01 Note added 2. Chapter 04 Note added 3. Chapter 05 Parameter changed by adding function 4. Chapter 06 Motion function block example added 5. Chapter 08 function's explanation & example added	1-9~10 4-3~4,12 5-10~14, 24~30 6-14~147 8-44~56, 72~104
V1.3	2020.7	1. Format and contents modification according to the change of company name(LSIS → LS ELECTRIC)	-
		1. Added new motion instruction content	Ch6.
		- Read motion info (MC_ReadMotionInfo) - Read actual position (MC_ReadActualPosition) - Read actual velocity (MC_ReadActualVelocity) - Read actual torque (MC_ReadActualTorque) - Read commanded position (MC_ReadCommandedPosition) - Read commanded velocity (MC_ReadCommandedVelocity) - Read commanded torque (MC_ReadCommandedTorque) - Read Cam Data2 (LS_ReadCamData2) - Variable Cam operation (LS_VarCamIn) - Variable gear operation (LS_VarGearIn) - Variable positioning gear operation (LS_VarGearInPos) - Read the slave location of the CAM table (LS_ReadCamTableSlavePos) - Speed control operation (CSV mode) (LS_SyncMoveVelocity) - Read the slave location of the CAM table (LS_ReadCamTableMasterPos)	
V1.4	2021.01	- OnOffCam operation (LS_OnOffCam) - OnOffCam operation (LS_OnOffCamEx) - Generate rotaryknife cam profile (LS_RotaryKnifeCamGen) - Generate crossseal cam profile (LS_CrossSealCamGen) - Relative positioning linear interpolation operation (LS_MoveLinearTimeRelative) - Linear interpolation operation for absolute position of coordinate system (LS_MoveLinearAbsolute) - Linear interpolation operation for relative position of coordinate system (LS_MoveLinearRelative) - Synchronization setting of the rotary table (MC_TrackRotaryTable) - JOG operation of the coordinate system (LS_RobotJog) - PID (PID) - Linear Acceleration Command (LINAC) - S-Curve Linear Acceleration Command (SLINAC)	

Version	Date	Remark	Revised position
V1.4	2021.01	2. New flag content added	Ch5.
		- Coordinate system setting error flag	
		- PDO error and EtherCAT status flag	
		- Motion driving status flag	
		- Acceleration, constant speed, deceleration operation status flag	
		- Buffered instruction status flag	
		- Encoder unit and speed flag	
		3. New parameter and function contents added	Ch5. Ch8
		- Encoder speed unit and encoder position filter time constant	5.1.3
		- Coordinate system jog operation setting	5.1.3
		- Velocity control operation mode	5.1.3
		- The Sync method depending on the direction of master axis operation	5.1.3, 8.2.11
		- Slave replace function	5.1.3, 8.3.6
- Position control range expansion	8.3.7		
- Coordinate system parameters (Delta3R, LinearDelta3/3R, T-Gantry/R)	5.1.3, 8.4.4		
- Coordinate system position time linear interpolation operation	8.4.6		
- Rotary table synchronized operation	8.4.9		
- Rotary knife operation	8.5		
4. Error code added according to function addition	Appendix 1.		
5. Appendix 4. (ESC(EtherCAT Slaver Controller) Register) added	Appendix 4.		
6. Appendix 5. (User Define Function & Function Block) added	Appendix 5.		
V1.4	2022.08	1. Change domain ( <a href="http://www.lselectric.co.kr">www.lselectric.co.kr</a> → <a href="http://www.ls-eletric.com">www.ls-eletric.com</a> )	7, Cover_back
V1.5	2024.06	1. Change quality warranty period	-

Thank you for purchasing PLC of LS ELECTRIC Co., Ltd.

Before use, make sure to carefully read and understand the User's Manual about the functions, performances, installation and programming of the product you purchased in order for correct use and importantly, let the end user and maintenance administrator to be provided with the User's Manual.

The User's Manual describes the product. If necessary, you may refer to the following description and order accordingly. In addition, you may connect our website (<http://www.ls-electric.com/>) and download the information as a PDF file.

### Relevant User's Manuals

Title	Description
XG5000 User's Manual (for XGK, XGB)	XG5000 software user manual describing online function such as programming, print, monitoring, debugging by using XGK, XGB CPU.
XG5000 User's Manual (for XGI, XGR)	XG5000 software user manual describing online function such as programming, print, monitoring, debugging by using XGI, XGR CPU.
XGK/XGB Instructions & Programming User's Manual	User's manual for programming to explain how to use instructions that are used PLC system with XGK, XGB CPU.
XGI/XGR/XEC Instructions & Programming User's Manual	User's manual for programming to explain how to use instructions that are used PLC system with XGI, XGR, XEC CPU.
XGK CPU User's Manual (XGK-CPUA/E/H/S/U)	XGK-CPUA/CPUE/CPUH/CPUS/CPUU user manual describing about XGK CPU module, power module, base, IO module, specification of extension cable and system configuration, EMC standard.
XGI CPU User's Manual (XGI-CPUU/CPUH/CPUS)	XGI-CPUU/CPUH/CPUS user manual describing about XGI CPU module, power module, base, IO module, specification of extension cable and system configuration, EMC standard.
XGR Redundant Series User's Manual	XGR- CPUH/F, CPUH/T user manual describing about XGR CPU module, power module, extension drive, base, IO module, specification of extension cable and system configuration, EMC standard.
XG-PM User's Manual	XG-PM software user manual describing online function such as motion programming, monitoring, debugging by using Positioning Module.

The User's Manual is based on XGF-M32E.

This manual is based on the following versions.

Product name	OS version
XGK-CPUH, CPUS, CPUA, CPUE, CPUU	V4.1
XGI-CPUU, CPUH, CPUS	V3.7
XGR-CPUH/F, CPUH/T	V2.5
XG5000(XG-PM)	V3.67



## © Table of Content ©

<b>Chapter 1 Overview .....</b>	<b>1-1 ~ 1-12</b>
1.1 Characteristics .....	1 - 1
1.2 Signal Flow of Positioning Module .....	1 - 4
1.3 Function Overview of Motion Control module .....	1 - 5
1.3.1 Positioning Control .....	1 - 5
1.3.2 Interpolation Control .....	1 - 6
1.3.3 Speed Control .....	1 - 10
1.3.4 Torque Control .....	1 - 11
<b>Chapter 2 Specification .....</b>	<b>2-1 ~ 2-10</b>
2.1 General Specification.....	2 - 1
2.2 Performance Specifications .....	2 - 2
2.2.1 Function Specifications .....	2 - 2
2.2.2 Communication specifications.....	2 - 3
2.2.3 Internal input/output specifications .....	2 - 4
2.2.4 Encoder Input Specifications .....	2 - 5
2.3 The Name of Each Part .....	2 - 6
2.3.1 The Name of Each Part .....	2 - 6
2.3.2 Specification of interface with external device.....	2 - 7
<b>Chapter 3 Operation Order and Installation .....</b>	<b>3-1 ~ 3-12</b>
3.1 Operation Order.....	3 - 1
3.2 Installation.....	3 - 2
3.2.1 Installation Environment.....	3 - 2
3.2.2 Notice in Handling .....	3 - 2
3.3 Notice in Wiring .....	3 - 3
3.3.1 Notice in Wiring .....	3 - 3
3.3.2 Connection Example of Servo and Stepping Motor Drive Machine.....	3 - 4
3.3.3 Encoder Input (DC 5V Voltage Output) Wiring Example.....	3 - 9

3.3.4 Encoder Input (DC 5V Line Driver Output) Wiring Example ..... 3-10

3.3.5 External Input Signal Wiring Example ..... 3-11

3.3.6 External Output Signal Wiring Example ..... 3-11

**Chapter 4 Motion Control Operation ..... 4-1 ~ 4-18**

4.1 Structure of Motion Control Module ..... 4-1

4.2 Configuration of Motion Control..... 4-2

4.3 Motion Control Task..... 4-3

    4.3.1 Types of Tasks ..... 4-3

    4.3.2 Task motion ..... 4-4

    4.3.3 Execution of Motion Commands ..... 4-7

4.4 EtherCAT Communication ..... 4-8

    4.4.1 What is EtherCAT ..... 4-8

    4.4.2 COE(CANopen over EtherCAT) ..... 4-8

    4.4.3 EtherCAT State Machine ..... 4-9

    4.4.4 EtherCAT Process Data Objective(PDO) ..... 4-10

    4.4.5 Specification of Motion Control Module EtherCAT Communication..... 4-11

    4.4.6 EtherCAT Network Connection ..... 4-11

    4.4.7 EtherCAT Network Setting ..... 4-13

4.5 Motion Control Program ..... 4-16

    4.5.1 Program Execution ..... 4-16

    4.5.2 Operation Modes..... 4-16

**Chapter 5 Memory and Parameter, I/O Signal ..... 5-1 ~ 5-52**

5.1 Memory ..... 5-1

    5.1.1 Flag ..... 5-1

    5.1.2 Device ..... 5-11

    5.1.3 Parameter..... 5-19

5.2 I/O Signal ..... 5-50

    5.2.1 Contents of I/O Signal..... 5-50

    5.2.2 Use of I/O Signal ..... 5-52

<b>Chapter 6 Function Block .....</b>	<b>6-1 ~ 6-202</b>
---------------------------------------	--------------------

6.1 Common Elements of Motion Function Blocks.....	6 - 1
6.1.1 The State of axis.....	6 - 1
6.1.2 The state of Group .....	6 - 3
6.1.3 Basic I/O Variable.....	6 - 4
6.1.4 BufferMode Input.....	6 - 7
6.1.5 Changes in Parameters during Execution of Motion Function Block.....	6 - 7
6.1.6 Group Operation Route Change Settings .....	6 - 7
6.1.7 Motion Function Block Errors .....	6 - 11
6.2 Motion Function Block .....	6 - 12
6.3 Single-Axis Motion Function Blocks .....	6 - 15
6.4 Multi-Axis Motion Function Blocks .....	6 - 66
6.5 Group Motion Function Blocks .....	6 - 88
6.6 Exclusive Function Blocks .....	6 - 118
6.7 Coordinate system operation function block .....	6 - 170
6.8 Other function block .....	6 - 195

<b>Chapter 7 Program .....</b>	<b>7-1 ~ 7-38</b>
--------------------------------	-------------------

7.1 Structure of the Program.....	7 - 1
7.2 Status Information Reading.....	7 - 2
7.3 Discrete Motion Program .....	7 - 2
7.3.1 Preparation for operation.....	7 - 2
7.3.2 Homing operation.....	7 - 4
7.3.3 Absolute Position/Relative Position Operation.....	7 - 6
7.3.4 Speed/Torque Control Operation.....	7 - 9
7.3.5 Axis Stop.....	7 - 12
7.3.6 Error Processing.....	7 - 14
7.3.7 Change in Operation.....	7 - 16
7.3.8 Parameter Write/Read .....	7 - 18
7.4 Multi-Axis Operation Program.....	7 - 23
7.4.1 Linear Interpolation Operation .....	7 - 23
7.4.2 Circular Interpolation Operation.....	7 - 25
7.4.3 Synchronous Operation.....	7 - 27

7.4.4	CAM Operation .....	7 - 30
7.4.5	Axis Group Processing .....	7 - 32
7.4.6	Example of axis group operation .....	7 - 34
7.5	I/O Processing Program .....	7 - 38
7.5.1	Input Signal Processing .....	7 - 38
7.5.2	Output Signal Processing .....	7 - 38
<b>Chapter 8 Function .....</b>		<b>8-1 ~ 8-120</b>
8.1	Origin Determination.....	8 - 1
8.1.1	Origin Determination .....	8 - 1
8.1.2	Homing .....	8 - 2
8.2	Type of Control Operation .....	8 - 9
8.2.1	Single-axis Position Control .....	8 - 9
8.2.2	Single-axis Speed Control .....	8 - 14
8.2.3	Single-axis Torque Control .....	8 - 16
8.2.4	Specified Velocity Operation after Position Operation.....	8 - 18
8.2.5	Switching Control.....	8 - 20
8.2.6	Axis Group Control.....	8 - 22
8.2.7	Linear Interpolation Control .....	8 - 24
8.2.8	Circular Interpolation Control .....	8 - 29
8.2.9	Axis Control Buffer Mode .....	8 - 38
8.2.10	Axis Group Control Buffer Mode and Transition Mode.....	8 - 41
8.2.11	Synchronous Control .....	8 - 43
8.2.12	Manual Control .....	8 - 56
8.2.13	SuperImposed operation .....	8 - 58
8.2.14	Phase correction control .....	8 - 60
8.3	Other Functions .....	8 - 62
8.3.1	Functions to Change Control.....	8 - 62
8.3.2	Auxiliary Function of Control .....	8 - 69
8.3.3	Data Management Function.....	8 - 75
8.3.4	EtherCAT communication diagnosis function.....	8 - 80
8.3.5	Cable duplication function .....	8 - 85
8.3.6	Replace function during connection .....	8 - 85
8.4	Coordinate system operation function .....	8 - 89

8.4.1 Summary of the coordinate systems operation ..... 8 - 89

8.4.2 ACS/MCS/PCS/TCP ..... 8 - 89

8.4.3 PCS setting..... 8 - 90

8.4.4 Machine information setting ..... 8 - 91

8.4.5 Work space setting..... 8 - 96

8.4.6 Coordinate system position time linear interpolation operation..... 8 - 98

8.4.7 Coordinate system circular interpolation operation..... 8 - 101

8.4.8 Conveyor belt synchronized operation..... 8 - 110

8.4.9 Rotary table synchronized operation..... 8 - 113

8.5 Rotary knife operation ..... 8 - 116

8.5.1 Overview of rotary knife operation ..... 8 - 116

8.5.2 Function of rotary knife operation ..... 8 - 116

**Appendix 1 Error Information & Solutions ..... A1-1~ A1-28**

**Appendix 2 Setting Example ..... A2-1~ A2-22**

**Appendix 3 Dimension ..... A3-2**

**Appendix 4 ESC(EtherCAT Slaver Controller) Register..... A4-4**

**Appendix 5 User Define Function & Function Block..... A5-8**

**Warranty and Environmental Policy**

# Chapter 1 Overview

This user's manual describes the standard of Motion Control module, installation method, the method to use each function, programming and the wiring with external equipment.

## 1.1 Characteristics

The characteristics of Motion Control module are as follows.

- (1) The Motion Control module is available for XGK/I/R Series.
- (2) Various Motion Control function  
It has various functions needed for motion control system such as position control, speed control etc.
  - (a) It supports various motion control commands.
    - 1) It supports a number of function blocks.
    - 2) It supports a number of motion function blocks compliant to PLCopen standards.
    - 3) Motion programs are supported in the form of LD or ST by using XG-PM.
  - (b) It can control actual axis of up to 32 axes, virtual axis of 4 axes and EtherCAT I/O (up to 256 points) of four units, and supports I/O of input 8 points and output 8 points and encoder input of two channels.
  - (c) Various sing-axis operations are available.
    - 1) Position control
    - 2) Speed control
    - 3) Synchronous control
    - 4) Multi-axis simultaneous start
  - (d) Various multi-axis group operations are available.
    - 1) Circular arc interpolation
    - 2) Linear interpolation
    - 3) Helical interpolation
    - 4) Group homing / Changes group position
  - (e) Switching control in operation is available.
    - 1) Position/Speed control switching
    - 2) Position/Torque control switching
    - 3) Speed/Torque control switching
  - (f) Cam Control is available.  
It is available to create up to 32 kinds of cam data with various cam profile of XG-PM.
  - (g) Various Homing Control Function.  
As for a homing method, you can use Homing method supported by each servo drive model.  
(Refer to the instruction manual of each servo drive for more detailed homing methods and servo parameter settings)
  - (h) For the Acceleration/Deceleration method, trapezoidal acceleration/deceleration and S-shaped acceleration/deceleration is supported, and S-shaped acceleration/deceleration can be implemented by setting jerk on a motion function block.
- (3) Speed-up of execution of the motion program  
Through realization of speed-up of processing at the time of start-up operation, the motion program set as main task can be performed at up to 1ms intervals. In addition, there is no delay time between axes in Simultaneous start and interpolation start.

- (4) Connection with the servo driver through EtherCAT\*<sup>1</sup>
- (a) Direct connection to servo drives of up to 32 units and EtherCAT I/O of up to 4 units can be achieved through EtherCAT.
  - (b) Since the connection between motion control module and servo drive is made using Ethernet cables. So wiring is simple.
  - (c) You can easily check and set up the servo driver information and parameter at the Motion Control module
  - (d) Max. connection distance is 100m.
- (5) Able to realize the absolute position system  
You can realize the absolute position system just by connecting to the servo drive using the absolute position encoder and in case of ON/OFF, it can know the current position of the motor without homing.
- (6) Easy maintenance  
As retain registers, parameters, cam data and location data are stored in MRAM (Magnetoresistive Random Access Memory) within the Motion Control module, data can be stored without delay, and there is no limited number of writes.
- (7) There are no restrictions in the quantity of the Motion Control module used in the base of XGK/I system. (However, they have to be used within the capacity of power module. The XGR system is limited to two units.)
- (8) Self-diagnosis, monitoring and test are available with strong software package, XG-PM.
- (a) Monitoring function (Module & Servo driver)
  - (b) Trace function
  - (c) Trend function
  - (d) Reading and saving module program/parameter
  - (e) Reading and saving servo parameter
  - (f) Creation of CAM data
  - (g) Providing details about errors and the solution for it
  - (h) Print function of various forms
- (9) Applicable XGK/I/R CPU version for Motion Control module.

XGT CPU Module Type	Version
XGK CPU Module	V4.10 or above
XGI CPU Module	V3.70 or above
XGR CPU Module	V2.50 or above

#### Note

##### 1. What is EtherCAT?

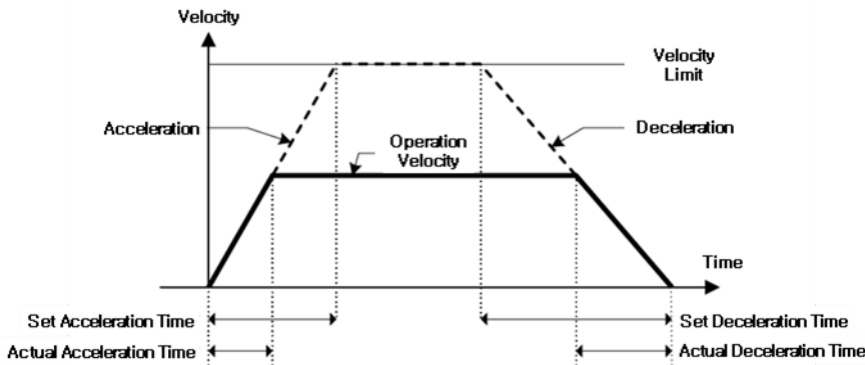
EtherCAT, Open Industrial Ethernet Solution, is developed by Beckhoff at 2002 and at 2003, November EtherCAT Technology Group (ETG-<http://www.ethercat.org>) is organized and it opens its technology. At 2005, February, that is authorized as IEC standard specification. Because of fast control speed and easiness for use and maintenance, it is widely used in the industrial field and conforming its performance. In our positioning module, data communication with service driver is done with master-slave method through EtherCAT, and electric Ethernet Cable is used.

**Note**

The unit of acceleration/deceleration of motion control module (XGF-M32E) and setting method differ in setting method of network position control module (XGF-PN8B). Please be aware of the differences in operation and settings in the following form.

1) The network position control module (XGF-PN8B) is used by setting the acceleration/deceleration time in operation parameter-basic parameter.

The acceleration time is the time it takes to reach the speed limit set in the basic parameter from the speed "0" (stop state), and the deceleration time is the time it takes to reach the speed "0" (stop state) from the speed limit set in the basic parameter. . In other words, please note that it is not the time it takes to reach the driving speed.



2) Motion control module (XGF-M32E) is used by inputting speed/acceleration/jerk in each function block (command) and setting the acceleration/deceleration setting unit as speed change rate.

If the acceleration and deceleration are set small, the acceleration and deceleration time are longer, and if the acceleration and deceleration are set large, the acceleration and deceleration time are shortened. Here, Jerk sets the amount of change in acceleration/deceleration. If the Jerk value is set to a small value, linear acceleration/deceleration operation is performed, and if the Jerk value is set to a large value, the sine curve type acceleration/deceleration operation is performed.

- ✓ Linear acceleration time = Velocity / Acceleration
- ✓ Determine the ratio of jerk application to linear acceleration time

$$\checkmark \text{ Jerk} = \frac{\text{Acceleration}}{\text{Linear Acceleration Time} \times \frac{\text{Jerk Application Ratio}}{2}}$$

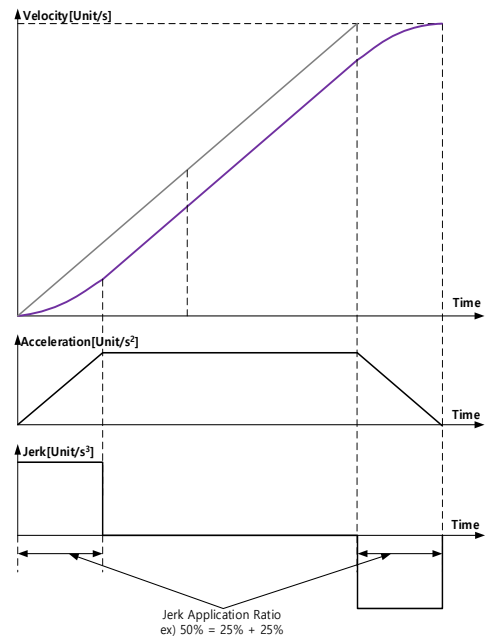
- ✓ Total acceleration time

- Jerk Ratio ≤ 200 %

$$\text{- Total Acceleration Time} = \frac{\text{Velocity}}{\text{Acceleration}} + \frac{\text{Acceleration}}{\text{Jerk}}$$

- Jerk Ratio > 200 %

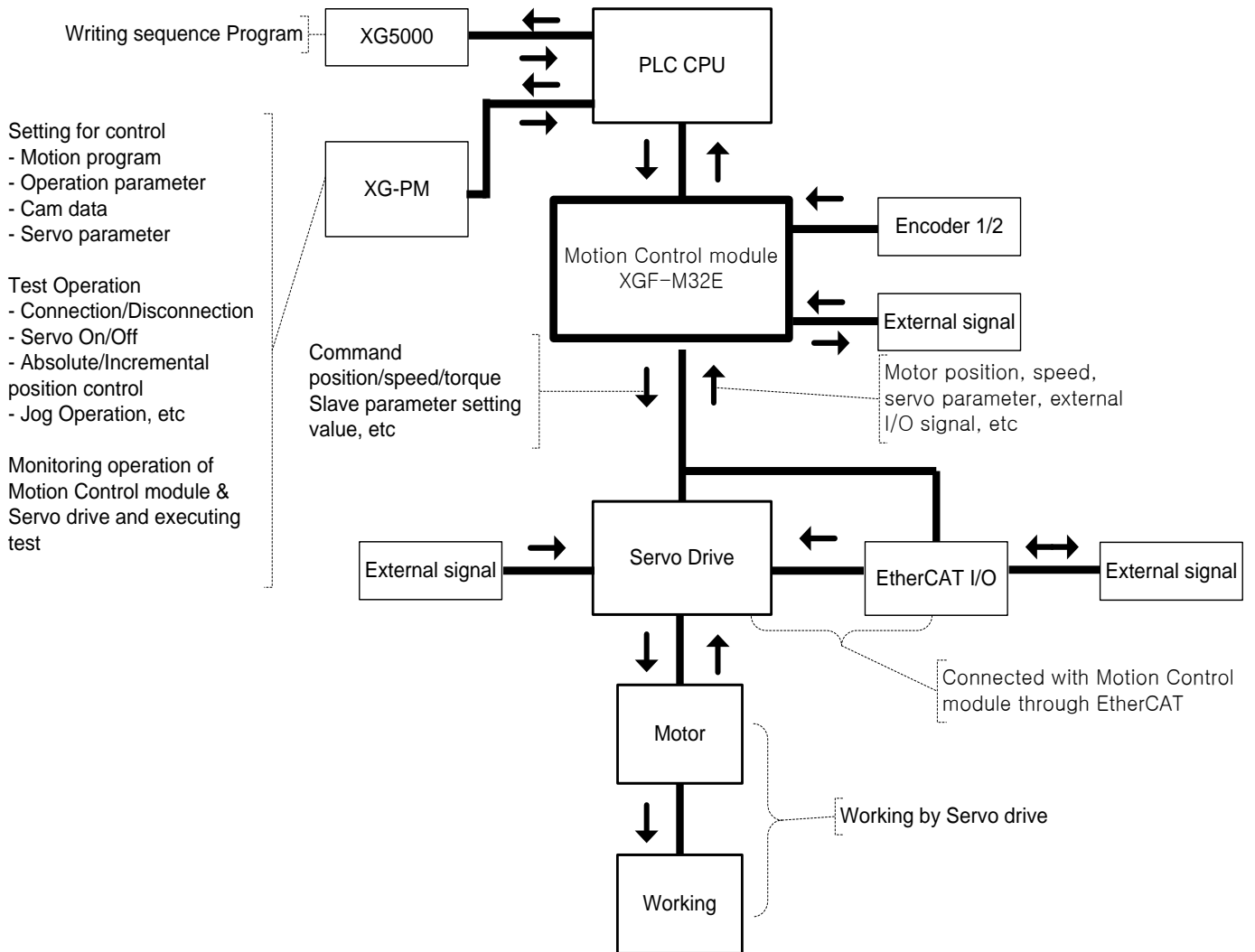
$$\text{- Total Acceleration Time} = 2 \times \sqrt{\frac{\text{Velocity}}{\text{Jerk}}}$$





## 1.2 Signal Flow of Positioning Module

The flow of PLC system using the Motion Control module is as follows.



### 1.3 Function overview of Motion Control module

Describe Representative functions of Motion Control module (Coordinate & Linear Interpolation, Circular Interpolation & Stop) briefly.

#### 1.3.1 Position Control

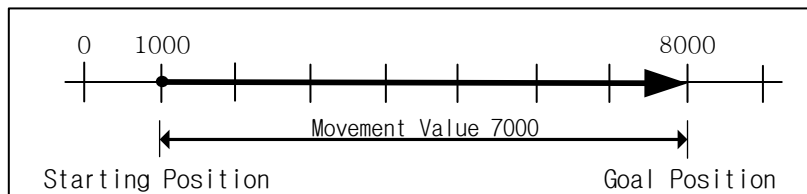
Execute positioning control for the designated axis from starting position(current position) to goal position(the position to move to).

##### (1) Control by Absolute coordinates

- (a) Execute positioning control from starting position to goal position designated in motion function block
- (b) Positioning control is executed based on home position designated in homing
- (c) Moving direction is decided by starting position and goal position.
  - 1) Starting Position < Goal Position : Forward Positioning Operation
  - 2) Starting Position > Goal Position : Reverse Positioning Operation

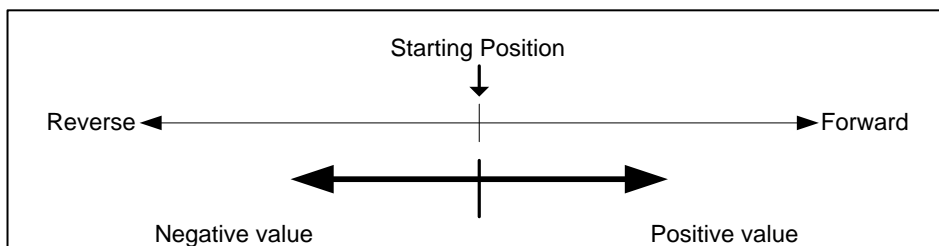
[ Example ]

- 1) Starting Position : 1000
  - 2) Target Position : 8000
- Value of Forward movement is 7000 ( $7000=8000-1000$ )



##### (2) Control by Incremental Coordinates

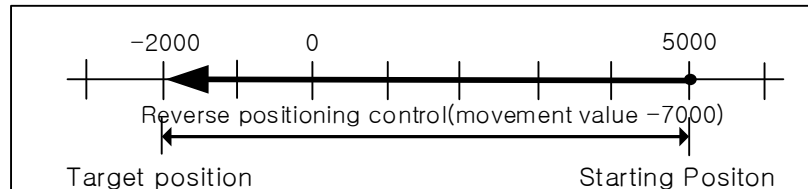
- (a) Execute positioning control from starting position as much as goal movement value. The difference from absolute coordinates control is that the goal position is movement value, not position value.
- (b) Moving direction depends on sign of movement value.
  - 1) Positive value (+ or 0) : Positioning operation with forward direction
  - 2) Negative value (-) : Positioning operation with reverse direction



[ Example ]

- 1) Starting Position : 5000
- 2) Target Position : -7000

In this condition, it moves reversely and stops at -2000.



## 1.3.2 Interpolation Control

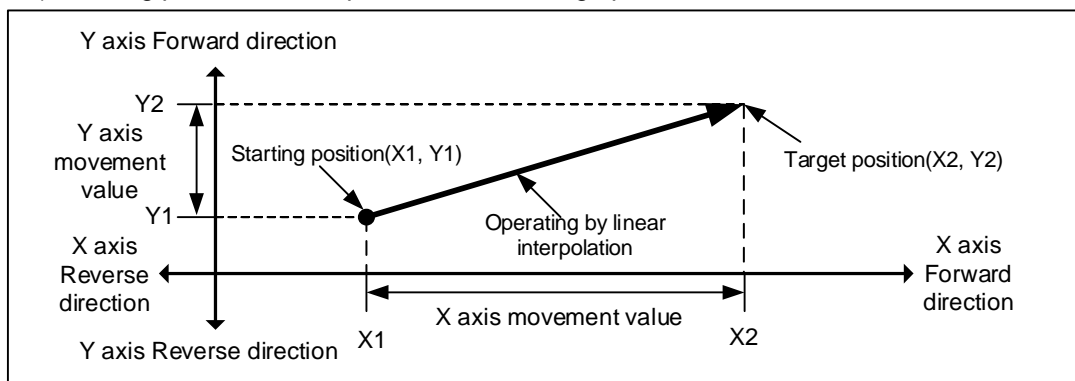
### (1) Linear Interpolation Control

Execute Linear interpolation control with designated axis at start position (Current position).

Combination of interpolation axis is unlimited and it is available to execute max. 4 axis Linear interpolation control.

(a) Linear interpolation by absolute coordinates

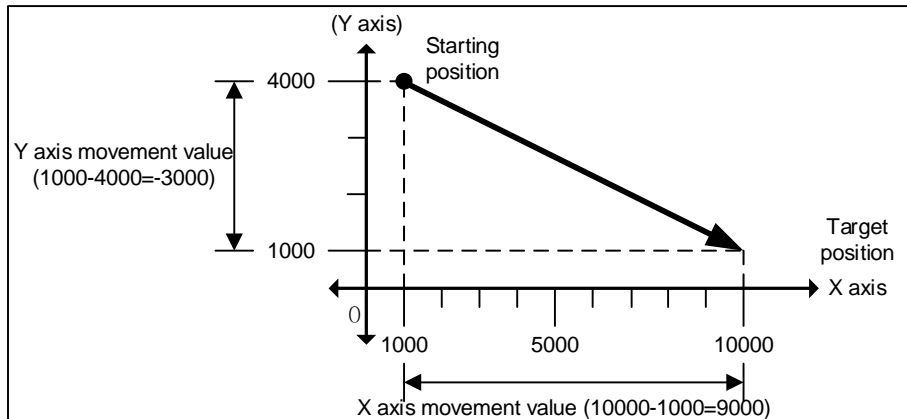
- 1) Execute Linear interpolation from starting position to goal position designated by positioning data.
- 2) Positioning control is executed based on home position designated in homing.
- 3) Movement direction is designated by starting position & goal position of each axis.
  - a) Starting position < Goal position : Positioning operation with forward direction
  - b) Starting position > Goal position : Positioning operation with reverse direction



[ Example ]

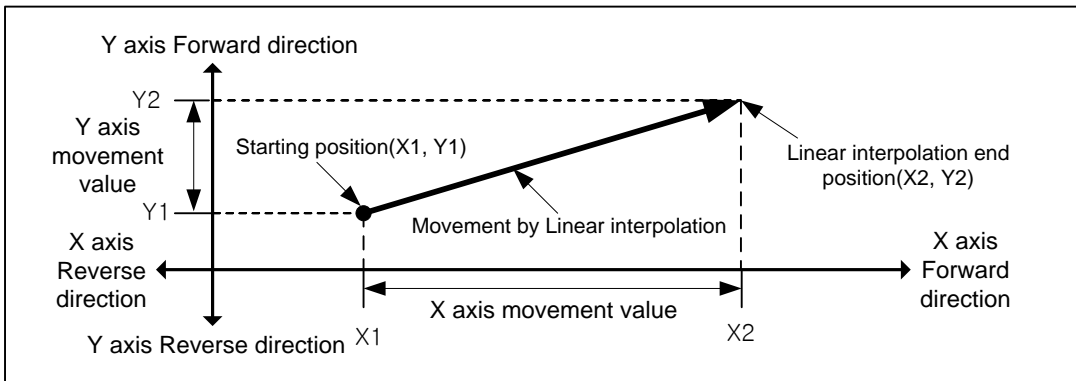
- a) Starting Position (1000, 4000)
- b) Target Position (10000, 1000)

In this condition, operation is as follows.



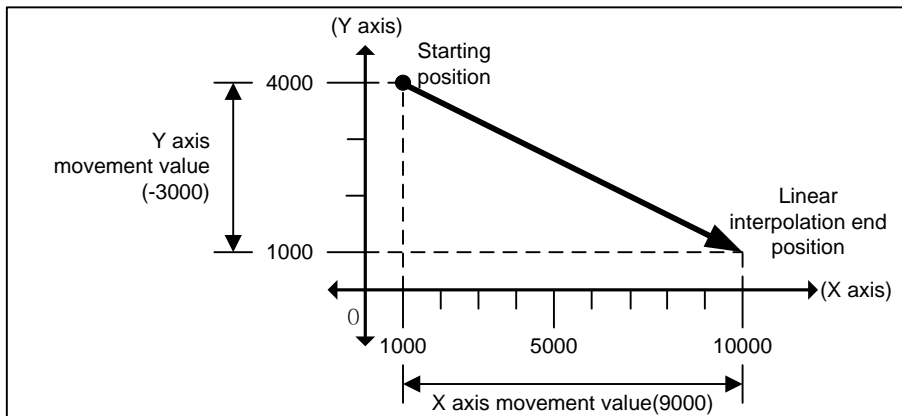
(b) Linear Interpolation by incremental coordinates

- 1) Goal value becomes movement value
- 2) Moving direction depends on movement value is positive or negative.
  - a) Positive value (+ or 0) : Positioning operation with forward direction
  - b) Negative value (-) : Positioning operation with reverse direction



[ Example ]

- a) Starting position (1000, 4000)
  - b) Target position (9000, -3000)
- In this condition, operation is as follows.



**(2) Circular Interpolation Control**

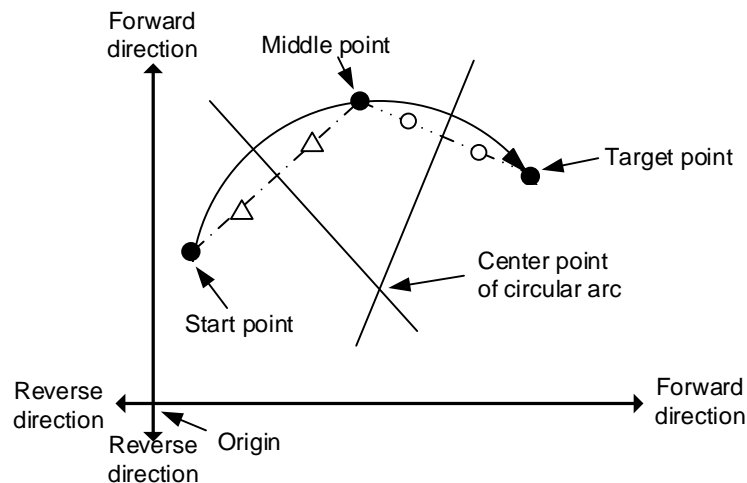
Execute interpolation operation along the trace of circle with 2 axes in forward direction that already designated for each axis.

Circular interpolation has 3 types according to auxiliary point, Middle point method passing auxiliary point, Center point method using auxiliary point as center of circle and Radius method using auxiliary point as radius of circle.

The combination of 2 axes that used in circular interpolation is unlimited. Any of the two axes from the actual axes (1-axis to 32-axis) or virtual axes (37-axis to 40-axis) can be used.)

**(a) Middle Point Specified Circular interpolation**

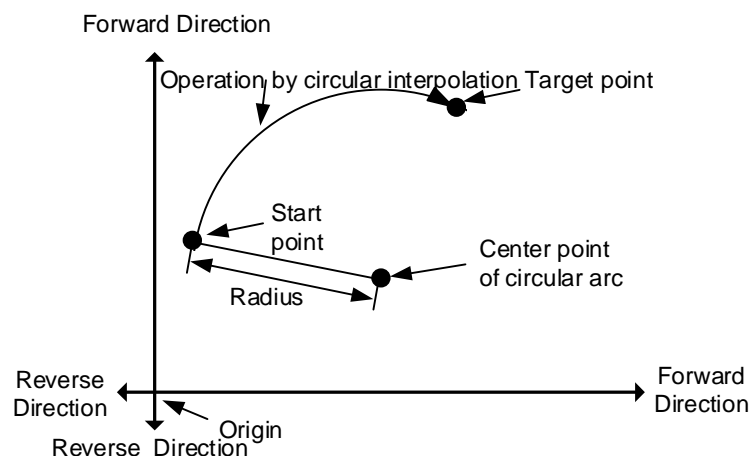
- 1) Starts operating at starting position and executes circular interpolation through the designated middle point.
- 2) There will be a circular arc whose center point is crossing point of perpendicular bisection between starting position and middle point or middle point and goal position.



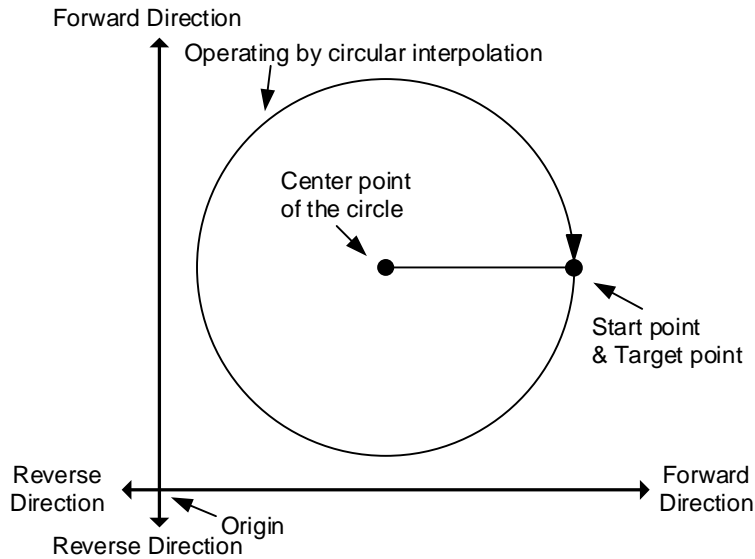
- 3) Movement direction is automatically designated by goal position and auxiliary point of circular interpolation.

**(b) Center Point Specified Circular interpolation**

- 1) Starts operating from starting position and execute circular interpolation along trace of circle that has distance from starting point to designated center point as radius.



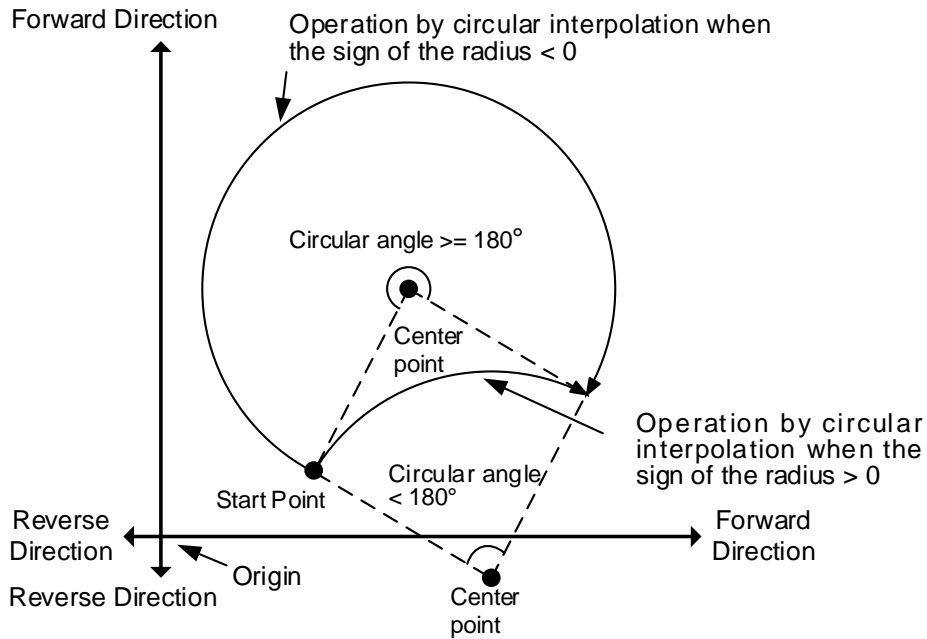
- 2) If the goal position is same as starting position, it is available to have an operation like a circle that has distance from starting point to auxiliary point as its radius.



- 3) The direction of movement is determined according to the selection of paths (CW, CCW) to be set at the time of motion function block.

(C) Radius Specified Circular interpolation

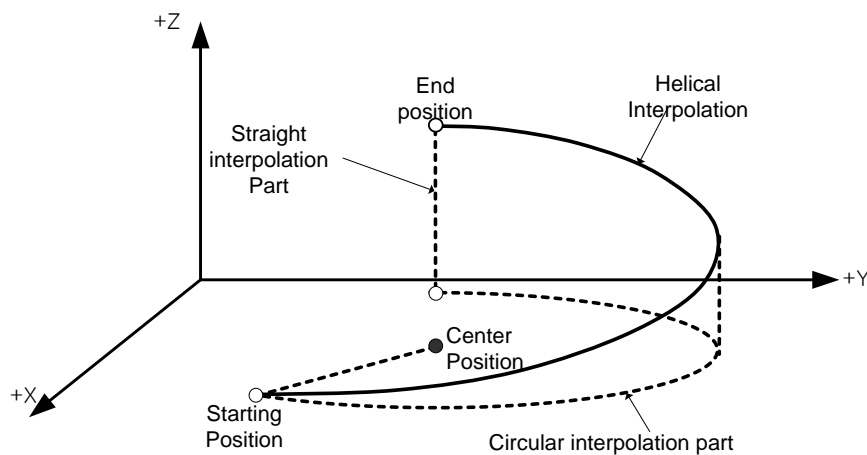
- 1) Starts operating from starting position and execute circular interpolation along trace of circular arc that has value designated in auxiliary point of main axis as it radius. An arc whose central point varies depending on the sign of the radius is drawn.



- 2) In radius designation form, goal position can not be set the same as starting position.
- 3) The operational directions and the size of the arc are determined by the path selection (CW, CCW) of circular interpolation commands and the sign of the radius.

### (3) Helical Interpolation

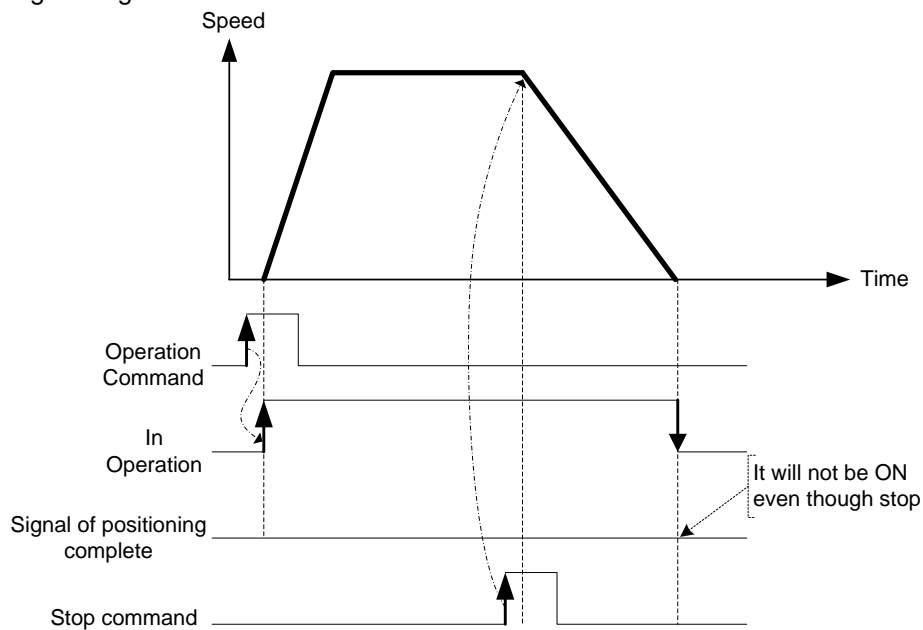
- (a) Moves along the designated trace of circular arc depending on circular arc interpolation setting and executes Linear interpolation synchronously.
- (b) There is no limit to the combination of axes to be used in helical interpolation, and three axes from actual axis (1 axis to 32 axes) or virtual axis (37 axes to 40 axes) are used.
- (c) Helical interpolation control is possible using the MC\_MoveCircularAbsolute, MC\_MoveCircularRelative commands.
- (d) The figure below shows the starting position of helical interpolation control, which is the command position of the point in time when the command is executed.
- (e) EndPoint, which is the input variables of MC\_CircularAbsolute, MC\_MoveCircularRelative commands sets the end position of the figure below. EndPoint[0] corresponds to X-axis, EndPoint[1] Y-axis, and EndPoint[2]Z-axis coordinates.



### 1.3.3 Speed Control

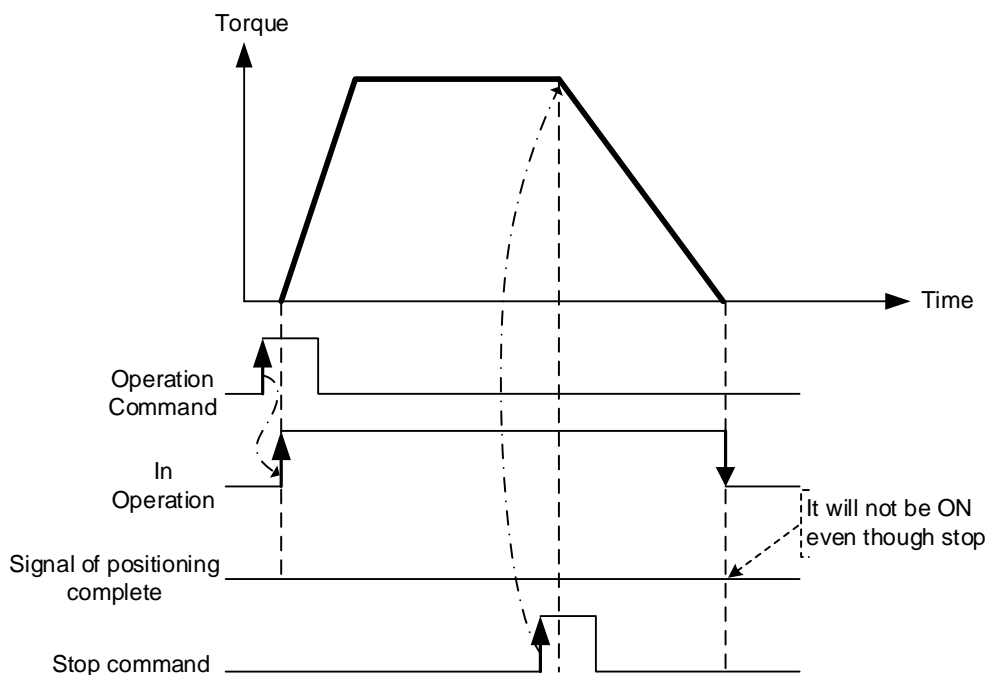
- (1) Execution is made by speed control commands, and the operation proceeds at the established rate until buffer commands are executed, or stop commands are entered.
- (2) Speed control has forward operation and reverse operation.
  - (a) Forward run: In case of velocity > 0 and forward direction, or velocity < 0 and reverse direction
  - (b) Reverse run: In case velocity > 0 and reverse direction, or velocity < 0 and reverse direction.

(3) Operating Timing



1.3.4 Torque Control

- (1) The execution is made by the torque control command, and the operation is done in the set torque until the buffer command or stop command is entered.
- (2) Torque control includes forward operation and a reverse operation..
  - (a) Forward operation: When direction input setting is '1-forward' direction
  - (b) Reverse operation: When direction input setting is 2-'reverse' direction
- (3) Operating Timing







## Chapter 2 Specification

### 2.1 General Specifications

The following table shows the general specification of XGT series.

No.	Item	Specifications	Related specifications					
1	Ambient temperature	0 ~ 55 °C	-					
2	Storage temperature	-25 ~ +70 °C	-					
3	Ambient humidity	5 ~ 95%RH (Non-condensing)	-					
4	Storage humidity	5 ~ 95%RH (Non-condensing)	-					
5	Vibration resistance	Occasional vibration		-	10 times each directions (X, Y and Z)	IEC61131-2		
		Frequency	Acceleration	Amplitude			How many times	
		$5 \leq f < 8.4\text{Hz}$	-	3.5mm				
		$8.4 \leq f \leq 150\text{Hz}$	$9.8 \text{ m/s}^2$ (1G)	-				
		For continuous vibration		Frequency			Acceleration	Amplitude
		$5 \leq f < 8.4\text{Hz}$	-	1.75mm				
$8.4 \leq f \leq 150\text{Hz}$	$4.9 \text{ m/s}^2$ (0.5G)	-						
6	Shock resistance	<ul style="list-style-type: none"> <li>Peak acceleration: <math>147 \text{ m/s}^2</math>(15G)</li> <li>Duration: 11ms</li> <li>Half-sine, 3 times each direction per each axis</li> </ul>	IEC61131-2					
7	Noise resistance	Square wave Impulse noise	AC: $\pm 1,500\text{V}$ DC: $\pm 900\text{V}$	LSIS standard				
		Electrostatic discharge	Voltage : 4kV (contact discharging)		IEC 61131-2, IEC 61000-4-2			
		Radiated electromagnetic field noise	80 ~ 1,000 MHz, 10V/m		IEC 61131-2, IEC 61000-4-3			
		Fast transient /bust noise	Segment	Power supply module	Digital/analog input/output communication interface	IEC 61131-2, IEC 61000-4-4		
	Voltage	2kV	1kV					
8	Environment	Free from corrosive gasses and excessive dust		-				
9	Altitude	Up to 2,000 ms		-				
10	Pollution degree	Less than equal to 2		-				
11	Cooling	Air-cooling		-				

#### Note

1. IEC (International Electrotechnical Commission):

An international nongovernmental organization which promotes internationally cooperated standardization in electric/electronic field, publishes international standards and manages applicable estimation system related with.

2. Pollution degree:

An index indicating pollution degree of the operating environment which decides insulation performance of the devices. For instance, Pollution degree 2 indicates the state generally that only non-conductive pollution occurs. However, this state contains temporary conduction due to dew produced.

## 2.2 Performance Specifications

The following table shows the performance specifications of XGT Positioning Module.

### 2.2.1 Function Specifications

Items		Specification
No. of control axis		32 axis(Real axis), 4 axis(Virtual axis), 4 axis(EtherCAT I/O)
Communication		EtherCAT (CoE: CANopen over EtherCAT)
Communication period		1ms, 2ms, 4ms (Same with main task period)
Servo drive		Servo drive to support EtherCAT CoE
Control period		1ms, 2ms, 4ms (Same with main task period)
Control unit		pulse, mm, inch, degree
I/O	Internal	Input 8 point, Output 8 point
	External	EtherCAT I/O 4 EA(Maximum 256 point)
Motion program	No. of program	Maximum 256 EA
	Capacity	Maximum 1MB
	Language	LD(FB), ST
	Position data	Specifying available (6400 Point/All axis)
Control method		Position, Velocity, Torque(Servo drive support) control, Synchronous control, Interpolation control
Range of position		$\pm$ LREAL, 0
Range of velocity		$\pm$ LREAL, 0
Torque unit		Rated torque % designation
Acc./Dec. process		Trapezoid type, S-type (Setting to specify the Jerk at function block)
Rage of Acc./Dec.		$\pm$ LREAL, -
Manual operation		JOG operation
CAM operation		32 blocks
Absolute System		Available (When using absolute encoder type servo drive)
Encoder input	Channel	2 channels
	Max. input	500 Kpps
	Input method	Line drive input (RS-422A IEC specification) Open collector output type encoder
	Input type	CW/CCW, Pulse/Dir, Phase A/B
Max. distance		100m

Items	Specification
Communication cable	Over CAT.5 STP(Shielded Twisted-pair) cable
Error indication	Indicated by LED
Communication status indication	Indicated by LED
Occupied point I/O	Variable: 16points, Fixed: 64points
Consumable current	900mA
Weight	122g

### Note

1. LREAL range:  $-1.7976931348623157e+308 \sim -2.2250738585072014e-308$  or 0 or  $2.2250738585072014e-308 \sim 1.7976931348623157e+308$
2. Jerk: Change rate of acceleration, which is index, how fast acceleration increasing or decreasing

### 2.2.2 Communication specifications

Item	Specification
Communication protocol	EtherCAT
Support specification	CoE(CANopen over EtherCAT)
Physical layer	100BASE-TX
Communication speed	100Mbps
Topology	Daisy Chain
Communication cable	Over Cat. 5 STP(Shielded Twisted-pair) cable
No. of maximum slave	36
Communication period	1ms/2ms/4ms
Synchronous Jitter	Within 1 $\mu$ s
Synchronous communication	PDO(Process Data Object) Mapping through CoE
Non-synchronous communication	SDO(Service Data Object) communication through CoE
Communication setting	Set the communication configuration using XG-PM

## 2.2.3 Internal input/output specifications

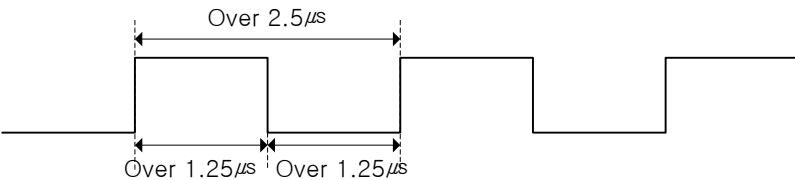
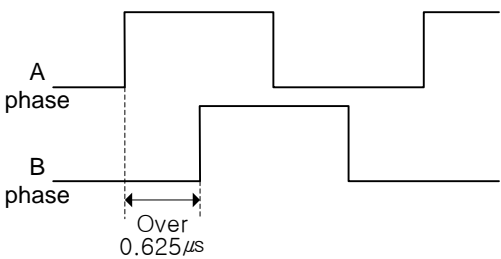
### 1. Input specifications (source/sink type)

Item	Specification
Input point	8 point
Insulation method	Photo-coupler insulation
Rated input voltage	24V
Rated output voltage	About 4mA
Used voltage range	DC20.4V~28.8V(within ripple rate 5%)
On voltage/On current	DC19V or above / 3mA or above
Off voltage/Off current	DC11V or less / 1.7mA or less
Input resistance	About 5.6 k $\Omega$
Response time	1ms or less
Working voltage	AC560Vrms/3 Cycle (Altitude 2000m)
Insulation resistance	Insulation resistance 10 M $\Omega$ or more
COMM method	8point / COM

### 2. Output specifications (sink type)

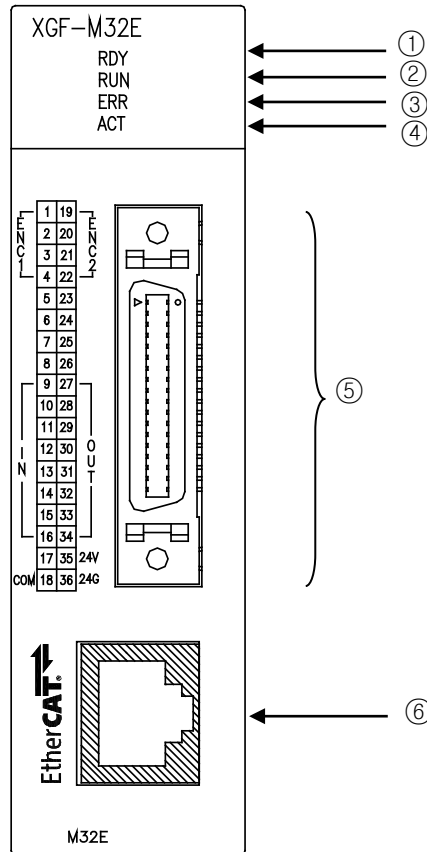
Item	Specification	
Output point	8 point	
Insulation method	Photo-coupler insulation	
Rated load voltage	DC 12V / 24V	
Used load voltage range	DC10.2V~26.4V	
Maximum load current	0.5A / 1 point, 2A / 1COM	
Off leakage current	0.1mA or less	
Maximum inrush current	4A / 10ms or less	
Maximum voltage drop(On)	DC 0.3V or less	
Surge absorber	Zener diode	
Response time	Off→On	1ms or less
	On→Off	1ms or less(Rated load, resistive load)
COM method	8 point /1COM	
External power	Voltage	DC 12/24V $\pm$ 10% (ripple voltage 4Vp-p or less)
	Current	10mA or less (DC 24V connection)

### 2.2.4 Encoder Input Specification

Item	Specification	
Input voltage	5V (4.5V ~ 5.5V)	In accordance with RS-422A Line Driver Level
Input current	7 mA ~ 11 mA	
Min. On guarantee voltage	4.1V	
Max. Off guarantee voltage	1.7V	
Input pulse	<p>1) Pulse width</p>  <p>2) Phase difference</p>  <p>When A phase input pulse is ahead of B phase input pulse : Position value increases</p> <p>When B phase input pulse is ahead of A phase input pulse : Position value decreases</p>	

## 2.3 The Name of Each Part

### 2.3.1 The name of each part



No.	Name	Description
①	Module ready(RDY)	On: Positioning module normal status Off: Power OFF or CPU module reset status
②	RUN/STOP indicator	On: Run user program Off: Stop user program Flicker: Write user program
③	Error display	Off: User program normal execution status Flicker: Error occurs during user program executing/communicating with servo drive
④	TRX status LED(ACT)	On: Wiring with servo driver is done Off: Wiring with servo driver is not done Flicker: communicating with servo driver
⑤	Wiring connector for encoder and internal input/output	Connector to connect with encoder and internal I/O signal
⑥	RJ-45 connector	RJ-45 connector to connect with servo drive

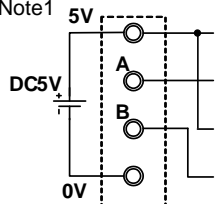
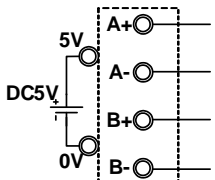
2.3.2 Specification of interface with external device

1. Pin arrangement of connector

Pin arrangement	Pin no.	Signal name	Signal direction	
	1	ENC1A+	Encoder 1A+ input	
	2	ENC1A-	Encoder 1A- input	Input
	3	ENC1B+	Encoder 1B+ input	
	4	ENC1B-	Encoder 1B- input	
	5 – 8	-	N.C	
	9	IN0	Input signal 0	Input
	10	IN1	Input signal 1	
	11	IN2	Input signal 2	
	12	IN3	Input signal 3	
	13	IN4	Input signal 4	
	14	IN5	Input signal 5	
	15	IN6	Input signal 6	
	16	IN7	Input signal 7	
	17	-	N.C	-
	18	COM	Input signal Common	Input
	19	ENC2A+	Encoder 2 A+ input	Input
	20	ENC2A-	Encoder 2 A- input	
	21	ENC2B+	Encoder 2 B+ input	
	22	ENC2B-	Encoder 2 B- input	
	23 – 26	-	N.C	-
	27	OUT0	Output signal 0	Output
	28	OUT1	Output signal 1	
	29	OUT2	Output signal 2	
	30	OUT3	Output signal 3	
	31	OUT4	Output signal 4	
	32	OUT5	Output signal 5	
	33	OUT6	Output signal 6	
	34	OUT7	Output signal 7	
	35	24V	DC 24V	Input
	36	GND	DC 24V GND	



2. Encoder internal circuit

Item	Pin No.	Signal	
*Note1 	1	ENC1A+	Encoder 1A+ input
	2	ENC1A-	Encoder 1 A- input
	3	ENC1B+	Encoder 1 B+ input
	4	ENC1B-	Encoder 1 B- input
*Note2 	19	ENC2A+	Encoder 2 A+ input
	20	ENC2A-	Encoder 2 A- input
	21	ENC2B+	Encoder 2 B+ input
	22	ENC2B-	Encoder 2 B- input

**Note**

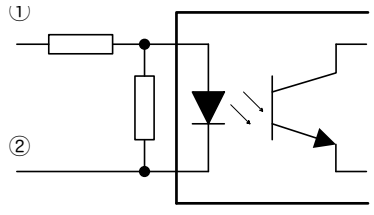
**\*Note1**

Wiring of encoder 1 is example about 5V voltage output type (open collector). When using 12V, 24V type MPG, change the input voltage from 5V to 12V or 24V and in case of 12V, connect 910Ω resistor to ENC1 A+(pin 1), ENC1 B+ (pin3), in case of 24V, 2.4kΩ resistor, before connecting the power source (adding PULL-UP resistor is needed)

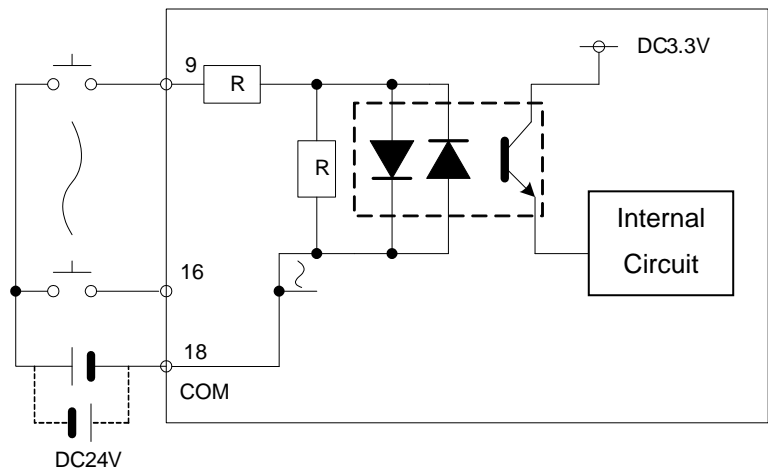
**\*Note2**

Wiring of encoder 2 is example about 5V voltage output type (line driver)

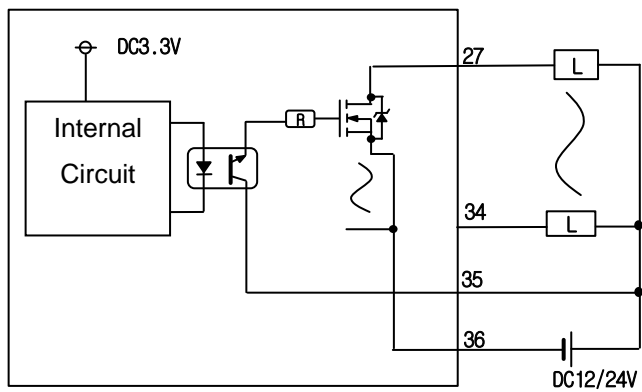
This describes the internal circuit of the module when connecting the encoder.

Item	Internal circuit	No.	Terminal	Pin number		Signal name
				Encoder1	Encoder2	
Input		①	A+	1	7	A phase pulse input +
		②	A-	2	8	A phase pulse input -
		①	B+	3	9	B phase pulse input +
		②	B-	4	10	B phase pulse input -

3. Input internal circuit



4. Output internal circuit

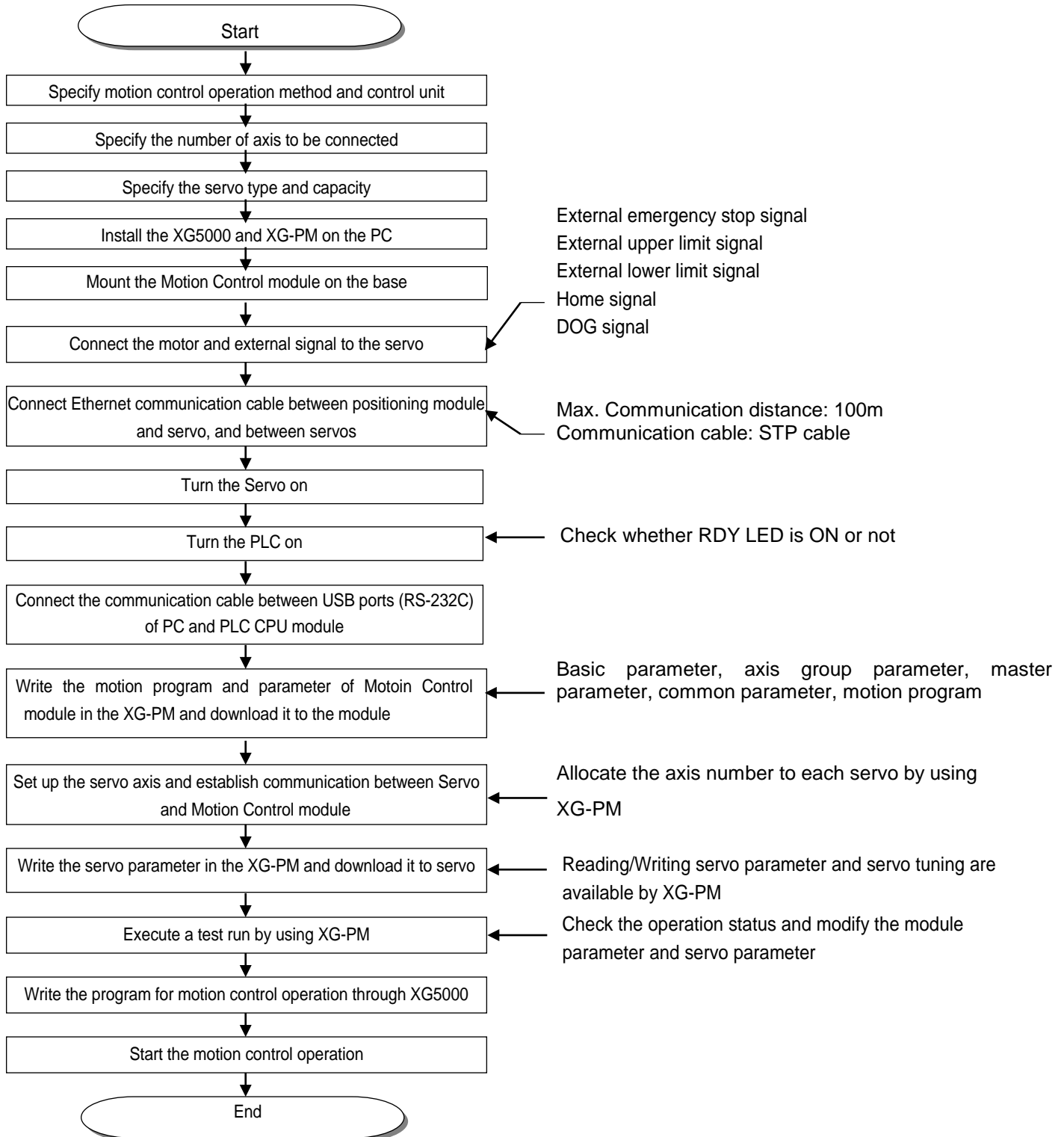




# Chapter 3 Operation Order and Installation

## 3.1 Operation Order

► Here describes the Operation order of Motion Control module.



## 3.2 Installation

### 3.2.1 Installation Environment

This machine has a good reliability regardless of installation environment but cares should be taken in the following items to guarantee the reliability and safety of the system.

#### 1. Environment Condition

- (1) Install the control panel available for water-proof, anti-vibration.
- (2) The place free from continuous impact or vibration.
- (3) The place not exposed to direct rays.
- (4) The place with no dew phenomena by rapid temperature change.
- (5) The place where surrounding temperature maintains 0-55°C.

#### 2. Installation Construction

- (1) In case of processing the screw hole or wiring, cares should be taken not to put the wiring remnants to PLC inside.
- (2) Install on the good place to operate.
- (3) Do not install the high voltage machine on the same Panel.
- (4) The distance from duct or surrounding module shall be more than 50mm.
- (5) Ground to the place where surrounding noise environment is good enough.

### 3.2.2 Notices in Handling

Here describes the notices in handling the positioning module from opening to installation.

- (1) Do not fall down or apply the strong impact.
- (2) Do not remove PCB from the case. It may cause the failure.
- (3) In wiring, cares should be taken not to put the wiring remnants or foreign materials to the upper part of module. If something entered, it should be removed.
- (4) The removal of module in the status of power ON is prohibited.

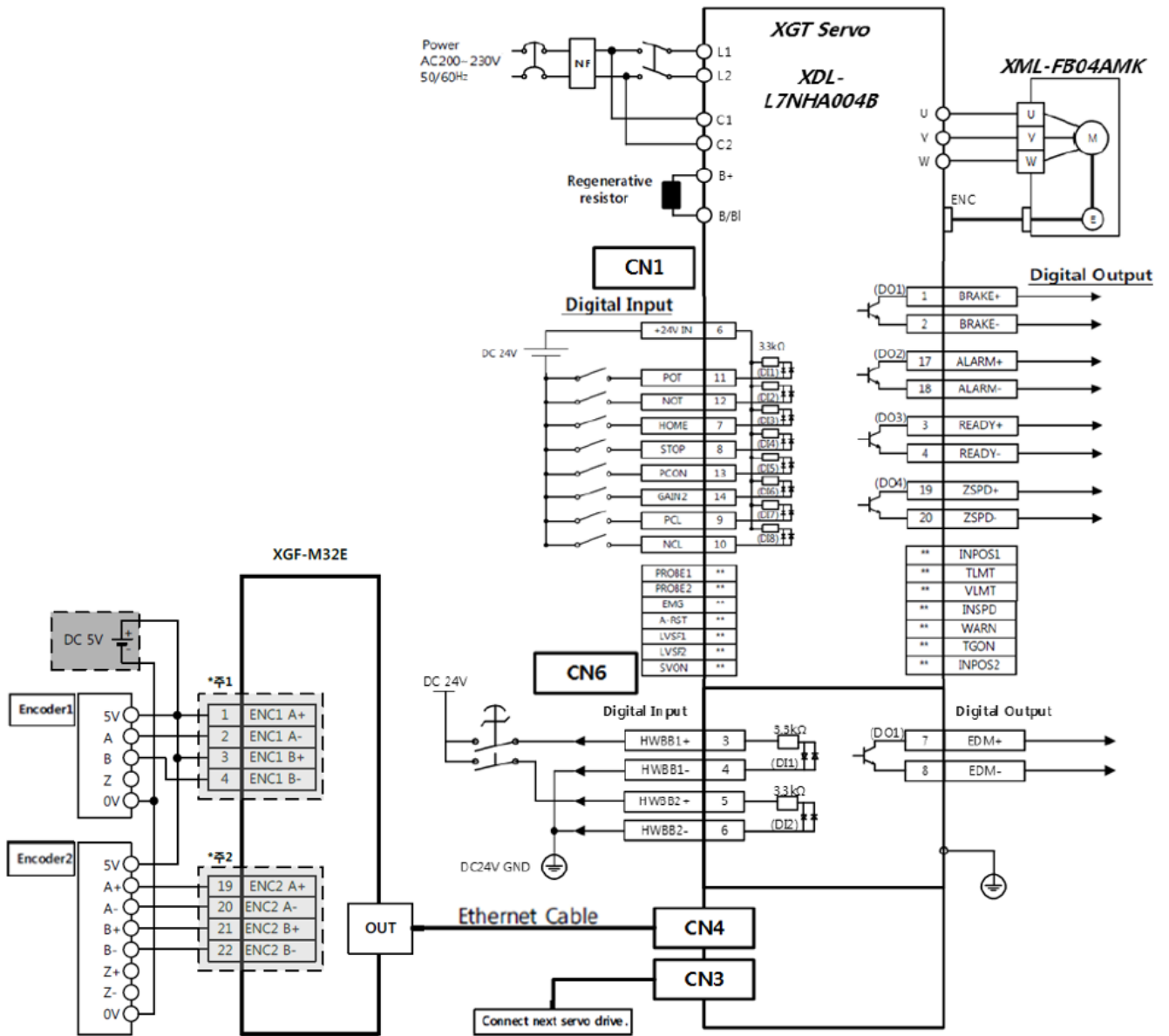
### 3.3 Notices in Wiring

#### 3.3.1 Notices in Wiring

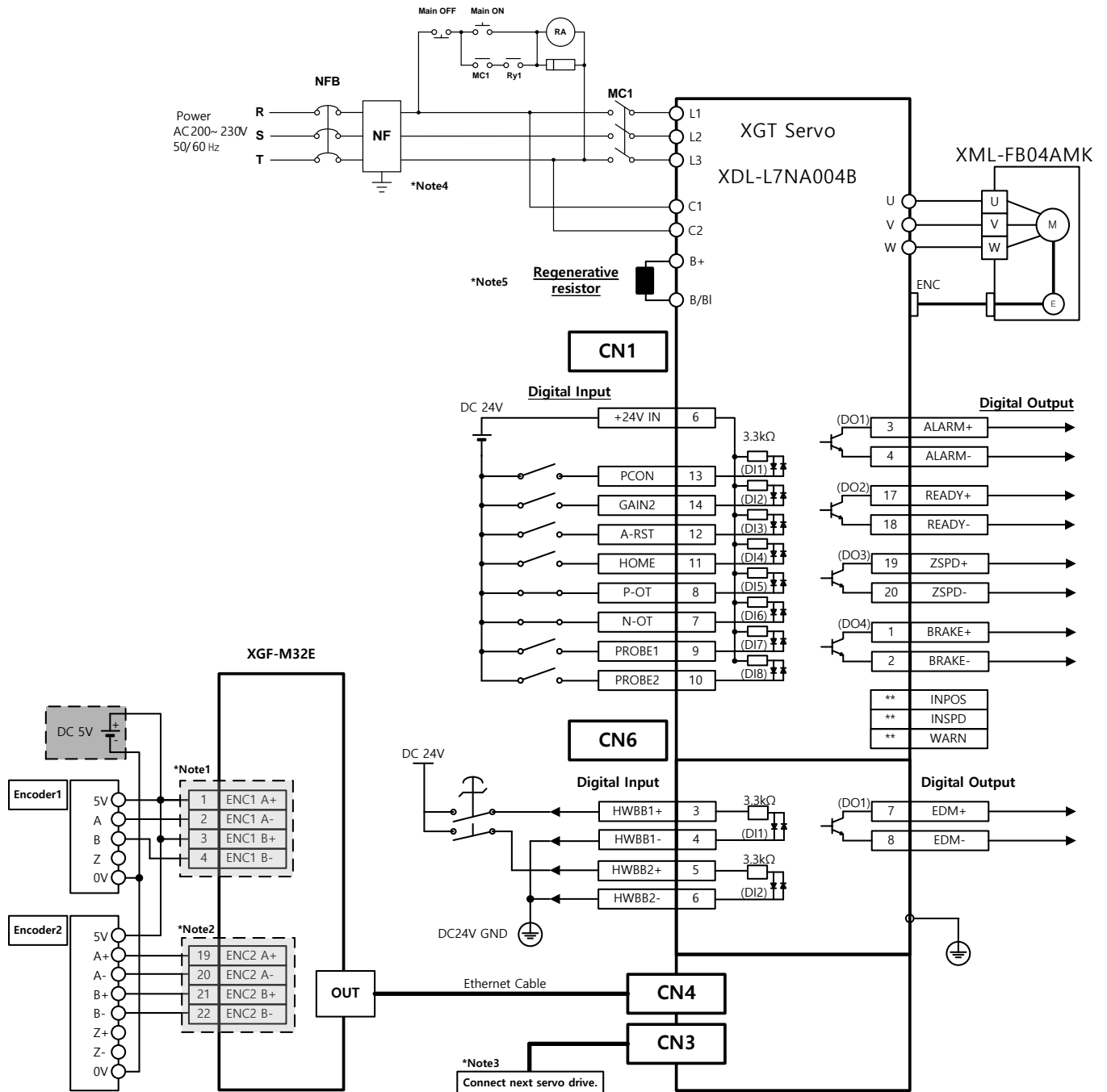
- (1) The length of connecting cable between positioning module and drive machine shall be as short as possible. (Max. length: 2m and 10m).
- (2) For alternating current and external I/O signal of positioning module, it is required to use the separate cables to avoid the surge or induction noise generated from the alternating current.
- (3) The wires should be selected considering surrounding temperature, allowable current and it is recommended to be more than max. size AWG22(0.3mm<sup>2</sup>).
- (4) In wiring, if it is too close to the high temperature machine or material or it is directly contacted to the oil for a long time, the short-circuit will occur that may cause the damage or malfunction.
- (5) Make sure to check the polarity before applying the external contact signal to the terminal board.
- (6) In case of wiring the high voltage cable and power cables together, the induction noise occurs that may cause the malfunction or failure.
- (7) In case of wiring by the pipe, the grounding of pipe is required.
- (8) Connect the line between motion control module and EtherCAT slave device by using more than STP CAT-5 in wiring between motion control module and drive unit.
- (9) When a communication error(0x0F50, 0x0F51, 0x1F00, 0x1011, 0x2011, etc.) occurs in operation of motion control module, attach Ferrite Core to communication cable connecting motion control module to EtherCAT slave device and run the module because it may be caused by noise interference in wiring between motion control module and EtherCAT slave device.
- (10) When using the wiring connector for encoder signal and external I/O signal, install it on the place where there is no dust or corrosive gas.

### 3.3.2 Connection Example of Servo and Stepping Motor Drive Machine

- (1) This is an example of wiring which connects EtherCAT servo drive/motor, the XDL-L7NH Model of XGT Servo, in motion control module (XGF-M32E). Refer to manual of each drive for details on installation and wiring.



- (2) This is an example of wiring which connects EtherCAT servo drive/motor, the XDL-L7N Model of XGT Servo, in motion control module (XGF-M32E). Refer to manual of each drive for details on installation and wiring.





### Note

#### \*Note1

Wiring of encoder 1 is an example about 5V voltage output (open collector) type.

#### \*Note2

Wiring of encoder 2 is an example about 5V voltage output (line driver) type.

#### \*Note3

When connecting more than 2 servo drivers, connect first servo driver's IN to the positioning module's OUT and for other servo drivers, connect previous servo driver's OUT to next servo driver's IN. last servo driver's OUT doesn't need to be connected. And connection order is not related with axis order.

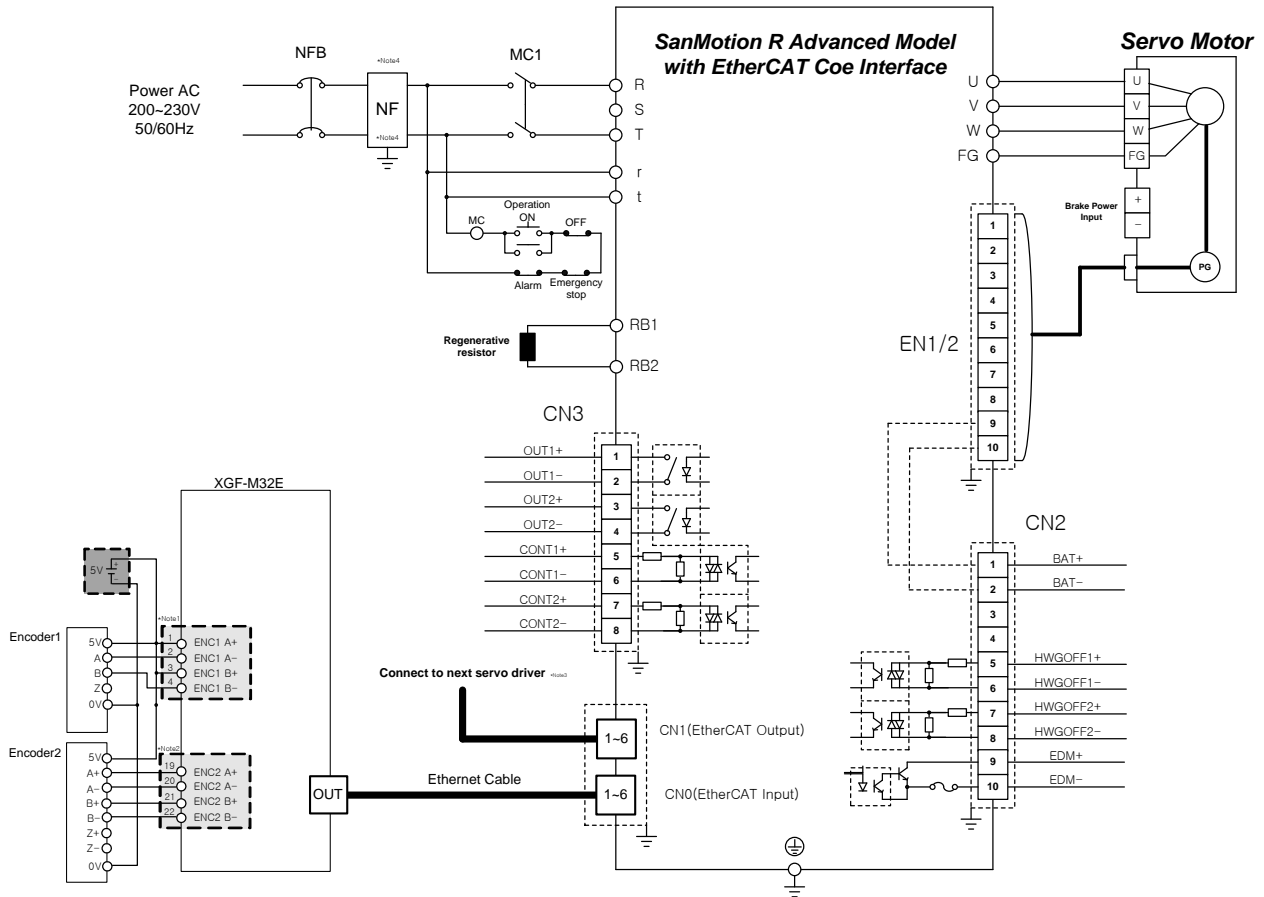
#### \*Note4

NF is abbreviation of Noise Filter. It is necessary to prevent the noise from coming in.

#### \*Note 5

Use after making a short circuit between terminals B and BI as regenerative resistor of L7NA001B~L7NA004B (50[W], 100[Ω]), L7NA008B ~L7NA010B(100[W], 40[Ω]), L7NA020B~ L7NA035B(150[W], 13[Ω]) is contained inside. In case of a high regeneration capacity due to frequent acceleration/deceleration, open the shorting pin(B, BI) and connect external resistor to B and BI to use.

- (3) This is wiring example connecting SanMotion R Advanced Model EtherCAT servo drive/motor to Motion Control module(XGF-M32E). For detail on installation and wiring, refer to the driver manual.



**Note**

\*Note1

Wiring of encoder 1 is an example about 5V voltage output (open collector) type.

\*Note2

Wiring of encoder 2 is an example about 5V voltage output (line driver) type.

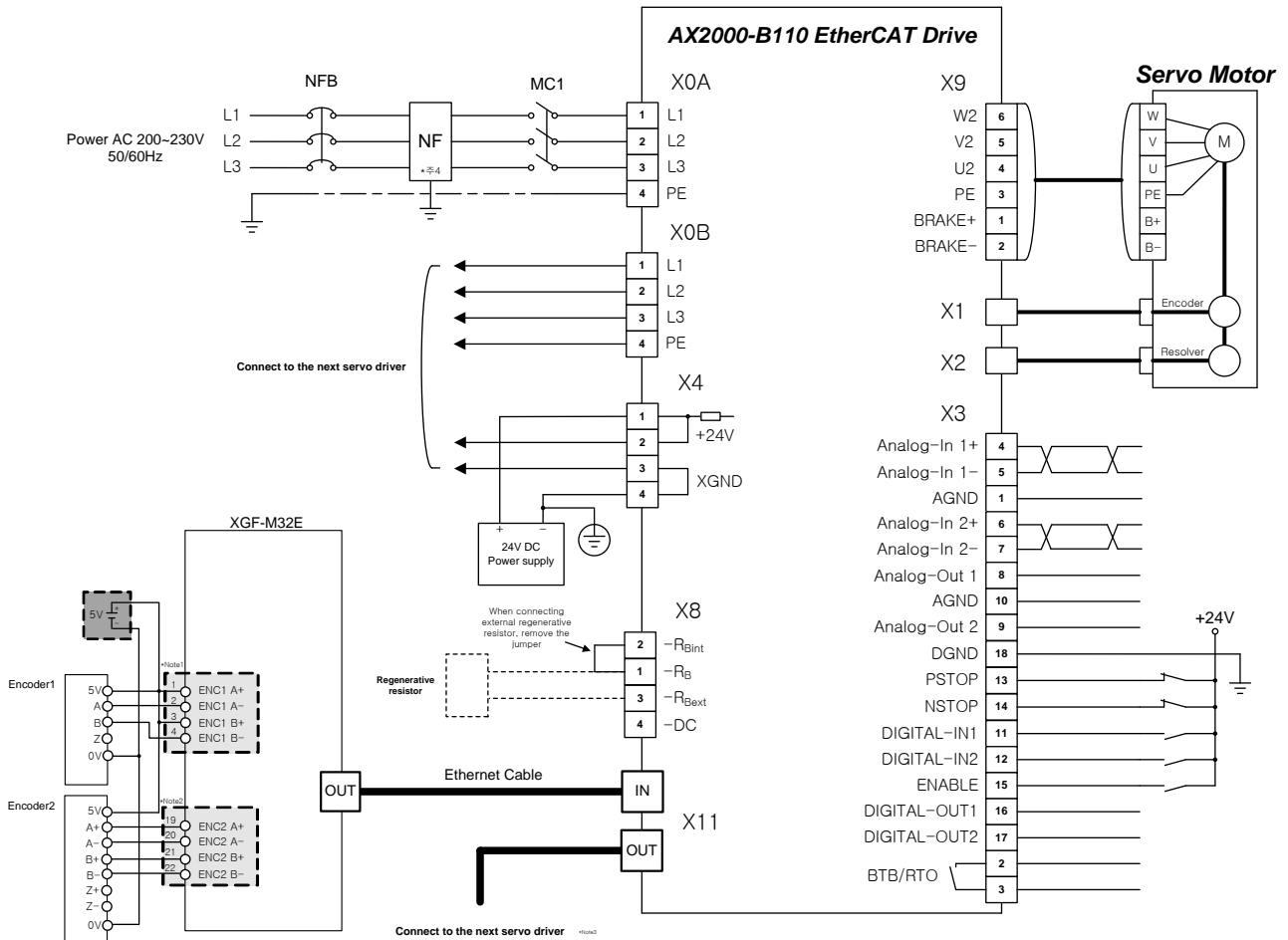
\*Note3

When connecting more than 2 servo drivers, connect first servo driver's IN to the positioning module's OUT and for other servo drivers, connect previous servo driver's OUT to next servo driver's IN. last servo driver's OUT doesn't need to be connected. And connection order is not related with axis order.

\*Note4

NF is abbreviation of Noise Filter. It is necessary to prevent the noise from coming in.

- (4) This is wiring example connecting BeckHoff AX2000 servo drive/motor to Motion Control module (XGF-M32E). For detail on installation and wiring, refer to the driver manual.



**Note**

\*Note1

Wiring of encoder 1 is an example about 5V voltage output (open collector) type.

\*Note2

Wiring of encoder 2 is an example about 5V voltage output (line driver) type.

\*Note3

When connecting more than 2 servo drivers, connect first servo driver's IN to the positioning module's OUT and for other servo drivers, connect previous servo driver's OUT to next servo driver's IN. last servo driver's OUT doesn't need to be connected. And connection order is not related with axis order.

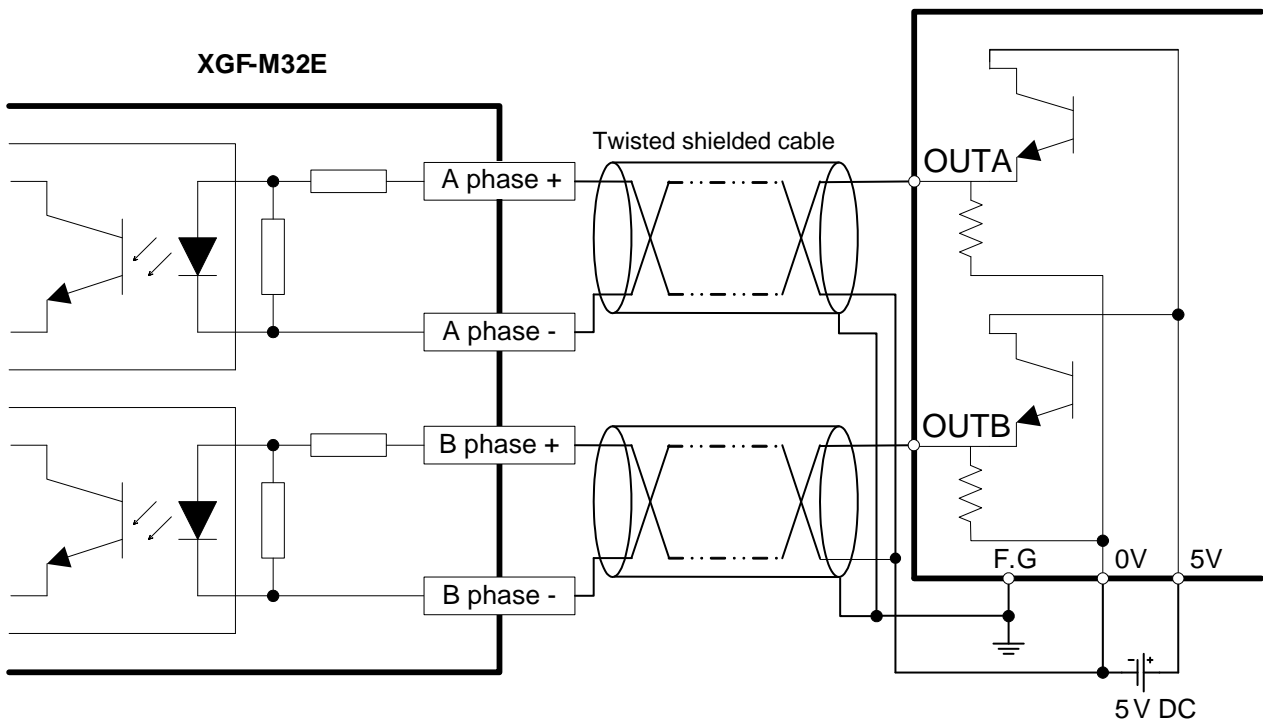
\*Note4

NF is abbreviation of Noise Filter. It is necessary to prevent the noise from coming in.

### 3.3.3 Encoder Input (DC 5V Voltage Output) Wiring Example

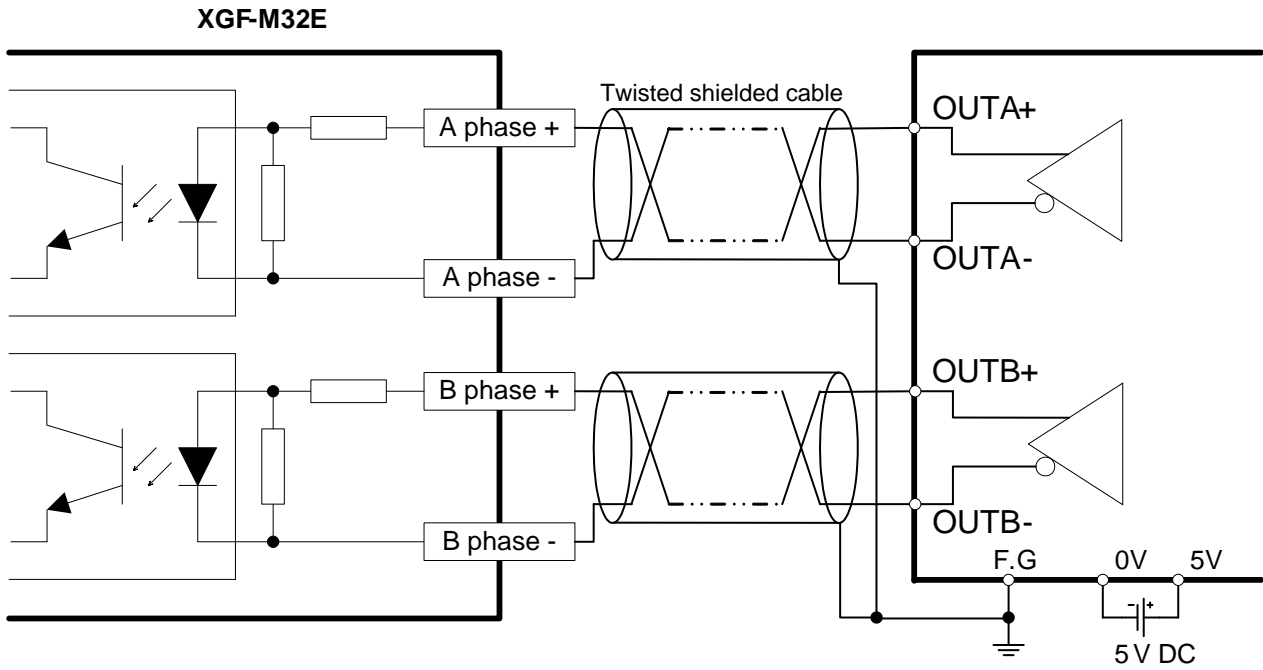
When Pulse Generator is a Voltage Output type, wiring example of positioning module and Encoder input part is as follows.

In case pulse generator is totem-pole output and used as voltage output style, wiring is equal.



**Notes**  
 Before Wiring, please consider maximum output distance of pulse generator.

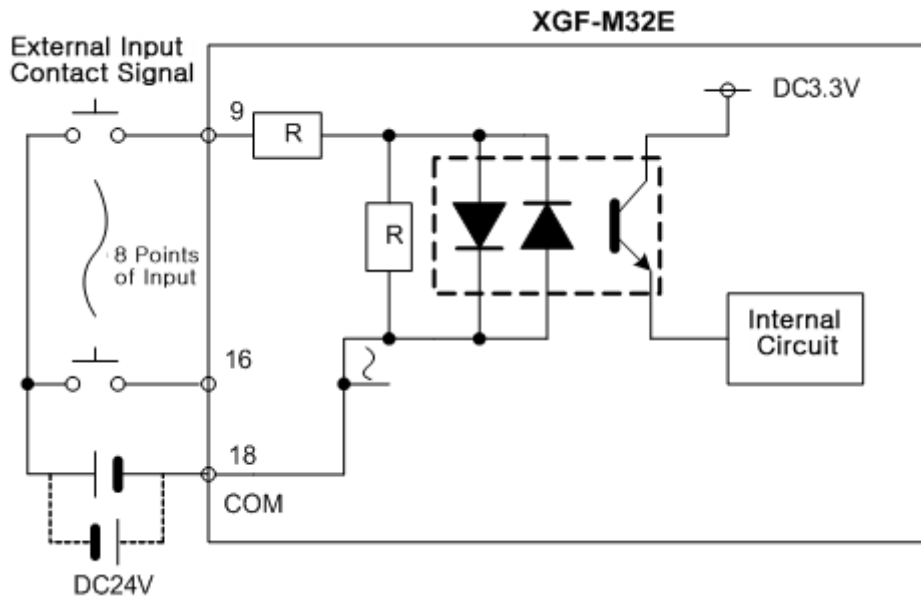
### 3.3.4 Encoder Input (5V Line Driver Output) Wiring Example



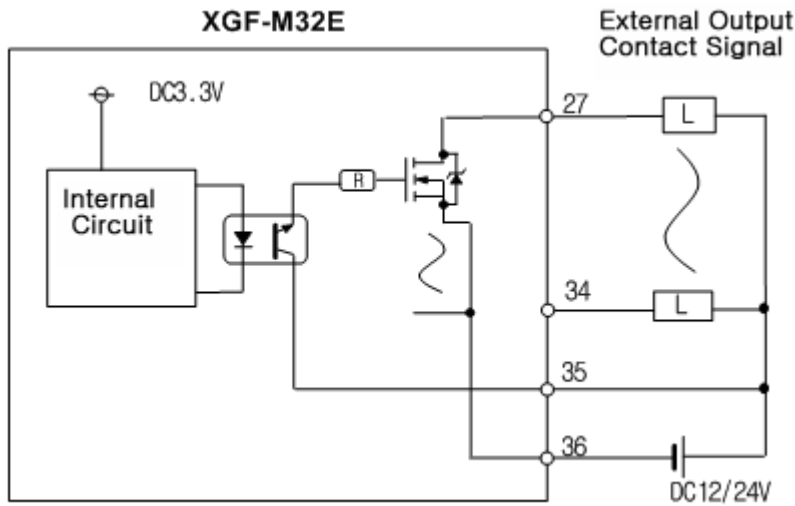
**Notes**

Before Wiring, please consider maximum output distance of pulse generator.

3.3.5 External Input Signal Wiring Example



3.3.6 External Output Signal Wiring Example



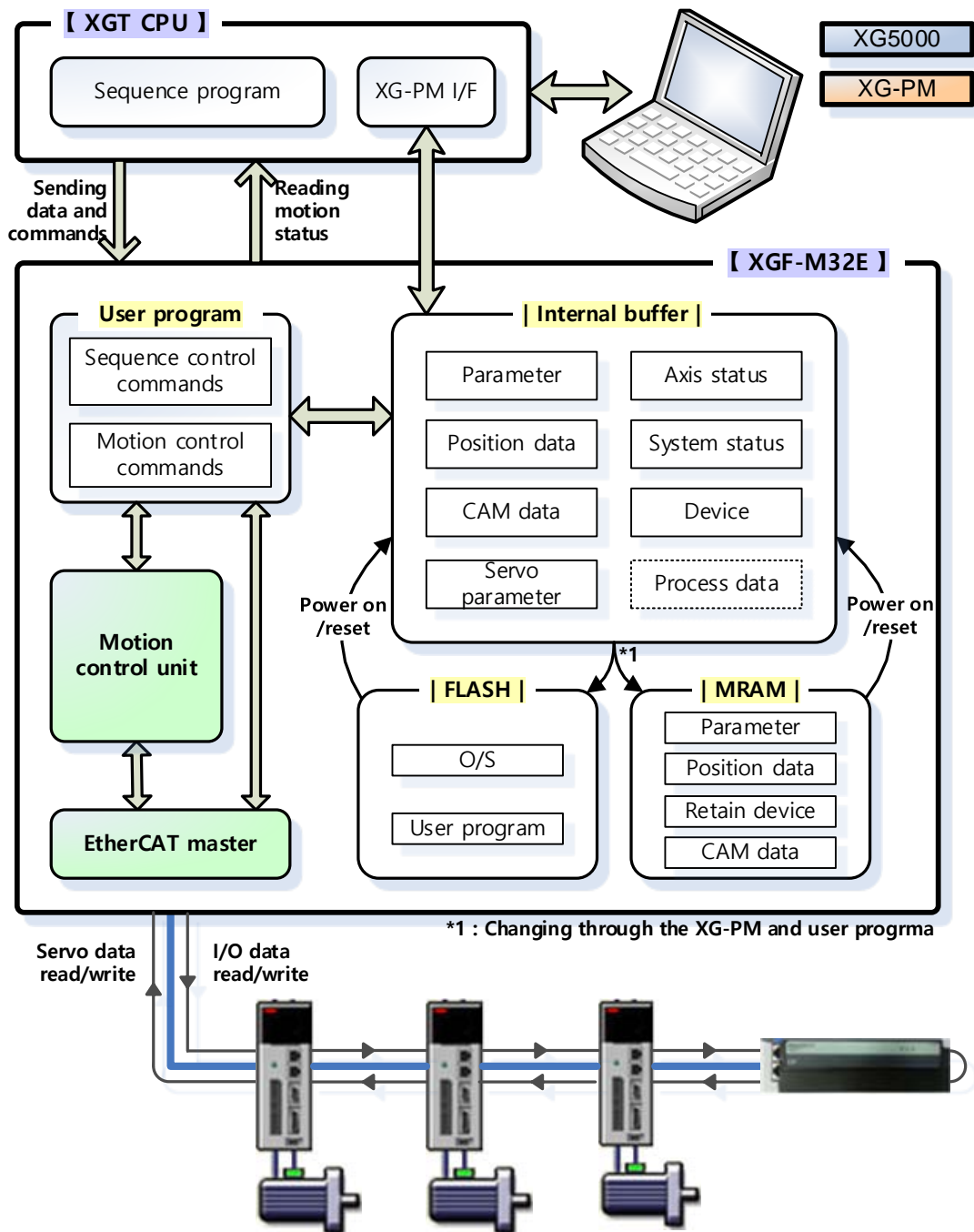


# Chapter 4 Motion Control Operation

This chapter describes structure, parameter and device of Motion Control module.

## 4.1 Structure of Motion Control Module

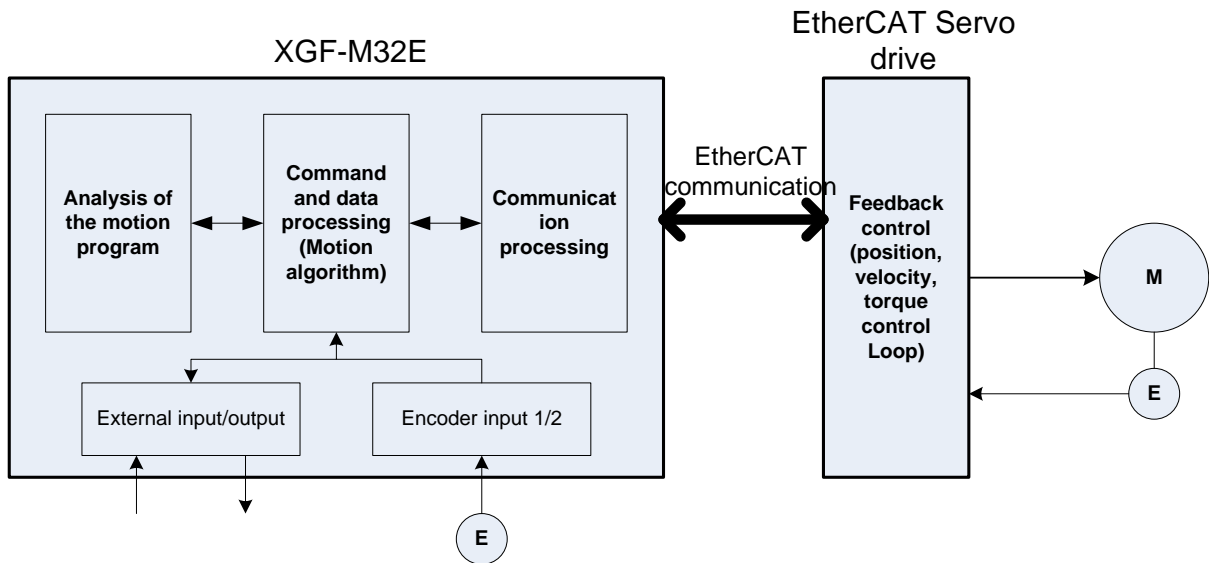
This picture describes process of parameter and operation data saved in the module.





## 4.2 Configuration of Motion Control

XGF-M32E is motion control module of XGK//R series; it can control up to 32 axes of actual motor axis and 4 virtual axes through EtherCAT. Also, it can control up to 4 EtherCAT I/Os besides 8 points of input and 8 points of output included inside. Motion control block diagram of motion control module is shown below.



### 4.3 Motion Control Tasks

The following describes tasks of the motion control module.

#### 4.3.1 Types of Tasks

There are 3 types of motion control tasks: main task, periodic task and initialization task.

The main task completes the motion within the period set by the user, and it performs I/O refresh, program process, motion control and processes EtherCAT synchronous communication. The set period of the main task is 1/2/4ms, and it can be set in the basic parameter of the motion control module.

The period of the periodic task can be set in multiples of the main task's period set by the user, and the periodic task is processed in the remaining time after the main task is completed during the period of each task.

Therefore, the periodic task can be performed over a number of main task periods.

The initialization task is only performed once at the beginning when the motion control module is entering the RUN mode, and it is normally used for setting the initial data of the system and the parameter.

Types of Tasks	Number of Programs	Motions
Main task	Up to 256	<ul style="list-style-type: none"> <li>· It performs I/O refresh, processing of programs assigned to main task and motion control.</li> <li>· It performs the above tasks at a time for each of the established control period (main task cycle).</li> <li>· It has higher priority than periodic task.</li> <li>· It uses programs that require synchronized control and high-speed operation processing through allocation since it is possible to process program fast.</li> <li>· Period possible to be set: 1ms, 2ms, 4ms</li> </ul>
Periodic task		<ul style="list-style-type: none"> <li>· It performs processing of programs assigned to main task.</li> <li>· It is performed for the remaining time after implementation of main task operation within the control period, and can be performed over multiple cycles.</li> <li>· Since it has lower priority than main task in the execution of motion control commands within main task program, the motion control commands executed in the main task program are processed first.</li> <li>· It uses programs of processing other monitoring data and control of device that doesn't require high-speed processing through allocation.</li> <li>· Period possible to be set: 1ms ~ 100ms (Set to a multiple of the main task cycle)</li> </ul>
Initialization task		<ul style="list-style-type: none"> <li>· It performs processing of programs assigned to the initialization task after implementing I/O refresh.</li> <li>· It is performed only once at the time of entering the RUN mode.</li> </ul>

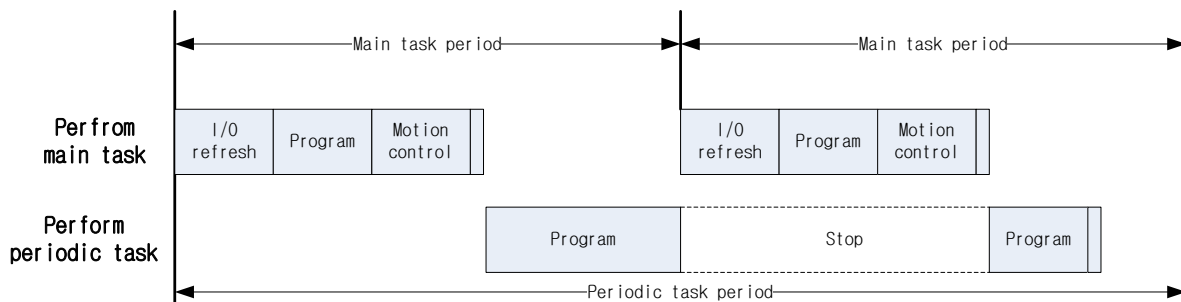
**Note**

If main task period exceeds setting range, an error 0x0051 occurs.  
 If periodic task period is not set to a multiple of the main task period, an error 0x0052 occurs.  
 Please check the task period if the above errors occur.

### 4.3.2 Task Operation

#### Overall task operation

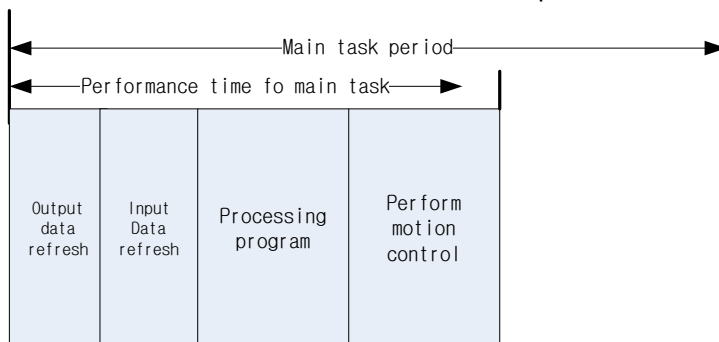
The task is composed of the main task and periodic task. The main task performs I/O refresh and processes program as well as motion control motion according to the processing of the program during the control period. The periodic task is performed in the control period in the remaining time after the main task is completed and it can be completed after going through many control periods.



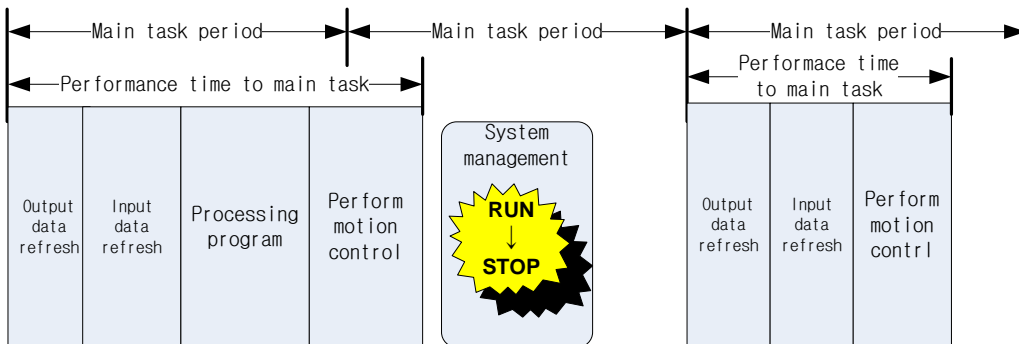
#### 2. Main task operation

The main task must be performed in the set task period, and if the performance of the main task exceeds the set main task period, an error occurs and if motion control module is in RUN state, it is changed to STOP state.

(1) Performance time of main task  $\leq$  Main task period



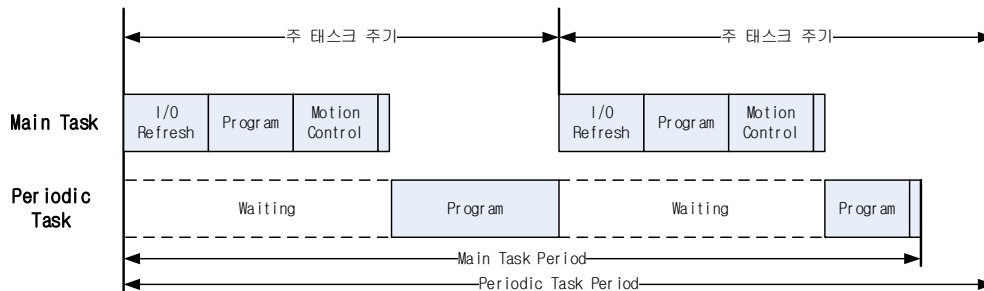
(2) Performance time of main task > Main task period



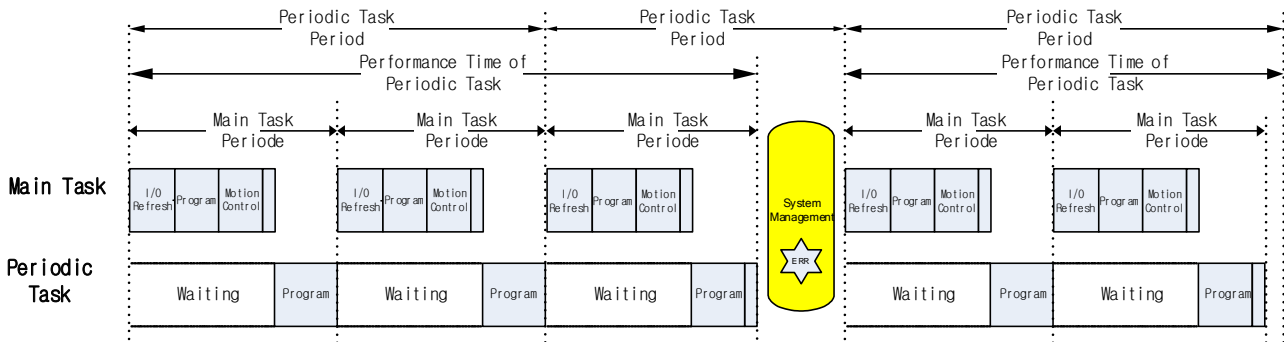
3. Periodic task operation

The periodic task is performed in the remaining time after performing the main task in the set control period and it can be performed over many control periods depending on the performance time of the task. An error will occur if the performance of the periodic task exceeds the set period of the periodic task, but it does not change the RUN/STOP state of the motion control module.

Performance time of periodic task ≤ Periodic task period



Performance time of periodic task > Periodic task period



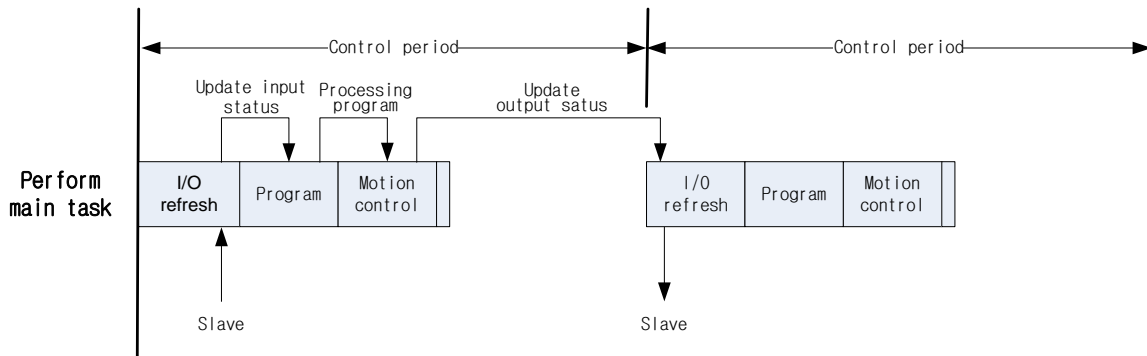
#### 4. Initialization task operation

The initialization task is a task performed only once at the beginning when motion control module is entering the RUN mode. It is mainly used to set the initial data of the system and the parameter. The initialization task must be also performed in the set task period like the main task, and an error will occur if the performance of the initialization task exceeds the set period of the main task, and it is changed to stop state. When using the basic function block and motion function block in the initialization task program, the function of the relevant function block may be limited. This is because it is only performed once when it enters the RUN mode due to the characteristic of the initialization task, and in the case of function block, the output parameter is not updated. Therefore, when using the basic function block and motion function block in the initialization task program, the output of the relevant function block may be different to its real function, so please take caution when in use.

### 4.3.3 Execution of Motion Commands

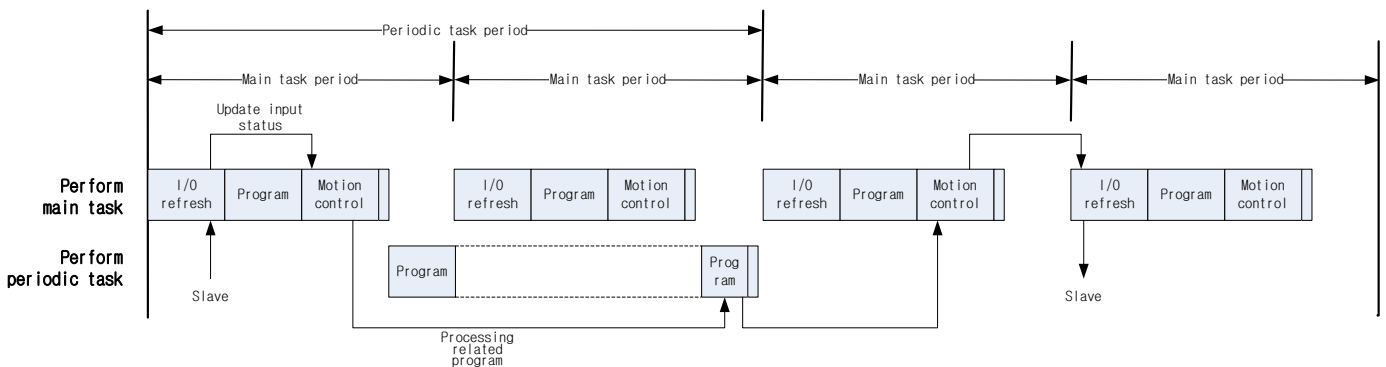
#### 1. Execution of motion commands in the main task

Execution of motion instruction of the main task is shown in the figure below. The input value of the slave and the system parameters are updated by the I/O refresh motion of the main task, and based on this information, the program is processed and motion control motion is performed. The outcome of the performance is output in slave module at the I/O refresh time of the next control period.



#### 2. Execution of motion commands in the periodic task

Execution of motion instruction in the periodic task is shown in the figure below. According to the I/O refresh motion of the main task, the input value of slave and the system parameters are updated and motion control is performed in the main task based on this information. The program of the periodic task is performed by this result, and motion control is performed with this result while the main task is being performed in the control period after the performance of the periodic task. Also the outcome of this motion control performance is output in slave at the I/O refresh time of the next control period

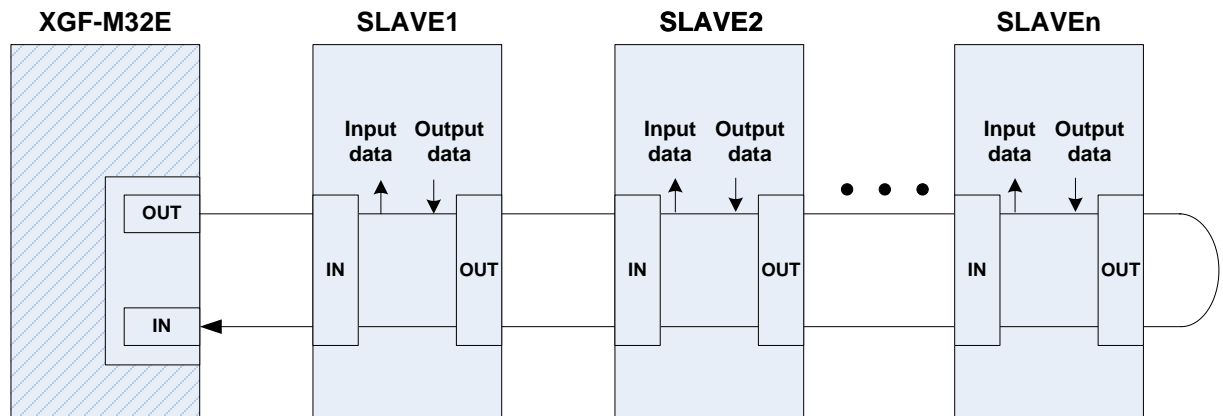


## 4.4 EtherCAT Communication

The communication of EtherCAT(Ethernet for Control Automation Technology) is explained here.

### 4.4.1 What is EtherCAT

EtherCAT is a high-performance industrial network system which uses Real-Time Ethernet based on the Ethernet developed by Beckhoff Company in Germany. EtherCAT is a communication between the master and the slave, and it provides a short communication cycle time by transmitting Ethernet Frame at a high speed between each nodes. When data Frame transmitted from the master to the slave passes through the slave, EtherCAT communication sends the received data to the relevant data Frame at the same time as the slave receives the transmission data. In other words, EtherCAT does not transmit data to each slave nodes of the network but passes one communication Frame to every slave in order, and each slave reads and writes Data in its relevant area in the Frame when the communication Frame passes through each slave. The communication Frame performs high speed data transmission with a structure where after going through the last slave, it turns back and passes through every slave and is transmitted to the master.



### 4.4.2 CoE(CANopen over EtherCAT)

Motion control module uses the slave and EtherCAT to communicate and uses CoE(CANopen over EtherCAT) as the protocol for information exchange.

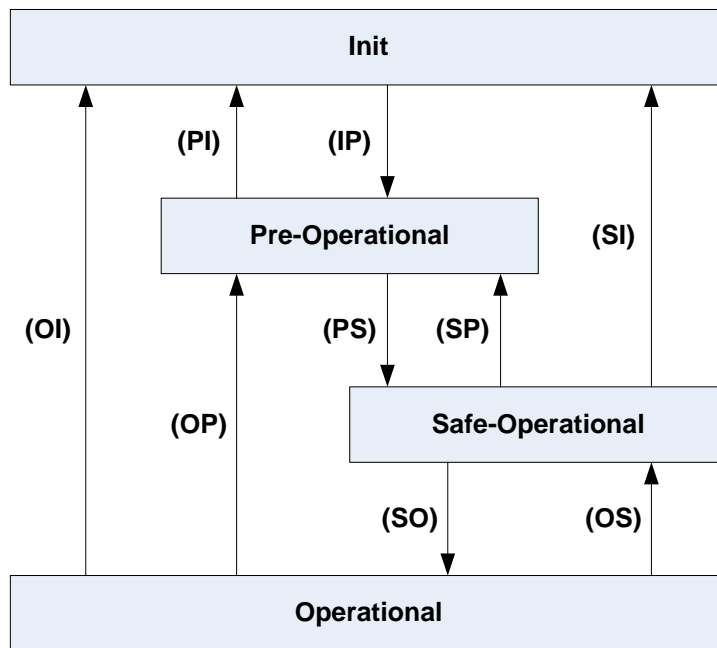
In CoE, parameter and data information of the slave are composed of Object Dictionary. Object Dictionary contains the information used in the configuration of the device and communication, and it is a group of the object (parameter) which can be accessed through the network. In the communication between master-slave using CoE, there are a communication which uses Process Data Object (PDO) and synchronously transmits information, and a Service Data Object (SDO) communication which occurs asynchronously.

Motion control module regularly performs process data communication to receive and send input/output signal and to control the position of EtherCAT slave (servo drive). It also performs service data communication in terms of an error state in the slave and the parameter reading/writing whenever there is a request.

Types of communication	Communication time	Contents
Process Data Communication (PDO Communication)	Synchronous (main task period)	servo drive position control data, input/output of data, etc.
Service Data Communication (SDO Communication)	Asynchronous (in request)	servo parameter reading/writing, servo error information reading, etc.

### 4.4.3 EtherCAT State Machine

The state and motion between states of EtherCAT communication are shown in the figure below.



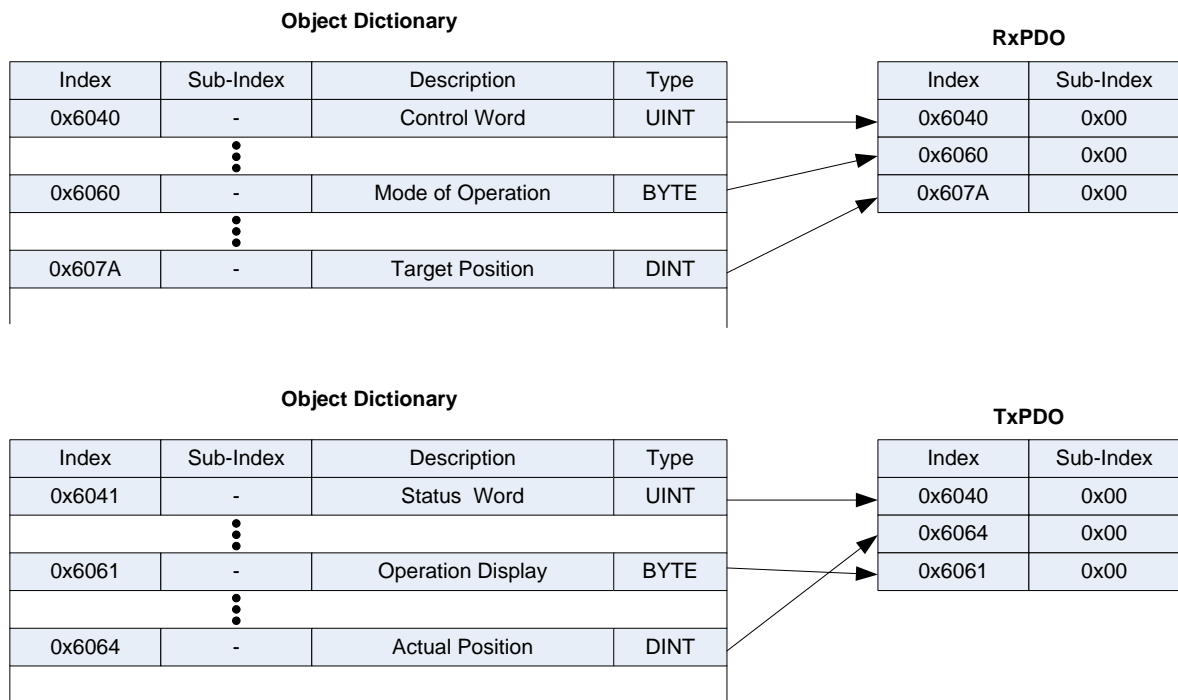
The communication between the master-slave of EtherCAT communication begins from the Initial state and progresses to the Operational state. In the motion control module, the slave servo drive can be controlled with a normal process data communication when it is in operational state.

If a communication error occurs while the motion control module performs the slave and EhterCAT communication at operational state, the communication state is changed to the Initial state and the communication between the slaves is discontinued. In this case, the factor of communication error should be removed and reconnect with the slave to restart the communication.



### 4.4.4 EtherCAT Process Data Objective(PDO)

The synchronous data communication in EtherCAT communication of motion control module occurs through process data object (PDO). There are two types of process data: TxPDO which is transmitted from the slave to motion control module, and RxPDO which is transmitted from motion control module to the slave. In RxPDO and TxPDO, data which are going to be synchronous communication can be put together to be set as the example of the figure below shows among the data defined in the Object Dictionary.



Slave manufacturers sometimes set many RxPDO and TxPDO in advance and provide Slave Information File including this information in xml format. When initially setting and test operating this slave information file, it should be transmitted to the motion control module using the XG-PM. This slave information file should be analyzed and communicated to the PDO data which is optimized for controlling.

### 4.4.5 Specification of Motion Control Module EtherCAT Communication

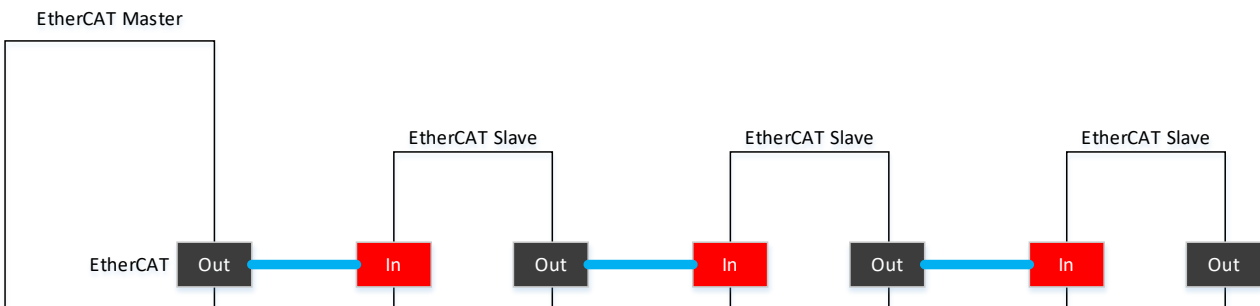
Item	Specification
Communication protocol	EtherCAT
Support specification	CoE(CANopen over EtherCAT)
Physical layer	100BASE-TX
Communication speed	100Mbps
Topology	Daisy Chain
Communication cable	Over Cat. 5 STP(Shielded Twisted-pair) cable
No. of maximum slave	36
Communication period	1ms/2ms/4ms
Synchronous Jitter	Within 1 $\mu$ s
Synchronous communication	PDO(Process Data Object) Mapping through CoE
Non-synchronous communication	SDO(Service Data Object) communication through CoE
Communication setting	Set the communication configuration using XG-PM

### 4.4.6 EtherCAT Network Connection

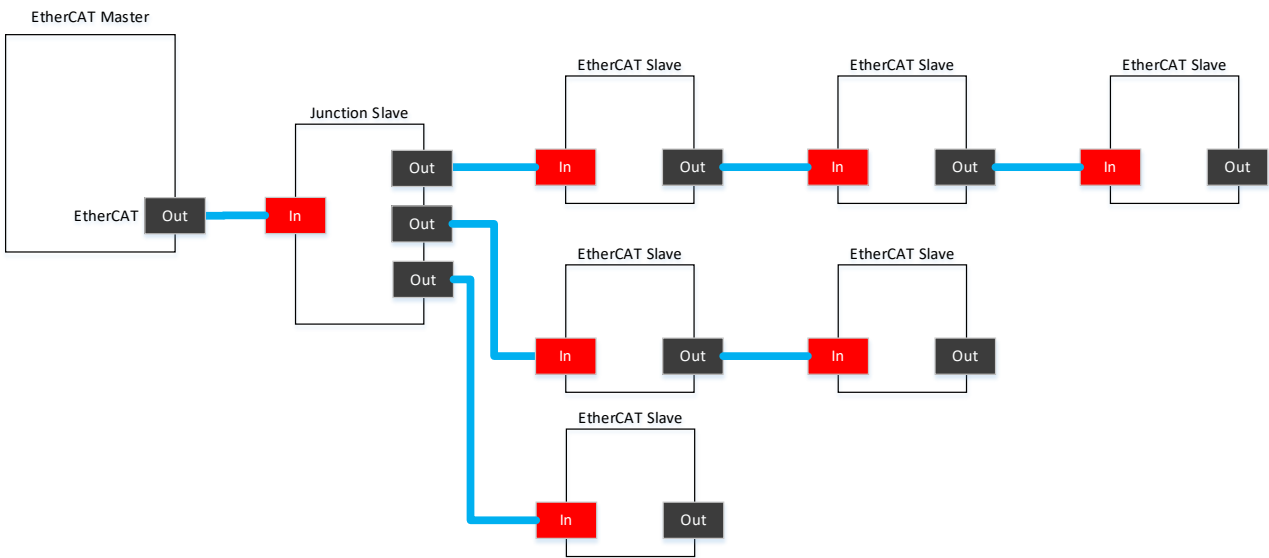
(1) Supported Topology

XMC generally constitutes a network using a daisy chain connection. It can constitute branches using junction slaves. XMC also can use cable duplication by constituting a network with rings using junction slaves.

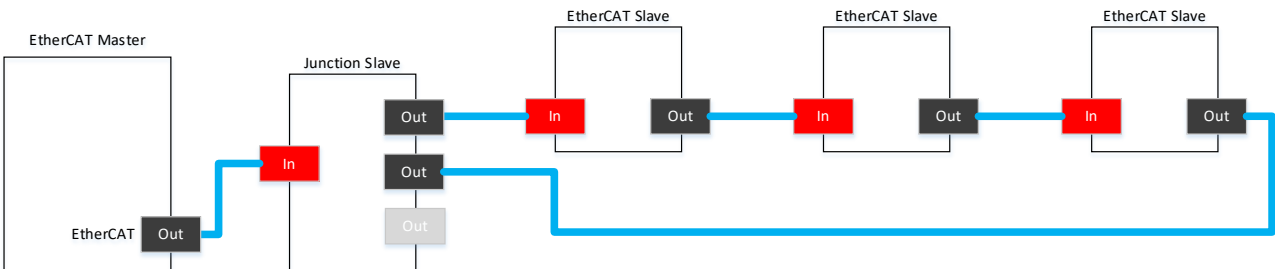
1) Not-using Branches



## 2) Using Branches



## 3) Cable Duplication Configuration



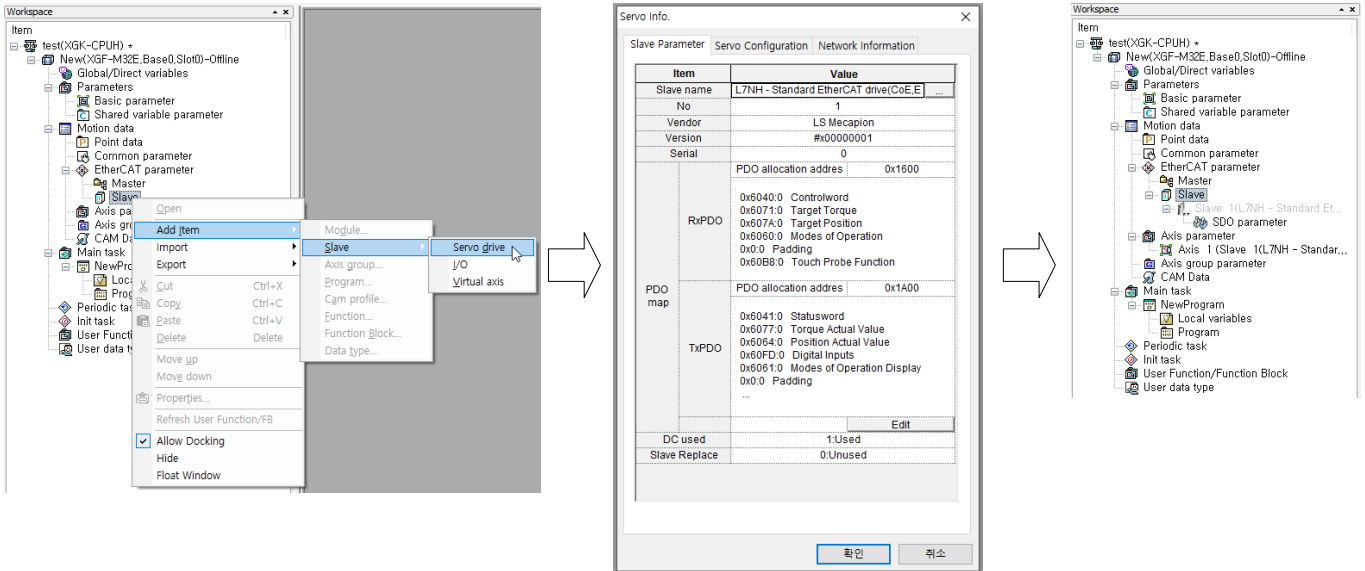
### (2) Notes

- 1) When connecting to EtherCAT slaves, be careful of not connecting to In/Out in reverse.
- 2) Equipment with several junction slaves is not allowed.
- 3) When using cable duplication with junction slaves, do not use the remaining ports of the junction slave.
- 4) Junction slaves must use products that provide the EtherCAT reference clock.
- 5) When connecting to EtherCAT, configuration of the slave setting should be identical with the real configuration.

### 4.4.7 EtherCAT Network Setting

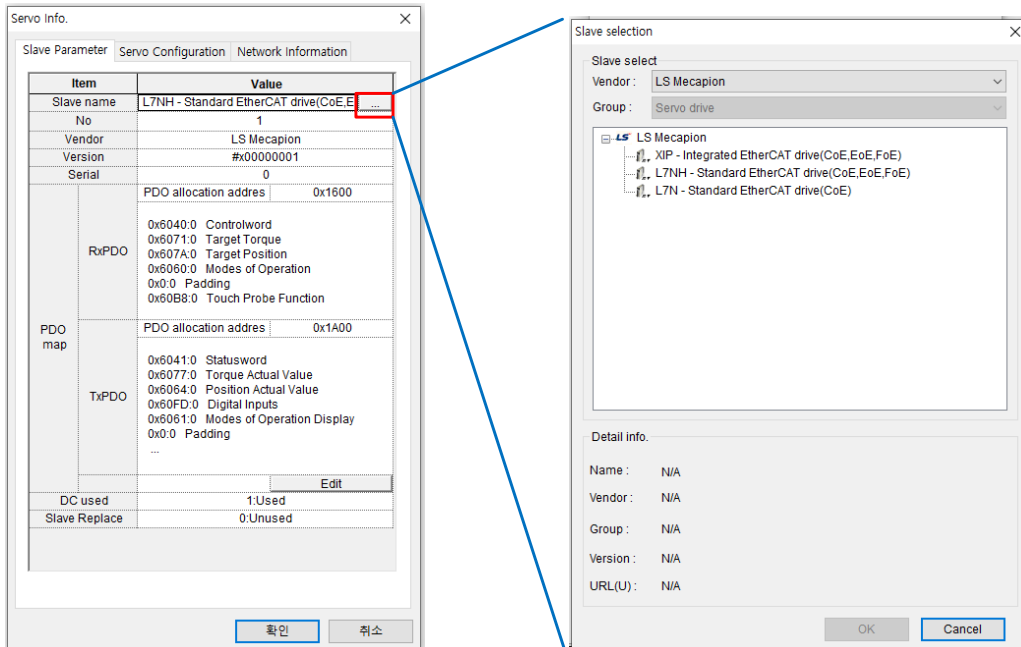
(1) Set Network in the Project Tree

- 1) To add slaves on the EtherCAT network, select “Add Items - Add Slaves” by clicking on the right mouse button over slaves in the project tree.



2) When the slave information window displays, check a slave name, select the confirmation button and add slaves.

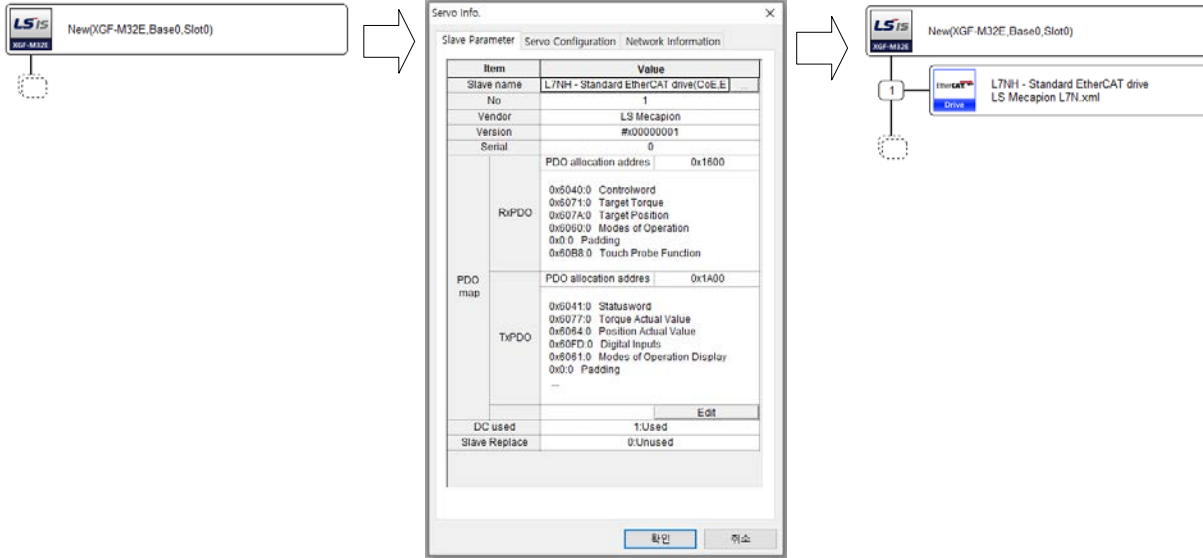
- 3) If adding other slaves, select slaves in the slave selection window by clicking the “...” button next to a slaves name.



4) Check if slaves are correctly added in the project window.

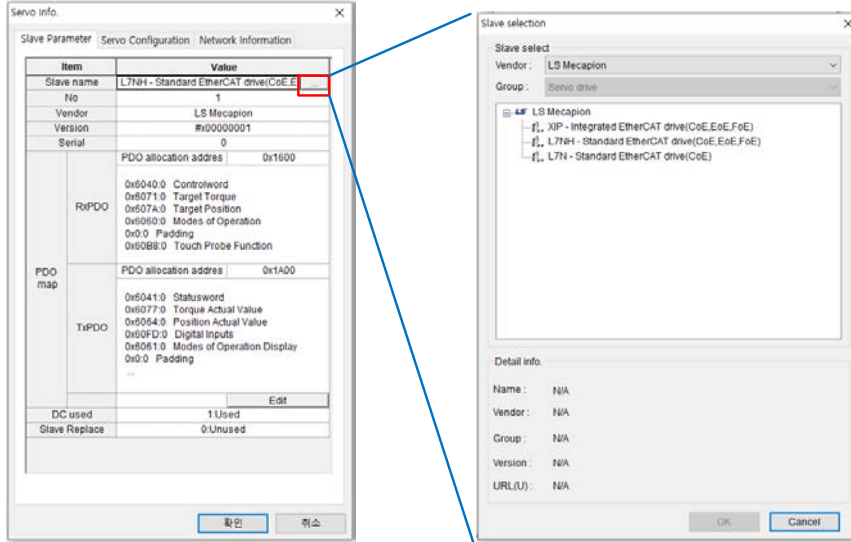
(2) Set Network in the EtherCAT Network Screen

1) Select View-EtherCAT Network from the menu.



2) Double-click  in the EtherCAT Network Screen.

3) Confirm a slave name in the slave information window and click the confirm button.







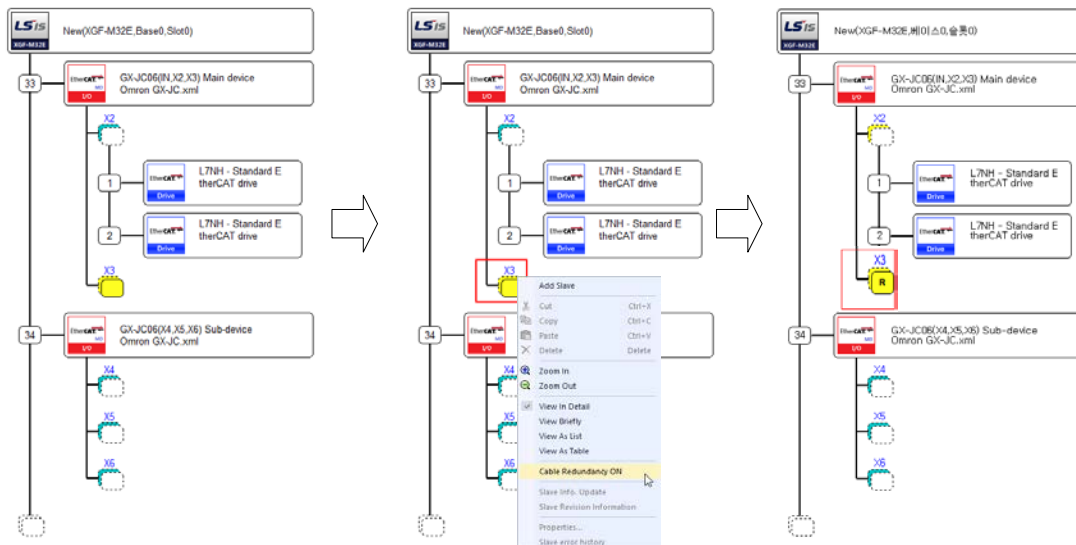
4) When adding other slaves, click the “...” button in the slave information window.

5) Confirm if a slave is correctly added in the network view screen.

(3) Set Cable Duplication in the EtherCAT Network Screen

A single motion controller supports cable duplication that uses junction slaves. To use the cable duplication function, the cable duplication setting is needed for EtherCAT network parameters when supporting EtherCAT Network cable duplication.

- 1) Click and add the junction slave by clicking  in the EtherCAT Network Screen.
- 2) Click  that represents the port of a junction slave and add slaves to the port 2 (X2) of a junction slave.
- 3) When adding slaves to the port 2, the display of the port changes into , which signifies the duplication setting is possible.
- 4) Select the port 3 (X3) or the port 5 (X5) of the junction slave and click the right mouse button.
- 5) Select the Cable Duplication Setting Menu.
- 6) Confirm if duplication is set to the port of a junction slave. A duplication port is marked as .



## 4.5 Motion Control Program

### 4.5.1 Program Execution

#### 1. Configuration of the program

Motion control program is composed of functional elements needed in performing certain controls and it is performed in the internal RAM of motion control module. The program is backed up in the flash memory. Programs with these functional elements are classified as follows.

Program	Processing information
Main task program	Process the command which is executed in every 'main task period'.
Periodic task program	Process the command which is executed in every 'periodic task period'.
Initialization task program	Execute the command which is executed once in case of motion control module RUN.

#### Note

Since the motion control program is stored in a flash memory, the number of program writes is limited to 100,000. Be careful when using the program.

### 4.5.2 Operation Modes

#### 1. RUN mode

This is a mode which normally performs the motion program calculation.

##### (1) Processing when changing the mode

Initialization is performed in the data area at the beginning, and possibility of performance is decided by examining the validity of the motion program.

##### (2) The contents of calculation processing

Motion program, motion command calculation, input/output data processing, and EtherCAT communication are performed.

#### 2. STOP mode

This is a mode in stop state which does not perform the motion program calculation.

##### (1) Processing when changing the mode

Every output data is in Off state.

##### (2) The contents of operation processing

This performs EtherCAT communication.

**3. TEST mode**

This is a mode which does not perform the motion program calculation but executes the command performed in command window.

(1) Processing when changing the mode

STOP mode is changed to TEST mode, and every output data is maintained in Off state.

(2) The contents of operation processing

This executes the command performed in command window and performs EtherCAT communication.

**4. Change in operation modes**

Operation mode of motion control module can be changed as follows.

PLC CPU Operation Mode	Motion Control Module Operation Mode	Remarks
In RUN	RUN or STOP	Motion control module can be made to perform RUN/STOP/TEST using PLC program or XG-PM.(However, TEST mode is possible only in case motion control mode is in STOP mode in XG-PM.)
STOP → RUN	RUN	If PLC CPU changes from STOP mode to RUN mode, motion control module is also changed from STOP mode to RUN mode.
RUN → STOP	STOP	If PLC CPU changes from RUN mode to STOP mode, motion control module is also changed from RUN mode to STOP mode.
In STOP	STOP	In case PLC CPU is in STOP mode, motion control module maintains STOP state. TEST mode can be switched only in case motion control module is in STOP mode in XG-PM.





## Chapter 5 Memory and Parameter, I/O Signal

### 5.1 Memory

#### 5.1.1 Flag

##### 1. Types of flags

###### (1) System flag

This flag indicates the motion, state, and information of motion control module.

Variable	Data Type	Address	Description
_RUN	BOOL	%FX0	RUN mode
_STOP	BOOL	%FX1	STOP mode
_ERROR	BOOL	%FX2	ERROR mode
_RUN_EDIT_ST	BOOL	%FX5	Downloading program during online editing
_RUN_EDIT_CHK	BOOL	%FX6	Processing during online editing
_RUN_EDIT_DONE	BOOL	%FX7	Complete during online editing
_RUN_EDIT_NG	BOOL	%FX8	Abnormally complete during online editing
_FLASH_BUSY	BOOL	%FX9	Writing to FLASH
_FLASH_FAIL	BOOL	%FX10	Failed to write to FLASH
_FORCE_IN	BOOL	%FX11	Forced input status
_FORCE_OUT	BOOL	%FX12	Forced output status
_PB1	BOOL	%FX14	Select program code 1
_PB2	BOOL	%FX15	Select program code 2
_BPRM_ER	BOOL	%FX35	Basic parameter error
_COMPRM_ER	BOOL	%FX36	Common parameter error
_AXISPRM_ER	BOOL	%FX37	Axis parameter error
_AXESPRM_ER	BOOL	%FX38	Axis group parameter error
_COORDPARAM_ER	BOOL	%FX46	Axis group parameter error - coordinate param
_NETPRM_ER	BOOL	%FX39	Network parameter error
_SDPRM_ER	BOOL	%FX40	Shared variable parameter error
_PGM_ER	BOOL	%FX41	Program error
_CODE_ER	BOOL	%FX42	Program code error
_SWDT_ER	BOOL	%FX45	Module abnormal termination error
_AB_SD_ER	BOOL	%FX64	Stop from abnormal operation
_PTASK_CYCLE_ER	BOOL	%FX67	Main task period error
_CTASK_CYCLE_ER	BOOL	%FX68	Periodic task period error

Variable	Data Type	Address	Description
_T20MS	BOOL	%FX96	20ms cycle clock
_T100MS	BOOL	%FX97	100ms cycle clock
_T200MS	BOOL	%FX98	200ms cycle clock
_T1S	BOOL	%FX99	1s cycle clock
_T2S	BOOL	%FX100	2s cycle clock
_T10S	BOOL	%FX101	10s cycle clock
_T20S	BOOL	%FX102	20s cycle clock
_T60S	BOOL	%FX103	60s cycle clock
_ON	BOOL	%FX104	All time on bit
_OFF	BOOL	%FX105	All time off bit
_1ON	BOOL	%FX106	The only first scan on bit
_1OFF	BOOL	%FX107	The only first scan off bit
_STOG	BOOL	%FX108	Reversal at every scanning
_ERR	BOOL	%FX112	Operation error flag
_LER	BOOL	%FX113	Operation error latch flag
_ARY_IDX_ERR	BOOL	%FX114	Out of arrangement array index error flag
_ARY_IDX_LER	BOOL	%FX115	Out of arrangement array index latch error flag
_OS_VER	DWORD	%FD4	OS version
_OS_DATE	DWORD	%FD5	OS distribution date
_OS_VER_PATCH	DWORD	%FD6	OS patch version
_SCAN_MAX	WORD	%FW14	Main task – Maximum scan time
_SCAN_MIN	WORD	%FW15	Main task – minimum scan time
_SCAN_CUR	WORD	%FW16	Main task – Current scan time
_CTASK_SCAN_MAX	WORD	%FW17	Periodic task – Maximum scan time
_CTASK_SCAN_MIN	WORD	%FW18	Periodic task – minimum scan time
_CTASK_SCAN_CUR	WORD	%FW19	Periodic task – Current scan time
_PLC_TIME	ARRAY[0..7] OF BYTE	%FB20	Current RTC time
_PLC_DATE	DATE	%FW24	Current RTC date
_PLC_TOD	TIME_OF_DAY	%FD13	Current time of RTC(ms unit)
_FLASH_WR_RATIO	WORD	%FW28	FLASH writing ratio
_FLASH_WR_CNT	DWORD	%FD16	Flash write count
_SCAN_WR	BOOL	%FX464	Initialize scan value
_CTASK_SCAN_WR	BOOL	%FX465	Periodic task – Initialize scan value

(2) Motion flag

The flag displayed following are as follows. It displays the state and data of the Motion Control.

The flag related to axis is displayed as “\_AXxx...”(xx indicates the relevant axis No.) and the flag related to axis group is displayed as “\_AGxx...”(xx indicates the axis group No.: 01 ~ 40).

a) Motion axis flags

Variable	Type	Address	Comment
_RUN_MODE	BOOL	%JX0.0	RUN mode
_STOP_MODE	BOOL	%JX0.1	STOP mode
_TEST_MODE	BOOL	%JX0.2	TEST mode
_WARNING	BOOL	%JX0.3	Warning state
_ALARM	BOOL	%JX0.4	Alarm state
_LINKUP_INFO	BOOL	%JX0.5	Link up / down information
_COMM	BOOL	%JX0.6	Communication connecting state
_COMM_ERR	BOOL	%JX0.7	Communication timeout error
_COM_ERR	BOOL	%JX0.8	Common error exist
_ERR_CODE	WORD	%JW0.1	Axis error code
_AX_RDY	ARRAY[0..31] OF BOOL	%JX0.32	Axis ready
_IO_RDY	ARRAY[0..3] OF BOOL	%JX0.64	IO ready
_AX_NUM	BYTE	%JB0.10	The number of connected axes
_IO_NUM	BYTE	%JB0.11	The number of connected I/O
_AX_SDO_BUSY	ARRAY[0..31] OF BOOL	%JX0.96	Axis SDO processing busy
_AX_SDO_ERR	ARRAY[0..31] OF BOOL	%JX0.128	Axis SDO processing error
_IO_SDO_BUSY	ARRAY[0..3] OF BOOL	%JX0.160	I/O SDO processing busy
_IO_SDO_ERR	ARRAY[0..3] OF BOOL	%JX0.176	I/O SDO processing error
_PDO_ERR_CNT	WORD	%JW0.12	PDO error count
_EC_LINE_FAIL_AX	ARRAY[0..31] OF BOOL	%JX0.224	EtherCAT Cable disconnection state - Drive(Ax)
_EC_LINE_FAIL_IO	ARRAY[0..3] OF BOOL	%JX0.256	EtherCAT Cable disconnection state - IO
_EC_SLAVE_NUM	UINT	%JW0.17	Number of connected EtherCAT Slave

Variable	Type	Address	Comment
_EC_ERR_SLAVE	UINT	%JW0.18	EtherCAT connection failed - Error slave number
_EC_AL_STS_CODE	WORD	%JW0.19	EtherCAT connection failed - AL error code
_AXxx_RDY	BOOL	%JXxx.0	Axis xx ready
_AXxx_WARNING	BOOL	%JXxx.1	Axis xx warning state
_AXxx_ALARM	BOOL	%JXxx.2	Axis xx alarm state
_AXxx_SV_ON	BOOL	%JXxx.3	Axis xx servo on/off state
_AXxx_SV_RDY	BOOL	%JXxx.4	Axis xx servo ready state
_AXxx_AX_TYPE	BOOL	%JXxx.5	Axis xx main axis/sub. axis state
_AXxx_MST_INFO	BYTE	%JBxx.1	Axis xx main axis information
_AXxx_SVON_INCMPL	BOOL	%JXxx.16	Axis xx servo on incomplete
_AXxx_COMM_WARN	BOOL	%JXxx.17	Axis xx communication warning
_AXxx_DEV_WARN	BOOL	%JXxx.18	Axis xx abnormal deviation warning
_AXxx_SV_ERR	BOOL	%JXxx.32	Axis xx servo drive error
_AXxx_HW_POT	BOOL	%JXxx.33	Axis xx upper limit detection
_AXxx_HW_NOT	BOOL	%JXxx.34	Axis xx lower limit detection
_AXxx_SW_POT	BOOL	%JXxx.35	Axis xx S/W upper limit detection
_AXxx_SW_NOT	BOOL	%JXxx.36	Axis xx S/W lower limit detection
_AXxx_SV_OFF	BOOL	%JXxx.37	Axis xx execution error of operation command in servo-off state
_AXxx_POS_OVR	BOOL	%JXxx.38	Axis xx exceeds the set range of positioning movement amount
_AXxx_VEL_OVR	BOOL	%JXxx.39	Axis xx exceed the speed limit
_AXxx_DEV_ERR	BOOL	%JXxx.40	Axis xx deviation error alarm
_AXxx_HOME_INCMPL	BOOL	%JXxx.41	Axis xx execution of absolute position operation command in the origin indetermination status
_AXxx_COMM_ERR	BOOL	%JXxx.42	Axis xx communication alarm
_AXxx_BUSY	BOOL	%JXxx.48	Axis xx motion command busy state
_AXxx_PAUSE	BOOL	%JXxx.49	Axis xx state of motion commands pause (velocity is zero)
_AXxx_STOP	BOOL	%JXxx.50	Axis xx stop state by the stop command
_AXxx_FAIL	BOOL	%JXxx.51	Axis xx end state by command error
_AXxx_CMPL	BOOL	%JXxx.52	Axis xx command execution complete
_AXxx_DIR	BOOL	%JXxx.53	Axis xx operation direction
_AXxx_JOG	BOOL	%JXxx.54	Axis xx JOG operating
_AXxx_HOME	BOOL	%JXxx.55	Axis xx Home return operating
_AXxx_P_CTRL	BOOL	%JXxx.56	Axis xx position control operating

Variable	Type	Address	Comment
_AXxx_V_CTRL	BOOL	%JXxx.57	Axis xx velocity control operating
_AXxx_T_CTRL	BOOL	%JXxx.58	Axis xx torque control operating
_AXxx_LINTP	BOOL	%JXxx.59	Axis xx linear interpolation operating
_AXxx_CINTP	BOOL	%JXxx.60	Axis xx circular interpolation operating
_AXxx_SYNC	BOOL	%JXxx.61	Axis xx synchronous start operation
_AXxx_COORD	BOOL	%JXxx.62	Axis xx coordinated operation
_AXxx_SYNCVEL_CTRL	BOOL	%JXxx.63	Axis xx Cyclic Synchronous Velocity(CSV) mode
_AXxx_POS_CMPL	BOOL	%JXxx.64	Axis xx positioning complete
_AXxx_INPOS	BOOL	%JXxx.65	Axis xx inposition detection
_AXxx_LATCH_CMPL	BOOL	%JXxx.66	Axis xx latch operation complete
_AXxx_HOME_CMPL	BOOL	%JXxx.67	Axis xx Home return complete
_AXxx_BUSY_ACC	BOOL	%JXxx.77	Axis xx Motion command acceleration operation status
_AXxx_BUSY_CONSTVEL	BOOL	%JXxx.78	Axis xx Motion command constant speed operation status
_AXxx_BUSY_DEC	BOOL	%JXxx.79	Axis xx Motion command deceleration operation status
_AXxx_Disabled	BOOL	%JXxx.80	Axis xx Disabled state
_AXxx_Standstill	BOOL	%JXxx.81	Axis xx Standstill state
_AXxx_Discrete	BOOL	%JXxx.82	Axis xx Discrete state
_AXxx_Continuous	BOOL	%JXxx.83	Axis xx Continuous state
_AXxx_Synchronized	BOOL	%JXxx.84	Axis xx Synchronized state
_AXxx_Homing	BOOL	%JXxx.85	Axis xx Homing state
_AXxx_Stopping	BOOL	%JXxx.86	Axis xx Stopping state
_AXxx_Errorstop	BOOL	%JXxx.87	Axis xx Errorstop state
_AXxx_CMDBUF_FULL	BOOL	%JXxx.95	Axis xx Buffered Command Buffer Full
_AXxx_CMDBUF_QUEUED	UINT	%JWxx.6	Axis xx Buffered Command Queued Count
_AXxx_CMDBUF_FREE	UINT	%JWxx.7	Axis xx Buffered command execution count
_AXxx_TPOS	LREAL	%JLxx.2	Axis xx target position
_AXxx_CPOS	LREAL	%JLxx.3	Axis xx command position of current scan
_AXxx_CVEL	LREAL	%JLxx.4	Axis xx command velocity
_AXxx_ACCDEC	LREAL	%JLxx.5	Axis xx command acc./dec.
_AXxx_CJERK	LREAL	%JLxx.6	Axis xx command jerk
_AXxx_CTRQ	LREAL	%JLxx.7	Axis xx command torque
_AXxx_POS	LREAL	%JLxx.8	Axis xx current position
_AXxx_VEL	LREAL	%JLxx.9	Axis xx current velocity

Variable	Type	Address	Comment
_AXxx_TRQ	LREAL	%JLxx.10	Axis xx current torque
_AXxx_POS_DEV	LREAL	%JLxx.11	Axis xx position deviation
_AXxx_ALM	BOOL	%JXxx.768	Axis xx drive alarm state
_AXxx_DRV_WARNING	BOOL	%JXxx.769	Axis xx drive warning state
_AXxx_SV_ON_STS	BOOL	%JXxx.770	Axis xx servo on status
_AXxx_POT	BOOL	%JXxx.771	Axis xx upper limit input
_AXxx_NOT	BOOL	%JXxx.772	Axis xx lower limit input
_AXxx_HOME_INPUT	BOOL	%JXxx.773	Axis xx home input
_AXxx_LATCH1	BOOL	%JXxx.774	Axis xx LATCH1 input
_AXxx_LATCH2	BOOL	%JXxx.775	Axis xx LATCH2 input
_AXxx_SVPARAM_BUSY	BOOL	%JXxx.776	Axis xx read/write operations of the SDO parameters
_AXxx_SDOCMD_BUSY	BOOL	%JXxx.777	Axis xx command operations of the SDO parameters
_AXxx_DRV_IN	DWORD	%JDxx.25	Axis xx servo drive input
_AXxx_AX_ERR	WORD	%JWxx.52	Axis xx error code
_AXxx_DRV_ERR	WORD	%JWxx.53	Axis xx servo drive error code

Note) \_AXxx\_HOME (flag used when returning to origin command) and \_AXxx\_Homing (display of operating status of PLC open standard) are flags indicating the same status.

b) Motion axis group flags

Variable	Type	Address	Comment
_AGyy_RDY	BOOL	%CXyy.0	Axis group yy ready to execute
_AGyy_WARNING	BOOL	%CXyy.1	Axis group yy warning state
_AGyy_SV_ON	BOOL	%CXyy.3	Axis group yy servo on/off state
_AGyy_SV_RDY	BOOL	%CXyy.4	Axis group yy servo ready state
_AGyy_BUSY	BOOL	%CXyy.16	Axis group yy motion command busy state
_AGyy_PAUSE	BOOL	%CXyy.17	Axis group yy state of motion commands pause(velocity is zero)
_AGyy_STOP	BOOL	%CXyy.18	Axis group yy stop state by the stop command
_AGyy_FAIL	BOOL	%CXyy.19	Axis group yy command error exit status
_AGyy_CMPL	BOOL	%CXyy.20	Axis group yy command execution complete
_AGyy_LINTP	BOOL	%CXyy.21	Axis group yy linear interpolation operating
_AGyy_CINTP	BOOL	%CXyy.22	Axis group yy circular interpolation operating
_AGyy_JOG	BOOL	%CXyy.27	Axis group yy coordinated JOG operation
_AGyy_CCINTP3D	BOOL	%CXyy.28	Axis group yy 3D circular interpolation operation
_AGyy_POS_CMPL	BOOL	%CXyy.32	Axis group yy positioning complete
_AGyy_BUSY_ACC	BOOL	%CXyy.45	Axis group yy motion command acceleration operation status
_AGyy_BUSY_CONSTVEL	BOOL	%CXyy.46	Axis group yy motion command constant speed operation status
_AGyy_BUSY_DEC	BOOL	%CXyy.47	Axis group yy motion command deceleration operation status
_AGyy_Disabled	BOOL	%CXyy.48	Axis group yy Disabled state
_AGyy_Standby	BOOL	%CXyy.49	Axis group yy Standby state
_AGyy_Moving	BOOL	%CXyy.50	Axis group yy Moving state
_AGyy_Homing	BOOL	%CXyy.51	Axis group yy Homing state
_AGyy_Stopping	BOOL	%CXyy.52	Axis group yy Stopping state
_AGyy_ErrorStop	BOOL	%CXyy.53	Axis group yy ErrorStop state
_AGyy_CMDBUF_FULL	BOOL	%CXyy.63	Axis group yy Buffered Command Buffer Full
_AGyy_CMDBUF_QUEUED	UINT	%CWyy.20	Axis group yy Buffered Command Queued Count
_AGyy_CMDBUF_FREE	UINT	%CWyy.21	Axis group yy Buffered command execution count
_AGyy_CMD_VEL	LREAL	%CLyy.1	Axis group yy command velocity
_AGyy_CMD_ACCDEC	LREAL	%CLyy.2	Axis group yy command acc./dec.
_AGyy_ACT_VEL	LREAL	%CLyy.3	Axis group yy current velocity
_AGyy_ERR	WORD	%CWyy.16	Axis group yy error code



_AGyy_AX_NUM	WORD	%CWyy.17	Axis group yy number of axes
_AGyy_AX1	BYTE	%CByy.36	Axis group yy composition Axis for Axis1
_AGyy_AX2	BYTE	%CByy.37	Axis group yy composition Axis for Axis2
_AGyy_AX3	BYTE	%CByy.38	Axis group yy composition Axis for Axis3
_AGyy_AX4	BYTE	%CByy.39	Axis group yy composition Axis for Axis4

(3) I/O Flag

The input/output flag indicates the embedded digital input and output values with embedded encoder values.

Variable	Data Type	Address	Comment
_IN	ARRAY[0..7] OF BOOL	%IX0.0	Internal digital input
_ENC1	LREAL	%IL0.1	Encoder1 input
_ENC2	LREAL	%IL0.2	Encoder2 input
_ENC1_UNIT	UINT	%IW0.12	Encoder1 unit (0: pulse, 1: mm, 2: inch, 3: degree)
_ENC2_UNIT	UINT	%IW0.13	Encoder2 unit(0: pulse, 1: mm, 2: inch, 3: degree)
_ENC1_VEL	LREAL	%IL0.4	Encoder1 speed
_ENC2_VEL	LREAL	%IL0.5	Encoder2 speed
_OUT	ARRAY[0..7] OF BOOL	%QX0.0	Internal digital output

In add, it indicates the PDO Data that is connected to the Motion Control Module under fixed-time communication. The below example displays the synchronized communication data flag when it is connected to L7N Servo Drive. PDO data can be registered in the global variable by executing the 'Register Module Address Comments' menu in XG-PM.

Variable	Data Type	Address	Comment
_EC001_RxPDO_1600_0_Controlword	UINT	%QW1.0	Controlword
_EC001_RxPDO_1600_1_Target_Torque	INT	%QW1.1	Target Torque
_EC001_RxPDO_1600_2_Target_Position	DINT	%QD1.1	Target Position
_EC001_RxPDO_1600_3_Mode_of_Operation	SINT	%QB1.8	Mode of Operation
_EC001_RxPDO_1600_4_Padding	USINT	%QB1.9	Padding
_EC001_RxPDO_1600_5_Touch_Probe_Function	UINT	%QW1.5	Touch Probe Function
_EC001_TxPDO_1A00_0_Statusword	UINT	%IW1.0	Statusword
_EC001_TxPDO_1A00_1_Torque_Actual_Value	INT	%IW1.1	Torque Actual Value
_EC001_TxPDO_1A00_2_Position_Actual_Value	DINT	%ID1.1	Position Actual Value
_EC001_TxPDO_1A00_3_Touch_Probe_1_Positive_Edge_Position_Value	DINT	%ID1.2	Touch Probe 1 Positive Edge Position Value
_EC001_TxPDO_1A00_4_Digital_Inputs	UDINT	%ID1.3	Digital Inputs
_EC001_TxPDO_1A00_5_Mode_of_Operation_Display	SINT	%IB1.16	Mode of Operation Display
_EC001_TxPDO_1A00_6_Padding	USINT	%IB1.17	Padding
_EC001_TxPDO_1A00_7_Touch_Probe_Status	UINT	%IW1.9	Touch Probe Status

## (4) Motion coordinate system flag

The coordinate system flag is a flag displayed during coordinate system operation. Displays the current TCP position of the MCS coordinate system during coordinate system operation. The coordinate system flag is displayed in the form of “\_Kyy\_...” (yy is the axis group number, decimal).

Variable	Data Type	Address	Comment
_Kyy_MTCP_Px	LREAL	%KLx.0	Coordinates 01 X axis position(MCS)
_Kyy_MTCP_Py	LREAL	%KLx.1	Coordinates 01 Y axis position(MCS)
_Kyy_MTCP_Pz	LREAL	%KLx.2	Coordinates 01 Z axis position(MCS)
_Kyy_MTCP_A	LREAL	%KLx.3	Coordinates 01 X axis rotation(MCS)
_Kyy_MTCP_B	LREAL	%KLx.4	Coordinates 01 Y axis rotation(MCS)
_Kyy_MTCP_C	LREAL	%KLx.5	Coordinates 01 Z axis rotation(MCS)
_Kyy_PTCP_Px	LREAL	%KLx.6	Coordinates 01 X axis position(PCS)
_Kyy_PTCP_Py	LREAL	%KLx.7	Coordinates 01 Y axis position(PCS)
_Kyy_PTCP_Pz	LREAL	%KLx.8	Coordinates 01 Z axis position(PCS)
_Kyy_PTCP_A	LREAL	%KLx.9	Coordinates 01 X axis rotation(PCS)
_Kyy_PTCP_B	LREAL	%KLx.10	Coordinates 01 Y axis rotation(PCS)
_Kyy_PTCP_C	LREAL	%KLx.11	Coordinates 01 Z axis rotation(PCS)

### 5.1.2 Device

#### 1. Types of devices

Types of device supported in motion control module are shown in the Table below.

Type	Size	Description
Automatic variable (A)	512KB	This is assigned when adding symbolic variable to automatic variable area. (able to set a maximum 64KB of retain)
Direct variable (G)	128KB	This is a global variable which can set 64KB of retain by selecting in the area of basic variable.
Input variable (I)	1B (input contact) 8B (encoder) 4.5KB (slave)	This assigns digital input contact. input value of 2ch encoder This assigns the slave TxPDO data.
Output variable (Q)	1B 4.5KB (slave)	This assigns digital output setting. This assigns the slave RxPDO data.
System variable (F)	-	State variable of the motion control state and module motion
Shared variable (D, M)	1MB each	The area for data sharing and CPU module CPU→module : 2,048words, CPU←module : 2,048words
Position data (P)	25KB	Position data used when moving to certain position 6400points

#### (1) Automatic variable

- This is a variable to be automatically assigned the position of variables by compiler; user does not need to specify the position of internal variable. The variables, which user sets but does not assign specific position, are assigned to automatic variable.
- Automatic variable is initialized to 0 when turning Off the power..

#### (2) Direct variable

- This is a variable which user forces the position of memory to be assigned by using the name and number of a device directly.
- The range of address assignment where direct variable is available is as follows.

Size of Variable	Designated range of Variable address
X(Bit)	%GX0 ~ %GX1048575
B(Byte)	%GB0 ~ %GB131071
W(Word)	%GW0 ~ %GW65535
D(Double Word))	%GD0 ~ %GD32767
L(Long Word))	%GL0 ~ %GL16383

#### (3) Input variable

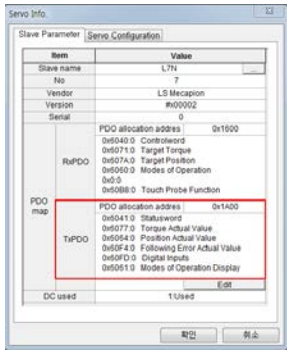
- This is a variable assigned to internal digital input and encoder input.
- Internal digital input is 8 points.
- Encoder input is the LREAL data and 2 channels are assigned.
- Input variable is expressed as follows.  
%|[size prefix]n1.n2

Number	Description
Size prefix	X(1 bit), B(1 byte), W(1 word), D(1 double word), L(1 long word)
n1	0: internal input and internal encoder input 1~36: slave number (TxPDO of n1 slave parameter is mapped)
n2	n2 data based on [size prefix] among n1 data

- Device depending on the input variable expression is assigned as follows.

Address	Description
%IX0.0	Internal Digital input 0
%IX0.1	Internal Digital input 1
%IX0.2	Internal Digital input 2
%IX0.3	Internal Digital input 3
%IX0.4	Internal Digital input 4
%IX0.5	Internal Digital input 5
%IX0.6	Internal Digital input 6
%IX0.7	Internal Digital input 7
%IL0.1	Encoder1 input
%IL0.2	Encoder2 input
%IW0.12	Encoder1 Unit (0: pulse, 1: mm, 2: inch, 3: degree)
%IW0.13	Encoder2 Unit (0: pulse, 1: mm, 2: inch, 3: degree)
%IL0.4	Encoder1 Speed
%IL0.5	Encoder2 Speed
%IW1.0 ~ %IW1.63	TxPDO Mapping Data of Servo Drive 01
:	:
%IW32.0 ~ %IW32.63	TxPDO Mapping Data of Servo Drive 32
%IW33.0 ~ %IW33.63	Input Data of EtherCAT IO Station 01(TxPDO Mapping Data)
:	:
%IW36.0 ~ %IW36.63	Input Data of EtherCAT IO Station 04(TxPDO Mapping Data)

For example, when the slave parameter of 3 axes servo drive is as follows, input flag is automatically assigned as follows.



Index	Name	Data Type	Size(Bytes)
0x6041:0	Statusword	UINT	2
0x6077:0	Actual torque value	INT	2
0x6064:0	Actual position value	DINT	4
0x60F4:0	Positioning error's actual value	DINT	4
0x60FD:0	Digital input	UDINT	4
0x6061:0	Operation mode display	SINT	1
0x2601:0	Commanded speed	INT	2
0x2600:0	Operating speed	INT	2
0x60B9:0	Touch probe status	UINT	2
0x60BA:0	Touch probe 1 forward's position value	DINT	4

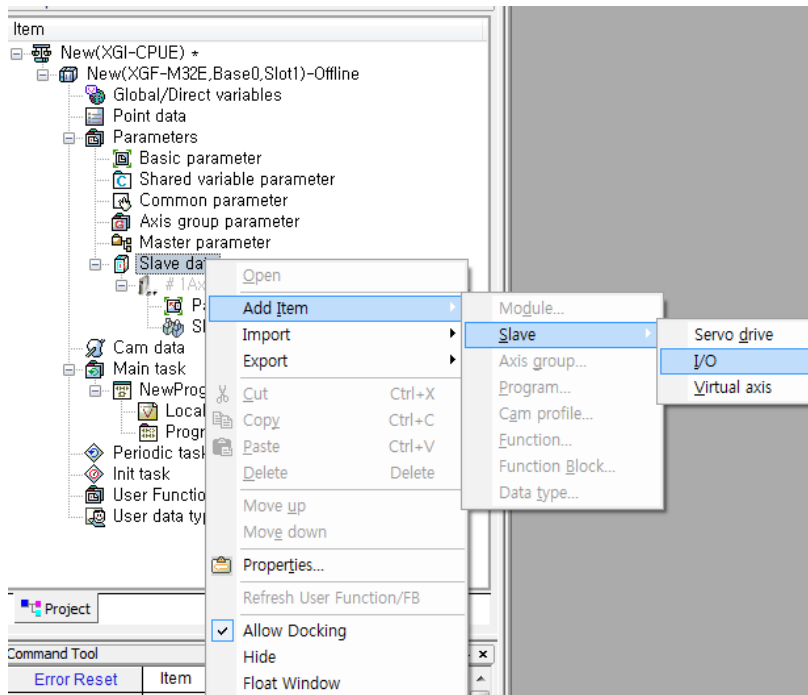


Variable	Data Type	Address	Description
_SL3_Statusword	UINT	%IW3.0	Statusword
_SL3_Torque_Actual_Value	INT	%IW3.1	Actual torque value
_SL3_Position_Actual_Value	DINT	%ID3.1	Actual position value
_SL3_Following_Error_Actual_Value	DINT	%ID3.2	Following error's actual value
_SL3_Digital_Inputs	UDINT	%ID3.3	Digital input
_SL3_Mode_of_Operation_Display	SINT	%IB3.16	Operation mode display
_SL3_Command_Speed(rpm)	INT	%IW3.9	Commanded speed
_SL3_Current_Speed(rpm)	INT	%IW3.10	Operating speed
_SL3_Touch_Probe_Status	UINT	%IW3.11	Touch probe status

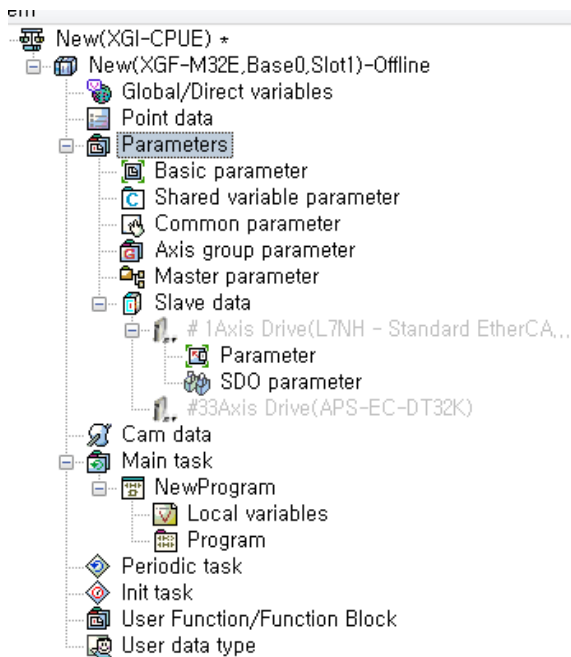
For example, 16 points EtherCAT I/O is connected to the 33 axes in use, the input points is automatically assigned as follows.

Address	Description
%IX33.0	EtherCAT I/O Digital input 0
%IX33.1	EtherCAT I/O Digital input 1
%IX33.2	EtherCAT I/O Digital input 2
:	:
%IX33.13	EtherCAT I/O Digital input 13
%IX33.14	EtherCAT I/O Digital input 14
%IX33.15	EtherCAT I/O Digital input 15

EtherCAT I/O can be added through a network slave automatic connection or slave data of the project. (Add item - Slave - I/O)



When EtherCAT I/O (digital input 16 points, digital output 16 points) is added in 33-axes



(4) Output variable

- This is a variable which is assigned to built-in digital output.
- Internal digital output is 8 points.
- Output variable is expressed as follows.

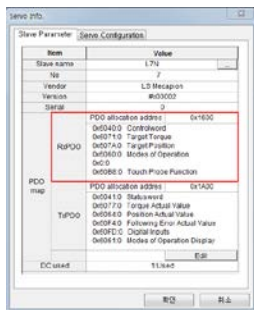
%[size prefix]n1.n2

Number	Description
Size prefix	X(1 bit), B(1 byte), W(1 word), D(1 double word), L(1 long word)
n1	0: internal output 1~36: slave number (TxPDO of n1 slave parameter is mapped)
n2	n2 data based on [size prefix] among n1 data

- Device depending on the output variable expression is assigned as follows.

Address	Description
%QX0.0	Internal Digital output 0
%QX0.1	Internal Digital output 1
%QX0.2	Internal Digital output 2
%QX0.3	Internal Digital output 3
%QX0.4	Internal Digital output 4
%QX0.5	Internal Digital output 5
%QX0.6	Internal Digital output 6
%QX0.7	Internal Digital output 7
%QW1.0 ~ %QW1.63	TxPDO Mapping Data of Servo Drive 01
:	:
%QW32.0 ~ %QW32.63	TxPDO Mapping Data of Servo Drive 32
%QW33.0 ~ %QW33.63	Output Data of EtherCAT IO Station 01(TxPDO Mapping Data)
:	:
%QW36.0 ~ %QW36.63	Output Data of EtherCAT IO Station 04(TxPDO Mapping Data)

For example, when the slave parameter of 3-axis servo drive is as follows, input flag is automatically assigned as follows. .



Index	Name	Data Type	Size(Bytes)
0x6040:0	Controlword	UINT	2
0x6071:0	Target torque	INT	2
0x607A:0	Target position	DINT	4
0x6060:0	Operation mode	SINT	1
0x0:0			1
0x60B8:0	Touch probe function	UINT	2



Variable	Data Type	Address	Description
_SLx_Controlword	UINT	%QWx.0	Controlword
_SLx_Target_Torque	INT	%QWx.1	Target torque
_SLx_Target_Position	DINT	%QDx.1	Target position
_SLx_Mode_of_Operation	USINT	%QBx.8	Operation mode
_SLx_Touch_Probe_Function	UINT	%QWx.5	Touch probe function

For example, 16 points EtherCAT I/O is connected to the 33 axes in use, the output points is automatically assigned as follows.



Address	Description
%QX33.0	EtherCAT I/O Digital output 0
%QX33.1	EtherCAT I/O Digital output 1
%QX33.2	EtherCAT I/O Digital output 2
:	:
%QX33.13	EtherCAT I/O Digital output 13
%QX33.14	EtherCAT I/O Digital output 14
%QX33.15	EtherCAT I/O Digital output 15

(5) System variable

- It is a variable that represents the operation status of module and motion control status.
- For details on the kinds of flags, refer to 1) System Flag of 5.1.1 Flag.

(6) Shared variable

- This is an area for data sharing between PLC CPU module and motion control module.
- Shared variable parameters can be set in XG5000, and XG-PM provides a function to check the shared variable parameters
- The data input to motion control module from PLC CPU module is up to 2,048 words. Common input variable is only available for reading.  
Available devices when setting the shared input variables in XG5000 are as follows
- The data output to PLC CPU from the motion control module is up to 2,048 words. Common output variable is available for reading/writing.
  - XGK CPU : D, M, R, ZR
  - XGI/XGR CPU : M, R, W

- The range of address assignment where shared variable is available is as follows.

Size of Variable	Designated range of D Variable address	Designated range of M Variable address
X(Bit)	%DX0 ~ %DX8388607	%MX0 ~ %MX8388607
B(Byte)	%DB0 ~ %DB1048575	%MB0 ~ %MB1048575
W(Word)	%DW0 ~ %DW524287	%MW0 ~ %MW524287
D(Double Word)	%DD0 ~ %DD262143	%MD0 ~ %MD262143
L(Long Word)	%DL0 ~ %DL131071	%ML0 ~ %ML131071

- For detailed setting methods, refer to (2) Shared variable parameters of 5.1.3. Parameters

(7) Positioning data

- This is an area of position data which can be referred when wanting to operate to specific position by using motion control module.
- This is not divided by each axis, and 6400 points can be assigned to every axis in common.
- Data are maintained even when turning Off the power.
- The range of address assignment where position data variable is available is as follows

Type of Variable	Designated range of Variable address
LREAL	%PL0 ~ %PL6399

- You can set the position values by selecting the position data in XG-PM project tree as below.

	Address	Value	Type	Comment
1	%PL0	1000	LREAL	Position data 1
2	%PL1	2000	LREAL	Position data 2
3	%PL2	3000	LREAL	Position data 3
4	%PL3	4000	LREAL	Position data 4
5	%PL4	5000	LREAL	Position data 5
6	%PL5	0	LREAL	Position data 6
7	%PL6	0	LREAL	Position data 7
8	%PL7	0	LREAL	Position data 8
9	%PL8	0	LREAL	Position data 9
10	%PL9	0	LREAL	Position data 10
11	%PL10	0	LREAL	Position data 11
12	%PL11	0	LREAL	Position data 12
13	%PL12	0	LREAL	Position data 13
14	%PL13	0	LREAL	Position data 14
15	%PL14	0	LREAL	Position data 15
16	%PL15	0	LREAL	Position data 16
17	%PL16	0	LREAL	Position data 17
18	%PL17	0	LREAL	Position data 18
19	%PL18	0	LREAL	Position data 19
20	%PL19	0	LREAL	Position data 20
21	%PL20	0	LREAL	Position data 21
22	%PL21	0	LREAL	Position data 22
23	%PL22	0	LREAL	Position data 23
24	%PL23	0	LREAL	Position data 24
25	%PL24	0	LREAL	Position data 25
26	%PL25	0	LREAL	Position data 26
27	%PL26	0	LREAL	Position data 27
28	%PL27	0	LREAL	Position data 28

**2. Retain setting**

Default (automatic) variable retain is used when wanting to keep and use the data that occurs while operating or the data required for an operation even in the case of restarting after the motion control module has stopped, and a certain part of the device in G area can be used as retain area by setting the basic parameter.

Characteristic table of the device which is available to set retain is shown below.

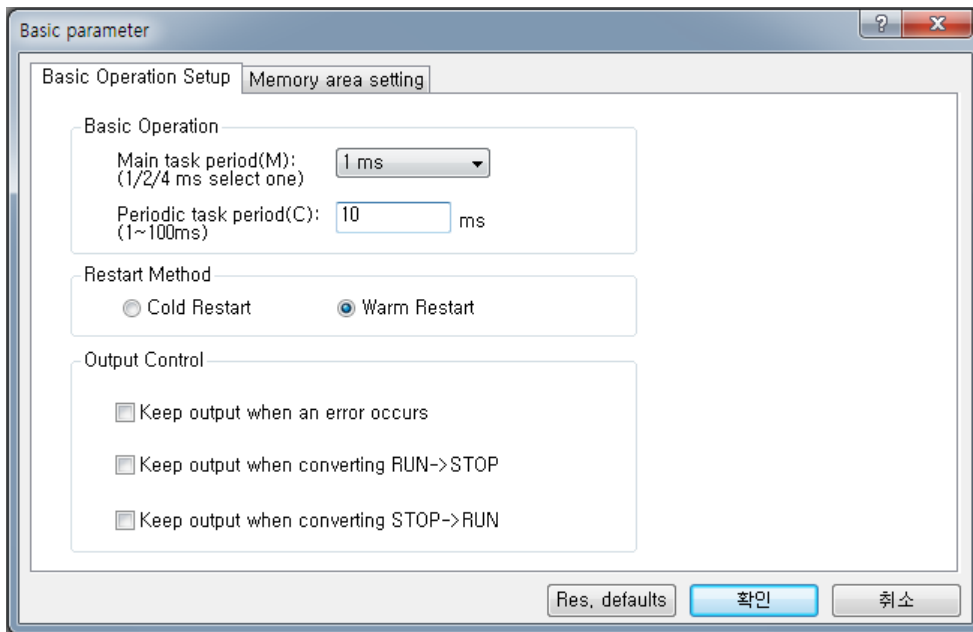
Device	Retain setting	Characteristic
Default	O	Enable retain setting when adding variable to automatical variable area
G	O	It is internal contact area and enable retain setting at parameter
I	X	Internal digital input contact and internal encoder input contact
Q	X	Internal digital output contact
D	X	Available area for sharing data between PLC CPU and motion control module
M	X	
P	X(Retain)	Available for position data and maintain data value when power off(Always maintain retain, No user setting)

### 5.1.3 Parameter

#### 1. Basic parameter

Explain Basic parameter of the motion control module.

##### (1) Basic motion setting



##### (a) Main task cycle

- Set the motion period of the main task. The period can be set by selecting one in 1ms/2ms/4ms.
- Set the control time of performing in the main task of motion control module considering the execution time of program.
- When the execution time of the main task exceeds the main task period, an error occurs and if motion control module is in RUN state, it is changed to STOP state.

##### (b) Periodic task cycle

- Set the motion period of the periodic task. The period can be set in multiples of the main task between 1 ~ 100ms.
- The periodic task is performed in the remaining time after performing the main task in the control period, and therefore, it can be performed through a number of control periods.

##### (c) Restart mode

Restart by PLC CPU reset or turning on the power after turning off is divided into cold restart and warm restart. With regard to restart mode, variables can be set in 3 different types such as default, initialization, and retain; and the initialization of variables set by restart mode is as follows.

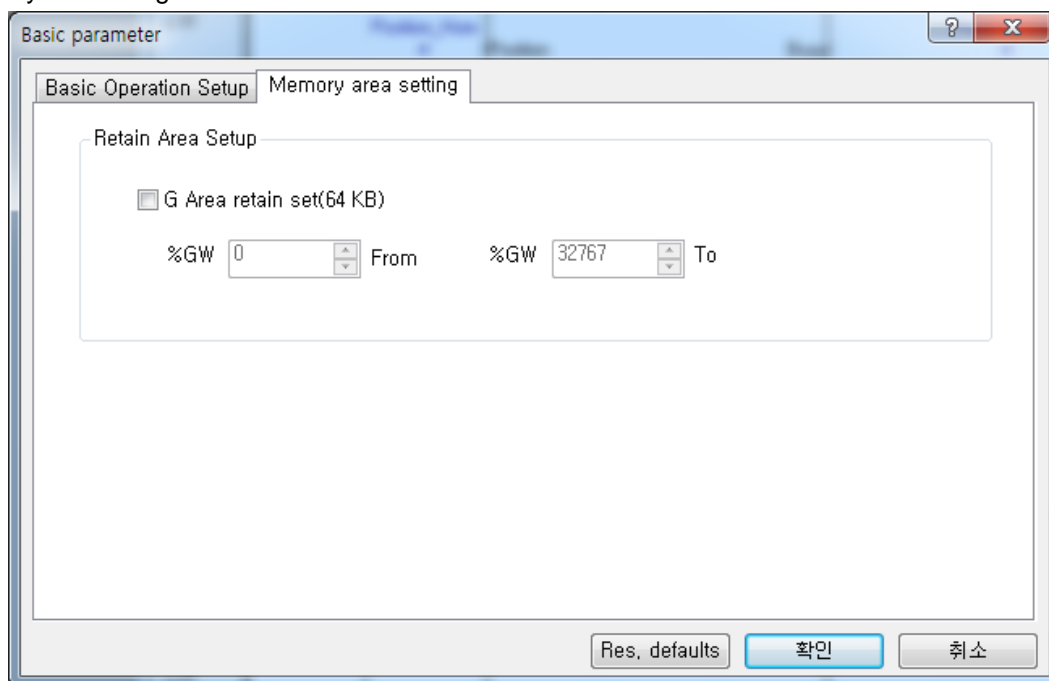
	Cold Restart	Warm Restart
Default	Initialize with '0'	'Initialize with '0'
Retain	Initialize with '0'	Maintain previous value
Initialization	Initialize with user setting value	Initialize with user setting value
Retain & Initialization	Initialize with user setting value	Maintain previous value

(d) Output control setting

When an error occurs in module or changing the motion mode of module, decide whether to maintain the data output or not.

Selection	Operation
Maintain the output in the event of an error	Decide whether to output the data normally when an error or certain input occurs in the module.
Maintain the output when switching from RUN to STOP	Decide whether to output the data normally during the operation mode of the motion control module is switching from RUN to STOP.
Maintain the output when switching from STOP to RUN	Decide whether to output the data normally during the operation mode of motion control module is switching from STOP to RUN.

(2) Memory area setting

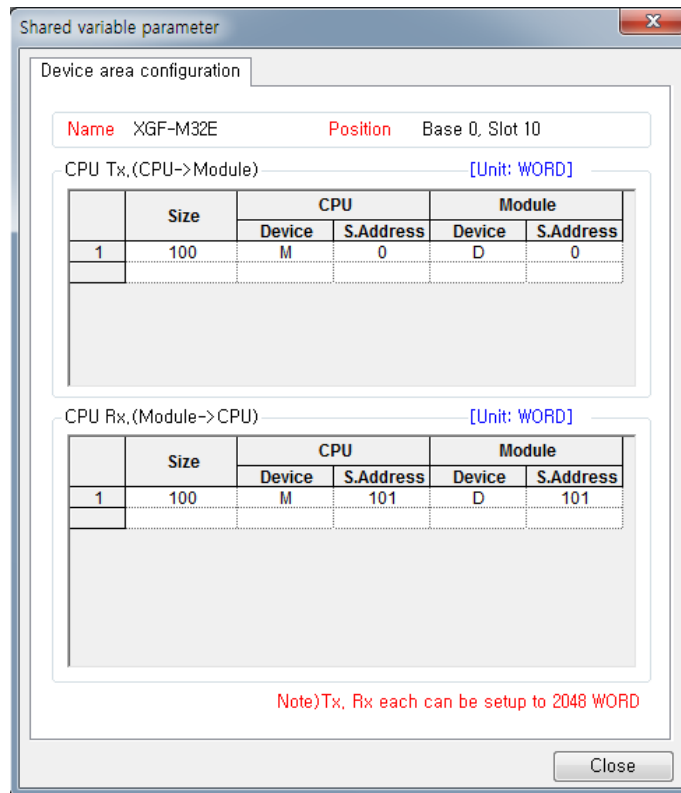
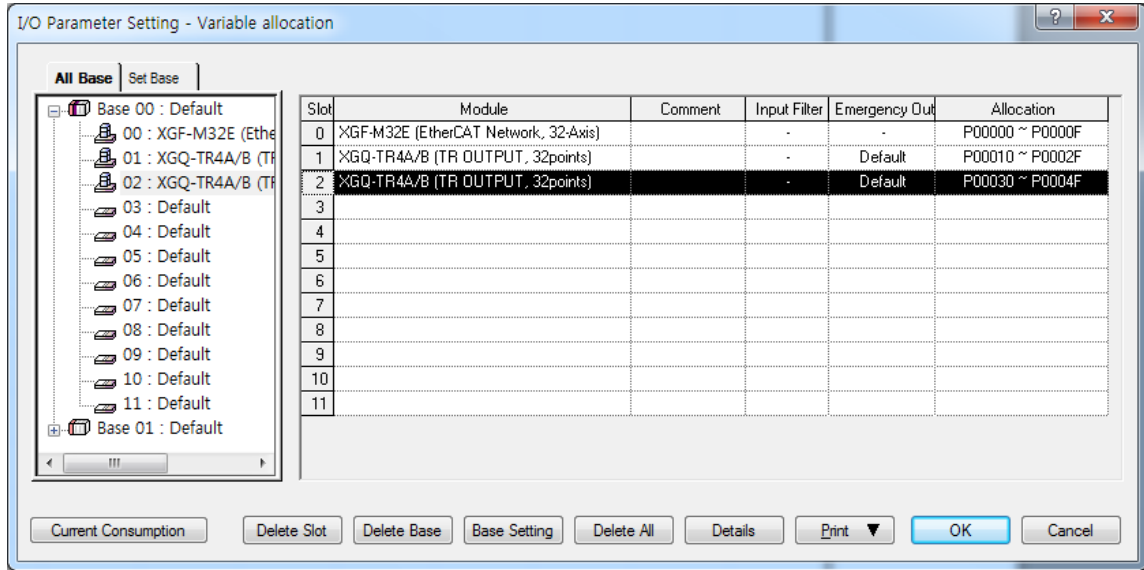


This is a parameter item which sets the retain area. Retain area can be set by checking the "G Area retain set" to activate retain setting. Retain can be set up to 64Kbyte, and if the beginning and ending addresses are set to be retain in G area, the value of relevant area is maintained even when turning off the power.

2. Shared variable parameter

(1) Sharing variable parameter is explained as follows.

- (a) Data are shared between CPU and motion control module by using the exclusive shared variable.
- (b) User can set the size of reading/writing by parameter, and the maximum setting size is 2,048 words each.
- (c) User can select and set motion control module in I/O parameter of XG5000.



(d) Shared variable set is transmitted to motion control module when running PLC CPU, and it can be identified by reading the shared variable parameter of motion control module in XG-PM.

### 3. Common parameter

Common parameter is explained as follows.

Item	Description	Settings	Initialize value
Encoder1 Unit	Set display unit of encoder position.	0: pulse, 1: mm 2: inch, 3:degree	0: pulse
Encoder1 Pulse count per rotation	Set Encoder1 pulses per rotation	1 ~ 4294967295	8192 pls
Encoder1 Travel distance per rotation	Set the movement amount of the load side moved per encoder 1 rotation.	0.000000001 ~ 4294967295	10 pls
Encoder1 Pulse input	Set the input mode in accordance with the output shape of encoder.	0: CW/CCW (x1) 1: PULSE/DIR (x1) 2: PULSE/DIR (x2) 3: PHASE A/B (x1) 4: PHASE A/B (x2) 5: PHASE A/B (x4)	3: PHASE A/B (x1)
Encoder1 Max. value	Set position display range of encoder.	Long Real(LREAL)	2147483647 pls
Encoder1 Min. value			-2147483648 pls
Encoder1 Speed Unit	Set encoder speed display unit.	0: Unit/sec, 1: Unit/min, 2: rpm	0: Unit/sec
Encoder1 Position filter time constant	Set the filter time constant (time) to calculate the encoder position average.	0~1000 (ms)	0 ms
Encoder2 Unit	Set display unit of encoder position.	0: pulse, 1: mm 2: inch, 3:degree	0: pulse
Encoder2 Pulse count per rotation	Set Encoder2 pulses per rotation	1 ~ 4294967295	8192 pls
Encoder2 Travel distance per rotation	Set the movement amount of the load side moved per encoder 2 rotation.	0.000000001 ~ 4294967295	10 pls
Encoder2 Pulse input	Set the input mode in accordance with the output shape of encoder.	0: CW/CCW (x1) 1: PULSE/DIR (x1) 2: PULSE/DIR (x2) 3: PHASE A/B (x1) 4: PHASE A/B (x2) 5: PHASE A/B (x4)	3: PHASE A/B (x1)
Encoder2 Max. value	Set position display range of encoder.	Long Real(LREAL)	2147483647 pls
Encoder2 Min. value			-2147483648 pls
Encoder2 Speed Unit	Set encoder speed display unit.	0: Unit/sec, 1: Unit/min, 2: rpm	0: Unit/sec
Encoder2 Position filter time constant	Set the filter time constant (time) to calculate the encoder position average.	0~1000 (ms)	0 ms
Override Mode	Set the application method of the input value when executing override command.	0: Specified by ratio 1: Specified by unit	0: Specified by ratio

### (1) Encoder unit

This is to set the display unit of encoder position, and each control target can be set by pulse, mm, inch, and degree. In case of the synchronous operation having the encoder as a center, the unit must be set by the same unit with it of the synchronous operation axis.

### (2) Encoder Pulses count per rotation

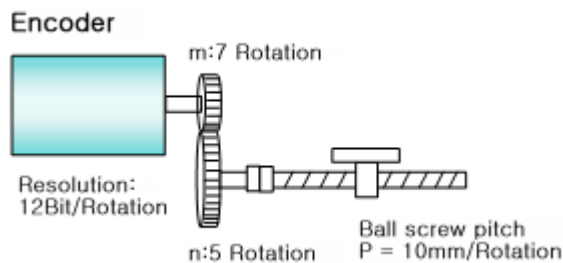
When using mm, inch, and degree for the encoder unit, set the number of purses per encoder rotation.

### (3) Encoder Travel distance per rotation

When using mm, inch, and degree for the encoder unit, set the amount of movement of the load side moved per encoder rotation.

### [Setting Example]

When the machine which is moved by ball screw is connected to the encoder with gear, the setting of the encoder unit / Encoder Pulses per rotation / Encoder Travel per rotation is as follows.



- Encoder unit: mm
- Encoder Pulses per rotation = Encoder resolution x Encoder side gear ratio  

$$= 4096 \times 7$$

$$= 28672 \text{ pls}$$
- Encoder Travel per rotation = Ball screw pitch x Machine side gear ratio  

$$= 10.0 \text{ mm} \times 5$$

$$= 50.0 \text{ mm}$$

### (4) Encoder Pulse input

When wanting to use the encoder signal of servo drive or manual pulse generator as an input, the signal, which is right to the output form of the encoder or manual pulse generator, can be selected to be used.

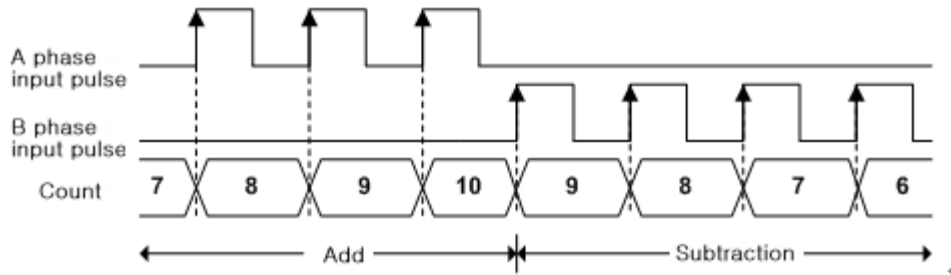
One among CW/CCW (x1), PULSE/DIR (x1), PULSE/DIR (x2), PHASE A/B (x1), PHASE A/B (x2), and PHASE A/B (x4) must be selected and set for the encoder input signal.

#### (a) CW/CCW (x1)

Count operation is performed when A phase input pulse increases or B phase input pulse increases; and adding operation is performed when A phase input pulse increases in the Low input of B phase input pulse; and subtraction operation is performed when B phase input pulse increases in the Low input of A phase input pulse.



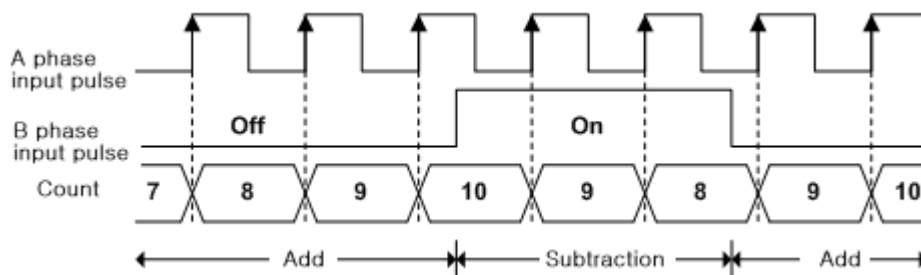
Add/Subtraction	A phase input pulse High	A phase input pulse Low
B phase input pulse High	-	Subtraction count
B phase input pulse Low	Add count	-



(b) PULSE/DIR (x1)

Count operation is performed when A phase input pulse increases, whether to be added or subtracted is decided by B phase.

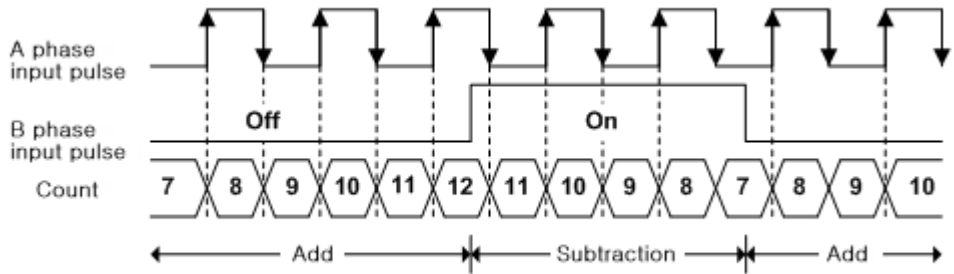
Add/Subtraction	A phase input pulse High	A phase input pulse Low
B phase input pulse Off	Add count	-
B phase input pulse On	Subtraction count	-



(c) PULSE/ DIR (x2)

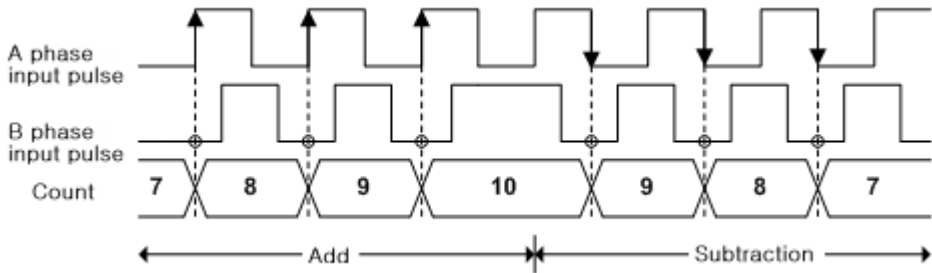
Count operation is performed when A phase input pulse increases and decreases, and whether to be added or subtracted is decided by B phase.

Add/Subtraction	A phase input pulse High	A phase input pulse Low
B phase input pulse Off	Add count	Add count
B phase input pulse On	Subtraction count	Subtraction count



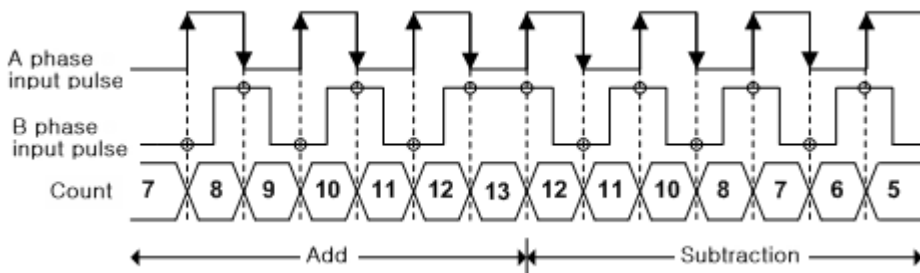
(d) PHASE A/B (x1)

Add operation is performed in case of the increase in A phase pulse when the phase of A phase input pulse is ahead of B phase input pulse, and subtraction operation is performed in case of the decrease in A phase pulse when the phase of B phase input pulse is ahead.



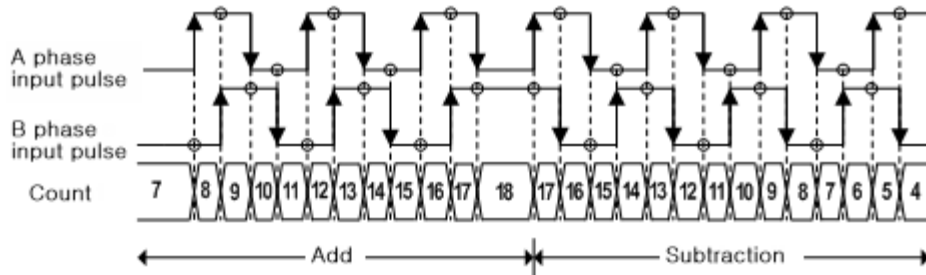
(e) PHASE A/B (x2)

Count operation is performed when both increase and decrease in A phase input pulse. Add operation is performed when the phase of A phase is input ahead of B phase, and subtraction operation is performed when the phase of B phase is input ahead of A phase.



(f) PHASE A/B (x4)

Count operation is performed in case of the increase/decrease in A phase input pulse and the increase/decrease in B phase; and add operation is performed when the phase of A phase is input ahead of B phase; and subtraction operation is performed when the phase of B phase is input ahead of A phase.

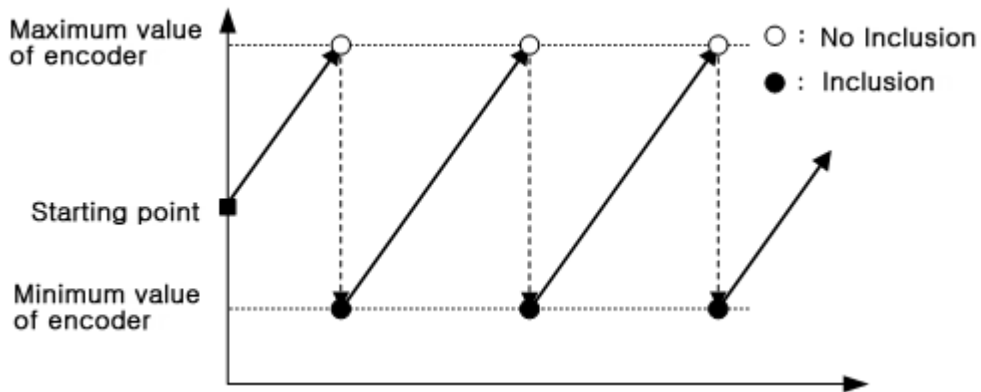


(g) Maximum and minimum values of encoder

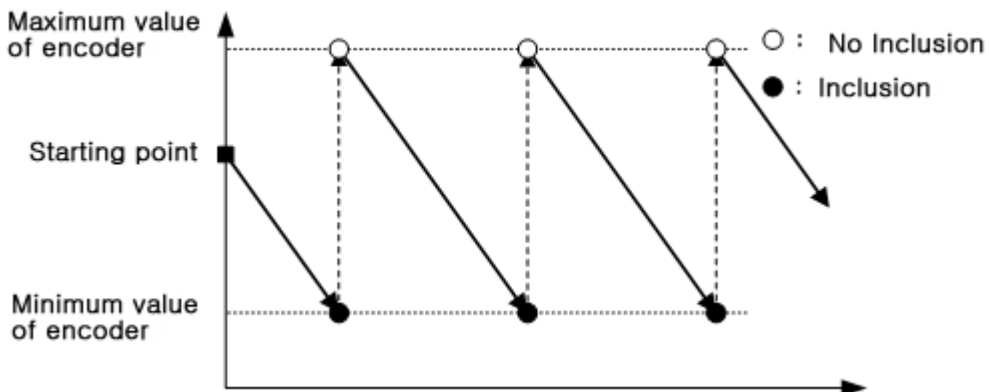
- ① The range of the encoder value is set to the maximum and minimum values of encoder when counting the input pulse from the encoder signal of servo drive or manual pulse generator and indicating it to encoder value.

- ② Operations are as shown in the figure below.

- In case of the increase in the encoder value



- In case of the decrease in the encoder value



(h) Encoder speed unit

This is to set the speed display unit of the encoder and sets the standard unit of the speed value.

If it is set to '0: Unit/sec', it is applied at the rate of change per second of the corresponding unit position set in the 'Unit' parameter. For example, if the "Unit" setting is mm, the display unit of the speed is "mm/s".

If it is set to '1: Unit/min', it is applied as the rate of change per minute of the corresponding unit position set in the 'Unit' parameter. For example, if the "Unit" setting is mm, the display unit of the speed is "mm/min".

When set to '2: rpm', the speed command unit is applied in rpm. When the speed display unit is rpm, when converting to unit speed internally, the values set in the parameters "Number of pulses per revolution" and "Transfer distance per revolution" are used.

(i) Encoder Position filter time constant

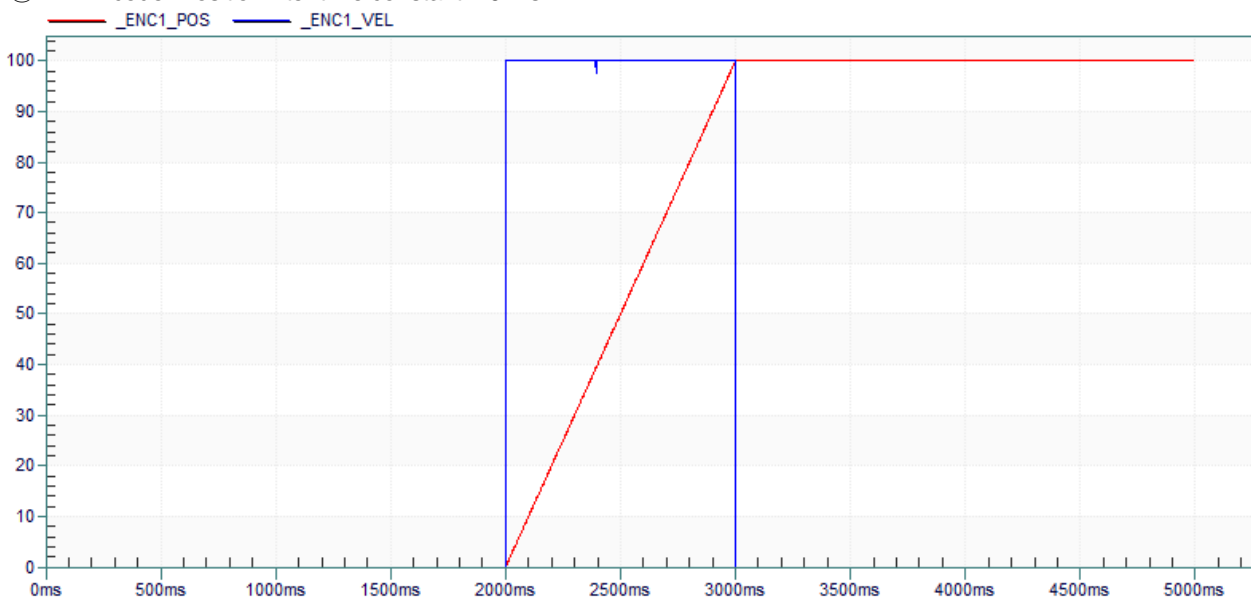
This is to set the speed display unit of the encoder and sets the standard unit of the speed value.

If it is set to '0: Unit/sec', it is applied at the rate of change per second of the corresponding unit position set in the 'Unit' parameter. For example, if the "Unit" setting is mm, the display unit of the speed is "mm/s".

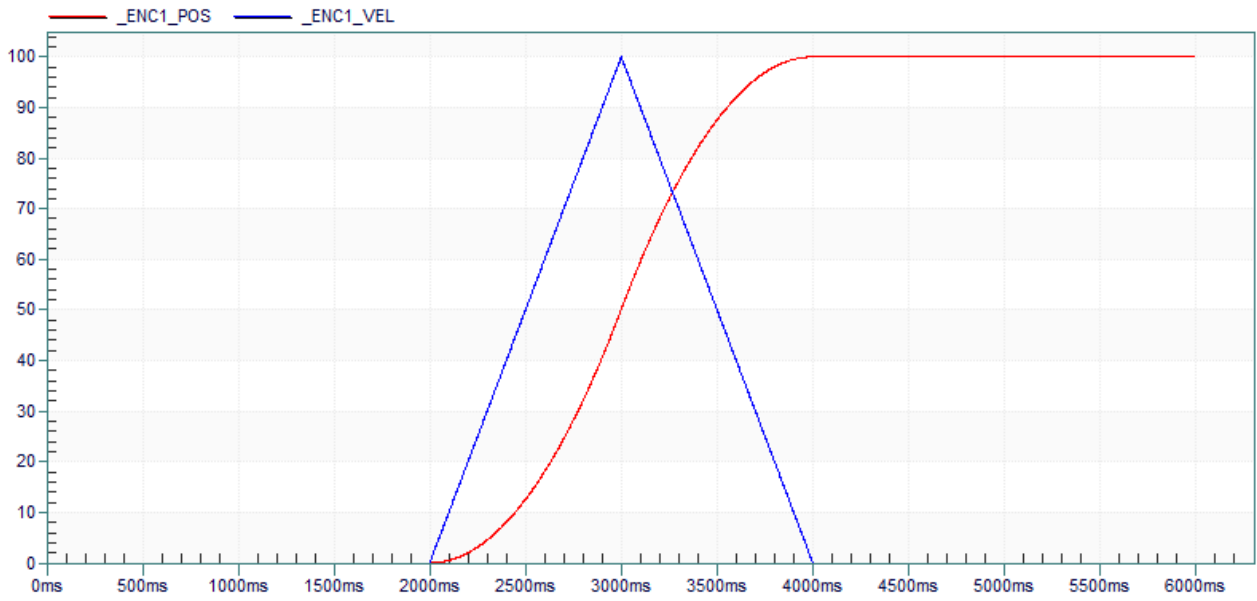
If it is set to '1: Unit/min', it is applied as the rate of change per minute of the corresponding unit position set in the 'Unit' parameter. For example, if the "Unit" setting is mm, the display unit of the speed is "mm/min".

When set to '2: rpm', the speed command unit is applied in rpm. When the speed display unit is rpm, when converting to unit speed internally, the values set in the parameters "Number of pulses per revolution" and "Transfer distance per revolution" are used.

① Encoder Position filter time constant = 0 ms



② Encoder Position filter time constant = 1,000 ms



#### 4. Axis group parameter

Axis group parameter item is explained as follows.

Item	Description	Settings	Initial value
Axis1	Set the axis which form axis group.	None, 1Axis ~ 32Axis(real axis), 37Axis ~ 40Axis(virtual axis)	None
Axis 2			None
Axis 3			None
Axis 4			None
Interpolation speed max	Set max speed of operation about axis group.	Long Real(LREAL) Positive number	20000000 u/s

##### (1) Configuration axis setting

Set the number of each axis which belongs to the relevant axis group. Each axis group can include up to 4 axes.

Virtual axis can also be set in the axis group parameter.

Axis setting must be set in order in axis group which executes circular interpolation or helical interpolation command. In other words, 「axis setting 1」 is X-axis of the arc, 「axis setting 2」 is Y-axis of the arc, and 「axis setting 3」 is Z-axis of helical interpolation.

Therefore, if circular interpolation command is executed when setting the axis group, errors occur as follows.

- In case the axis group is comprised of 4 axes (error code: 0x20A9)
- In case the set value of 「axis setting 1」 or 「axis setting 2」 is 'none' (error code: 0x20AA)
- In case the set value of 「axis setting 3」 is 'none' and the remaining axes are set (error code: 0x20AA)

##### (2) Interpolation speed max

This refers to the configurable maximum speed of interpolation control operation when controlling interpolation with axes which belongs to the relevant axis group.

In case of interpolation operation of the relevant axis group, interpolation speed must be set below the set Interpolation speed max.

### 5. Coordinate system configuration

Coordinate system parameter is explained as follows.

Part	Description	Setting range	Initial value
Coordinate system	Set the type of robot that is applied in the operation of coordinate system.	0: None 1: XYZ 2: Delta3 3:Delta3R 4:LinearDelta3 5:LinearDelta3R 6:T-Gantry 7:T-GantryR	0: None
Coordinate system parameter	Set the parameters of the machine depending on the type of coordinate system.	-	-

(1) XYZ

XYZ is a robot where the axis set in 「axis setting 1」 in X-axis, the axis set in 「axis setting2」 in Y-axis, and the axis set in 「axis setting 3」 in Z-axis make a one-to-one correspondence and move in Cartesian coordinate. If the type of coordinate system is set to XYZ, there is no need to set the coordinate system parameters.

(2) Delta3/3R

Delta3 is a delta robot composed of 3-axes. If the type of coordinate system is set to Delta3, the four Rf/Rm/Lf/Lm coordinate system parameters should be set.

	Parameter	Description
	Fixed frame radius(Rf)	Distance from the center of a fixed frame to the link of the fixed frame (mm)
	Fixed frame link length(Lf)	Fixed frame's link length (mm)
	Moving frame link length (Lm)	Moving frame's link length (mm)
	Moving frame radius(Rm)	Distance from the center of a moving frame to the link of the moving frame (mm) (The left figure is a case where X, Y coordinates of the fixed and moving frames are the same.)

(3) LinearDelta3/3R

LinearDelta is a delta robot composed of 3 linear axes. When the coordinate system type is set to LinearDelta, 5 coordinate system parameter values must be set: Lm/Hf/RfTop/RfBottom/Rm.

	Parameter	Description
	Moving frame link length (Lm)	Link length of moving frame (mm)
	Fixed frame height (Hf)	Fixed frame height (mm)
	Fixed frame radius(RfTop)	Radius of fixed frame (mm)
	Fixed frame radius (RfBottom)	Radius of fixed frame (mm)
Moving frame radius (Rm)	Distance from the center of the moving frame to the link of the moving frame (mm) (The figure on the left is when the fixed frame and the moving frame have the same X and Y coordinates.)	

6. Tool configuration

Tool setting parameter is explained as follows.

Part	Description	Setting range	Initial value
X axis offset	Set the X axis offset of the end (tool) of the robot.	LREAL	0
Y axis offset	Set the Y axis offset of the end (tool) of the robot.	LREAL	0
Z axis offset	Set the Z axis offset of the end (tool) of the robot.	LREAL	0

Tool setting parameter enables the position of a tool to be set in offset to ensure control of the end of the tool in cases where a separate tool is attached to the end of the robot for use.

7. Workspace configuration

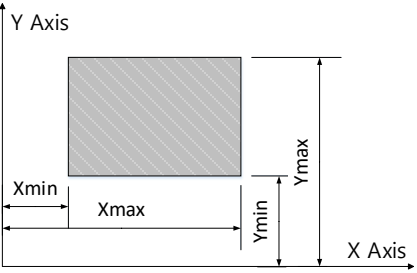
Workspace parameter is explained as follows.

Part	Description	Setting range	Initial value
Workspace type	Set the workspace type.	0: Rectangle 1: Cylinder	0

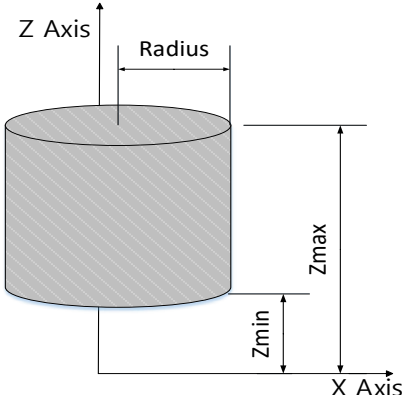


		2: Delta 3: Sector 2: Cylinder 3: Delta 4: Sector	
Workspace error check	It sets the occurrence of an error in the outside of workspace.	0: Prohibition 1: Permit	0
Workspace parameter	Set the parameter depending on the type of workspace.	LREAL	0

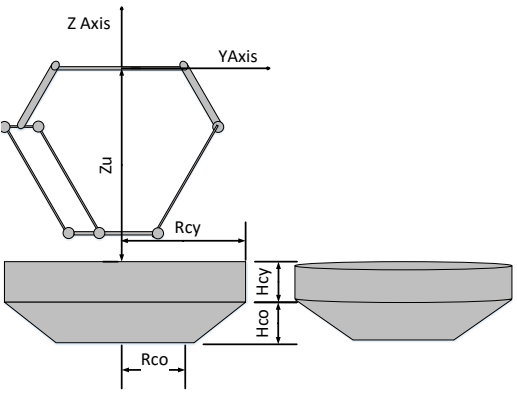
(1) Rectangle

	Parameter	Value
	Workspace parameter 1	X min(mm)
	Workspace parameter 2	X max(mm)
	Workspace parameter 3	Y min(mm)
	Workspace parameter 4	Y max(mm)
	Workspace parameter 5	Z min(mm)
	Workspace parameter 6	Z max(mm)
	-	-

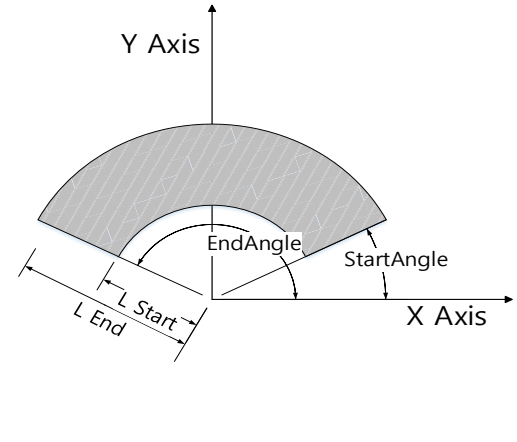
(2) Cylinder

	Parameter	Value
	Workspace parameter 1	Radius(mm)
	Workspace parameter 2	Z min(mm)
	Workspace parameter 3	Z max(mm)
-	-	

(3) Delta

	Parameter	Value
	Workspace parameter 1	Zu(mm)
	Workspace parameter 2	Hcy(mm)
	Workspace parameter 3	Hco(mm)
	Workspace parameter 4	Rcy(mm)
	Workspace parameter 5	Rco(mm)
-	-	

(4) Sector

	Parameter	Value
	Workspace parameter 1	L start(mm)
	Workspace parameter 2	L end(mm)
	Workspace parameter 3	Z min(mm)
	Workspace parameter 4	Z max(mm)
	Workspace parameter 5	SartAngle(degree)
Workspace parameter 6	EndAngle(degree)	
-	-	

8. PCS Configuration

PCS Configuration is explained as follows.

Part	Description	Setting range	Initial value
X axis movement value	Set the X axis movement distance from the home position of MCS to that of PCS.	LREAL	0 mm
Y axis movement value	Set the Y axis movement distance from the home position of MCS to that of PCS.	LREAL	0 mm
Z axis movement value	Set the X axis movement distance from the home position of MCS to that of PCS.	LREAL	0 mm
X axis rotation	Set the X axis rotation value of PCS.	-360~360	0 deg
Y axis rotation	Set the Y axis rotation value of PCS.	-360~360	0 deg
Z axis rotation	Set the Z axis rotation value of PCS.	-360~360	0 deg

PCS parameter sets the home position to PCS to easily perform the operation of moving from the top of a specific object in the

coordinate system operation. In the operation of PCS coordinate system, the coordinate system operation to make the set PCS as the home position is performed.

### 9. Coordinate system jog configuration

It describes the setting items of coordinate system jog configuration.

The coordinate system jog speed parameter sets the speed when moving from coordinate system operation to jog operation.

Part	Description	Setting range	Initial value
XYZ high speed	Set the jog high-speed operation speed of the linear axis of coordinate system operation.	LREAL	5 mm/sec
XYZ low speed	Set the jog low-speed operation speed of the linear axis of coordinate system operation.	LREAL Should be less than or equal to XYZ high speed speed.	1 mm/sec
ABC high speed	Set the jog high-speed operation speed of the rotation axis of coordinate system operation.	LREAL	5 deg/sec
ABC low speed	Set the jog low-speed operation speed of the rotation axis of coordinate system operation.	LREAL Should be less than or equal to ABC high speed speed.	1 deg/sec

### 10. Network parameter

The items related to EtherCAT network setting are explained here.

In modifying network parameters, be sure to write master/slave parameter and slave data in Project Write menu before use.

#### (1) Master parameter

Set master function related to EtherCAT slave connection when connecting network.

Master parameter setting items are as follows.

Item	Description	Settings	Initial value
Slave Revision Check	Specify whether to check Revision information of parameter matches the Revision value of actual slave at the time of network connection.	0: Don't check 1: Check	0: Don't check
Slave Serial Number Check	Specify whether to check serial number information of parameter matches the serial number value of actual slave at the time of network connection.	0: Don't check 1: Check	0: Don't check
Periodic communication time-out count	Specify the number of criteria that periodic communication time-out occurs.	1 ~ 8	2

#### (a) Slave Revision check

Whether to proceed with the connection is determined by comparing the revision information set in the slave parameters at the time of network connection with that possessed by the slave which is actually connected.

Motions according to the set values are as follows.

- '0:Don't check'

The communication connection process is continued while not comparing the Revision information set in the slave parameter and the Revision information which the slave has.

- '1: Check'

Compare the Revision information set in the slave parameter and the Revision information which the connected slave has, and if it does not correspond, a network configuration mismatch error (error code: 0x0F1F) occurs and ends the communication connection process.

It may not operate normally if the Revision of the slave parameter and a slave with no compatibility are connected in case that you set the check standard of slave Revision to '0: Don't check'. Therefore, use it after checking the availability of the compatibility between the Revisions

### (b) Slave Serial Number Check

When connecting to the network, decide whether or not to continue the connection process by comparing the serial number information set in the slave parameter and the serial number information which actually connected slave has.

Motions according to the set values are as follows.

- '0: Don't check'

The communication connection process is continued while not comparing the serial number information set in the slave parameter and the serial number information which the slave has.

- '1: Check'

Compare the serial number information set in the slave parameter and the serial number information which the connected slave has, and if it does not correspond, a network configuration mismatch error (error code: 0x0F1F) occurs and ends the communication connection process.

If the slave's serial number check is set to '1: Check', you are able to know the changes made to the network when the network configuration order is changed or when the slave is replaced, which is useful for maintaining and repairing such as resetting the slave parameter. Resetting of the serial number in XG-PM is required to connect to the changed network configuration.

### (c) Periodic communication time-out count

The standard number occurring time-out error is specified when it cannot receive the periodic data during execution of periodic communication between the motion control module and the slave device.

When the communication time-out error occurs frequently from various noise environments (power surges, induction noise or noise interference between the motion control module and the wiring of the slave device), set the set value high.

The available setting range is between 1 to 8 times.

## (2) Slave data

### (a) Slave parameter

Set the information of EtherCAT slave used when connecting to the network. The slave parameter can be identified in the slave information window which is displayed when adding the slave by executing [Slave data] – [Add item] – [Slave] in the XG-PM project tree. Or you can check it in the slave information window which is displayed after executing each slave's 'Properties' linked to the sub-tree of the [Slave data] on the XG-PM project tree

The setting items for the slave parameter are as follows.

Item		Description	Settings	Initial value
Slave name		Select the slave and displays the name of selected slave.	XML	L7NH
Number		Set the number of station which is applied to the selected slave.	1 ~ 32 33 ~ 36	1 (Increase automatically when adding the slave)
Vendor		The name of the selected slave supplier is automatically displayed.	Setting is not available	LS ELECTRIC
Version		Revision of the selected slave is automatically displayed.	Setting is not available	#x00000001
PDO Map	RxPDO	RxPDO mapping information of the slave is automatically displayed.	XML	0x1600 PDO map information
	TxPDO	TxPDO mapping information of the slave is automatically displayed.	XML	0x1A00 PDO map information
DC Used		Set the DC use of the slave.	0: Unused 1: Used	1: Used
Slave Replace		Set whether to use the replacement function during connection.	0: Unused 1: Used	0: Unused

① Slave name

Select the slave you want to connect to the motion control module, and display the name of the selected slave.

L7N servo drive is selected for the initial value when adding the slave to the slave data.

Display the supportable list by bringing the slave information from XML file which is in the folders below.

- Korean version: 'XG-PM setting folder' > \\.kor\DriveInfo, \\.kor\IOInfo folder
- English version: 'XG-PM setting folder' > \\.eng\DriveInfo, \\.eng\IOInfo folder

When wanting to add new slave, copy the relevant XML file to the folders above and restart XG-PM.

② The number of station

Set the number of station which is applied to the selected slave. The set number of station is the slave number and IO device number.

Setting ranges are as follows.

- Servo drive: 1 ~ 32
- EtherCAT I/O device: 33 ~ 36

In the event of connecting servo drive automatically, axis order is automatically set in accordance with connection order.

③ Vendor

The name of the selected slave supplier is automatically displayed. User cannot arbitrarily change it.

④ Version

Revision information of the selected slave is automatically displayed. User cannot arbitrarily change it.

### ⑤ RxPDO

Set the synchronous data which is transmitted from the motion control module to the slave in every communication period. RxPDO item supported by the relevant slave is automatically set when selecting a slave.

Object that the user wants can be added or deleted by using the editing function.

When editing the PDO object, the following objectives must be included as they are essential items used in the motion control module.

- 0x6040:0          Controlword
- 0x607A:0          Target position

The synchronous data assigned here is automatically registered as input/output flag and it can be referred in the user program.

For example, 'Controlworld' object from RxPDO synchronous data of L7N servo drive which is linked to the slave 1 is registered as I/O flag, `_SL1_Controlword (%QW1.0)`.

### ⑥ TxPDO

Set the synchronous data which is read from the slave in the motion control module every communication period. When selecting the slave, the TxPDO item which is supported by the relevant slave is set automatically. Object that the user wants can be added or deleted by using the editing function.

When editing the PDO object, the following objects must be included as they are essential items used in the motion control module.

- 0x6041:0          Statusword
- 0x6064:0          Position Actual Value

The synchronous data assigned here is automatically registered as I/O flag and it can be referred in the user program.

For example, 'Statusword' object from TxPDO synchronous data of L7N servo drive which is linked to the slave 2 is registered as I/O flag, `_SL1_Statusword (%IW1.0)`.

### ⑦ DC Used

If the slave supports the DC function, it is automatically set from the XML file. If you do not want to use the DC function, select it to 0: Unused.

DC(Distributed Clock) is a function used to synchronize the EtherCAT master and the EtherCAT slave, and it allows high-definition synchronous control between the Ethercat slaves.

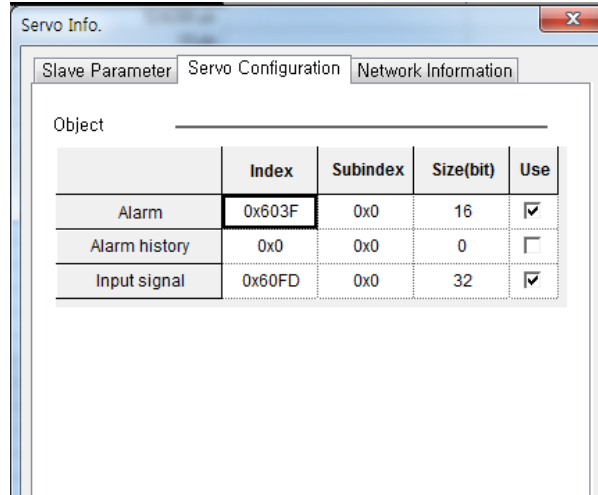
DC shares the time information between the EtherCAT master and EtherCAT slave; and adjusts the synchronization between each slave. In order to share the time information, the first slave that is connected to the motion control module provides the Reference Clock. The Reference Clock distributes time information to each slave every communication period.

### ⑧ Slave Rreplace

If the slave that was stopped due to network disconnection or malfunction while using the cable redundancy function is recovered from an error and is connected to the network, it detects the connection and provides a function to connect to the network of individual slaves without the need to reconnect the entire network. For detailed description of the function, refer to 8.3.6 Replacement function during connection.

(b) Servo configuration

Servo configuration includes the object information that has alarm information/alarm history information/input signal information. The information is the content which is not defined in the xml file from the device manufacturer, and there it is set automatically when the servo driver is added. Since if the servo setting information does not match the actual device, there may be constraints on the device use, a user is required to modify the servo setting information in person.



(3) Operation parameter

(a) Basic parameter

Basic parameter among operation parameters is explained as follows.

Item	Description	Settings	Initial value
Unit	Set the command position unit of the axis.	0: pulse 1: mm 2: inch 3:degree	0: pulse
Pulse/Rev Value	Set the number of pulses per rotation of motor which corresponds encoder resolution.	1 ~ 4294967295	524288 pls
Travel distance per rotation	Set the movement amount of the load side moved per rotation of motor.	0.000000001 ~ 4294967295	10 pls
Speed command unit	Set the command speed unit of the axis.	0: Unit/sec 1: rpm	0: Unit/sec
Speed limit	Set the maximum speed in case of the speed command of each axis.	Long real(LREAL) Positive number	20000000 pls/s
Emergency stop deceleration	Set the deceleration used in the sudden stop conditions.	0 or Long real(LREAL) Positive number	0 pls/s <sup>2</sup>
Encoder select	Set the type of encoder to be used.	0: Incremental Encoder 1: Absolute Encoder	0: Incremental Encoder
Gear ratio of motor side	Set the gear ratio between motor and load.	1~65535	1
Gear ratio of machine side		1~65535	1

Operating mode of the reverse rotation	Specify the operation method in case operation direction is reversed in the input conditions of newly executed command.	0: Deceleration stop 1: Immediate stop	0: Deceleration stop
Position control range expansion	Set whether to use the function used by expanding the controllable position range during position control.	0: No 1: Use	0: No
Velocity control operation mode	When controlling speed using MC_MoveVelocity, it sets the operation mode of the servo drive.	0: CSP (Cyclic Sync. Position) 1: CSV (Cyclic Sync. Velocity)	0: CSP (Cyclic Sync. Position)

① Unit

This is used to set the command unit during motion control, and depending on the control target, the unit of pulse, mm, inch, and degree can be set for each axis.

When changing the setting of the unit, other parameters or variable values are not changed. Therefore, when changing the units, the relevant parameters must be reset so that they can be adjusted to the setting range of the relevant unit.

② Pulse/Rev Value

When using mm, inch, and degree for the motion control command units and indicating the speed in rpm, the number of pulses required per motor rotation is set to be used.

③ Travel distance per rotation

Set the movement amount of the load side per motor rotation when using mm, inch and degree for motion control command unit.

How the machine moves from a rotation of motor is determined by the structure of the machine.

④ Speed command unit

The base unit of the value of the speed used for the motion control command is set.

If it is set to '0: unit/time', it is applied by the rate of change per second from the position of the relevant unit set in the 「unit」 parameter. For example, if the setting of the 「unit」 is in mm, the unit of the speed command is 'mm/s'.

If it is set to '1: rpm', rpm is applied to the speed command unit. If the speed command unit is rpm and it is internally changed to the unit speed, values set in the 「Pulses per rotation」 and 「Travel per rotation」 parameters are used.

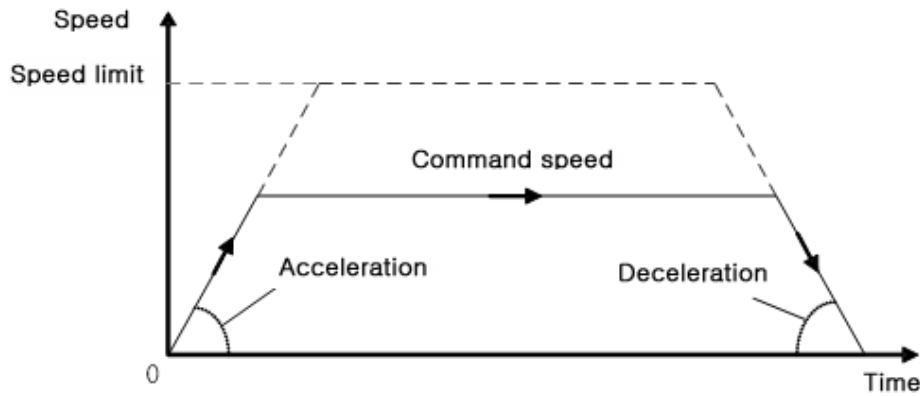
When changing the setting of the speed command unit, other parameters or variable values are not changed. Therefore, the related parameters must also be reset according to the setting range of the relevant unit.

⑤ Speed limit

Speed limit refers to the maximum rate of the available setting of motion control operation.

When operating the relevant axis, the operation speed should be set below the speed limit set.





⑥ Emergency stop deceleration

Deceleration in the event of a sudden stop sets the deceleration for situations where a sudden stop needs to be made while operating the axis due to internal or external factors.

Conditions for a emergency stop are as follows.

- In case the software upper limit/lower limit is detected
- In case the operation speed of the serve axis exceeds the speed limit in synchronized operation (gear, cam)
- In case the setting for 「error level of tracking error」 is '1: alarm' and the error of tracking error occurs
- In case the emergency stop command is executed during the test operation in XG-PM
- In case an error occurs in the command executed while axis is currently operating during the checking of execution conditions

(Except for occasions when restarting the command or ContinuousUpdate is activated.)

⑦ Encoder select

Set the type of encoder that is going to be used. When using the absolute position system, select 1: absolute encoder. The following shows the setting of “Encoder select”

Item	Settings	Description
Encoder select	0: Incremental Encoder	After power on/off, the previous location of servo motor is not maintained. After power of/off, origin fix state is off.
	1: Absolute Encoder	The absolute position system is activated. After power on/off, the previous location of servo motor is maintained. Origin fix state maintain last condition before power on/off.

⑧ Gear ratio(Motor, Machine)

Set gear ratio between the motor and the load. If it is a structure that the load side rotates n times when the motor side rotates m times, set the gear ratios as below.

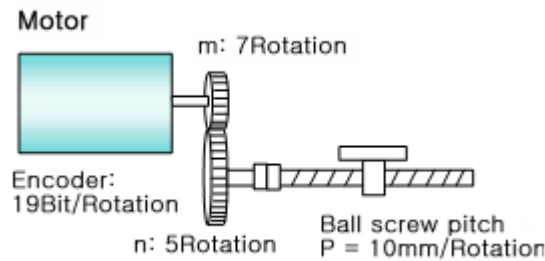
- Motor side gear ratio = m

- Machine side gear ratio = n

If the 「unit」 setting is '0: pulse', this parameter is invalid.

### [Setting Example]

When the machine which is moved by ball screw is connected to the encoder with gear, the setting of the encoder unit/ Pulses per rotation/ travel per rotation is as follows.



- Unit: mm
- Pulses per rotation = 524288 (19Bit Encoder)
- Travel per rotation = Ball screw pitch  
= 10.0 mm
- Gear ratio(Motor) = 7
- Gear ratio(Machine) = 5

### Note

If the unit from above 'Setting example' is set to '0', it is moved to by a position corresponding to the encoder pulse, regardless of the motor and machine gear ratio.

In other words, in order to move the 10mm it must make a command of the  $524288 * 7/5 = 734003$  pulse

### ⑨ Operating mode of the reverse rotation

Specify the method of motion when the operation direction is reversed in the input conditions of newly executed commands.

When starting or restarting the command which the BufferMode is Aborting, or activating ConinuousUpdate, in case where the command condition and the current operating direction are in reverse of each other, stop it by following the method set in the parameter, and start operation in the set speed.

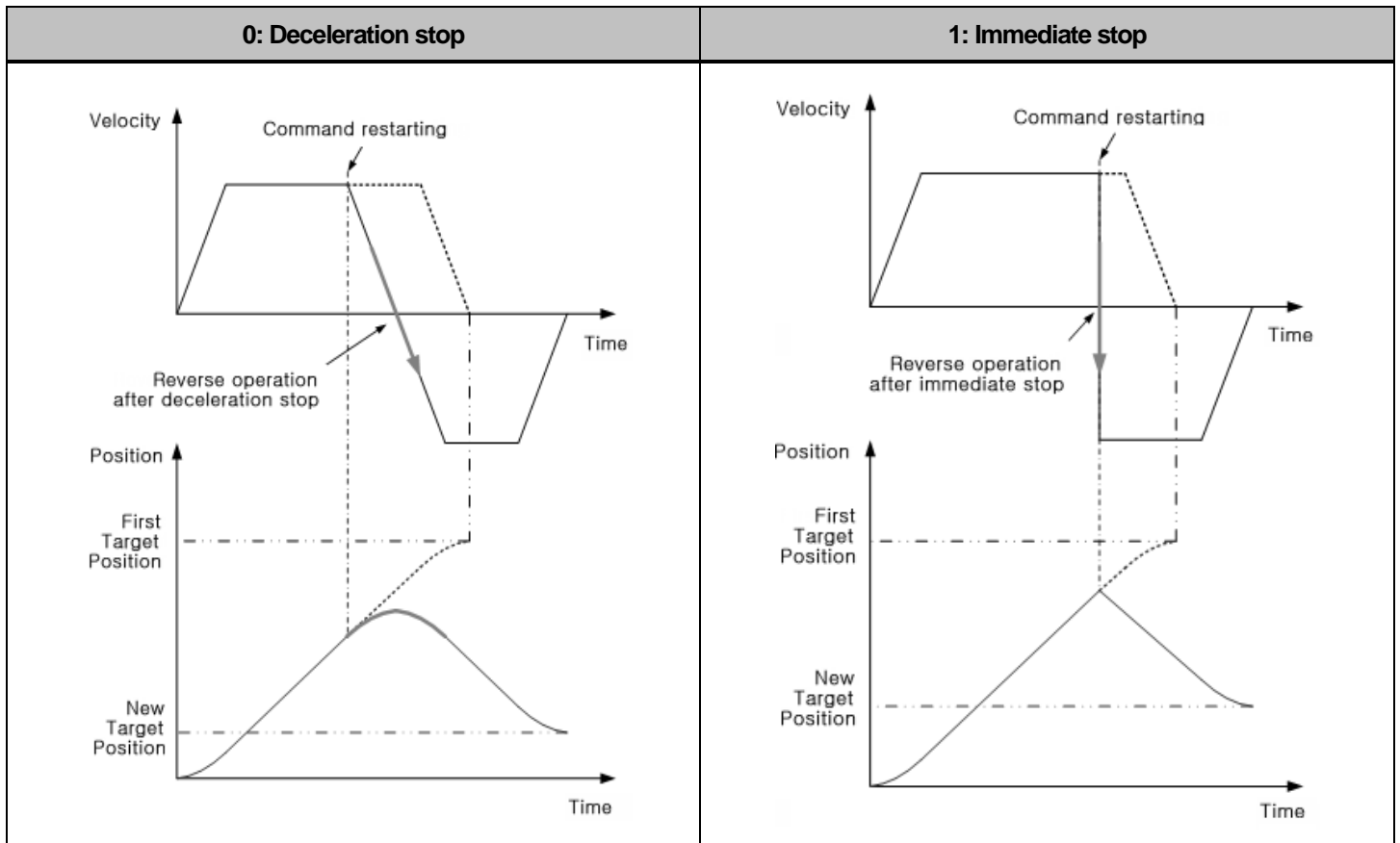
If the BufferMode is not Aborting, it is run in the specified continuous running method in the BufferMode rather than the method set in the parameter.

- '0: Deceleration stop'

When the operation direction is reversed by the condition of newly executed command, make a deceleration pause to 0 speed and continue accelerating to the target position or operate at the targeted speed.

- '1: Immediate stop'

When the operation direction is reversed by the condition of newly executed command, stop immediately and continue operating in the opposite direction in the same operation speeds to the target position or at the targeted speed.



⑩ Position control range expansion

Set whether to use the function used by expanding the controllable position range during position control. When designating the target position in the motion control command, an error occurs when the position after converting the unit position set by LREAL into pulse units is out of the position control range.

The position control range according to the parameter setting is as follows.

Item	Value	Position control range
Position control range expansion	0: No	Int 32bit, $-2^{31} \sim 2^{31}-1$ (-2,147,483,648 ~ 2,147,483,647)
	1: Use	Int 48bit, $-2^{47} \sim 2^{47}-1$ (-140,737,488,355,328 ~ 140,737,488,355,327)

⑪ Velocity control operation mode

Execute MC\_MoveVelocity to set the operation mode of the servo drive to use when controlling the axis speed. The operation according to the parameter setting is as follows.

Item	Value	Operation
Velocity control operation mode	0: CSP (Cyclic Sync. Position)	The servo drive is set to CSP operation mode, and the position increment corresponding to the command speed is reflected in the target position at every weekly task cycle and transmitted to the servo drive. The servo drive performs position control.

	1: CSV (Cyclic Sync. Velocity)	Set the servo drive to the CSV operation mode, and transmit the command speed to the servo drive every weekly task cycle. The servo drive performs speed control.
--	--------------------------------	---

(b) Extended parameter

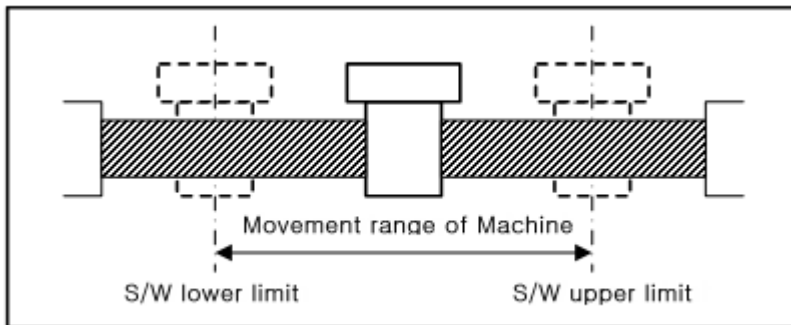
The following explains extended parameter of operation parameter

Item	Description	Settings	Initial value
S/W upper limit	Set the range of the software limit functions.	Long real(LREAL)	2147483647 pls
S/W lower limit			-2147483648 pls
Infinite running repeat position	Set the value of the repetitive position range in case infinite running repeat mode is used.	Long real(LREAL) Positive number	360 pls
Infinite running repeat	Set the allowable status of infinite length repetitive operation functions.	0: Disable 1: Enable	0: Disable
Command in-position range	Set the range where inposition signal is On before completion of positioning.	0 or Long real(LREAL) Positive number	0 pls
Tracking error over-range value	Set the value to detect more than position deviation.	0 or Long real(LREAL) Positive number	0
Tracking error level	Set the error level more than deviation.	0: Warning 1: Alarm	0: Warning
Current position compensation amount	Set the compensation threshold to indicate the current position value as the target position value.	0 or Long real(LREAL) Positive number	0
Current speed filter time constant	Set the time to calculate movement average of the current speed.	0 ~ 100	0
Error reset monitoring time	Set the monitoring time when resetting error occurred in servo drive.	1 ~ 1000	100
S/W limit during speed control	Set whether the soft limit is detected during the speed control.	0: Don't detection 1: Detect	0: Don't detection
The Sync method depending on the direction of master axis operation	It sets the operation direction of the main axis referenced during synchronous operation.	0: Sync to bi-direction operation of master axis 1: Sync to forward direction operation of master axis 2: Sync to reverse direction operation of master axis	0: Sync to bi-direction operation of master axis
JOG high speed	Set the values of speed / acceleration / deceleration / jerk which is referred in jog operation command	Long real(LREAL)	100000 pls/s
JOG low speed		Positive number	10000 pls/s
JOG Acceleration		0 or	100000 pls/s <sup>2</sup>
JOG Deceleration		Long real(LREAL)	100000 pls/s <sup>2</sup>
JOG Jerk		Positive number	0 pls/s <sup>3</sup>

① Software upper limit / Software lower limit

This is a function which sets the available range of the movement of the machine in the way of software by setting the upper limit & lower limit and allows the machine not to be operated beyond the set range. In other words, this is used to prevent a breakaway due to an error from setting the operation position and false operation that occurs from the user program error.

Set the external input upper limit and lower limit beyond the range of the software upper limit and the software lower limit.



The range check of the software upper limit and lower limit is conducted at the beginning of operation and during the operation.

If the soft upper limit and lower limit is detected, an error occurs and the module suddenly stops a motor. Therefore, check the cause of the error and use it after resetting the error when restarting the operation.

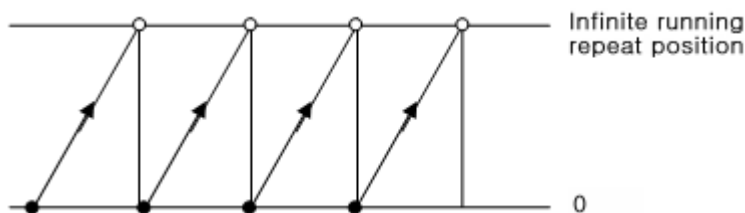
If you set the software upper limit and lower limit to be the initial value (upper limit: 2,147,483,647, lower limit: -2,147,483,648) or the same value, the soft upper limit and lower limit is not be detected.

② Infinite running repeat position

When using in infinite running repeat mode, set the position value which is repeated.

This is applied when the setting of extended parameter, 「Infinite running repeat」 parameter, is '1:Enable'.

When the 「Infinite running repeat」 parameter is '1:Enable', the command position and current position is indicated as "0~ (infinite running repeat position of -1). (「Unit」 = 0: pulse based)



③ Infinite running repeat

Set the function availability of infinite running repeat operation.

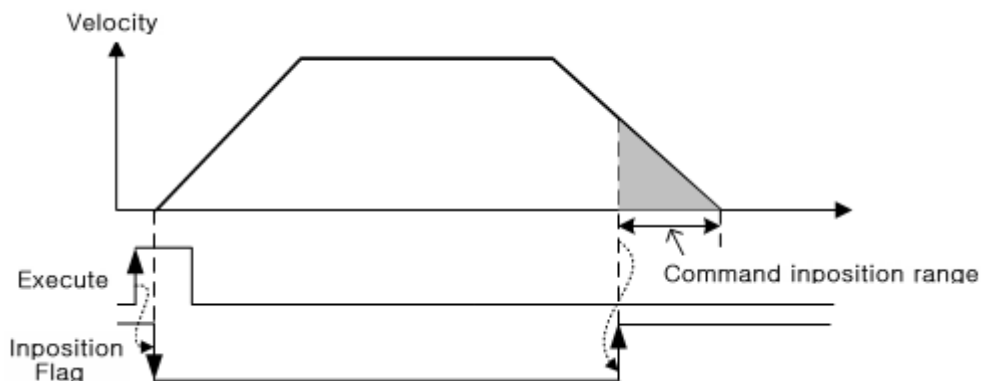
If this parameter is set to '1: Enable', the display of the command position and current position is updated periodically and automatically in the range set in the infinite length repetition position.

You must set it to '0: Disable' when you are not using the infinite running repeat operation function.

### ④ Command in-position range

This item sets the distance to the target position where inposition flag (`_AXxx_INPOS`) is On.

When starting up the motion control, the in-position flag (`_AXxx_INPOS`) is Off, and it is On when the current position goes inside the 「Command inposition range」 from the target position. In-position flag can be used as a trigger when executing other assistant work before completing the position control.



### ⑤ Exceeding value of tracking error

Set the value which will detect the value over position deviation. If a value exceeds this range, the 「Over deviation warning (`_AXxx_DEV_WARN`)」 or 「Over deviation alarm (`_AXxx_DEV_ERR`)」 flag is On.

If this set value is 0, it won't detect the value over the deviation. You can set whether you want it to be a warning or an alarm for over deviation in the 「Error level of tracking error」 of the expanded parameter.

### ⑥ Tracking error level

Set whether to make it a warning or an alarm when the value over deviation is detected.

Operations according to the set values are as follows.

–'0: Warning'

When an error occurs in tracking error, the 「Over deviation warning (`_AXxx_DEV_WARN`)」 flag is On, and warning error of tracking error (error code: 0x101D) occurs. The axis does not stop and keeps operation.

–'1: Alarm'

When an error occurs in tracking error, the 「Over deviation alarm (`_AXxx_DEV_ERR`)」 flag is On, and the alarm error of tracking error (error code: 0x101C) occurs. The axis suddenly stops at the 「Emergency stop deceleration」 of basic parameter.

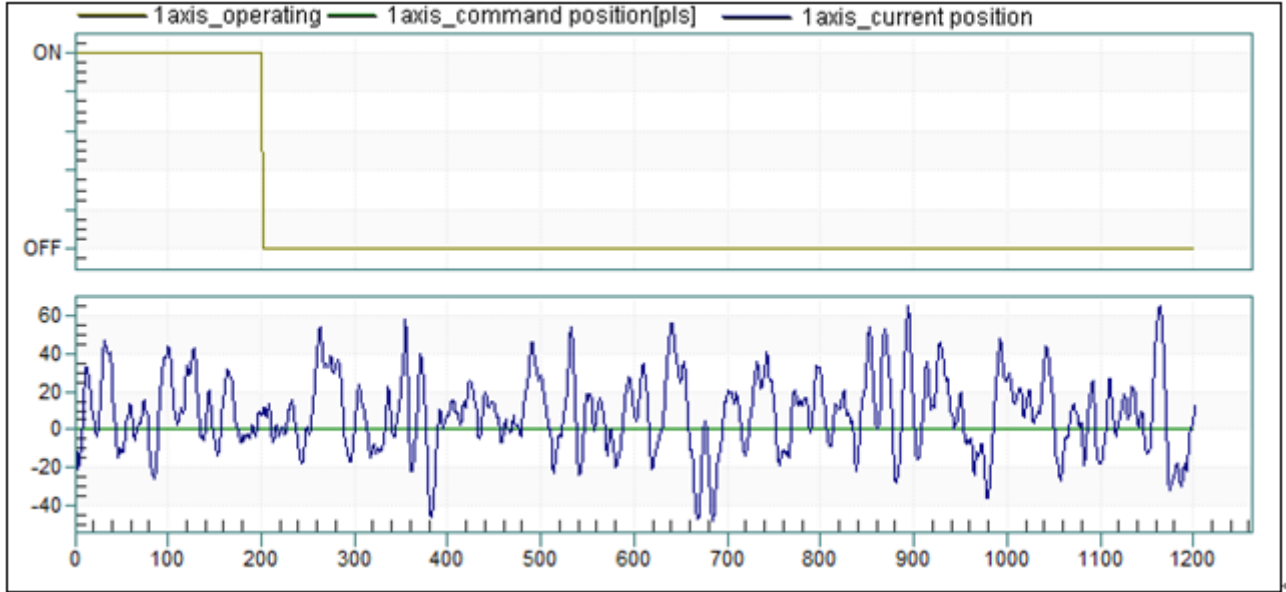
In the following situations, the error in tracking error is not examined.

- In case the 「Tracking error over-range value」 is 0
- In case of the operation in homing or torque control
- In case the 「Tracking error over-range value」 is 0
- In case of the operation in homing or torque control

### ⑦ Current position compensation amount

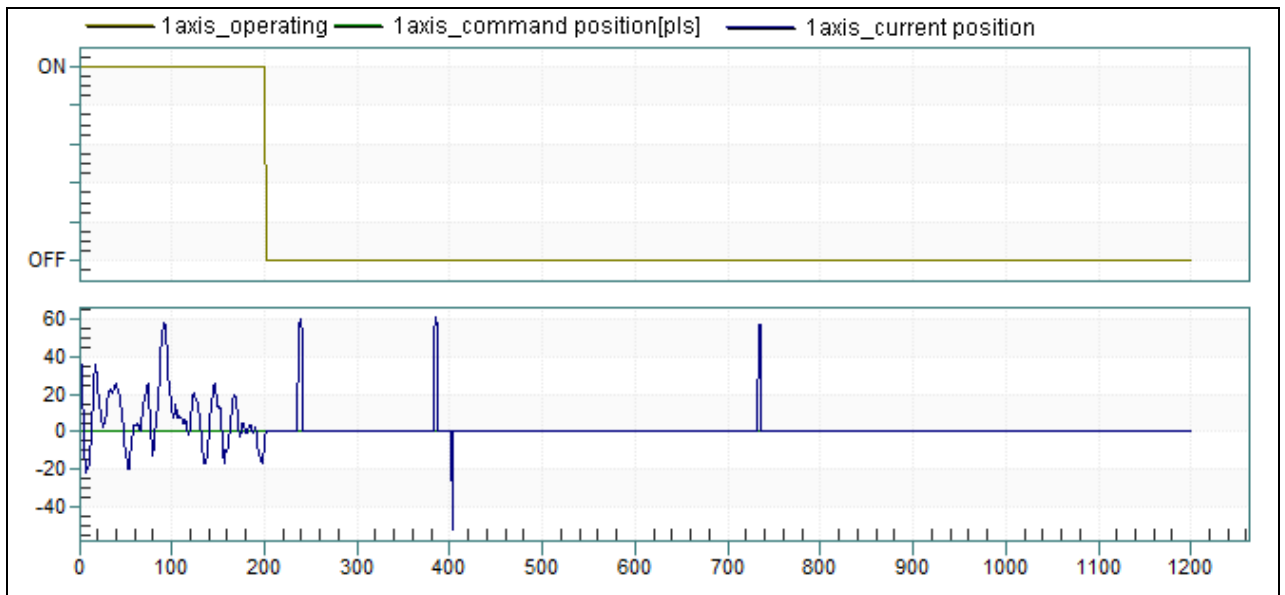
Current position compensation amount is a parameter unit used to display the current position value as the command position when the servo motor's current position value is not displayed as a fixed value but changed slightly depending

on the personal setting of the user application and the servo drive



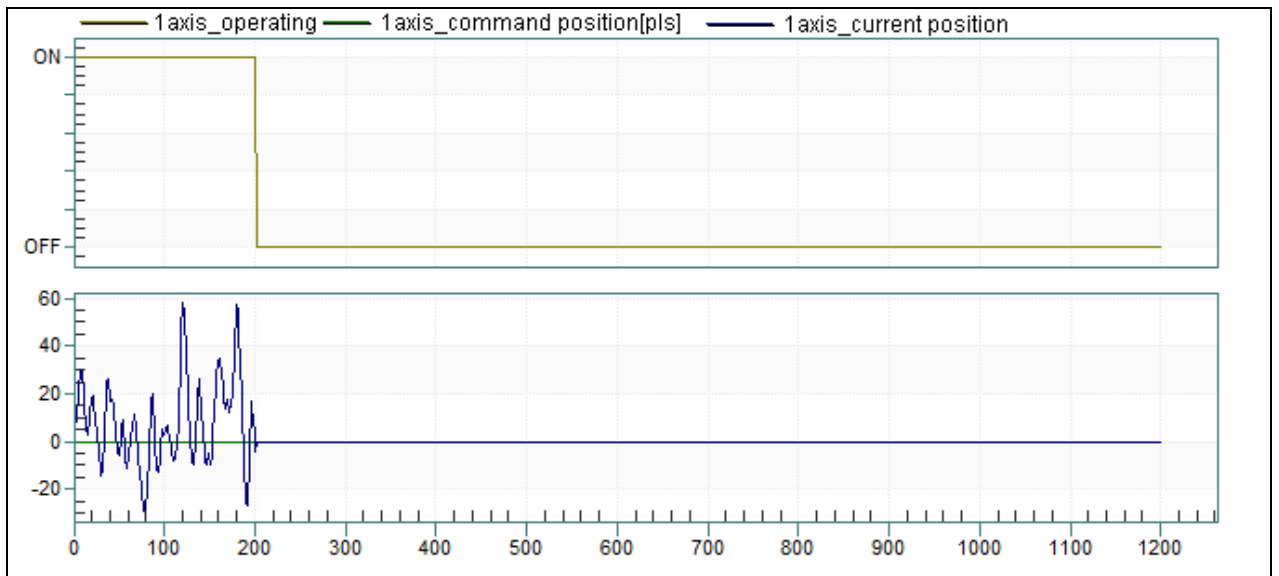
■ Current position compensation amount = 50 pls

If the current position value is within  $\pm 50$  of command position after the end of operation, it is displayed as the command position value. .



■ Current position compensation amount = 100 pls

If the current position value is within  $\pm 100$  of command position after the end of operation, it is displayed as the command position value.



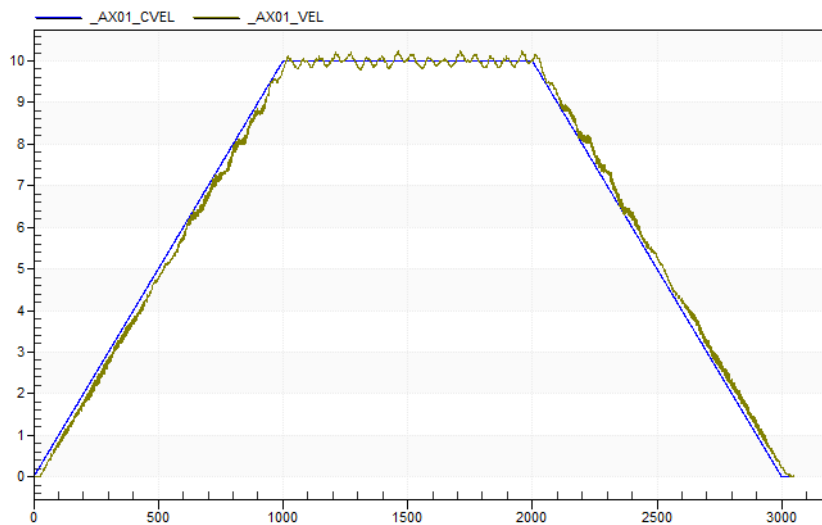
⑧ Current speed filter time constant

Set the time to calculate the average of movement at current speed. (unit: ms) Current speed filter time constant is not applied if it is set to '0'.

When the speed of axis is slow or there are wide variations in current speed (ex. 「unit」 setting is '0: pulse', stable speed can be achieved by applying the average of movement to the current speed.

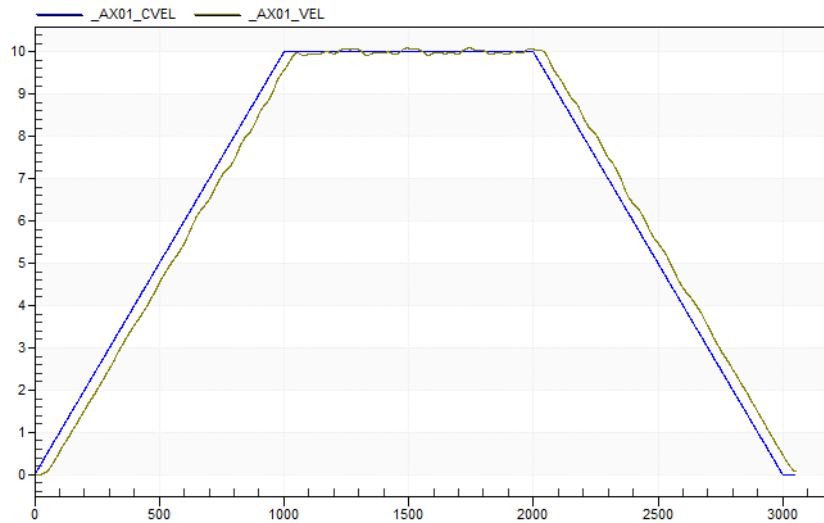
You can check the differences in current speed depending on the value of Current speed filter time constant in the list below which traces command speed and current speed at 10 mm/s of command speed.

■ Current speed filter time constant = 0 ms

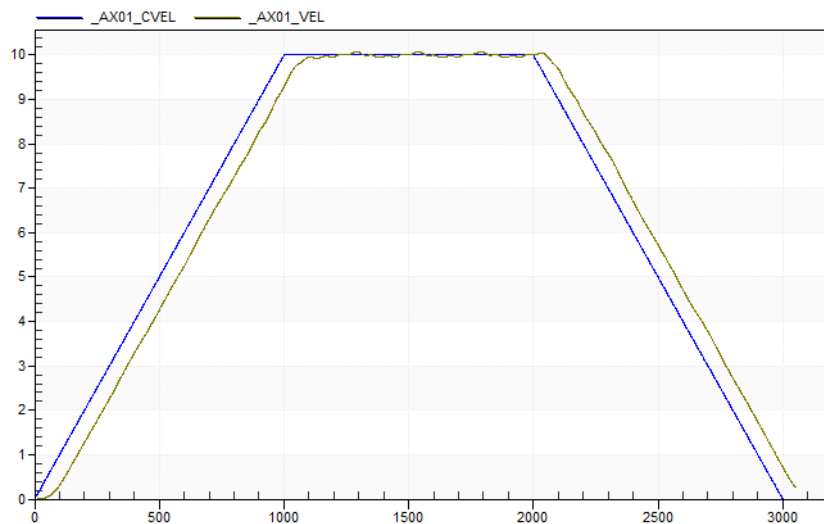




■ Current speed filter time constant = 50 ms



■ Current speed filter time constant = 100 ms



⑨ Error reset monitoring time

Set the monitoring time in the event of error reset occurred in the servo drive. (unit: ms) If the error which occurred in the servo drive within the error reset monitoring time, error reset monitoring is terminated and error reset time out error of servo drive (error code: 0x1070) is occurred.

⑩ SW limit during speed control

When software limit is detected during the operation at fixed speed by speed control, this is used to stop the motor. Operations according to the set values are as follows.

– ‘0: Don’t detect’

If it is under the speed control even when the software limit function is activated, software limit is not detected.

– ‘1: Detect’

If it is under the speed control even when the software limit function is activated, software limit is detected.

Even when the parameter value is set to '1: detect', if the software upper limit/lower limit is set to the initial value (upper limit: 2,147,483,647, lower limit: -2,147,483,648) or the same value, software limit is not detected.

⑪ The Sync method depending on the direction of master axis operation

It is used to set the operation direction of the main axis referenced by the sub axis in synchronous control commands such as CAM and Gear operation.

When the main axis set in the synchronous command operates in the opposite direction to the synchronous operation direction set in this parameter, the sub axis stops synchronous operation.

After the main axis starts driving in the synchronous operation direction again, when it passes the position that was previously operated in the opposite direction, the sub axis starts synchronous operation again.

The setting values are as follows.

- 0: Sync to bi-direction operation of master axis
- 1: Sync to forward direction operation of master axis
- 2: Sync to reverse direction operation of master axis

⑫ JOG high speed / JOG low speed

Jog speed is related to the speed when operating jog which is a type of manual operation. Jog operation is divided into JOG high speed and JOG low speed.

Jog is operated in the pattern with the areas of acceleration, fixed speed, and deceleration. Therefore, the acceleration area is controlled by jog acceleration time and the deceleration area is controlled by jog deceleration time.

Setting range of JOG high speed cannot exceed the speed limit. Also, JOG high speed must be the same with or bigger than JOG low speed.

⑬ JOG acceleration, JOG deceleration, JOG jerk

Set the values of acceleration, deceleration, and jerk which are applied in the case of JOG high speed and JOG low speed operation.

If JOG acceleration is 0, it is operated immediately at JOG set speed without acceleration area at the beginning of JOG operation.

If JOG deceleration is 0, it is stopped immediately at 0 without deceleration area at the stop of JOG operation.

If JOG jerk is 0, the form of acceleration/deceleration is in a linear as acceleration is fixed

⑭ Drive absolute position error detection function

If you want to initialize the origin fix state when an absolute position error is detected in the drive, you can use the drive absolute position error detection function to initialize the origin fix state. It can be used only on drives that support absolute position valid signals.

	<b>Drive</b>
LS	L7NH, PEGASUS, iX7NH

When a situation occurs in which the absolute position of the drive is damaged (ex. encoder cable disconnection) in the origin fix state, it is used to initialize the origin fix state and prevent malfunctions in operation due to absolute position abnormalities.

The function only works on drives that support absolute position valid signals.

This function operates when the extended parameter "Drive absolute position error detection" is set to 1: Origin fix state initialization.

When it is detected that the drive's absolute position valid signal changes from ON to OFF through EtherCAT communication, the origin fix state of the relevant axis is initialized and an axis error (absolute position abnormality detection error: 0x1240) occurs.

When communication is connected through the EtherCAT connection command, if the absolute position valid signal is OFF, the origin fix state of the relevant axis is initialized.

When changing the extended parameter "Drive absolute position error detection" from 0: No detection to 1: Drive absolute position error detection, if the absolute position valid signal of the relevant axis is OFF, the origin fix state of the relevant axis is initialized and an axis error (absolute position error during parameter writing) is set to OFF. An abnormality detection error: 0x1241) occurs.

If the current position setting function is executed while the drive absolute position valid signal of the corresponding axis is OFF, an axis error (absolute position abnormality detection error while performing the current position setting function: 0x1096) will occur.



## 5.2 I/O signal

Explain about the contents and functions of the I/O signal for data exchange of Motion control module and XGK CPU module.

### 5.2.1 Contents of I/O Signal

1. I/O Signal of Motion control module use input 48Bit, output 16bit.
2. The operation preparation signal (Uxx.00.F) of motion control module is a signal which always remains On when the module is in a normal state by the way of hardware, and the module recognition process is completed normally by CPU.  
If PLC CPU operation mode is RUN and there is the initialization task program when turning the initial power On, the operation preparation signal is On after the initialization task program has ended.  
When an error related to the hardware occurs during the operation of motion control module, the operation preparation signal is Off.
3. The relevant Bit is On in only the connected axis when the operation preparation signal for each axis of the motion control module is connected with EtherCAT communication between the motion control module and servo drive regardless of the operation mode of motion control module.
4. Output signal  
The signal delivers from PLC CPU to Motion control module.

Axis	Signal direction: PLC CPU → Motion Control Module	
	Output Signal	Description
Common	Uxx.03.0	RUN/STOP Command (0:RUN, 1:STOP)
-	Uxx.03.1	Unused
-	Uxx.03.2	Unused
-	Uxx.03.3	Unused
-	Uxx.03.4	Unused
-	Uxx.03.5	Unused
-	Uxx.03.6	Unused
-	Uxx.03.7	Unused
-	Uxx.03.8	Unused
-	Uxx.03.9	Unused
-	Uxx.03.A	Unused
-	Uxx.03.B	Unused
-	Uxx.03.C	Unused
-	Uxx.03.D	Unused
-	Uxx.03.E	Unused
-	Uxx.03.F	Unused

5. Input signal

The signal delivers from Motion control module to PLC CPU.

Signal direction: Motion Control Module → PLC CPU		
Axis	Output Signal	Description
Common	Uxx.00.0	RUN/STOP state (0:RUN, 1:STOP)
Common	Uxx.00.1	Error state
Common	Uxx.00.2	Communication state
-	Uxx.00.3	Unused
-	Uxx.00.4	Unused
-	Uxx.00.5	Unused
-	Uxx.00.6	Unused
-	Uxx.00.7	Unused
-	Uxx.00.8	Unused
-	Uxx.00.9	Unused
-	Uxx.00.A	Unused
-	Uxx.00.B	Unused
-	Uxx.00.C	Unused
-	Uxx.00.D	Unused
Common	Uxx.00.E	Link up/down information
Common	Uxx.00.F	Operation ready of Motion control module

Signal direction: Motion Control Module → PLC CPU		
Axis	Output Signal	Description
1 Axis	Uxx.01.0	1Axis operation ready
2 Axis	Uxx.01.1	2 Axis operation ready
3 Axis	Uxx.01.2	3 Axis operation ready
4 Axis	Uxx.01.3	4 Axis operation ready
5 Axis	Uxx.01.4	5 Axis operation ready
6 Axis	Uxx.01.5	6 Axis operation ready
7 Axis	Uxx.01.6	7 Axis operation ready
8 Axis	Uxx.01.7	8 Axis operation ready
9 Axis	Uxx.01.8	9 Axis operation ready
10 Axis	Uxx.01.9	10 Axis operation ready
11 Axis	Uxx.01.A	11 Axis operation ready
12 Axis	Uxx.01.B	12 Axis operation ready
13 Axis	Uxx.01.C	13 Axis operation ready
14 Axis	Uxx.01.D	14 Axis operation ready
15 Axis	Uxx.01.E	15 Axis operation ready
16 Axis	UXX.01.F	16 Axis operation ready

Signal direction: Motion Control Module → PLC CPU		
Axis	Output Signal	Description
17 Axis	Uxx.02.0	17 Axis operation ready
18 Axis	Uxx.02.1	18 Axis operation ready
19 Axis	Uxx.02.2	19 Axis operation ready
20 Axis	Uxx.02.3	20 Axis operation ready
21 Axis	Uxx.02.4	21 Axis operation ready
22 Axis	Uxx.02.5	22 Axis operation ready
23 Axis	Uxx.02.6	23 Axis operation ready
24 Axis	Uxx.02.7	24 Axis operation ready
25 Axis	Uxx.02.8	25 Axis operation ready
26 Axis	Uxx.02.9	26 Axis operation ready
27 Axis	Uxx.02.A	27 Axis operation ready
28 Axis	Uxx.02.B	28 Axis operation ready
29 Axis	Uxx.02.C	29 Axis operation ready
30 Axis	Uxx.02.D	30 Axis operation ready
31 Axis	Uxx.02.E	31 Axis operation ready
32 Axis	UXX.02.F	32 Axis operation ready

## 5.2.2 Use of I/O Signal

### 1. Ready signal of axis operation

- (1) Ready signal of axis operation use EtherCAT communication to motion control module. Signal related to the connected axis is on when connecting servo drive.
- (2) Can check the axis which is accessed to motion control module and performs EtherCAT communication.
- (3) When Disconnecting the communication between the motion control module and servo drive by using the motion function block, "LS\_Disconnect", in the motion control program, the operation preparation signals of every axis become Off.
- (4) "Uxx.00.zz" indicate signal. 'U' is U of PLC CPU, 'xx' is installed position of motion control module, 'zz' is Bit of input signal.

### 2. Link up/down information

- (1) Link up/down information is on when network cable is physically connected at motion control module.  
Link up/down information is off when network cable is physically disconnected at motion control module.
- (2) Can check the factor that causes an error by checking whether the network cable is connected.

### 3. RUN/STOP Command, RUN/STOP State

- (1) RUN/STOP command (Uxx.03.0) is a signal which changes the state of the motion control module into RUN or STOP.  
When PLC CPU is RUN, the motion control module is RUN for the relevant signal 0 and STOP for the signal 1.
- (2) RUN/STOP state (Uxx.00.0) is a signal which communicates the current state of motion control module to PLC CPU.  
If motion control module is RUN, this is 0 and if the module is STOP, this is 1.

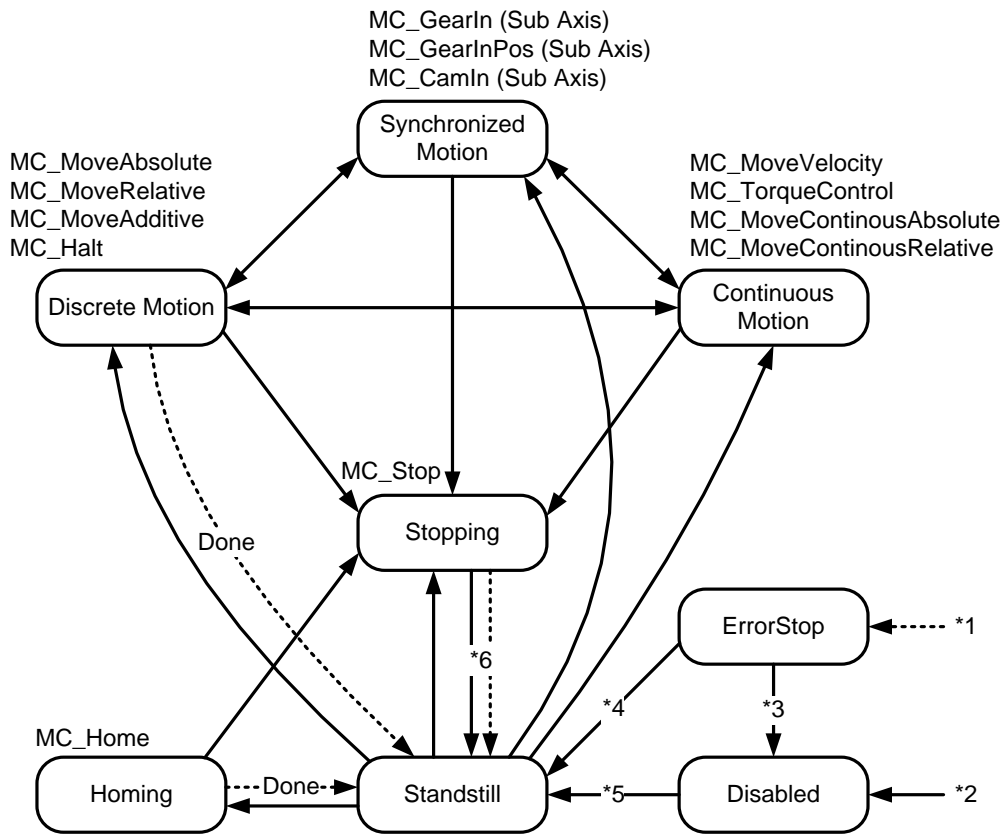
## Chapter 6 Motion Function Block

This chapter describes the basic function block library mentioned in the previous chapter and other application function block library.

### 6.1 Common Elements of Motion Function Blocks

#### 6.1.1 The State of axis

Each axis in the motion control module is changed to the relevant state depending on the situation and command. The changing structure of each situation is shown in the figure below.



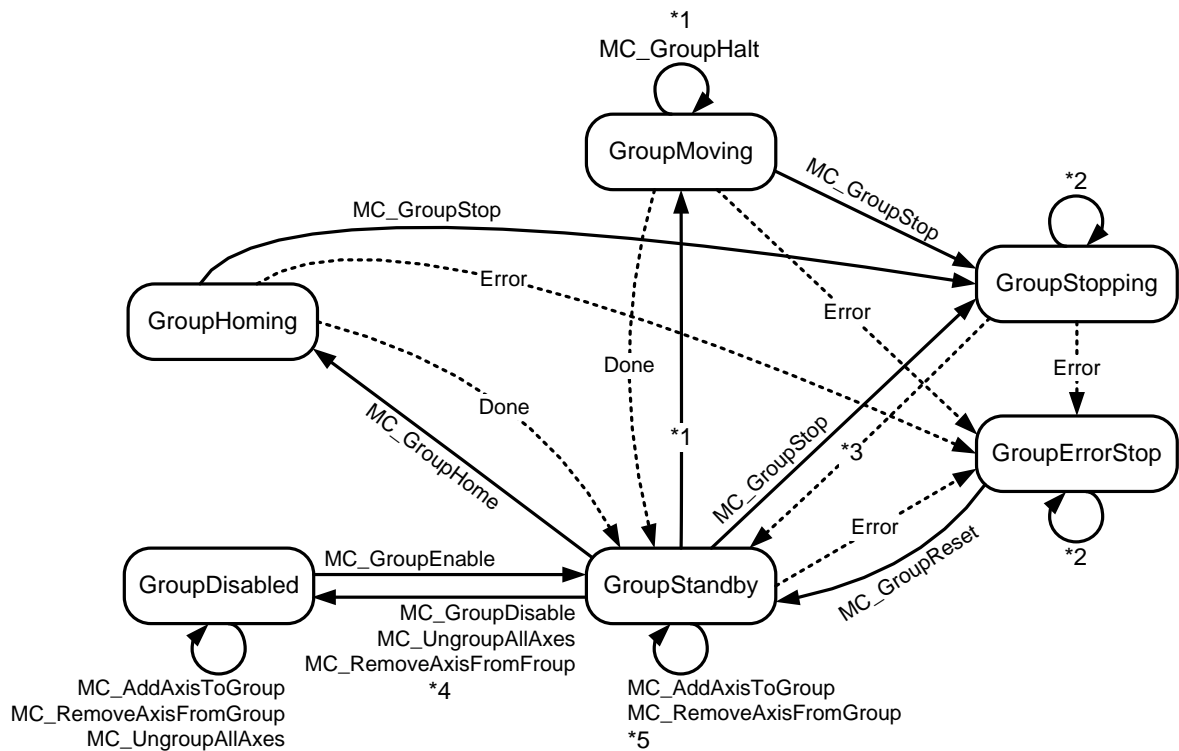
- \*1 ErrorStop: in case axis error occurs regardless of the current state of axis
- \*2 Disabled: in case MC\_Power.Enable input is Off when axis error does not occur
- \*3 ErrorStop → Disabled: in case MC\_Reset command has issued when MC\_Power.Status output is Off
- \*4 ErrorStop → Standstill: in case MC\_Reset command has issued when MC\_Power.Status output is on and MC\_Power.Enable input is On
- \*5 Disabled → Standstill: in case of turning On MC\_Power.Enable input when MC\_Power.Status output is On
- \*6 Stopping → Standstill: in case of turning Off MC\_Stop.Execute input when MC\_Stop.Done output is On



The state of axis	Description
<b>Disabled</b>	Disabled state indicates the state in which no command is given to a single axis, and no error occurs. In case there is no motion control module at the time of first operation, each axis begins in the disabled state. Afterwards, axis status is changed to standstill state in case servo-on status emerges when Enable input of servo On/Off (MC_Power) motion function block is On. The axis becomes disabled state when Enable input of serve On/Off (MC_Power) motion function block is Off in case of not being in ErrorStop state. In case there is motion function block which is currently being performed, the command is interrupted.(The CommandAborted output of the motion block function is On)
<b>ErrorStop</b>	No matter which state the current axis is in, it is changed to ErrorStop state when axis error occurs, and the axis decelerates to stop. In the state where error occurs, ErrorStop state is maintained even though servo On/Off (MC_Power) motion function block is executed. The motion axis which is in ErrorStop state maintains stationary state, and any command except for error reset is not executed.
<b>StandStill</b>	When the power of axis is activated, there is no error in the axis and any command is not made, the axis state indicates StandStill state.
<b>Homing</b>	Homing state indicates the axis is in homing operation.
<b>Stopping</b>	In case emergency stop (MC_Stop) function block is executed, the axis state is changed to stopping state. When the axis is in stopping state, other motion commands cannot be given to the axis until the Stop is completed (until Done output is activated). If Done output is On, and Execute input is On, the state is switched to Standstill status.
<b>Continuous Motion</b>	It indicates state where operation continues until the current axis becomes operation stop status.
<b>Discrete Motion</b>	It indicates reduced operating status with target position.
<b>Synchronized Motion</b>	Synchronized motion indicates axis is in synchronized operation.

6.1.2 The State of Group

Each group in motion control module is changed to the relevant state depending on the situation and command. The changing structure of each state is shown in the figure below.

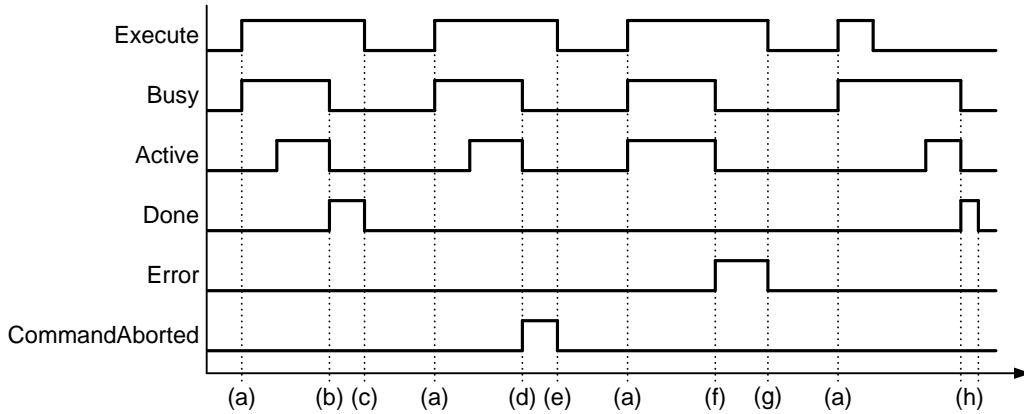


- \*1 GroupMoving: in case of performing the motion function block of general group operation
- \*2 GroupStopping, GroupErrorStop  
: The relevant motion function block is not performed when different motion function block is performed in GroupStopping or GroupErrorStop state, and when MC\_GroupReset function block is performed in GroupErrorStop state, the state of the relevant group is changed to GroupStandby.
- \*3 GroupStopping → GroupStandby  
: when MC\_GroupStop.DONE output is On and MC\_SroupStop.EXECUTE input is Off
- \*4 GroupStandby → GroupDisabled  
: in case there is no axis belonging to the group when performing the axis remove command (MC\_RemoveAxisFromGroup, MC\_UnGroupAllAxes)
- \*5 GroupStandby  
: in case more than one axis belongs to the group when performing the axis add or remove command in group (MC\_AddAxisToGroup, MC\_RemoveAxisFromGroup)
- \*6 GroupDisabled  
: When performing MC\_GroupDisable or MC\_UnGroupAllDisable function block, the relevant group is changed to GroupDisabled state regardless of its current state.

### 6.1.3 Basic I/O Variable

#### 1. Edge operation motion function block

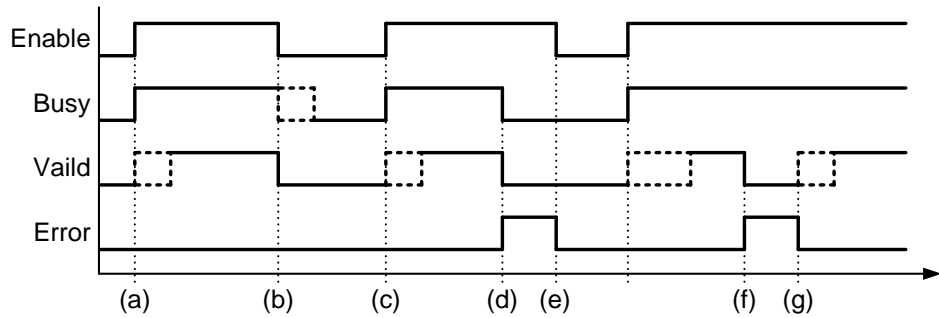
Relationships of the basic I/O parameter in the Edge operation motion function block are as below.



Variable	Description
<b>Execute</b>	This is an input to run the relevant function block in Edge operation function block. Function block is executed in the rising Edge. (Figure a state)
<b>Busy</b>	This is an output to indicate the relevant motion function block is currently running (= not completed), and this indicates the output of motion function block can be changed. Busy output is On in the rising Edge of Execute input (Figure a state), and it is Off when Done output is On (Figure b state), CommandAborted output is On (Figure d state), or Error output is On (Figure f state).
<b>Active</b>	This indicates the relevant motion function block is actually controlling axis. When running many motion function block to one axis (in case only one motion function block is controlling and other motion function blocks are Buffered), Active output is On in only one motion function block which is controlling, and in motion function blocks which are Buffered, Busy output is On.
<b>Done</b>	This is an output to indicate operation of the relevant motion function block has been successfully completed. If Done output is On, Busy and Active output is Off. (Figure d state) Done output is Off when Execute input is Off (Figure e state), if Execute output was Off when Done output became On, it remains On only during 1 scan (Figure h state).
<b>Error</b>	This is an output to indicate an error occurs while running motion function block. Error output is Off when Execute input is Off (Figure f state). If Execute output was Off when Error output became On, it remains On only during 1 scan (Figure h state).
<b>ErrorID</b>	This outputs error code regarding the relevant error when an error occurs while running motion function block. ErrorID output and elimination time are same with Error output.

Variable	Description
<b>CommandAborted</b>	This indicates the relevant motion function block is interrupted by the other motion function block. CommandAborted output is Off when Execute input is Off (Figure g state). If Execute output was Off when Done output became On, it remains On only during one scan.
<p>※ When Execute input is On in Edge operation(Execute input) motion function block, depending on the state of axis, one output in Busy, Done, Error, and CommandAborted output is On. Busy, Done, Error, and CommandAborted output are available to be On one at a time, and if one output in four is On, other three outputs become Off.</p>	

2. Motion function block for level motion



Variable	Description
<b>Enable</b>	This is an input to run function block for level operation motion. This runs motion function block in the rising Edge (Figure a state), and stops it in the falling Edge(Figure b state).
<b>Busy</b>	This is an output to indicate the relevant motion function block is currently running ((= not completed), and it indicates the output of motion function block can be changed. Busy output is On in the rising Edge of Enable input (Figure b state), and it remains on while motion function is in operation.
<b>Valid</b>	This is an output to indicate the relevant motion function block is successfully performed and output & motion are valid. Valid output is Off when Enable input is Off (Figure b state).

Variable	Description
<b>Error</b>	<p>This is an output to indicate an error occurs while running motion function block.</p> <p>If an error which cannot be automatically restored occurs while motion function block is in operation, Error output is On, Busy &amp; Valid output is Off (Figure d state), and motion function block stops operating.</p> <p>Error output is Off when Enable input is Off (Figure e state).</p> <p>If an error which can be automatically restored occurs while function block is in operation, Error output is On and Valid input is Off (Figure f state).</p> <p>When the error in the relevant motion function block is restored, Error output is Off, and operation is resumed (Figure g state).</p>
<b>ErrorID</b>	<p>This outputs error code regarding the relevant error when an error occurs while running motion function block. ErrorID output and elimination time are same with Error output.</p>
<p>※ Valid and Error outputs are not On at the same time.</p>	

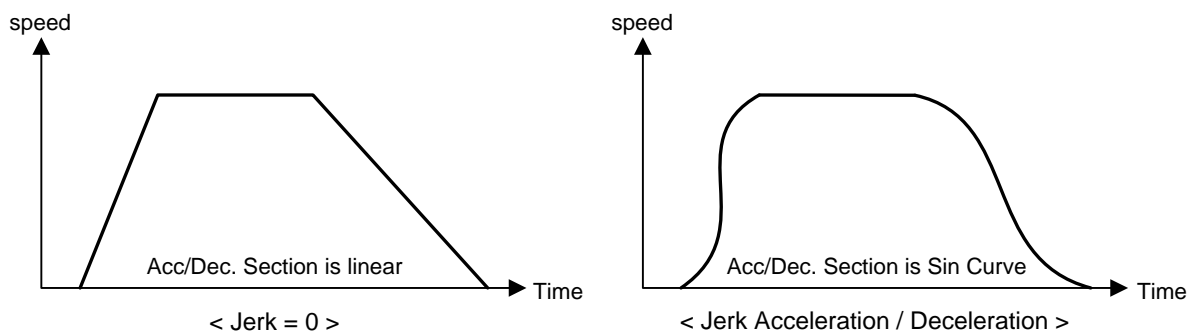
**Note**

1. Axis input

Each motion function block can be specified by Axis input to the axis which is subject to the relevant command. Motion control module can control 1-32 actual axes and 37~40 virtual axes, and 41-41 encoders can be used as main axis depending on motion function block. Therefore, values of 1~32, 37~40, and 41~42 can be input in Axis input depending on motion function block. When it is out of the range which is available to set in each motion function block, "error 0x0006" occurs.

2. Jerk

Jerk sets the rate of acceleration/deceleration. A lower Jerk value results in an acceleration/deceleration close to a flat line. A higher Jerk value results in an acceleration/deceleration close to a sine curve.



### 6.1.4 BufferMode Input

This is an input which can specify whether to wait until the existing command is completed or to cancel the existing motion function block and execute the command in case the axis is already running other motion function block when running motion function block in a certain axis. The number between 0-5 can be specified, and if it is out of the range, "error 0x101A" occurs in the axis command and "error 0x201A" occurs in the axis group command. The values which are available to be set in BufferMode are as below.

Number	Buffer Mode	Explanation
0	mcAborting	Execute the command immediately. The existing command in operation is interrupted.
1	mcBuffered	Execute the command after the existing command in operation is completed.
2	mcBlendingLow	Do combined operation to combine the speeds of the existing command and command issuing to the low speed by comparing.
3	mcBlendingPrevious	Do combined operation to combine the speeds of the existing command.
4	mcBlendingNext	Do combined operation to combine the speeds of the command issuing.
5	mcBlendingHigh	Do combined operation to combine the speeds of the existing command and command giving to the high speed by comparing.

### 6.1.5 Changes in Parameters during Execution of Motion Function Block

The parameter of the relevant command can be changed at the time motion function block is running, and the detailed operations are as below.

- (1) When executing Edge operation motion function block in the Off state of ContinuousUpdate input (turn On the Execute input), the relevant motion function block is operated by application of the parameter at the time when Execute input was On (rising Edge). In this case, the change of the parameter input value in the middle of execution of motion function block does not affect operation.  
When wanting to change the parameter while the relevant motion function block is in operation, change the parameter and turn On Execute input again.
- (2) When executing Edge operation motion function block in the On state of ContinuousUpdate input (turn On the Execute input), the parameter of the time when Execute input was On (rising Edge) is applied at first.  
When changing the parameter while ContinuousUpdate input is On, the relevant motion function block operates reflecting the every change in parameter.  
But, if you change the parameter at the completion or after the stop of the operation of the relevant motion function block (Busy output is Off), the change is not reflected any more. (Parameter changing operation using ContinuousUpdate does not rerun the motion function block which is completed or interrupted, In other words, ContinuousUpdate operation is applied only to the motion function block which is currently running.)
- (3) For a function block without ContinuousUpdate input, the changed parameters can be applied by re-executing the function block (Execute input is On) before the command is completed.
- (4) As for level operation motion function block, it is operated by the application of the parameter at the time when Enable input was On (rising Edge), and continuous change of parameter is available while Enable input is On.

- (5) For MC\_CAMIN function block, only the following inputs can be updated: MasterOffset, SlaveOffset, MasterScaling, SlaveScaling, MasterStartDistance, and MasterSyncPosition(If InSync=On, only MasterOffset, SlaveOffset, MasterScaling, and SlaveScaling are updated.)
- (6) For MC\_GEARIN function block, only the following inputs can be updated: RatioNumerator, RatioDenominator, Acceleration, and Deceleration (If InGear=On, only RatioNumerator and RatioDenominator are updated.)

### 6.1.6 Group Operation Route Change Settings

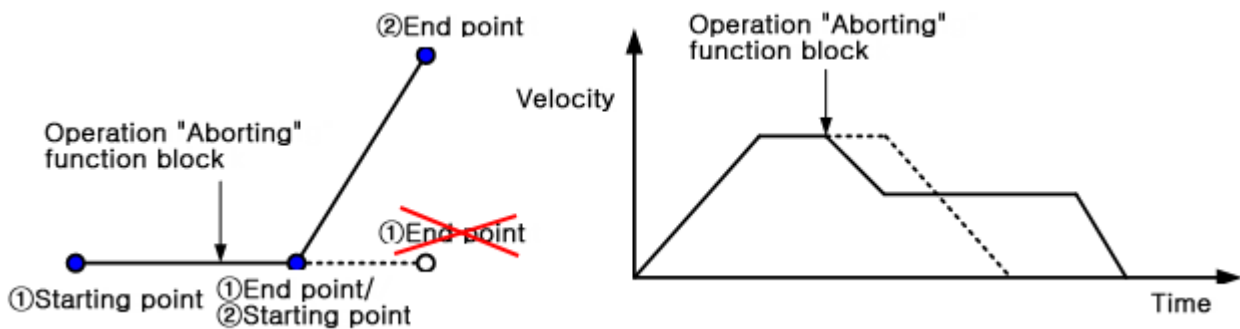
When the axis group of the current motion control module is executing a command, other command can be issued to the relevant axis group. At this point, the path, which the next command will achieve, can specify how the existing command will be connected to the existing path. The parameter of connection track is specified in TransitionParameter input.

Number	TRANSITION Mode	Explanation
0	TMNone	Do not generate a connection track.
3	TMCornerDistance	Generate a connection track which specifies the corner distance of a connection track and draws circular arcs at the specified corner distance.

#### 1. TransitionMode “TMNone”

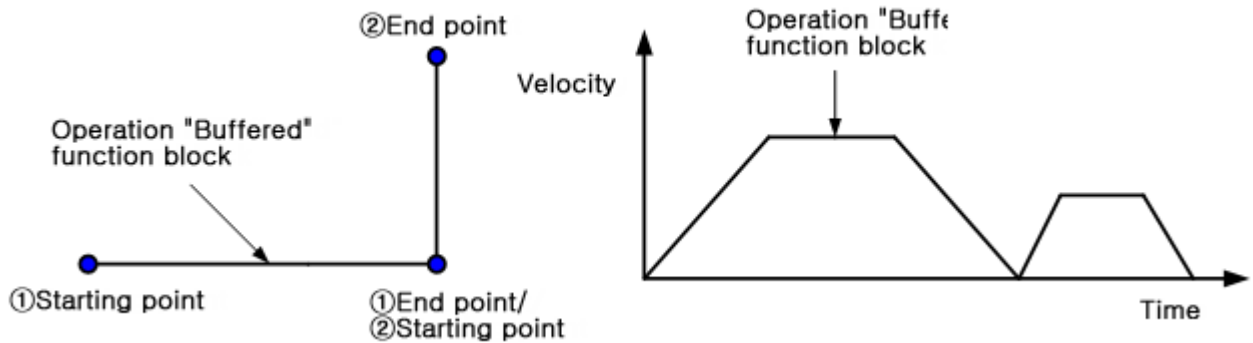
Connection track is not generated. TransitionMode input is available only to “TMNone” in case BufferMode input of motion function block is “Aborting” or “Buffered”.

The Figure below shows the case when running BufferMode of motion function block in the setting of ‘Aborting’. The Figure in the left shows that motion function block ② is executed in the setting of ‘Aborting’ while motion function block ① is running. Motion function block ① is forced to be terminated at ‘end point ① / starting point ②’ without reaching ‘end point ①’. The Figure in the right shows that deceleration pause is performed at the moment of the execution of ‘Aborting’ function block, and the next motion function block is executed.



<In case BufferMode is specified as "Aborting">

The Figure below shows that the case when running BufferMode of motion function block in the setting of 'Buffered'. The Figure in the left shows that motion function block ② is executed in the setting of 'Buffered' while motion function block ① is running. Motion function block ② is executed after motion function block ① has reached target position. The Figure in the right shows that when 'Buffered' function block is executed, the next motion function block is executed after it reaches original target position.



<In case BufferMode is specified as "Buffered">

2. TransitionMode "TMCornerDistance"

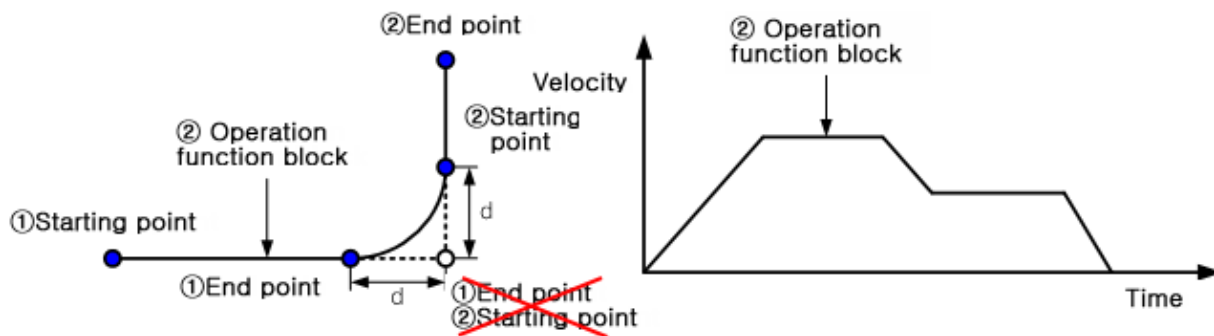
The radius of a connection track is specified and the connection track which draws a circle having specified radius is output. This mode is operated only when BufferMode is "BlendingXXXX", and it is operated in "TMNone" when BufferMode is "Aborting" or "Buffered".

When drawing a connection track, the maximum speed of the path complies with the specified speed in BufferMode, and the length of radius complies with the value specified in TransitionParameter.

The Figure below shows the generation of a connection track which draws radius circle in two linear interpolation commands. The Figure in the left shows that motion function block ② is executed in the setting of "TMcornerDistance" while motion function block ① is running. The original target position of motion function block ① was end point ① / starting point ②, but straight-line motion is stopped and circular motion is started at the point ahead as far as radius 'd' (end point ①). Circular operation starts at end point ① and finishes at starting point ②, and executes motion function block ②.

The Figure in the right shows that the speed does not stop in the middle of two function blocks and continues.





<In case BufferMode is specified as "BlendingLow" and TransitionMode is specified as "TMCornerDistance">

### 6.1.7 Motion Function Block Errors

Errors occurring in ErrorID variable of motion function block are as follows.

STAT	Content	Detailed Description
0x0000	Normal	In case motion function block is normally executed, "O" is displayed on ErrorID.
0x0005	The current motion module does not support the motion function block.	The motion function block is not executed in the version of current module. Check the version in which the motion function block can be executed.
0x0006	Axis number of motion function block (Axis input) exceeded allowable range.	Check the axis that can implement allocation by motion function block, and set axis number to the areas of 1~32 and 37~40.
0x0007	Axis group number of motion function block (AxisGroup input) exceeded allowable range.	Set axis group number to a value between 1 and 16.
0x0012	Internal execution error of motion function block occurred during the execution of the motion function block.	Check the version of XG-PM and XGF-M32E.
0x0013	Motion response error occurred during the execution of motion function block.	Check the version of XG-PM and XGF-M32E.
0x0020 : 0x0FFF	It indicates a common error of the motion control module. For more details, refer to 'error information and measures in APPENDIX 1'.	
0x1000 : 0x1FFF	It indicates error that occurs in relation to axis control of motion control module. For more details, refer to 'error information and measures in APPENDIX 1'.	
0x2000 : 0x2FFF	It indicates error that occurs in relation to axis control of motion control module. For more details, refer to 'error information and measures in APPENDIX 1'.	

## 6.2 Motion Function Block

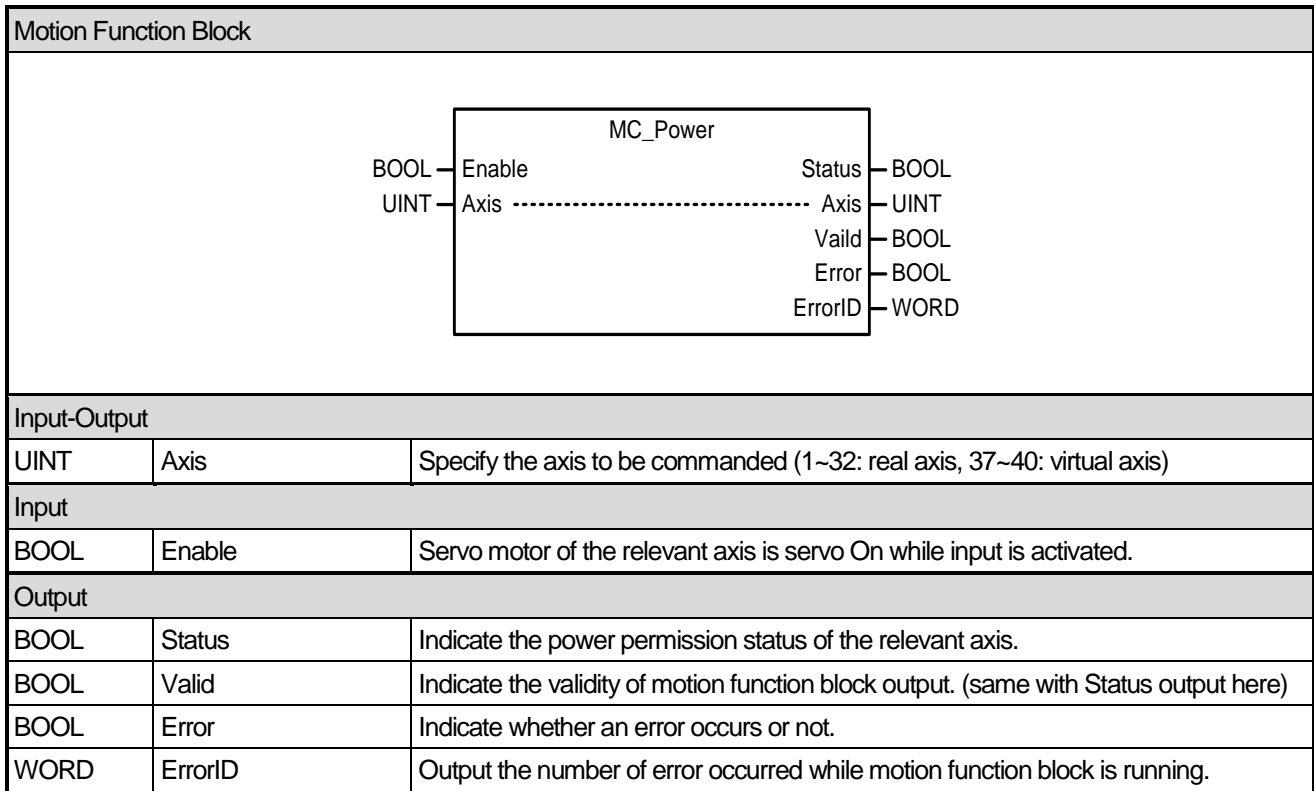
No.	Name	Discription	Command Condition
<b>Single-axis Motion Command</b>			
1	MC_Power	Servo On/Off	Level
2	MC_Home	Perform the search home	Edge
3	MC_Stop	Stop immediately	Edge
4	MC_Halt	Stop	Edge
5	MC_MoveAbsolute	Absolute positioning operation	Edge
6	MC_MoveRelative	Relative positioning operation	Edge
7	MC_MoveAdditive	Additive positioning operation	Edge
8	MC_MoveVelocity	Specified velocity operation	Edge
9	MC_MoveContinuousAbsolute	A specified absolute position ending with the specified velocity	Edge
10	MC_MoveContinuousRelative	A specified relative distance ending with the specified velocity	Edge
11	MC_TorqueControl	Torque control operation	Edge
12	MC_SetPosition	Setting the current position	Edge
13	MC_SetOverride	Velocity/Acceleration override	Level
14	MC_ReadParameter	Reads parameter	Level
15	MC_WriteParameter	Writes parameter	Edge
16	MC_Reset	Reset axis error	Edge
17	MC_TouchProbe	Touch probe function	Edge
18	MC_AbortTrigger	Abort trigger events	Edge
19	MC_MoveSuperImposed	SuperImposed operation	Edge
20	MC_HaltSuperImposed	Halt SuperImposed	Edge
<b>Multi-axis Command</b>			
21	MC_CamIn	Camming run	Edge
22	MC_CamOut	Camming stop	Edge
23	MC_GearIn	Electrical gearing run	Edge
24	MC_GearOut	Electrical gearing disengage	Edge
25	MC_GearInPos	Electrical gearing by specifying the position	Edge
26	MC_Phasing	Phase compensation	Edge
27	MC_GearInEx	Electrical gearing run	Edge
28	MC_GearInPosEx	Electrical gearing by specifying the position	Edge
<b>Group Command</b>			
29	MC_AddAxisToGroup	Adds one axis to a group in a structure AxesGroup	Edge

No.	Name	Discription	Command Condition
30	MC_RemoveAxisFromGroup	Removes one axis from the group AxesGroup	Edge
31	MC_UngroupAllAxes	Removes all axes from the group AxesGroup	Edge
32	MC_GroupEnable	Changes the state for a group from GroupDisabled to GroupStandby	Edge
33	MC_GroupDisable	Changes the state for a group to GroupDisabled	Edge
34	MC_GroupHome	The AxesGroup to perform the search home sequence	Edge
35	MC_GroupSetPosition	Sets the Position of all axes in a group without moving the axes	Edge
36	MC_GroupStop	Stops a Group immediately	Edge
37	MC_GroupHalt	Stops a Group	Edge
38	MC_GroupReset	Resets a group error	Edge
39	MC_MoveLinearAbsolute	Absolute positioning linear interpolation operation	Edge
40	MC_MoveLinearRelative	Relative positioning linear interpolation operation	Edge
41	MC_MoveCircularAbsolute	Absolute positioning circular interpolation operation	Edge
42	MC_MoveCircularRelative	Relative positioning circular interpolation operation	Edge
<b>LS Command</b>			
43	LS_Connect	Connect servo drives	Edge
44	LS_Disconnect	Disconnect servo drives	Edge
45	LS_ReadServoParameter	Read servo parameters	Edge
46	LS_WriteServoParameter	Write servo parameters	Edge
47	LS_SaveServoParameter	Save Servo Parameters	Edge
48	LS_EncoderPreset	Encoder preset	Edge
49	LS_Jog	JOG operation	Level
50	LS_ReadCamData	Read Cam Data	Edge
51	LS_ReadCamData2	Read Cam Data2	Edge
52	LS_WriteCamData	Write Cam Data	Edge
53	LS_ReadEsc	Write ESC	Edge
54	LS_WriteEsc	Read ESC	Edge
55	LS_CamSkip	Cam Skip	Edge
56	LS_VarCamIn	Variable Cam operation	Edge
57	LS_VarGearIn	Variable gear operation	Edge
58	LS_VarGearInPos	Variable positioning gear operation	Edge
59	LS_ReadCamTableSlavePos	Read the slave location of the CAM table	Edge
60	LS_SyncMoveVelocity	Speed control operation (CSV mode)	Edge
61	LS_ReadCamTableMasterPos	Read the master location of the CAM table	Edge
62	LS_OnOffCam	OnOffCam operation	Edge
63	LS_OnOffCamEx	OnOffCam operation	Edge
64	LS_RotaryKnifeCamGen	Generate rotaryknife cam profile	Edge

No.	Name	Discription	Command Condition
65	LS_CrossSealCamGen	Generate crossseal cam profile	Edge
66	LS_VarGearInEx	Variable gearing run	Edge
67	LS_VarGearInPosEx	Variable positioning gear operation	Edge
<b>Coordinate system Dedicated Command</b>			
68	MC_SetKinTransform	Machine information setting	Edge
69	MC_SetCartesianTransform	PCS setting	Edge
70	LS_SetWorkSpaceTransform	Work space setting	Edge
71	LS_MoveLinearTimeAbsolute	Coordinate system absolute position time linear interpolation operation	Edge
72	LS_MoveLinearTimeRelative	Coordinate system relative position time linear interpolation operation	Edge
73	LS_MoveLinearAbsolute	Coordinate System absolute position linear interpolation operation	Edge
74	LS_MoveLinearRelative	Coordinate System relative position linear interpolation operation	Edge
75	MC_MoveCircularAbsolute2D	Coordinate absolute positioning 2D circular interpolation operation	Edge
76	MC_MoveCircularRelative2D	Coordinate relative positioning 2D circular interpolation operation	Edge
77	MC_TrackConveyorBelt	Synchronization setting of the conveyor belt	Edge
78	MC_TrackRotaryTable	Synchronization setting of the rotary table	Edge
79	LS_RobotJog	JOG operation of the coordinate system	Level
<b>Status Read Command</b>			
80	MC_ReadActualPosition	Read actual position	Level
81	MC_ReadActualTorque	Read actual torque	Level
82	MC_ReadActualVelocity	Read actual velocity	Level
83	MC_ReadCommandedPosition	Read commanded position	Level
84	MC_ReadCommandedTorque	Read commanded torque	Level
85	MC_ReadCommandedVelocity	Read commanded velocity	Level
86	MC_ReadMotionInfo	Read motion Information	Level
<b>Other function block</b>			
87	PID	PID operation	Level
88	LINAC	Linear Accleration Command	Level
89	SLINAC	S-Curve Linear Accleration Command	Level

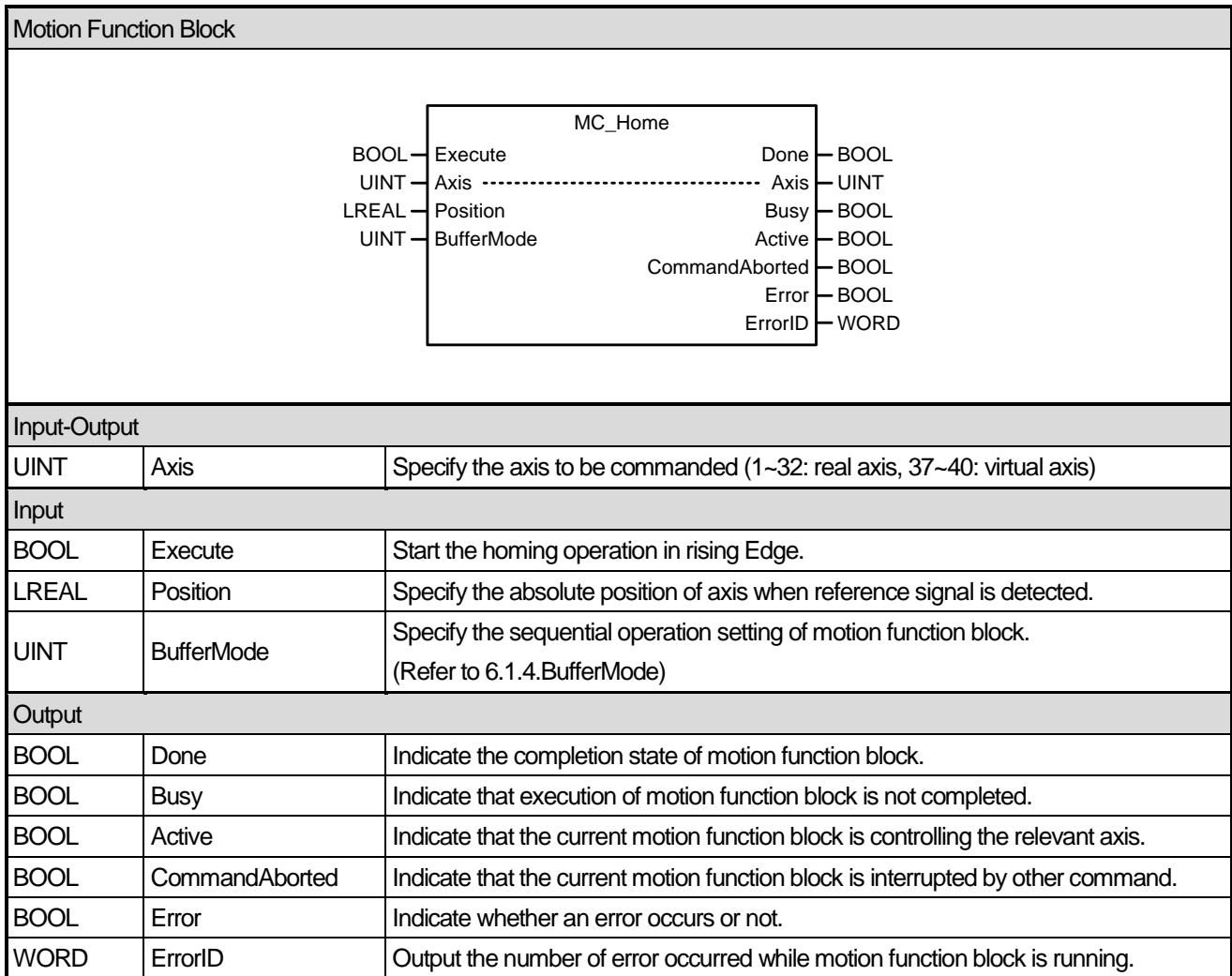
### 6.3 Single-Axis Motion Function Block

#### 6.3.1 Servo on/off (MC\_Power)



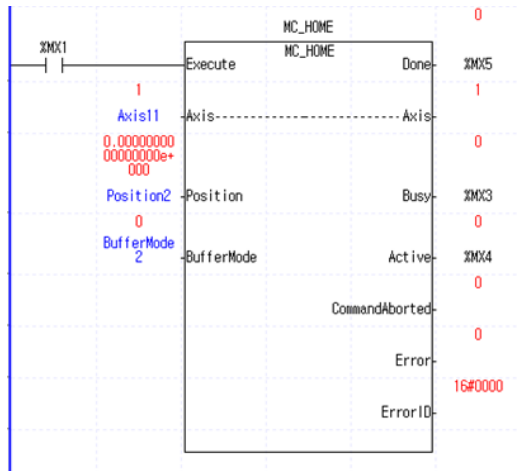
- (1) This motion function block is to give servo On/Off command to the relevant axis.
- (2) When Enable input is On, Servo On command is given to the relevant axis, and when it is Off, servo Off command is given.
- (3) If servo On command is executed when the axis is in 'Disable' state, the axis state is 'StandStill', and failure in servo On brings 'ErrorStop' state.

6.3.2 Perform the search home(MC\_Home)



- (1) This motion function block is to give a homing command to the relevant axis.
- (2) Homing method is operated as specified in the operation parameter of the relevant axis in advance.
- (3) As for Position input, absolute position of axis is specified when Reference Signal is detected or homing is completed.
- (4) While this motion function block is running, the axis is 'Homing' state, and when the command is completed, it is switched to 'Standstill'.
- (5) The changed parameters can be applied by re-executing the function block (Execute input is On) before the command is completed. Only Position input can be updated.
- (6) Example program  
This example shows execution of MC\_HOME command when the current command position is 100,000.

(a) Function block setting

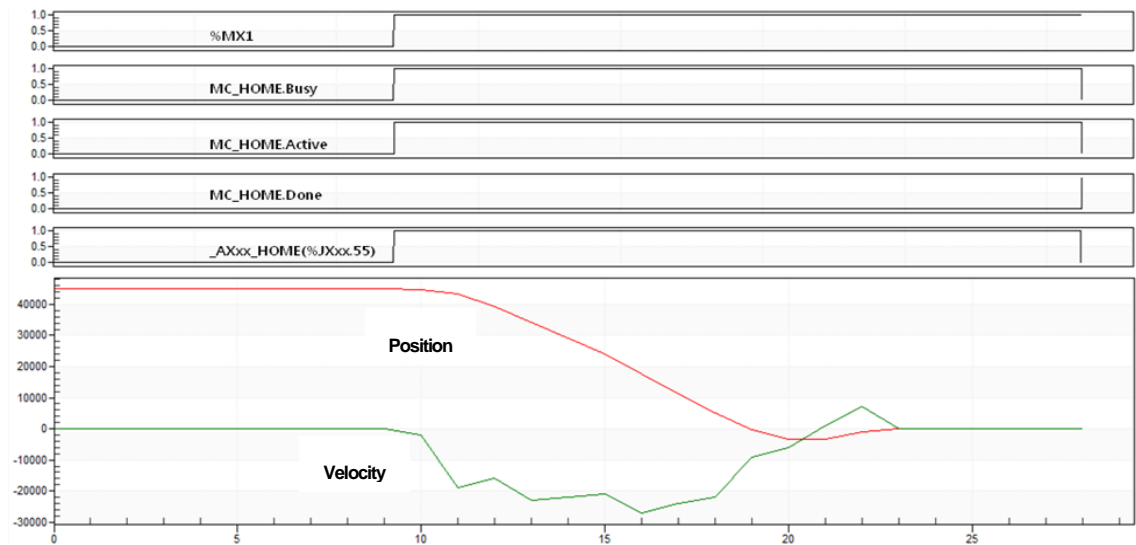


(b) Parameter setting

- Set the Homing method in SDO parameters to 33.

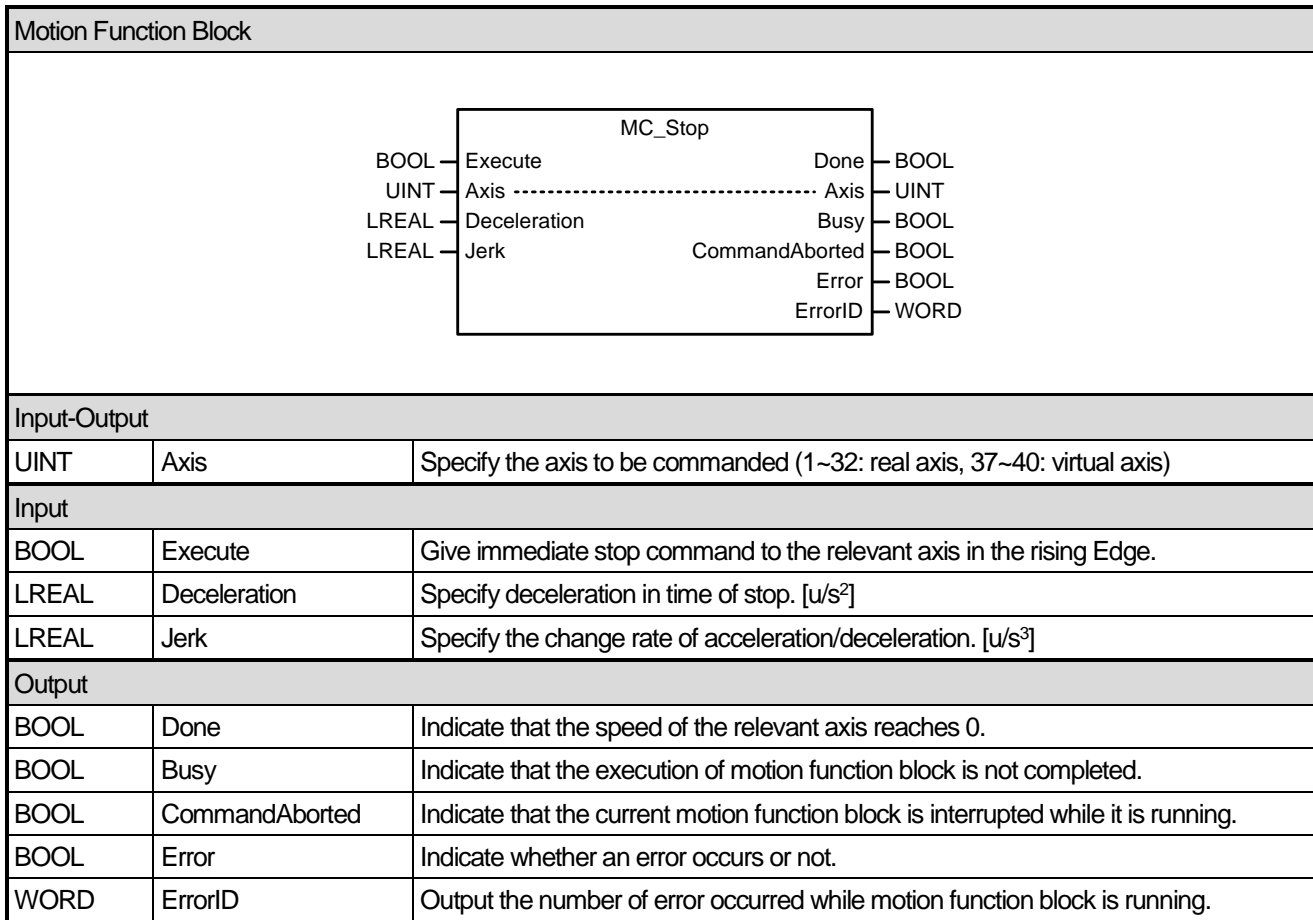
Index	Name	Unit	Current Value	Initial Value	Access
607A	Target Position	UU	0	0	rw
607C	Home Offset	UU	0	0	rw
607D:00	Software Position Limit	-	2	2	rw
607F	Maximum Profile Velocity	UU/s	2147483647	2147483647	rw
6080	Maximum Motor Speed	rpm	0	0	ro
6081	Profile Velocity	UU/s	200000	200000	rw
6083	Profile Acceleration	UU/s <sup>2</sup>	200000	200000	rw
6084	Profile Deceleration	UU/s <sup>2</sup>	200000	200000	rw
6085	Quick Stop Deceleration	UU/s <sup>2</sup>	2000	2000	rw
6087	Torque Slope	0.1%/s	1000	1000	rw
6091:00	Gear Ratio	-	2	2	rw
6098	Homing Method	-	33	34	rw
6099:00	Homing Speeds	-	2	2	rw
609A	Homing Acceleration	UU/s <sup>2</sup>	200000	200000	rw
60B0	Position Offset	UU	0	0	rw
60B1	Velocity Offset	UU/s	0	0	rw
60B2	Torque Offset	0.1%	0	0	rw

(c) Timing diagram



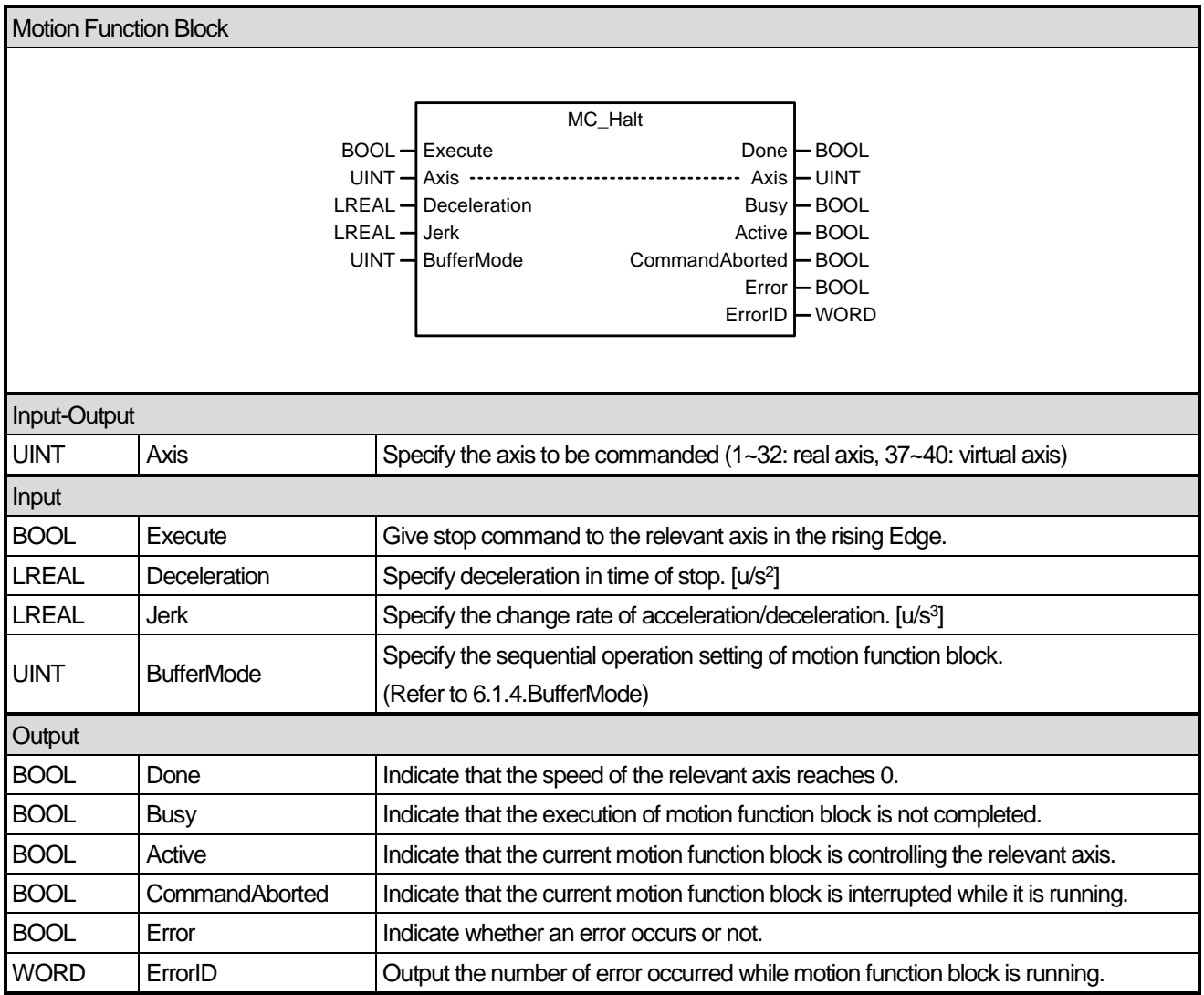


## 6.3.3 Stop immediately(MC\_STOP)



- (1) This motion function block is to give an emergency stop command to the relevant axis.
- (2) When executing immediate stop (MC\_Stop) motion function block, the existing motion function block being executed in the relevant axis is stopped, and the axis state changed to 'Stopping'. When the relevant axis is in 'Stopping' state, other motion function block cannot be executed in the relevant axis until the stopping is completed (until the Done output is activated).
- (3) CommandAborted output indicates that the current motion function block is interrupted while it is running. Other motion function block cannot interrupt immediate stop (MC\_Stop) motion function block while immediate stop (MC\_Stop) motion function block is running, therefore, CommandAborted output is On in general when the power of servo is blocked or servo Off command is executed.
- (4) If Execute input is On or the speed of axis is not 0, the axis is in 'Stopping' state, and when Done output is On and Execute input is Off, it is switched to 'Standstill' state.
- (5) The changed parameters can be applied by re-executing the function block (Execute input is On) before the command is completed. Only Deceleration and Jerk input can be updated

6.3.4 Stop(MC\_Halt)



- (1) This motion function block is to give a stop command to the relevant axis.
- (2) The axis is 'DiscreteMotion' state while this motion function block is running, and when the speed of the relevant axis is 0, 'Done' output is On and changed to 'Standstill' state.
- (3) BufferMode can be selected, unlike MC\_Stop command. Halt command (MC\_Halt) can be stopped by another motion function block.
- (4) The changed parameters can be applied by re-executing the function block (Execute input is On) before the command is completed.

### 6.3.5 Absolute positioning operation (MC\_MoveAbsolute)

Motion Function Block																																										
<div style="border: 1px solid black; padding: 10px; width: fit-content; margin: 0 auto;"> <p style="text-align: center; margin: 0;">MC_MoveAbsolute</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%;">BOOL</td> <td style="width: 40%;">Execute</td> <td style="width: 30%;">Done</td> <td style="width: 10%;">BOOL</td> </tr> <tr> <td>UINT</td> <td>Axis</td> <td>Axis</td> <td>UINT</td> </tr> <tr> <td>BOOL</td> <td>ContinuousUpdate</td> <td>Busy</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Position</td> <td>Active</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Velocity</td> <td>CommandAborted</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Acceleration</td> <td>Error</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Deceleration</td> <td>ErrorID</td> <td>WORD</td> </tr> <tr> <td>LREAL</td> <td>Jerk</td> <td></td> <td></td> </tr> <tr> <td>UINT</td> <td>Direction</td> <td></td> <td></td> </tr> <tr> <td>UINT</td> <td>BufferMode</td> <td></td> <td></td> </tr> </table> </div>			BOOL	Execute	Done	BOOL	UINT	Axis	Axis	UINT	BOOL	ContinuousUpdate	Busy	BOOL	LREAL	Position	Active	BOOL	LREAL	Velocity	CommandAborted	BOOL	LREAL	Acceleration	Error	BOOL	LREAL	Deceleration	ErrorID	WORD	LREAL	Jerk			UINT	Direction			UINT	BufferMode		
BOOL	Execute	Done	BOOL																																							
UINT	Axis	Axis	UINT																																							
BOOL	ContinuousUpdate	Busy	BOOL																																							
LREAL	Position	Active	BOOL																																							
LREAL	Velocity	CommandAborted	BOOL																																							
LREAL	Acceleration	Error	BOOL																																							
LREAL	Deceleration	ErrorID	WORD																																							
LREAL	Jerk																																									
UINT	Direction																																									
UINT	BufferMode																																									
Input-Output																																										
UINT	Axis	Specify the axis to be commanded (1~32: real axis, 37~40: virtual axis)																																								
Input																																										
BOOL	Execute	Give an absolute position operation command to the relevant axis in the rising Edge.																																								
BOOL	ContinuousUpdate	Specify the update setting of input value. (Refer to 6.1.5.Changes in Parameters during Execution of Motion Function Block)																																								
LREAL	Position	Specify the target position.																																								
LREAL	Velocity	Specify the maximum speed. [u/s]																																								
LREAL	Acceleration	Specify the acceleration. [u/s <sup>2</sup> ]																																								
LREAL	Deceleration	Specify the deceleration. [u/s <sup>2</sup> ]																																								
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]																																								
UINT	Direction	Specify the operation direction. (0~4: 0-Not specified, 1-Forward direction, 2-Shortest distance, 3-Reverse direction, 4-Current direction)																																								
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)																																								
Output																																										
BOOL	Done	Indicate whether to reach the specified distance.																																								
BOOL	Busy	Indicate that the execution of motion function block is not completed.																																								
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.																																								
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.																																								
BOOL	Error	Indicate whether an error occurs or not.																																								
WORD	ErrorID	Output the number of error occurred while motion function block is running.																																								

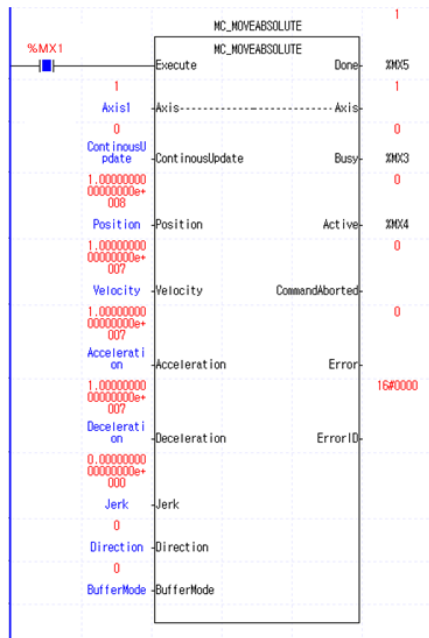
- (1) This motion function block is to give the relevant absolute position operation commands.
- (2) Operation direction of the axis in Infinite length repetition operation is set in Direction input, and if Infinite length repetition operation is set to Prohibited, Direction input is ignored. When Direction input is the shortest distance(=2), the relevant axis doing Infinite length repetition operation automatically selects the direction which allows the

shortest distance. The available range is 0-4 (0-Not specified, 1-Forward direction, 2-Shortest distance, 3-Reverse direction, 4-Current direction), and "error 0x1017" occurs in case of excess of the range.

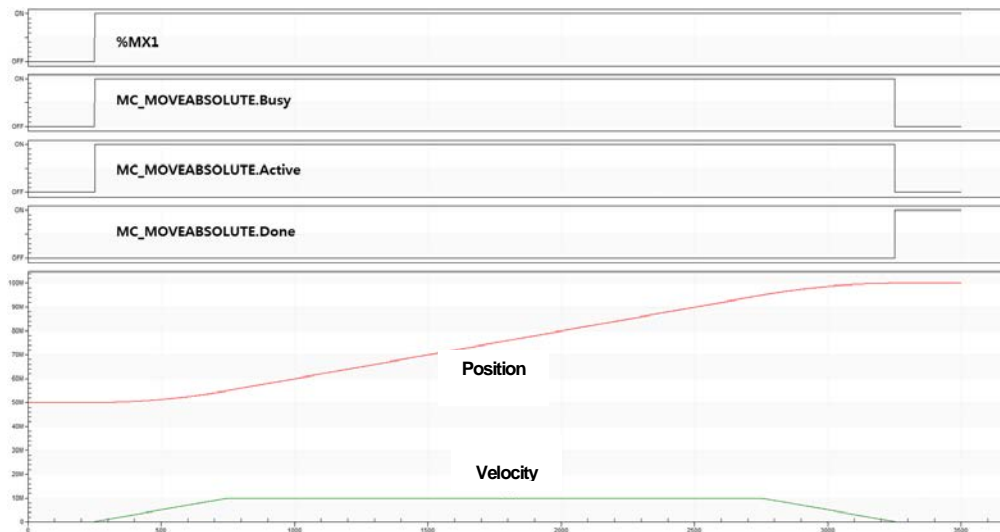
- (3) On condition that there is no motion function block is on standby after the current motion function block, If the speed is 0 after reaching the target point, operation is completed and Done output is On.
- (4) The axis is in 'DiscreteMotion' state while this motion function block is running, and it is switched to 'Standstill' state when operation is completed.
- (5) The changed parameters can be applied by re-executing the function block (Execute input is On) before the command is completed. Only Position, Velocity, Acceleration, Deceleration, Jerk, Direction input can be updated.
- (6) Example program

This example shows the movement from the current command position of 50,000,000 to the 100,000,000 position.

(a) Function block setting



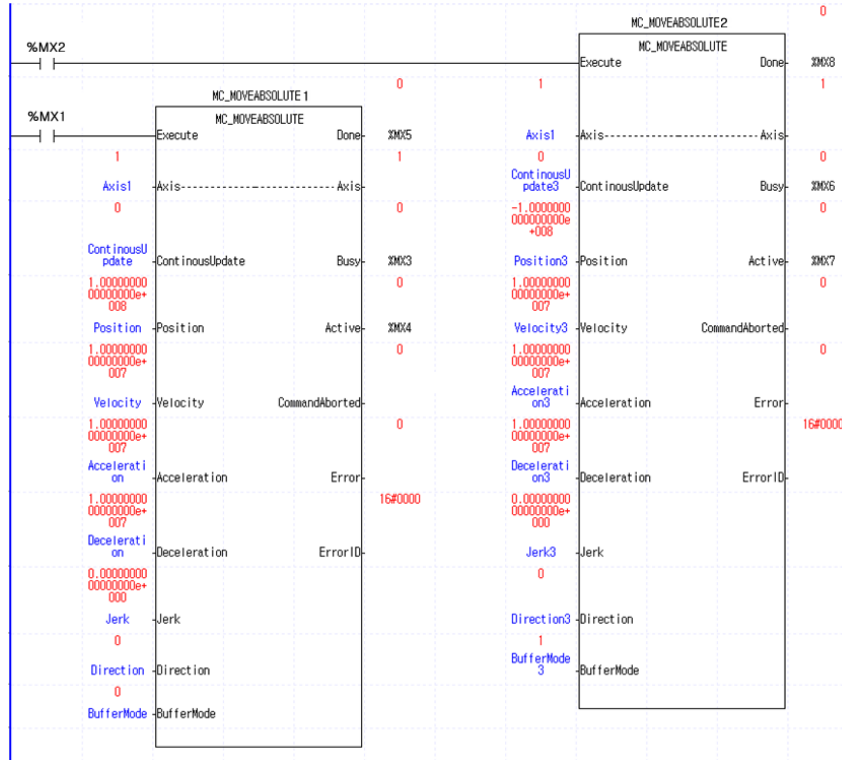
(b) Timing diagram



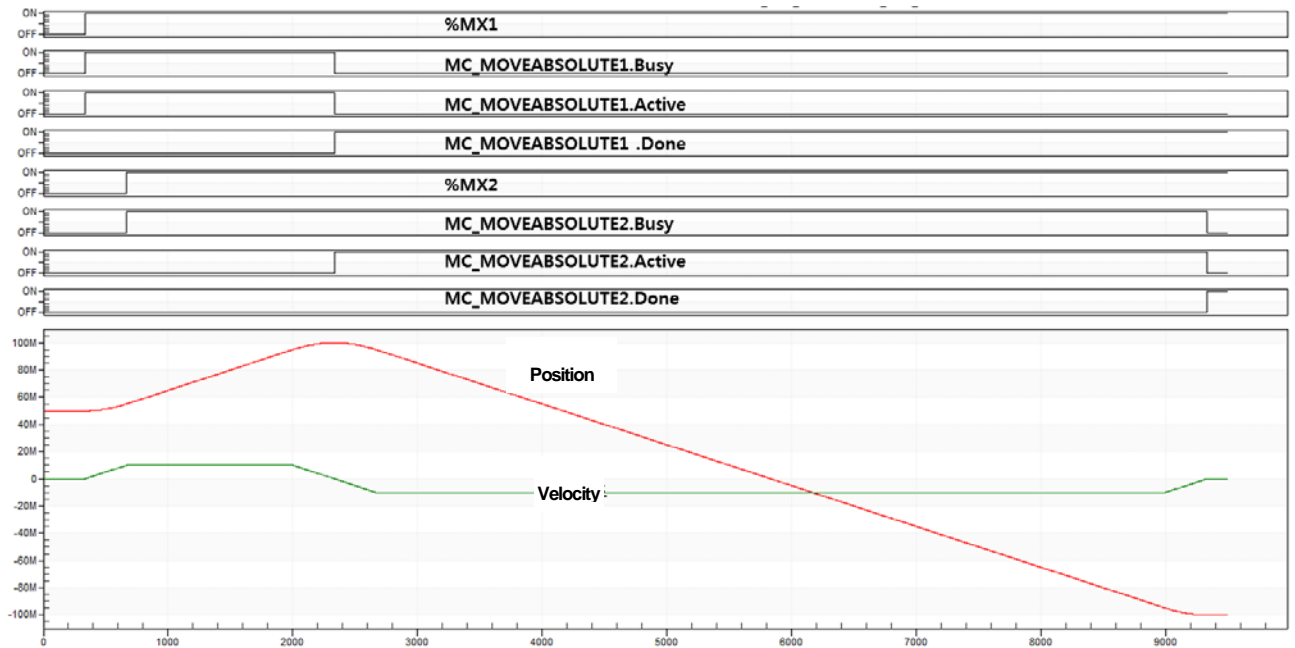
(7) Application example program

This example shows the execution of another function block with BufferMode set to 1 while moving from the current command position of 50,000,000 to the 100,000,000 position, to move to the -100,000,000 position

(a) Function block setting



(b) Timing diagram



6.3.6 Relative positioning operation(MC\_MoveRelative)

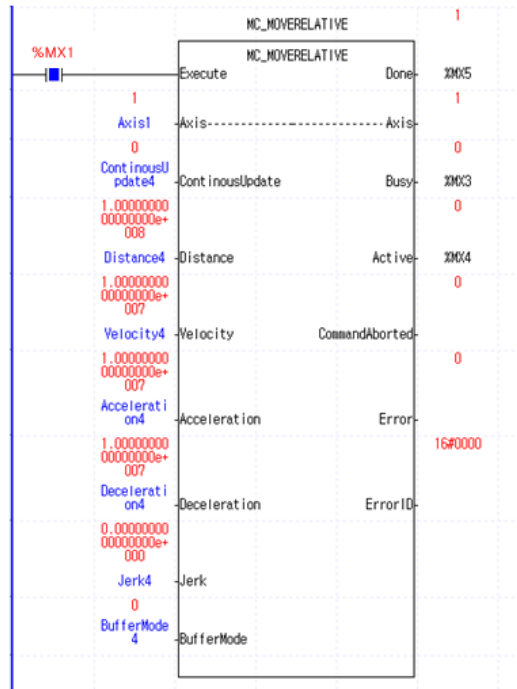
Motion Function Block		
<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="border: 1px solid black; padding: 5px;"> <p style="text-align: center; margin: 0;">MC_MoveRelative</p> <p>BOOL Execute Done BOOL</p> <p>UINT Axis ..... Axis UINT</p> <p>BOOL ContinuousUpdate Busy BOOL</p> <p>LREAL Distance Active BOOL</p> <p>LREAL Velocity CommandAborted BOOL</p> <p>LREAL Acceleration Error BOOL</p> <p>LREAL Deceleration ErrorID WORD</p> <p>LREAL Jerk</p> <p>UINT BufferMode</p> </div> </div>		
Input-Output		
UINT	Axis	Specify the axis to be commanded (1~32: real axis, 37~40: virtual axis)
Input		
BOOL	Execute	Give an absolute position operation command to the relevant axis in the rising Edge.
BOOL	ContinuousUpdate	Specify the update setting of input value. (Refer to 6.1.5.Changes in Parameters during Execution of Motion Function Block)
LREAL	Distance	Specify the target distance.
LREAL	Velocity	Specify the maximum speed. [u/s]
LREAL	Acceleration	Specify the acceleration. [u/s <sup>2</sup> ]
LREAL	Deceleration	Specify the deceleration. [u/s <sup>2</sup> ]
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)
Output		
BOOL	Done	Indicate whether to reach the specified distance.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block is to give relative position operation command to the relevant axis.
- (2) Relative position motion (MC\_MoveRelative) is the motion function block which moves as far as the target distance specified in Distance input from the current position.
- (3) Moving direction is decided depending on the sign of the target distance specified in Distance input, and positive (+ or No sign) moving direction leads to the forward direction, and negative (-) moving direction leads to the reverse direction.
- (4) If there is no motion function block is on standby after the current motion function block and the speed is 0 after moving to the target distance, operation is completed and Done output is On.

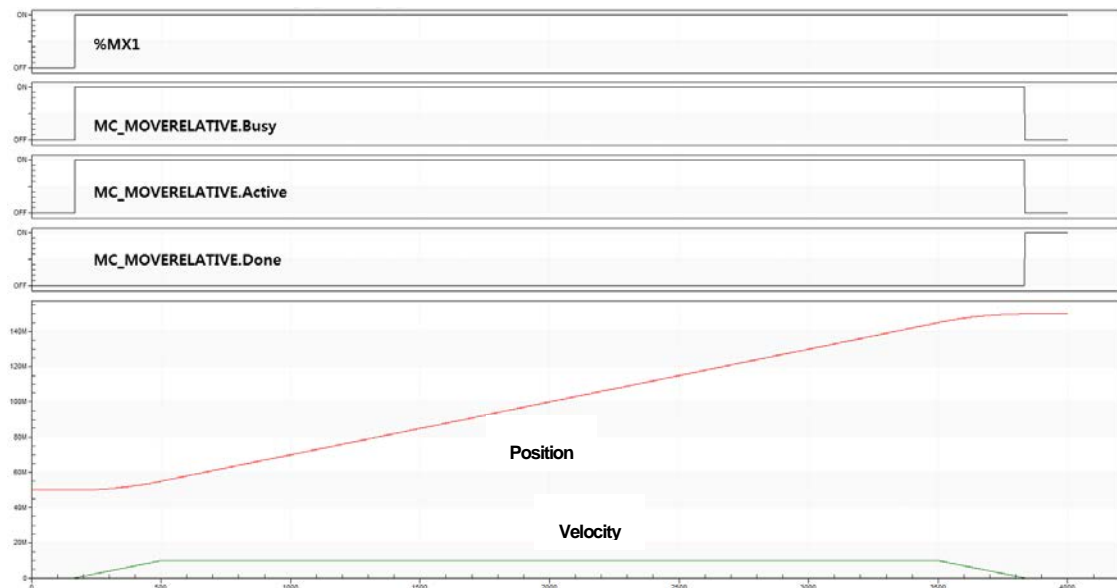
- (5) The axis is in "DiscreteMotion" state when this motion function block is running, and it is switched to "StandStill" state when operation is completed.
- (6) The changed parameters can be applied by re-executing the function block (Execute input is On) before the command is completed. Only Distance, Velocity, Acceleration, Deceleration, Jerk input can be updated.
- (7) Example program

This example shows the movement from the current command position of 50,000,000 to the 150,000,000 position by moving the distance corresponding to the set value (100,000,000).

(a) Function block setting



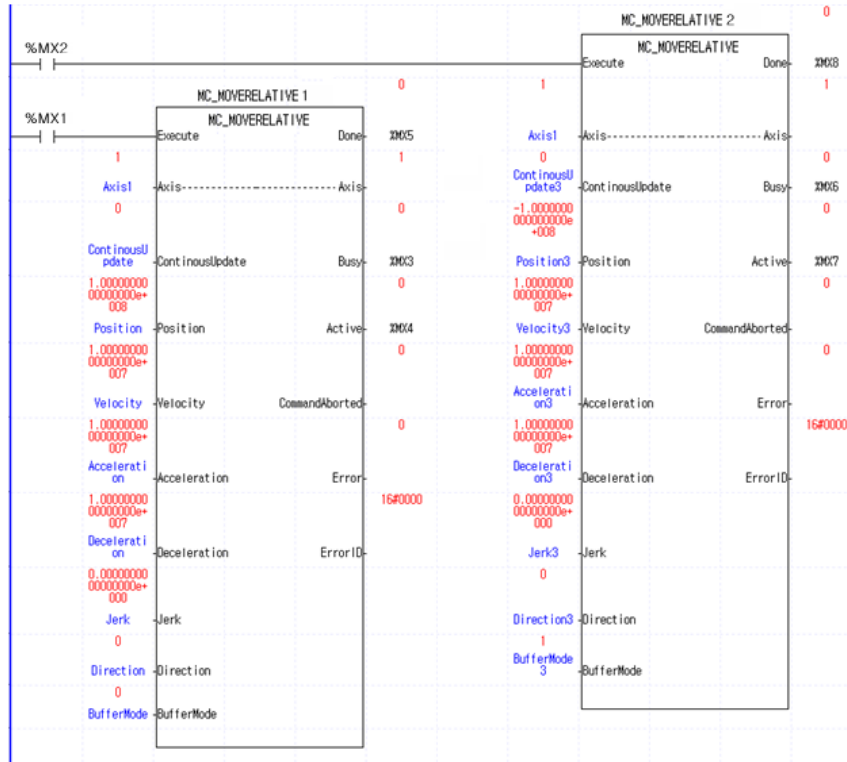
(b) Timing diagram



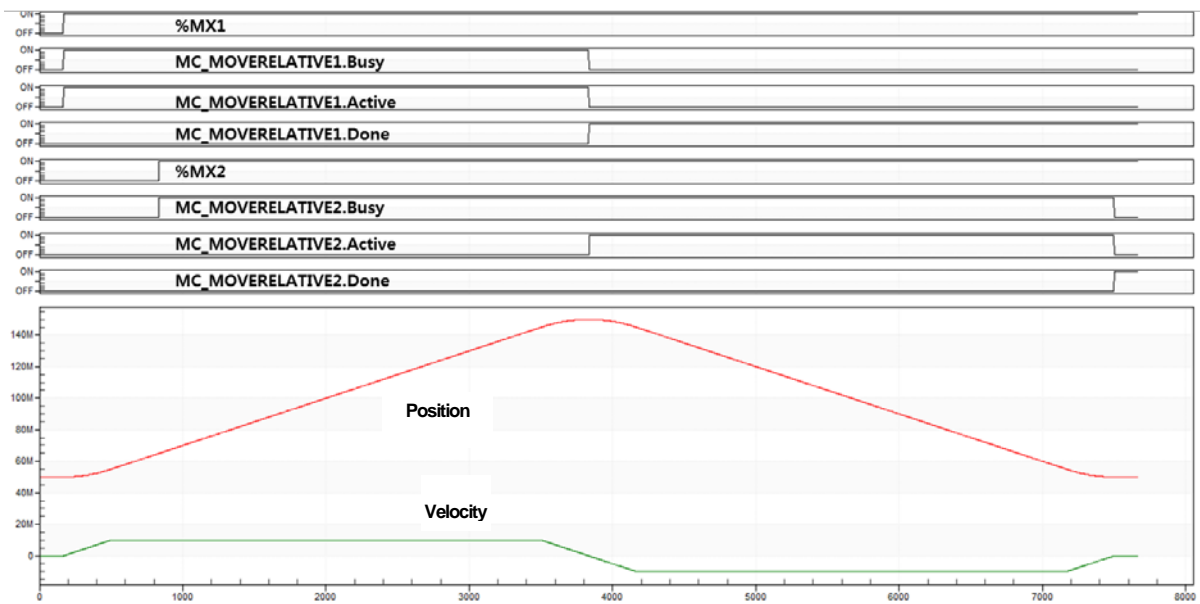
(8) Application example program

This example shows the execution of another function block with BufferMode set to 1 while moving from the current command position of 50,000,000 to the 150,000,000 position, to move to the 50,000,000 position.

(a) Function block setting



(b) Timing diagram





6.3.7 Additive positioning operation(MC\_MoveAdditive)

Motion Function Block																																						
<div style="border: 1px solid black; padding: 10px; margin: 0 auto; width: fit-content;"> <p style="text-align: center; margin: 0;">MC_MoveAdditive</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%; border-right: 1px solid black; padding: 2px;">BOOL</td> <td style="padding: 2px;">Execute</td> <td style="width: 30%; padding: 2px;">Done</td> <td style="width: 30%; border-left: 1px solid black; padding: 2px;">BOOL</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">UINT</td> <td style="padding: 2px;">Axis ----- Axis</td> <td style="padding: 2px;"></td> <td style="border-left: 1px solid black; padding: 2px;">UINT</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">BOOL</td> <td style="padding: 2px;">ContinuousUpdate</td> <td style="padding: 2px;">Busy</td> <td style="border-left: 1px solid black; padding: 2px;">BOOL</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">LREAL</td> <td style="padding: 2px;">Distance</td> <td style="padding: 2px;">Active</td> <td style="border-left: 1px solid black; padding: 2px;">BOOL</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">LREAL</td> <td style="padding: 2px;">Velocity</td> <td style="padding: 2px;">CommandAborted</td> <td style="border-left: 1px solid black; padding: 2px;">BOOL</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">LREAL</td> <td style="padding: 2px;">Acceleration</td> <td style="padding: 2px;">Error</td> <td style="border-left: 1px solid black; padding: 2px;">BOOL</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">LREAL</td> <td style="padding: 2px;">Deceleration</td> <td style="padding: 2px;">ErrorID</td> <td style="border-left: 1px solid black; padding: 2px;">WORD</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">LREAL</td> <td style="padding: 2px;">Jerk</td> <td style="padding: 2px;"></td> <td style="border-left: 1px solid black; padding: 2px;"></td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">UINT</td> <td style="padding: 2px;">BufferMode</td> <td style="padding: 2px;"></td> <td style="border-left: 1px solid black; padding: 2px;"></td> </tr> </table> </div>			BOOL	Execute	Done	BOOL	UINT	Axis ----- Axis		UINT	BOOL	ContinuousUpdate	Busy	BOOL	LREAL	Distance	Active	BOOL	LREAL	Velocity	CommandAborted	BOOL	LREAL	Acceleration	Error	BOOL	LREAL	Deceleration	ErrorID	WORD	LREAL	Jerk			UINT	BufferMode		
BOOL	Execute	Done	BOOL																																			
UINT	Axis ----- Axis		UINT																																			
BOOL	ContinuousUpdate	Busy	BOOL																																			
LREAL	Distance	Active	BOOL																																			
LREAL	Velocity	CommandAborted	BOOL																																			
LREAL	Acceleration	Error	BOOL																																			
LREAL	Deceleration	ErrorID	WORD																																			
LREAL	Jerk																																					
UINT	BufferMode																																					
Input-Output																																						
UINT	Axis	Specify the axis to be commanded (1~32: real axis, 37~40: virtual axis)																																				
Input																																						
BOOL	Execute	Give an absolute position operation command to the relevant axis in the rising Edge.																																				
BOOL	ContinuousUpdate	Specify the update setting of input value. (Refer to 6.1.5.Changes in Parameters during Execution of Motion Function Block)																																				
LREAL	Distance	Specify the target distance.																																				
LREAL	Velocity	Specify the maximum speed. [u/s]																																				
LREAL	Acceleration	Specify the acceleration. [u/s <sup>2</sup> ]																																				
LREAL	Deceleration	Specify the deceleration. [u/s <sup>2</sup> ]																																				
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]																																				
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)																																				
Output																																						
BOOL	Done	Indicate whether to reach the specified distance.																																				
BOOL	Busy	Indicate that the execution of motion function block is not completed.																																				
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.																																				
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.																																				
BOOL	Error	Indicate whether an error occurs or not.																																				
WORD	ErrorID	Output the number of error occurred while motion function block is running.																																				

- (1) This motion function block is to give the relevant additive position operation commands.
- (2) Additive position motion (MC\_MoveAdditive) is the motion function block which additionally moves as far as the position specified in Distance input from the final target position of the currently running motion function block or the latest motion function block executed in 'DiscreteMotion' state. If the current axis is executing motion function block 'ContinuousMotion' state, it executes operation based on the position where additive position motion (MC\_MoveAdditive) is executing.

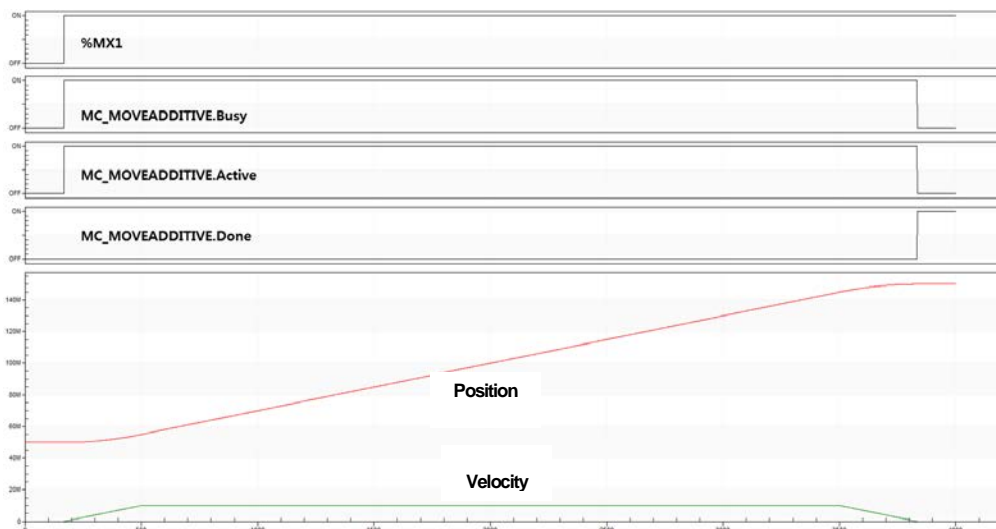
- (3) Moving direction is decided depending on the sign of the specified target distance in Distance input, and positive (+ or No sign) moving direction leads to forward direction, and negative (-) moving direction leads to reverse direction.
- (4) When reaching the target position without motion function block on standby after the current motion function block, 'Done' output is On.
- (5) The axis is in 'DiscreteMotion' state while this motion function block is running, and it is switched to 'Standstill' state when operation is completed.
- (6) The changed parameters can be applied by re-executing the function block (Execute input is On) before the command is completed. Only Distance, Velocity, Acceleration, Deceleration, Jerk input can be updated.
- (7) Example program

This example shows the movement from the current command position of 50,000,000 to the 150,000,000 position by moving the distance corresponding to the set value (100,000,000).

(a) Function block setting



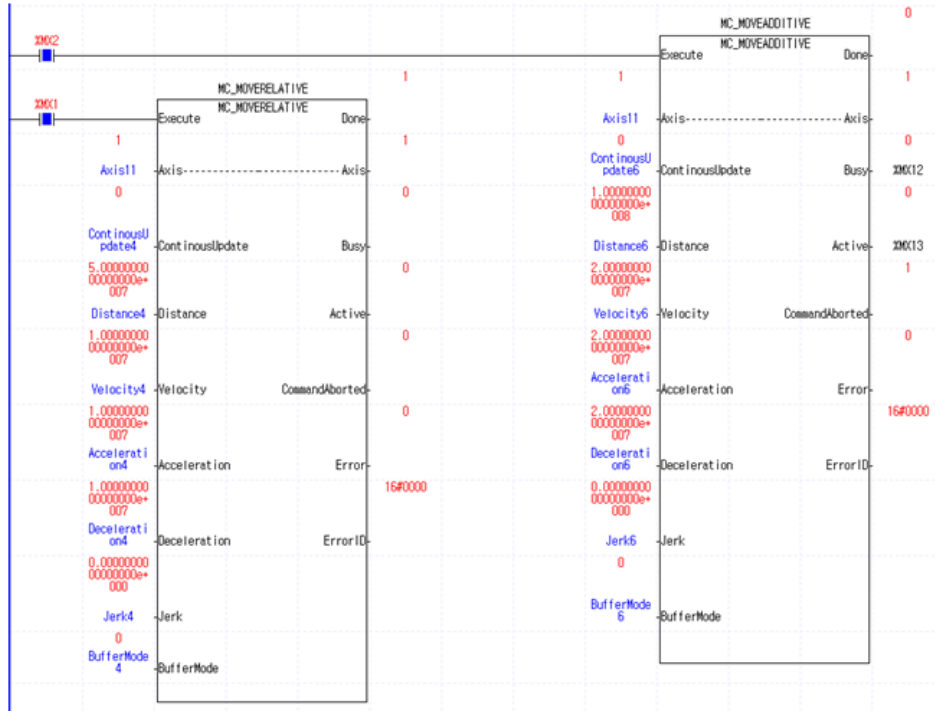
(b) Timing diagram



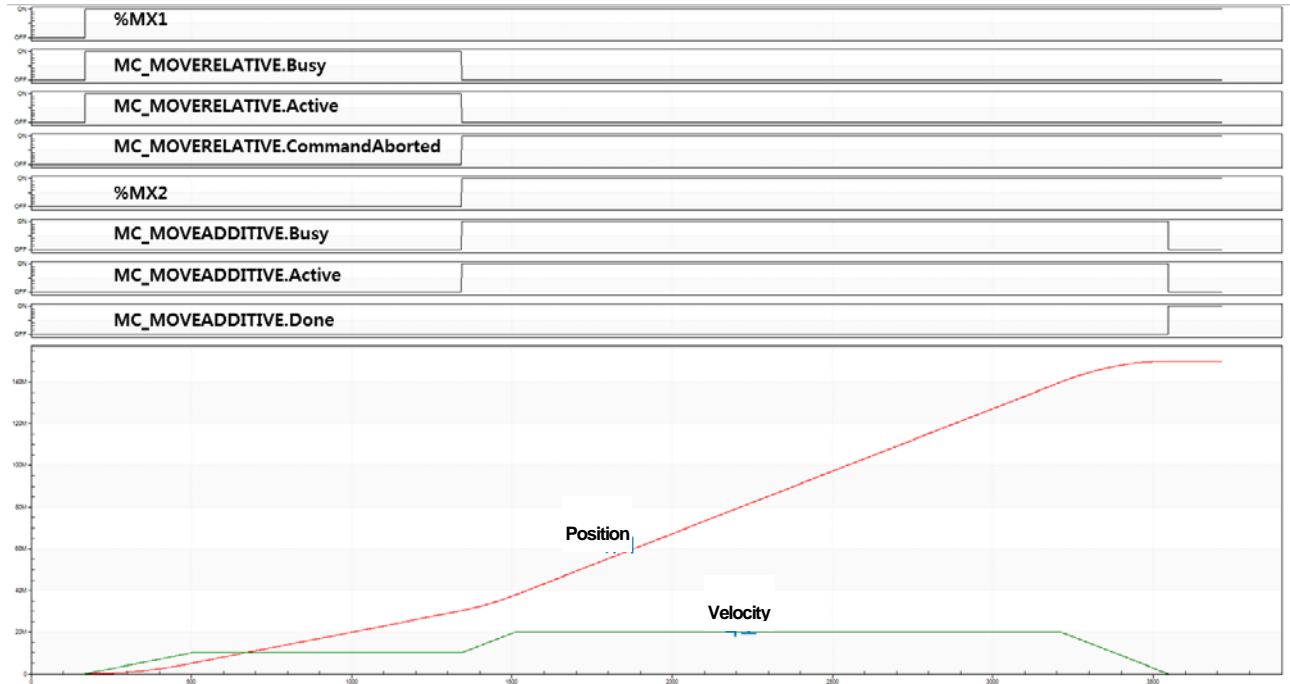
(8) Application example program

This example shows the execution of MC\_MOVEADDITIVE function block while moving from current command position of 0 to the 50,000,000 position, to move an additional 100,000,000 to the 150,000,000 position.

(a) Function block setting



(b) Timing diagram



6.3.8 Specified velocity operation(MC\_MoveVelocity)

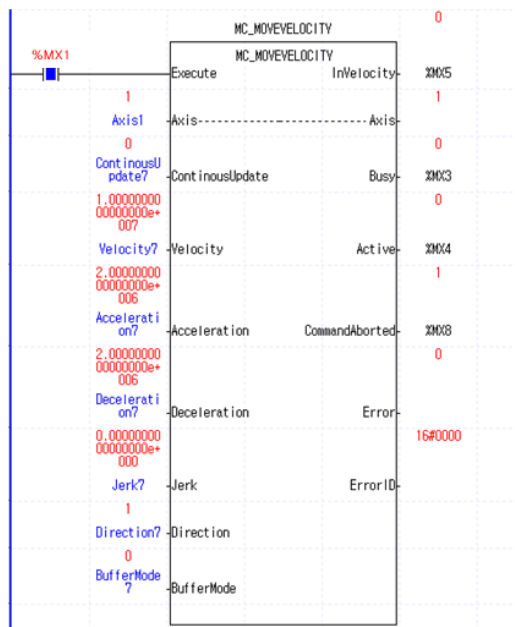
Motion Function Block																																															
<div style="border: 1px solid black; padding: 10px; width: fit-content; margin: 0 auto;"> <p style="text-align: center; margin: 0;">MC_MoveVelocity</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%;">BOOL</td> <td style="width: 40%;">Execute</td> <td style="width: 30%;"></td> <td style="width: 30%;">InVelocity</td> <td style="width: 30%;">BOOL</td> </tr> <tr> <td>UINT</td> <td>Axis</td> <td style="text-align: center;">-----</td> <td>Axis</td> <td>UINT</td> </tr> <tr> <td>BOOL</td> <td>ContinuousUpdate</td> <td></td> <td>Busy</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Velocity</td> <td></td> <td>Active</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Acceleration</td> <td></td> <td>CommandAborted</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Deceleration</td> <td></td> <td>Error</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Jerk</td> <td></td> <td>ErrorID</td> <td>WORD</td> </tr> <tr> <td>UINT</td> <td>Direction</td> <td></td> <td></td> <td></td> </tr> <tr> <td>UINT</td> <td>BufferMode</td> <td></td> <td></td> <td></td> </tr> </table> </div>			BOOL	Execute		InVelocity	BOOL	UINT	Axis	-----	Axis	UINT	BOOL	ContinuousUpdate		Busy	BOOL	LREAL	Velocity		Active	BOOL	LREAL	Acceleration		CommandAborted	BOOL	LREAL	Deceleration		Error	BOOL	LREAL	Jerk		ErrorID	WORD	UINT	Direction				UINT	BufferMode			
BOOL	Execute		InVelocity	BOOL																																											
UINT	Axis	-----	Axis	UINT																																											
BOOL	ContinuousUpdate		Busy	BOOL																																											
LREAL	Velocity		Active	BOOL																																											
LREAL	Acceleration		CommandAborted	BOOL																																											
LREAL	Deceleration		Error	BOOL																																											
LREAL	Jerk		ErrorID	WORD																																											
UINT	Direction																																														
UINT	BufferMode																																														
Input-Output																																															
UINT	Axis	Specify the axis to be commanded (1~32: real axis, 37~40: virtual axis)																																													
Input																																															
BOOL	Execute	Give an absolute position operation command to the relevant axis in the rising Edge.																																													
BOOL	ContinuousUpdate	Specify the update setting of input value. (Refer to 6.1.5.Changes in Parameters during Execution of Motion Function Block)																																													
LREAL	Velocity	Specify the maximum speed. [u/s]																																													
LREAL	Acceleration	Specify the acceleration. [u/s <sup>2</sup> ]																																													
LREAL	Deceleration	Specify the deceleration. [u/s <sup>2</sup> ]																																													
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]																																													
UINT	Direction	Specify the operation speed. (1 ~ 3 : 1-Forward direction, 2-Reverse direction, 3-Current direction)																																													
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)																																													
Output																																															
BOOL	InVelocity	Indicate whether to reach the specified speed.																																													
BOOL	Busy	Indicate that the execution of motion function block is not completed.																																													
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.																																													
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.																																													
BOOL	Error	Indicate whether an error occurs or not.																																													
WORD	ErrorID	Output the number of error occurred while motion function block is running.																																													

- (1) This motion function block is to give specified velocity operation command to the relevant axis.
- (2) Giving a stop command or execution of other motion function block allow to interrupt specified velocity motion.
- (3) Specify the operation speed in Velocity input. Positive sign (+ or No sign) of the operation speed value leads to forward direction, and negative (-) sign leads to reverse direction.

- (4) Specify the operation direction in Direction input. But, the operation direction is affected by the sign of the specified speed value by Velocity input. For example, if you specify the negative number for the Velocity value and reverse direction for Direction input, the relevant axis lastly does forward direction operation.
- (5) Output InVelocity is On when the relevant axis reaches the specified speed, and it is Off when the specified speed operation is interrupted.
- (6) The axis is in 'ContinuousMotion' state when this motion function block is running.
- (7) The changed parameters can be applied by re-executing the function block (Execute input is On) before the command is completed. Only Distance, Velocity, Acceleration, Deceleration, Jerk, Direction input can be updated.
- (8) Example program

This example program shows the movement at a velocity of 10,000,000. Once the set velocity is reached, InVelocityoutput is on.

(a) Function block setting



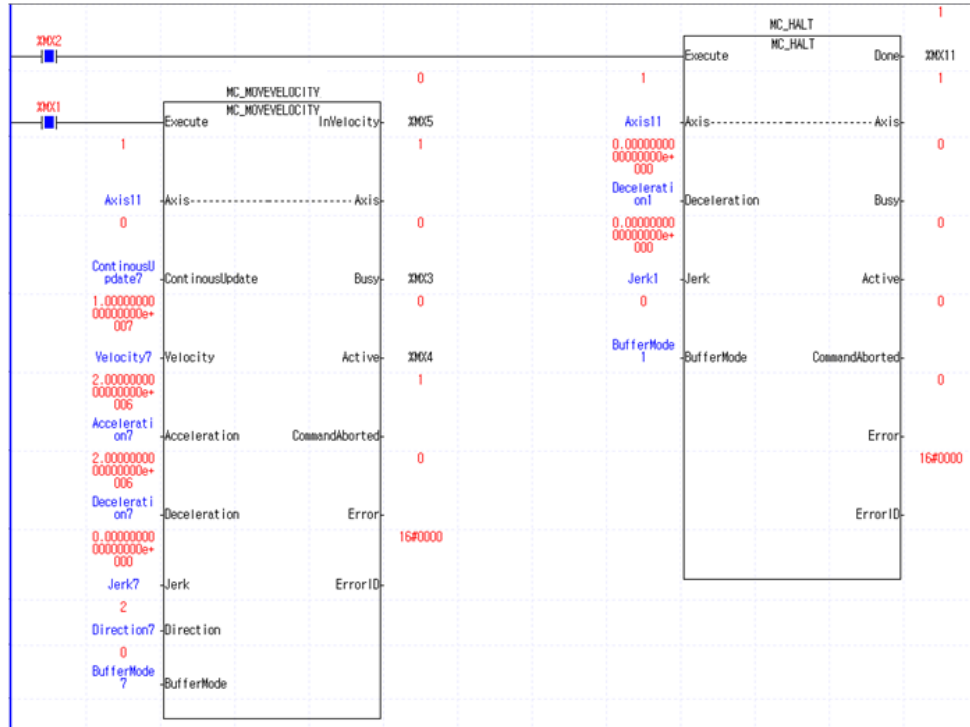
(b) Timing diagram



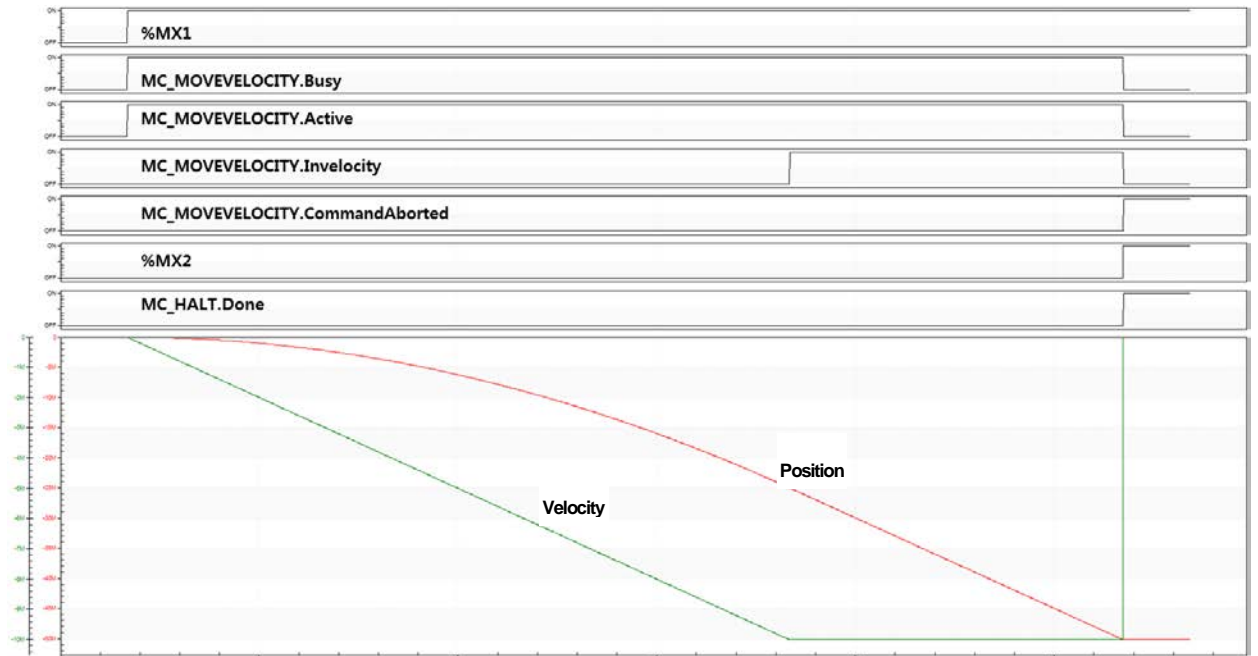
(9) Application example program

This example program shows that it stops running due to the execution of MC-Halt function block, while moving in the reverse direction at a velocity of 10,000,000.

(a) Function block setting



(b) Timing diagram



6.3.9 Absolute position operation ending with specified velocity operation

(MC\_MoveContinuousAbsolute)

Motion Function Block																																														
<div style="border: 1px solid black; padding: 10px; width: fit-content; margin: 0 auto;"> <p style="text-align: center; margin: 0;">MC_MoveContinuousAbsolute</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%;">BOOL</td> <td style="width: 40%;">Execute</td> <td style="width: 30%;">InEndVelocity</td> <td>BOOL</td> </tr> <tr> <td>UINT</td> <td>Axis</td> <td>Axis</td> <td>UINT</td> </tr> <tr> <td>BOOL</td> <td>ContinuousUpdate</td> <td>Busy</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Position</td> <td>Active</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>EndVelocity</td> <td>CommandAborted</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Velocity</td> <td>Error</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Acceleration</td> <td>ErrorID</td> <td>WORD</td> </tr> <tr> <td>LREAL</td> <td>Deceleration</td> <td></td> <td></td> </tr> <tr> <td>LREAL</td> <td>Jerk</td> <td></td> <td></td> </tr> <tr> <td>UINT</td> <td>Direction</td> <td></td> <td></td> </tr> <tr> <td>UINT</td> <td>BufferMode</td> <td></td> <td></td> </tr> </table> </div>			BOOL	Execute	InEndVelocity	BOOL	UINT	Axis	Axis	UINT	BOOL	ContinuousUpdate	Busy	BOOL	LREAL	Position	Active	BOOL	LREAL	EndVelocity	CommandAborted	BOOL	LREAL	Velocity	Error	BOOL	LREAL	Acceleration	ErrorID	WORD	LREAL	Deceleration			LREAL	Jerk			UINT	Direction			UINT	BufferMode		
BOOL	Execute	InEndVelocity	BOOL																																											
UINT	Axis	Axis	UINT																																											
BOOL	ContinuousUpdate	Busy	BOOL																																											
LREAL	Position	Active	BOOL																																											
LREAL	EndVelocity	CommandAborted	BOOL																																											
LREAL	Velocity	Error	BOOL																																											
LREAL	Acceleration	ErrorID	WORD																																											
LREAL	Deceleration																																													
LREAL	Jerk																																													
UINT	Direction																																													
UINT	BufferMode																																													
Input-Output																																														
UINT	Axis	Specify the axis to be commanded (1~32: real axis, 37~40: virtual axis)																																												
Input																																														
BOOL	Execute	Give an absolute position operation command to the relevant axis in the rising edge																																												
BOOL	ContinuousUpdate	Specify the update setting of input value. (Refer to 6.1.5.Changes in Parameters during Execution of Motion Function Block)																																												
LREAL	EndVelocity	Specify the operation speed after reaching the target position. [u/s]																																												
LREAL	Velocity	Specify the maximum speed to reach the target position. [u/s]																																												
LREAL	Acceleration	Specify the acceleration. [u/s <sup>2</sup> ]																																												
LREAL	Deceleration	Specify the deceleration. [u/s <sup>2</sup> ]																																												
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]																																												
UINT	Direction	Specify the operation direction. (0~4: 0-Not specified, 1-Forward direction, 2-Shortest distance, 3-Reverse direction, 4-Current direction)																																												
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)																																												
Output																																														
BOOL	InEndVelocity	Indicate the operation at the specified speed after reaching the target position.																																												
BOOL	Busy	Indicate that the execution of motion function block is not completed.																																												
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.																																												
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.																																												
BOOL	Error	Indicate whether an error occurs or not.																																												
WORD	ErrorID	Output the number of error occurred while motion function block is running.																																												

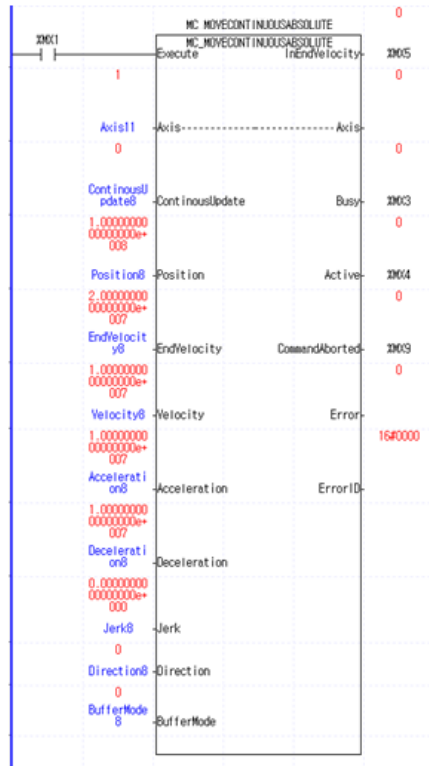
(1) This motion function block is to give Specified velocity operation after relative position operation command to the

relevant axis.

- (2) When executing MC\_MoveContinuousAbsolute, the relevant axis moves to the position specified in Position and operates at the specified speed in EndVelocity if there is no motion function block is on standby.
- (3) Giving a stop command or execution of other motion function block allow to interrupt speed operation.
- (4) Set the operation direction of the axis in infinite length repetition operation in Direction input, and if infinite length repetition operation is set to Prohibited, Direction input is ignored. When Direction input is the shortest distance (=2), the relevant axis selects the direction which allows the shortest distance and operates if it does infinite length repetition operation. The range can be set to 0~4(0-No specified, 1-Forward direction, 2-Shortest distance, 3-Reverse direction, 4-Current direction), if the value outside the range is set and motion function block is executed, Error is On and "0x1017" occurs in ErrorID.
- (5) Output InEndVelocity is on when the relevant axis starts speed operation after reaching the specified position, and when the specified operation is interrupted, it is Off.
- (6) The axis is in 'ContinuousMotion' state while this command is executing.
- (7) The changed parameters can be applied by re-executing the function block (Execute input is On) before the command is completed. Only Position, EndVelocity, Velocity, Acceleration, Deceleration, Jerk, Direction input can be updated. (However, in case of InEndVelocity=On, it is reflected only EndVelocity inputs).
- (8) Example program

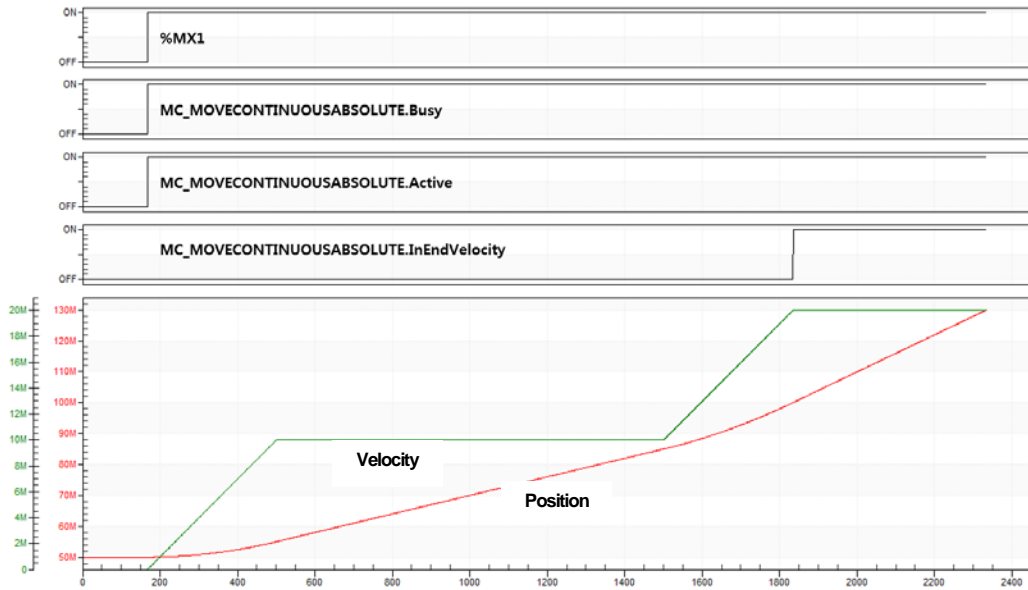
This example program shows the operation at a speed of 20,000,000 after moving from the current command position of 50,000,000 to the 100,000,000 position. Once the set position is reached, InEndVelocity output is on.

(a) Function block setting





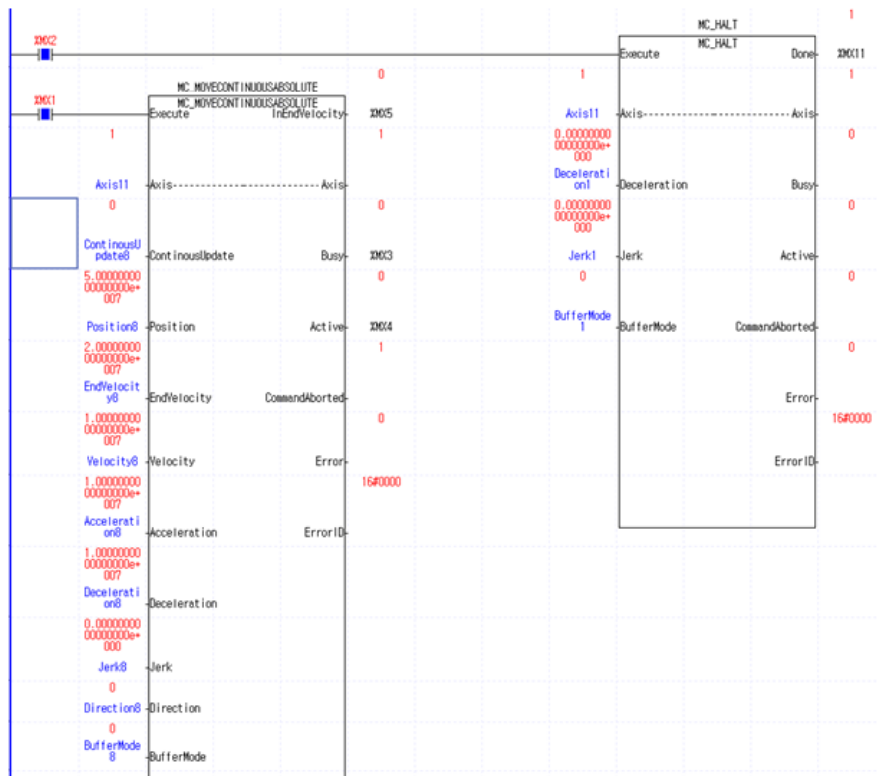
(b) Timing diagram



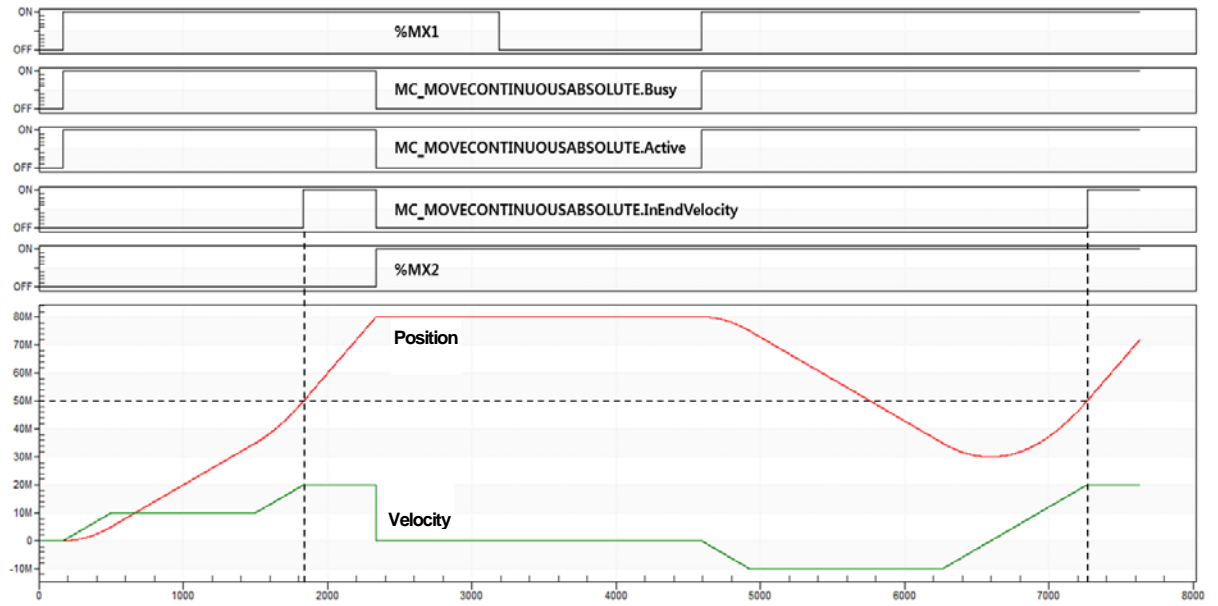
(9) Application example program

This example program shows the movement in the direction of the same speed when re-executing the function block after stopping the execution of MC-Halt function block, while moving from the current command position of 0 to the 50,000,000, then operating at a speed of 20,000,000.

(a) Function block setting



(b) Timing diagram



6.3.10 Relative position operation ending with specified velocity operation

(MC\_MoveContinuousRelative)

Motion Function Block																																										
<div style="border: 1px solid black; padding: 10px; margin: 0 auto; width: fit-content;"> <p style="text-align: center; margin: 0;">MC_MoveContinuousRelative</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%;">BOOL</td> <td style="width: 40%;">Execute</td> <td style="width: 30%;">InEndVelocity</td> <td>BOOL</td> </tr> <tr> <td>UINT</td> <td>Axis</td> <td>Axis</td> <td>UINT</td> </tr> <tr> <td>BOOL</td> <td>ContinuousUpdate</td> <td>Busy</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Distance</td> <td>Active</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>EndVelocity</td> <td>CommandAborted</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Velocity</td> <td>Error</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Acceleration</td> <td>ErrorID</td> <td>WORD</td> </tr> <tr> <td>LREAL</td> <td>Deceleration</td> <td></td> <td></td> </tr> <tr> <td>LREAL</td> <td>Jerk</td> <td></td> <td></td> </tr> <tr> <td>UINT</td> <td>BufferMode</td> <td></td> <td></td> </tr> </table> </div>			BOOL	Execute	InEndVelocity	BOOL	UINT	Axis	Axis	UINT	BOOL	ContinuousUpdate	Busy	BOOL	LREAL	Distance	Active	BOOL	LREAL	EndVelocity	CommandAborted	BOOL	LREAL	Velocity	Error	BOOL	LREAL	Acceleration	ErrorID	WORD	LREAL	Deceleration			LREAL	Jerk			UINT	BufferMode		
BOOL	Execute	InEndVelocity	BOOL																																							
UINT	Axis	Axis	UINT																																							
BOOL	ContinuousUpdate	Busy	BOOL																																							
LREAL	Distance	Active	BOOL																																							
LREAL	EndVelocity	CommandAborted	BOOL																																							
LREAL	Velocity	Error	BOOL																																							
LREAL	Acceleration	ErrorID	WORD																																							
LREAL	Deceleration																																									
LREAL	Jerk																																									
UINT	BufferMode																																									
Input-Output																																										
UINT	Axis	Specify the axis to be commanded (1~32: real axis, 37~40: virtual axis)																																								
Input																																										
BOOL	Execute	Give an absolute position motion command to the relevant axis in the rising Edge.																																								
BOOL	ContinuousUpdate	Specify the update setting of input value. (Refer to 6.1.5.Changes in Parameters during Execution of Motion Function Block)																																								
LREAL	Distance	Specify the target distance.																																								
LREAL	EndVelocity	Specify the operation speed after reaching the target position. [u/s]																																								
LREAL	Velocity	Specify the maximum speed to reach the target position. [u/s]																																								
LREAL	Acceleration	Specify the acceleration. [u/s <sup>2</sup> ]																																								
LREAL	Deceleration	Specify the deceleration. [u/s <sup>2</sup> ]																																								
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]																																								
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)																																								
Output																																										
BOOL	InEndVelocity	Indicate the operation at the specified speed after reaching the target position.																																								
BOOL	Busy	Indicate that the execution of motion function block is not completed.																																								
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.																																								
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.																																								
BOOL	Error	Indicate whether an error occurs or not.																																								
WORD	ErrorID	Output the number of error occurred while motion function block is running.																																								

- (1) This motion function block gives MC\_MoveContinuousRelative command to the relevant axis.
- (2) When executing MC\_MoveContinuousRelative, the relevant axis operates at the speed specified in

EndVelocity after moving the distance specified in Distance if there is no motion function block is on standby.

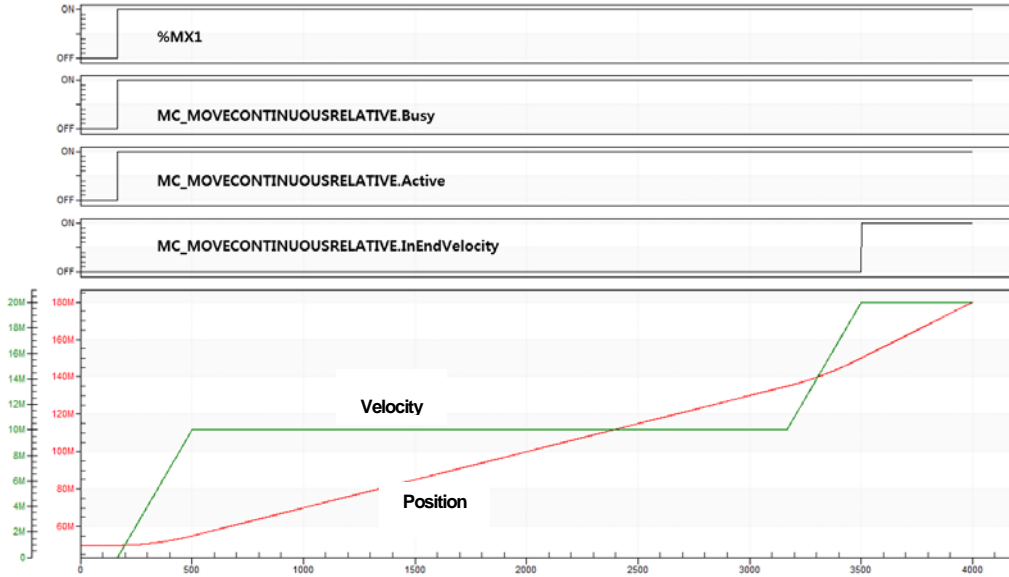
- (3) Giving a stop command or operation of other motion function block allow to interrupt specified velocity motion.
- (4) Output InEndVelocity is On when the relevant axis starts speed operation and reaches the specified speed after moving the specified distance, and when specified velocity motion is interrupted, it is Off.
- (5) The axis is in 'ContinuousMotion' state while this motion function block is running.
- (6) The changed parameters can be applied by re-executing the function block (Execute input is On) before the command is completed. Only Distance, EndVelocity, Velocity, Acceleration, Deceleration, Jerk input can be updated. (However, in case of InEndVelocity=On, it is reflected only EndVelocity inputs.
- (7) Example program

This example program shows the operation at a velocity of 20,000,000 after moving from the current command position of 50,000,000 to the 150,000,000 position by moving the distance corresponding to the set value (100,000,000). Once the set position is reached, InEndVelocity is on.

(a) Function block setting



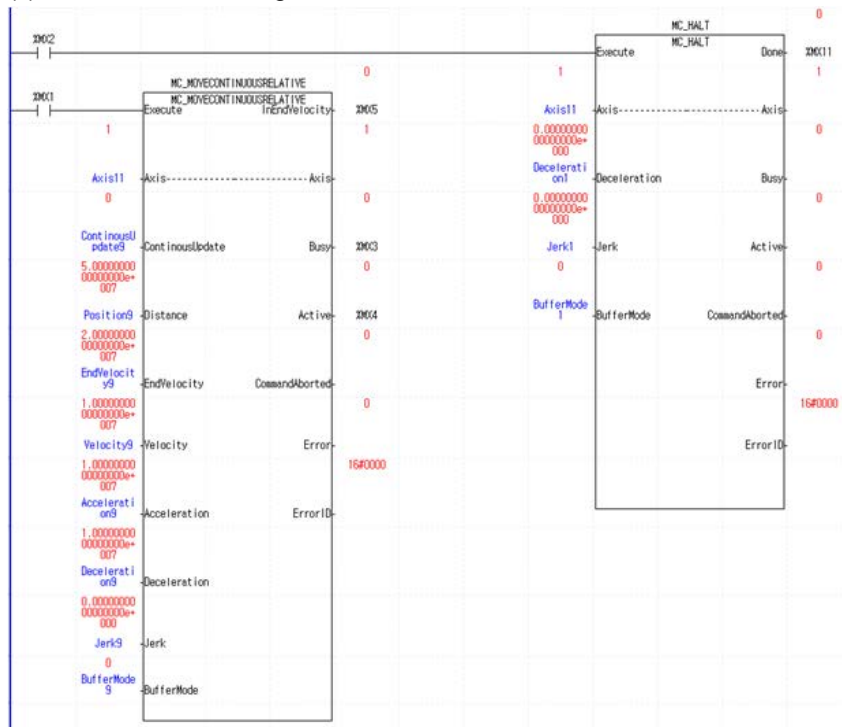
(b) Timing diagram



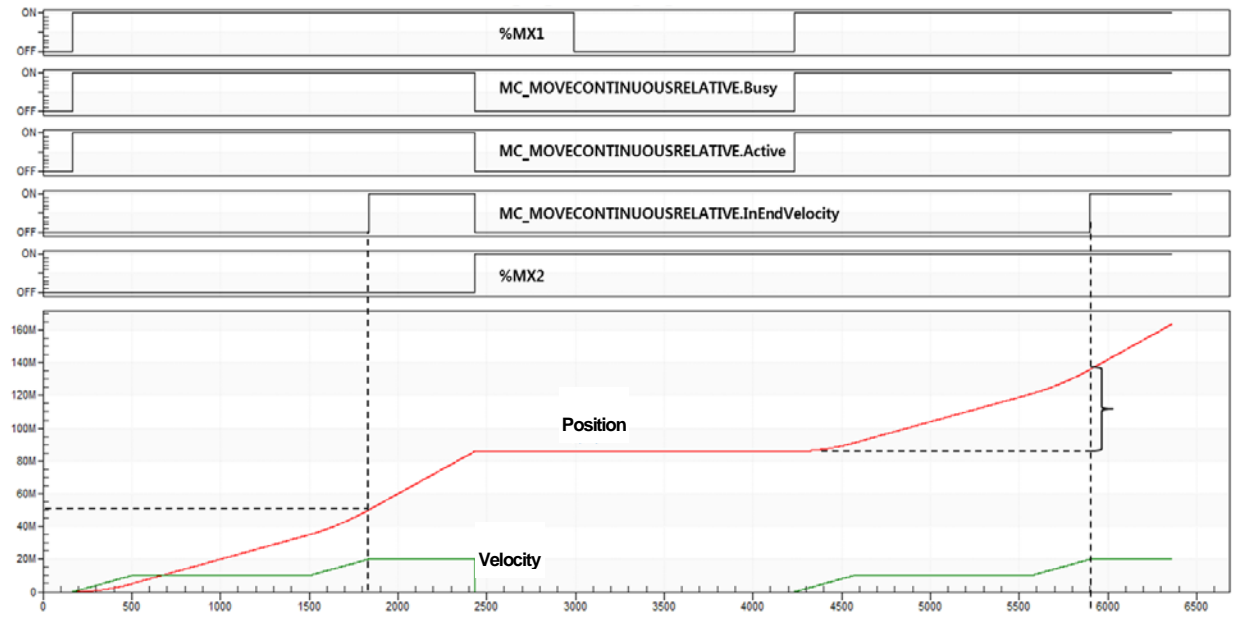
(8) Application example program

This example program shows the movement at a velocity of 20,000,000 after moving from the current command position of 0 to the 50,000,000 position, then operating at a velocity of 20,000,000, stopping by executing MC\_Halt function block, moving to the same relative position (20,000,000) by re-executing the function block.

(a) Function block setting



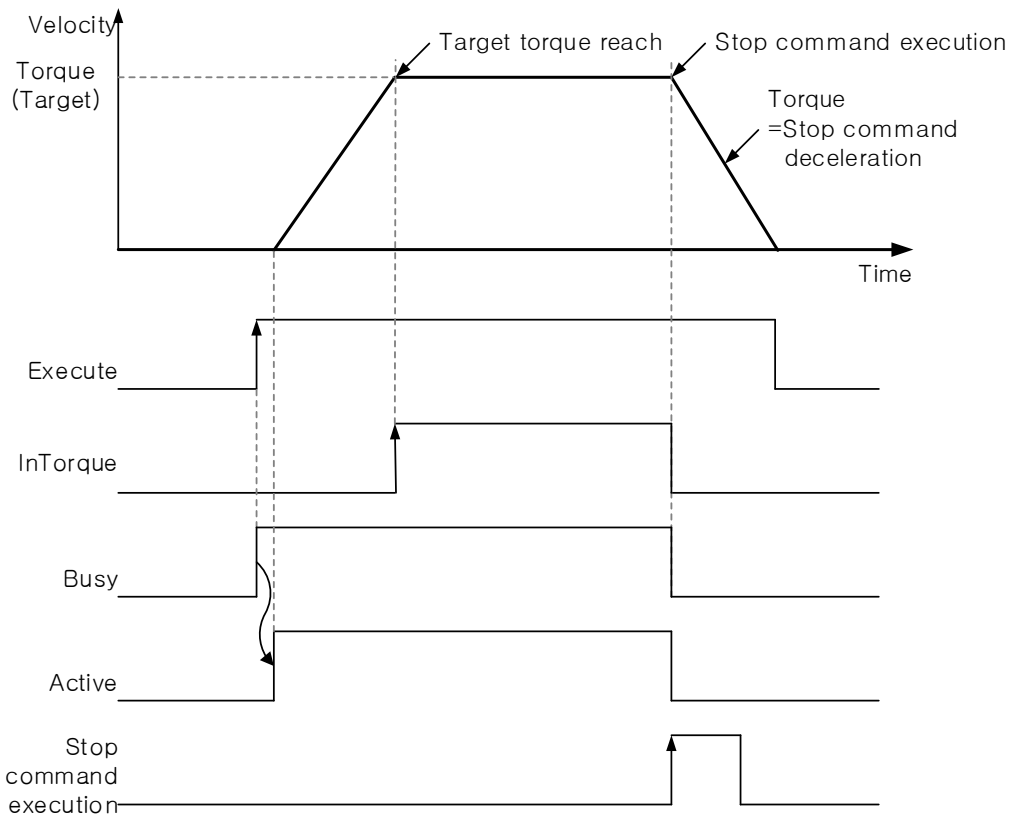
(b) Timing diagram



### 6.3.11 Torque control operation(MC\_TorqueControl)

Motion Function Block		
<p>The diagram shows a central box labeled 'MC_TorqueControl'. On the left side, there are inputs: Execute (BOOL), Axis (UINT), ContinuousUpdate (BOOL), Torque (LREAL), TorqueRamp (LREAL), Velocity (LREAL), Acceleration (LREAL), Deceleration (LREAL), Jerk (LREAL), Direction (UINT), and BufferMode (UINT). On the right side, there are outputs: InTorque (BOOL), Axis (UINT), Busy (BOOL), Active (BOOL), CommandAborted (BOOL), Error (BOOL), and ErrorID (WORD).</p>		
Input-Output		
UINT	Axis	Specify the axis to be commanded (1~32: real axis)
Input		
BOOL	Execute	Give an absolute position operation command to the relevant axis in the rising Edge.
BOOL	ContinuousUpdate	Specify the update setting of input value. (Refer to 6.1.5.Changes in Parameters during Execution of Motion Function Block)
LREAL	Torque	Specify the target torque. [u]
LREAL	TorqueRamp	Specify the ascending slope of torque. [u/s]
LREAL	Velocity	Unused
LREAL	Acceleration	Unused
LREAL	Deceleration	Unused
LREAL	Jerk	Unused
UINT	Direction	Specify the operation direction. (1~2 : 1-Forward direction, 2-Reverse direction)
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)
Output		
BOOL	InTorque	Indicate that the input torque value and currently operating torque value are same.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block is to give torque control command to the relevant axis.
- (2) When executing torque control (MC\_Torque), the relevant axis performs the control to keep the torque value specified in Torque input.
- (3) Giving a stop command or operation of other motion function block allow to interrupt specified velocity motion.
- (4) Specify the gradient to reach the target torque value in TorqueRamp input.
- (5) Specify the operation direction in Direction input. When setting the value outside the range and executing motion function block, Error is On and "0x1017" occurs in ErrorID.
- (6) Output InTorque is On when the relevant axis reaches the specified torque, and when torque control operation is interrupted, it is Off.
- (7) The axis is in 'ContinuousMotion' state when this motion function block is running.
- (8) The changed parameters can be applied by re-executing the function block (Execute input is On) before the command is completed. Only Torque, TorqueRamp, Direction input can be updated.
- (9) Timing diagram





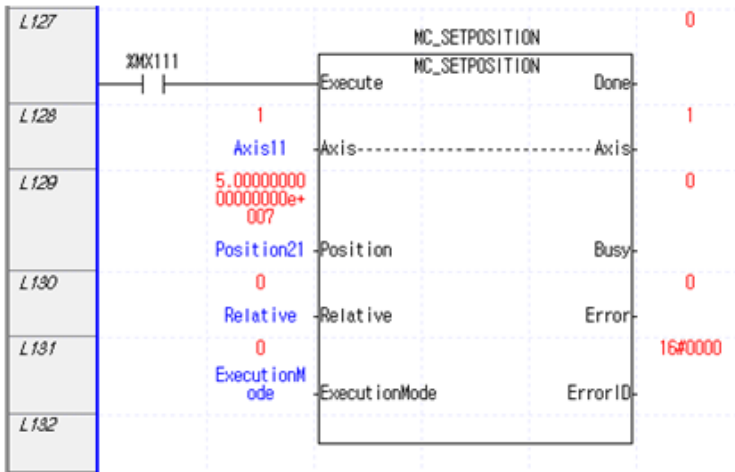
6.3.12 Setting the current position(MC\_SetPosition)

Motion Function Block		
Input-Output		
UINT	Axis	Specify the axis to be commanded (1~32: real axis, 37~40: virtual axis)
Input		
BOOL	Execute	Specify the current position of the relevant axis in the rising Edge.
LREAL[ ]	Position	Specify the position.
BOOL	Relative	0: Position value=Absolute position, 1: Position value=Relative position
UINT	ExecuteMode	0: Immediately applied the position value, 1: Applied at the same point with 'Buffered' of Buffermode
Output		
BOOL	Done	Indicate the state of motion function block completion.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

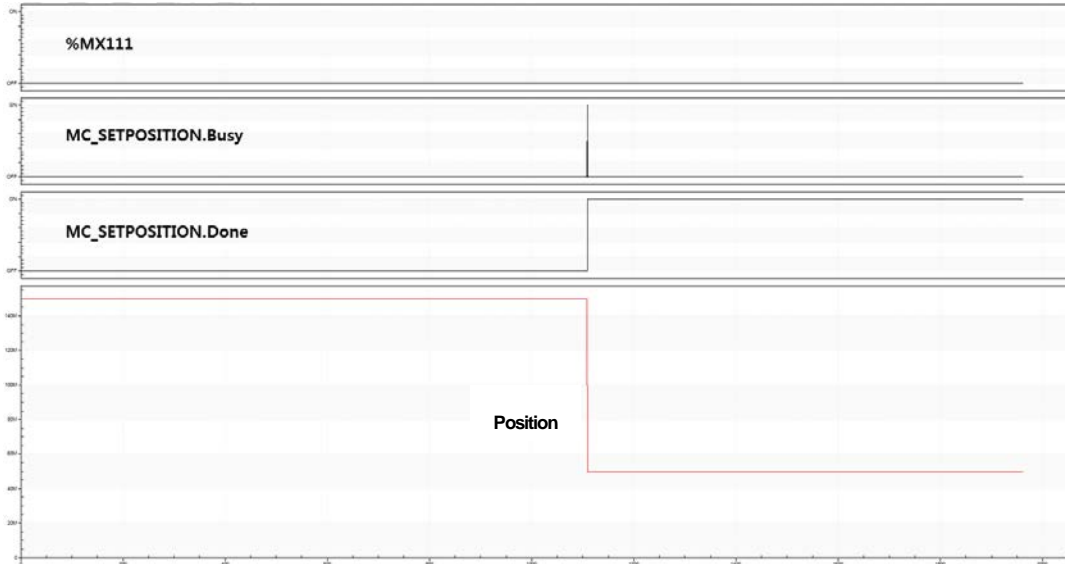
- (1) This motion function block is to set the current position of the relevant axis.
- (2) Specify the position in Position input. When executing motion function block, if Relative input is Off, the position of the relevant axis is replaced by the value of Position input, and if Relative input is On, the value of Position input is added to the current position of the relevant axis.
- (3) ExecutionMode input specifies the setting point. 0 means to be set immediately after motion function block, and 1 means to be set at the same point with 'Buffered' in sequential operation setting. The value unable to be set causes "error0x101B".
  - 0 (mcImmediately): Change the parameter value immediately after executing function block (rising Edge in Execute input). If the relevant axis is in running, operation can be affected.
  - 1 (mcQueued): Changed at the same point with 'Buffered' in Buffermode. (Refer to 6.1.4.BufferMode Input)
- (4) (4) When an instruction is executed with the ExecutionMode set to 1 and waiting for execution, if another instruction is executed with BufferMode 0 (Aborting) and aborted, Error is 1 and ErrorId is 0.
- (5) Example program
 

This example program shows the setting of the current position to 200,000,000 position by adding a relative position (Relative=1) corresponding to the set value (50,000,000) from the current position of 150,000,000.

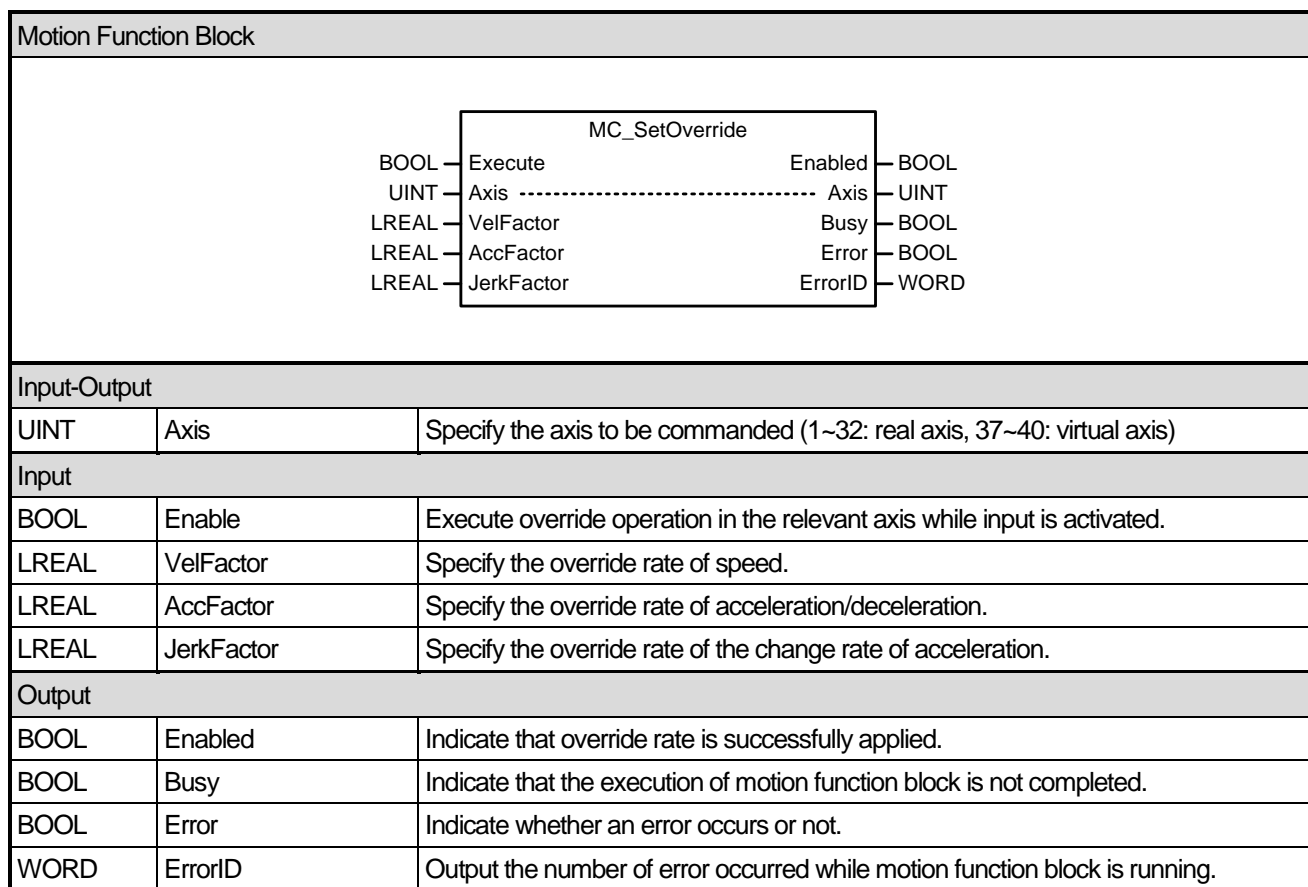
  - (a) Function block setting



(b) Timing diagram

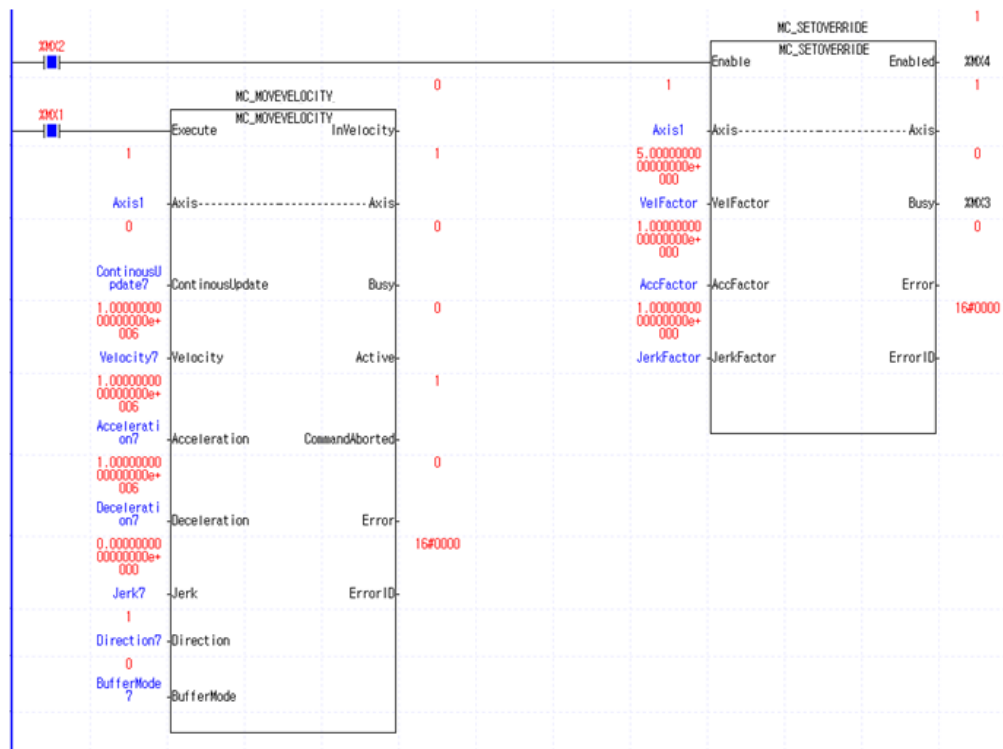


6.3.13 Velocity/Acceleration override(MC\_SetOverride)

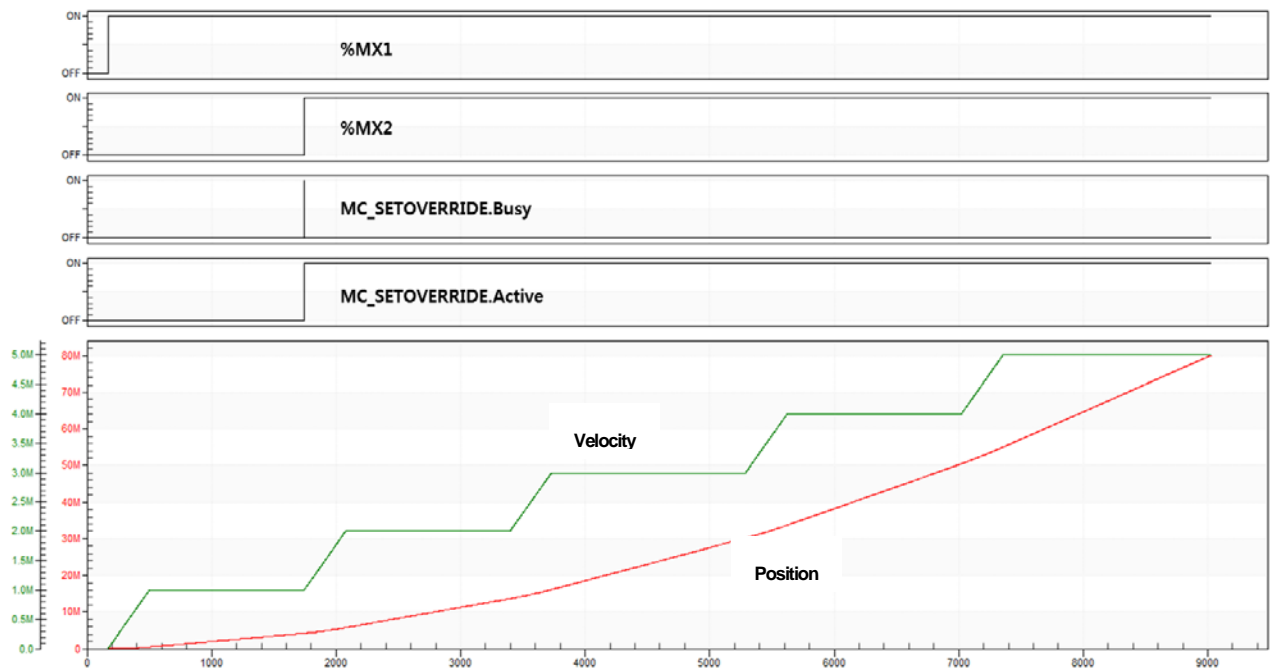


- (1) This motion function block is to override the speed of the relevant axis, acceleration, and the change rate of acceleration.
- (2) Override rate which is applied to the relevant axis can be specified and changed while Enable input is On. If Enable input is Off, override rate right before the Off is maintained.
- (3) Speed override rate is specified in VelFactor input. If the specified value is 0.0, the relevant axis stops but it is not changed to 'StandStill' state.
- (4) Specify acceleration/deceleration and override rate of jerk (change rate of acceleration) in AccFactor and JerkFactor input respectively.
- (5) Negative number cannot be input in each Facotr, and if it is input, "error 0x10C1" occurs.
- (6) Default of each override rate is 1.0, and it means 100% of the command speed of function block currently running.
- (7) Override operation does not affect the serve axis of the relevant axis.
- (8) Example program
- (9) This example shows the operation by changing the current velocity to 2,000,000/ 3,000,000/ 4,000,000/ 5,000,000 if VelFactor is changed to 2/3/4/5 at the current velocity of 1,000,000.

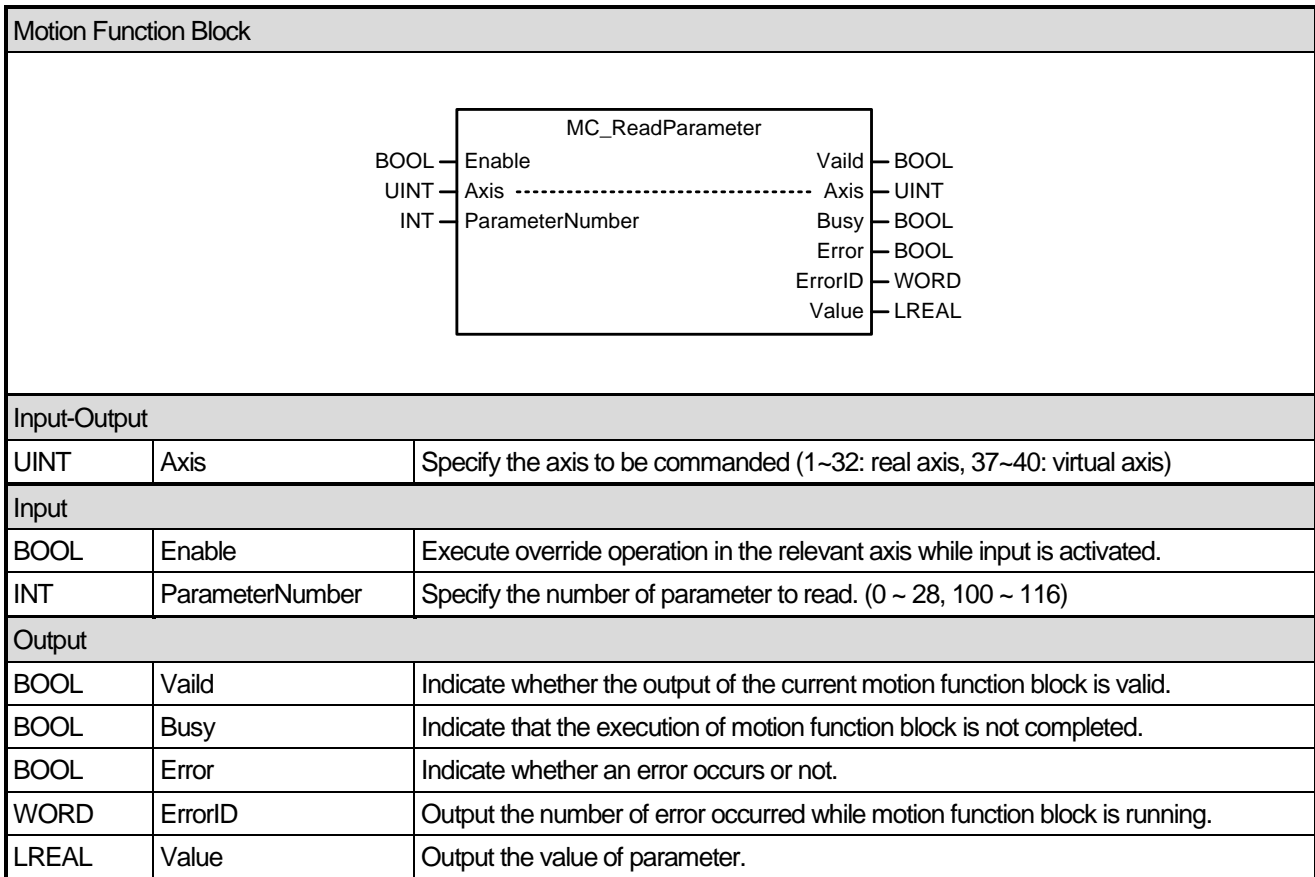
(a) Function block setting



(b) Timing diagram



6.3.14 Reads Parameter(MC\_ReadParameter)



- (1) This command is a motion function block which outputs parameter of the relevant axis.
- (2) The value of the relevant parameter is continuously output in Value while Enable input is On.
- (3) Specify the number of parameter to read in ParameterNumber input.
- (4) The numbers of parameter are as below.

No	Parameter	Item	Description
0	Basic Parameter	Unit	0:pulse,1:mm,2:inch,3:degree
1		Purses per rotation	1 ~ 4,294,967,295 [pulse]
2		Travel per rotation	0.00000001 ~ 4,294,967,295 [Unit]
3		Speed command unit	0:Unit/Time, 1:rpm
4		Speed limit	LREAL Positive number [Unit/s, rpm] (Change according to Unit, Pulses per rotation, Travel per rotation, Speed command unit)
5		Emergency stop deceleration	0 or LREAL Positive number [Unit/s <sup>2</sup> ]
6		Encoder select	0:Incremental Encoder, 1:Absolute Encoder
7		Gear ratio(Motor)	1 ~ 65,535
8		Gear ratio(Machine)	1 ~ 65,535
9		Operating mode of the reverse rotation	0:E.Stop, 1:Stop

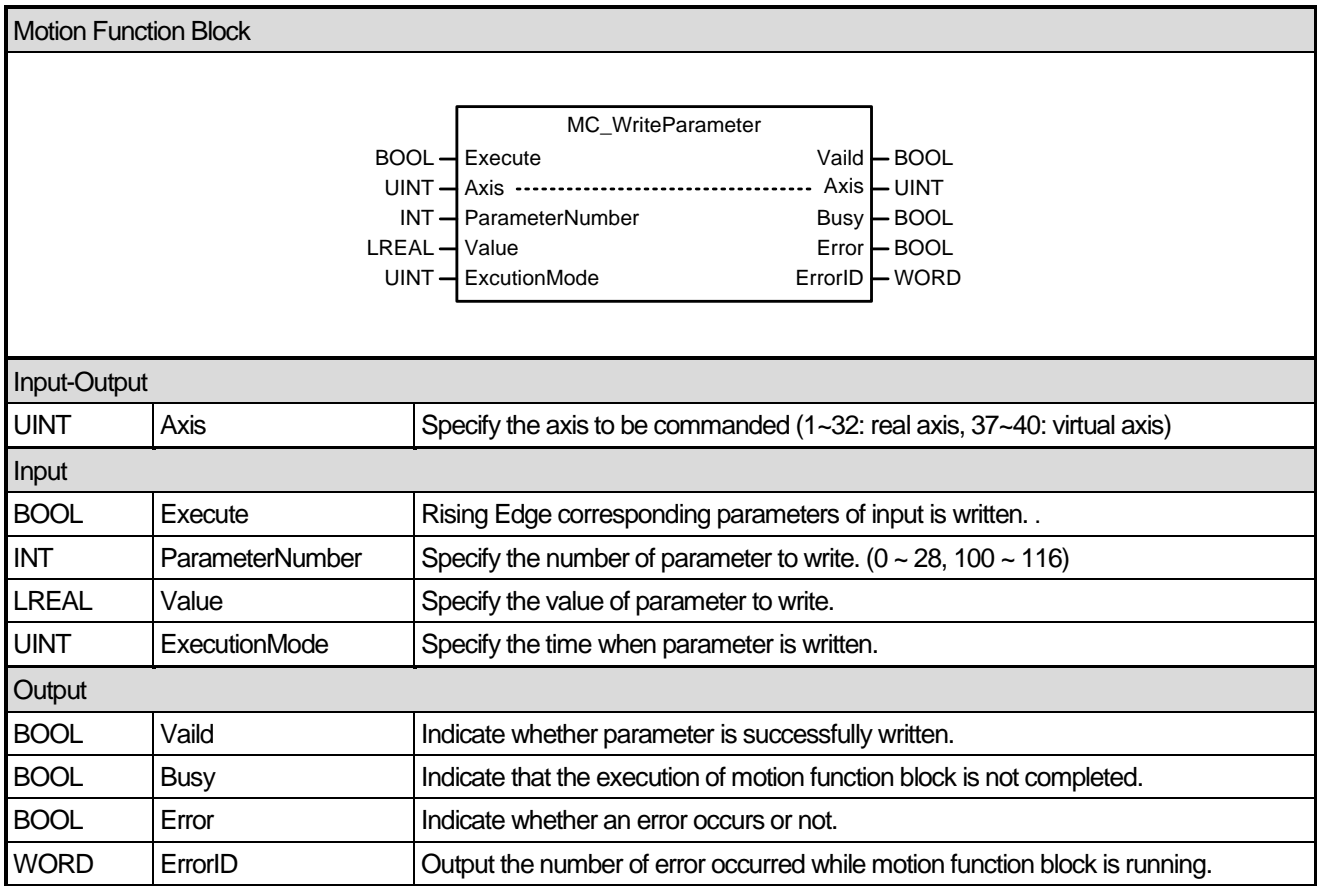
26		Velocity control operation mode	0: CSP (Cyclic Sync. Position) 1: CSV (Cyclic Sync. Velocity)
28		Position Control range expansion	0: No 1: Use
10	Extended Parameter	S/W upper limit	LREAL [Unit]
11		S/W lower limit	LREAL [Unit]
12		Infinite running repeat position	LREAL Positive number [Unit]
13		Infinite running repeat	0:Disable, 1:Enable
14		Command Inposition range	0 or LREAL Positive number [Unit]
15		Tracking error over-range value	0 or LREAL Positive number [Unit]
16		Current position compensation amount	0 or LREAL Positive number [Unit]
17		Current speed filter time constant	0 ~ 100
18		Error reset monitoring time	1 ~ 1000 [ms]
19		S/W limit during speed control	0:Don't detect, 1:Detect
20		Tracking error level	0:Warning, 1:Alarm
21		JOG high Speed	LREAL Positive number [Unit] (Jog low speed ~speed limit ) [Unit/s]
22		JOG low Speed	LREAL Positive number [Unit] ( < Jog high speed) [Unit/s]
23		JOG acceleration	0 or LREAL Positive number [Unit/ s <sup>2</sup> ]
24		JOG deceleration	0 or LREAL Positive number [Unit/ s <sup>2</sup> ]
25	JOG jerk	0 or LREAL Positive number [Unit/ s <sup>2</sup> ]	
27		The Sync method depending on the direction of master axis operation	0: Sync to bi-direction operation of master axis 1: Sync to forward direction operation of master axis 2: Sync to reverse direction operation of master axis
100	Common Parameter	Encoder1 unit	0: pulse, 1: mm, 2: inch, 3:degree
101		Encoder1 pulse per rotation	1 ~ 4294967295
102		Encoder1 travel per rotation	0.000000001 ~ 4294967295
103		Encoder1 pulse input	0:CW/CCW 1 multiplier, 1:PULSE/DIR 1 multiplier 2:PULSE/DIR 2 multiplier, 3:PHASE A/B 1 multiplier 4:PHASE A/B 2 multiplier, 5: PHASE A/B 4multiplier
104		Encoder2 unit	0: pulse, 1: mm, 2: inch, 3:degree
105		Encoder2 pulse per rotation	1 ~ 4294967295
106		Encoder2 travel per rotation	0.000000001 ~ 4294967295

107	Encoder2 pulse input	0: CW/CCW 1 multiplier, 1: PULSE/DIR 1 multiplier 2: PULSE/DIR 2 multiplier, 3: PHASE A/B 1 multiplier 4: PHASE A/B 2 multiplier, 5: PHASE A/B 4 multiplier
108	Encoder1 max. value	LREAL numbers
109	Encoder1 min. value	
110	Encoder2 max. value	
111	Encoder2 min. value	
112	Override	0: Specified by ratio, 1: Specified by unit
113	Encoder1 Position filter time constant	0~1000 ms
114	Encoder2 Position filter time constant	0~1000 ms
115	Encoder1 Speed unit	0: Unit/sec, 1: rpm, 2: Unit/min
116	Encoder2 Speed unit	0: Unit/sec, 1: rpm, 2: Unit/min

\*Remak1) LREAL range: 2.2250738585072e-308 ~ 1.79769313486232e+308

LREAL positive range:  $0 < x \leq 1.79769313486232e+308$

6.3.15 Writes Parameter(MC\_WriteParameter)



- (1) This motion function block is to write the value specified parameter of the relevant axis.
- (2) Parameter is written in the rising Edge of Execute input.
- (3) Specify the number of parameter to write in ParameterNumber input. The value unable to be set causes "error 0x10F0".
- (4) Specify the value to write in parameter for Value input.
- (5) In ExecutionMode, correct the time when parameter is written and the values below can be set. The value unable to be set causes "error 0x101B".
  - 0 (mcImmediately): Change the parameter value immediately after executing function block (rising Edge in Execute input). If the relevant axis is in running, operation can be affected.
  - 1 (mcQueued): Changed at the same point with 'Buffered' in Buffermode. (Refer to 6.1.4.BufferMode Input)
- (6) The numbers of parameter are as below.

No.	Parameter	Item	Description
0	Basic Parameter	Unit	0:pulse,1:mm,2:inch,3:degree
1		Purses per rotation	1 ~ 4,294,967,295 [pulse]
2		Travel per rotation	0.000000001 ~ 4,294,967,295 [Unit]
3		Speed command unit	0:Unit/Time, 1:rpm



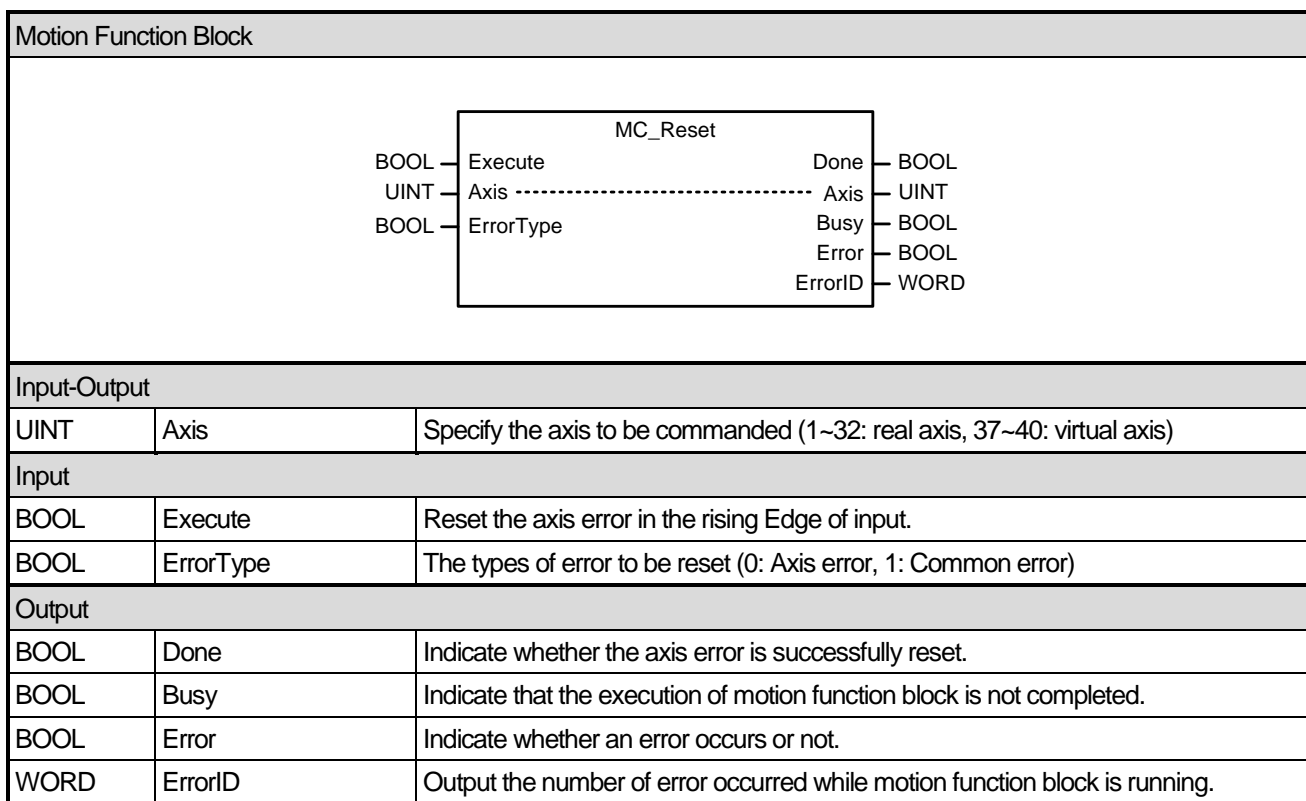
4		Speed limit	LREAL Positive number [Unit/s, rpm] (Change according to Unit, Pulses per rotation, Travel per rotation, Speed command unit)
5		Emergency stop deceleration	0 or LREAL Positive number [Unit/s <sup>2</sup> ]
6		Encoder select	0:Incremental Encoder, 1:Absolute Encoder
7		Gear ratio(Motor)	1 ~ 65,535
8		Gear ratio(Machine)	1 ~ 65,535
9		Operating mode of the reverse rotation	0:E.Stop, 1:Stop
26		Velocity control operation mode	0: CSP (Cyclic Sync. Position) 1: CSV (Cyclic Sync. Velocity)
28		Position Control range expansion	0: No 1: Use
10	Extended Parameter	S/W upper limit	LREAL [Unit]
11		S/W lower limit	LREAL [Unit]
12		Infinite running repeat position	LREAL Positive number [Unit]
13		Infinite running repeat	0:Disable, 1:Enable
14		Command Inposition range	0 or LREAL Positive number [Unit]
15		Tracking error over-range value	0 or LREAL Positive number [Unit]
16		Current position compensation amount	0 or LREAL Positive number [Unit]
17		Current speed filter time constant	0 ~ 100
18		Error reset monitoring time	1 ~ 1000 [ms]
19		S/W limit during speed control	0:Don't detect, 1:Detect
20		Tracking error level	0:Warning, 1:Alarm
21		JOG high Speed	LREAL Positive number [Unit] (Jog low speed ~speed limit ) [Unit/s]
22		JOG low Speed	LREAL Positive number [Unit] ( < Jog high speed) [Unit/s]
23		JOG acceleration	0 or LREAL Positive number [Unit/ s <sup>2</sup> ]
24		JOG deceleration	0 or LREAL Positive number [Unit/ s <sup>2</sup> ]
25		JOG jerk	0 or LREAL Positive number [Unit/ s <sup>2</sup> ]
27			The Sync method depending on the direction of master axis operation
100	Common Parameter	Encorder1 unit	0: pulse, 1: mm, 2: inch, 3:degree
101		Encorder1 pulse per rotation	1 ~ 4294967295
102		Encorder1 travel per rotation	0.000000001 ~ 4294967295

103	Encoder1 pulse input	0:CW/CCW 1 multiplier, 1:PULSE/DIR 1 multiplier 2:PULSE/DIR 2 multiplier, 3:PHASE A/B 1 multiplier 4:PHASE A/B 2 multiplier, 5: PHASE A/B 4multiplier
104	Encoder2 unit	0: pulse, 1: mm, 2: inch, 3:degree
105	Encoder2 pulse per rotation	1 ~ 4294967295
106	Encoder2 travel per rotation	0.000000001 ~ 4294967295
107	Encoder2 pulse input	0:CW/CCW 1 multiplier, 1:PULSE/DIR 1 multiplier 2:PULSE/DIR 2 multiplier, 3:PHASE A/B 1 multiplier 4:PHASE A/B 2 multiplier, 5: PHASE A/B 4multiplier
108	Encoder1 max. value	LREAL numbers
109	Encoder1 min. value	
110	Encoder2 max. value	
111	Encoder2 min. value	
112	Override	0: Specified by ratio, 1: Specified by unit
113	Encoder1 Position filter time constant	0~1000 ms
114	Encoder2 Position filter time constant	0~1000 ms
115	Encoder1 Speed unit	0: Unit/sec, 1: rpm, 2: Unit/min
116	Encoder2 Speed unit	0: Unit/sec, 1: rpm, 2: Unit/min

\*Remak1) LREAL range: 2.2250738585072e-308 ~ 1.79769313486232e+308

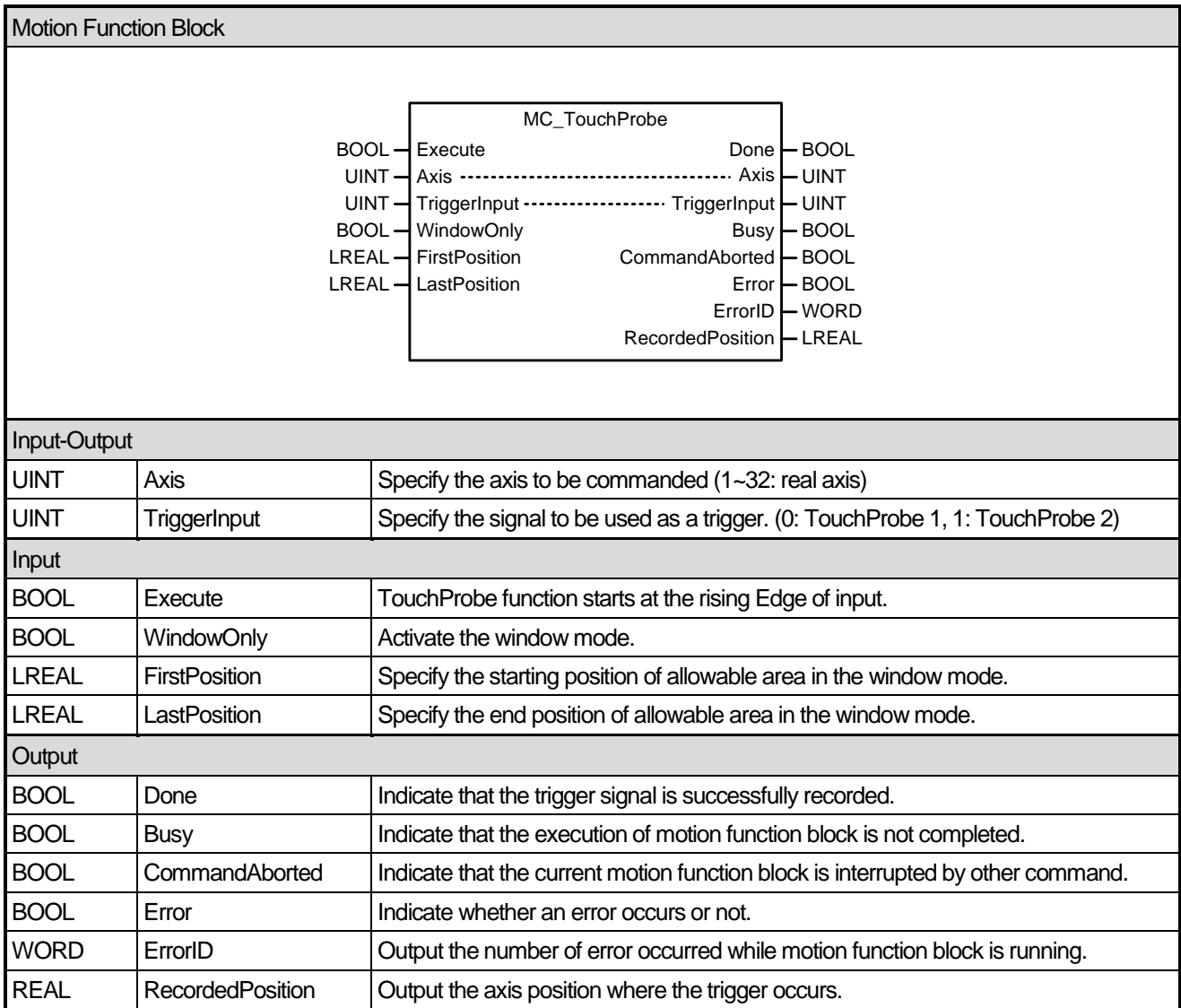
LREAL positive range:  $0 < x \leq 1.79769313486232e+308$

6.3.16 Reset axis error(MC\_Reset)



- (1) This motion function block is to reset the error of the relevant axis. When setting ErrorType to '0' and executing motion function block in case the relevant axis is in ' ErrorStop' state, every axis error is reset and the axis state is switched to 'StandStill' or 'Disabled' state.
- (2) If ErrorType is set to '1' and motion function block is executed, common error occurred in the relevant module is reset.
- (3) Motion function block is executed in the rising Edge of Execute input.

6.3.17 Touch Probe function(MC\_TouchProbe)

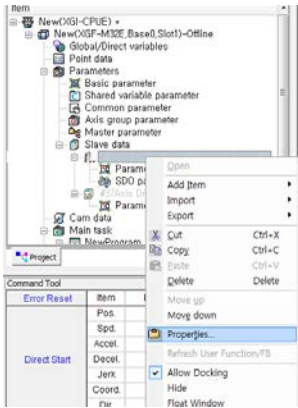


- (1) This motion function block is to execute 'TouchProbe' function which records the axis position at the time when the trigger event occurs.
- (2) TouchProbe function starts at the rising Edge of Execute input.
- (3) Specify the signal to be used as a trigger in TriggerInput. The value unable to be set causes "error 0x10E1".
- (4) When activating the window mode, allowable area where accepts the trigger signal of axis can be set. Operation timing of each signal when the window mode is activated is as below.

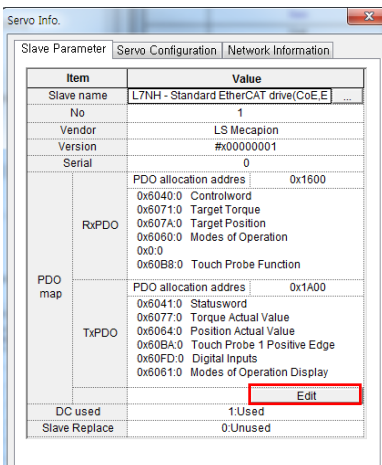
**Note**

In the case of using Touch Probe 2, please set the slave parameters before use.

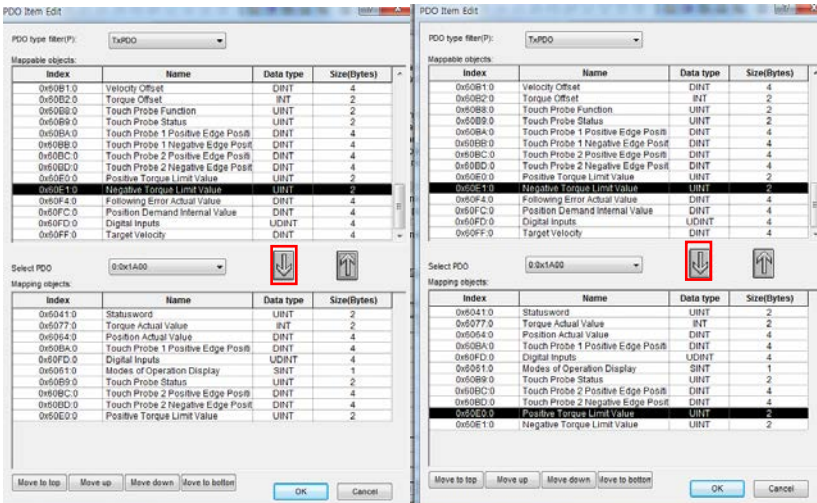
1. At XG-PM, click the registration information of the servo drive.

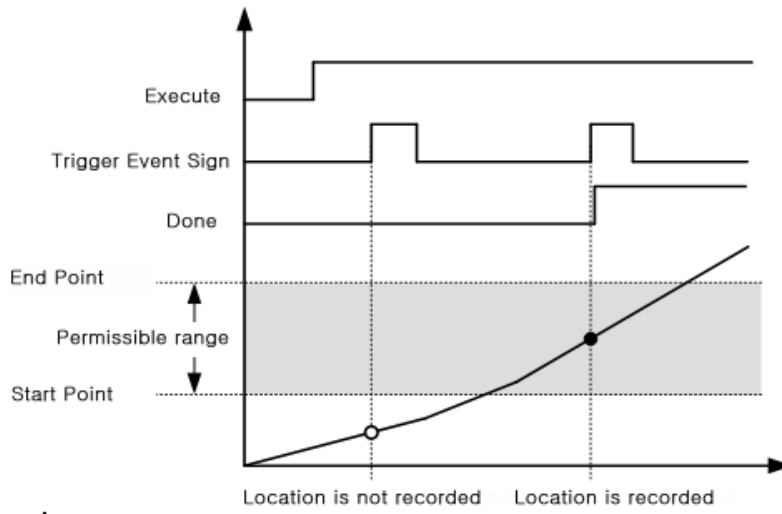


2. Select Edit at the slave information window.



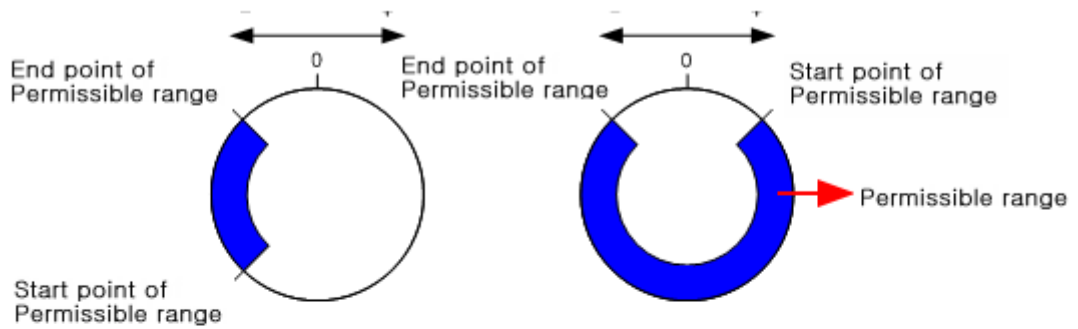
3. At the PDO edit window, select the forward direction position value for Touch Probe 2, and select the down arrow. For some servo drive, a PDO setting error (0xF22) may occur, preventing connection to the servo drive. In such a case, the number of PDOs selected should be adjusted (deselect unused PDOs) as shown on the right.



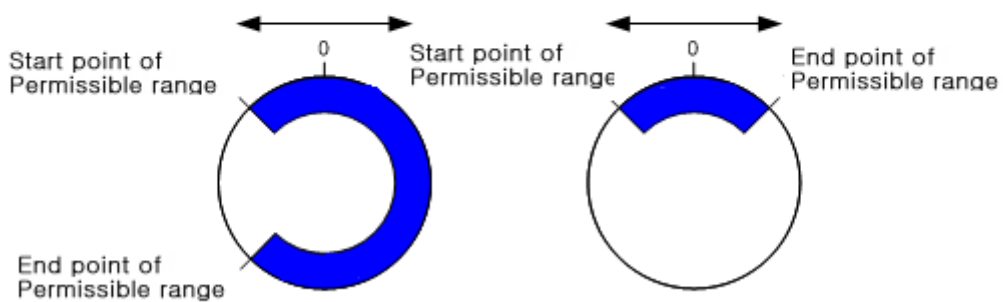


< In case TouchProbe function is the window mode, Operation timing >

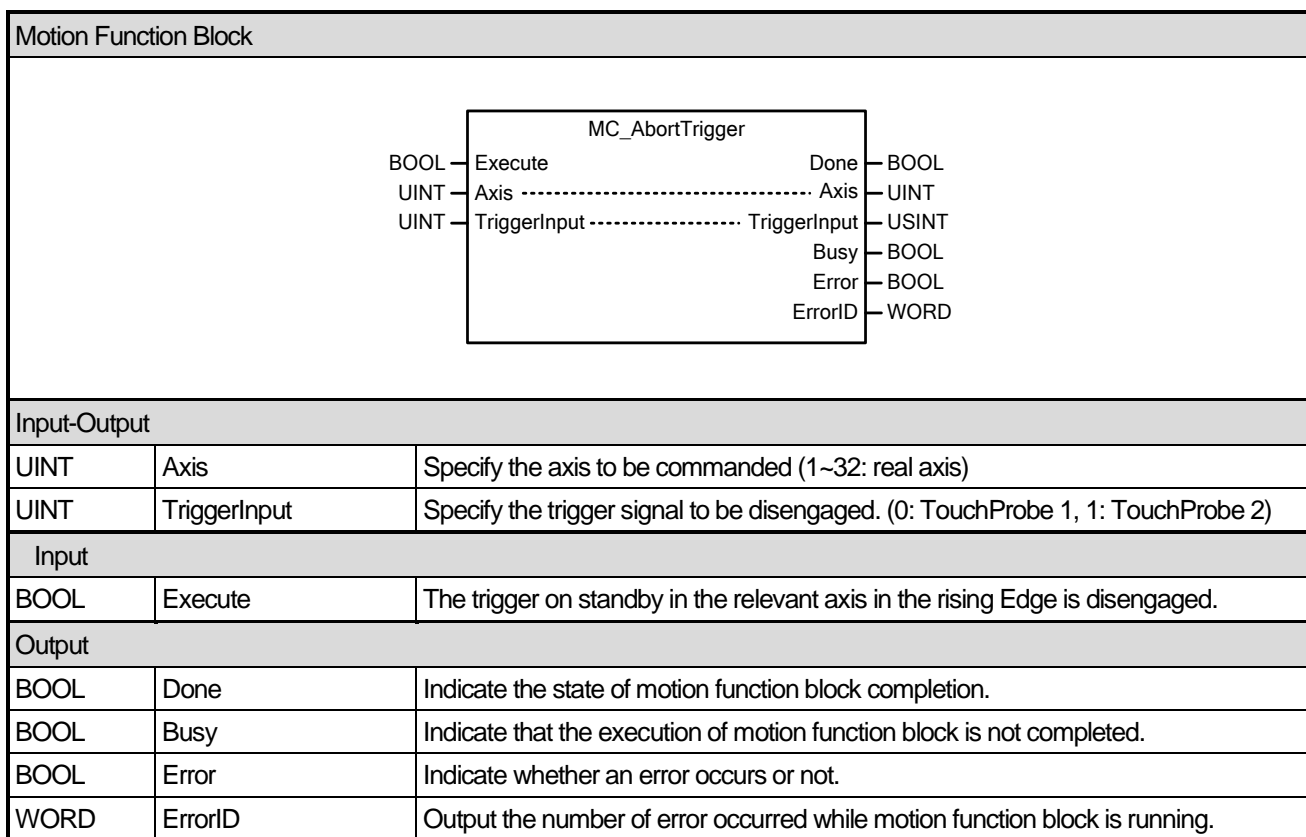
● In case of Permissible range start point < Permissible range end point



● In case of Permissible range start point > Permissible range end point

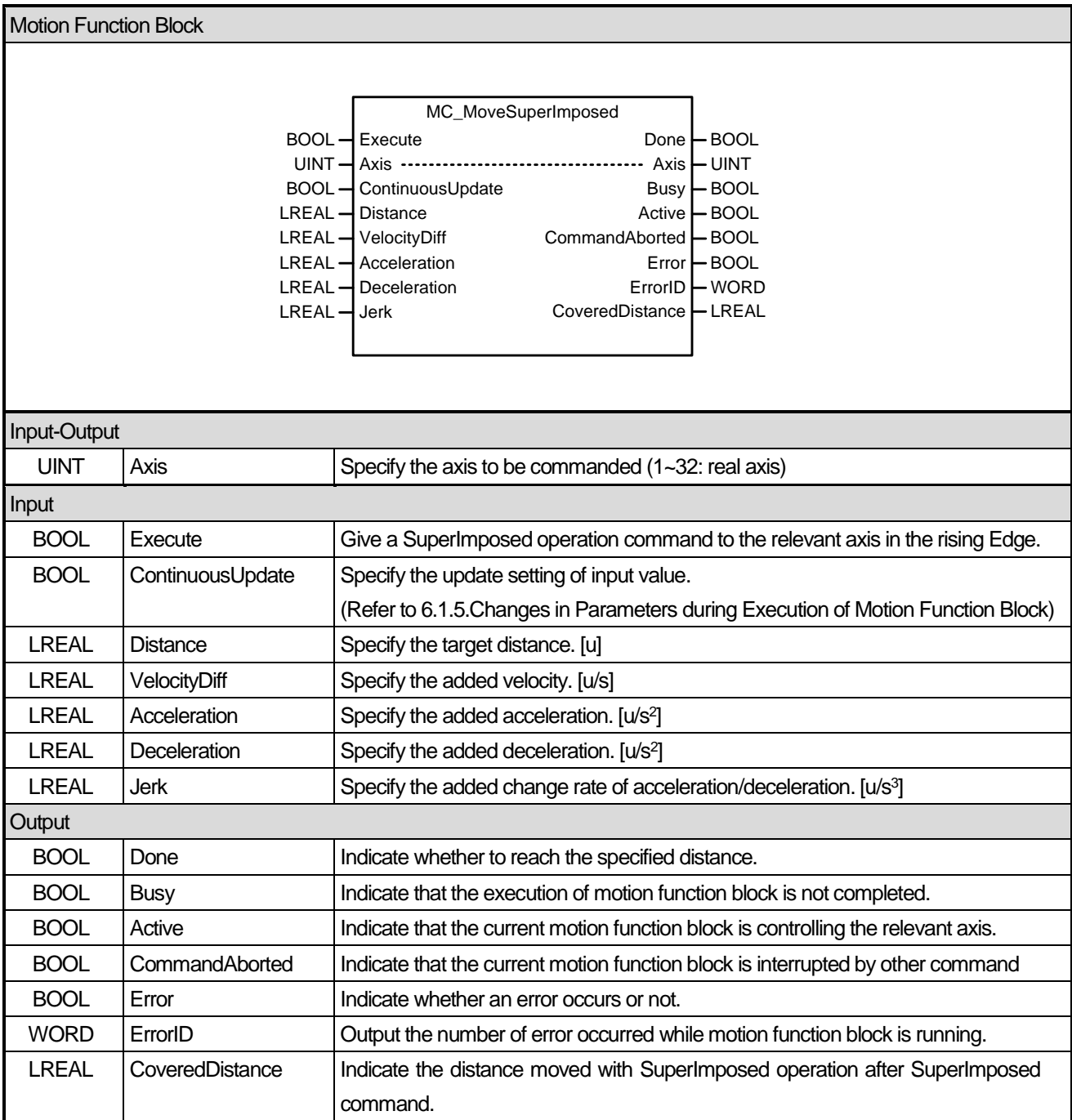


6.3.18 Abort trigger events(MC\_AbortTrigger)



- (1) This motion function block is to disengage the trigger which is on standby in the relevant axis.
- (2) Specify the trigger signal to be disengaged in TriggerInput. The value unable to be set causes "error 0x10E1".

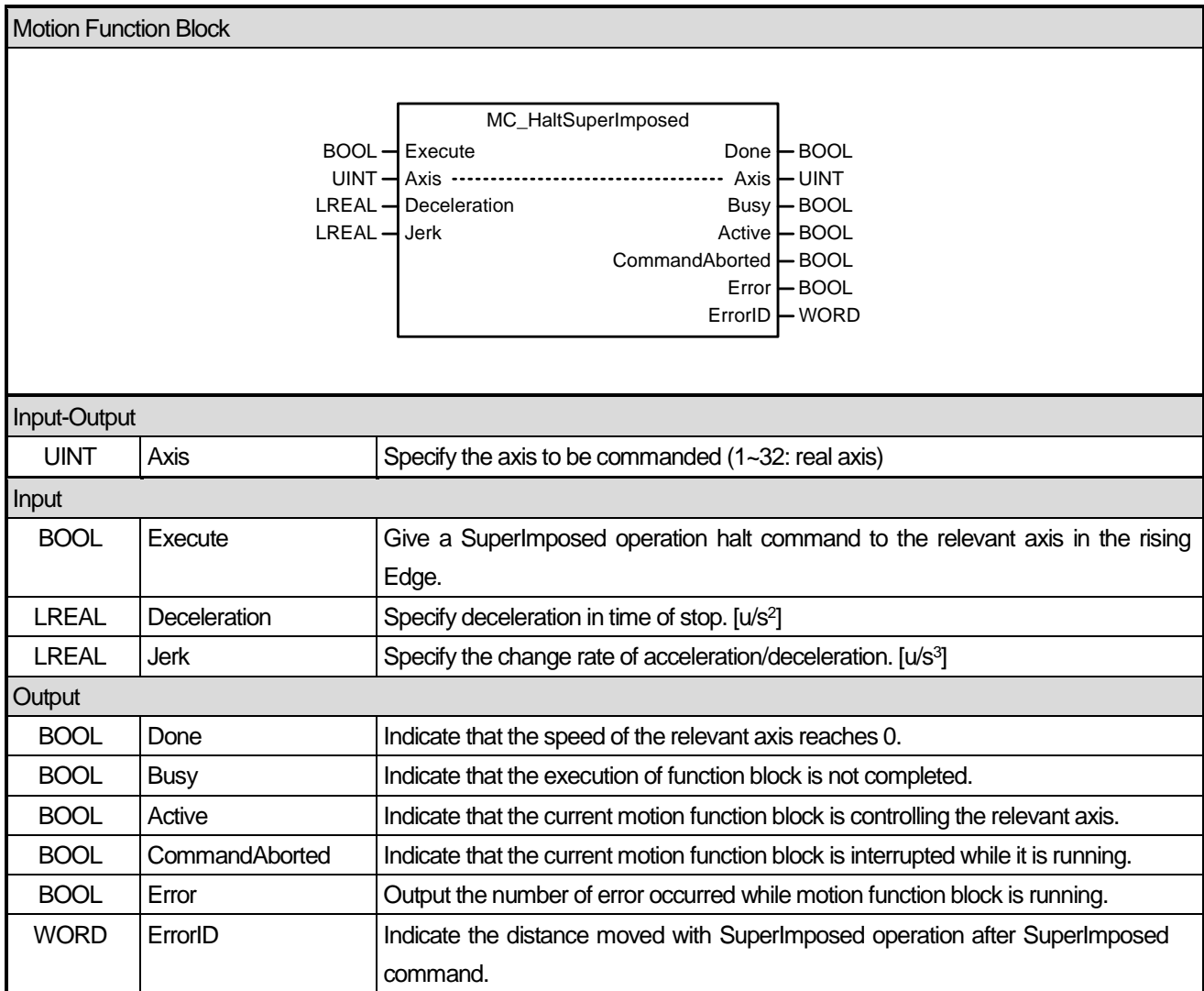
6.3.19 SuperImposed operation(MC\_MoveSuperImposed)



- (1) This motion function block is a command issuing aSuperImposed operation order to the relevant axis.
- (2) SuperImposed is a command ordering to move from the current position at the time of the command to the target distance set by Distance input.
- (3) The direction of the movement is determined by the positivity/negativity of the set distance. Positive distance (+ or no sign) means forward movement, and negative distance (-) means reverse movement.
- (4) After moving the target distance, when the velocity reaches 0, the command is completed and Doneoutput is on.

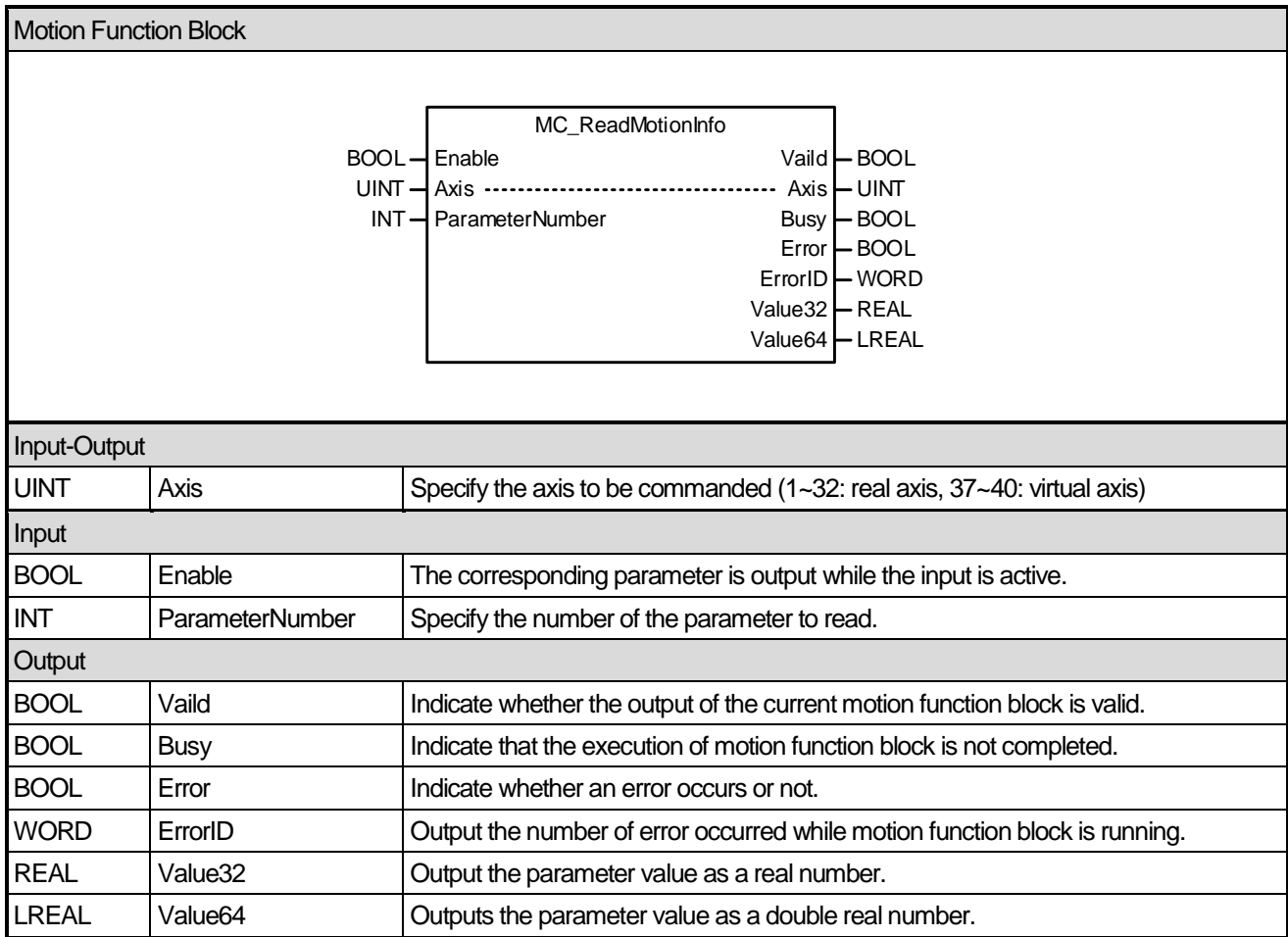


6.3.20 Halt SuperImposed(MC\_HaltSuperImposed)



- (1) This motion function block is a command issuing an order to halt SuperImposed operation to the relevant axis.
- (2) Halt command for SuperImposed operation is a command ordering to decelerate and halt at a given acceleration and jerk at the time of performing the command.
- (3) After moving the target distance, when the velocity reaches 0, the command is completed and Done output is on.

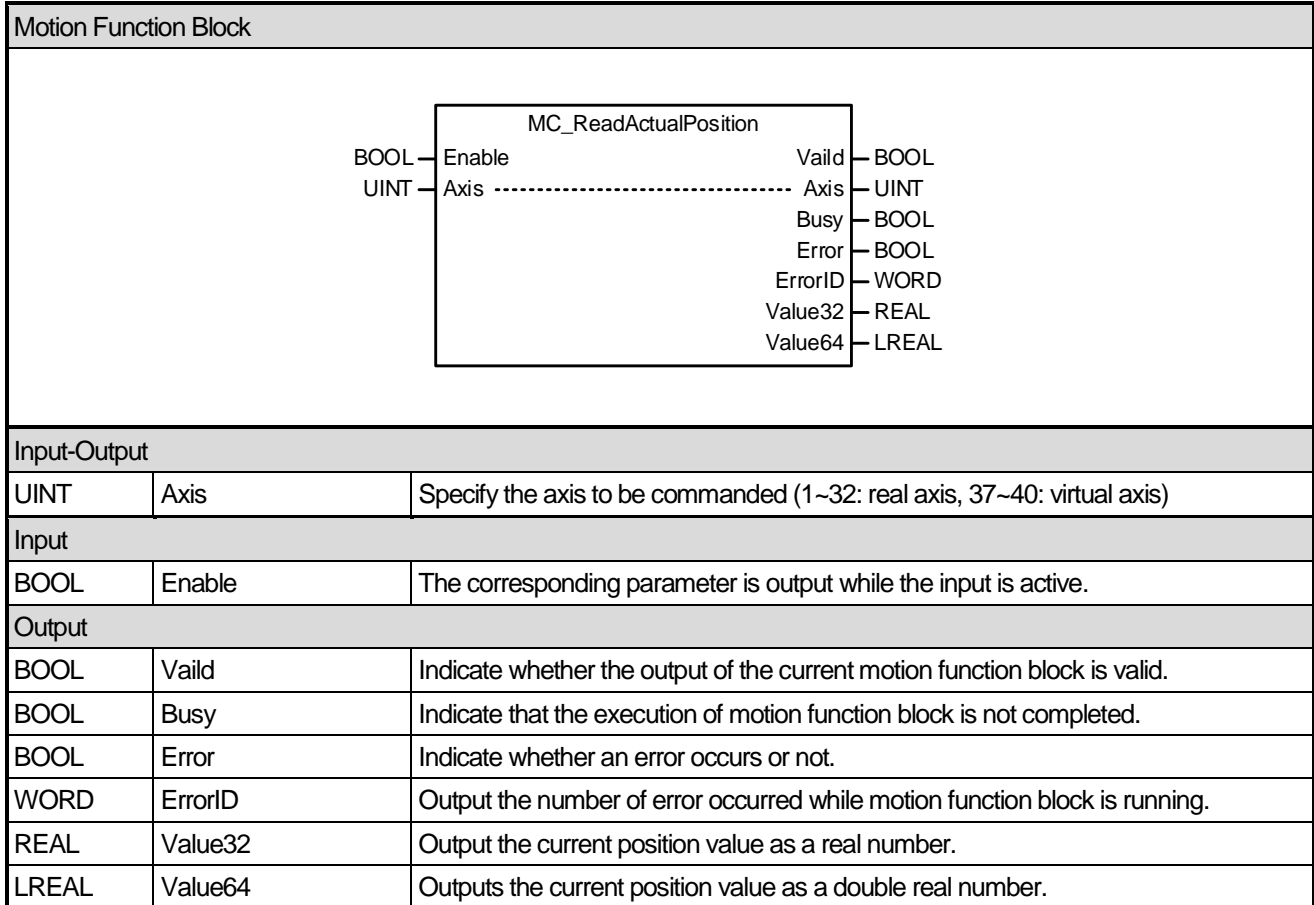
6.3.21 Read motion information (MC\_ReadMotionInfo)



- (1) This command is a motion function block that outputs motion information of the relevant axis.
- (2) While the Enable input is On, the value of the corresponding parameter is continuously output to Value32 and Value64.
- (3) For ParameterNumber input, specify the number of the parameter to be read. The number of axis parameter is as follows.

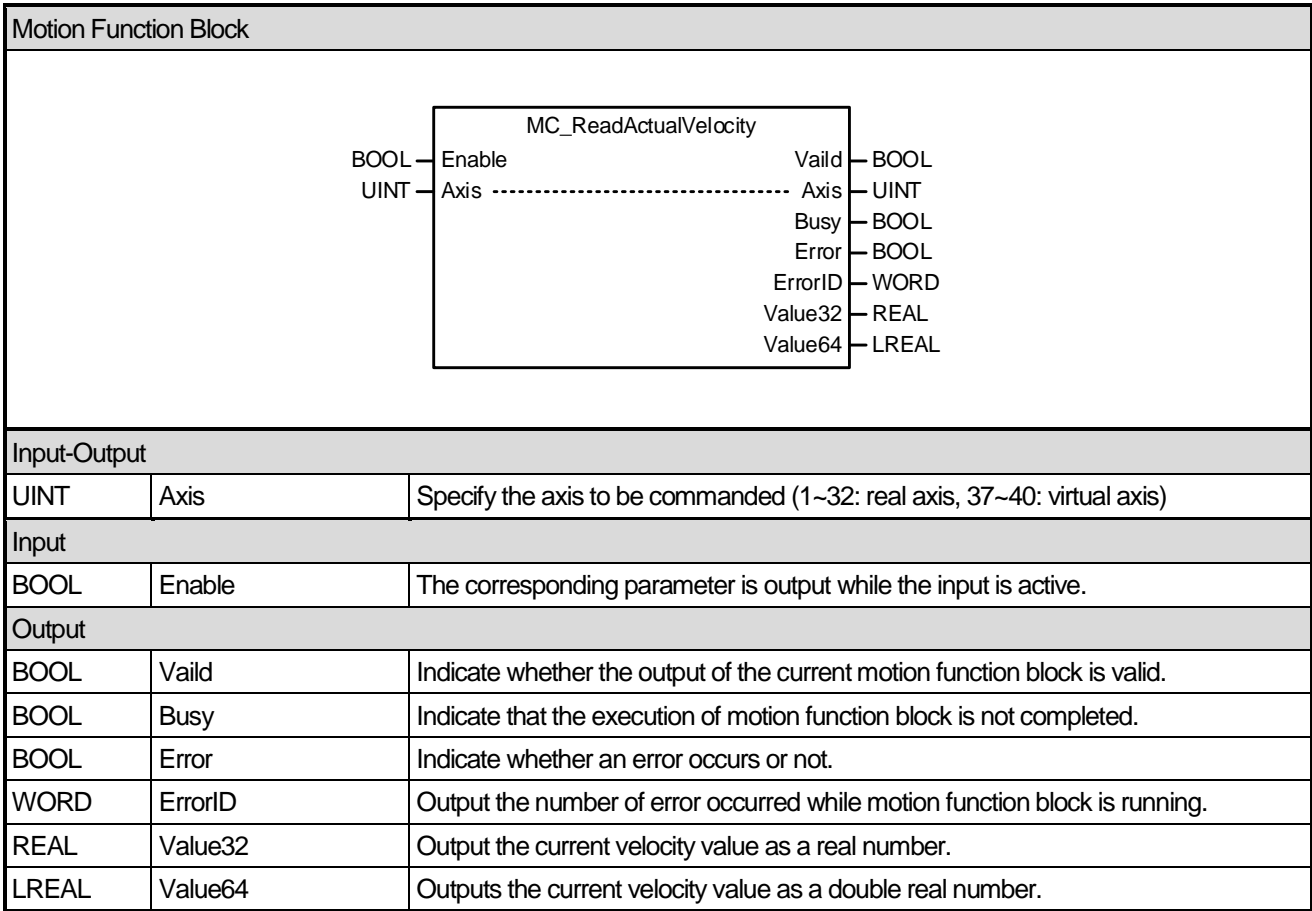
No.	Content	Remark	OS
0	Current Position	Unit	V1.30
1	Command Position	Unit	V1.30
2	Current Velocity	Unit/sec	V1.30
3	Command Velocity	Unit/sec	V1.30
4	Current Torque	% Of rated torque	V1.30
5	Command Torque	% Of rated torque	V1.30

6.3.22 Read actual position (MC\_ReadActualPosition)



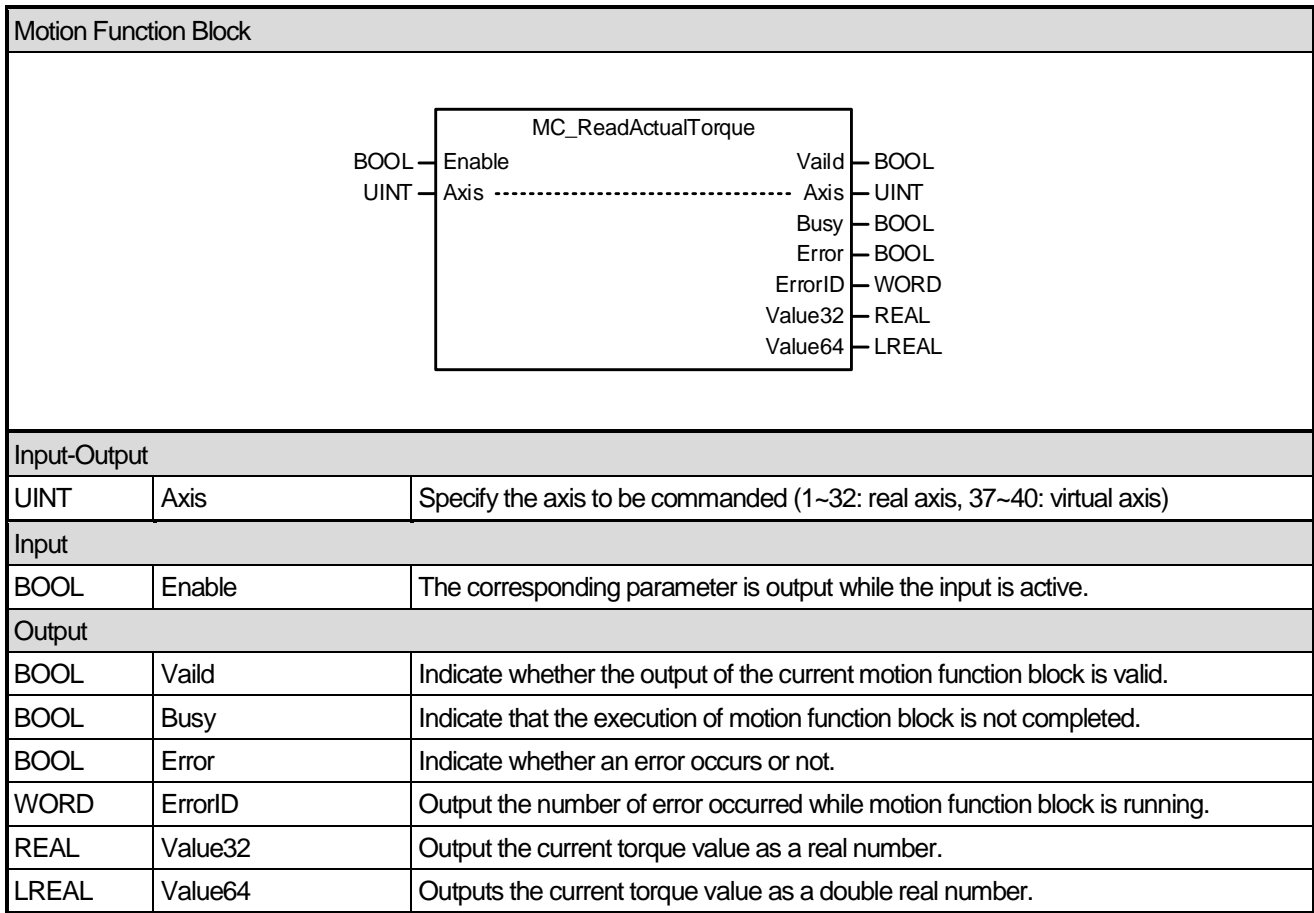
- (1) This command is a motion function block that outputs the current position of the relevant axis.
- (2) While the Enable input is On, the value of the corresponding parameter is continuously output to Value32 and Value64.

6.3.23 Read actual velocity (MC\_ReadActualVelocity)



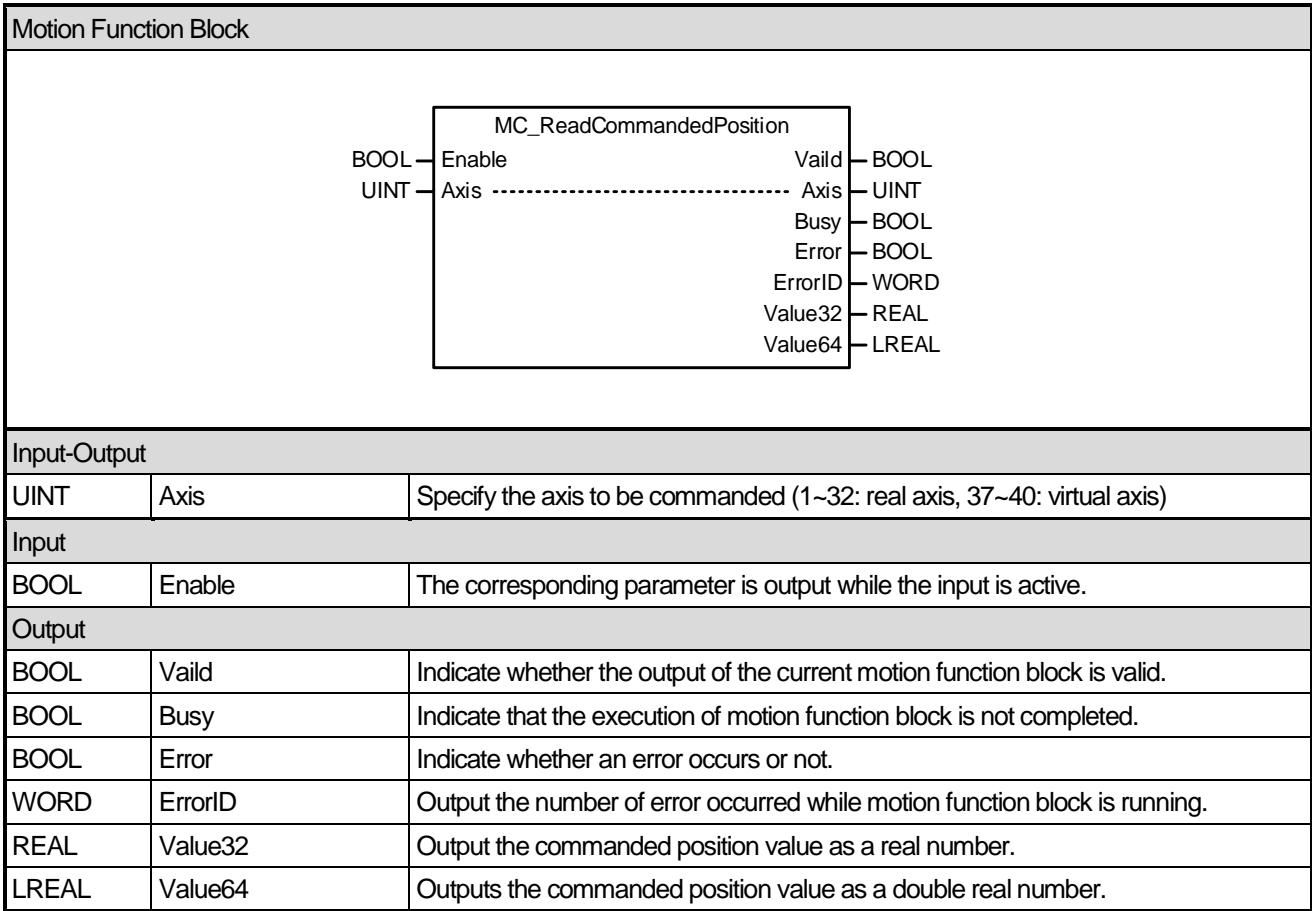
- (1) This command is a motion function block that outputs the current velocity of the relevant axis.
- (2) While the Enable input is On, the value of the corresponding parameter is continuously output to Value32 and Value64.

6.3.24 Read actual torque (MC\_ReadActualTorque)



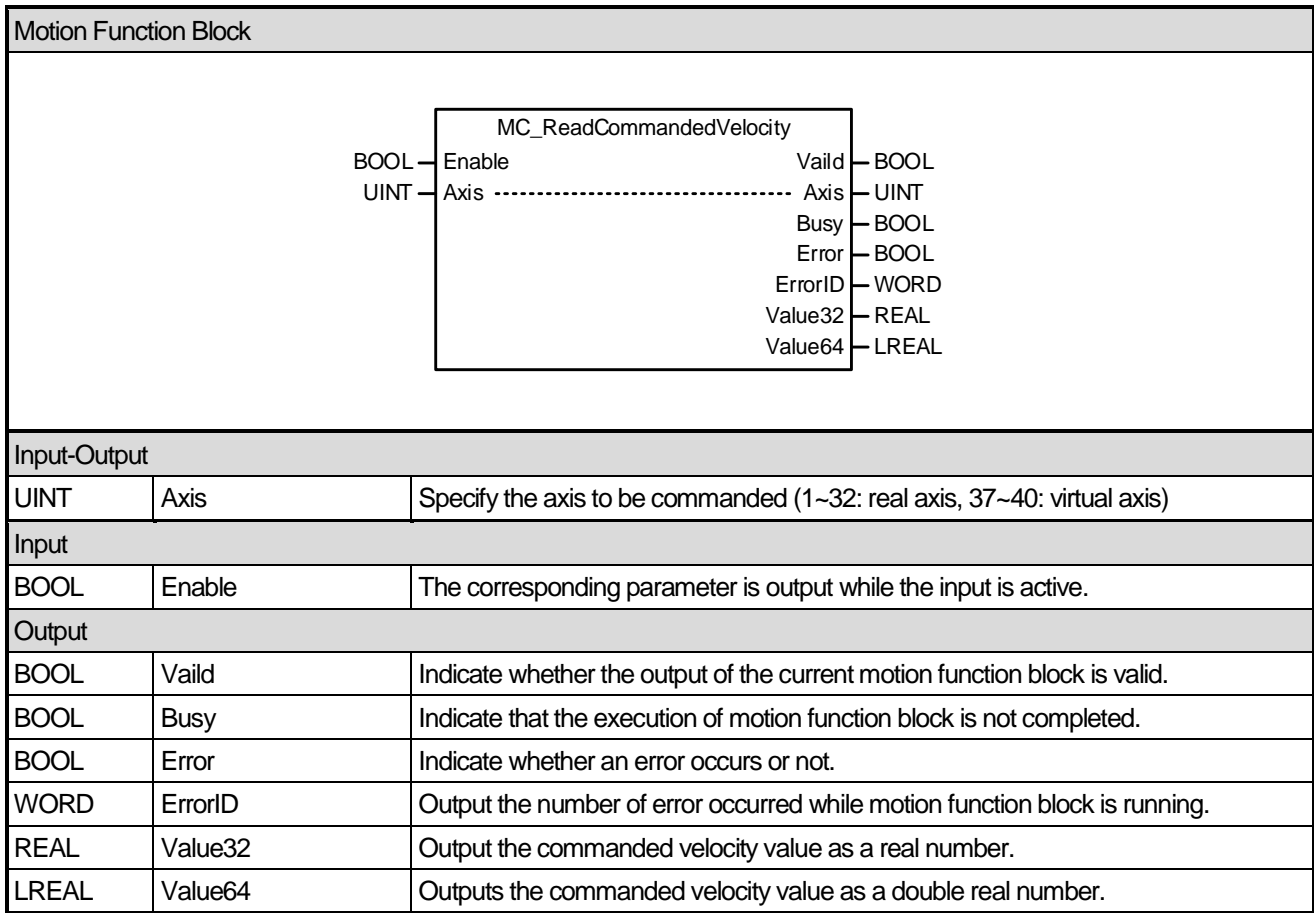
- (1) This command is a motion function block that outputs the current torque of the relevant axis.
- (2) While the Enable input is On, the value of the corresponding parameter is continuously output to Value32 and Value64.

6.3.25 Read commanded position (MC\_ReadCommandedPosition)



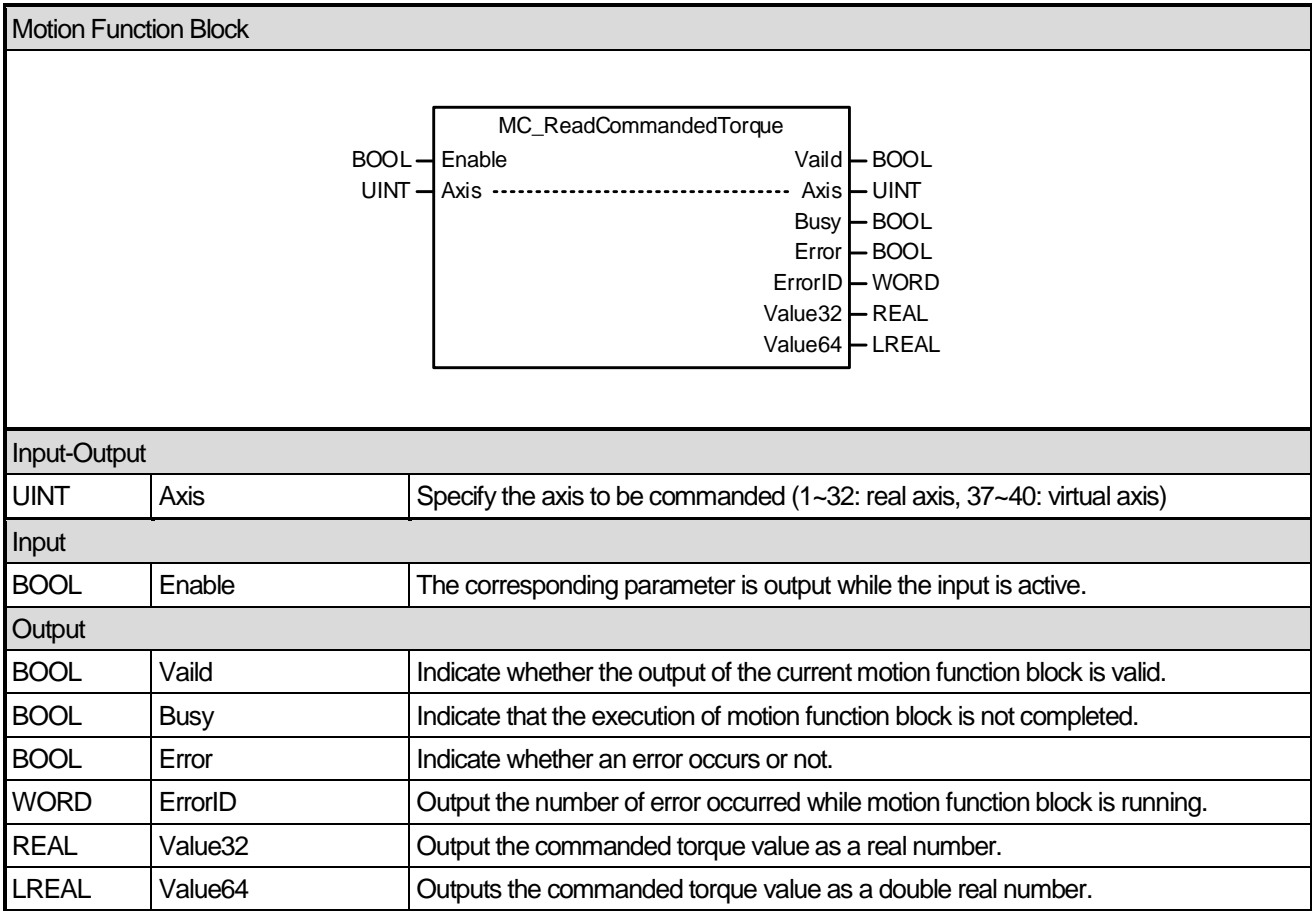
- (1) This command is a motion function block that outputs the commanded position of the relevant axis.
- (2) While the Enable input is On, the value of the corresponding parameter is continuously output to Value32 and Value64.

6.3.26 Read commanded velocity (MC\_ReadCommandedVelocity)



- (1) This command is a motion function block that outputs the commanded velocity of the relevant axis.
- (2) While the Enable input is On, the value of the corresponding parameter is continuously output to Value32 and Value64.

6.3.27 Read commanded torque (MC\_ReadCommandedTorque)



- (1) This command is a motion function block that outputs the commanded torque of the relevant axis.
- (2) While the Enable input is On, the value of the corresponding parameter is continuously output to Value32 and Value64.



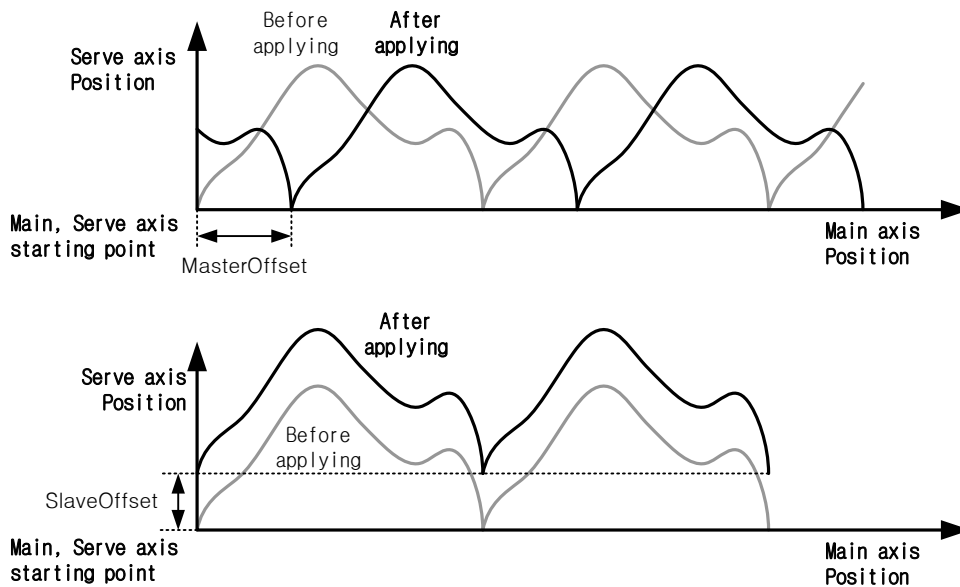
## 6.4 Multi-Axis Motion Function Block

### 6.4.1 Camming run(MC\_CamIn)

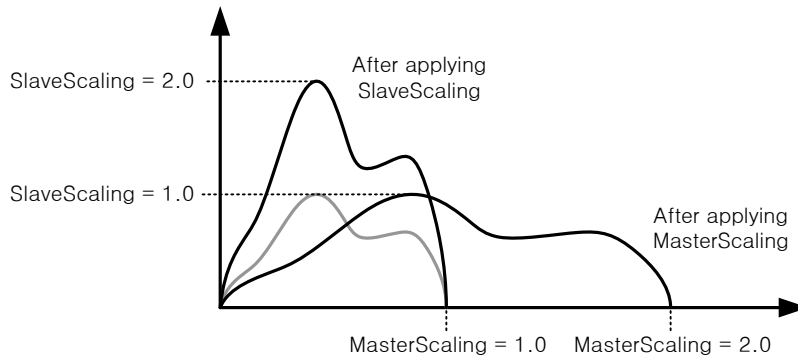
Motion Function Block																																																																								
<div style="border: 1px solid black; padding: 10px; margin: 0 auto; width: fit-content;"> <p style="text-align: center; margin: 0;">MC_CamIn</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%; border-right: 1px solid black; padding: 2px;">BOOL</td> <td style="padding: 2px;">Execute</td> <td style="width: 30%; padding: 2px;"></td> <td style="padding: 2px;">InSync</td> <td style="width: 30%; border-left: 1px solid black; padding: 2px;">BOOL</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">UINT</td> <td style="padding: 2px;">Master</td> <td style="padding: 2px;">-----</td> <td style="padding: 2px;">Master</td> <td style="border-left: 1px solid black; padding: 2px;">UINT</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">UINT</td> <td style="padding: 2px;">Slave</td> <td style="padding: 2px;">-----</td> <td style="padding: 2px;">Slave</td> <td style="border-left: 1px solid black; padding: 2px;">UINT</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">LREAL</td> <td style="padding: 2px;">ContinuousUpdate</td> <td style="padding: 2px;"></td> <td style="padding: 2px;">Busy</td> <td style="border-left: 1px solid black; padding: 2px;">BOOL</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">LREAL</td> <td style="padding: 2px;">MasterOffset</td> <td style="padding: 2px;"></td> <td style="padding: 2px;">Active</td> <td style="border-left: 1px solid black; padding: 2px;">BOOL</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">LREAL</td> <td style="padding: 2px;">SlaveOffset</td> <td style="padding: 2px;">CommandAborted</td> <td style="padding: 2px;"></td> <td style="border-left: 1px solid black; padding: 2px;">BOOL</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">LREAL</td> <td style="padding: 2px;">MasterScaling</td> <td style="padding: 2px;"></td> <td style="padding: 2px;">Error</td> <td style="border-left: 1px solid black; padding: 2px;">BOOL</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">LREAL</td> <td style="padding: 2px;">SlaveScaling</td> <td style="padding: 2px;"></td> <td style="padding: 2px;">ErrorID</td> <td style="border-left: 1px solid black; padding: 2px;">WORD</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">LREAL</td> <td style="padding: 2px;">MasterStartDistance</td> <td style="padding: 2px;">EndOfProfile</td> <td style="padding: 2px;"></td> <td style="border-left: 1px solid black; padding: 2px;">BOOL</td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">LREAL</td> <td style="padding: 2px;">MasterSyncPosition</td> <td style="padding: 2px;"></td> <td style="padding: 2px;"></td> <td style="border-left: 1px solid black; padding: 2px;"></td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">UINT</td> <td style="padding: 2px;">StartMode</td> <td style="padding: 2px;"></td> <td style="padding: 2px;"></td> <td style="border-left: 1px solid black; padding: 2px;"></td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">UINT</td> <td style="padding: 2px;">MasterValueSource</td> <td style="padding: 2px;"></td> <td style="padding: 2px;"></td> <td style="border-left: 1px solid black; padding: 2px;"></td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">UINT</td> <td style="padding: 2px;">CamTableID</td> <td style="padding: 2px;"></td> <td style="padding: 2px;"></td> <td style="border-left: 1px solid black; padding: 2px;"></td> </tr> <tr> <td style="border-right: 1px solid black; padding: 2px;">UINT</td> <td style="padding: 2px;">BufferMode</td> <td style="padding: 2px;"></td> <td style="padding: 2px;"></td> <td style="border-left: 1px solid black; padding: 2px;"></td> </tr> </table> </div>			BOOL	Execute		InSync	BOOL	UINT	Master	-----	Master	UINT	UINT	Slave	-----	Slave	UINT	LREAL	ContinuousUpdate		Busy	BOOL	LREAL	MasterOffset		Active	BOOL	LREAL	SlaveOffset	CommandAborted		BOOL	LREAL	MasterScaling		Error	BOOL	LREAL	SlaveScaling		ErrorID	WORD	LREAL	MasterStartDistance	EndOfProfile		BOOL	LREAL	MasterSyncPosition				UINT	StartMode				UINT	MasterValueSource				UINT	CamTableID				UINT	BufferMode			
BOOL	Execute		InSync	BOOL																																																																				
UINT	Master	-----	Master	UINT																																																																				
UINT	Slave	-----	Slave	UINT																																																																				
LREAL	ContinuousUpdate		Busy	BOOL																																																																				
LREAL	MasterOffset		Active	BOOL																																																																				
LREAL	SlaveOffset	CommandAborted		BOOL																																																																				
LREAL	MasterScaling		Error	BOOL																																																																				
LREAL	SlaveScaling		ErrorID	WORD																																																																				
LREAL	MasterStartDistance	EndOfProfile		BOOL																																																																				
LREAL	MasterSyncPosition																																																																							
UINT	StartMode																																																																							
UINT	MasterValueSource																																																																							
UINT	CamTableID																																																																							
UINT	BufferMode																																																																							
Input-Output																																																																								
UINT	Master	Set the main axis. (1~32: Actual axes, 37~40: Virtual axes, 41~42: Encoders)																																																																						
UINT	Slave	Set the the serve axis. (1~32: Actual axes, 37~40: Virtual axes)																																																																						
Input																																																																								
BOOL	Execute	Give cam operation command to the relevant axis in the rising Edge.																																																																						
BOOL	ContinuousUpdate	Specify the update setting of input value. (Refer to 6.1.5.Changes in Parameters during Execution of Motion Function Block)																																																																						
LREAL	MasterOffset	Set the offset value of the main axis.																																																																						
LREAL	SlaveOffset	Set the offset value of the the serve axis cam table.																																																																						
LREAL	MasterScaling	Specify the magnification of the main axis.																																																																						
LREAL	SlaveScaling	Specify the magnification of the serve axis cam table.																																																																						
LREAL	MasterStartDistance	Specify the position of the main axis where cam operation of the slave.																																																																						
LREAL	MasterSyncPosition	Specify the starting point at cam table when cam operation starts.																																																																						
UINT	StartMode	Set the cam operation mode. 0 : Cam table is applied as an absolute value (mcAbsolute) 1: Cam table is applied as a relative value based on the command starting point (mcRelative)																																																																						
UINT	MasterValueSource	Select the source of the main axis for cam operation. 0 : Synchronized in the target value of the main axis.																																																																						

		1 : Synchronized in the current value of the serve axis.
UINT	CamTableID	Specify the cam table to operate.
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)
Output		
BOOL	InSync	Indicate that cam operation is normally being fulfilled. (Indicate that the serve axis is following the cam table.)
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.
BOOL	EndOfProfile	Indicates that the end of the currently running cam has been reached.

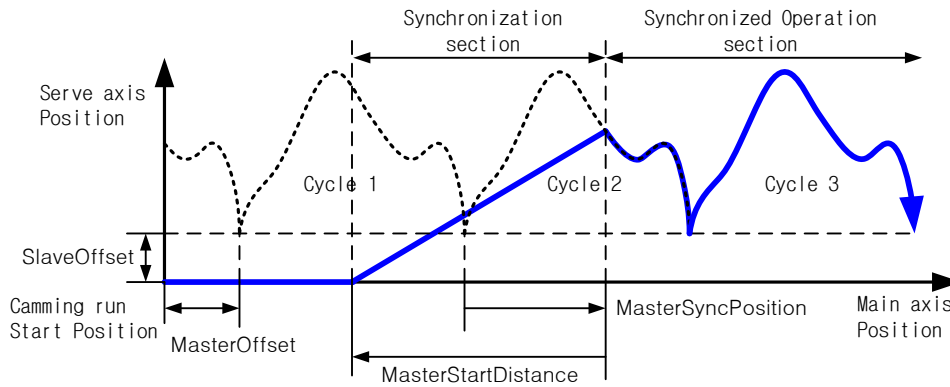
- (1) This motion function block is to operate the serve axis cam depending on the main axis.
- (2) Cam operation command can be given to the serve axis even if the main axis is in stop state.
- (3) You must give cam operation abort (MC\_CamOut) command to the serve axis or operate other motion function block to stop cam operation.
- (4) The axis is in 'Synchronized Motion' while this motion function block is running.
- (5) Set the offset of cam table to be applied in MasterOffset and SlaveOffset. MasterOffset sets the offset with the starting point of the main axis, and SlaveOffset sets the offset with the starting point of the serve axis. Refer to the Figure below.



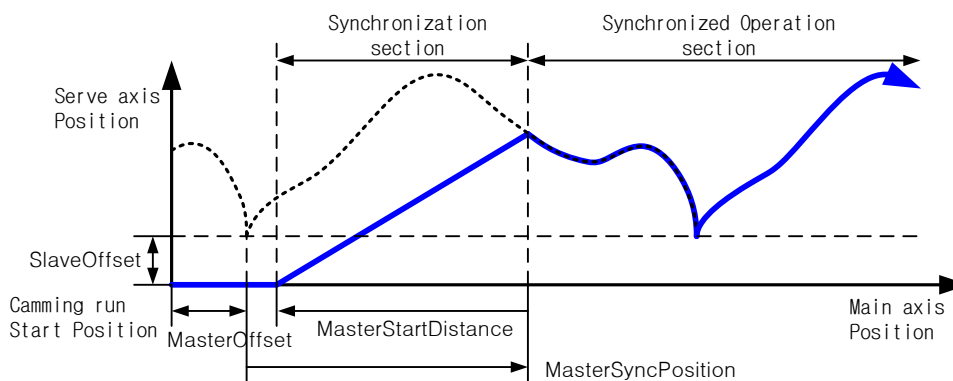
- (6) Set the magnification of cam data to be applied in MasterScaling and SlaveScaling. Set the magnification of the main axis data in MasterScaling, and set the magnification of the the serve axis data. Refer to the Figure below.



- (7) MasterSyncPosition input specifies the position of the main axis within the table where the synchronization of actual cam operation is completed, and MasterStartDistance input specifies the relative position of the main axis where the synchronization starts. If unable to start synchronized operation at Cycle 1 as shown below (if the distance from the start position to the synchronized operation start position is shorter than MasterStartDistance), synchronized operation starts at Cycle 2.



In case MasterScaling is 1.0



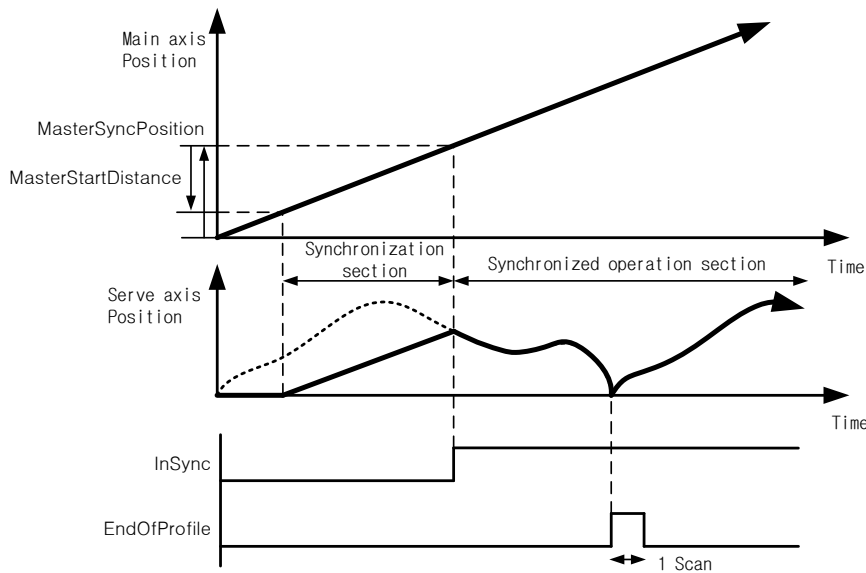
In case MasterScaling is 2.0

MasterSyncPosition position is based on the position within the cam table, and actual synchronization position is decided by considering MasterOffset and MasterScale parameters.

The serve axis starts moving to the synchronization position from the distance of the input value away based on the position where MasterSyncPosition is actually applied. If it is before starting moving, the serve axis waits at the relevant position in stop state, and if the serve axis is already in the section to move to the synchronization position at the beginning of the command, take back the position of the synchronization starting point by the length of a table until it escapes the MasterStartDistance range.

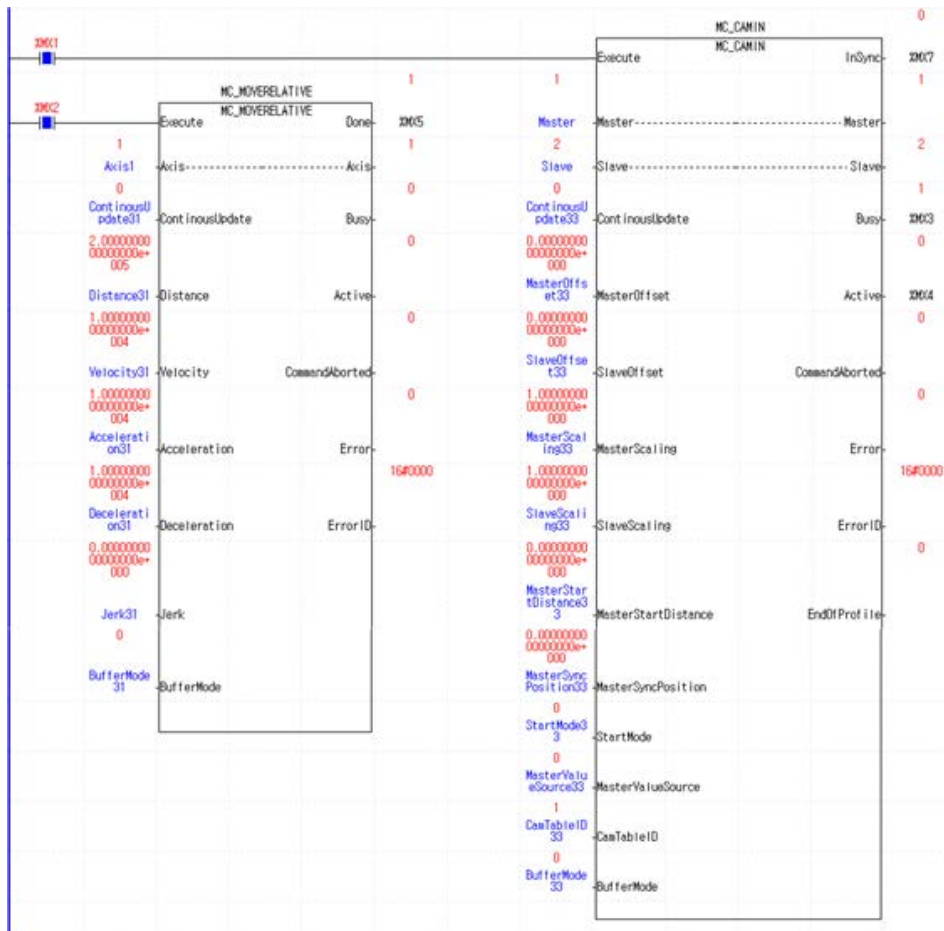
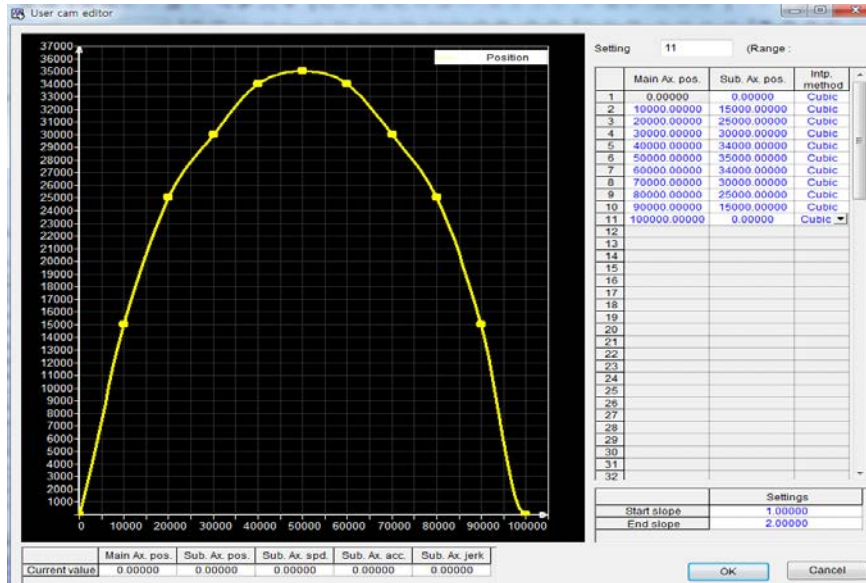
Actual synchronization position can vary depending on MasterScaling and SlaveScaling because MasterSyncPosition is a value based on the inside of cam table, but MasterOffset and MasterStartDistance value remain unaffected.

- (8) If the ContinuousUpdate input is On, the changed parameter can be applied.  
Only MasterOffset, SlaveOffset, MasterScaling, SlaveScaling, MasterStartDistance, MasterSyncPosition can be updated (However, In InSync=On case, MasterOffset, SlaveOffset, MasterScaling, SlaveScaling can be updated).
- (9) Once cam operation starts normally, InSync output is On, and EndOfProfile output is 1 scan On every time one cam table operation is completed.

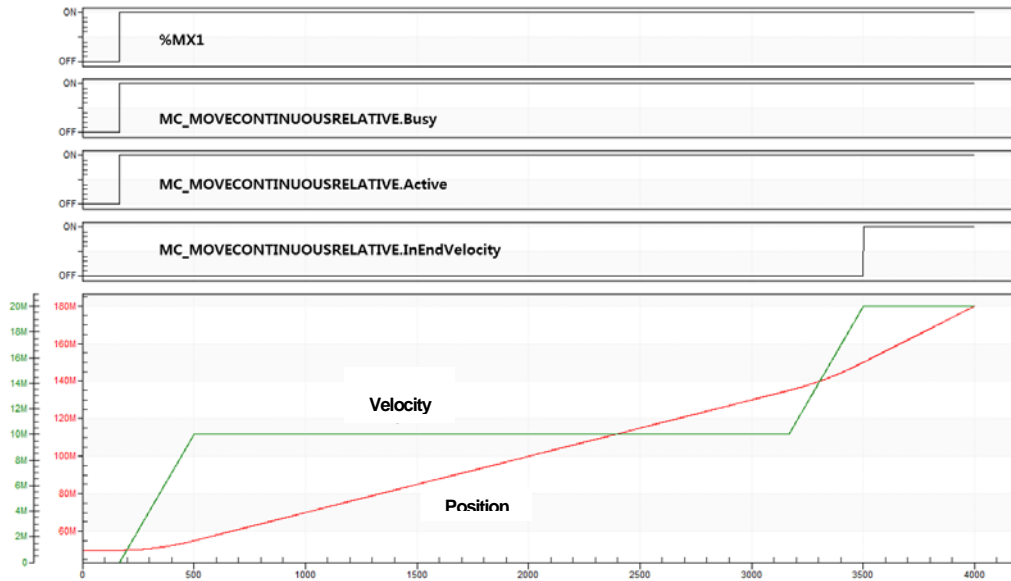


- (10) Cam operation mode is set in StartMode. Setting range is 0 or 1, and the input value outside the setting range causes an error.
- (11) MasterValueSource selects the source of the main axis to be synchronized. If it is set to 0, the serve axis performs cam operation based on the command position of the main axis which is calculated in motion control module, and if it is set to 1, the serve axis performs cam operation based on the current position which is received by communication in servo drive of main axis.
- (12) CamTableID sets the number of cam table to be applied to cam operation. Setting range is 1~32 , and the input value outside the setting range causes error "0x1115" in motion function block.
- (13) The relevant axis is in "SynchronizedMotion" state while this motion function block is running.
- (14) Example program  
This example shows the movement of the main-axis from 0 to 200,000 positions after generating a cam profile and then executing MC\_CAMIN command on the sub-axis.

(a) Function block setting



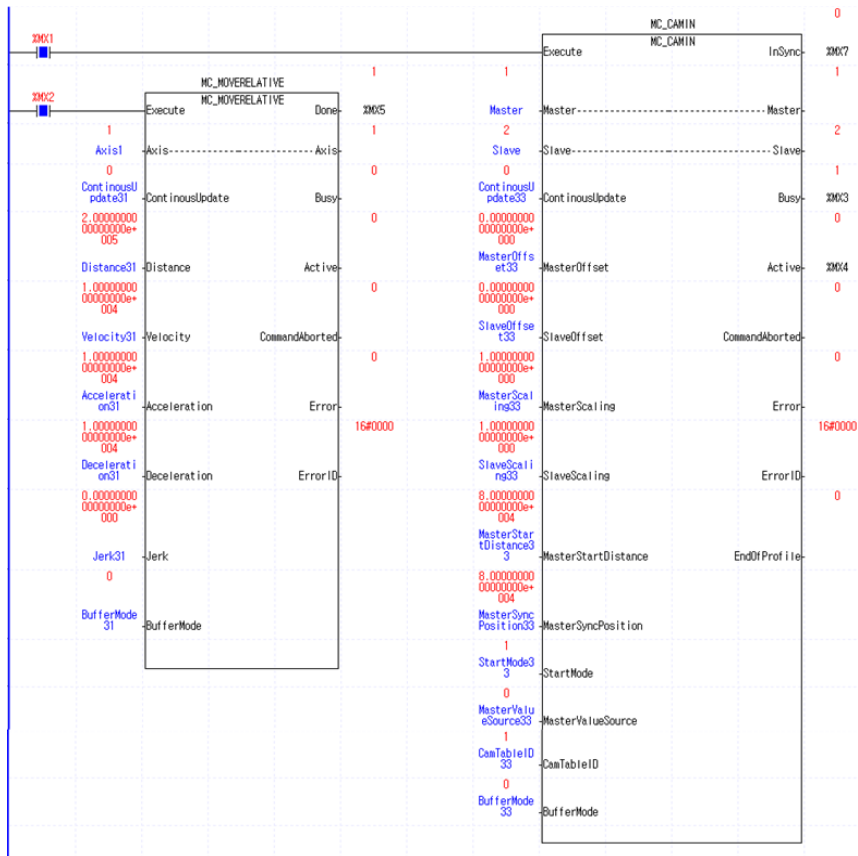
(b) Timing diagram



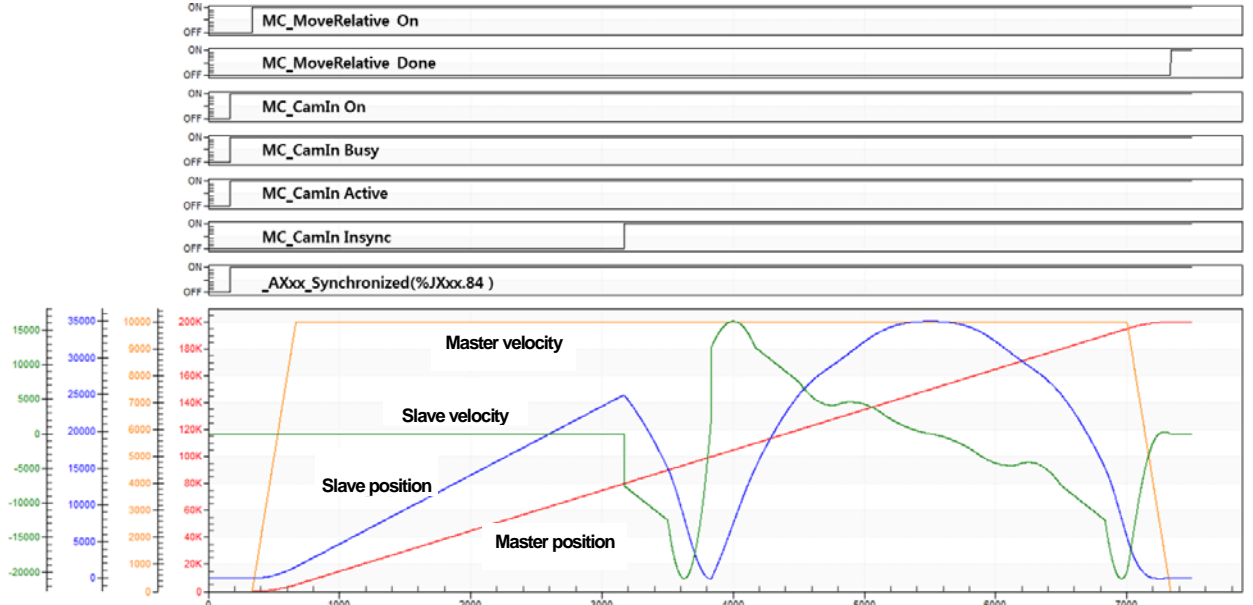
(15) Application example program

This example shows the movement of the main-axis from 0 to 200,000 positions after generating the same profile and then executing C\_CAMIN command where MasterSyncPosition and MasterSyncDistance are set to 80,000 in sub-axis.

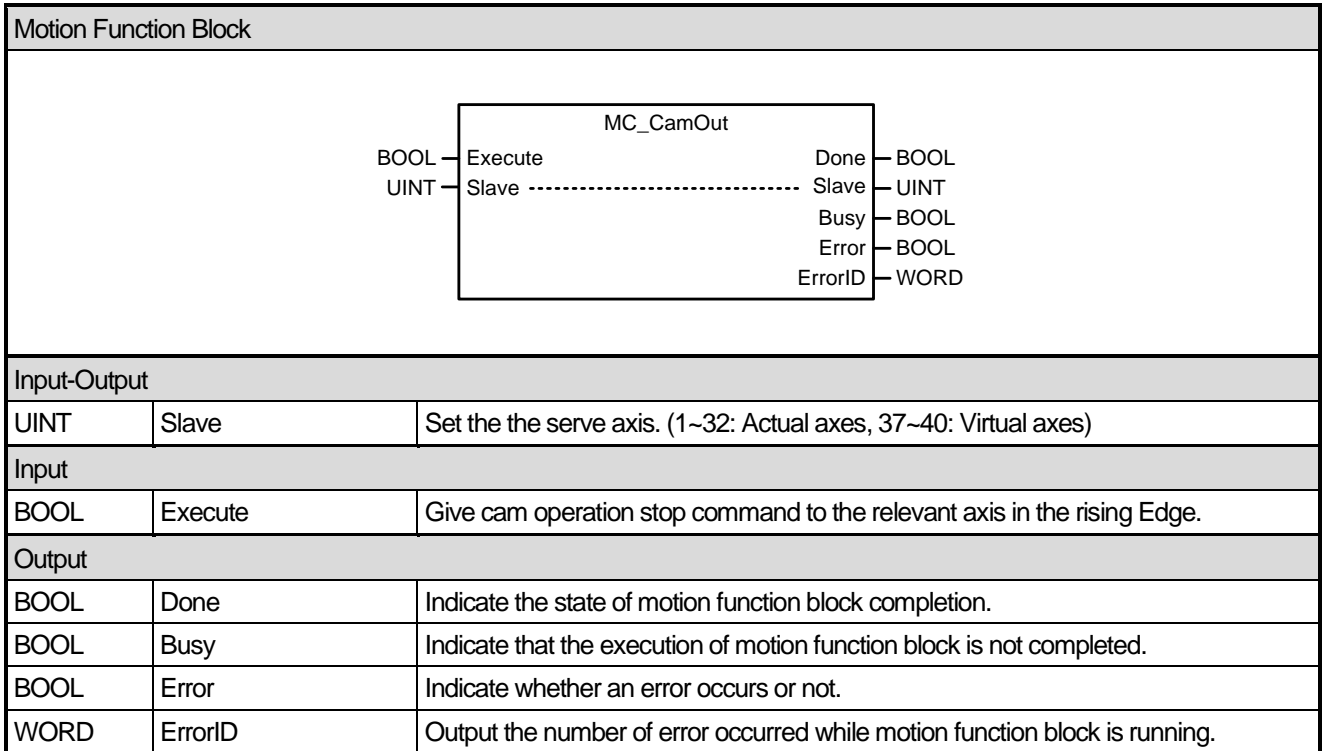
(a) Function block setting



(b) Timing diagram



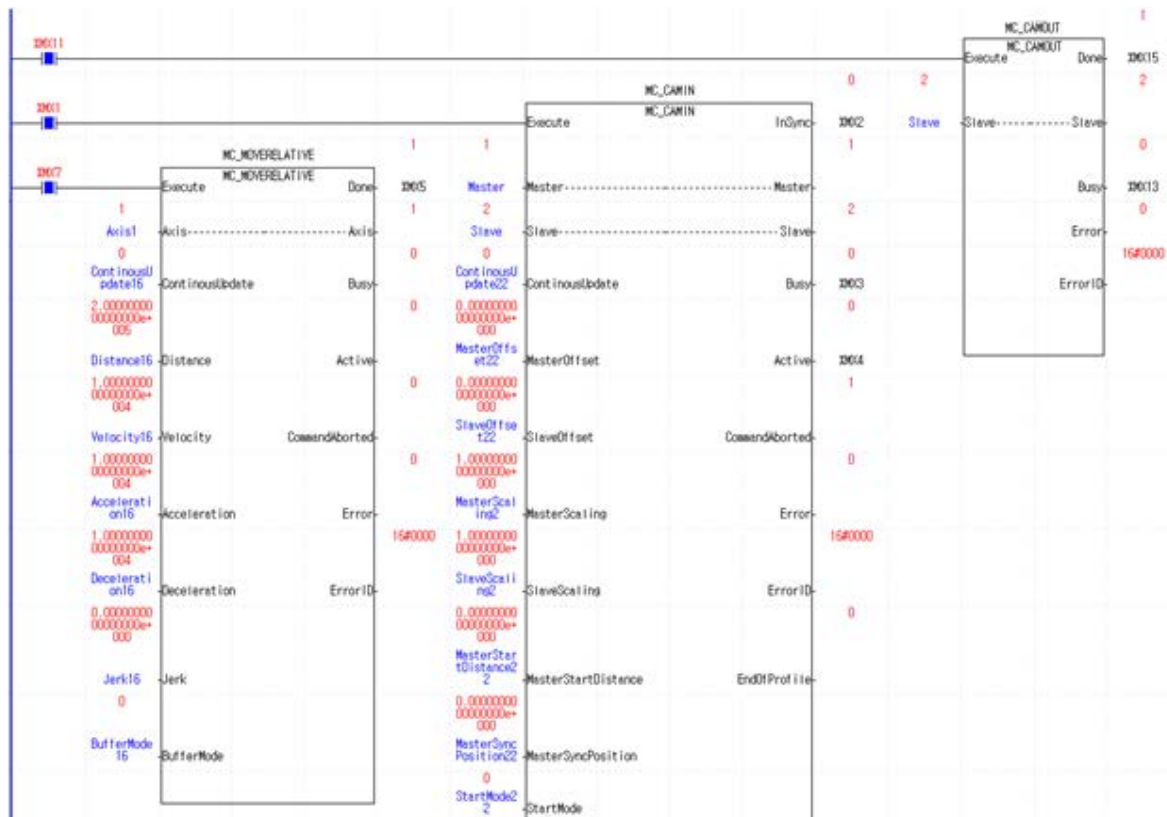
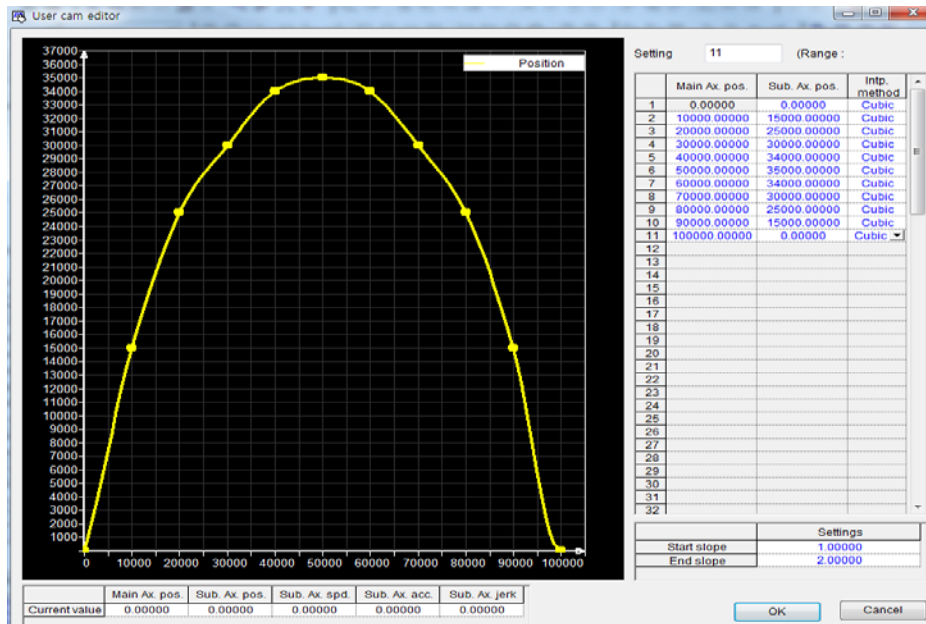
6.4.2 Camming stop(MC\_CamOut)



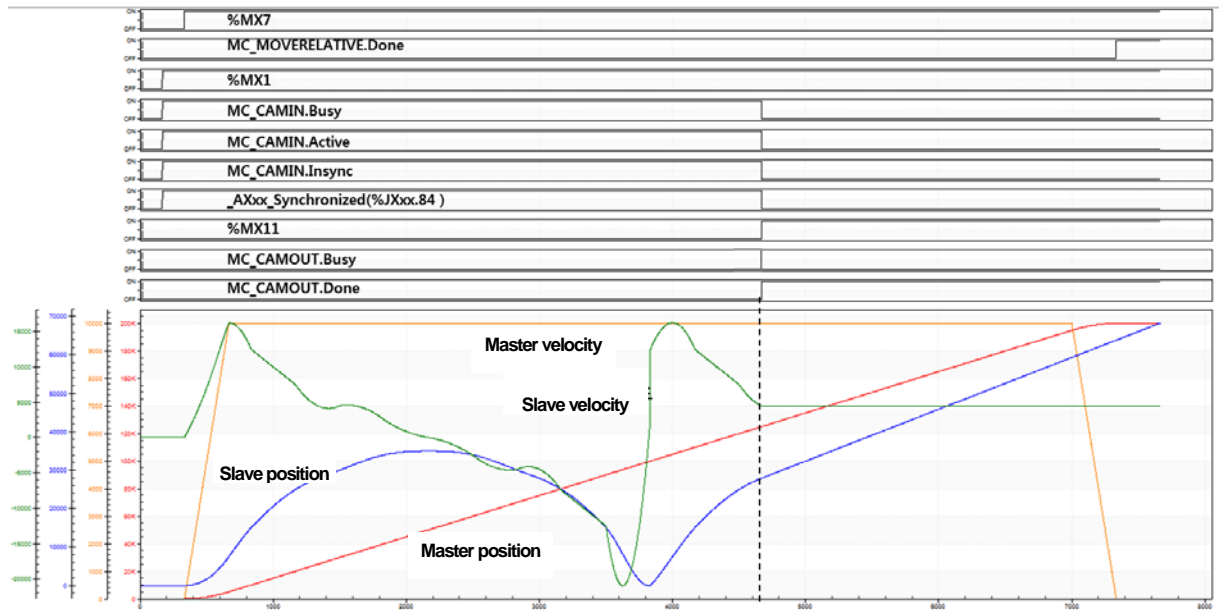
- (1) This motion function block immediately disengages cam operation running in the serve axis.
- (2) If motion function block of which BufferMode is Aborting in the serve axis where cam operation is running, cam operation is automatically disengaged and the relevant motion function block is executed. To execute cam operation abort (MC\_CamOut) motion function block, the relevant axis do operation which keeps the speed at the time when cam operation is disengaged. If you want to completely stop the serve axis, use stop (MC\_Halt) or immediate stop (MC\_Stop) motion function block.
- (3) When MC\_CamOut motion function block is executed, the InSync output of MC\_CamIn function block and the Synchronized status flag (\_AXxx\_Synchronized) is off.
- (4) Example program  
 This example shows generating a cam profile, executing MC\_CAMIN command on the sub-axis, moving the main-axis to the 200,000 position, and then executing MC\_CAMOUT. The sub-axis maintains the velocity at the time when the cam operation is terminated.



(a) Function block setting



(b) Timing diagram



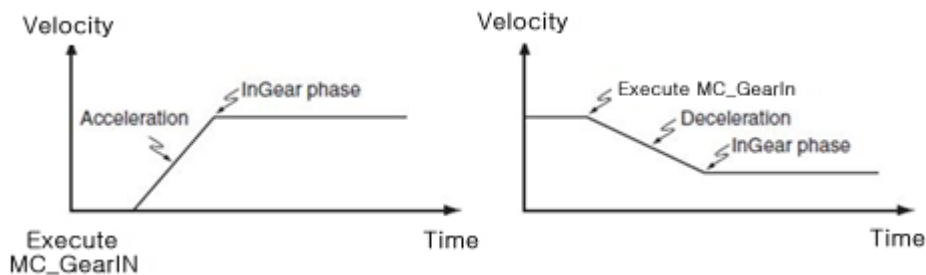
6.4.3 Electrical gearing run(MC\_GearIn)

Motion Function Block		
Input-Output		
UINT	Master	Set the main axis. (1~32: Actual axes, 37~40: Virtual axes, 41~42: Encoders)
UINT	Slave	Set the the serve axis. (1~32: Actual axes, 37~40: Virtual axes)
Input		
BOOL	Execute	Give gear operation command to the relevant axis in the rising Edge.
BOOL	ContinuousUpdate	Specify the update setting of input value. (Refer to 6.1.5.Changes in Parameters during Execution of Motion Function Block)
INT	RatioNumerator	Specify the numerator of gear ratio. (-32768 ~ 32767)
UINT	RatioDenominator	Specify the denominator of gear ratio. (0 ~ 65535)
UINT	MasterValueSource	Select data of the main axis to be synchronized. 0: Synchronize in the command position of the main axis. 1: Synchronize in the current position of the main axis.
LREAL	Acceleration	Specify the acceleration at the beginning of gear operation synchronization. [u/s <sup>2</sup> ]
LREAL	Deceleration	Specify the deceleration at the beginning of gear operation synchronization. [u/s <sup>2</sup> ]
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)
Output		
BOOL	InGear	Indicate that gear operation is running by applying gear ration.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

(1) This motion function block is an operation to synchronize the speed of the main axis and the serve axis

depending on gear ratio which is set.

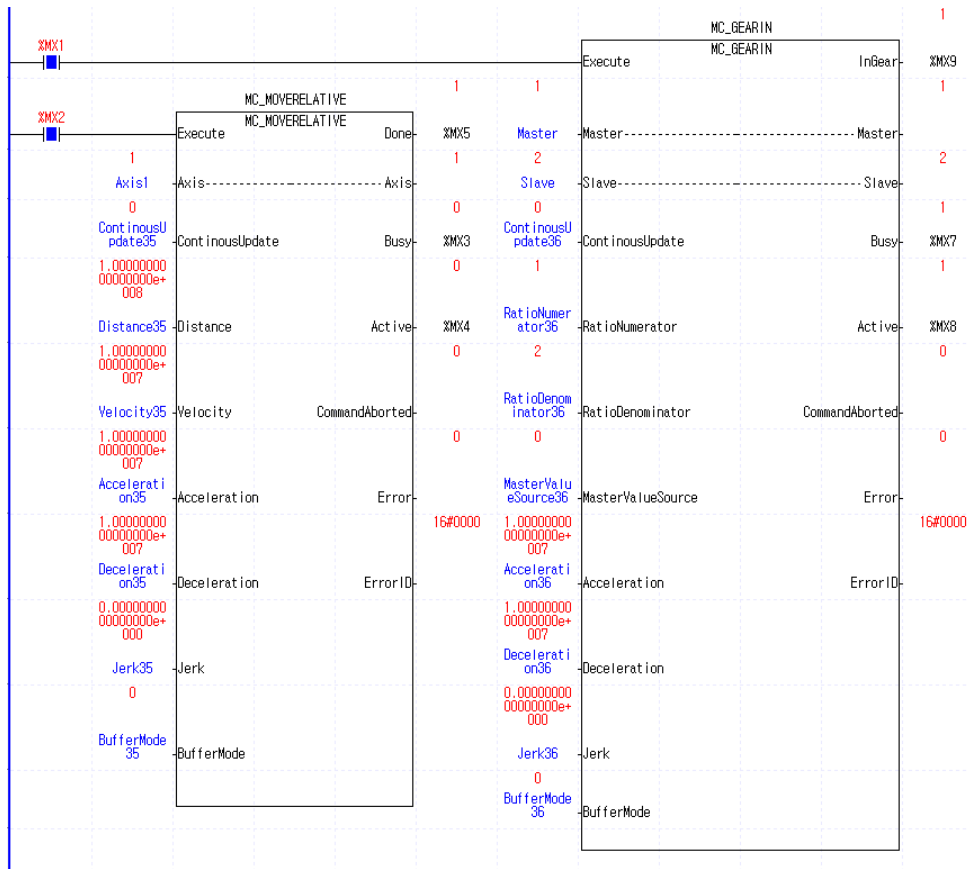
- (2) Giving gear operation abort (MC\_GearOut) commands to the relevant axis or execution of other motion function block allow to disengage gear operation.
- (3) RatioNumerator and RatioDenominator set the numerator and denominator to be applied to the serve axis respectively. If the numerator is set to negative number, the rotation direction of the serve axis is the opposite of the main axis.
- (4) MasterValueSource select the data of the main axis which is a standard of synchronization. If it is set to 0, synchronization operation is based on the command position of the main axis of motion control module, and if it is set to 1, synchronization operation is based on the current position. Other values set besides these two make Error of motion function block On and cause "0x1114" in ErrorID.
- (5) When this motion function block is executed, the serve axis is synchronized with the main axis through acceleration/deceleration at the speed in synch with the relevant gear ratio.
- (6) The serve axis is in 'SynchronizedMotion' while this motion function block is running.



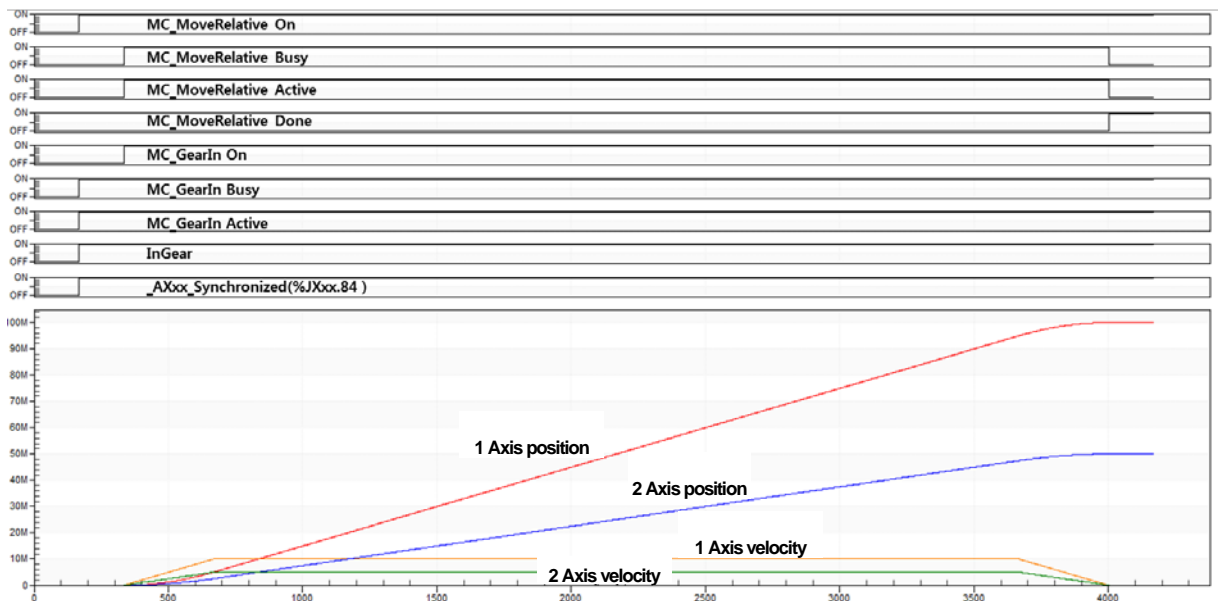
- (7) The changed parameters can be applied when ContinuousUpdate input is On. Only RatioNumerator, RatioDenominator, Acceleration, Deceleration input can be updated. (However, in case of InGear=On case, RatioNumerator, RatioDenominator input can be updated)
- (8) Example program

This example shows the operation of 2-axis up to 50,000,000 when moving 1-axis (main-axis) to 100,000,000 after executing MC\_GearIn command on axis 2(sub-axis) at the current position of 0.

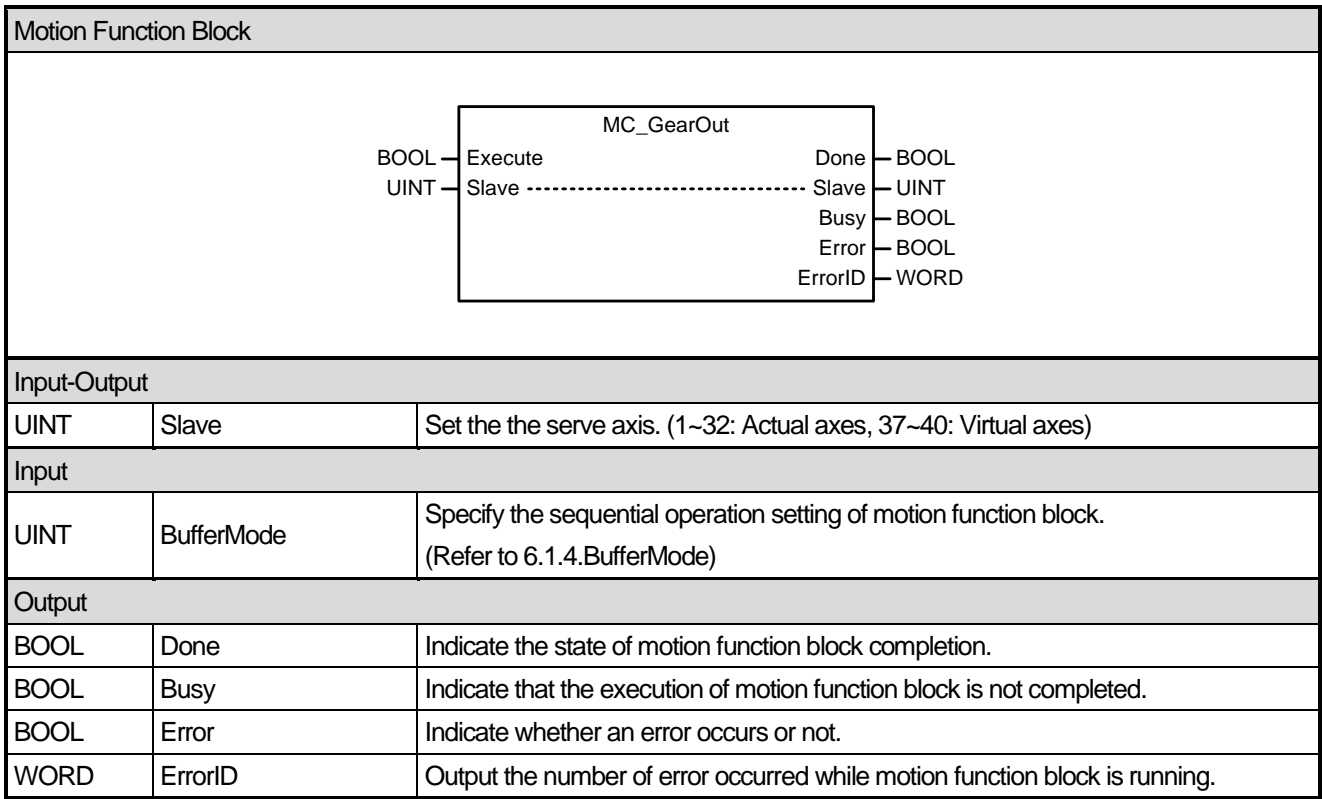
(a) Function block setting



(b) Timing diagram

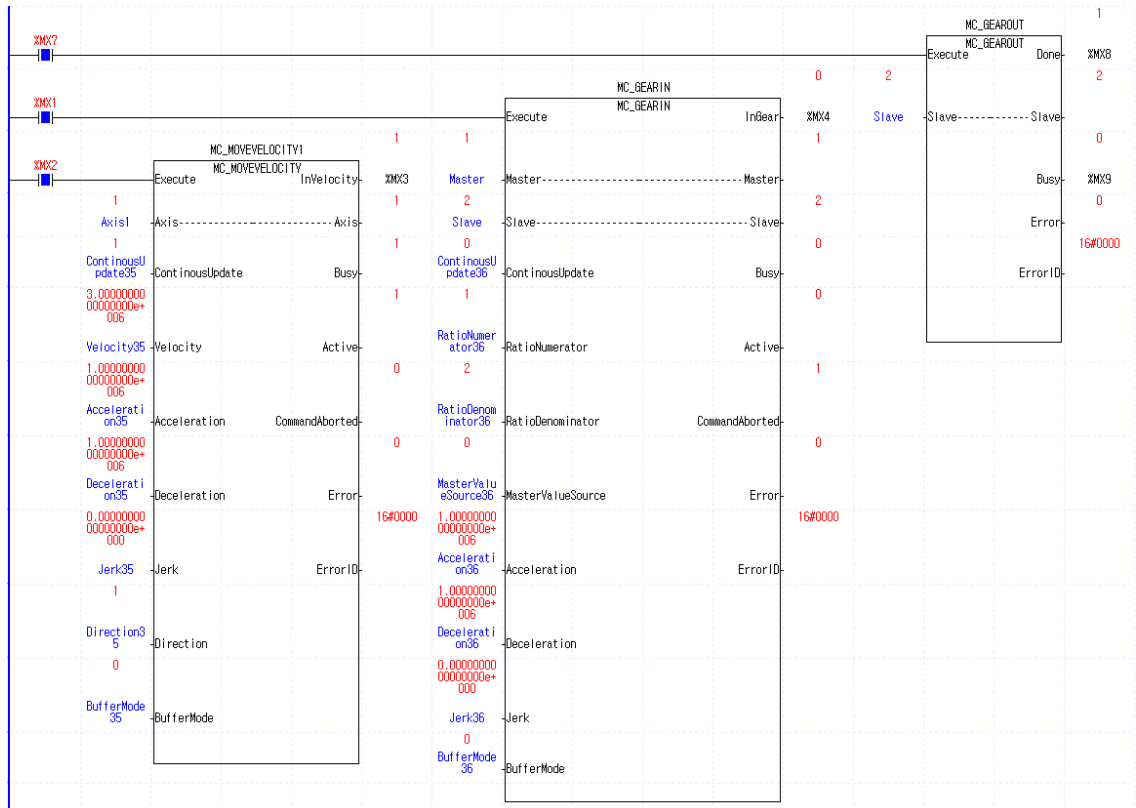


6.4.4 Electrical gearing disengage(MC\_GearOut)

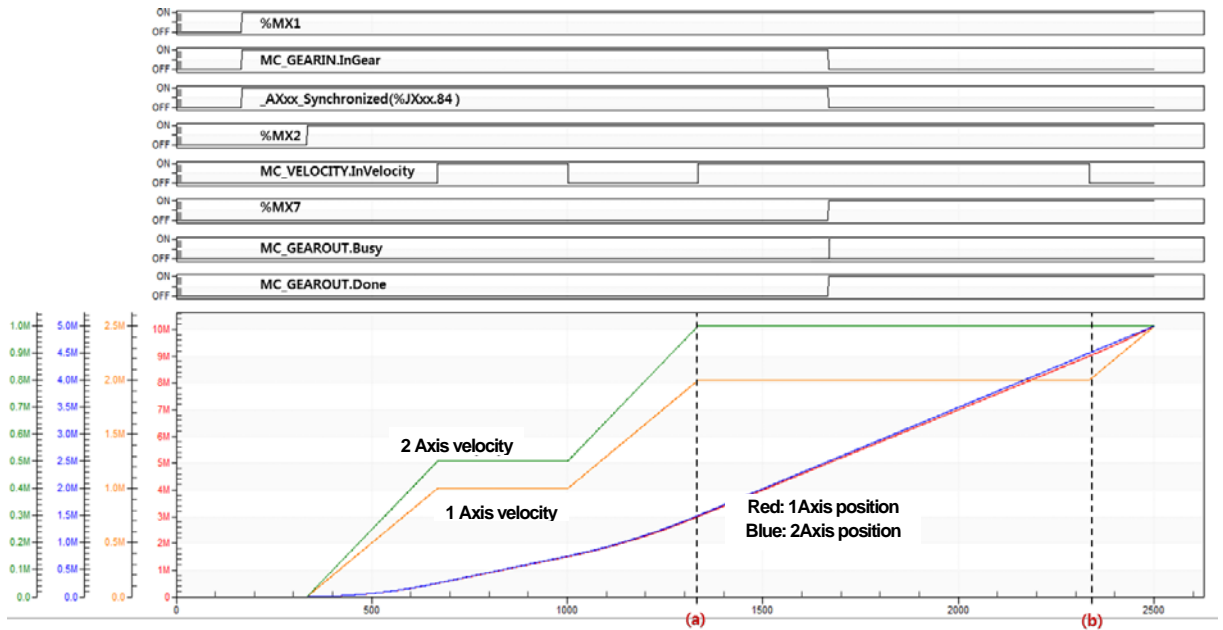


- (1) This motion function block immediately disengages gear operation running in the spindle.
- (2) If motion function block of which BufferMode is Aborting in the spindle where cam operation is running, gear operation is automatically disengaged and the relevant motion function block is executed. If gear operation abort (MC\_GearOut) motion function block is only to be executed, the relevant axis performs operation to maintain the speed at the time when gear operation is disengaged. To completely stop the spindle, use stop (MC\_Halt) or immediate stop (MC\_Stop) motion function block.
- (3) Example program  
 After the execution of MC GearIn command in sub-axis at the current position of 0, ContinuousUpdate of main-axis is set to 1, and then the velocity is gradually changed (1,000,000 → 2,000,000 → 3,000,000). This examples show the operation to ensure that the velocity of sub-axis is no longer changed (b) by executing MC\_GearOut command when the velocity of main-axis is 2,000,000.

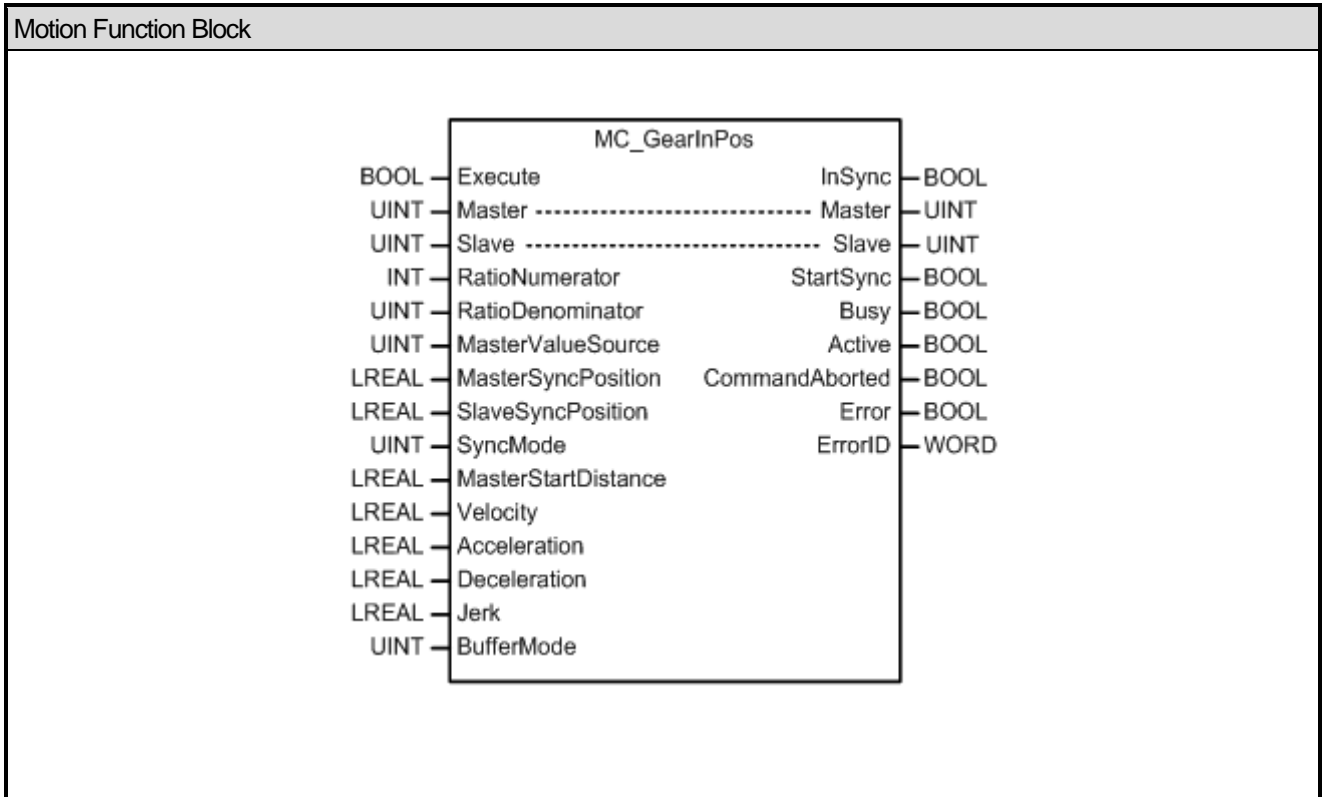
(a) Function block setting



(b) Timing diagram



6.4.5 Electrical gearing by specifying the position(MC\_GearInPos)

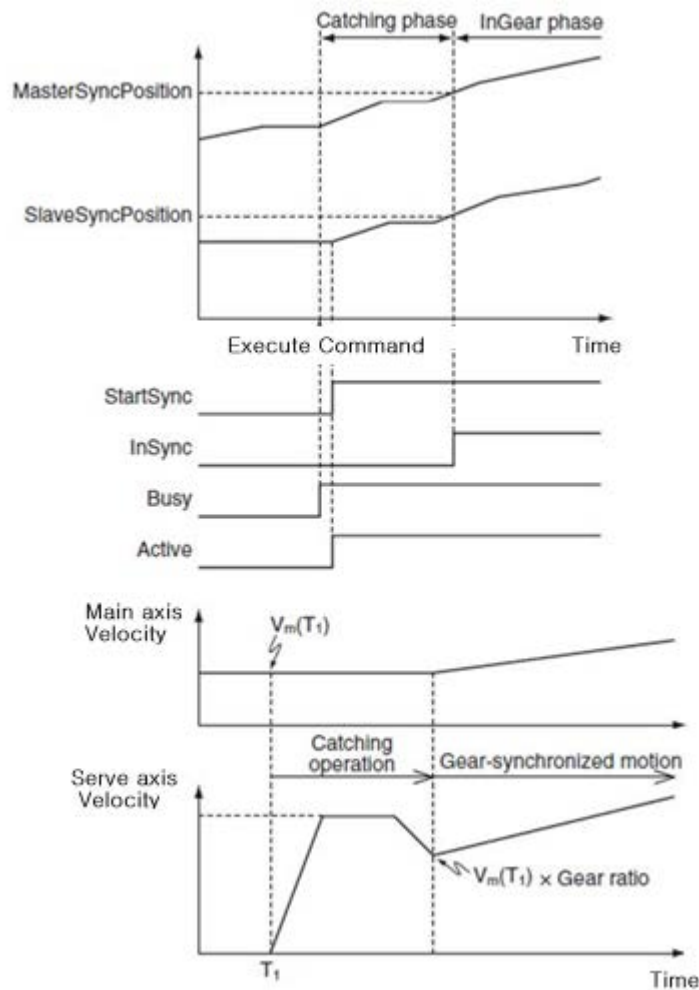
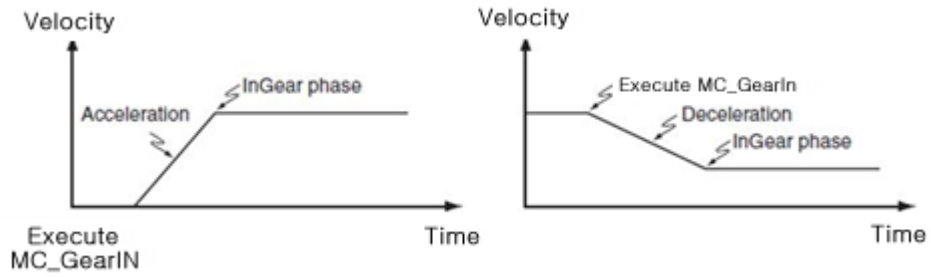


Input-Output		
UINT	Master	Set the main axis. (1~32: Actual axes, 37~40: Virtual axes, 41~42: Encoders)
UINT	Slave	Set the the serve axis. (1~32: Actual axes, 37~40: Virtual axes)
Input		
BOOL	Execute	Give a gear operation command to the relevant axis in the rising Edge.
INT	RatioNumerator	Specify the numerator of gear ratio. (-32768~32767)
UINT	RatioDenominator	Specify the denominator of gear ratio. (0~65535)
UINT	MasterValueSource	Select the standard of the main axis value to be synchronized. 0(mcSetValue): Synchronize in the target position of the main axis. 1(mcActualValue): Synchronize in the current position of the main axis.
LREAL	MasterSyncPosition	Specify the position of the main axis where gear operation starts.
LREAL	SlaveSyncPosition	Specify the position of the spindle where gear operation starts.
LREAL	MasterStartDistance	Specify the distance of the main axis where synchronization starts.
LREAL	Velocity	Specify the maximum speed of the spindle at the beginning of synchronization. [u/s]
LREAL	Acceleration	Specify the maximum acceleration of the spindle at the beginning of synchronization. [u/s <sup>2</sup> ]
LREAL	Deceleration	Specify the maximum deceleration of the spindle at the beginning of synchronization. [u/s <sup>2</sup> ]
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]



UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)
Output		
BOOL	InSync	Indicate that gear operation is normally being fulfilled as the specified gear ratio is applied.
BOOL	StartSync	Indicate synchronization is starting.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block is an operation to synchronize the speed of the main axis and the spindle in the set position depending on gear ratio which is set in the specific position.
- (2) Giving gear operation abort (MC\_GearOut) commands to the spindle or operation of other motion function block allow to stop gear operation.
- (3) RatioNumerator and RatioDenominator set the numerator and denominator of gear ratio to be applied to the spindle respectively. If the numerator is set to negative number, the rotation direction of the spindle goes into reverse of the main axis.
- (4) MasterValueSource selects the source of the main axis to be synchronized. If it is set to 0 (mcSetValue), synchronization is performed by putting the target position of the main axis in the current motion control period as a source, and if it is set to 1(mcActualValue), synchronization is performed by putting the current position of the main axis got feedback from the current motion control period as a source. Other values set besides these two cause "error 0x10D1".
- (5) Input the positions of the main axis and the spindle where gear operation is completed synchronization in MasterSyncPosition input and SlaveSyncPosition input respectively. Input the distance where the spindle starts synchronization in MasterStartDistance input, and the spindle starts synchronization at the position away the distance set in MasterStartDistance input from the position set in MasterSyncPosition input.
- (6) Once synchronization starts, StartSync output is On. When synchronization is completed and gear operation starts, StartSync output is Off and InSync output is On.
- (7) The spindle is in 'SynchronizedMotion' while this motion function block is running.

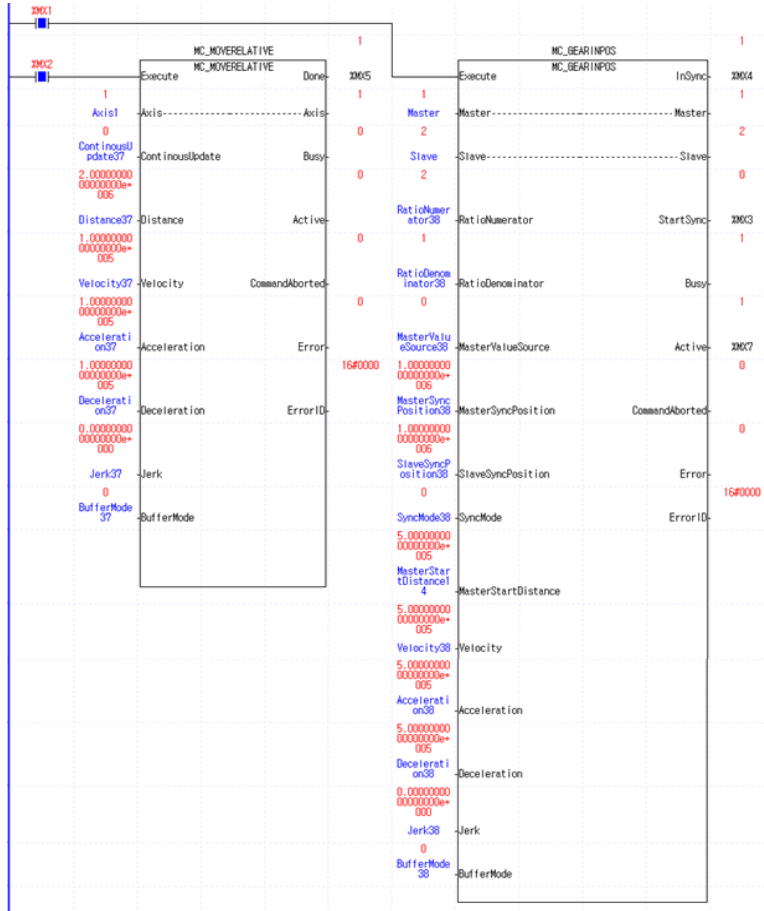


- (8) The changed parameters can be applied by re-executing the function block (Execute input is On) before the command is completed. Only RatioNumerator, RatioDenominator, MasterSyncPosition, SlaveSyncPosition, MasterStartDistance, Velocity, Acceleration, Deceleration input can be updated. (However, in case of InGear=On, RatioNumerator, RatioDenominator input can be updated.
- (9) Example program

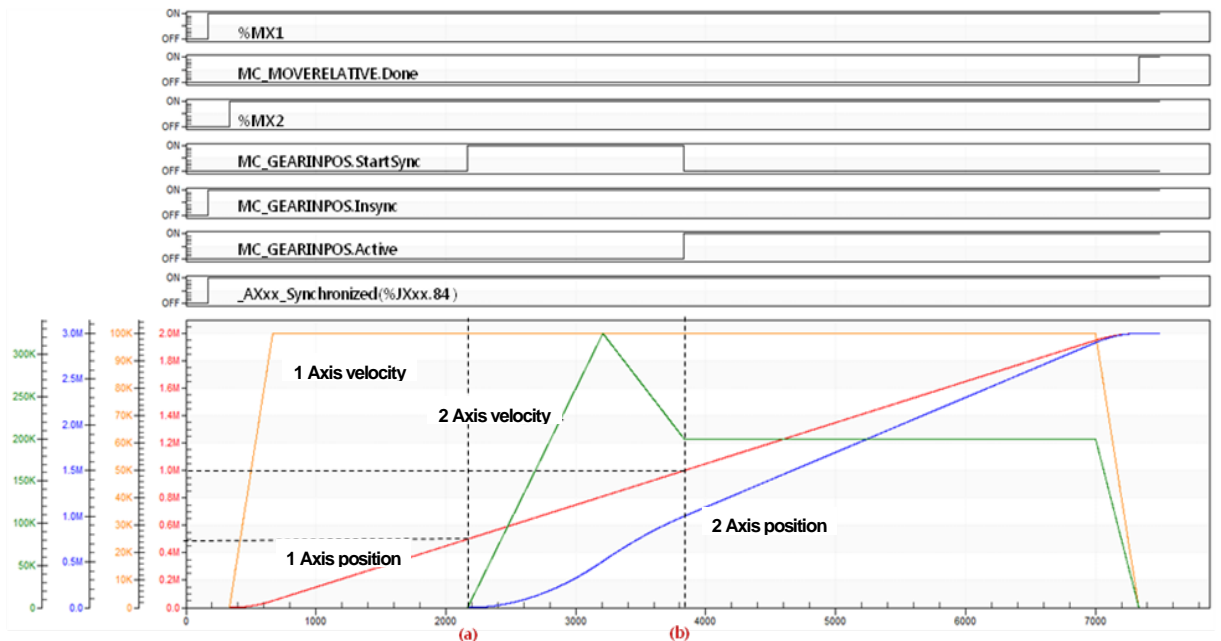
This example program executes MC\_GearInPos function block in which sub-axis starts synchronization from a position away as long as the distance of MasterStartDistance(500,000) from MasterSyncPosition(1,000,000), and executes MC\_MoveRelative for relative movement to the 2,000,000 position. Once synchronization starts, StartSyncoutput is on (a) and when the synchronization is completed and gear operation starts, StartSync

output is off, and InSyncoutput is on. (b)

(a) Function block setting



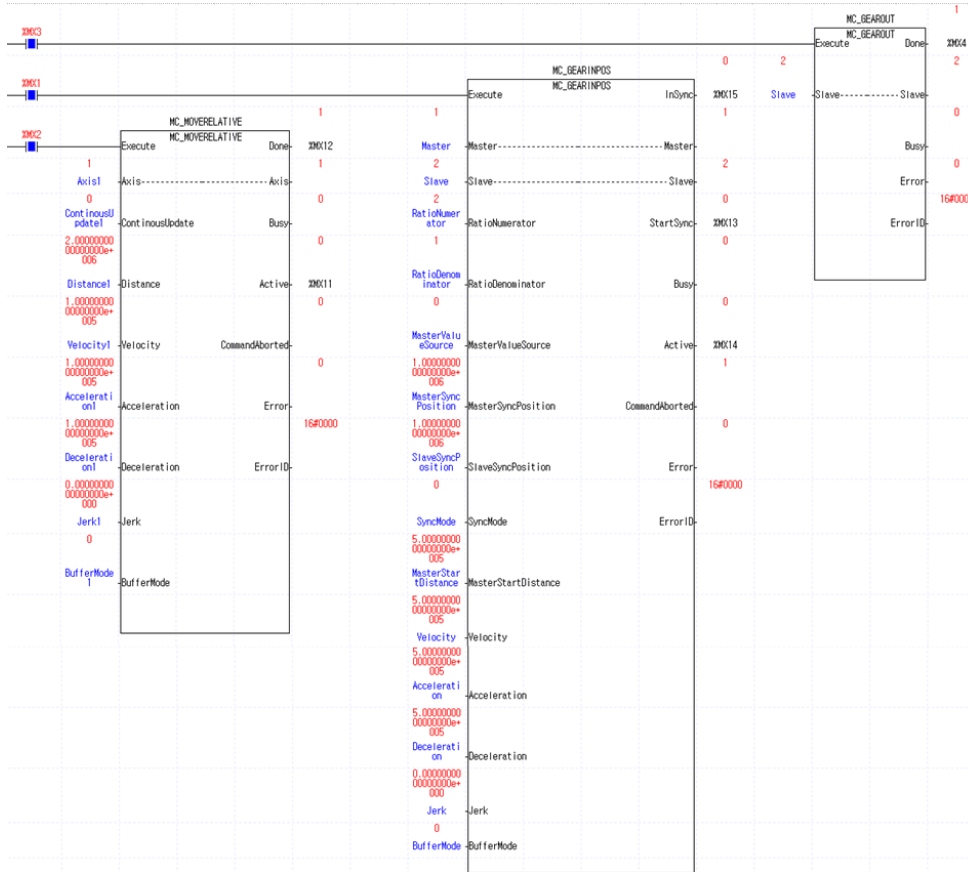
(b) Timing diagram



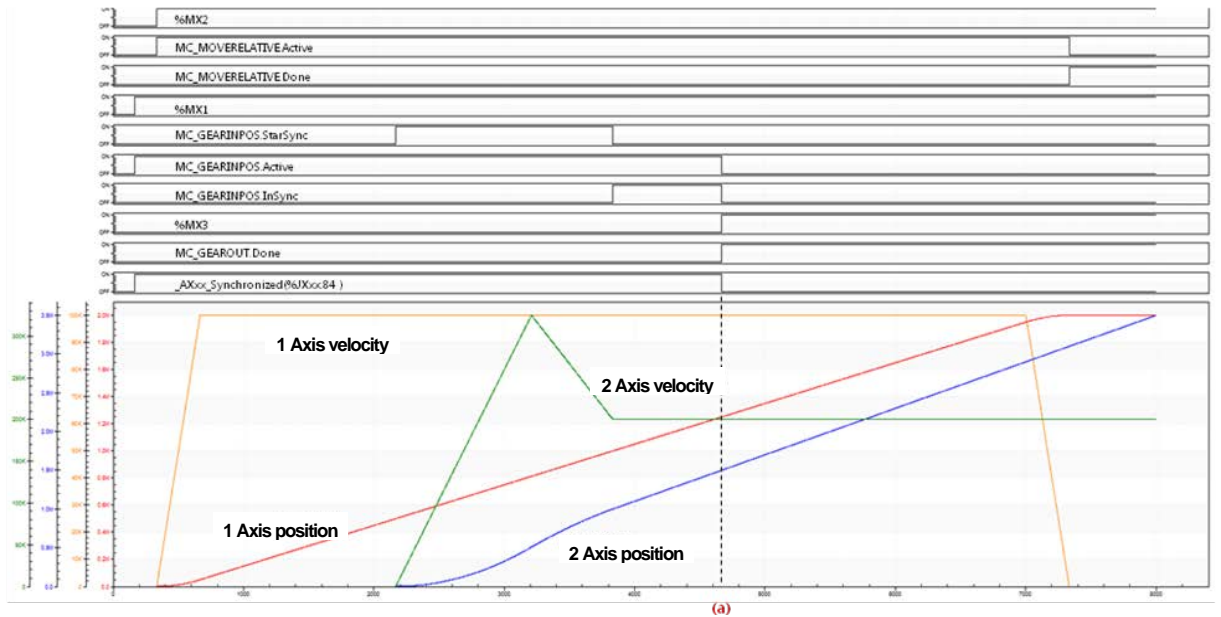
(10) Application example program

This example program shows MC\_GearInPos Active and InSync being off and gear operation being terminated when MC\_GearOut command is issued on 2-axis at (a) position during the motion shown in the basic example program. (Gear operation termination can be verified by 1-axis that stops and 2-axis that continues to operate)

(a) Function block setting



(b) Timing diagram



6.4.6 Phase compensation(MC\_Phasing)

Motion Function Block																													
<div style="border: 1px solid black; padding: 10px; margin: 10px auto; width: fit-content;"> <p style="text-align: center; margin: 0;">MC_Phasing</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%; text-align: right;">BOOL — Execute</td> <td style="width: 30%;"></td> <td style="width: 30%; text-align: left;">Done — BOOL</td> </tr> <tr> <td style="text-align: right;">UINT — Master</td> <td style="text-align: center;">-----</td> <td style="text-align: left;">Master — UINT</td> </tr> <tr> <td style="text-align: right;">UINT — Slave</td> <td style="text-align: center;">-----</td> <td style="text-align: left;">Slave — UINT</td> </tr> <tr> <td style="text-align: right;">LREAL — PhaseShift</td> <td></td> <td style="text-align: left;">Busy — BOOL</td> </tr> <tr> <td style="text-align: right;">LREAL — Velocity</td> <td></td> <td style="text-align: left;">Active — BOOL</td> </tr> <tr> <td style="text-align: right;">LREAL — Acceleration</td> <td style="text-align: center;">CommandAborted</td> <td style="text-align: left;">— BOOL</td> </tr> <tr> <td style="text-align: right;">LREAL — Deceleration</td> <td></td> <td style="text-align: left;">Error — BOOL</td> </tr> <tr> <td style="text-align: right;">LREAL — Jerk</td> <td></td> <td style="text-align: left;">ErrorID — WORD</td> </tr> <tr> <td></td> <td style="text-align: center;">CoveredPhaseShift</td> <td style="text-align: left;">— LREAL</td> </tr> </table> </div>			BOOL — Execute		Done — BOOL	UINT — Master	-----	Master — UINT	UINT — Slave	-----	Slave — UINT	LREAL — PhaseShift		Busy — BOOL	LREAL — Velocity		Active — BOOL	LREAL — Acceleration	CommandAborted	— BOOL	LREAL — Deceleration		Error — BOOL	LREAL — Jerk		ErrorID — WORD		CoveredPhaseShift	— LREAL
BOOL — Execute		Done — BOOL																											
UINT — Master	-----	Master — UINT																											
UINT — Slave	-----	Slave — UINT																											
LREAL — PhaseShift		Busy — BOOL																											
LREAL — Velocity		Active — BOOL																											
LREAL — Acceleration	CommandAborted	— BOOL																											
LREAL — Deceleration		Error — BOOL																											
LREAL — Jerk		ErrorID — WORD																											
	CoveredPhaseShift	— LREAL																											
Input-Output																													
UINT	Master	Set the main axis. (1~32: Actual axes, 37~40: Virtual axes, 41~42: Encoders)																											
UINT	Slave	Set the the serve axis. (1~32: Actual axes, 37~40: Virtual axes)																											
Input																													
BOOL	Execute	Give a phase compensation command to the relevant axis in the rising Edge																											
LREAL	PhaseShift	Specify the main axis compensation amount.																											
LREAL	Velocity	Specify the phase compensation velocity. [u/s]																											
LREAL	Acceleration	Specify the acceleration. [u/s <sup>2</sup> ]																											
LREAL	Deceleration	Specify the deceleration. [u/s <sup>2</sup> ]																											
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]																											
Output																													
BOOL	Done	Indicate whether to reach the specified phase compensation distance.																											
BOOL	Busy	Indicate that the execution of motion function block is not completed.																											
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.																											
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.																											
BOOL	Error	Indicate whether an error occurs or not.																											
WORD	ErrorID	Output the number of error occurred while motion function block is running.																											
LREAL	CoveredPhaseShift	Continuously output the compensation amount reflected while the phase compensation is running																											

- (1) This motion function block performs phase correction of axis during synchronous control operation. Phase correction is performed on the main-axis position referred to by sub-axis in synchronous control operation, to perform synchronous control operation of the sub-axis to the corrected main-axis position.
- (2) Once phase correction command is executed, the current position of the main-axis is phase-corrected using the phase shift setting at PhaseShift- Velocity / Acceleration /Deceleration / Jerk.

- (3) Phase correction does not change the actual command position or current position of the main-axis. Phase correction is performed on the main-axis position referred to by sub-axis in synchronous control operation. In other words, the main-axis does not know that phase correction is executed by the sub-axis.
- (4) Phase correction of the same amount can be performed again from the current position by re-executing the function block (Execute input is on) before the command is completed. In other words, phase shift is a relative value from the execution point.
- (5) After executing phase correction command, when the phase shift is reached, Done output is on.

## 6.5 Group Motion Function Blocks

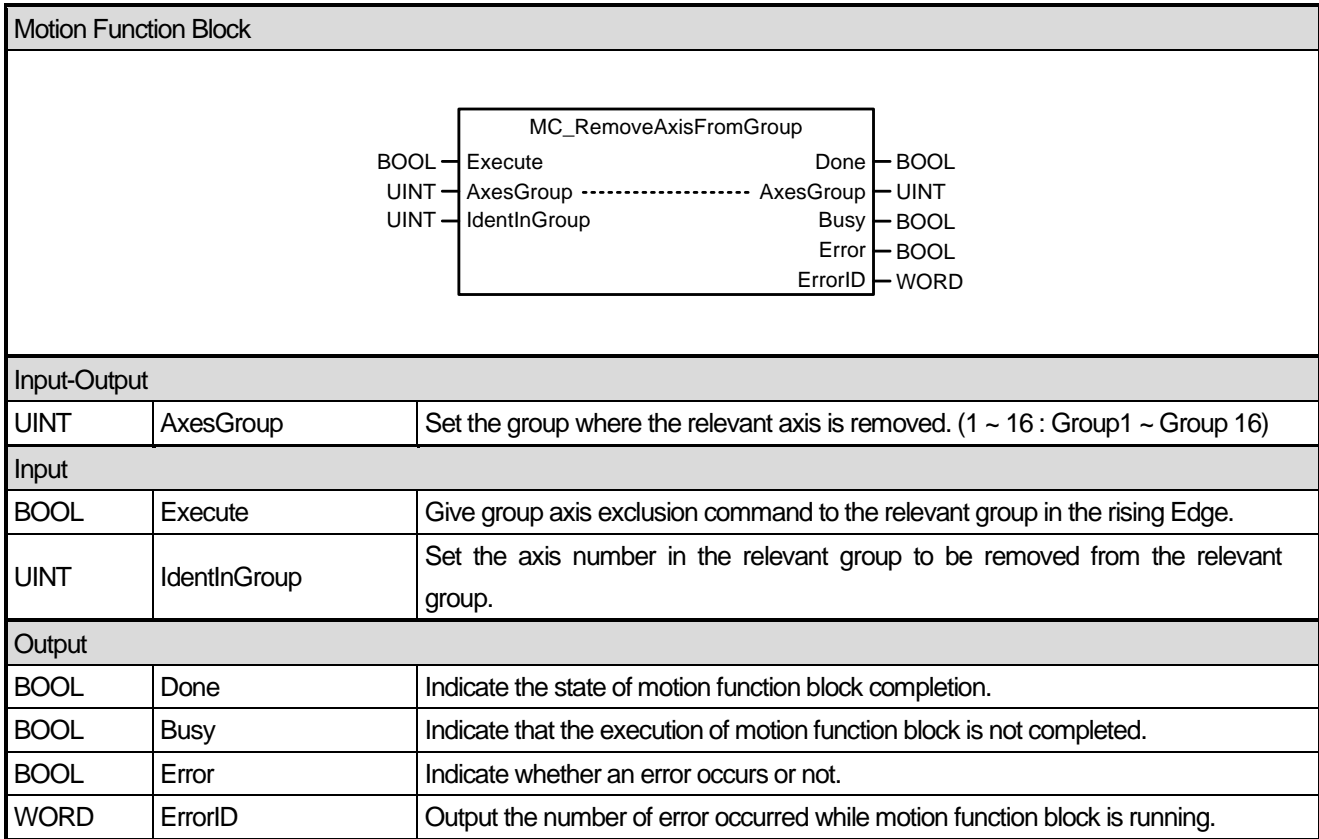
### 6.5.1 Adds one axis to a group in a structure AxesGroup(MC\_AddAxisToGroup)

Motion Function Block		
Input-Output		
UINT	AxesGroup	Set the group where the relevant axis is added. (1 ~ 16 : Group 1 ~ Group 16)
UINT	Axis	Set the axis to be added to the relevant group. (1~32: Actual axes, 37~40: Virtual axes)
Input		
BOOL	Execute	Give group axis addition command to the relevant axis in the rising Edge.
UINT	IdentInGroup	Set the ID of the relevant axis to be used in the relevant group. (1 ~ 4)
Output		
BOOL	Done	Indicate the state of motion function block completion.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block adds Axis specified axis to the axis group specified in AxesGroup input.
- (2) ID in the axis group specified to IdentInGroup must have unique value for each axis. (ID of each axis must be different.) Maximum 4 axes can be included in each axis group, axis ID can be specified in the range of 1-4. If the specified axis number is outside the range, "error 0x0006" occurs, and if numbers in the axis group overlap, "error 0x2051" occurs.
- (3) Axis group setting can be performed in the same way at XG-PM axis group parameter setting.

	Item	Axis group 1
Axis group parameter	Axis1	1 Axis
	Axis2	2 Axis
	Axis3	3 Axis
	Axis4	None
	Intp. speed Max	20000000 u/s

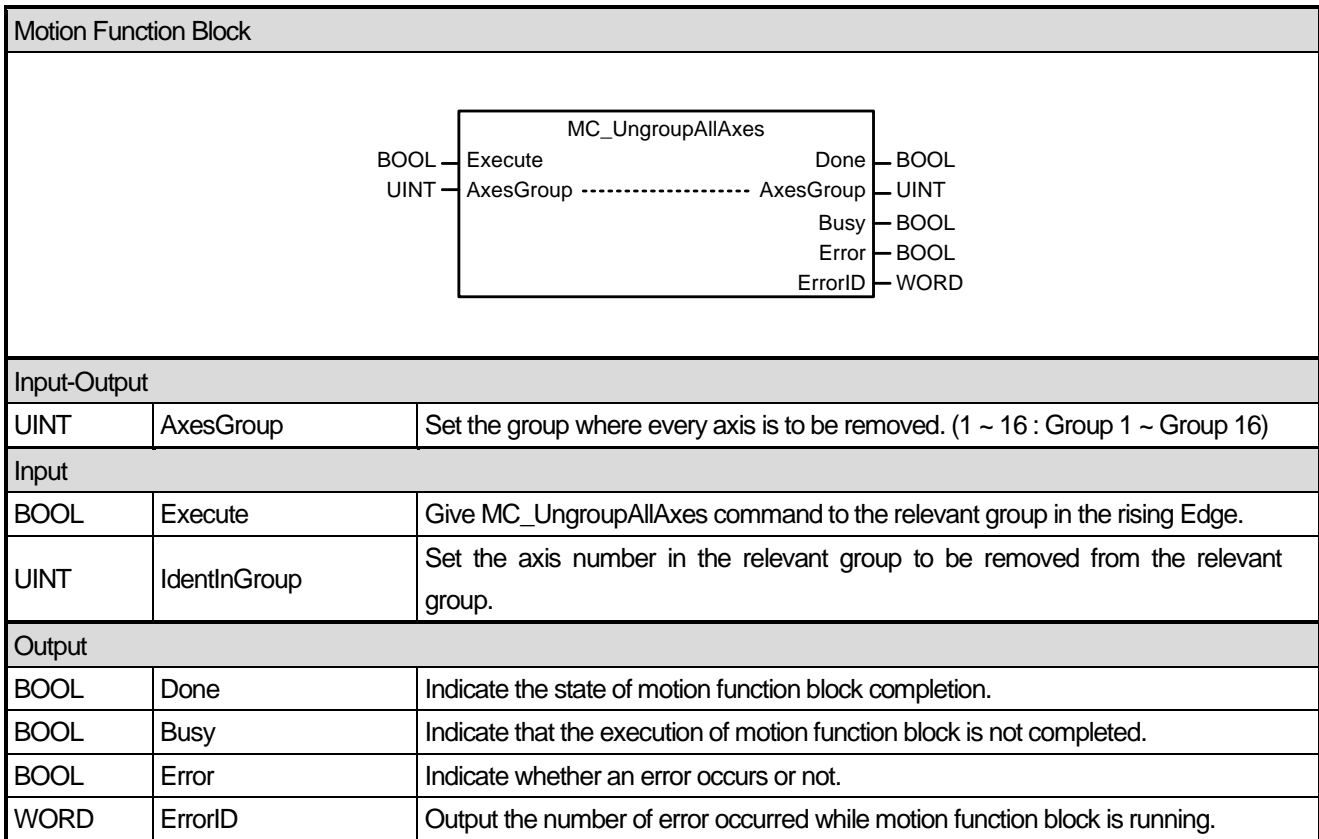
6.5.2 Removes one axis from the group AxesGroup(MC\_RemoveAxisFromGroup)



- (1) This motion function block removes the axis which is specified to IdentInGroup in the axis group specified in AxesGroup input.
- (2) If the execution of group axis exclusion is tried when the axis group is not in GroupDisabled, GroupStandBy, and GroupErrorStop state, "error 0x2003 or 0x2004 or 0x2005" occurs and the axis is not removed. In other words, the axis cannot be removed when the axis group does not completely stop.
- (3) If all the constituent axes are excluded from the designated axis group and there is no axis belonging to the group, the group is converted to GroupDisabled status.

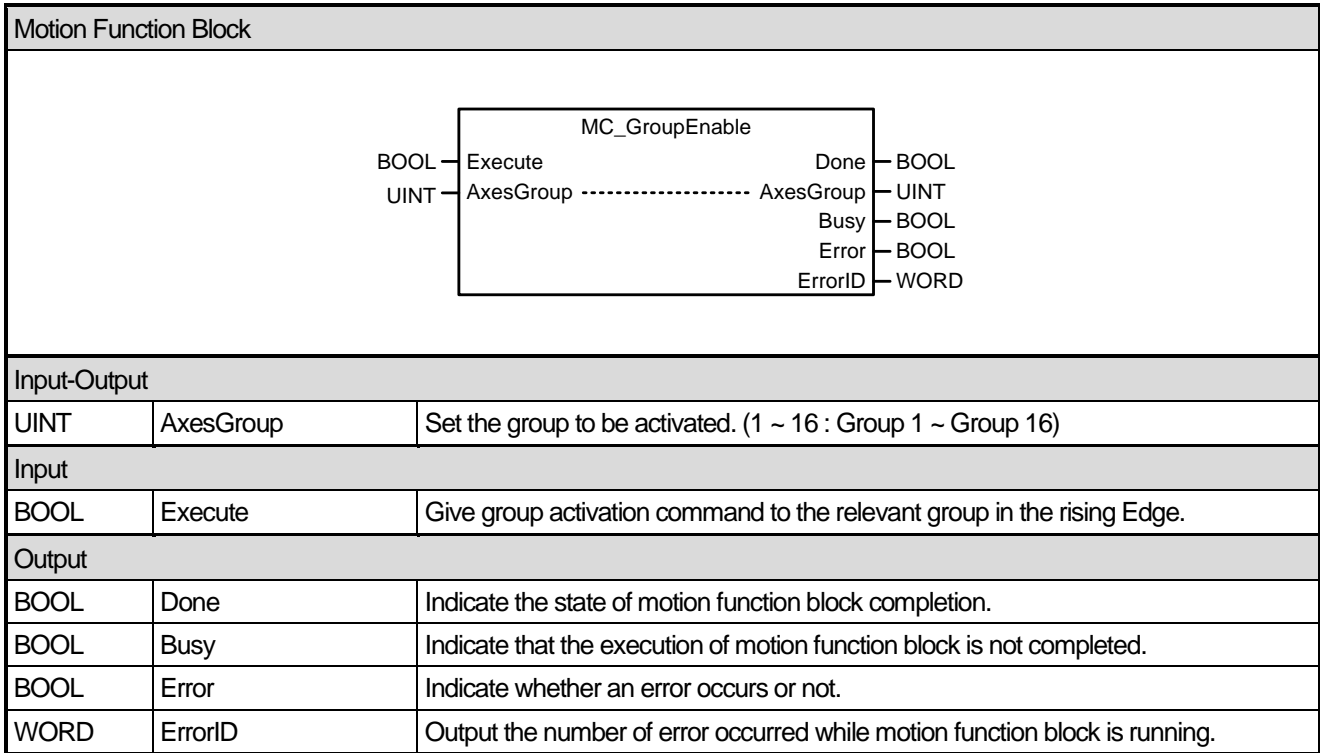


6.5.3 Removes all axes from the group AxesGroup(MC\_UngroupAllAxes)



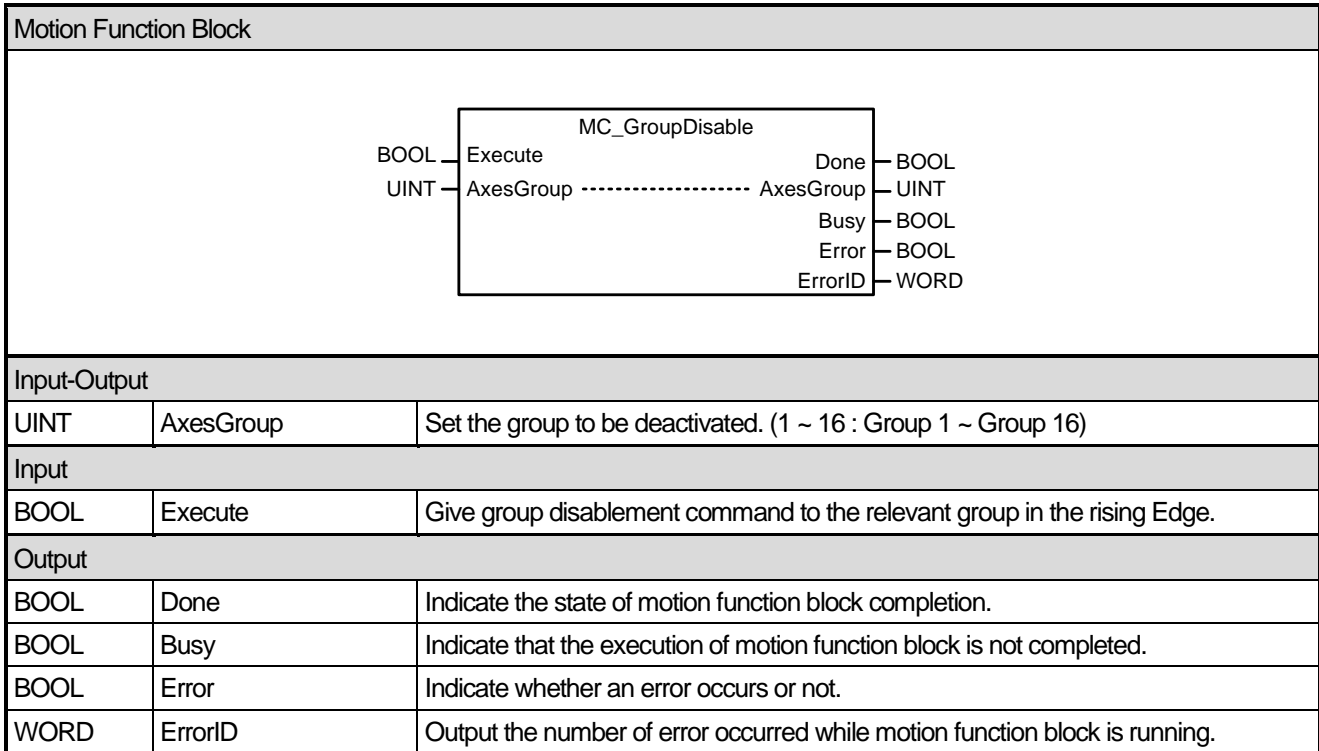
- (1) This motion function block removes every axis which belongs to the axis group specified in AxesGroup input.
- (2) If this motion function block is executed when the axis group is not in GroupDisabled, GroupStandBy, and GroupErrorStop state, "error 0x2003 or 0x2004 or 0x2005" occurs and the axis is not removed. In other words, the axis cannot be removed when the axis group does not completely stop.
- (3) When the axis which belongs to the group is successfully removed, the relevant group is switched to GroupDisabled state.

6.5.4 Changes the state for a group from GroupDisabled to GroupEnable(MC\_GroupEnable)



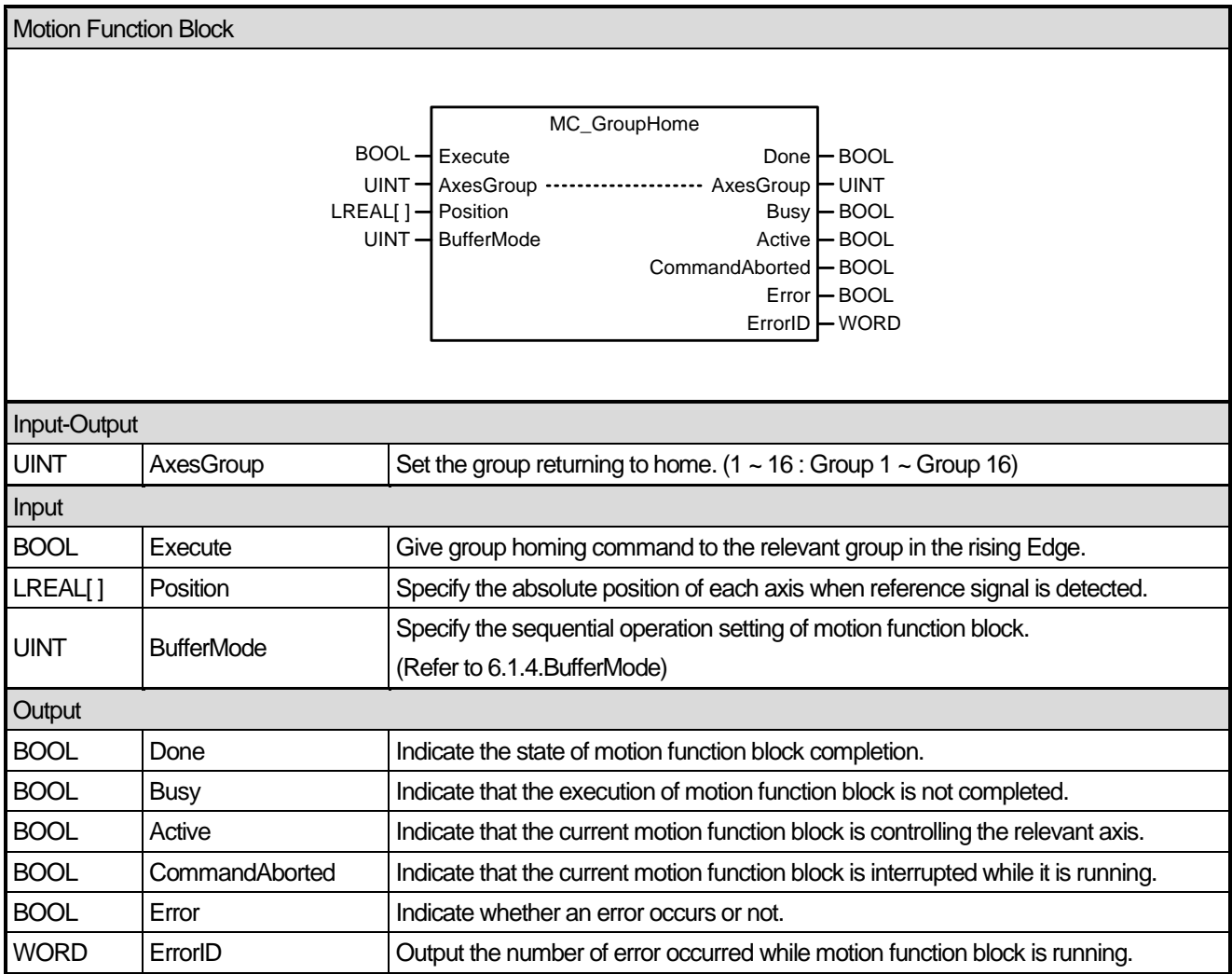
- (1) This motion function block is to activate the axis group specified in AxesGroup input.
- (2) When giving this command to the axis group in GroupDisable state, the relevant axis group is switched to GroupStandby state.
- (3) This motion function block does not affect the power state of each axis in the relevant group.

6.5.5 Changes the state for a group to GroupDisabled(MC\_GroupDisable)



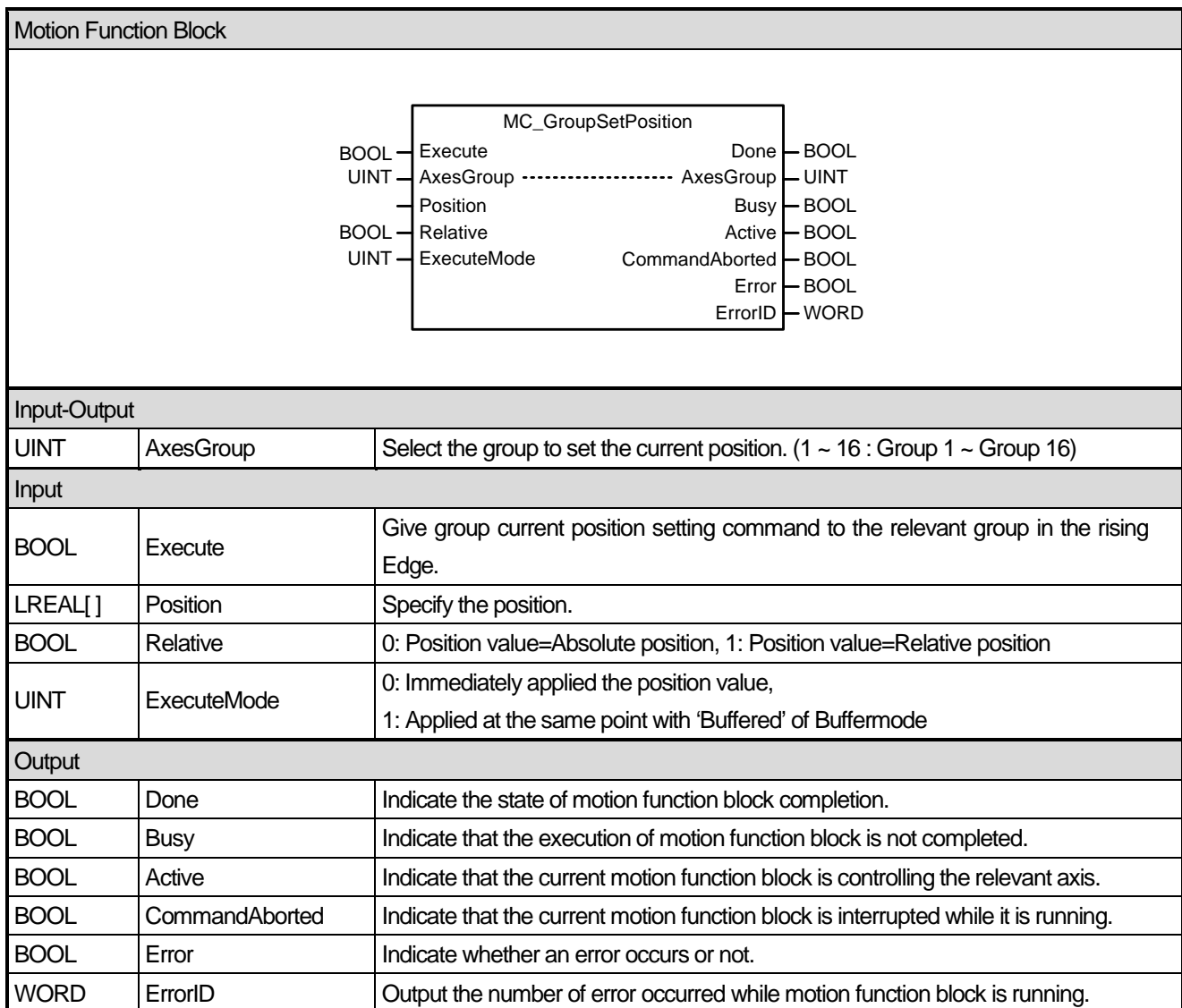
- (1) This motion function block is to deactivate the axis group specified in AxesGroup input.
- (2) The axis group which executes this motion function block is switched to GroupDisabled.
- (3) This motion function block does not affect the power state of each axis in the relevant group.

6.5.6 The AxesGroup to perform the search home sequence(MC\_GroupHome)



- (1) This motion function block is to give homing command to the axis group specified in AxesGroup input.
- (2) Homing method is operated as specified in servo parameter of the relevant axis in advance.
- (3) In Position input, specify the absolute position to the array to be set when homing is completed or Reference Signal is detected. Values in the array and the axis in the group correspond in the order of [1, 2, 3, 4]. (1~4 are the axis ID in the axis group)
- (4) The axis group is in 'GroupHoming' state while this motion function block is running, and it is switched to 'GroupStandby' state when motion function block is completed.
- (5) If the function block is re-executed (Execute input On) before the instruction is terminated, the changed parameters are applied. Only Position input can be updated.

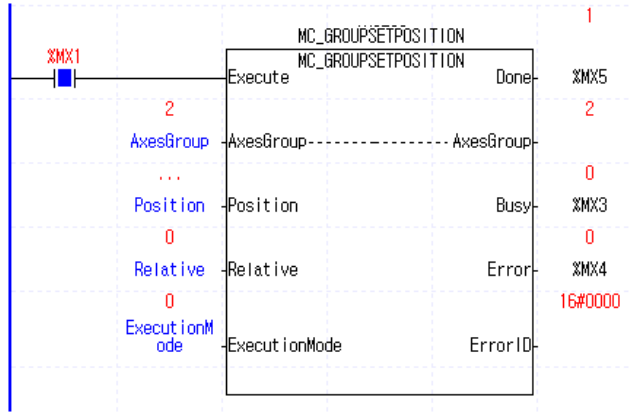
6.5.7 Sets the Position of all axes in a group without moving(MC\_GroupSetPosition)



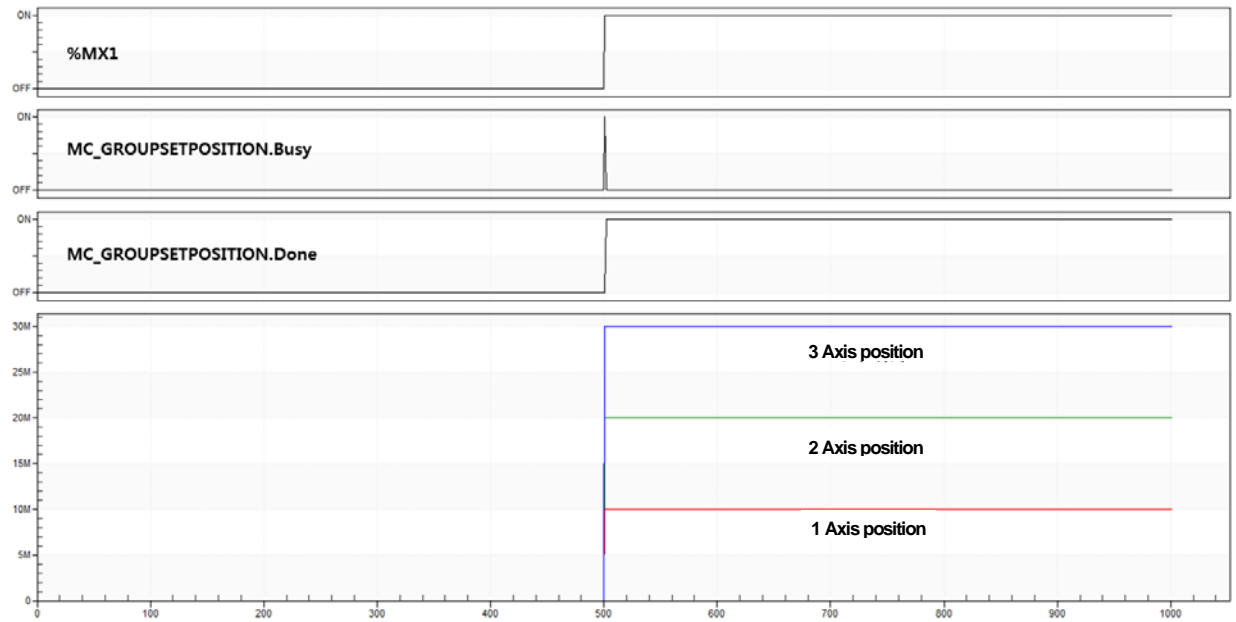
- (1) This motion function block sets the current position of the relevant axis group.
- (2) Specify the position of each axis in the group to the array. When executing this motion function block, if Relative input is Off, the position of the relevant axis is replaced by the Position input value, and if Relative input is On, the Position input value is added to the current position of the relevant axis. Values in the array and the axis in the group correspond in the order of [1, 2, 3, 4]. (1~4 are the axis ID in the axis group)
- (3) ExecutionMode input specifies the setting point. If it is 0, it is set immediately after the execution of a command, If it is 1, it is set at the same point with 'Buffered' of sequential operation setting. The value unable to be set causes "error 0x201B".
  - 0 (mcImmediately): Change the value of parameter immediately after the execution of motion function block (rising Edge in Execute input). If the relevant axis is running, the operation can be affected.
  - 1 (mcQueued): Changed at the same point of 'Buffered' of Buffermode. (Refer to 6.1.4.BufferMode Input)
- (4) Example program

This example shows the change of the current position to position values (10,000,000/20,000,000/30,000,000) set in the position variables when executing MC\_GroupSetPosition function block at the status where 1-axis, 2-axis and 3-axis are set as a single group.

(a) Function block setting



(b) Timing diagram

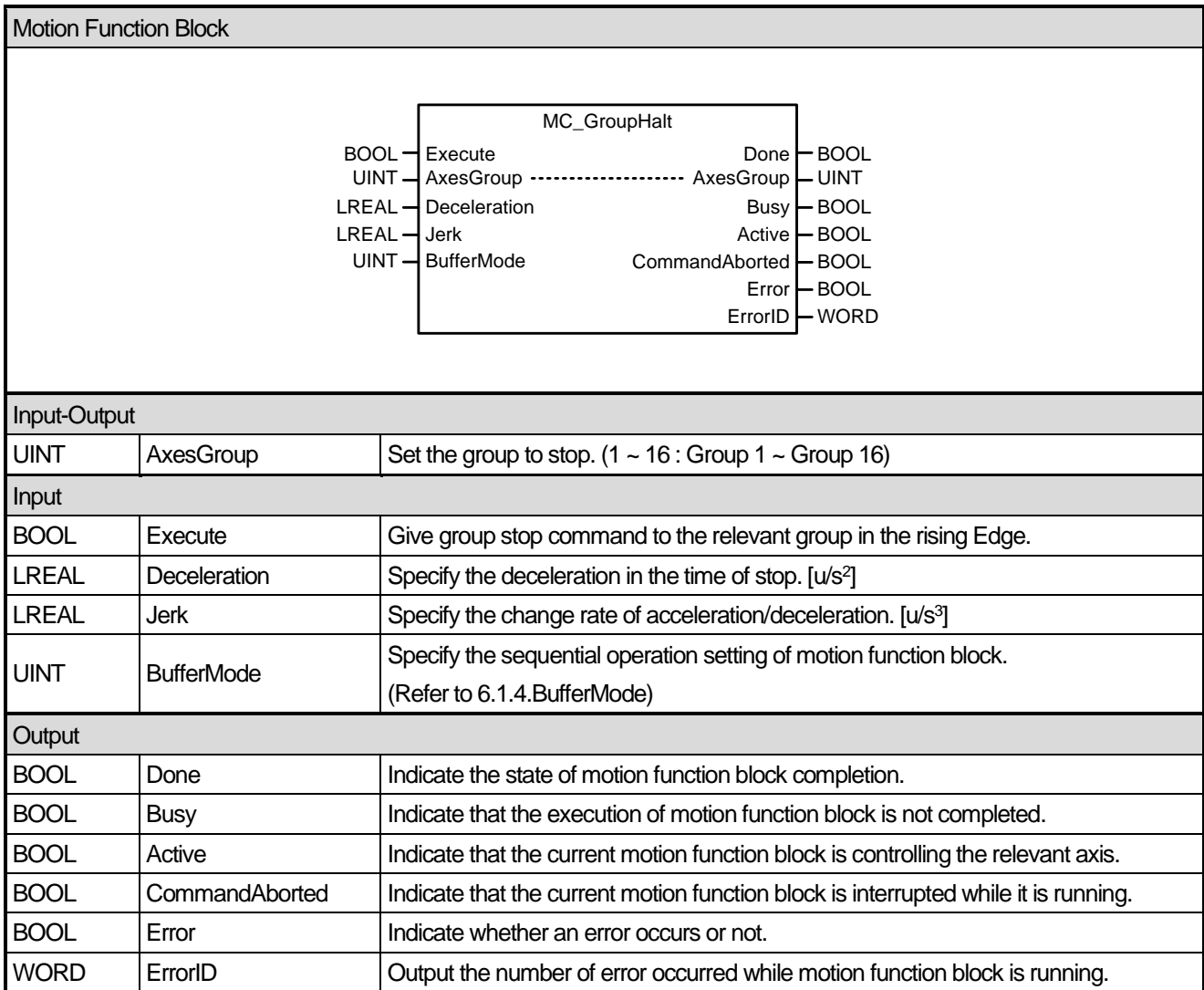


## 6.5.8 Stop a Group immediately(MC\_GroupStop)

Motion Function Block		
Input-Output		
UINT	AxesGroup	Set the group to stop immediately. (1 ~ 16 : Group 1 ~ Group 16)
Input		
BOOL	Execute	Give group immediate stop command to the relevant group in the rising Edge.
LREAL	Deceleration	Specify the deceleration in time of stop. [ $\mu\text{s}^2$ ]
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [ $\mu\text{s}^3$ ]
Output		
BOOL	Done	Indicate the state of motion function block completion.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block is to give an emergency stop command to the relevant axis group.
- (2) The relevant axis group moves on the route which it was following until it completely stops.
- (3) When executing group immediate stop (MC\_GroupStop) motion function block, motion function block which the relevant axis group is performing is interrupted, and the axis is changed to 'GroupStopping'. When the relevant axis group is in 'GroupStopping' state, other motion function block cannot be given to the relevant axis until the stop is completed (until Done output is On).
- (4) CommandAborted output indicates that the current motion function block is interrupted while it was executed. Because other motion function block cannot interrupt group immediate stop (MC\_GroupStop) command while group immediate stop (MC\_GroupStop) command is being executed, CommandAborted output is On when the power of servo is cut, servo Off command is executed, or servo connection is disconnected.
- (5) If Execute input is On or the speed of the axis is not 0, the axis is in 'GroupStopping' state, and if Done output is On and Execute input is Off, the axis is switched to 'GroupStandBy' state.
- (6) If the function block is re-executed (Execute input On) before the instruction is terminated, the changed parameters are applied. Only Deceleration and Jerk inputs can be updated.

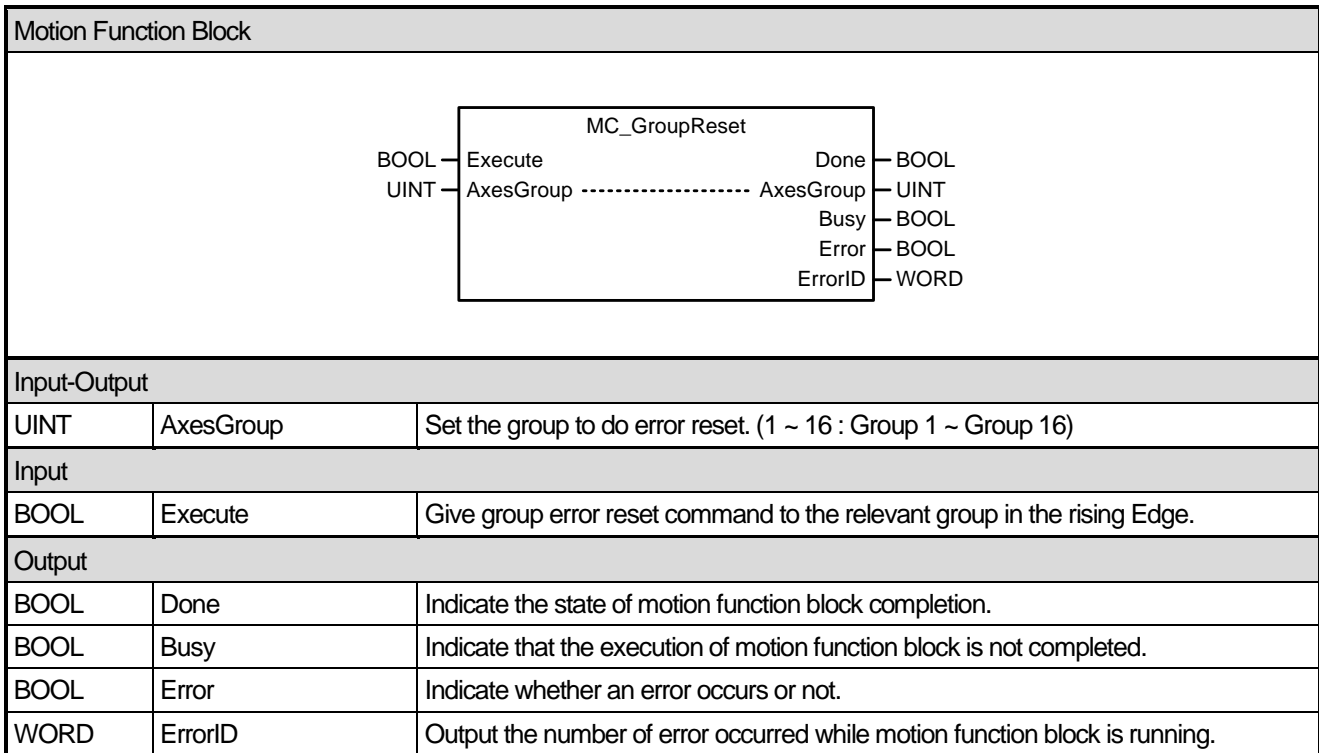
6.5.9 Stop a Group(MC\_GroupHalt)



- (1) This motion function block is to give a stop command to the relevant axis.
- (2) The relevant axis group moves on the route which it was following until it completely stops.
- (3) The axis is in 'GroupMoving' state while this motion function block is running, and if the axis group completely stops, 'Done' output is On and the group state is changed to 'GroupStandBy' state.
- (4) If the function block is re-executed (Execute input On) before the instruction is terminated, the changed parameters are applied. Only Deceleration and Jerk inputs can be updated.



6.5.10 Reset a group error(MC\_GroupReset)



- (1) This motion function block is to reset the error of the relevant axis group. When the relevant axis is in 'GroupErrorStop', the execution of motion function block resets the error occurred in the current relevant axis and switches the axis group to 'GroupStandBy' state.
- (2) When executing this motion function block, every error occurred in each axis in the group is reset. (This has the same effect with when executing the axis error reset (MC\_Reset) command in each axis.)

6.5.11 Absolute positioning linear interpolation operation(MC\_MoveLinearAbsolute)

Motion Function Block		
<pre> graph LR     subgraph MC_MoveLinearAbsolute         Execute[Execute]         AxesGroup[AxesGroup]         Position[Position]         Velocity[Velocity]         Acceleration[Acceleration]         Deceleration[Deceleration]         Jerk[Jerk]         BufferMode[BufferMode]         TransitionMode[TransitionMode]         TransitionParameter[TransitionParameter]         Done[Done]         Busy[Busy]         Active[Active]         CommandAborted[CommandAborted]         Error[Error]         ErrorID[ErrorID]     end     Execute --- AxesGroup     Position --- Velocity     Acceleration --- Deceleration     Jerk --- BufferMode     TransitionMode --- TransitionParameter     Done --- Busy     Active --- CommandAborted     Error --- ErrorID         </pre>		
Input-Output		
UINT	AxesGroup	Set the group to perform absolute position linear interpolation operation. (1 ~ 16: Group 1 ~ Group 16)
Input		
BOOL	Execute	Give absolute position linear interpolation operation command to the relevant group in the rising Edge.
LREAL[ ]	Position	Specify the target position of each axis.
LREAL	Velocity	Specify the maximum speed of the route. [u/s]
LREAL	Acceleration	Specify the maximum acceleration. [u/s <sup>2</sup> ]
LREAL	Deceleration	Specify the maximum deceleration. [u/s <sup>2</sup> ]
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)
UINT	TransitionMode	Specify the route change mode of group operation. (Refer to 6.1.6.TransitionMode )
LREAL	TransitionParameter	Specify the parameter of the route change setting of group operation.. (Refer to 6.1.6.TransitionMode )
Output		
BOOL	Done	Indicate whether to reach the specified position.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block is to give an absolute position linear interpolation command to the axis group specified in AxesGroup input.
- (2) When this motion function block is executed, interpolation control is performed in a linear path from the current

position to the target position of each axis, and the moving direction is decided by the starting point and the target point of each axis.

Beginning position < Target position: Forward direction operation

Beginning position > Target position: Reverse direction operation

- (3) In Position input, specify the target position of each axis in the group as matrix. The values in the array and the axis in the group correspond in the order of [1, 2, 3, 4].(1~4 are axis ID in the axis group).
- (4) Specify the speed, acceleration, deceleration, and the change rate of acceleration/deceleration of interpolation route in Velocity, Acceleration, Deceleration, and Jerk inputs respectively.
- (5) Velocity is to set the interpolation speed of the axis group, and it indicates the integrated speed of each axis.

Operation speeds of each configuration axis are calculated as follows.

Interpolation speed (F) = Target speed specified in the Velocity

$$\text{Interpolation movement amount (S)} = \sqrt{S_1^2 + S_2^2 + S_3^2 + S_4^2}$$

$$\text{Configuration axis 1 speed (V}_1\text{)} = \text{Interpolation speed (F)} \times \frac{\text{Configuration axis 1 movement amount (S}_1\text{)}}{\text{Interpolation movement amount (S)}}$$

$$\text{Configuration axis 2 speed (V}_2\text{)} = \text{Interpolation speed (F)} \times \frac{\text{Configuration axis 2 movement amount (S}_2\text{)}}{\text{Interpolation movement amount (S)}}$$

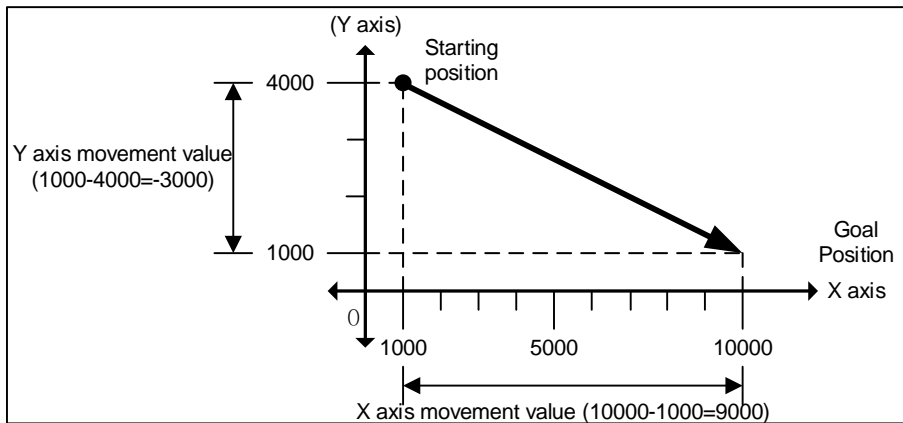
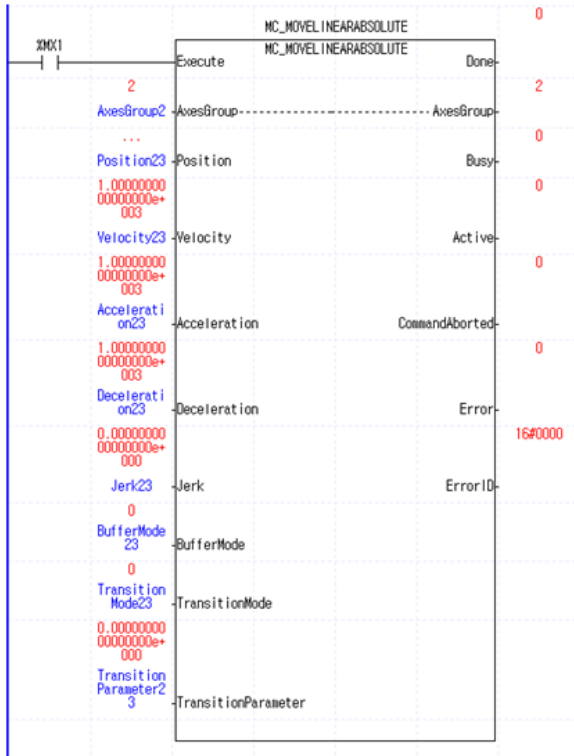
$$\text{Configuration axis 3 speed (V}_3\text{)} = \text{Interpolation speed (F)} \times \frac{\text{Configuration axis 3 movement amount (S}_3\text{)}}{\text{Interpolation movement amount (S)}}$$

$$\text{Configuration axis 4 speed (V}_4\text{)} = \text{Interpolation speed (F)} \times \frac{\text{Configuration axis 4 movement amount (S}_4\text{)}}{\text{Interpolation movement amount (S)}}$$

- (6) Refer to chapter 8.2.6 linear interpolation control part in motion control module's manual for more details.
- (7) The changed parameters can be applied by re-executing the function block (Execute input is On) before the command is completed. Only Velocity, Acceleration, Deceleration, Jerk, Position input can be updated.
- (8) Example program

This example shows the linear interpolation to the target position (10000, 1000) when the current command position is (1000, 4000).

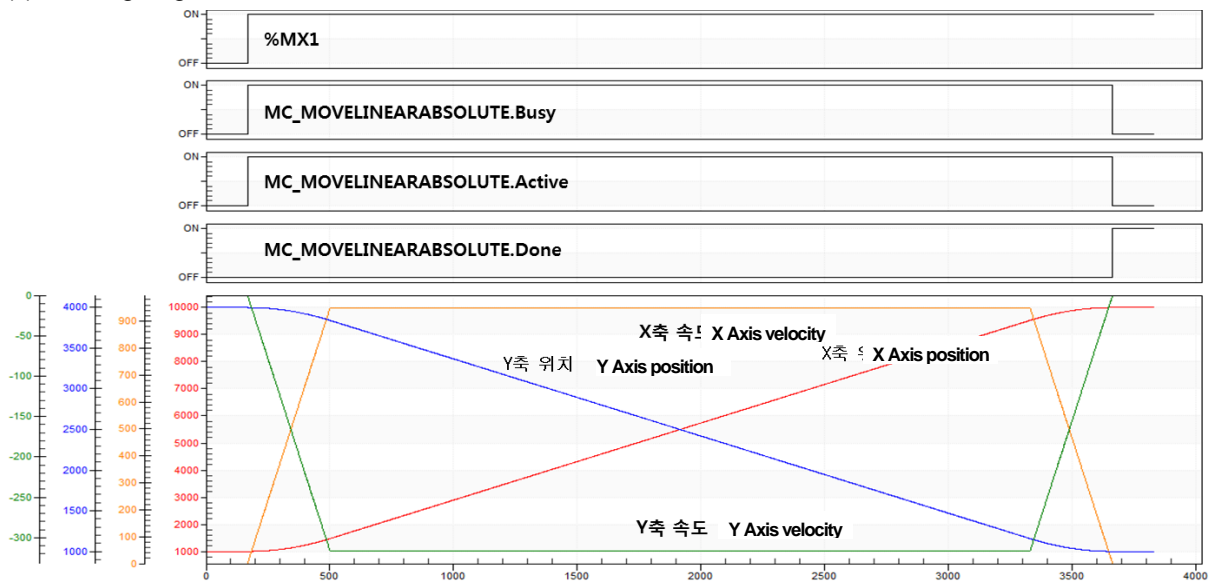
(a) Function block setting



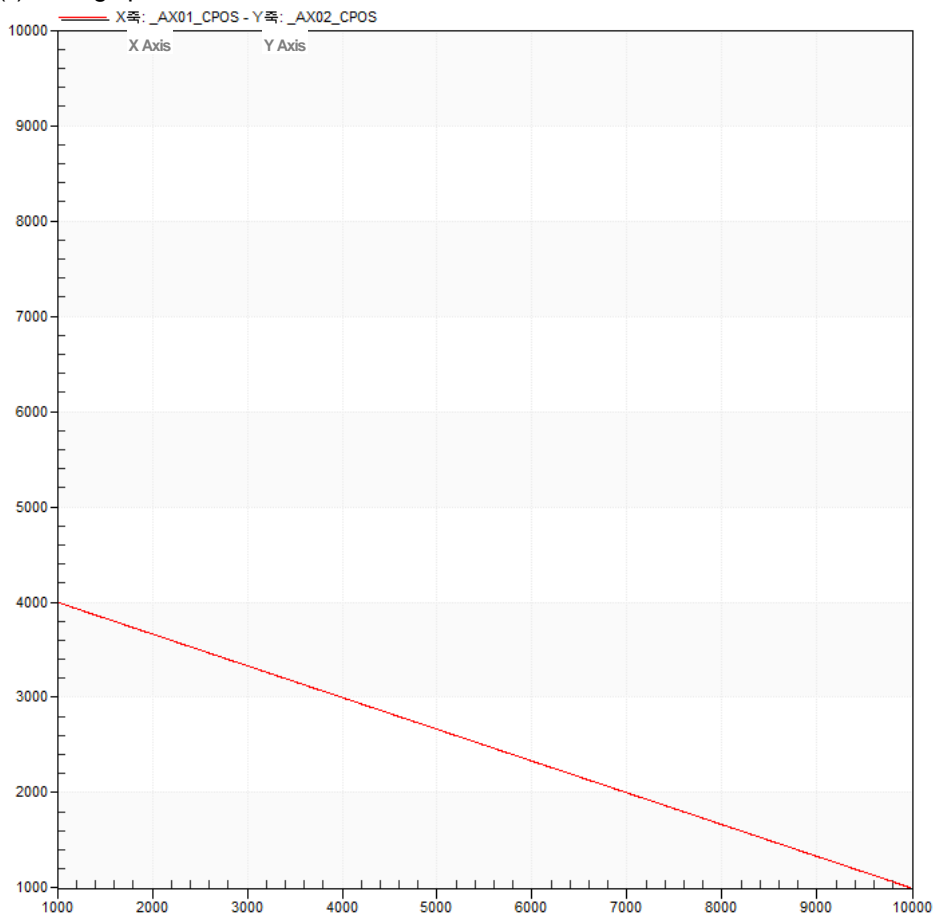
1	<GLOBAL>	%JL1.3		1.0000000000000000e+003	LREAL	_AX01_CPOS
2	<GLOBAL>	%JL2.3		4.0000000000000000e+003	LREAL	_AX02_CPOS
3	<GLOBAL>	%JL1.4		0.0000000000000000e+000	LREAL	_AX01_CVEL
4	<GLOBAL>	%JL2.4		0.0000000000000000e+000	LREAL	_AX02_CVEL
5	Group	GroupHome		On	BOOL	
6	Group	GroupHalt		Off	BOOL	
7	Group	Position23			ARRAY[0..3] OF LREAL	
8	Group	Position23[0]		1.0000000000000000e+004	LREAL	
9	Group	Position23[1]		1.0000000000000000e+003	LREAL	
10	Group	Position23[2]		0.0000000000000000e+000	LREAL	
11	Group	Position23[3]		0.0000000000000000e+000	LREAL	
12						

From start position to target position

(b) Timing diagram



(c) XY graph



## 6.5.12 Relative positioning linear interpolation operation(MC\_MoveLinearRelative)

Motion Function Block		
<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="border: 1px solid black; padding: 5px;"> <p style="text-align: center; margin: 0;">MC_MoveLinearRelative</p> <p>BOOL — Execute</p> <p>UINT — AxesGroup ----- AxesGroup</p> <p>LREAL[ ] — Distance</p> <p>LREAL — Velocity</p> <p>LREAL — Acceleration</p> <p>LREAL — Deceleration</p> <p>LREAL — Jerk</p> <p>UINT — BufferMode</p> <p>UINT — TransitionMode</p> <p>LREAL — TransitionParameter</p> </div> <div style="margin-left: 20px;"> <p>Done — BOOL</p> <p>Busy — BOOL</p> <p>Active — BOOL</p> <p>CommandAborted — BOOL</p> <p>Error — BOOL</p> <p>ErrorID — WORD</p> </div> </div>		
Input-Output		
UINT	AxesGroup	Set the group to do relative position linear interpolation operation. (1 ~ 16: Group 1 ~ Group 16)
Input		
BOOL	Execute	Give relative position linear interpolation operation command to the relevant group in the rising Edge.
LREAL[ ]	Distance	Set the target distance of each axis.
LREAL	Velocity	Specify the maximum speed of the route. [u/s]
LREAL	Acceleration	Specify the maximum acceleration. [u/s <sup>2</sup> ]
LREAL	Deceleration	Specify the maximum deceleration. [u/s <sup>2</sup> ]
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)
UINT	TransitionMode	Specify the route change mode of group operation. (Refer to 6.1.6.TransitionMode )
LREAL	TransitionParameter	Specify the parameter of the route change setting of group operation.. (Refer to 6.1.6.TransitionMode )
Output		
BOOL	Done	Indicate whether to reach the specified position.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block is to give a relative position linear interpolation command to the axis group specified in AxesGroup input.
- (2) When this motion function block is executed, interpolation control performed in a linear path from the current position

to the target position of each axis, and the moving direction is decided by the sign of the target distance of each axis.

Target distance > 0: Forward direction operation

Target distance < 0: Reverse direction operation

- (3) In Distance input, specify the target distance of each axis in the group as array. The specified array and the axis in the group correspond in the order of specified axis ID [ID1 target distance, ID2 target distance, ...].
- (4) Set the speed, acceleration, deceleration, and the change rate of acceleration/deceleration of interpolation route in Velocity, Acceleration, Deceleration, and Jerk inputs respectively.
- (5) Velocity is to set the interpolation speed of the axis group, and it indicates the integrated speed of each axis.

Operation speeds of each configuration axis are calculated as follows.

Interpolation speed (F) = Target speed specified in the Velocity

$$\text{Interpolation movement amount (S)} = \sqrt{S_1^2 + S_2^2 + S_3^2 + S_4^2}$$

$$\text{Configuration axis 1 speed (V}_1\text{)} = \text{Interpolation speed (F)} \times \frac{\text{Configuration axis 1 movement amount (S}_1\text{)}}{\text{Interpolation movement amount (S)}}$$

$$\text{Configuration axis 2 speed (V}_2\text{)} = \text{Interpolation speed (F)} \times \frac{\text{Configuration axis 2 movement amount (S}_2\text{)}}{\text{Interpolation movement amount (S)}}$$

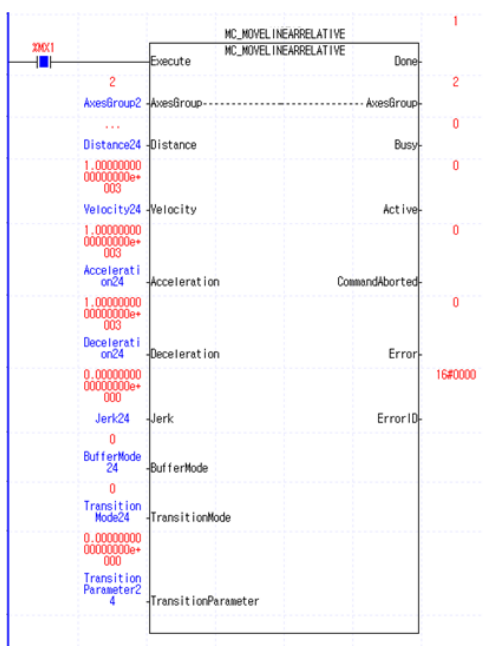
$$\text{Configuration axis 3 speed (V}_3\text{)} = \text{Interpolation speed (F)} \times \frac{\text{Configuration axis 3 movement amount (S}_3\text{)}}{\text{Interpolation movement amount (S)}}$$

$$\text{Configuration axis 4 speed (V}_4\text{)} = \text{Interpolation speed (F)} \times \frac{\text{Configuration axis 4 movement amount (S}_4\text{)}}{\text{Interpolation movement amount (S)}}$$

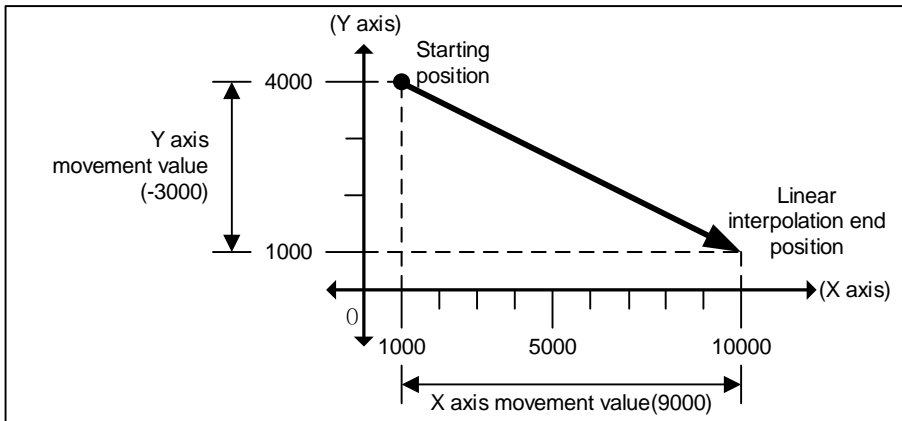
- (6) Refer to chapter 8.2.6 linear interpolation control part in motion control module's manual for more details.
- (7) The changed parameters can be applied by re-executing the function block (Execute input is On) before the command is completed. Only Velocity, Acceleration, Deceleration, Jerk, Position input can be updated.
- (8) Example program

This example shows the linear interpolation to the target position (10000, 1000) by moving the target distance (X-axis: 9000, Y-axis: -3000) when the current command position is (1000, 4000).

(a) Function block setting



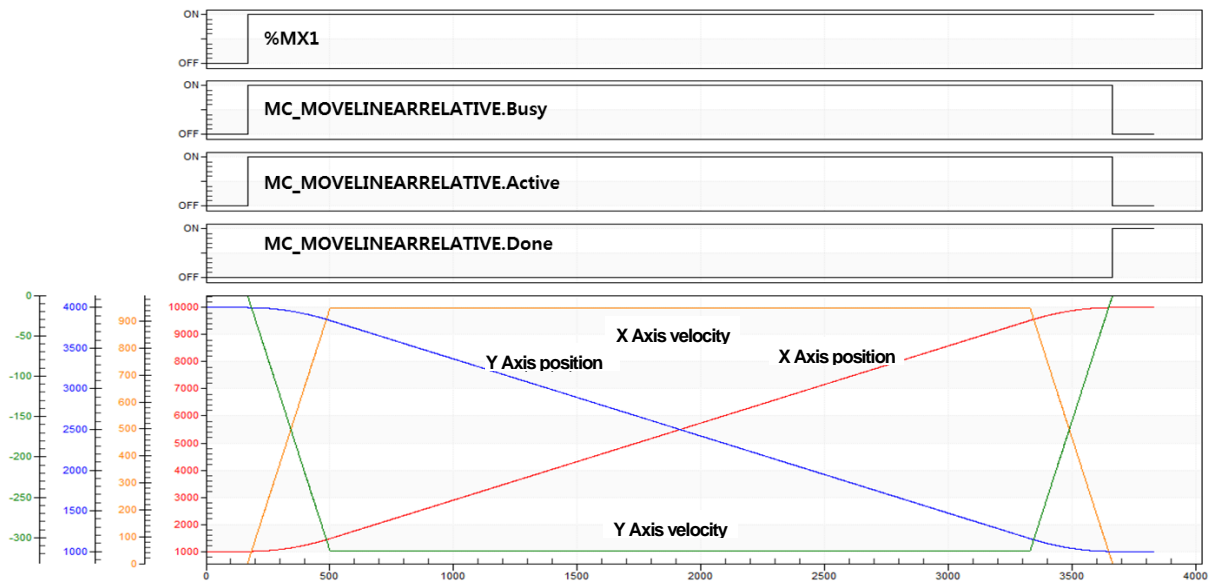




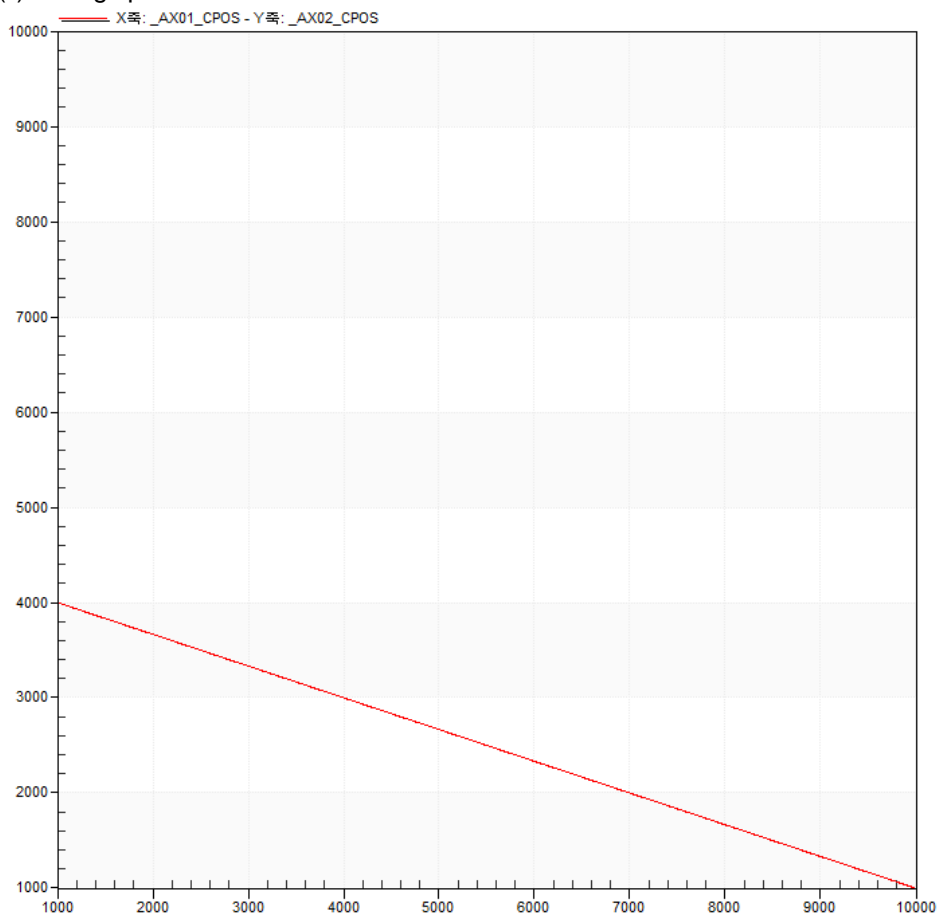
1	<GLOBAL>	%JL1.3	1.0000000000000000e+004	LREAL	_AX01_CPOS
2	<GLOBAL>	%JL2.3	1.0000000000000000e+003	LREAL	_AX02_CPOS
3	<GLOBAL>	%JL1.4	0.0000000000000000e+000	LREAL	_AX01_CVEL
4	<GLOBAL>	%JL2.4	0.0000000000000000e+000	LREAL	_AX02_CVEL
5	Group	GroupHome	On	BOOL	
6	Group	GroupHalt	Off	BOOL	
7	Group	Distance24		ARRAY[0..3] OF LREAL	
8	Group	Distance24 [0]	9.0000000000000000e+003	LREAL	
9	Group	Distance24 [1]	-3.0000000000000000e+003	LREAL	
10	Group	Distance24 [2]	0.0000000000000000e+000	LREAL	
11	Group	Distance24 [3]	0.0000000000000000e+000	LREAL	

Move as much as target move amount

(b) Timing diagram



(c) XY graph



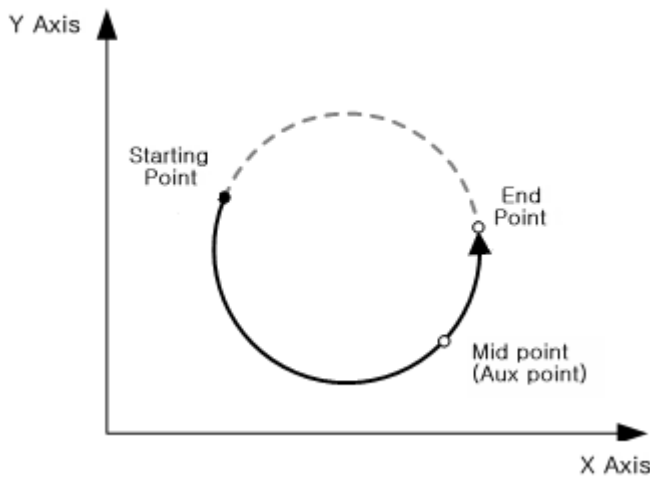
6.5.13 Absolute positioning circular interpolation operation(MC\_MoveCircularAbsolute)

Motion Function Block		
Input-Output		
UINT	AxesGroup	Set the group to do absolute position circular interpolation operation. (1 ~ 16: Group 1 ~ Group 16)
Input		
BOOL	Execute	Give absolute position circular interpolation operation command to the relevant group in the rising Edge.
UINT	CirMode	Circular interpolation method setting [0: Midpoint, 1: Central point, 2: Radius]
LREAL[]	AuxPoint	Specify the position of auxiliary point depending on the circular interpolation method in an absolute coordinate.
LREAL[]	EndPoint	Specify the end point of circular arc in an absolute coordinate.
BOOL	PathChoice	Circular route selection 0: Clockwise, 1: Counterclockwise
LREAL	Velocity	Specify the maximum speed of the route. [u/s]
LREAL	Acceleration	Specify the maximum acceleration. [u/s <sup>2</sup> ]
LREAL	Deceleration	Specify the maximum deceleration. [u/s <sup>2</sup> ]
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)
UINT	TransitionMode	Unused
LREAL	TransitionParameter	Unused
Output		
BOOL	Done	Indicate whether to reach the specified position.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.

BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

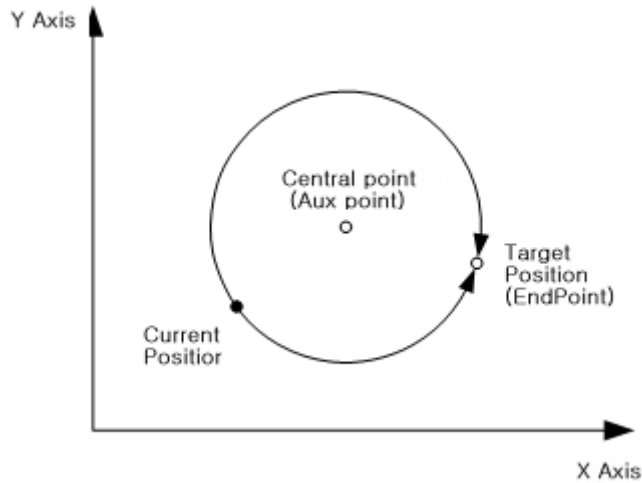
- (1) This motion function block is to give an absolute position circular interpolation command to the axis group specified in AxesGroup input.
- (2) When this motion function block starts, each axis performs circular path interpolation control which refers to the set auxiliary point, and the movement direction is decided by PathChoice input. When setting PathChoice input to 0, circular interpolation operation is done clockwise, and when setting it to 1, circular interpolation operation is done counterclockwise.
- (3) Specify the absolute position of the auxiliary point to refer when doing circular interpolation of each axis in AuxPoint and EndPoint inputs as array. The entered array and the axis in the group correspond in the order of the specified axis ID [ID1, ID2, ID3, ...]. (The 3 LEAL type sized array should be entered in Position input as there are 3 axes which comprise the group to give a circular interpolation operation command.)
- (4) Specify the speed, acceleration, deceleration, and the change rate of acceleration of interpolation route in Velocity, Acceleration, Deceleration, and Jerk inputs respectively.
- (5) Set the circular interpolation method in CircMode input. The circular interpolation methods which are different from the value specified in CircMode are as below.
  - (a) Circular interpolation of midpoint specifying method (BORDER, CircMode = 0)

In this method, operation starts at the starting point and it does circular interpolation through the specified position of the central point to the target position. The Figure below shows that the coordinate of the axis group at the beginning of a command corresponds to the starting point, the coordinate entered in AuxPoint corresponds to the central point, and the coordinate entered in EndPoint corresponds to the target position in an absolute value.



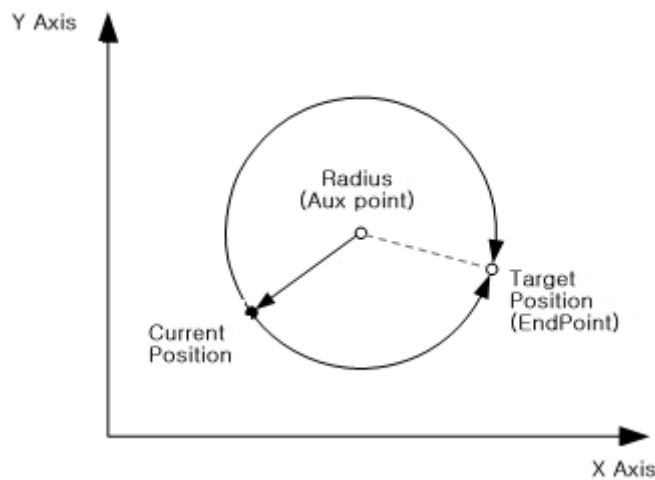
(b) Circular interpolation of central point specifying method

In this method, operation starts at the current position, and it does circular interpolation to the target position along the circular path, which has a radius of the distance to the specified central position. The Figure below shows that the coordinate of the axis group at the beginning of a command corresponds to the current position, the coordinate entered in AuxPoint corresponds to the central point, and the coordinate entered in EndPoint corresponds to the target point as an absolute value.



(c) Circular interpolation using the radius specifying method

In this method, operation starts at the current position, and it does circular interpolation to the target position along the circular path which has a radius of the value specified in the radius. The Figure below shows that the coordinate of the axis group at the beginning of a command corresponds to the current position, the value entered in X-axis of AuxPoint corresponds to the radius, and the coordinate entered in EndPoint corresponds to the target point in an absolute value.



(6) Refer to chapter 8.2.7 linear interpolation control part in motion control module's manual for more details.

(7) The changed parameters can be applied by re-executing the function block (Execute input is On) before the command is completed. Only Velocity, Acceleration, Deceleration, Jerk, AuxPoint, EndPoint input can be updated.

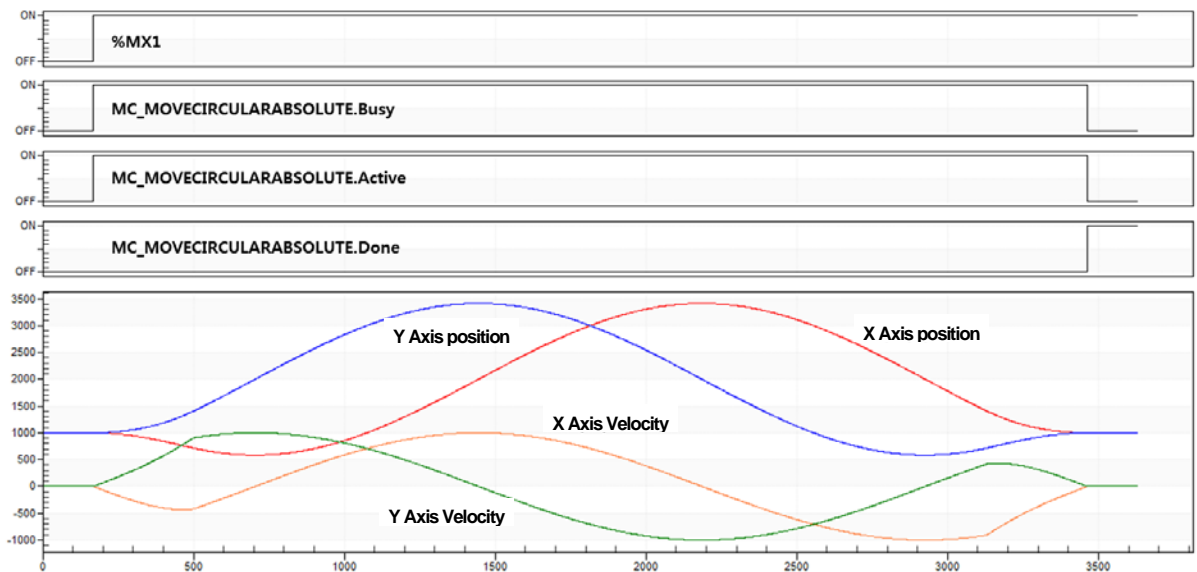
(8) Example program

This example shows the circular interpolation to the target position (1000, 1000) by moving clock-wise after setting the center point (2000,2000) specification method when the current command position is (1000, 1000).

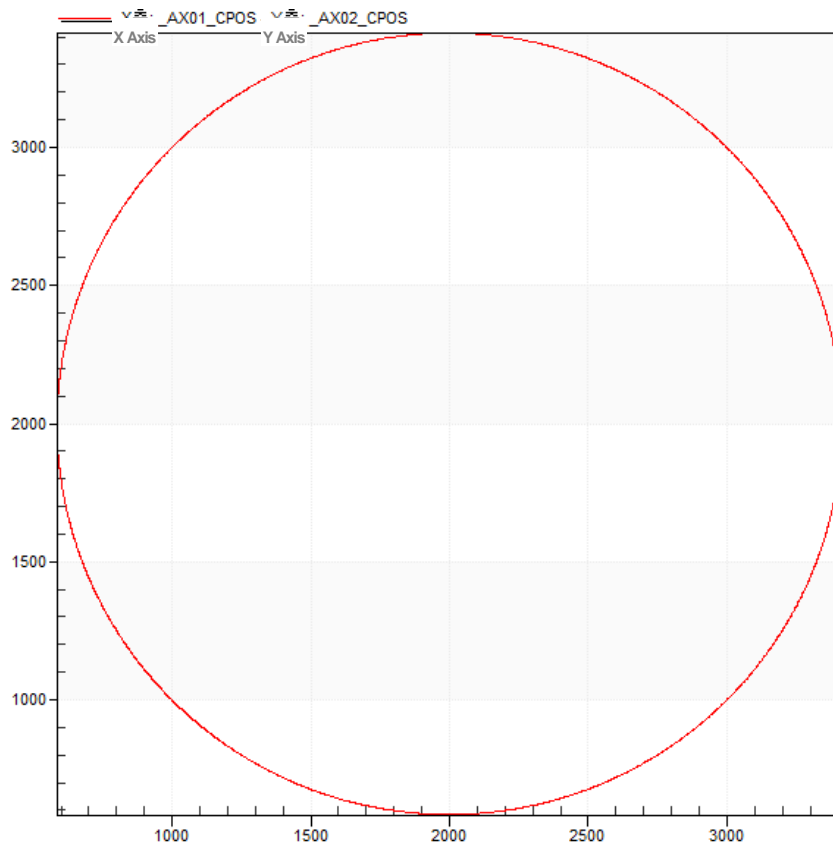
(a) Function block setting

1	<GLOBAL>	%JL1.3	1.0000000000000000e+003	LREAL	_AX01_CPOS	Start position
2	<GLOBAL>	%JL2.3	1.0000000000000000e+003	LREAL	_AX02_CPOS	
3	<GLOBAL>	%JL1.4	0.0000000000000000e+000	LREAL	_AX01_CVEL	
4	<GLOBAL>	%JL2.4	0.0000000000000000e+000	LREAL	_AX02_CVEL	
5	Group	AuxPoint		ARRAY[0..2] OF LREAL		
6	Group	AuxPoint[0]	2.0000000000000000e+003	LREAL		Middle point
7	Group	AuxPoint[1]	2.0000000000000000e+003	LREAL		
8	Group	AuxPoint[2]	0.0000000000000000e+000	LREAL		
9	Group	Endpoint		ARRAY[0..2] OF LREAL		
10	Group	Endpoint[0]	1.0000000000000000e+003	LREAL		Target position
11	Group	Endpoint[1]	1.0000000000000000e+003	LREAL		
12	Group	Endpoint[2]	0.0000000000000000e+000	LREAL		

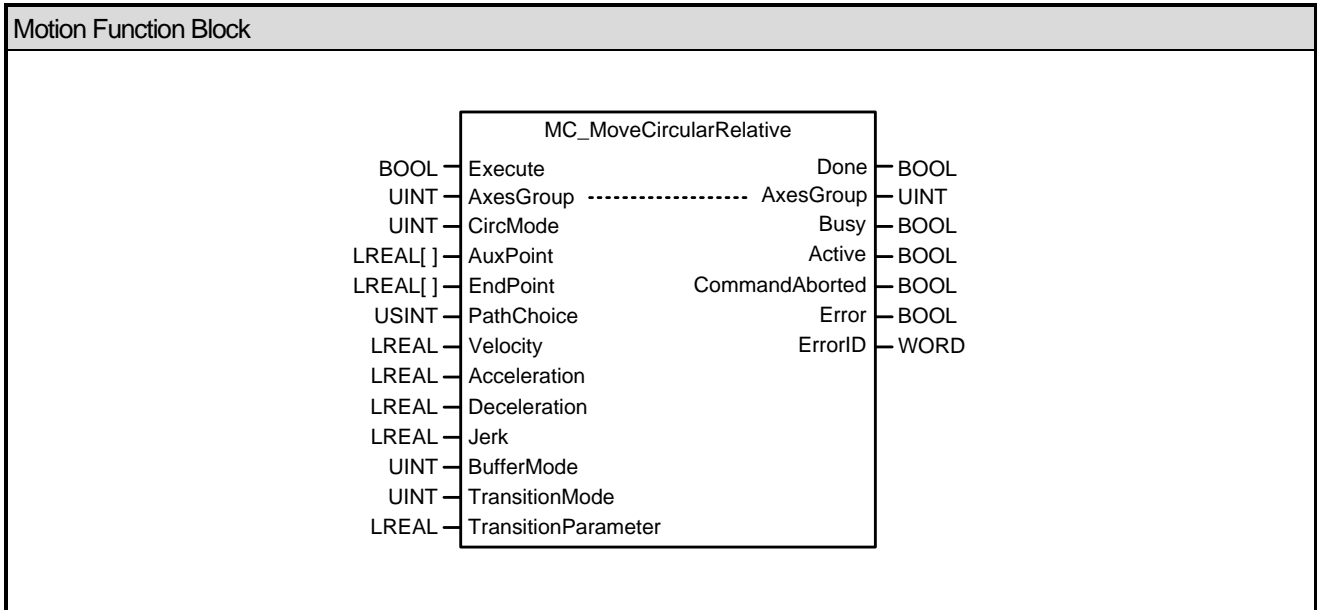
(b) Timing diagram



(c) XY graph



6.5.14 Relative positioning circular interpolation operation(MC\_MoveCircularRelative)



Input-Output

UINT	AxesGroup	Set the group to do absolute position circular interpolation operation. (1 ~ 16: Group 1 ~ Group 16)
------	-----------	--

Input

BOOL	Execute	Give relative position circular interpolation operation command to the relevant group in the rising edge.
UINT	CirMode	Circular interpolation method setting [0: Midpoint, 1: Central point, 2: Radius]
LREAL[]	AuxPoint	Specify the position of auxiliary point depending on the circular interpolation method as the relative coordinate based on the starting point.
LREAL[]	EndPoint	Specify the end point of circular arc as the relative coordinate based on the starting point.
BOOL	PathChoice	Circular route selection 0: Clockwise, 1: Counterclockwise
LREAL	Velocity	Specify the maximum speed of the route. [u/s]
LREAL	Acceleration	Specify the maximum acceleration. [u/s <sup>2</sup> ]
LREAL	Deceleration	Specify the maximum deceleration. [u/s <sup>2</sup> ]
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)
UINT	TransitionMode	Unused
LREAL	TransitionParameter	Unused

Output

BOOL	Done	Indicate whether to reach the specified position.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.

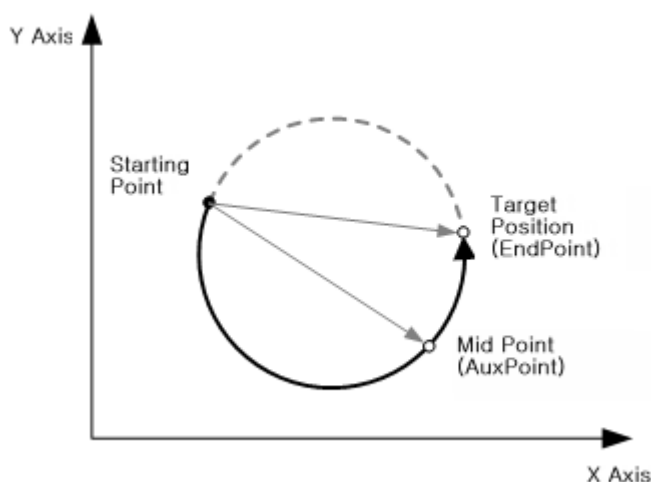


BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block is to give a relative position circular interpolation command to the axis group specified in AxesGroup input.
- (2) When this motion function block starts, each axis performs circular path interpolation control which refers to the set auxiliary point, and the movement direction is decided by PathChoice input. When setting PathChoice input to 0, circular interpolation operation is done clockwise, and when setting it to 1, circular interpolation operation is done counterclockwise.
- (3) Specify the relative position of the auxiliary point to refer when doing circular interpolation of each axis in AuxPoint and EndPoint inputs as array. The entered array and the axis in the group correspond in the order of the specified axis ID [ID1, ID2, ID3, ...]. (The 3 LEAL type sized array should be entered in Position input as there are 3 axes which comprise the group to give a circular interpolation operation command.)
- (4) Specify the speed, acceleration, deceleration, and the change rate of acceleration of interpolation route in Velocity, Acceleration, Deceleration, and Jerk inputs respectively.
- (5) Set the circular interpolation method in CircMode input. The circular interpolation methods which are different from the value specified in CircMode are as below.
  - (a) Circular interpolation of midpoint specifying method (BORDER, CircMode = 0)

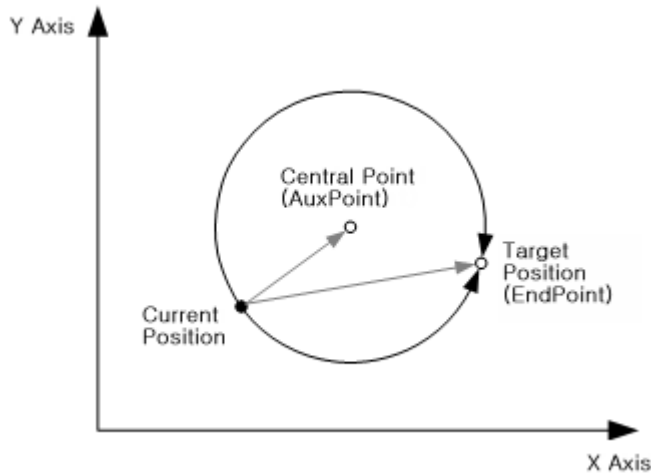
In this method, operation starts at the current position and it does circular interpolation through the specified position of the central point to the target position.

The Figure below shows that the coordinate of the axis group at the beginning of a command corresponds to the current position, the coordinate entered in AuxPoint corresponds to the central point, and the coordinate entered in EndPoint corresponds to the target position in a relative value.



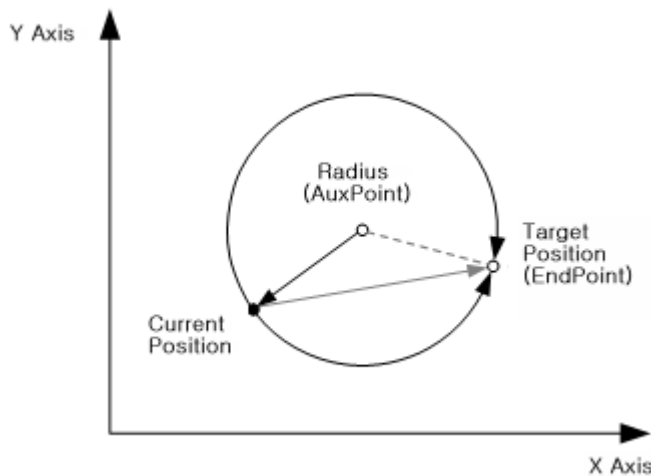
(b) Circular interpolation of central point specifying method

In this method, operation starts at the current position, and it does circular interpolation to the target position along the circular path, which has a radius of the distance to the specified central position. The Figure below shows that the coordinate of the axis group at the beginning of a command corresponds to the current position, the coordinate entered in AuxPoint corresponds to the central point, and the coordinate entered in EndPoint corresponds to the target point as a relative value.



(c) Circular interpolation using the radius specifying method

In this method, operation starts at the current position, and it does circular interpolation to the target position along the circular path which has a radius of the value specified in the radius. The Figure below shows that the coordinate of the axis group at the beginning of a command corresponds to the current position, the value entered in X-axis of AuxPoint corresponds to the radius, and the coordinate entered in EndPoint corresponds to the target point in a relative value.



(6) Refer to linear interpolation control part in motion control module's manual for more details.

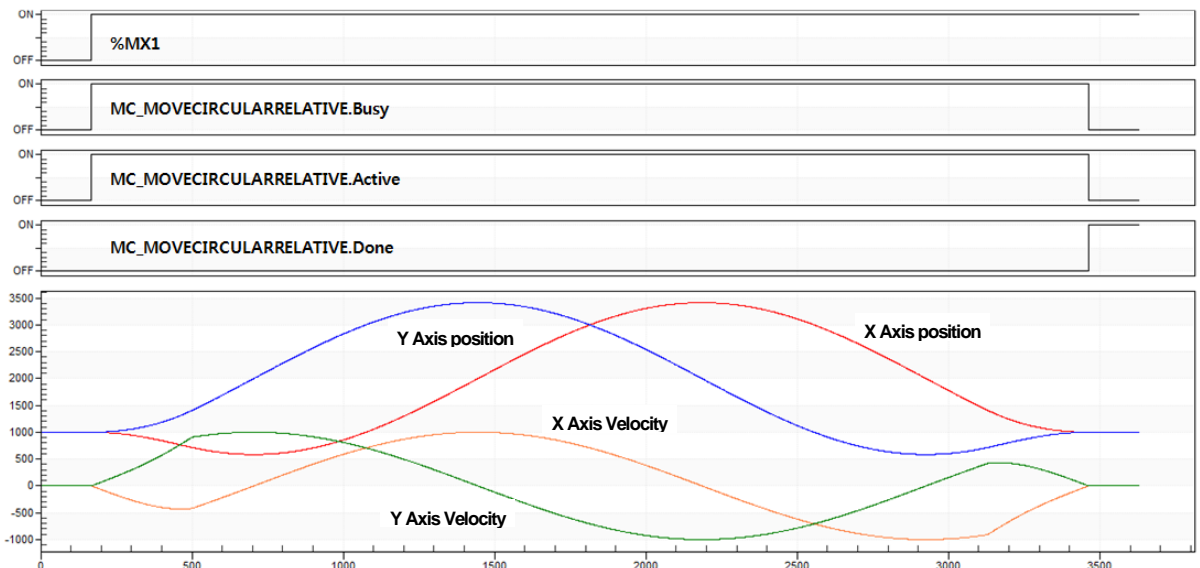
(7) Example program

This example is to set the center point specification method when the current command position is (1000, 1000) (set the relative position from the current position to the center point to set: 1000, 1000), and move clock-wise to perform circular interpolation to the target position (set the relative position from the current position to the target position: 0, 0).

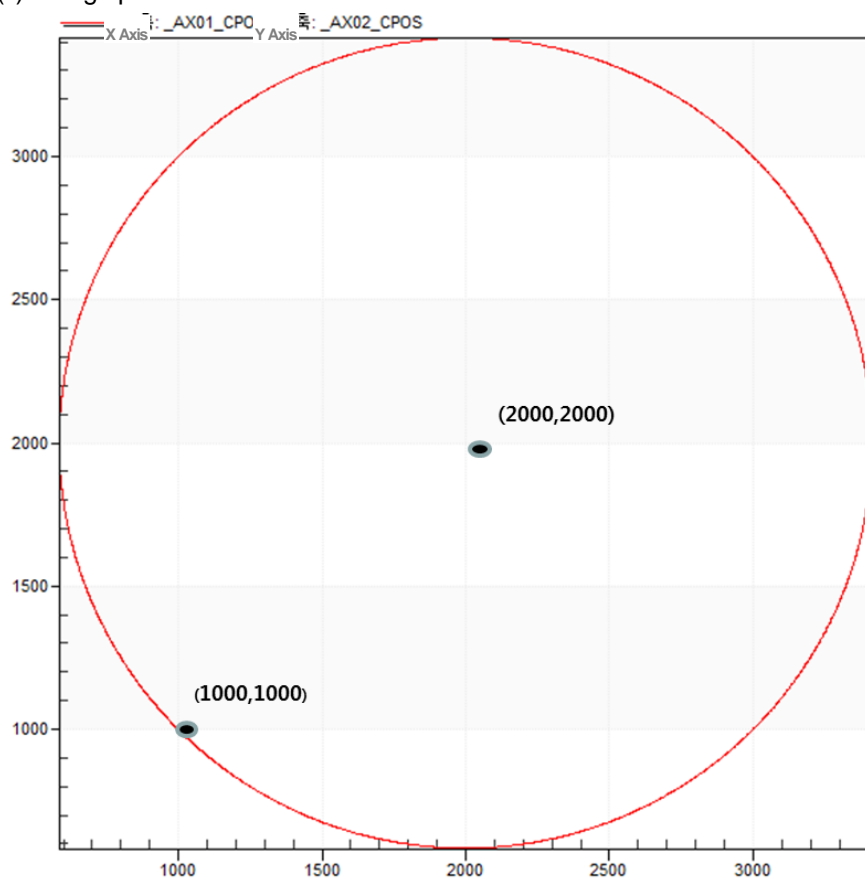
(a) Function block setting

1	<GLOBAL>	%JL1.3	±10	1.0000000000000000e+003	LREAL	_AX01_CPOS	Start position
2	<GLOBAL>	%JL2.3	±10	1.0000000000000000e+003	LREAL	_AX02_CPOS	
3	<GLOBAL>	%JL1.4	±10	0.0000000000000000e+000	LREAL	_AX01_CVEL	Distance to the middle point (Distance from the start position)
4	<GLOBAL>	%JL2.4	±10	0.0000000000000000e+000	LREAL	_AX02_CVEL	
5	Group	AuxPoint52			ARRAY[0..2] OF LREAL		Distance to the target (Distance from the start position)
6	Group	AuxPoint52 [0]	±10	1.0000000000000000e+003	LREAL		
7	Group	AuxPoint52 [1]	±10	1.0000000000000000e+003	LREAL		
8	Group	AuxPoint52 [2]	±10	0.0000000000000000e+000	LREAL		
9	Group	Endpoint52			ARRAY[0..2] OF LREAL		
10	Group	Endpoint52 [0]	±10	0.0000000000000000e+000	LREAL		
11	Group	Endpoint52 [1]	±10	0.0000000000000000e+000	LREAL		
12	Group	Endpoint52 [2]	±10	0.0000000000000000e+000	LREAL		

(b) Timing diagram

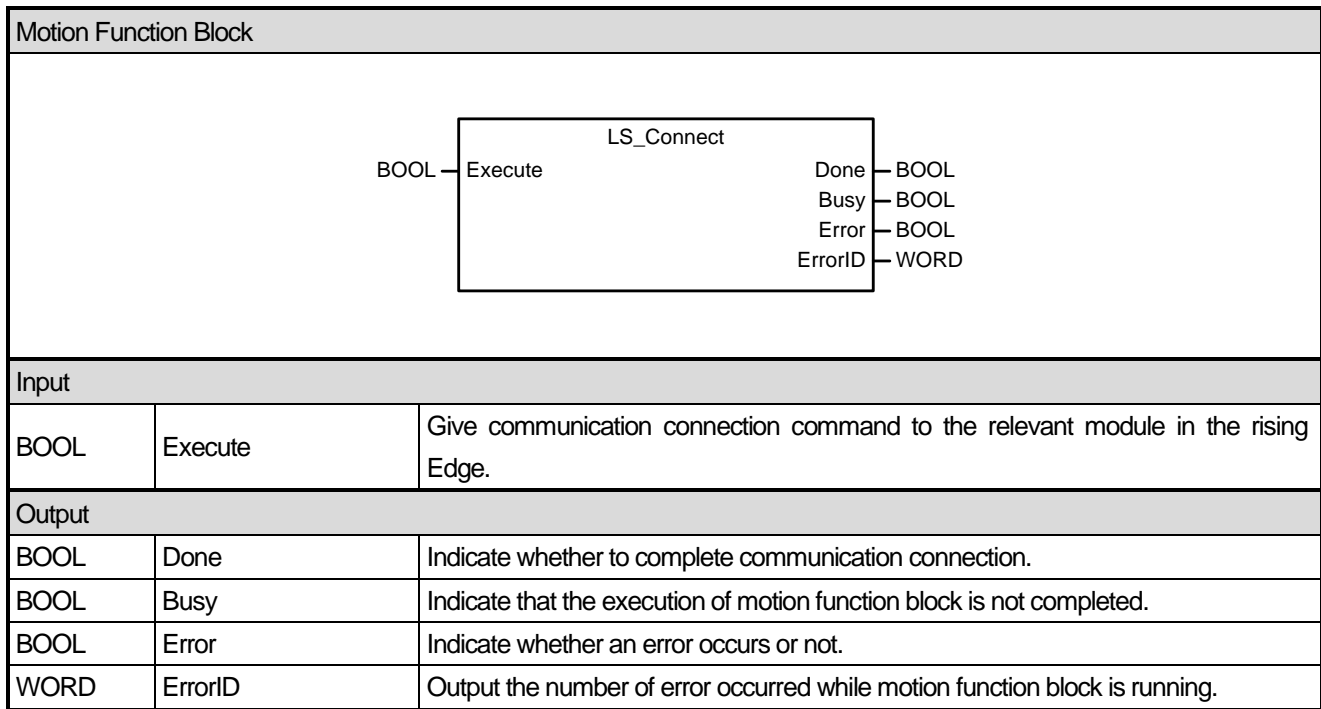


(c) XY graph



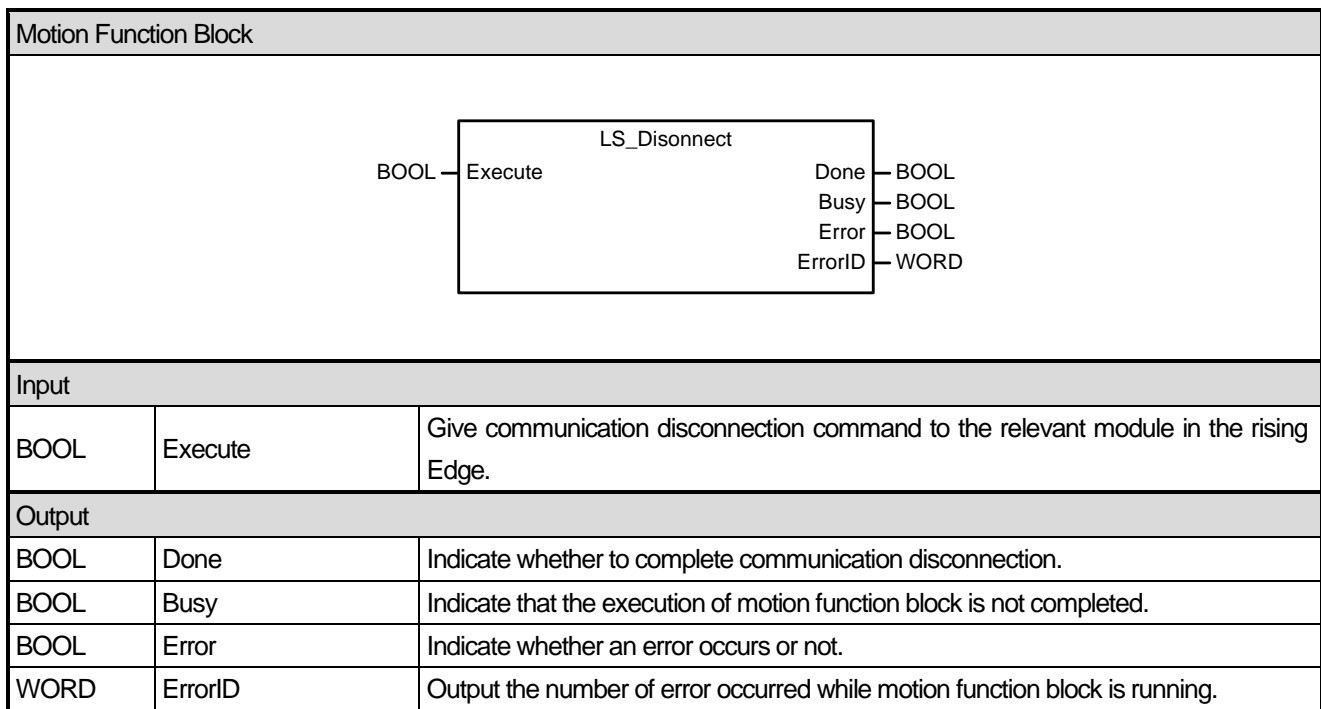
## 6.6 Exclusive Function Blocks

### 6.6.1 Connect servo drives(LS\_Connect)



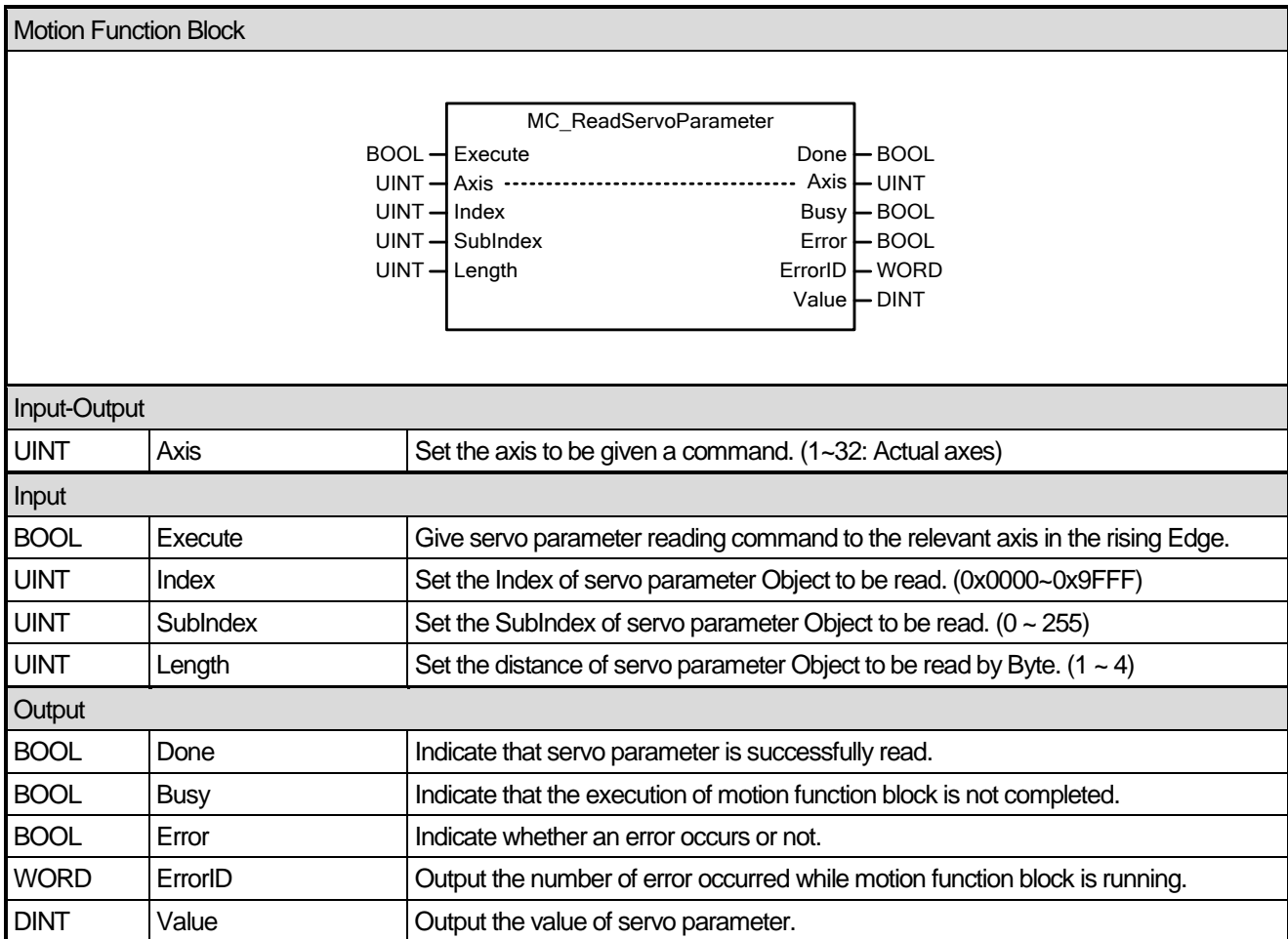
- (1) This motion function block is to give a command to connect communication with servo drive or external input/output apparatus to the module.
- (2) When slave devices are normally connected, Done is On and Busy is Off.
- (3) If an error occurs during the communication connection, Error is On and error number is output in ErrorID according to the cause.

6.6.2 Disconnect servo drives(LS\_Disconnect)



- (1) This motion function block gives a command which orders the module to disconnect the communication with servo drive or external input/output apparatuses.
- (2) If communication slave is disconnected, Done is On and Busy is off.
- (3) If an error occurs during the execution of communication disconnection, Error is On and error number is output in ErrorID according to the error situation.

6.6.3 Read servo parameters(LS\_ReadServoParameter)

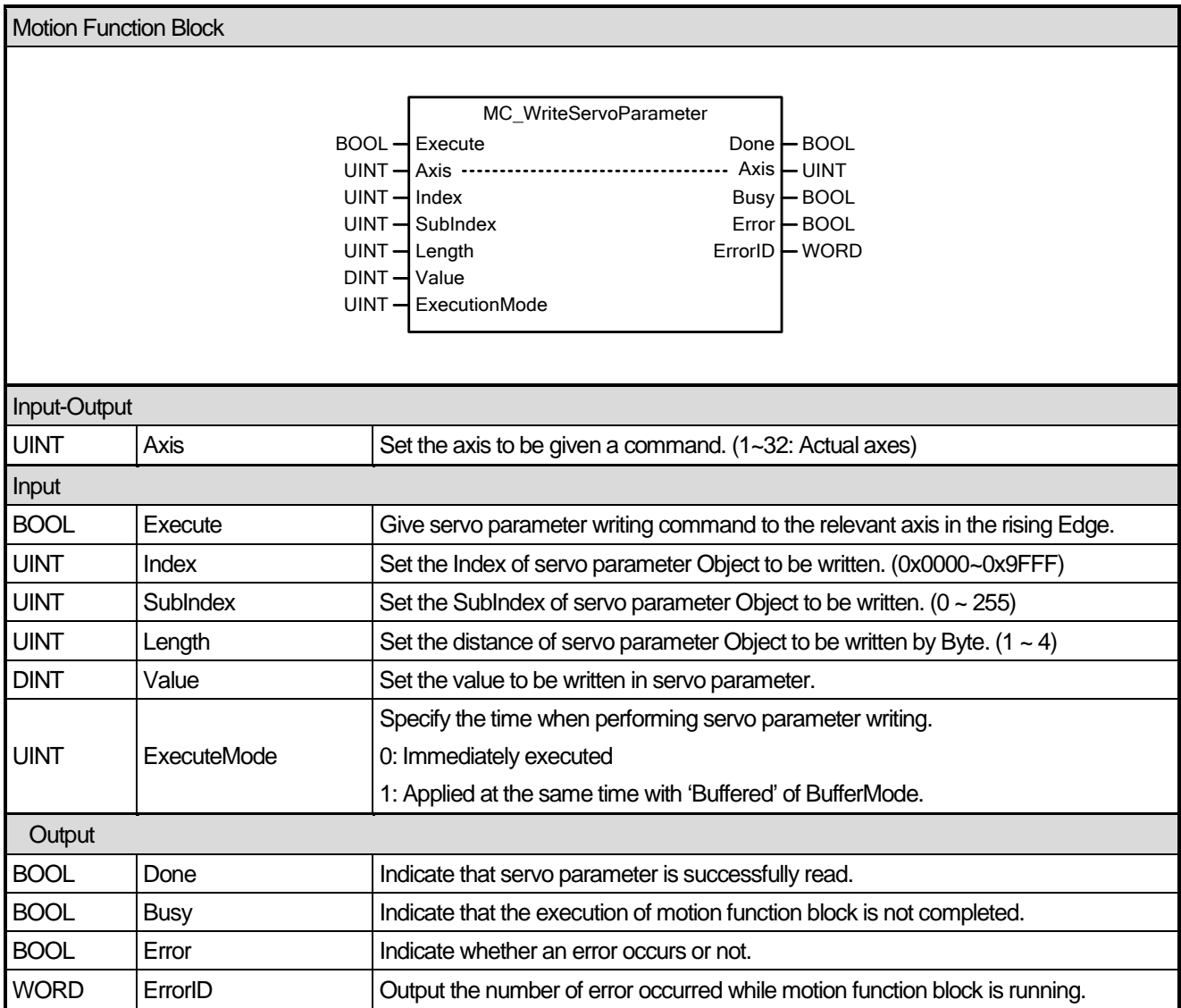


- (1) This motion function block is to read the parameter (CoE Object) value of servo drive in the relevant axis, and reads the servo parameter value of the position specified in Index and SubIndex of the axis specified by Axis input as much as the size of Length and indicates it on Value output.
- (2) Value output is eliminated to 0 when motion function block is running, and it is output as the read value when the running is completed (Done output is On).
- (3) Index input can be set as below. If the value is set outside the range, "error 0x1F12" occurs.

Variable	Description
16#0000 ~ 16#0FFF	Data Type Description
16#1000 ~ 16#1FFF	Communication objects
16#2000 ~ 16#5FFF	Manufacturer Specific Profile Area
16#6000 ~ 16#9FFF	Standardized Device Profile Area

- (4) The value between 0~255 can be entered in SubIndex, and if the value is set outside the range, "error 0x1F12" occurs.
- (5) The value between 1~4 can be set in Length, which means 1~4 Byte. If the value is set outside the range, "error 0x1F12" occurs.

6.6.4 Write servo parameters(LS\_WriteServoParameter)



- (1) This motion function block is to write the parameter (CoE Object) value of the relevant axis servo drive, and it writes the value entered in Value as the size of the Length in servo parameter of the position specified as Index and SubIndex of the axis specified in Axis input.
- (2) Index input can be set as below. When it is set to the value besides the set value, "error 0x1F12" occurs.

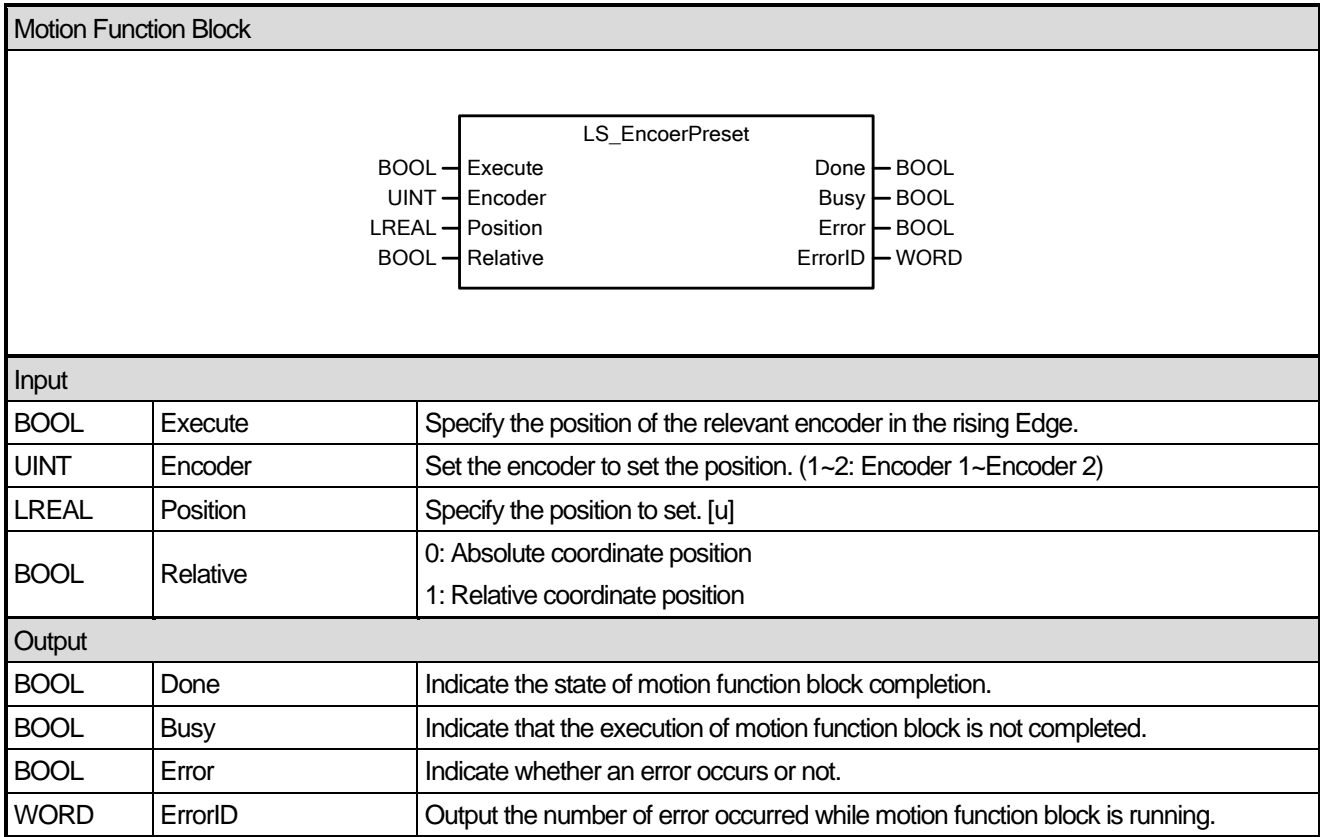
Value	Description
16#0000 ~ 16#0FFF	Data Type Description
16#1000 ~ 16#1FFF	Communication objects
16#2000 ~ 16#5FFF	Manufacturer Specific Profile Area
16#6000 ~ 16#9FFF	Standardized Device Profile Area

- (3) The value between the range of 0~255 can be entered in SubIndex, and if the value outside the range is set, "error 0x1F12" occurs.



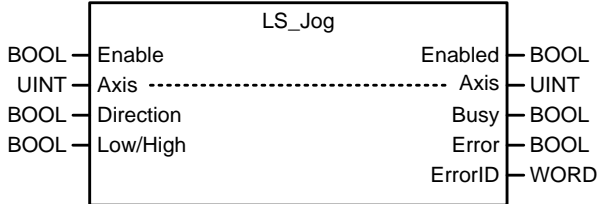
- (4) The value between the range of 1~4 can be entered in Length, which means 1~4 Byte. If the value outside the range is set, "error 0x1F12" occurs.
- (5) The time when parameter is written is set in ExecutionMode, and values can be set as below. The value unable to be set causes "error0x101B".
  - 0 (mcImmediately): Change the parameter value immediately after the execution of motion function block(rising Edge in Execute input) If the relevant axis is running, operation can be affected.
  - 1 (mcQueued): Changed at the same time with'Buffered'of BufferMode. (Refer to 6.1.4.BufferMode Input)
- (6) When an instruction is executed with ExecutionMode set to 1 and waiting for execution, if another instruction is executed with BufferMode 0 (Aborting) and aborted, Error is 1 and ErrorId is 0.

6.6.5 Encoder preset(LS\_EncoerPreset)



- (1) This motion function block is to set the current position of the relevant encoder.
- (2) Specify the position in Position input. When executing motion function command, if Relative input is Off, the position of the current axis is replaced with the Position input value, and if the Relative input is On, the Position input value is added to the current position of the relevant axis.

### 6.6.6 JOG operation( LS\_Jog )

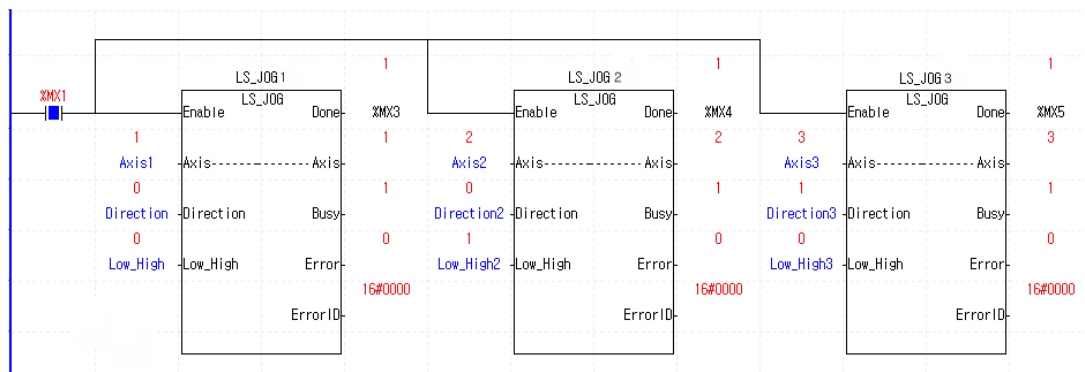
Motion Function Block		
		
Input-Output		
UINT	Axis	Set the axis to be given a command. (1~32: Actual axes)
Input		
BOOL	Enable	Give jog command to the relevant axis while input is On.
BOOL	Direction	Set the rotation direction in jog (0: Forward direction, 1: Reverse direction)
BOOL	Low/High	Set the jog speed in jog. (0: Jog low speed operation, 1: Jog high speed operation)
Output		
BOOL	Enabled	Indicate that the relevant axis is in jog.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block is to make the relevant axis perform jog operation.
- (2) Jog is a manual operation function for test and is used to confirm the position address for system operation, wiring condition check, and teaching. Jog can be used by dividing the speed into high speed and low speed.
- (3) When Enable input is On (in jog), if the value set in Low/High is changed, speed change occurs without stop in jog, and if the value set in JOG\_DIR is changed, Jog is continued by changing the direction after the deceleration pause.

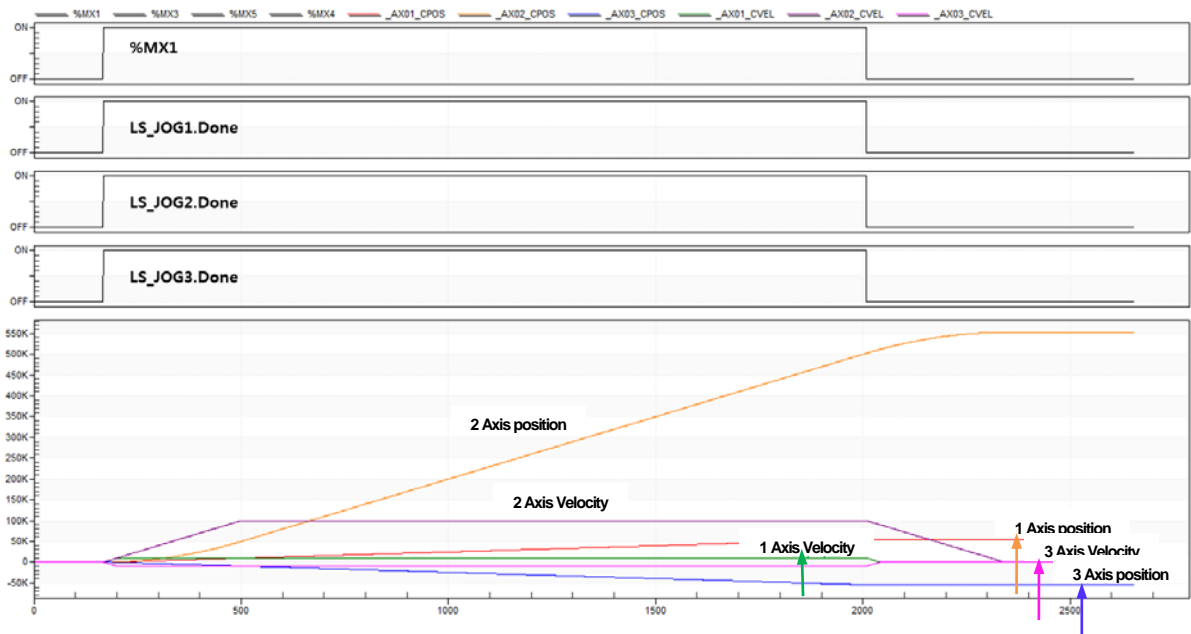
(4) Example program

This example shows jog operation under the following settings when the current command position is 0.

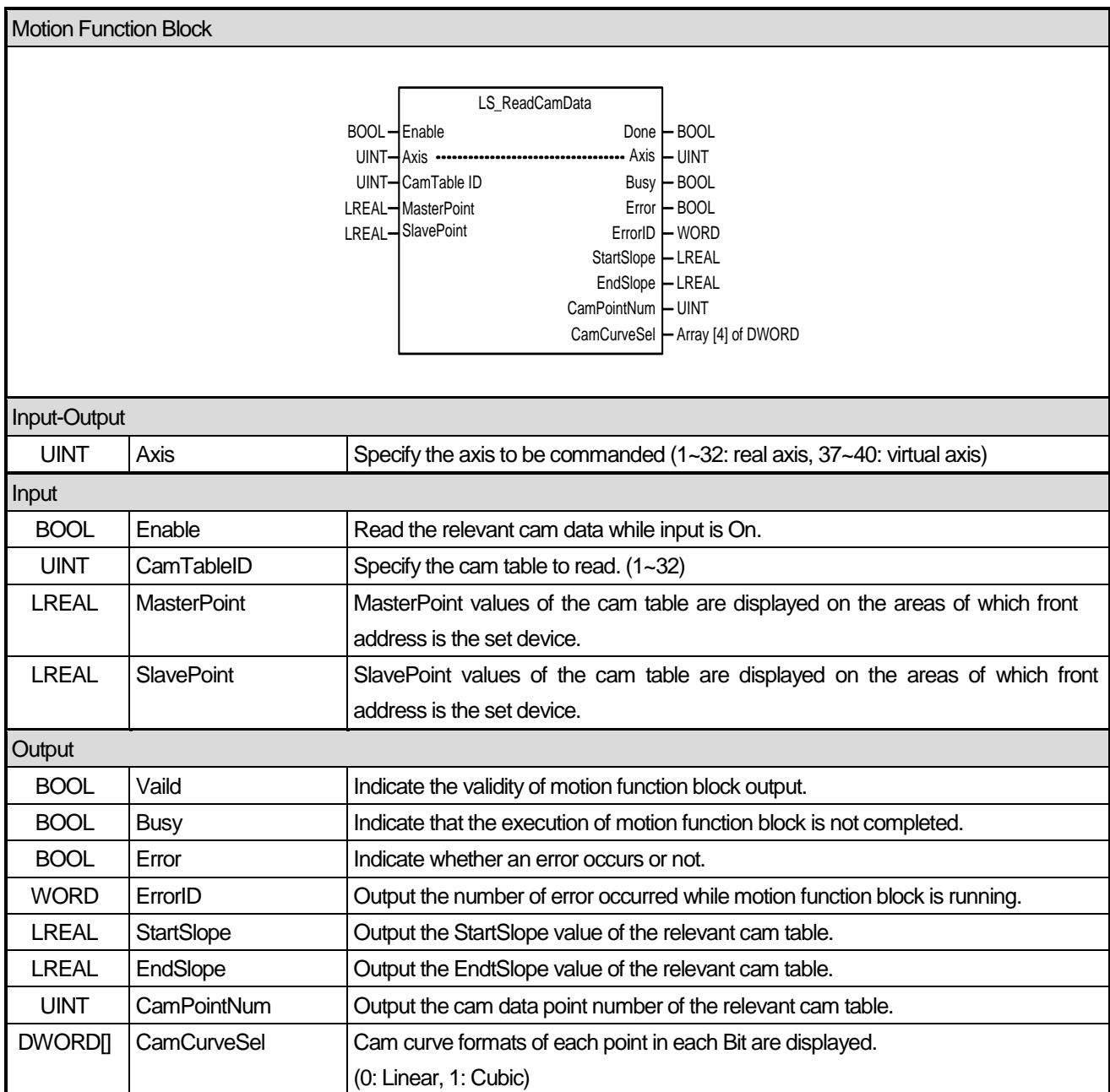
(a) Function block setting



(b) Timing diagram



6.6.7 Read Cam Data(LS\_ReadCamData)

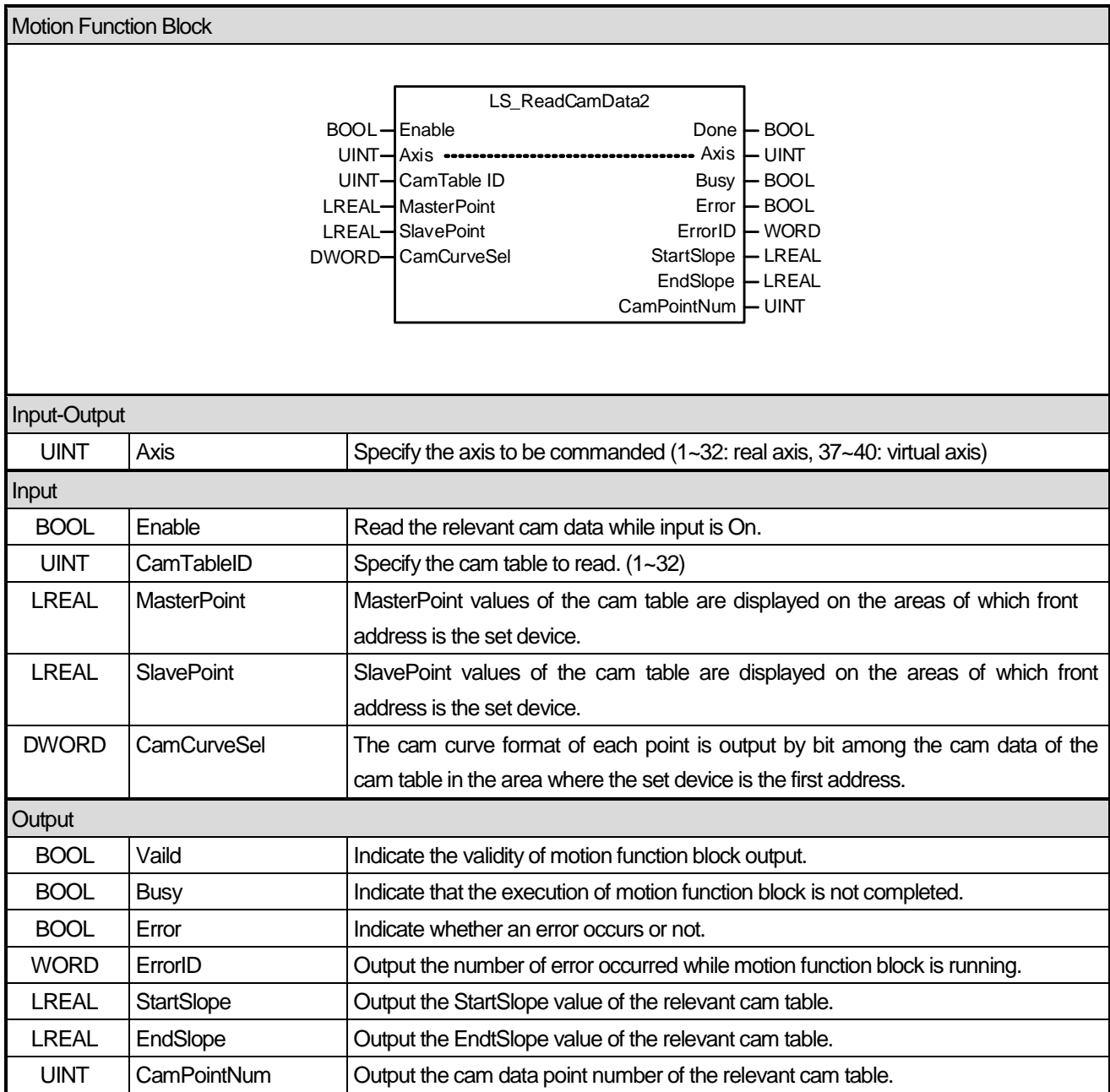


- (1) This function block displays the data of the cam table.
- (2) While Enable input is activated, the data values of the cam table are displayed in succession.
- (3) In MasterPoint and SlavePoint, set the first address of variables to store the values of 'main axis position' and 'sub axis position' among the data read from the corresponding cam profile. For example, In order to save the 'main axis position' value in the %ML100~%ML199 device among the read data and save the 'sub axis position' value in the %ML300~399 device among the read data, you must set %ML100 to the MasterPoint of the function block and set %ML300 to the SlavePoint.

(4) CamCurveSel outputs the curve type of the point for each bit. (Available only up to Point32)

CamCurveSel[0]	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Point 8	Point 7	Point 6	Point 5	Point 4	Point 3	Point 2	Point 1
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Point 16	Point 15	Point 14	Point 13	Point 12	Point 11	Point 10	Point 9
	Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16
	Point 24	Point 23	Point 22	Point 21	Point 20	Point 19	Point 18	Point 17
	Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24
	Point 32	Point 31	Point 30	Point 29	Point 28	Point 27	Point 26	Point 25

6.6.8 Read Cam Data2 (LS\_ReadCamData2)



- (1) This function block displays the data of the cam table. It was added to complement the CamCurveSel function of the LS\_ReadCamData function block. If you want to use more than 33 points of CamCurveSel output, you should use LS\_ReadCamData2.
- (2) While Enable input is activated, the data values of the cam table are displayed in succession.
- (3) In MasterPoint and SlavePoint, set the first address of variables to store the values of 'main axis position' and 'sub axis position' and 'cam curve format' among the data read from the corresponding cam profile. For example, In order to save the 'main axis position' value in the %ML100~%ML199 device among the read data and save the 'sub axis position' value in the %ML300~399 device among the read data and save the 'cam curve format' value in the %MD1000 device among the read data, you must set %ML100 to the MasterPoint of the function block and

set %ML300 to the SlavePoint and set %MD1000 to the CamCurveSel.

- (4) From the head address of the internal memory set in CamCurveSel, the curve type of the corresponding point is output for each bit.

CamCurveSel (DWORD)	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Point 8	Point 7	Point 6	Point 5	Point 4	Point 3	Point 2	Point 1
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Point 16	Point 15	Point 14	Point 13	Point 12	Point 11	Point 10	Point 9
	Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16
	Point 24	Point 23	Point 22	Point 21	Point 20	Point 19	Point 18	Point 17
	Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24
Point 32	Point 31	Point 30	Point 29	Point 28	Point 27	Point 26	Point 25	
CamCurveSel + 1 (DWORD)	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Point 40	Point 39	Point 38	Point 37	Point 36	Point 35	Point 34	Point 33
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Point 48	Point 47	Point 46	Point 45	Point 44	Point 43	Point 42	Point 41
	Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16
	Point 56	Point 55	Point 54	Point 53	Point 52	Point 51	Point 50	Point 49
	Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24
Point 64	Point 63	Point 62	Point 61	Point 60	Point 59	Point 58	Point 57	
CamCurveSel + 2 (DWORD)	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Point 72	Point 71	Point 70	Point 69	Point 68	Point 67	Point 66	Point 65
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Point 80	Point 79	Point 78	Point 77	Point 76	Point 75	Point 74	Point 73
	Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16
	Point 88	Point 87	Point 86	Point 85	Point 84	Point 83	Point 82	Point 81
	Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24
Point 96	Point 95	Point 94	Point 93	Point 92	Point 91	Point 90	Point 89	
CamCurveSel + 3 (DWORD)	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Not used.				Point 100	Point 99	Point 98	Point 97
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Not used.							
	Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16
	Not used.							
	Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24
Not used.								



6.6.9 Write Cam data(LS\_WriteCamData)

Motion Function Block		
<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: right;"> <p>BOOL—Execute</p> <p>UINT—Axis</p> <p>UINT—CamTable ID</p> <p>LREAL—StartSlope</p> <p>LREAL—EndSlope</p> <p>UINT—CamPointNum</p> <p>Array[4] of DWORD—CamCurveSel</p> <p>LREAL—MasterPoint</p> <p>LREAL—SlavePoint</p> <p>UINT—ExecutionMode</p> </div> <div style="border: 1px solid black; padding: 5px; text-align: center;"> <p>LS_WriteCamData</p> </div> <div style="text-align: left;"> <p>Done—BOOL</p> <p>Axis—UINT</p> <p>Busy—BOOL</p> <p>Error—BOOL</p> <p>ErrorID—WORD</p> </div> </div>		
Input-Output		
UINT	Axis	Specify the axis to be commanded (1~32: real axis, 37~40: virtual axis)
Input		
BOOL	Execute	Give the cam data writing command in the rising Edge of the input.
UINT	CamTableID	Specify the ID of the cam table to write. (1~32)
LREAL	StartSlope	Specify the StartSlope value of the cam table to write.
LREAL	EndSlope	Specify the StartSlope value of the cam table to write.
UINT	CamPointNum	Specify the cam data point number of the cam table to write.
DWORD[]	CamCurveSel	Of the cam data to write, set the cam curve format of each point by bit. (0: Linear, 1: Cubic)
LREAL	MasterPoint	Of the cam data to write, set the leading address of the device where Master Point value is stored.
LREAL	SlavePoint	Of the cam data to write, set the leading address of the device where Slave Point value is stored.
UINT	ExecutionMode	Set the timing to write the cam data. 0 - Immediately applied, 1: Applied at the same point with 'Buffered' of Buffermode
Output		
BOOL	Done	This represents successful cam data writing.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block is a command to write the data value of the cam table. Of the cam table data set by CamTableID input, use the value of the device set at MasterPoint and Slave Point at the value set at StartSlope and EndSlope and the set number at CamPointNum as the MasterPoint and SlavePoint values.
- (2) CamTableID input can be set to between 1 and 32. Setting a value outside the above range will cause "Error 16#000B"

- (3) CamPointNum input can be set to between 1 and 100. Setting a value outside the above range will cause "Error 16#000B"
- (4) The curve type of the point can be set for each bit in CamCurveSel[4].

CamCurveSel[0]	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Point 8	Point 7	Point 6	Point 5	Point 4	Point 3	Point 2	Point 1
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Point 16	Point 15	Point 14	Point 13	Point 12	Point 11	Point 10	Point 9
	Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16
	Point 24	Point 23	Point 22	Point 21	Point 20	Point 19	Point 18	Point 17
	Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24
CamCurveSel[1]	Point 32	Point 31	Point 30	Point 29	Point 28	Point 27	Point 26	Point 25
	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Point 40	Point 39	Point 38	Point 37	Point 36	Point 35	Point 34	Point 33
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Point 48	Point 47	Point 46	Point 45	Point 44	Point 43	Point 42	Point 41
	Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16
	Point 56	Point 55	Point 54	Point 53	Point 52	Point 51	Point 50	Point 49
CamCurveSel[2]	Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24
	Point 64	Point 63	Point 62	Point 61	Point 60	Point 59	Point 58	Point 57
	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Point 72	Point 71	Point 70	Point 69	Point 68	Point 67	Point 66	Point 65
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Point 80	Point 79	Point 78	Point 77	Point 76	Point 75	Point 74	Point 73
	Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16
CamCurveSel[3]	Point 88	Point 87	Point 86	Point 85	Point 84	Point 83	Point 82	Point 81
	Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24
	Point 96	Point 95	Point 94	Point 93	Point 92	Point 91	Point 90	Point 89
	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Not used				Point 100	Point 99	Point 98	Point 97
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Not used							
Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16	
Not used								
Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24	
Not used								

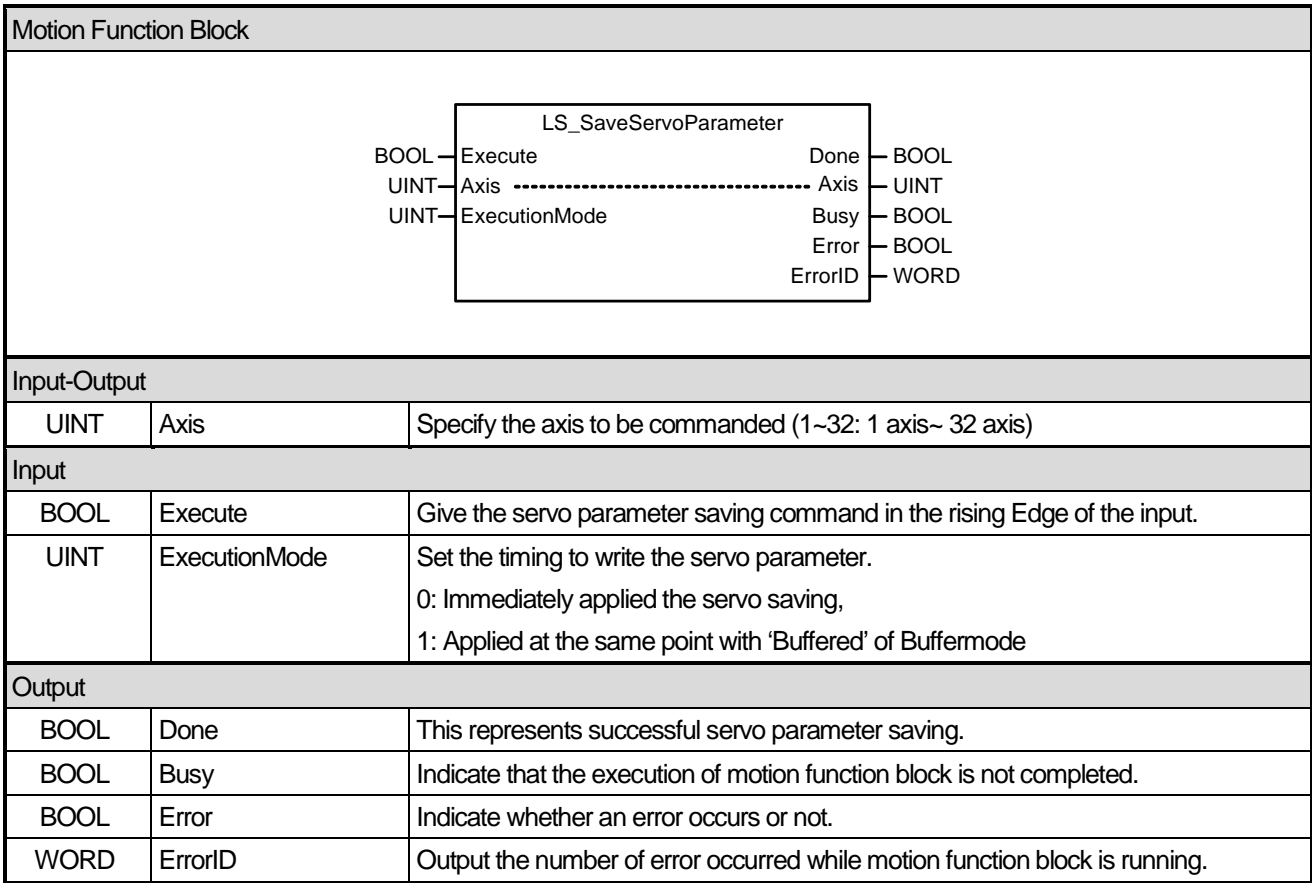
- (5) ExecutionMode input sets the setting timing. When the input is 0, setting is performed upon executing the command. When the input is 1, setting is performed at the same time as "Buffered" at the sequential operation. Setting an incorrect value will cause "Error 16#000B".

0(mclImmediately) : Itchanges the (Upward Edge of Execute input) parameter value upon executing the function block. If the axis is in operation, the motion may be affected.

1(mcQueued) : It is changed at the same point of time as in "Buffered" of Buffermode.(Refer to 6.1.4. BufferMode Input)

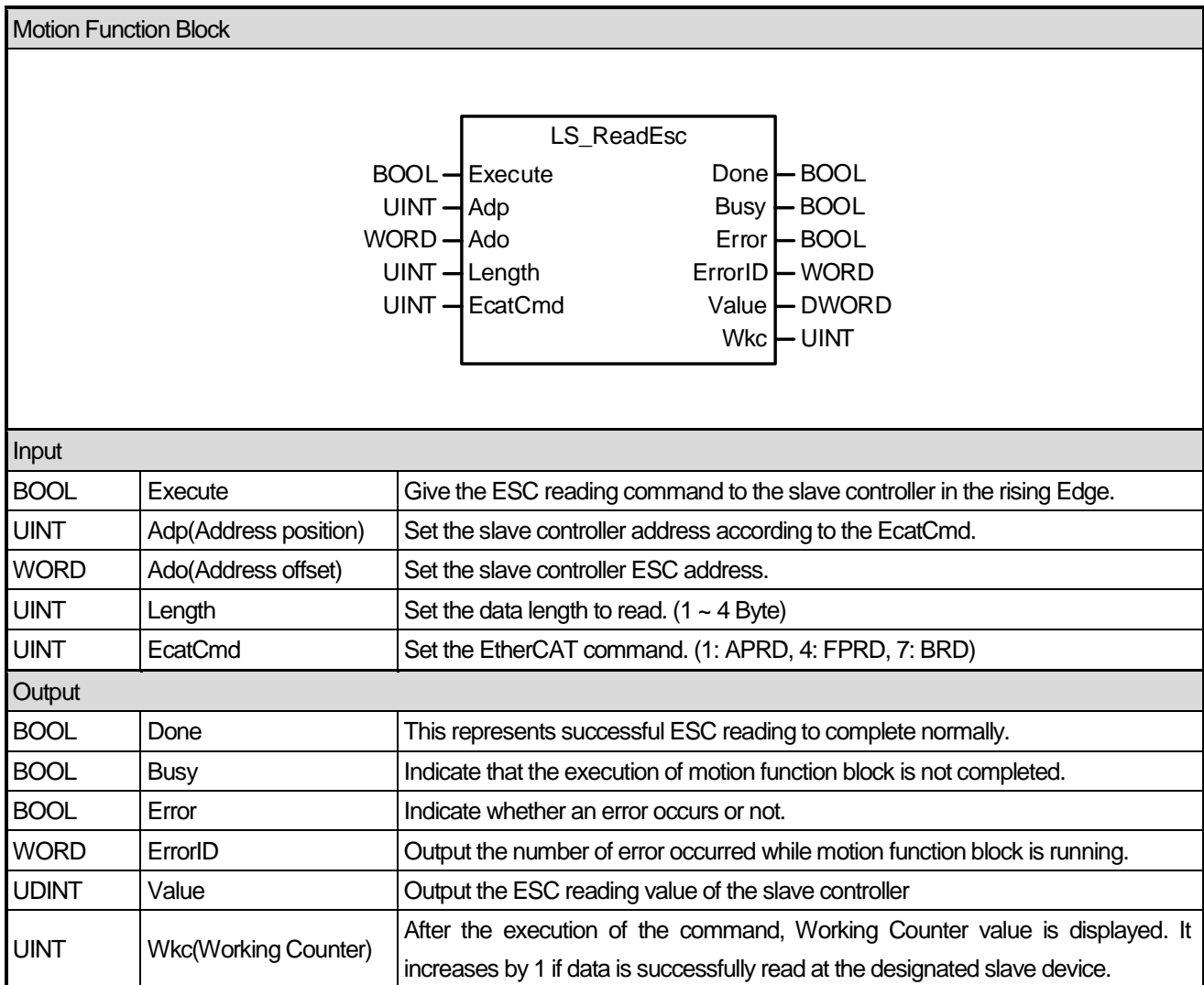
- (6) When an instruction is executed with the ExecutionMode set to 1 and waiting for execution, if another instruction is executed with BufferMode 0 (Aborting) and aborted, Error is 1 and ErrorId is 0.
- (7) Of the data to write to the cam table, the first address of the Main Ax. Pos and Sub Ax. Pos variables are set at MasterPoint and SlavePoint. For example, if Main Ax. Pos is set to the array variable called MainAxPos[100], and Sub Ax. Pos is set to the array variable called SubAxPos[100], MainAxPos[0]s should be set at the MasterPoint of the function block, and SubAxPos[0] should be set at the SlavePoint.

6.6.10 Save Servo Parameters (LS\_SaveServoParameter)



- (1) This motion function block is a command to save the parameter of the servo driver of the designated axis to the EEPROM of the servodrive.
- (2) ExecutionMode input sets the setting timing. When the input is 0, setting is performed upon executing the command. When the input is 1, setting is performed at the same time as "Buffered" at the sequential operation. Setting an incorrect value will cause "Error 16#000B".
  - 0(mclmmediately) : It changes parameter values upon executing the function block(Upward Edge of Execute input). If the axis is in operation, the motion may be affected.
  - 1(mcQueued) : It is changed at the same point of time as in "Buffered" of Buffermode. (Refer to 6.1.4.BufferMode Input)
- (3) When an instruction is executed with the ExecutionMode set to 1 and waiting for execution, if another instruction is executed with BufferMode 0 (Aborting) and aborted, Error is 1 and Errorld is 0.

6.6.11 Read ESC(LS\_ReadEsc)



- (1) This motion function block is a function block to read the data of the address set from the ESC (EtherCAT Slave Controller) of the designated slave device.
- (2) Value and Wkc(Working Counter) is displayed as 0 when the motion function block is executed. When the execution is completed (Done output is on), the read data value is displayed at Value, and the Working Counter value is displayed at Wkc.
- (3) Adp(Address position) is designating the address of the EtherCAT slave device. The following values can be set depending on the EcatCmd setting. If EcatCmd setting is 7(BRD), Adp input value is ignored. If a value outside the range is set for Adp input, "Error 0x0F60" occurs.

EcatCmd	Adp range
1 (APRD)	0x0000: The first slave connected(0) 0xFFFF: The second slave connected(65535) 0xFFFE: The third slave connected(65534) : 0xFFDD: 36th slave connected(65501)
4 (FPRD)	1001 ~ 1036: Slave 1 ~ Slave 36
7 (BRD)	-

- (4) Length can be set to between 1 and 4, which means 1-4 bytes. Setting a value outside the above range will cause "Error 0x0F61. "
- (5) At EcatCmd, set the type of command to use when reading ESC (EtherCAT Slave Controller). One of the following commands can be used: Setting a value outside the above range at EcatCmd will cause "Error 0x0F62."

1) 1 - APRD (Auto Increment Physical Read)

This command is used when reading the slave device data following the order of physical connection before normal communication connection by the master. A slave device receiving Adp with 0 value will read data of the size designated by Length. Adp of each slave device increases when EtherCAT frame is received. . For example, if EcatCmd is 1, and Adp is set to 0xFFFF, when executing ESC read function block, read motion is not performed because the Adp at the time of receiving EtherCAT frame from the first slave device is not 1, only increasing Adp by 1. When the second slave device receives EtherCAT frame, read motion is performed because the Adp value of the first slave value increased by 1 to 0. The Adp setting values depending on the slave device connection order are as follows.

Slave controller	Setting value
The first slave connected	0
The second slave connected	0xFFFF
:	:
36th slave connected	0xFFDD

2) 4 - FPRD (Configured Address Physical Read)

This order is used to read the data by designating the station address of the slave device after normal communication connection by the master. If the Station Address of the slave device set by EtherCAT master matches the transmitted Adp, the slave device reads data of the size designated by Length in the Ado area. The Station Address of slave device set by the master are as follows.

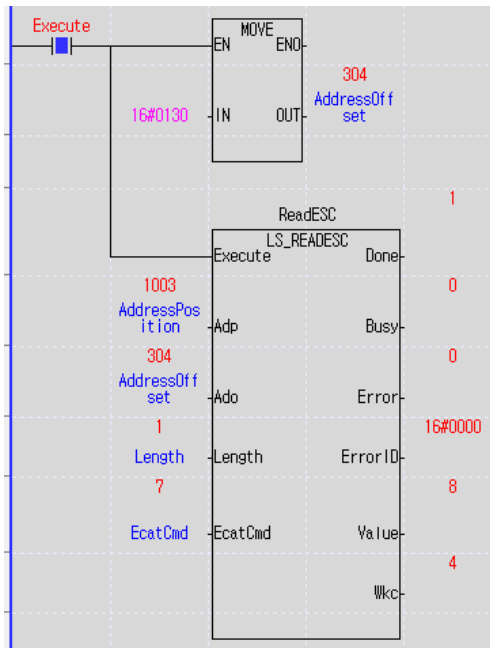
Slave controller	Setting value
Slave 1	1001
Slave 2	1002
:	:
Slave 36	1036

3) 7 – BRD (Broadcast Read)

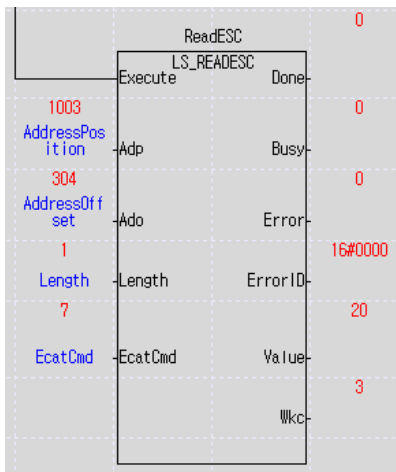
All connected slave devices read data of the size set by Length in the Ado area, and saves the result after Bitwise-OR (OR operation of each bit). The designated address value at Adp is ignored, and Wkc increase by 1 due to all slaves that performed normal read operation

- (6) Wkc stands for Working Counter. If data is successfully read at the designated slave device, it increases by 1. If EcatCmd is 7(BRD), it increases by 1 due to all slaves that performed normal read operation.
- (7) After the execution of ESC read command, if normal data read operation is executed from the designated slave device, Doneoutput is on.
- (8) Please refer to 8. 3. 4 EtherCAT Communication Diagnosis Function for further details.
- (9) Please refer to EtherCAT Slave Controller (ESC) data sheet for detailed information on register and Process RAM.
- (10) Example program

- 1) This example is to check communication link disconnection through ESC read command at a system connected with 4 axes.
- 2) Function block setting

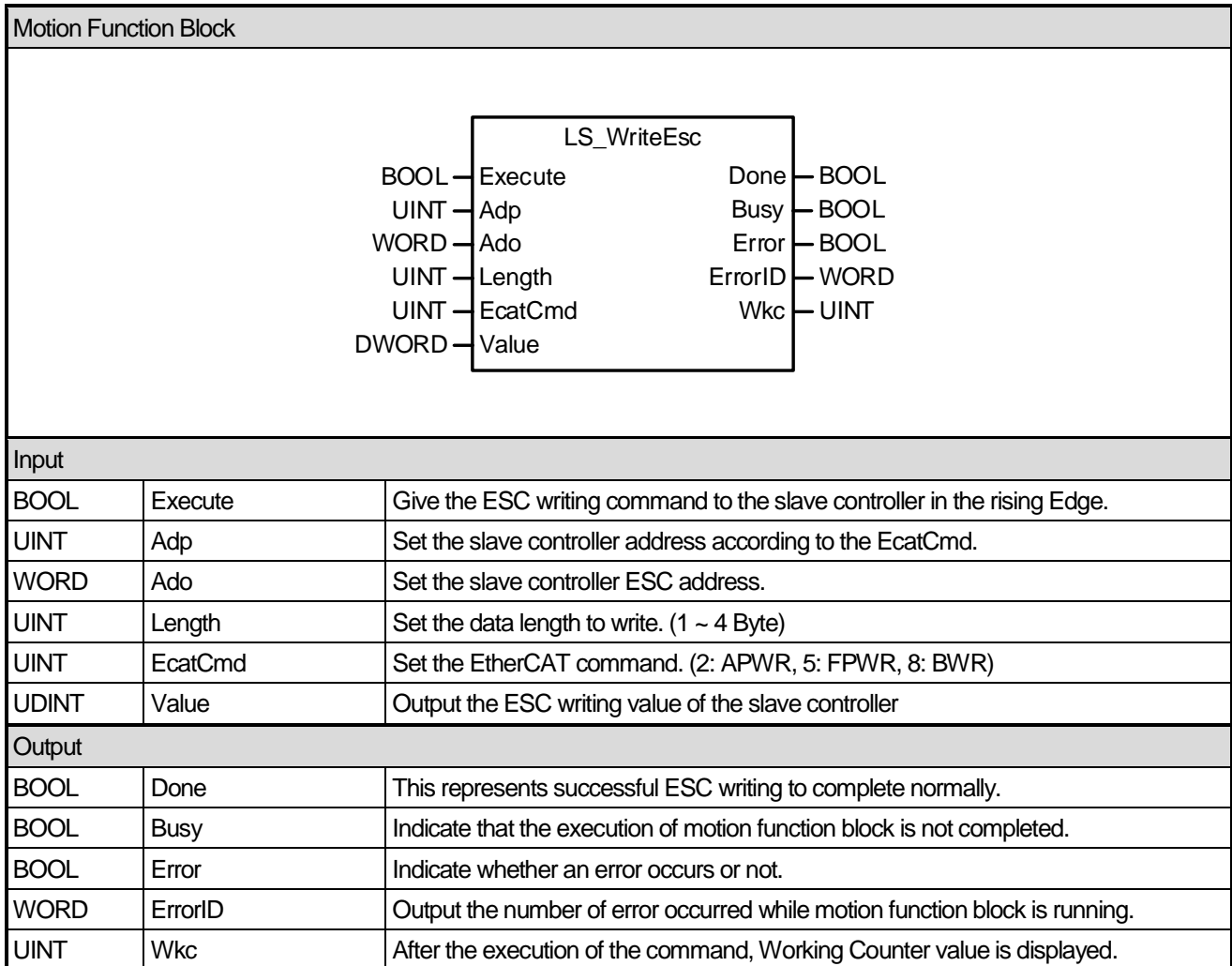


- A. Set the Ado – 16#0130(ESC Register: AL Status), Length – 1, EcatCmd – 7 (Adp is Ignored if EcatCmd is BRD: 7)
- B. If Wkc is 4, it means the 4 axes are safely connected. If Wkc is 3, the connection between the 3rd slave and the 4th slave should be checked.
- C. Value 8 means normal operation state. As shown below, 20(16#00000014) means Safe-Operational state:4. Since the State is not set normally, it means Error Ind: 1.





6.6.12 Write ESC(LS\_WriteEsc)



- (1) This motion function block writes data using the address set by Ado to ESC (EtherCAT Slave Controller) of the slave device set by Adp.
- (2) Wkc value is displayed as 0 when the motion function block is executed, and the Working Counter value is displayed when execution is completed (Done output is on). Wkc increases by 1 through each slave device designated by EcatCmd and Adp.
- (3) Adp input designates the EtherCAT slave device address. The following values can be set depending on EcatCmd setting. If EcatCmd setting is 8(BWR), Adp input value is ignored. If a value outside the range is set for Adp input, "Error 0x0F70" occurs.

EcatCmd	Adp range
2 (APWR)	0x0000: The first slave connected(0) 0xFFFF: The second slave connected(65535) 0xFFFE: The third slave connected(65534) : 0xFFDD: 36th slave connected(65501)
5 (FPWR)	1001 ~ 1036: Slave 1 ~ Slave 36
8 (BWR)	-

- (4)
- (5) Length can be set to between 1 and 4, which means 1-4 bytes. Setting a value outside the above range will cause "Error 0x0F71".
- (6) At EcatCmd, set the type of command to use when reading ESC (EtherCAT Slave Controller). The following write commands can be used. Setting a value outside the range at EcatCmd will cause "Error 0x0F72".

1) 2 - APW (Auto Increment Physical Write)

This command is used when reading the slave device data following the order of physical connection before normal communication connection by the master. A slave device receiving Adp with 0 value will read data of the size designated by Length. Adp of each slave device increases when EtherCAT frame is received. . For example, if EcatCmd is 2, and Adp is set to 0xFFFF, when executing ESC read function block, reading is not performed because the Adp at the time of receiving EtherCAT frame from the first slave device is not 0, only increasing Adp by 1. When the second slave device receives EtherCAT frame, writing is performed because the Adp value of the first slave value increased by 1 to 0. The Adp values depending on the slave device connection order are as follows.

Slave controller	Setting value
The first slave connected	0
The second slave connected	0xFFFF
:	:
36th slave connected	0xFFDD

2) 5 - FPWR (Configured Address Physical Write)

This order is used to write the data by designating the station address of the slave device after normal communication connection by the master. If the Station Address of the slave device set by EtherCAT master matches the transmitted Adp, the slave device writes data of the size designated by Length in the Ado area. The Station Address of slave device set by the master is as follows.

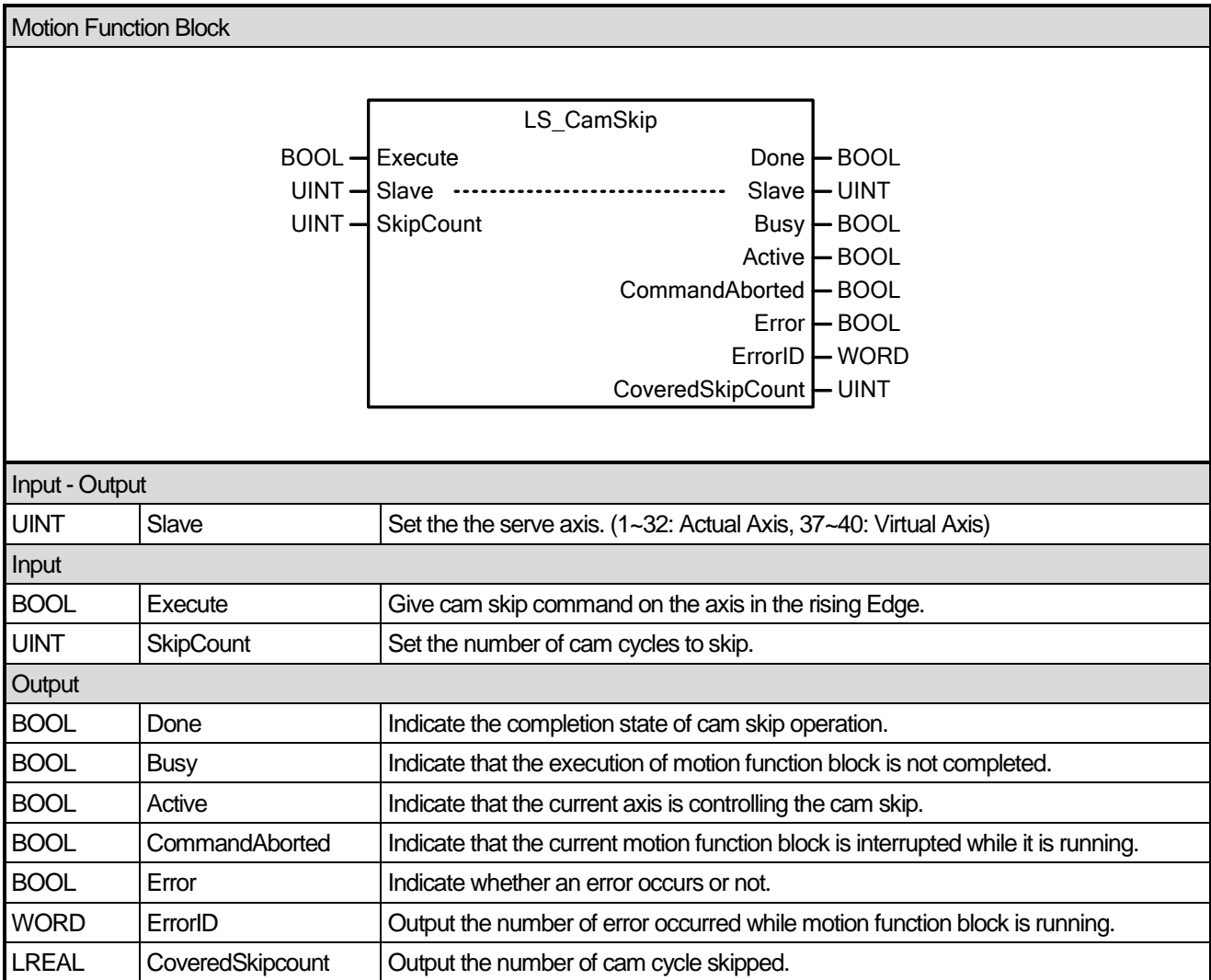
Slave controller	Setting value
Slave 1	1001
Slave 2	1002
:	:
Slave 36	1036

### 3) 8-BWR, Broadcast Write

All connected slave devices write data of the size set by Length in the Ado area, and saves the result after Bitwise-OR (OR operation of each bit). The designated address value at Adp is ignored, and Wkc increase by 1 due to all slaves that performed normal write operation.

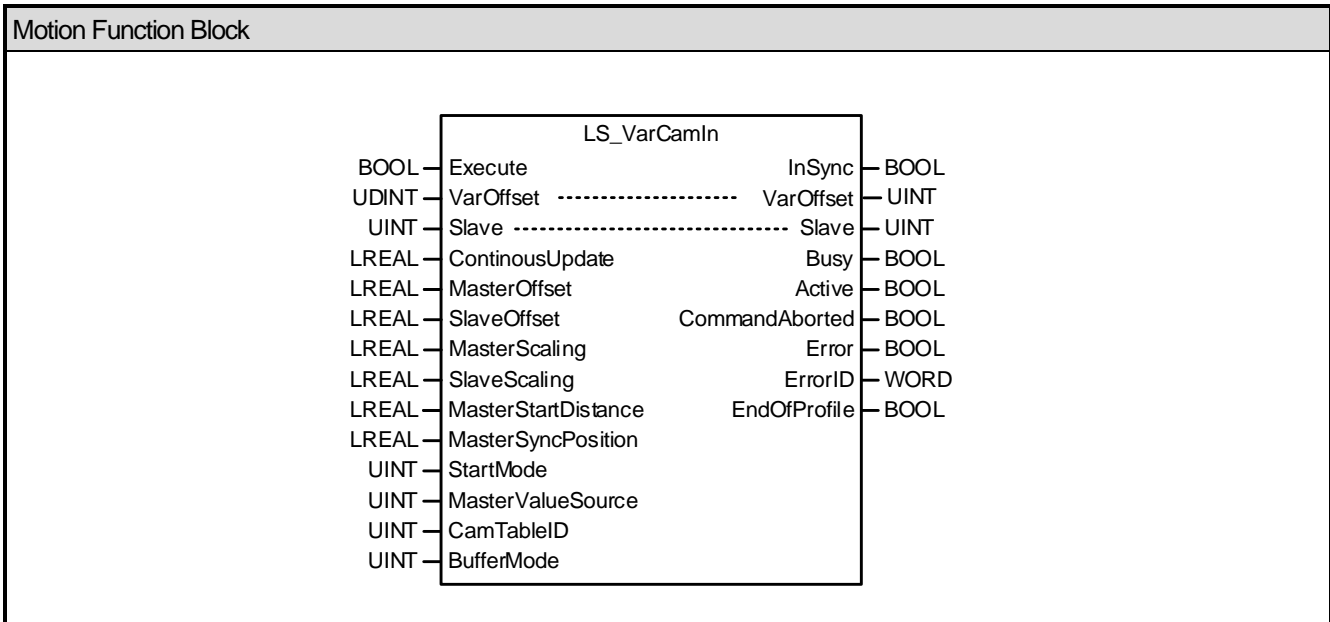
- (7) Wkc stands for Working Counter. If data is successfully written at the designated slave device, it increases by 1. If EcatCmd is 8(BWR), it increases by 1 due to all slaves that performed normal write operation.
- (8) After the execution of ESC write command, if normal data write operation is executed in the designated slave device, Doneoutput is on.
- (9) Please refer to 8. 3. 4 EtherCAT Communication Diagnosis Function for further details.
- (10) Please refer to EtherCAT Slave Controller (ESC) data sheet for detailed information on register and Process RAM.

6.6.13 Cam skip (LS\_CamSkip)



- (1) This motion function block commands Cap Skip command which skip cam operation cycles as designated for the cam currently in operation.
- (2) SkipCount determines the number of cam cycles to skip. If 0 is entered, SkipCount Error (Error 0x111E) is displayed.
- (3) When Cam Skip command is issued on a sub-axis during cam operation, the skip motion starts when the current cam cycle is completed. During cam skip, the sub-axis is in stand-by at the end of the cam table.
- (4) CoveredSkipCount displays the number of cam cycles skipped. The count increases with each skpped cycle, and becomes 0 when Done output is off after the function block motion is completed
- (5) Done output is on when the set number of cycles are skipped after executing Cam Skip command.

6.6.14 Variable Cam operation(LS\_VarCamIn)



Input-Output		
UDINT	VarOffset	Set the offset value of the M device where the variable to be used as the main axis is located.
UINT	Slave	Set the sub axis. (1~32: real axis, 37~40: virtual axis)
Input		
BOOL	Execute	Give a cam operation command to the relevant axis in the rising Edge.
BOOL	ContinuousUpdate	Specify the update setting of input value. (Refer to 6.1.5.Changes in Parameters during Execution of Motion Function Block)
LREAL	MasterOffset	Set the offset value of the main axis.
LREAL	SlaveOffset	Set the offset value of the the serve axis cam table.
LREAL	MasterScaling	Specify the magnification of the main axis.
LREAL	SlaveScaling	Specify the magnification of the serve axis cam table.
LREAL	MasterStartDistance	Specify the position of the main axis where cam operation of the slave.
LREAL	MasterSyncPosition	Specify the starting point at cam table when cam operation starts.
UINT	StartMode	Set the cam operation mode. 0 : Cam table is applied as an absolute value (mcAbsolute) 1: Cam table is applied as a relative value based on the command starting point (mcRelative)
UINT	MasterValueSource	Select the source of the main axis for cam operation. 0 : Synchronized in the target value of the main axis. 1 : Synchronized in the current value of the serve axis.
UINT	CamTableID	Specify the cam table to operate.
UINT	BufferMode	Specify the sequential operation setting of motion function block.

		(Refer to 6.1.4.BufferMode)
Output		
BOOL	InSync	Indicate that cam operation is normally being fulfilled. (Indicate that the serve axis is following the cam table.)
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.
BOOL	EndOfProfile	Indicates that the end of the currently running cam has been reached.

- (1) This motion function block is a motion function block that performs sub-axis cam operation according to the main axis by setting the variable value designated as offset as the main axis.
- (2) The variable value designated by the main axis should use LREL type. Example) When designating a variable allocated to memory with %ML100 as the main axis value, %ML100 should be used as LREAL type, and the offset value designating the variable is UDINT type, and input 100 in VarOffset.
- (3) The rest of the settings and functions are the same as the MC\_CamIn function block.
- (4) The version information that can use this motion function block is as follows.

Content Module	Module O/S	XG-PM
XGF-M32E	V1.30	V3.1

6.6.15 Variable gear operation(LS\_VarGearIn)

Motion Function Block																																																									
<div style="border: 1px solid black; padding: 10px; width: fit-content; margin: 0 auto;"> <p style="text-align: center;">LS_VarGearIn</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%;">BOOL</td> <td style="width: 40%;">Execute</td> <td style="width: 30%;"></td> <td style="width: 30%;">InGear</td> <td style="width: 30%;">BOOL</td> </tr> <tr> <td>UDINT</td> <td>VarOffset</td> <td>-----</td> <td>VarOffset</td> <td>UINT</td> </tr> <tr> <td>UINT</td> <td>Slave</td> <td>-----</td> <td>Slave</td> <td>UINT</td> </tr> <tr> <td>BOOL</td> <td>ContinuousUpdate</td> <td></td> <td>Busy</td> <td>BOOL</td> </tr> <tr> <td>INT</td> <td>RatioNumerator</td> <td></td> <td>Active</td> <td>BOOL</td> </tr> <tr> <td>UINT</td> <td>RatioDenominator</td> <td></td> <td>CommandAborted</td> <td>BOOL</td> </tr> <tr> <td>UINT</td> <td>MasterValueSource</td> <td></td> <td>Error</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Acceleration</td> <td></td> <td>ErrorID</td> <td>WORD</td> </tr> <tr> <td>LREAL</td> <td>Deceleration</td> <td></td> <td></td> <td></td> </tr> <tr> <td>LREAL</td> <td>Jerk</td> <td></td> <td></td> <td></td> </tr> <tr> <td>UINT</td> <td>BufferMode</td> <td></td> <td></td> <td></td> </tr> </table> </div>			BOOL	Execute		InGear	BOOL	UDINT	VarOffset	-----	VarOffset	UINT	UINT	Slave	-----	Slave	UINT	BOOL	ContinuousUpdate		Busy	BOOL	INT	RatioNumerator		Active	BOOL	UINT	RatioDenominator		CommandAborted	BOOL	UINT	MasterValueSource		Error	BOOL	LREAL	Acceleration		ErrorID	WORD	LREAL	Deceleration				LREAL	Jerk				UINT	BufferMode			
BOOL	Execute		InGear	BOOL																																																					
UDINT	VarOffset	-----	VarOffset	UINT																																																					
UINT	Slave	-----	Slave	UINT																																																					
BOOL	ContinuousUpdate		Busy	BOOL																																																					
INT	RatioNumerator		Active	BOOL																																																					
UINT	RatioDenominator		CommandAborted	BOOL																																																					
UINT	MasterValueSource		Error	BOOL																																																					
LREAL	Acceleration		ErrorID	WORD																																																					
LREAL	Deceleration																																																								
LREAL	Jerk																																																								
UINT	BufferMode																																																								
Input-Output																																																									
UDINT	VarOffset	Set the offset value of the M device where the variable to be used as the main axis is located.																																																							
UINT	Slave	Set the sub axis. (1~32: real axis, 37~40: virtual axis)																																																							
Input																																																									
BOOL	Execute	Give gear operation command to the relevant axis in the rising Edge.																																																							
BOOL	ContinuousUpdate	Specify the update setting of input value. (Refer to 6.1.5.Changes in Parameters during Execution of Motion Function Block)																																																							
INT	RatioNumerator	Specify the numerator of gear ratio. (-32768 ~ 32767)																																																							
UINT	RatioDenominator	Specify the denominator of gear ratio. (0 ~ 65535)																																																							
UINT	MasterValueSource	Select data of the main axis to be synchronized. 0: Synchronize in the command position of the main axis. 1: Synchronize in the current position of the main axis.																																																							
LREAL	Acceleration	Specify the acceleration at the beginning of gear operation synchronization. [u/s <sup>2</sup> ]																																																							
LREAL	Deceleration	Specify the deceleration at the beginning of gear operation synchronization. [u/s <sup>2</sup> ]																																																							
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]																																																							
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)																																																							
Output																																																									
BOOL	InGear	Indicate that gear operation is running by applying gear ration.																																																							
BOOL	Busy	Indicate that the execution of motion function block is not completed.																																																							
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.																																																							
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.																																																							

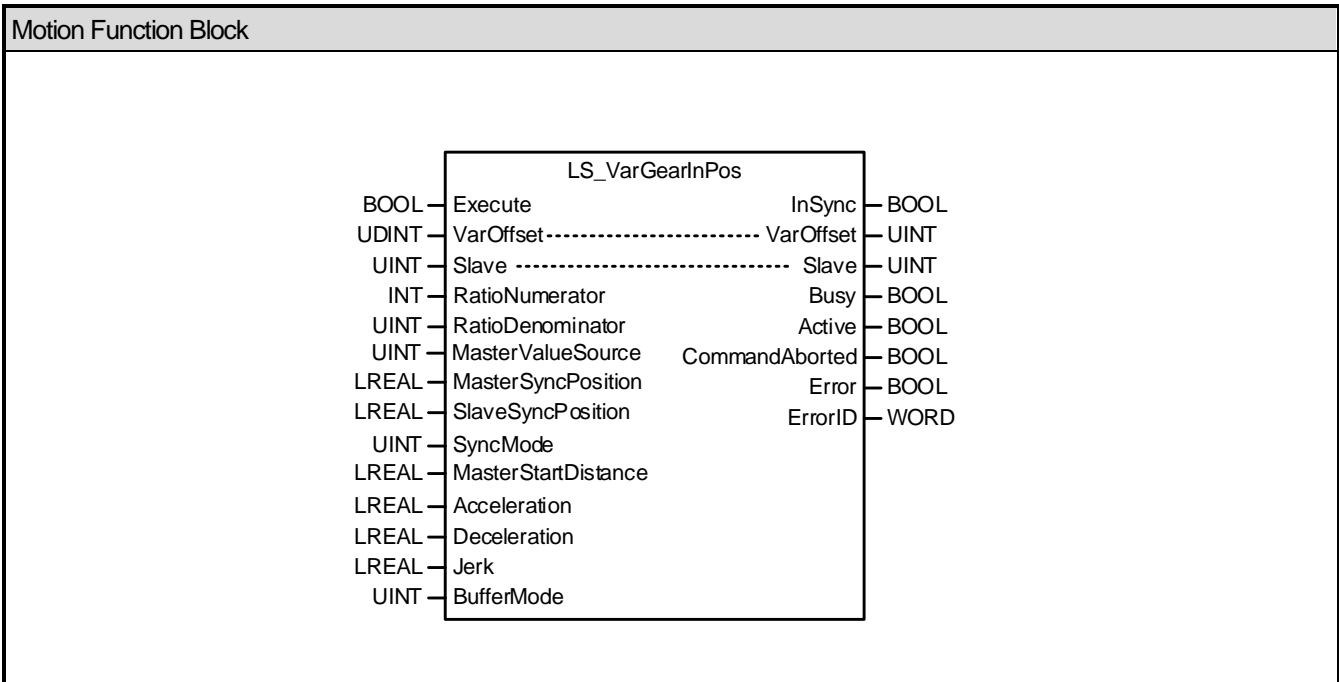
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block is a function block that sets the variable value designated as an offset as the main axis and drives the main axis and the sub axis as a gear operation (speed synchronization).
- (2) The variable value designated by the main axis should use LREL type. Example) When designating a variable allocated to memory with %ML100 as the main axis value, %ML100 should be used as LREAL type, and the offset value designating the variable is UDINT type, and input 100 in VarOffset.
- (3) The rest of the settings and functions are the same as the MC\_GearIn function block.
- (4) The version information that can use this motion function block is as follows.

Content Module	Module O/S	XG-PM
<b>XGF-M32E</b>	V1.30	V3.1



6.6.16 Variable positioning gear operation(LS\_VarGearInPos)



Input-Output		
UDINT	VarOffset	Set the offset value of the M device where the variable to be used as the main axis is located.
UINT	Slave	Set the sub axis. (1~32: real axis, 37~40: virtual axis)
Input		
BOOL	Execute	Give gear operation command to the relevant axis in the rising Edge.
INT	RatioNumerator	Specify the numerator of gear ratio. (-32768 ~ 32767)
UINT	RatioDenominator	Specify the denominator of gear ratio. (0 ~ 65535)
UINT	MasterValueSource	Select data of the main axis to be synchronized. 0: Synchronize in the command position of the main axis. 1: Synchronize in the current position of the main axis.
LREAL	MasterSyncPosition	Specify the position of the main axis where gear operation starts.
LREAL	SlaveSyncPosition	Specify the position of the sub axis where gear operation starts.
LREAL	SyncMode	Unused
LREAL	MasterStartDistance	Specify the distance of the main axis where synchronization starts.
LREAL	Velocity	Specify the maximum speed of the sub axis at the beginning of synchronization. [u/s]
LREAL	Acceleration	Specify the acceleration at the beginning of gear operation synchronization. [u/s <sup>2</sup> ]
LREAL	Deceleration	Specify the deceleration at the beginning of gear operation synchronization. [u/s <sup>2</sup> ]
LREAL	Jerk	Unused
UINT	BufferMode	Specify the sequential operation setting of motion function block.

		(Refer to 6.1.4.BufferMode)
Output		
BOOL	InSync	Indicate that gear operation is normally being fulfilled as the specified gear ratio is applied.
BOOL	StartSync	Indicate synchronization is starting.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block is a function block that sets the variable value designated as an offset as the main axis and synchronizes the main axis and the sub axis according to the gear ratio set at a specific position.
- (2) The variable value designated by the main axis should use LREL type. Example) When designating a variable allocated to memory with %ML100 as the main axis value, %ML100 should be used as LREAL type, and the offset value designating the variable is UDINT type, and input 100 in VarOffset.
- (3) The rest of the settings and functions are the same as the MC\_GearInPos function block.
- (4) The version information that can use this motion function block is as follows.

Content Module	Module O/S	XG-PM
XGF-M32E	V1.30	V3.1

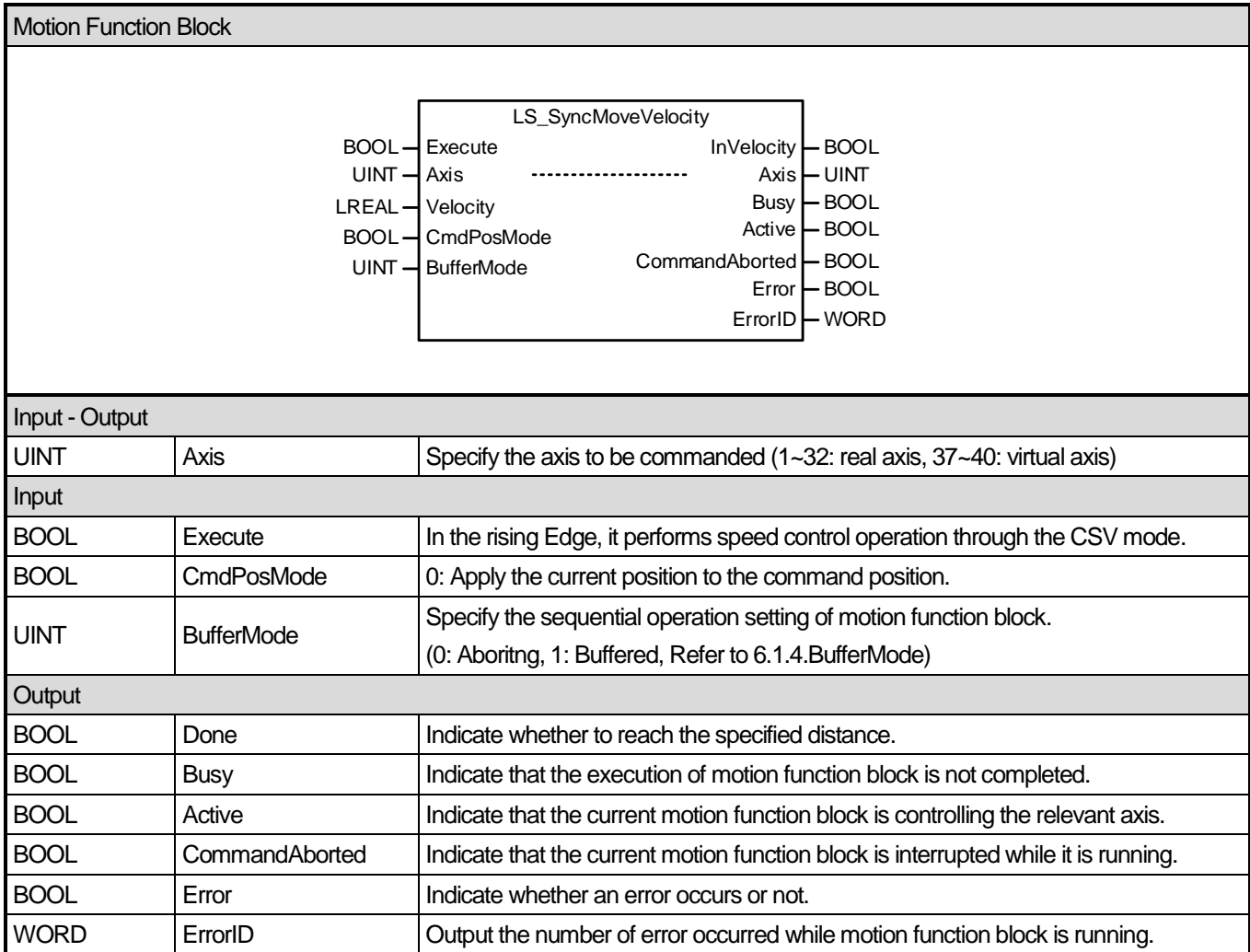
6.6.17 Read the slave location of the CAM table(LS\_ReadCamTableSlavePos)

Motion Function Block																																		
<div style="border: 1px solid black; padding: 10px; width: fit-content; margin: 0 auto;"> <p style="text-align: center;">LS_ReadCamTableSlavePos</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%;">BOOL</td> <td style="width: 40%;">Execute</td> <td style="width: 30%;">Done</td> <td>BOOL</td> </tr> <tr> <td>UINT</td> <td>Axis</td> <td>Axis</td> <td>UINT</td> </tr> <tr> <td>UINT</td> <td>CamTableID</td> <td>Busy</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>MasterPos</td> <td>SlavePos</td> <td>LREAL</td> </tr> <tr> <td></td> <td></td> <td>SlaveVel</td> <td>LREAL</td> </tr> <tr> <td></td> <td></td> <td>SlaveAccel</td> <td>LREAL</td> </tr> <tr> <td></td> <td></td> <td>Error</td> <td>BOOL</td> </tr> <tr> <td></td> <td></td> <td>ErrorID</td> <td>WORD</td> </tr> </table> </div>			BOOL	Execute	Done	BOOL	UINT	Axis	Axis	UINT	UINT	CamTableID	Busy	BOOL	LREAL	MasterPos	SlavePos	LREAL			SlaveVel	LREAL			SlaveAccel	LREAL			Error	BOOL			ErrorID	WORD
BOOL	Execute	Done	BOOL																															
UINT	Axis	Axis	UINT																															
UINT	CamTableID	Busy	BOOL																															
LREAL	MasterPos	SlavePos	LREAL																															
		SlaveVel	LREAL																															
		SlaveAccel	LREAL																															
		Error	BOOL																															
		ErrorID	WORD																															
Input-Output																																		
UINT	Axis	Specify the axis to be commanded (1~32: real axis, 37~40: virtual axis)																																
Input																																		
BOOL	Execute	Give read the slave location of the CAM table operation command to the relevant axis in the rising Edge.																																
UINT	CamTableID	Specify the cam table number to read. (1~32)																																
LREAL	MasterPos	Specify the position on the main axis on the cam table.																																
Output																																		
BOOL	Done	Indicates that the operation of reading cam table slave position has been successfully completed.																																
BOOL	Busy	Indicate that the execution of motion function block is not completed.																																
LREAL	SlavePos	Outputs the slave position.																																
LREAL	SlaveVel	Outputs the slave speed. [u/s]																																
LREAL	SlaveAccel	Outputs the slave's acceleration. [u/s <sup>2</sup> ]																																
BOOL	Error	Indicate whether an error occurs or not.																																
WORD	ErrorID	Output the number of error occurred while motion function block is running.																																

- (1) This motion function block is a function to output the position of the sub axis according to the position of the main axis in the designated cam table.
- (2) Set the position value of the main axis to be read from the cam table as the MasterPos value. Offset/gear ratio/phase correction operation applied to the command axis are not reflected in SlavePos output.
- (3) When the operation of reading cam table slave position is completed, Done output is On.
- (4) The version information that can use this motion function block is as follows.

Content Module	Module O/S	XG-PM
XGF-M32E	V1.30	V3.1

6.6.18 Speed control operation (CSV mode) (LS\_SyncMoveVelocity)



- (1) This motion function block is the function block that allows speed control using the CSV (Cyclic Synchronous Velocity) mode of CiA402 profile on the set axis.
- (2) In order to stop the specified speed operation, you can make a stop command or execute another motion function block.
- (3) Velocity input specifies the speed to operate. When the sign of the operation speed value is positive (+ or no sign), it moves in the forward direction and when it is negative (-), it moves in the reverse direction.
- (4) CmdPosMode is used to set the update methods of the current position at the time of command. Only the initial value of 0 is available and the current position of the command is updated using the feedback current position.
- (5) The output InVelocity is turned on when the axis reaches the specified speed, and it is turned off when the specified speed operation is stopped.
- (6) When this Motion Function Block is running, the axis status is 'Continuous Motion'.

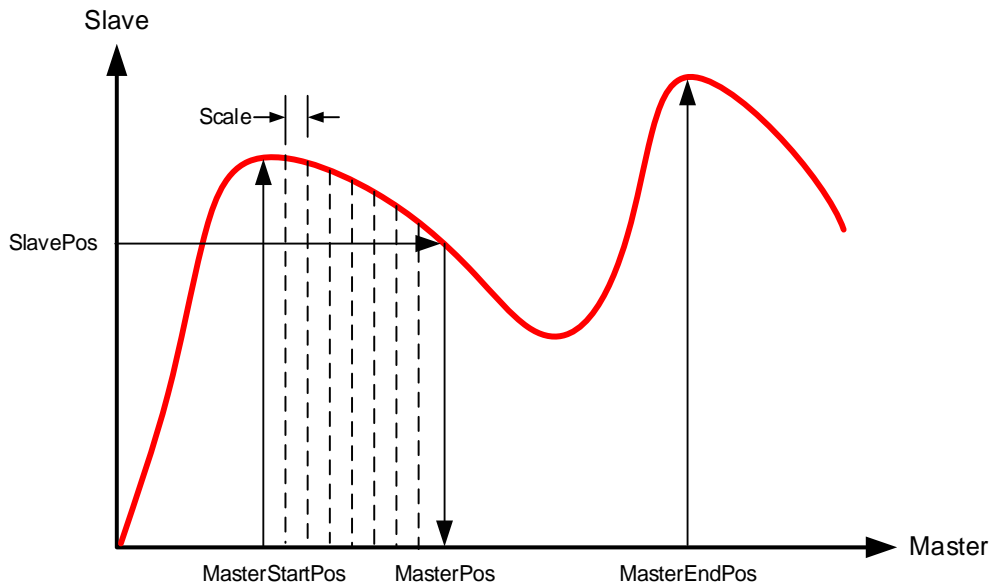
(7) The version information that can use this motion function block is as follows.

<b>Content</b> <b>Module</b>	<b>Module O/S</b>	<b>XG-PM</b>
<b>XGF-M32E</b>	V1.30	V3.1

6.6.19 Read the master location of the CAM table(LS\_ReadCamTableMasterPos)

Motion Function Block																														
<div style="border: 1px solid black; padding: 10px; width: fit-content; margin: 0 auto;"> <p style="text-align: center;">LS_ReadCamTableMasterPos</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%;">BOOL</td> <td style="width: 40%;">Execute</td> <td style="width: 30%;">Done</td> <td style="width: 10%;">BOOL</td> </tr> <tr> <td>UINT</td> <td>Axis</td> <td>Axis</td> <td>UINT</td> </tr> <tr> <td>UINT</td> <td>CamTableID</td> <td>Busy</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>MasterStartPos</td> <td>MasterPos</td> <td>LREAL</td> </tr> <tr> <td>LREAL</td> <td>MasterEndPos</td> <td>Error</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>SlavePos</td> <td>ErrorID</td> <td>WORD</td> </tr> <tr> <td>LREAL</td> <td>Scale</td> <td></td> <td></td> </tr> </table> </div>			BOOL	Execute	Done	BOOL	UINT	Axis	Axis	UINT	UINT	CamTableID	Busy	BOOL	LREAL	MasterStartPos	MasterPos	LREAL	LREAL	MasterEndPos	Error	BOOL	LREAL	SlavePos	ErrorID	WORD	LREAL	Scale		
BOOL	Execute	Done	BOOL																											
UINT	Axis	Axis	UINT																											
UINT	CamTableID	Busy	BOOL																											
LREAL	MasterStartPos	MasterPos	LREAL																											
LREAL	MasterEndPos	Error	BOOL																											
LREAL	SlavePos	ErrorID	WORD																											
LREAL	Scale																													
Input - Output																														
UINT	Axis	Specify the axis to be commanded (1~32: real axis, 37~40: virtual axis)																												
Input																														
BOOL	Execute	Give cam table master position reading command to the relevant axis in the rising Edge.																												
UINT	CamTableID	Set the number of cam table to read (1~32)																												
LREAL	MasterStartPos	Start position to read position of cam main axis																												
LREAL	MasterEndPos	End position to read position of cam main axis																												
LREAL	SlavePos	Position of cam serve axis																												
LREAL	Scale	Accuracy of main axis position reading																												
Output																														
BOOL	Done	Indicate that the cam table main axis reading is successfully completed.																												
BOOL	Busy	Indicated that the execution of motion function is not completed.																												
LREAL	MasterPos	Output the position of the slave																												
BOOL	Error	Indicate whether an error occurs or not																												
WORD	ErrorID	Output the number of error occurred while motion function block is running																												

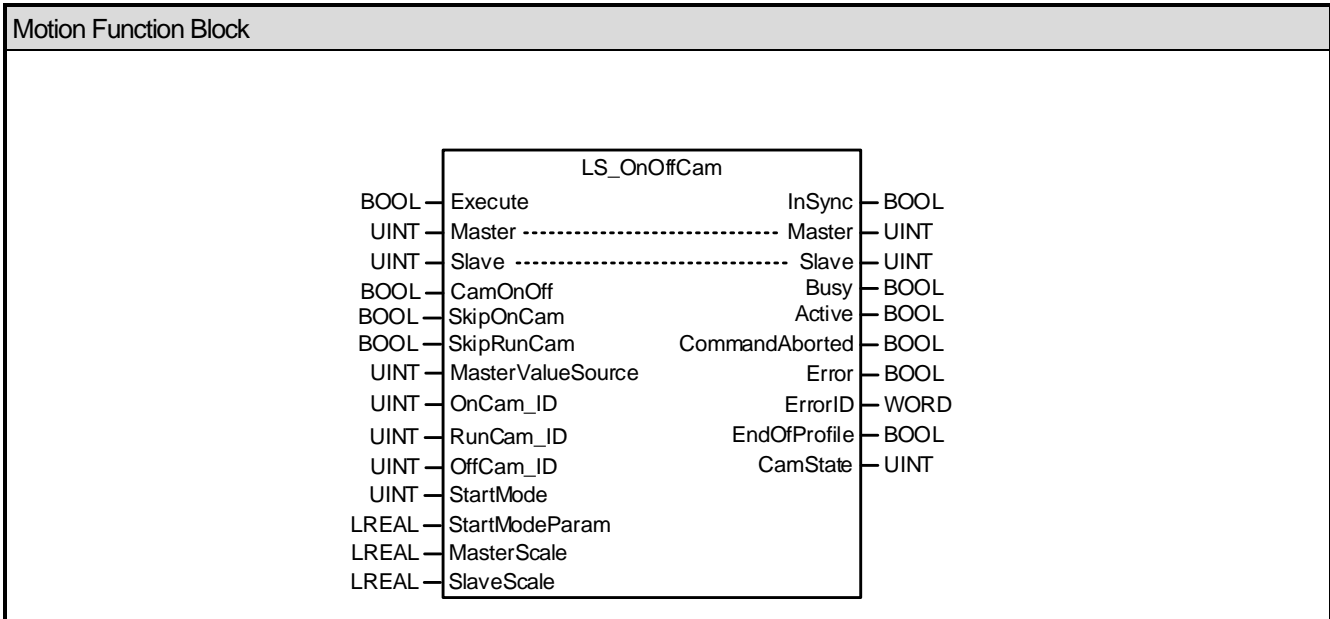
- (1) This motion function block outputs the position of the main axis corresponding to the position of the serve axis set in SlavePos, among the values between MasterStartPos and MasterEndPos in the specified cam table.



- (2) Set the position of serve axis to read in the cam table as SlavePos value. Offset/Gear ratio/Phase correction operation applied to the command axis is not reflected in the MasterPos output.
- (3) When the cam table master position reading operation is completed, the Done output turns on.
- (4) The 'Scale', which is the accuracy value of the cam table master position reading, can't input 0. If the 'Scale' is 0, an error (error number: 0x0B) occurs. If the 'Scale' value is large, an error may occur between the magnified MasterPos value and the actual spindle position. Also, if the 'Scale' value is small, the execution time of the function block may become long.
- (5) If the position of the main axis corresponding to the position of the serve axis set in SlavePos does not exist among the values between MasterStartPos and MasterEndPos, Error is On and "0x1124" occurs in ErrorID.
- (6) The value of MasterEndPos must be greater than the value of MasterStartPos. If the MasterEndPos value is less than or equal to MasterStartPos, Error is On and "0x0B" occurs in ErrorID.
- (7) The version information that can use this motion function block is as follows.

Content Module	Module O/S	XG-PM
XGF-M32E	V1.30	V3.1

6.6.20 OnOffCam operation(LS\_OnOffCam)



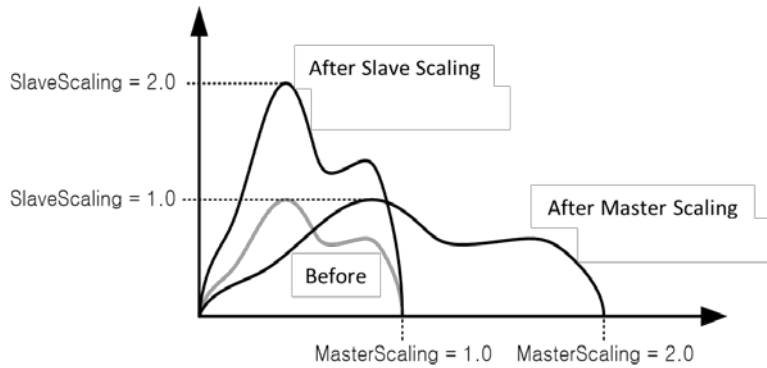
Input-Output		
UINT	Master	Set the main axis. (1~32: real axis, 37~40: virtual axis, 41~42: encoder), only variables can be set
UINT	Slave	Set the sub axis. (1~32: real axis, 37~40: virtual axis), only variables can be set
Input		
BOOL	Execute	Give On/Off CAM command to the relevant axis in the rising Edge.
BOOL	CamOnOff	Set the on/off state of the cam operation. 1: Complete OnCam and switch to RunCam. 0: Complete OffCam in RunCam and switch the cam to the stop status
BOOL	SkipOnCam	Exclude OnCam from OnOff cam operation and carry out RunCam->OffCam in order.
BOOL	SkipRunCam	Exclude RunCam from OnOff cam operation and carry out OnCam->OffCam in order.
UINT	MasterValueSource	Select the source of the main axis for cam operation. 0: Synchronizes to the command position of the main axis. 1: Synchronizes to the current position of the main axis.
UINT	OnCam_ID	Specify the cam table to operate in the OnCam state.
UINT	RunCam_ID	Specify the cam table to operate in the RunCam state.
UINT	OffCam_ID	Specify the cam table to operate in the OffCam state.
UINT	StartMode	Specify the method for starting the cam operation. 0: Start when CamOnOff is set to 1. 1: Start when CamOnOff is set to 1 and the main axis reaches the position set in StartModeParam. 2: Start when CamOnOff is set to 1 and the main axis moves the distance set in StartModeParam.



		3: Use the profile generated with LS_CrossSealCamGen.
LREAL	StartModeParam	Set the parameter according to the method for starting the cam operation.
LREAL	MasterScale	Specify the scale of the main axis.
LREAL	SlaveScale	Specify the magnification of the sub axis.
Output		
BOOL	InSync	Indicates that cam operation has entered the RunCam state.
BOOL	Busy	Indicates that the execution of the motion function block is not completed.
BOOL	Active	Indicates that the current motion function block is controlling the relevant axis.
BOOL	CommandAborted	Indicates that the current motion function block is interrupted by another command.
BOOL	Error	Indicates whether an error occurs or not.
WORD	ErrorID	Outputs the error ID that occurred while the motion function block is running.
BOOL	EndOfProfile	Indicates the end of the current cam operation.
UINT	CamState	0: Stop state 1: Executing OnCam 2: Executing RunCam 3: Executing OffCam

- (1) This motion function block uses three cam tables to carry out the cam operation that is switched to a Stop state->OnCam->RunCam or a RunCam->OffCam->Stop state depending on the CamOnOff input.  
오류! 편집 중 필드 코드에서는 개체를 만들 수 없습니다.
- (2) The cam operation runs under a state where Execute is the rising Edge. The cam operation does not stop even if Execute is changed to Off during the operation. To stop the OnOffCam operation, you must give the MC\_CamOut command or run another motion function block.
- (3) If StartMode is set to 0, OnCam runs as soon as 1 is input in CamOnOff. If StartMode is set to 1, OnCam does not run as soon as 1 is input in CamOnOff, but when the position of the main axis passes by the position set in StartModeParam. If StartMode is set to 2, OnCam runs when 1 is input in CamOnOff and the main axis then moves in the distance set in StartModeParam.
- (4) If you are using a cam generated with the LS\_CrossSealCamGen function block, set StartMode to 3. If StartMode is set to 3 and the length of OnCam\_ID is 270, the same operation is conducted as if StartMode is set to 1 and StartModeParam is 270. If OnCam\_ID is 180, the same operation is conducted as if StartMode is set to 1 and StartModeParam is set to 0.
- (5) EndOfProfile outputs On when passing the end of a profile during the operation of each OnCam/OffCam/RunCam cam profile.
- (6) If the CamOnOff signal is Off, the operation to switch to RunCam->OffCam->Stop state is performed. If the CamOnOff signal is switched from Off to On in the RunCam state, the RunCam state is maintained if OffCam is not yet executed. In a state where OffCam is executed, the state switches to the OnCam->RunCam state again after switching to the OffCam->Stop state. (When turning off CamOnOff in RunCam, the operation must be maintained until an EndOfProfile signal is generated.)  
오류! 편집 중 필드 코드에서는 개체를 만들 수 없습니다.
- (7) Set the magnification of cam data to be applied to MasterScaling and SlaveScaling. MasterScaling sets the magnification of the main axis data, and SlaveScaling sets the magnification of the subordinate axis data. Please

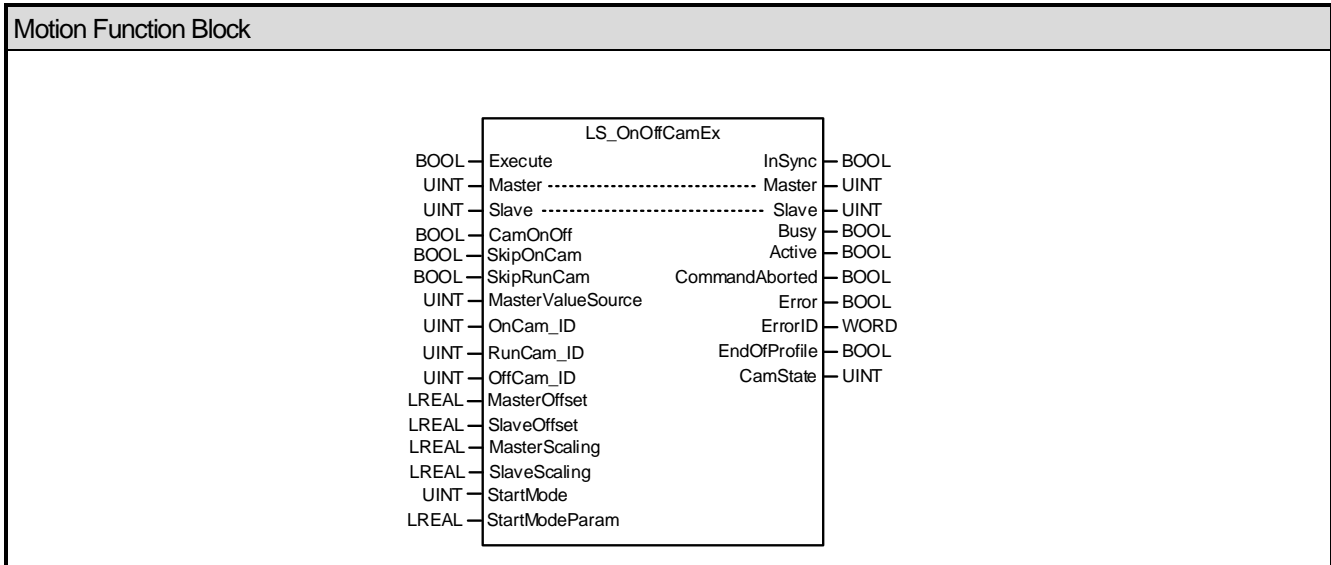
refer to the picture below.



- (8) If the SkipOnCam signal is On, RunCam is executed instantly without OnCam. If CamOnOff turns off after executing RunCam, perform the operation to switch to RunCam->OffCam->Stop state. In an operation where the SkipOnCam signal is On, the operation is executed from the middle of RunCam.
- (9) If the SkipRunnCam signal is On, OffCam is executed without executing RunCam after executing OnCam. If CamOnOff is On at this time, the operation repeats in the order of OnCam->OffCam->Stop->OnCam->OffCam->Stop.
- (10) To stop the OnOffCam operation completely, use the halt (MC\_Halt) or immediate stop (MC\_Stop) motion function block.
- (11) The CamState value is output as Stop(0) / OnCam(1) / RunCam(2) / OffCam(3) depending on the state of cam operation.
- (12) Once the cam operation set in RunCam\_ID is executed, InSync outputs On.
- (13) MasterValueSource selects the source of the main axis for synchronization. If set to 0, the serve axis performs cam operations based on the command position of the main axis calculated in the motion controller, and if set to 1, the serve axis performs cam operations based on the current position received via communication from the servo drive of the main axis.
- (14) RunCam\_ID sets the cam profile to execute during the operation of OnOffCam. Before executing RunCam in a Stop state, set the cam profile to run as OnCam\_ID. OffCam\_ID sets the cam profile to execute before RunCam reaches the Stop state. The setting range for each ID is 1-32, and an input value outside of the range causes a "0x1115" error in the motion function block.
- (15) Any changes made to the MasterValueSource/OnCam\_ID/RunCam\_ID/OffCam\_ID value during operation are not reflected.
- (16) The corresponding axis is in a "SynchronizedMotion" state when this motion function block is running.
- (17) For more information, see Chapter 8.5 RotaryKnife Operation under Chapter 8 Motion Control Function.
- (18) The version information that can use this motion function block is as follows.

Content Module	Module O/S	XG-PM
XGF-M32E	V1.30	V3.1

6.6.21 OnOffCam operation(LS\_OnOffCamEx)



Input-Output

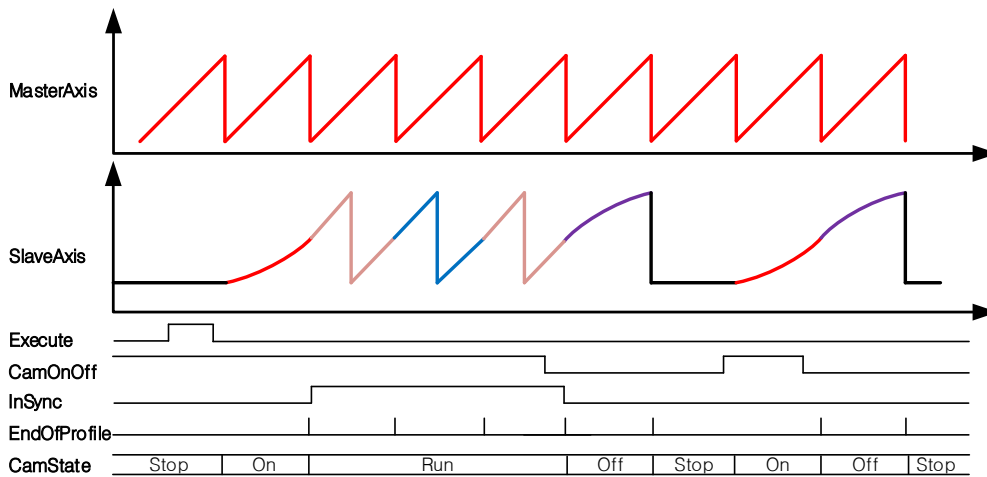
UINT	Master	Set the main axis. (1~32: real axis, 37~40: virtual axis, 41~42: encoder), only variables can be set
UINT	Slave	Set the sub axis. (1~32: real axis, 37~40: virtual axis), only variables can be set

Input

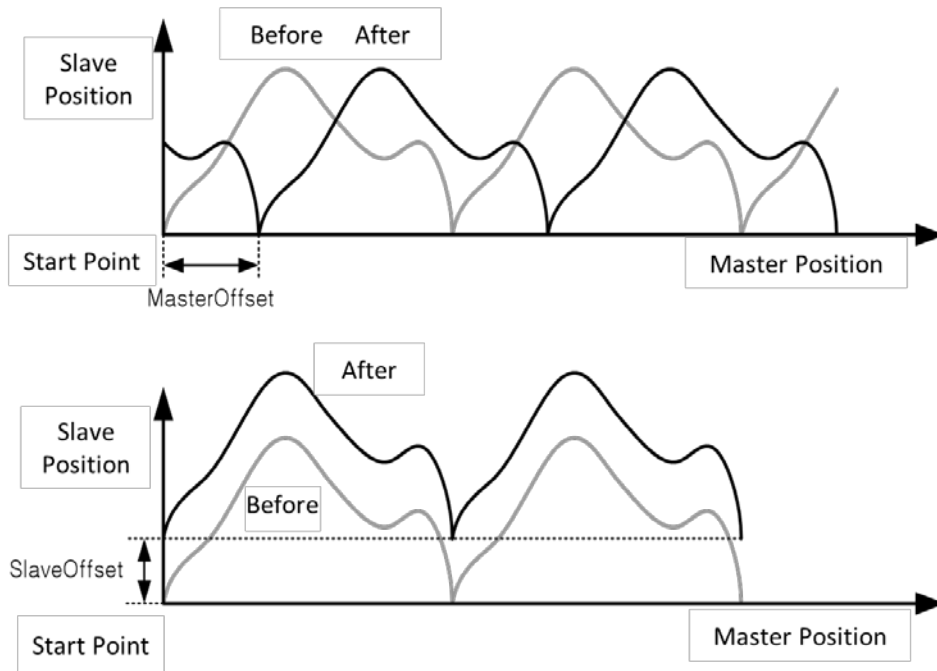
BOOL	Execute	Give On/Off CAM command to the relevant axis in the rising Edge.
BOOL	CamOnOff	Set the on/off state of the cam operation. 1: Complete OnCam and switch to RunCam. 0: Complete OffCam in RunCam and switch the cam to the stop status
BOOL	SkipOnCam	Exclude OnCam from OnOff cam operation and carry out RunCam->OffCam in order.
BOOL	SkipRunCam	Exclude RunCam from OnOff cam operation and carry out OnCam->OffCam in order.
UINT	MasterValueSource	Select the source of the main axis for cam operation. 0: Synchronizes to the command position of the main axis. 1: Synchronizes to the current position of the main axis.
UINT	OnCam_ID	Specify the cam table to operate in the OnCam state.
UINT	RunCam_ID	Specify the cam table to operate in the RunCam state.
UINT	OffCam_ID	Specify the cam table to operate in the OffCam state.
LREAL	MasterOffset	Set the offset value of the main axis.
LREAL	SlaveOffset	Set the offset value of the sub axis.
LREAL	MasterScaling	Specify the scale of the main axis.
LREAL	SlaveScaling	Specify the magnification of the sub axis.
UINT	StartMode	Specify the method for starting the cam operation. 0: Start when CamOnOff is set to 1. 1: Start when CamOnOff is set to 1 and the main axis reaches the position set in

		StartModeParam. 2: Start when CamOnOff is set to 1 and the main axis moves the distance set in StartModeParam. 3: Use the profile generated with LS_CrossSealCamGen.
LREAL	StartModeParam	Set the parameter according to the method for starting the cam operation.
Output		
BOOL	InSync	Indicates that cam operation has entered the RunCam state.
BOOL	Busy	Indicates that the execution of the motion function block is not completed.
BOOL	Active	Indicates that the current motion function block is controlling the relevant axis.
BOOL	CommandAborted	Indicates that the current motion function block is interrupted by another command.
BOOL	Error	Indicates whether an error occurs or not.
WORD	ErrorID	Outputs the error ID that occurred while the motion function block is running.
BOOL	EndOfProfile	Indicates the end of the current cam operation.
UINT	CamState	0: Stop state 1: Executing OnCam 2: Executing RunCam 3: Executing OffCam

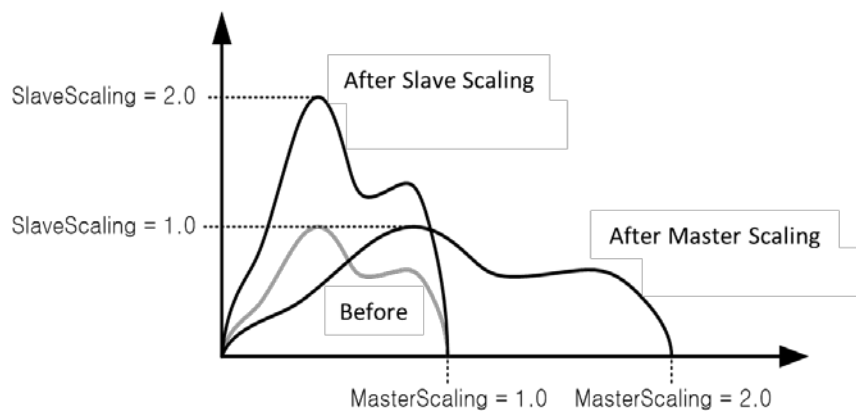
- (1) This motion function block uses three cam tables to carry out the cam operation that is switched to a Stop state->OnCam->RunCam or a RunCam->OffCam->Stop state depending on the CamOnOff input.



- (2) The cam operation runs under a state where Execute is the rising Edge. The cam operation does not stop even if Execute is changed to Off during the operation. To stop the OnOffCam operation, you must give the MC\_CamOut command or run another motion function block.
- (3) For MasterOffset and SlaveOffset, set the offset of the cam table to be applied. MasterOffset sets the offset from the main axis start point, and SlaveOffset sets the offset from the sub axis start point. Please refer to the picture below.

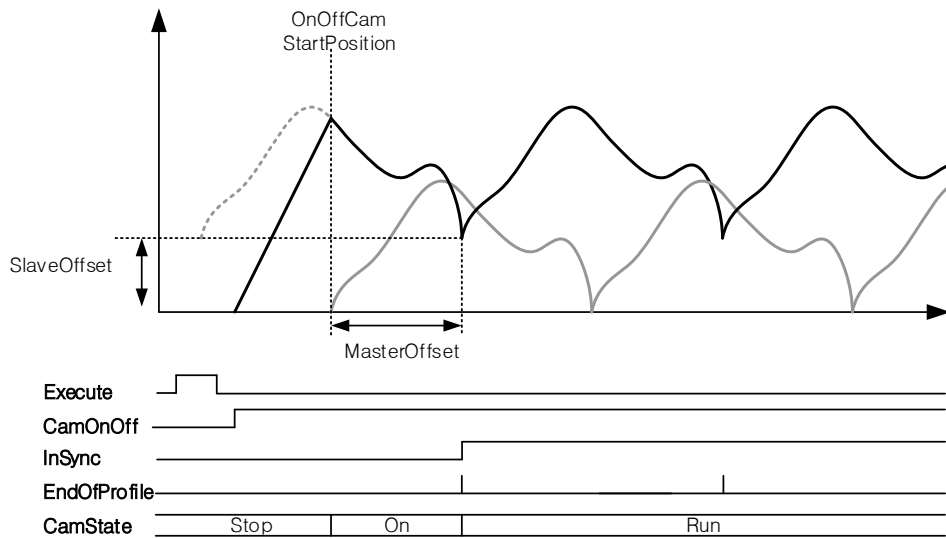


- (4) Set the magnification of cam data to be applied to MasterScaling and SlaveScaling. MasterScaling sets the magnification of the main axis data, and SlaveScaling sets the magnification of the subordinate axis data. Please refer to the picture below.

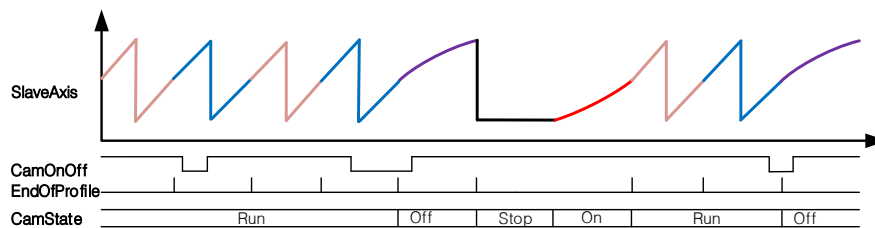


- (5) If StartMode is set to 0, OnCam runs as soon as 1 is input in CamOnOff. If StartMode is set to 1, OnCam does not run as soon as 1 is input in CamOnOff, but when the position of the main axis passes by the position set in StartModeParam. If StartMode is set to 2, OnCam runs when 1 is input in CamOnOff and the main axis then moves in the distance set in StartModeParam.
- (6) If you are using a cam generated with the LS\_CrossSealCamGen function block, set StartMode to 3. If StartMode is set to 3 and the length of OnCam\_ID is 270, the same operation is conducted as if StartMode is set to 1 and StartModeParam is 270. If OnCam\_ID is 180, the same operation is conducted as if StartMode is set to 1 and StartModeParam is set to 0.

- (7) When MasterOffset/SlaveOffset is set, if 1 is input to CamOnOff, operation starts to the OnOffCam start position set as StartMode and StartModeParam. When the start position of OnOffCam is reached, OnOffCam operation is performed. If MasterOffset/SlaveOffset is set and StartMode is set to 0 and OnOffCam operation is performed, shock may occur at the start of operation.



- (8) EndOfProfile outputs On when passing the end of a profile during the operation of each OnCam/OffCam/RunCam cam profile.
- (9) If the CamOnOff signal is Off, the operation to switch to RunCam->OffCam->Stop state is performed. If the CamOnOff signal is switched from Off to On in the RunCam state, the RunCam state is maintained if OffCam is not yet executed. In a state where OffCam is executed, the state switches to the OnCam->RunCam state again after switching to the OffCam->Stop state. (When turning off CamOnOff in RunCam, the operation must be maintained until an EndOfProfile signal is generated.)

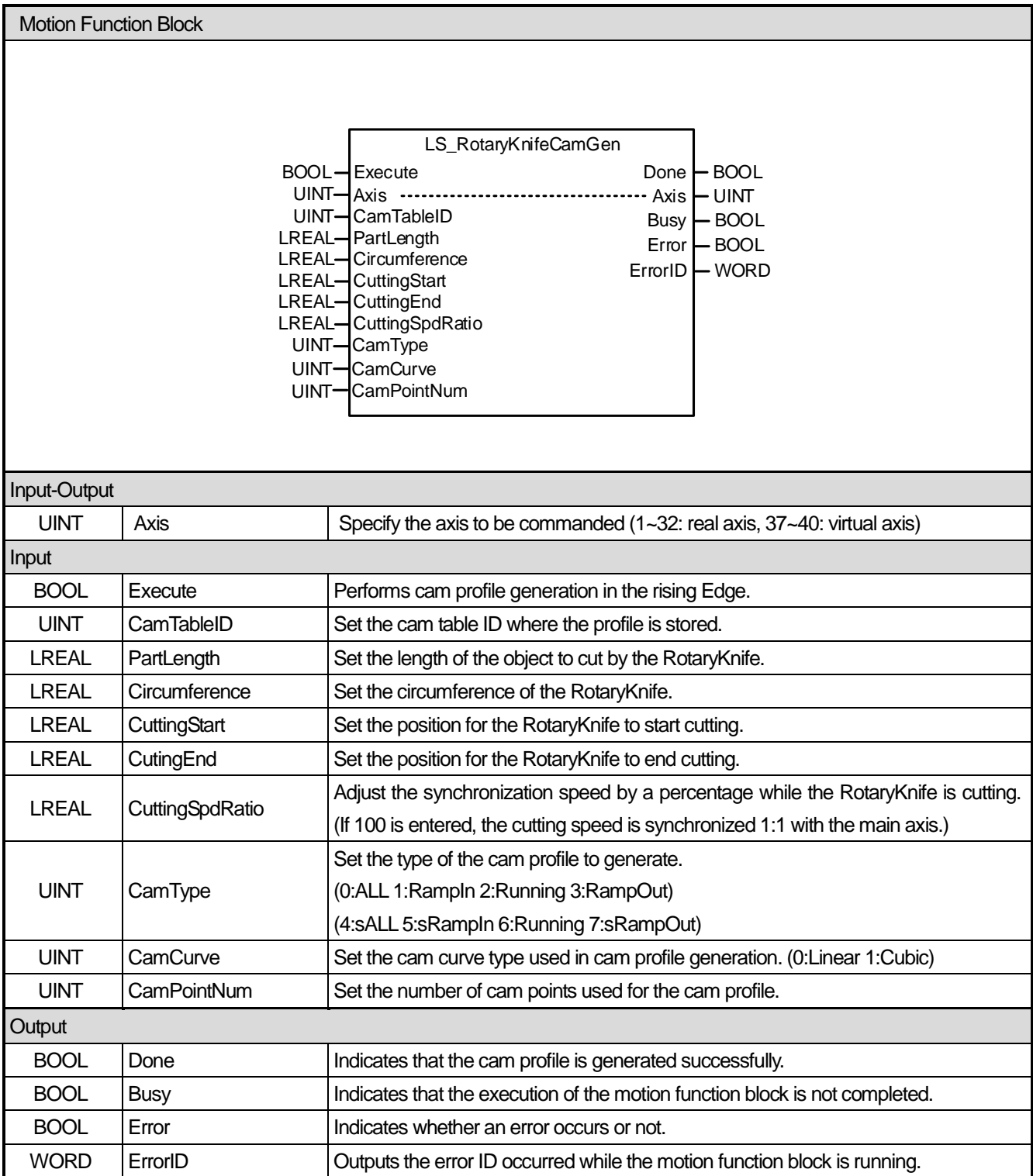


- (10) If the SkipOnCam signal is On, RunCam is executed instantly without OnCam. If CamOnOff turns off after executing RunCam, perform the operation to switch to RunCam->OffCam->Stop state. In an operation where the SkipOnCam signal is On, the operation is executed from the middle of RunCam.
- (11) If the SkipRunnCam signal is On, OffCam is executed without executing RunCam after executing OnCam. If CamOnOff is On at this time, the operation repeats in the order of OnCam->OffCam->Stop->OnCam->OffCam->Stop.

- (12) To stop the OnOffCam operation completely, use the halt (MC\_Halt) or immediate stop (MC\_Stop) motion function block.
- (13) The CamState value is output as Stop(0) / OnCam(1) / RunCam(2) / OffCam(3) depending on the state of cam operation.
- (14) Once the cam operation set in RunCam\_ID is executed, InSync outputs On.
- (15) MasterValueSource selects the source of the main axis for synchronization. If set to 0, the serve axis performs cam operations based on the command position of the main axis calculated in the motion controller, and if set to 1, the serve axis performs cam operations based on the current position received via communication from the servo drive of the main axis.
- (16) RunCam\_ID sets the cam profile to execute during the operation of OnOffCam. Before executing RunCam in a Stop state, set the cam profile to run as OnCam\_ID. OffCam\_ID sets the cam profile to execute before RunCam reaches the Stop state. The setting range for each ID is 1-32, and an input value outside of the range causes a "0x1115" error in the motion function block.
- (17) Any changes made to the MasterValueSource/OnCam\_ID/RunCam\_ID/OffCam\_ID value during operation are not reflected.
- (18) The corresponding axis is in a "SynchronizedMotion" state when this motion function block is running.
- (19) For more information, see Chapter 8.5 RotaryKnife Operation under Chapter 8 Motion Control Function.
- (20) The version information that can use this motion function block is as follows.

Content Module	Module O/S	XG-PM
XGF-M32E	V1.30	V3.1

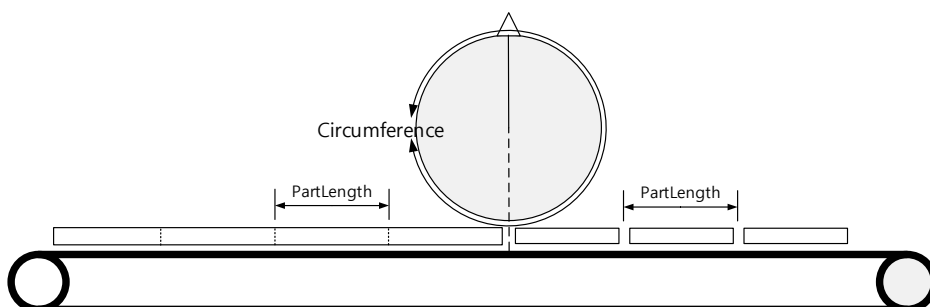
6.6.22 Generate rotaryknife cam profile(LS\_RotaryKnifeCamGen)



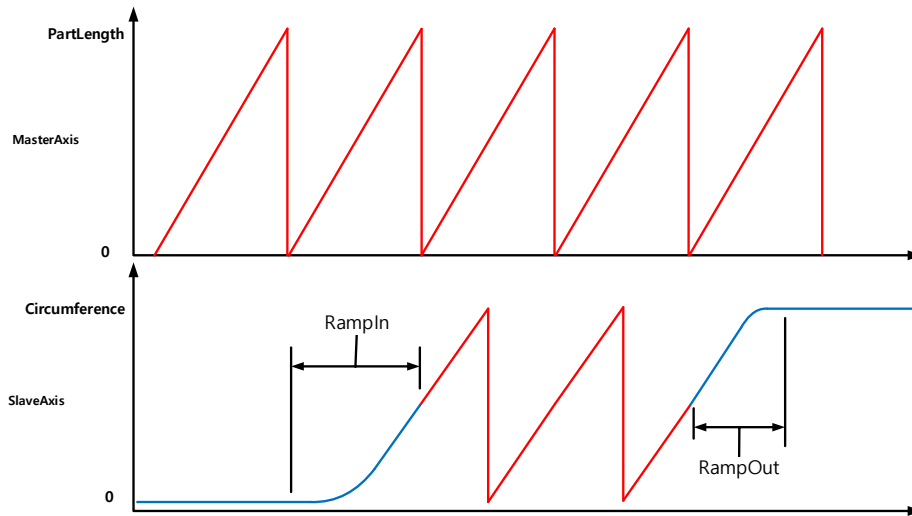
- (1) This motion function block generates the cam profile which performs the RotaryKnife action.
- (2) Use the cam profile generated through LS\_RotaryKnifeCamGen in the LS\_OnOffCam function block.
- (3) On the PartLength input, enter the length of the object to perform cutting using the RotaryKnife.



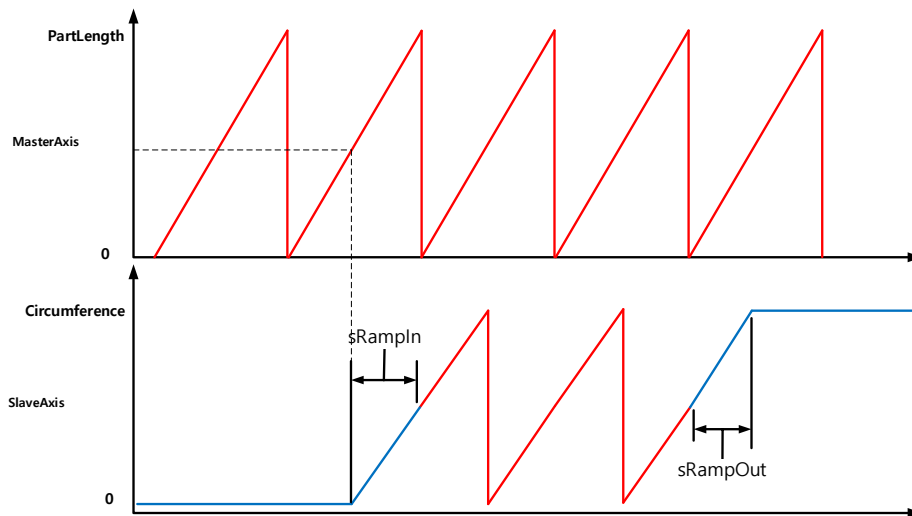
- (4) On the Circumference input, enter the circumference of the RotaryKnife.



- (5) On the CuttingStart input, enter the starting position for the RotaryKnife to start cutting. On the CuttingEnd input, enter the ending position for the RotaryKnife to end cutting. The speed of the conveyor and the RotaryKnife are synchronized between CuttingStart and CuttingEnd. (If you want a cutting region of 10 when the Circumference is 360, set CuttingStart to 175 and CuttingEnd to 185.)
- (6) On the generated cam profile, the movement amount of the main axis is 360Degree in ratio to PartLength. This means that you must set the gear ratio of the motor and the machine in the parameter so that 1 rotation of the main axis equals PartLength.
- (7) On the generated cam profile, the movement amount of the serve axis is 360Degree in ratio to the Circumference. This means that you must set the gear ratio of the motor and the machine in the parameter so that 1 rotation of the serve axis equals the Circumference.
- (8) For CuttingStart, you cannot enter a value that is less than 1/8 of the Circumference or greater than CuttingEnd. A "0x1172" error occurs if there is an error in the CuttingStart value.
- (9) For CuttingEnd, you cannot enter a value that is greater than 7/8 of the Circumference or smaller than CuttingEnd. A "0x1172" error occurs if there is an error in the CuttingEnd value. To set the cutting region to the minimum, set CuttingEnd and CuttingStart as equal values.
- (10) On the CamType, enter the type of cam profile to generate. Available values are 1:RampIn 2:Running 3:RampOut 5:sRampIn 6:Running 7:sRampOut. If you enter 0, RampIn/Running/RampOut will be generated at once. The Running type generates a cam profile which performs repeated cutting actions. The RampIn type generates a profile that includes the stop state to the action of the Running cam profile performing the cutting action. The RampOut type generates a profile to switch RotaryKnife from a running state to a stop state. A "0x1176" error occurs if the CamType value is outside of the range.



- (11) The sRampIn and sRampOut types generate a shortened cam profile of RampIn and RampOut respectively. When operating using sRampIn and sRampOut and you want to main axis to reach the 1/2Circumference position of the serve axis, the main axis must start at the 1/2 position of PartLength.



- (12) On the CuttingSpdRatio input, set the speed ratio for the cutting region. If CuttingSpdRatio is set to 100, a cam profile is generated which operates by synchronizing 1:1 with the speed of the main axis in the cutting region. As the CuttingSpdRatio value is higher, the faster the synchronization speed on the cutting region. The setting range of CuttingSpdRatio is 50-200 and a "0x1174" error occurs if there is an error in the CuttingSpdRatio value.
- (13) On the CamCurve, enter the curve of the cam profile to generate. If you enter 0:Linear, a cam profile is generated using linear interpolation. Once you select linear interpolation, you must specify the number of cam profile points to generate by setting CamPointNum. Take care when setting the number of points as too little can lead to a shock due to the acceleration or deceleration of cam operation and too many can lead to an overload in the program due to the amount of computing resources for saving cam profiles. If you enter 1:Cubic, a cam profile is generated that uses cubic interpolation. A "0x1176" error occurs if the CamCurve value is outside of the range.
- (14) The minimum number of cam points required for CamPointNum is 10 and a "0x1177" error occurs if there is an error in the CamPointNum value. The maximum CamPointNum is 1024.

(15) The version information that can use this motion function block is as follows.

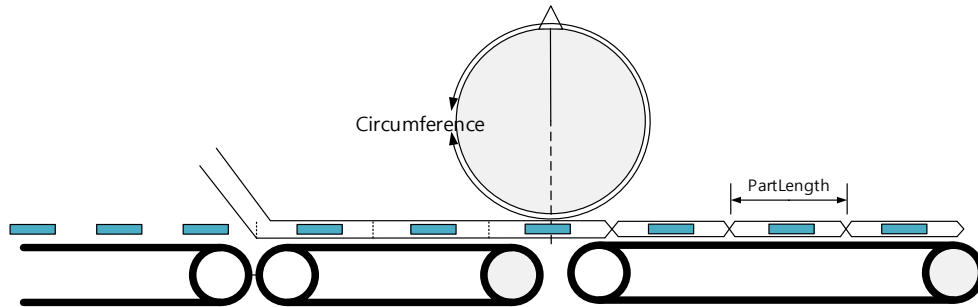
<b>Content</b> <b>Module</b>	<b>Module O/S</b>	<b>XG-PM</b>
<b>XGF-M32E</b>	V1.30	V3.1

6.6.23 Generate crossseal cam profile(LS\_CrossSealCamGen)

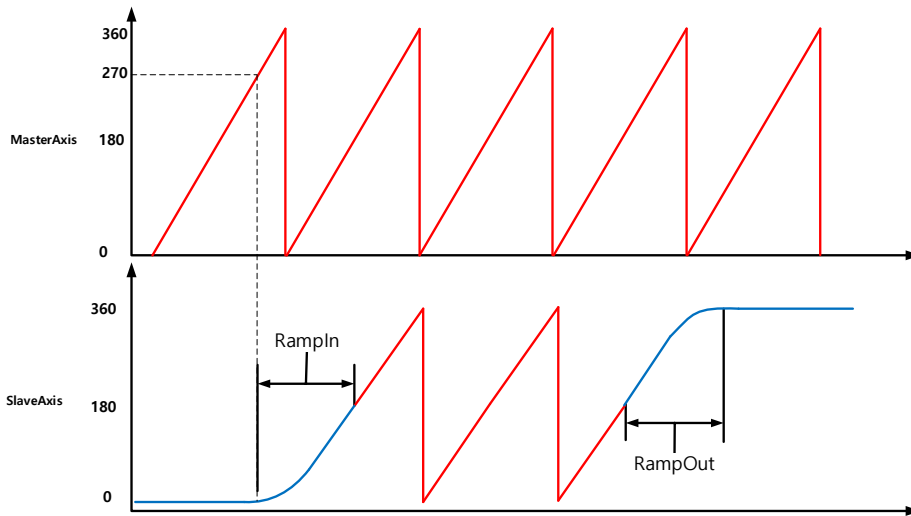
Motion Function Block		
<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: right;"> <p>BOOL— Execute</p> <p>UINT— Axis</p> <p>UINT— CamTableID</p> <p>LREAL— PartLength</p> <p>LREAL— Circumference</p> <p>LREAL— SealStart</p> <p>LREAL— SealEnd</p> <p>LREAL— SealSpdRatio</p> <p>UINT— CamType</p> <p>UINT— CamCurve</p> <p>UINT— CamPointNum</p> </div> <div style="border: 1px solid black; padding: 10px; text-align: center; width: 60%;"> <p>LS_CrossSealCamGen</p> </div> <div style="text-align: left;"> <p>Done— BOOL</p> <p>Axis— UINT</p> <p>Busy— BOOL</p> <p>Error— BOOL</p> <p>ErrorID— WORD</p> </div> </div>		
Input-Output		
UINT	Axis	Specify the axis to be commanded (1~32: real axis, 37~40: virtual axis)
Input		
BOOL	Execute	Performs cam profile generation in the rising Edge.
UINT	CamTableID	Set the cam table ID to store the cam profile.
LREAL	PartLength	Set length of the object sealed by the cross sealer.
LREAL	Circumference	Set circumference of the cross sealer.
LREAL	SealStart	Set the position for the cross sealer to start sealing.
LREAL	SealEnd	Set the position for the cross sealer to end sealing.
LREAL	SealSpdRatio	Adjust the synchronization speed in percentage while the cross sealer is sealing. (If 100 is entered, the sealing speed is synchronized 1:1 with the main axis.)
UINT	CamType	Set the type of the cam profile to generate. (0:ALL 1:RampIn 2:Running 3:RampOut) (4:sALL 5:sRampIn 6:Running 7:sRampOut)
UINT	CamCurve	Set the cam curve type used in cam profile generation. (0:Linear 1:Cubic)
UINT	CamPointNum	Set the number of cam points used for the cam profile.
Output		
BOOL	Done	Indicates that the cam profile is generated successfully.
BOOL	Busy	Indicates that the execution of the motion function block is not completed.
BOOL	Error	Indicates whether an error occurs or not.
WORD	ErrorID	Outputs the error ID occurred while the motion function block is running.

- (1) This motion function block generates the cam profile which performs the cross sealer action. Use the cam profile generated through LS\_CrossSealCamGen in the LS\_OnOffCam function block.
- (2) On the PartLength input, enter the length of the object to perform sealing using the cross sealer.

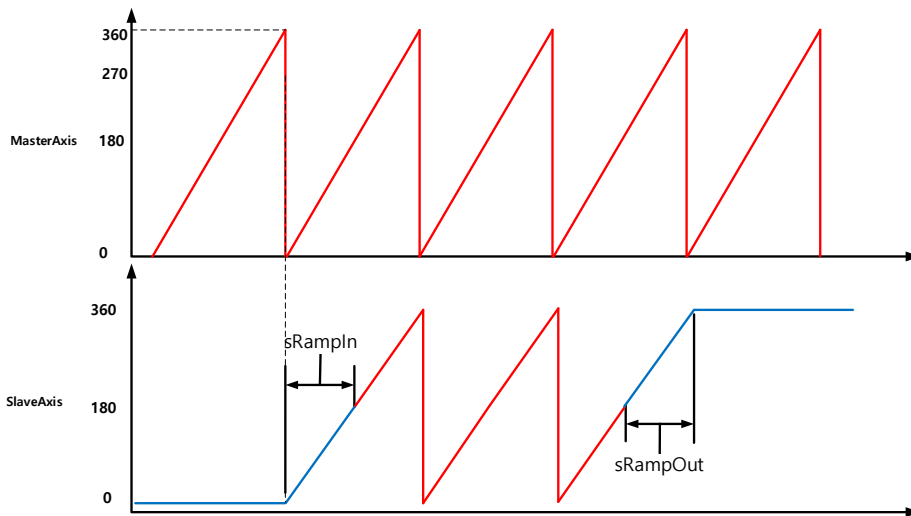
- (3) On the Circumference input, enter the circumference of cross sealer.
- (4) Both the main and serve axes of the generated cam profile is output within the 0-360 range. For the PartLength and Circumference values, you must enter the distance moved by the main axis when the main and serve axes move in 360 value.



- (5) On the SealStart input, enter the starting position for the cross sealer to start sealing. On the SealStart input, enter the starting position for the cross sealer to end sealing. The speed of conveyor and the cross sealer are synchronized between SealStart and SealEnd. (If you want a sealing region of 10 when the Circumference is 360, set SealStart to 175 and SealEnd to 185.)
- (6) On the generated cam profile, the movement amount of the main axis is 360 in ratio to PartLength. This means that you must set the gear ratio of the motor and the machine in the parameter so that when the main axis moves 360, the real distance equals PartLength.
- (7) On the generated cam profile, the movement amount of the serve axis is 360 in ratio to Circumference. This means that you must set the gear ratio of the motor and the machine in the parameter so that when the serve axis moves 360, the real distance equals Circumference.
- (8) For SealStart, you cannot enter a value that is less than 1/8 of the Circumference or greater than SealEnd. A "0x1172" error occurs if there is an error in the SealStart value.
- (9) For SealEnd, you cannot enter a value that is greater than 7/8 of the Circumference or smaller than SealEnd. A "0x1172" error occurs if there is an error in the SealEnd value. To set the sealing region to the minimum, set SealEnd and SealStart as equal values.
- (10) On the CamType, enter the type of cam profile to generate. Available values are 1:RampIn 2:Running 3:RampOut 5:sRampIn 6:Running 7:sRampOut. If you enter 0, RampIn/Running/RampOut will be generated at once. The Running type generates a cam profile which performs repeated sealing actions. The RampIn type generates a profile that includes the stop state to the action of the Running cam profile performing the sealing action. The RampOut type generates a profile to switch the cross sealer from a running state to a stop state. A "0x1176" error occurs if the CamType value is outside of the range.



- (11) The cam profile generated in the LS\_CrossSealCamGen function is similar to the cam profile generated in the LS\_RotaryCutCamGen. For the RampIn profile, the operation starts when the main axis is at 270 and not at 0. The profile also starts to perform sealing when the main axis is at 180 degrees.
- (12) The sRampIn and sRampOut types generate a shortened cam profile of RampIn and RampOut respectively. When operating using sRampIn and sRampOut, the cam operation starts when the main axis is at 0.



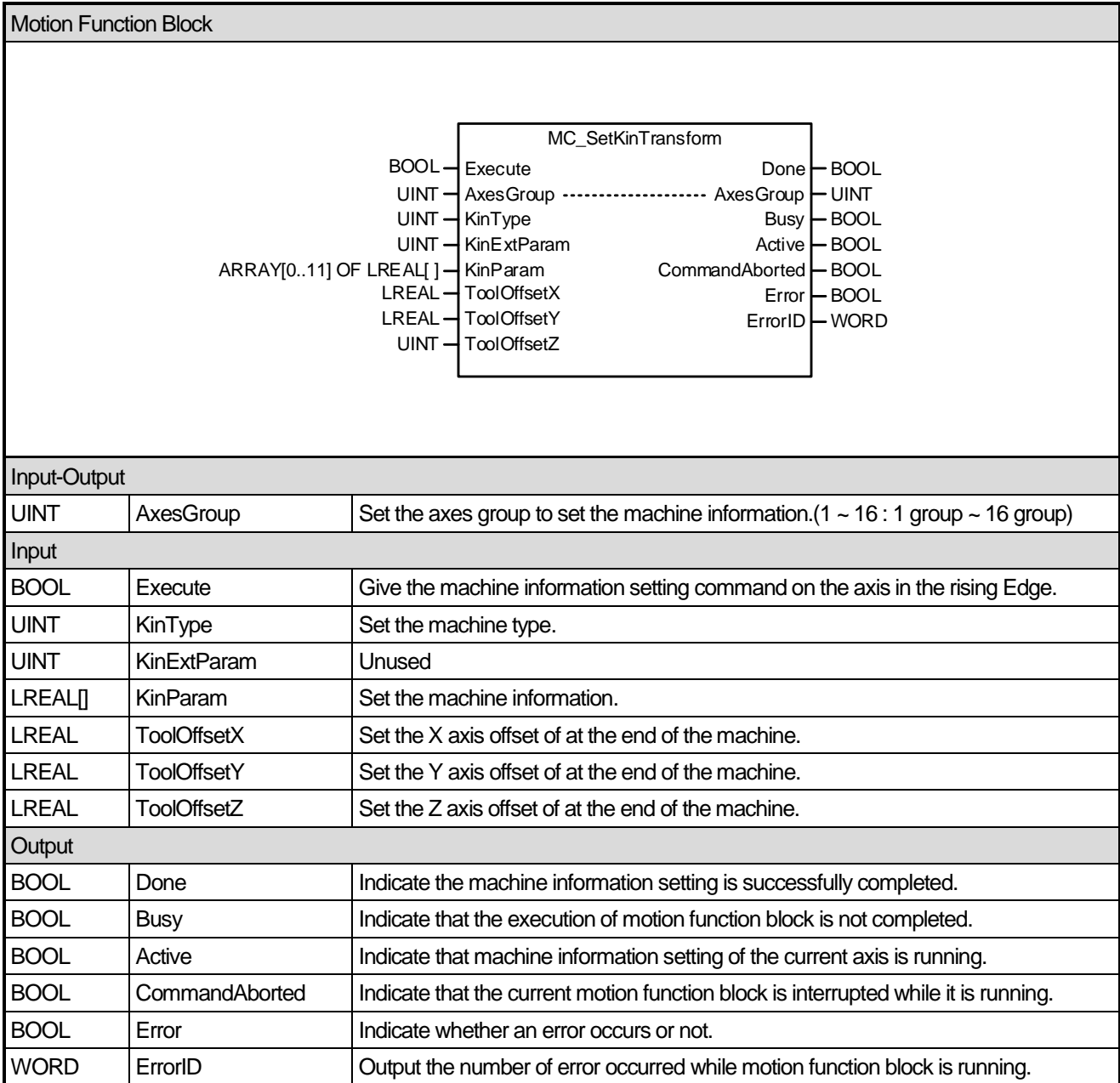
- (13) On the SealSpdRatio input, set the speed ratio for the sealing region. If SealSpdRatio is set to 100, a cam profile is generated which operates by synchronizing 1:1 with the speed of the main axis in the sealing section. The higher the SealSpdRatio value, the faster the synchronization speed in the cutting region. The setting range of SealSpdRatio is 50-200 and a "0x1174" error occurs if there is an error in the SealSpdRatio value.
- (14) On the CamCurve, enter the curve of the cam profile to generate. If you enter 0:Linear, a cam profile is generated using linear interpolation. Once you select linear interpolation, you must specify the number of cam profile points to generate by setting CamPointNum. Take care when setting the number of points as too little can lead to a shock due to the acceleration or deceleration of cam operation and too many can lead to an overload in the program due to the amount of computing resources for saving cam profiles. If you enter 1:Cubic, a cam profile is generated that uses cubic interpolation. A "0x1176" error occurs if the CamCurve value is outside of the range.

- (15) The minimum number of cam points required for CamPointNum is 10 and a "0x1177" error occurs if there is an error in the CamPointNum value. The maximum CamPointNum is 1024.
- (16) The version information that can use this motion function block is as follows.

<b>Content Module</b>	<b>Module O/S</b>	<b>XG-PM</b>
<b>XGF-M32E</b>	V1.30	V3.1

6.7 Coordinate system operation function block

6.7.1 Machine information setting(MC\_SetKinTransform)

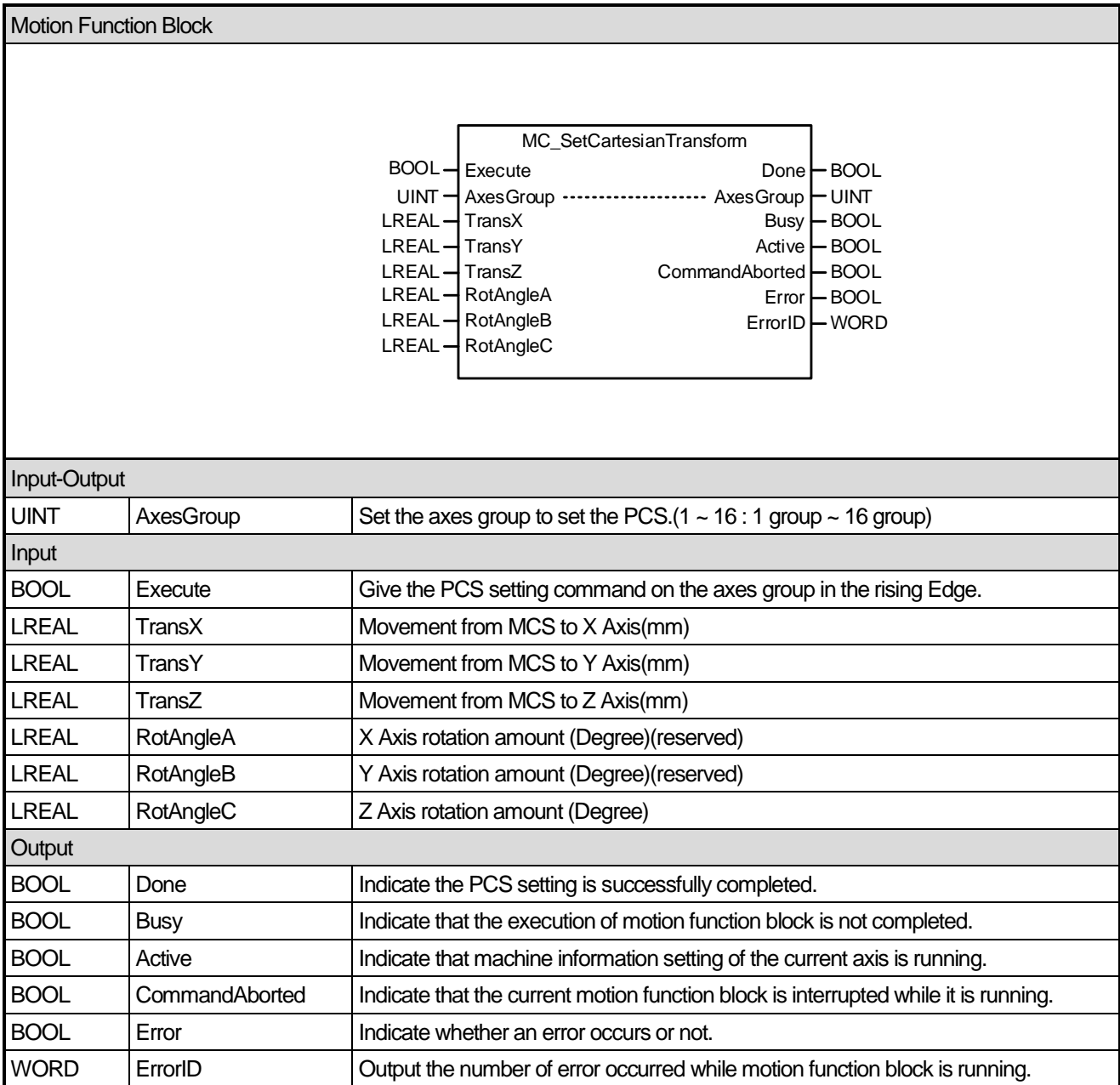


- (1) This motion function block sets the ACS and MCS conversion based on the machine model defined in advance at AxesGroup.
- (2) The same setting can be applied to the XG-PM group parameter settings.
- (3) KinType input is used to set the type of the device, and you can set the device as follows.



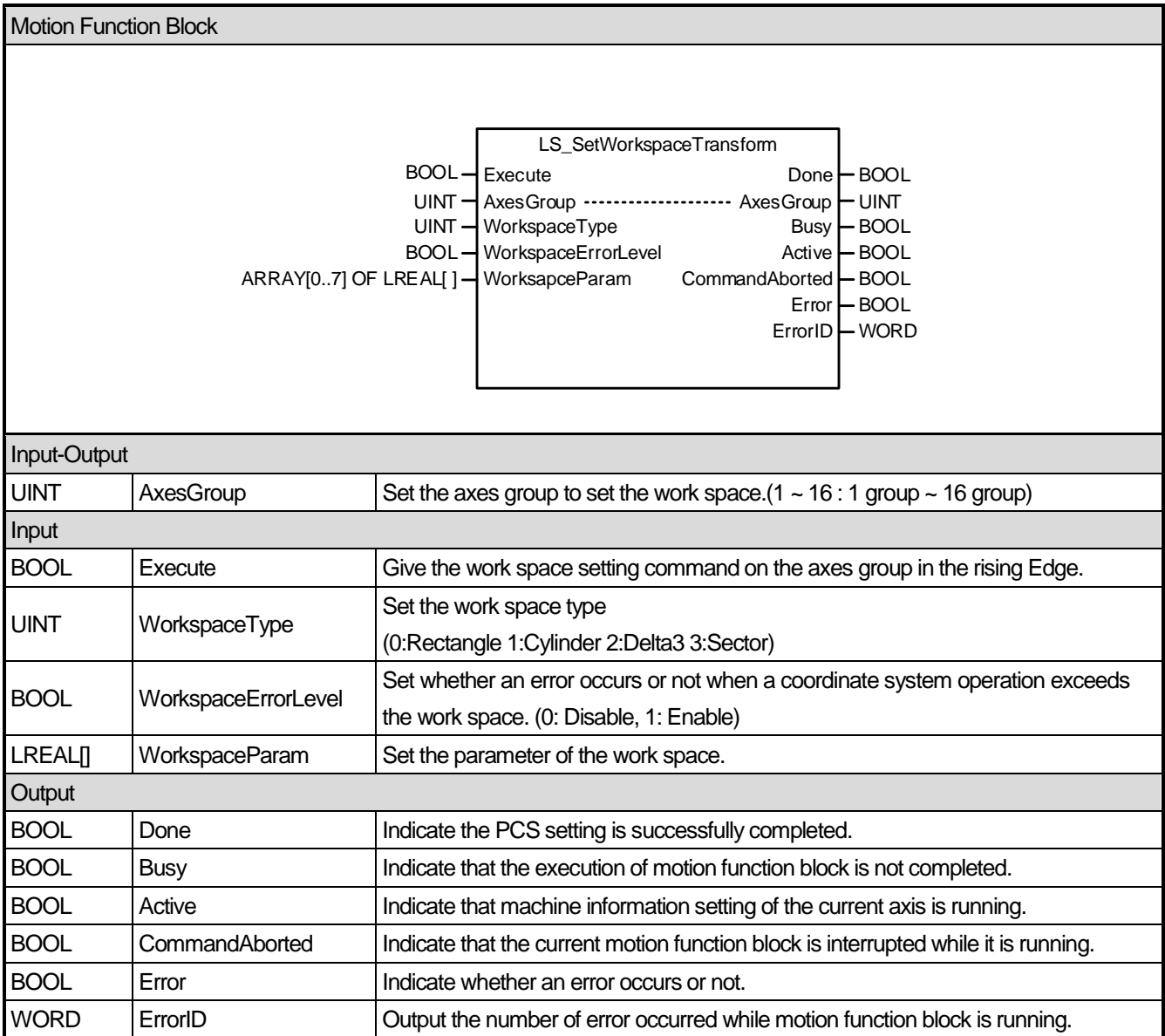
- 1) 0: None
  - 2) 1: XYZ
  - 3) 2: Delta3
  - 4) 3: Delta3R
  - 5) 4: LinearDelta3
  - 6) 5: LinearDelta3R
  - 7) 6: T-Gantry
  - 8) 7: T-GantryR
- (4) KinParam input is used to set the machine information. (No setting is required for XYZ type).
- (5) ToolOffsetX/ToolOffsetY/ToolOffsetZ inputs set the offset at the end point of the machine.
- (6) Refer to chapter 8.4.4 machine information setting in motion control module's manual for more details.

6.7.2 PCS setting (MC\_SetCartesianTransform)



- (1) This motion function block sets the perpendicular coordinate conversion between MCS and PCS at AxesGroup.
- (2) Axis group setting can be performed in the same way at XG-PM axis group parameter setting.
- (3) Refer to chapter 8.4.3 PCS setting in motion control module's manual for more details.

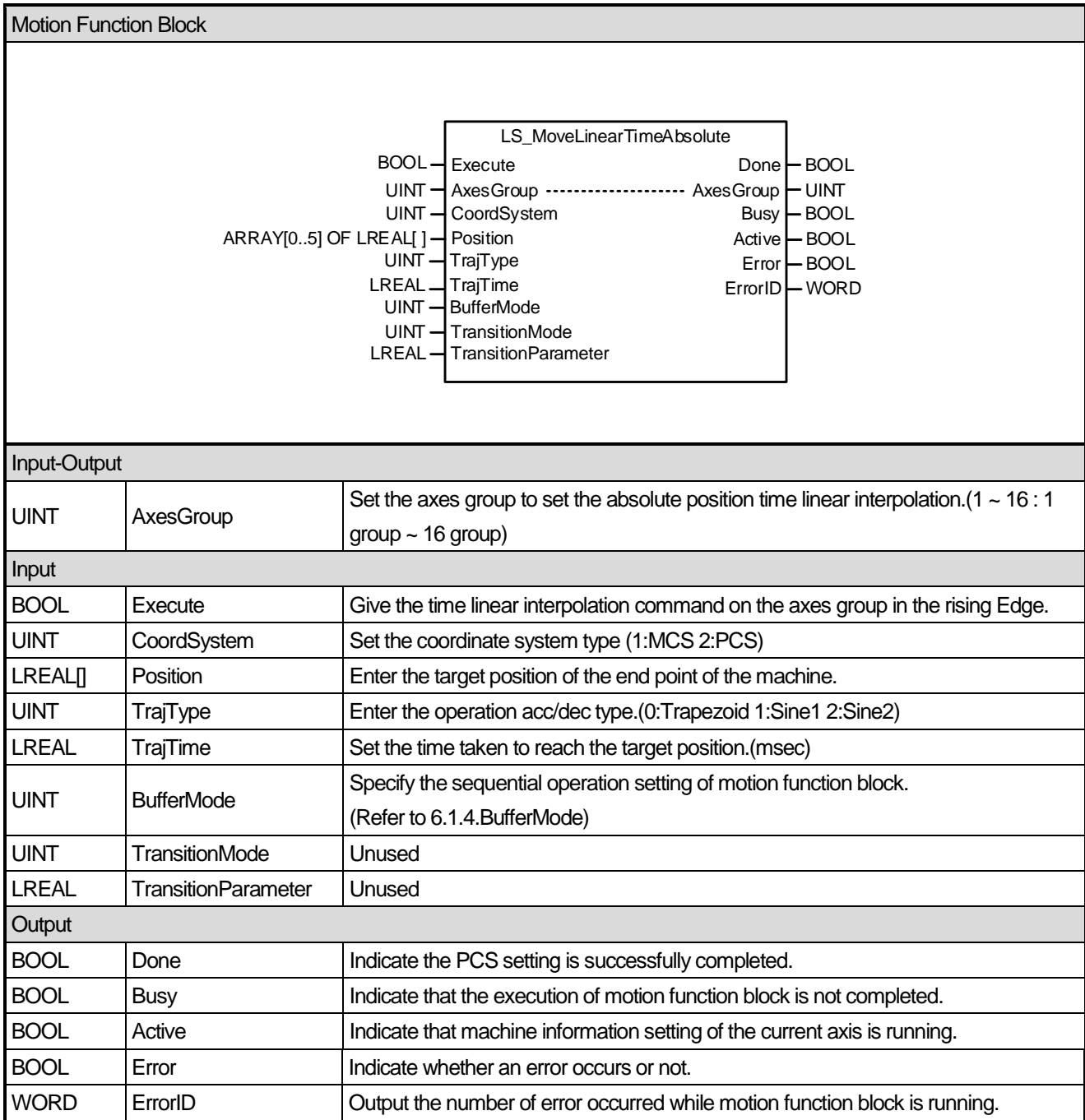
6.7.3 Work space setting(LS\_SetWorkspace)



- (1) This motion function block sets the work space based on the coordiante system at the axes group designated by AxesGroup input.
- (2) The same setting can be performed in XG-PM group parameter setting.
- (3) WorkspaceType can be selected from 4 types (0:Rectangle 1:Cylinder 2:Delta3 4:Sector).
- (4) WorkspaceErrorLevel input determines whether an error occurs when a coordinate system operation exceeds the work space.
- (5) WorkspaceParam input sets the parameters depending on the work space type.
- (6) Refer to chapter 8.4.5 Workspace setting in motion control module’s manual for more details.

6.7.4 Coordinate system absolute position time linear interpolation operation

(LS\_MoveLinearTimeAbsolute)



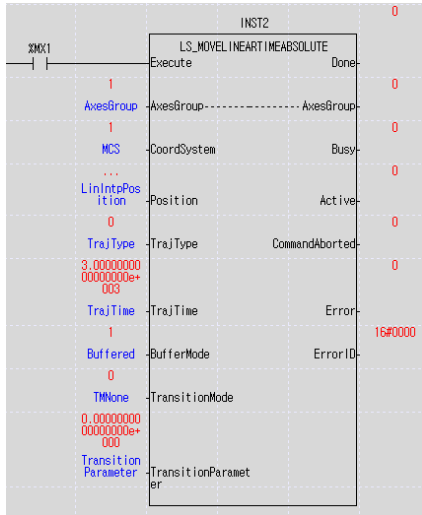
- (1) This motion function block issues absolute position/time linear interpolation command based on coordinate system on the axes group designated by AxesGroup input
- (2) When this motion function block is executed, interpolation control is performed in a linear trajectory from the machine end point of each axes group to the target position.
- (3) TrajType inputs sets the type of velocity, acceleration, deceleration of interpolation trajectory. The type can be selected

from three types: Trapezoid/Sine1/Sine2.

- (4) TrajTime sets the time taken to reach the target position.
- (5) Please refer to 8. 4. 6 Coordinate System Absolute Position/Time Linear Interpolation Control for further details.
- (6) Example program

This example shows the linear interpolation to the target position of MCS (100, 200,-380) when the current command position is 0,0,-380 of MCS coordinate system.

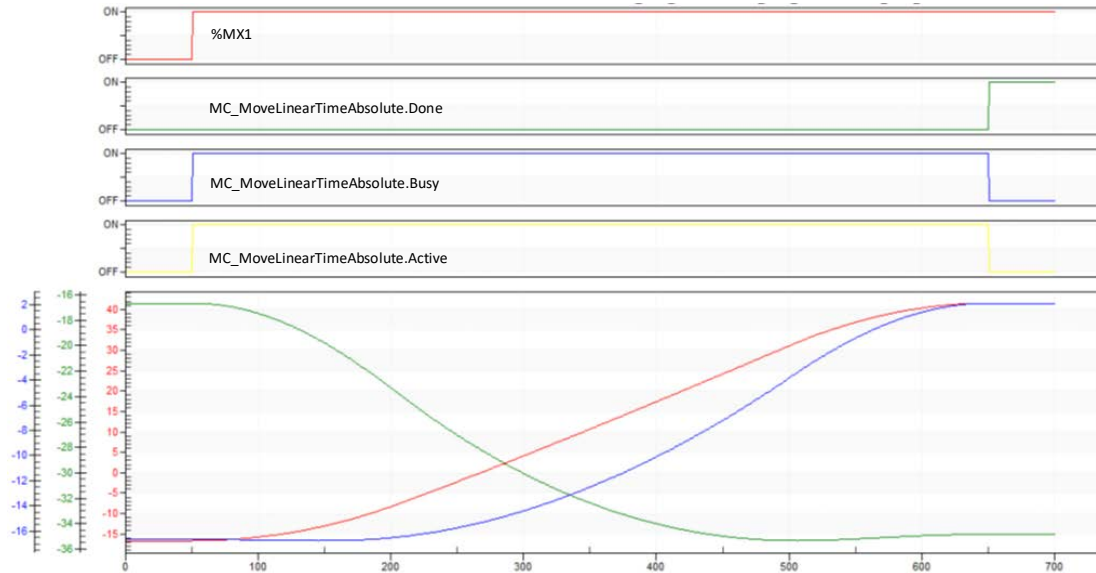
(a) Function block setting



1	_AX01_CPOS	-1.3572036743164063e+001	LREAL
2	_AX02_CPOS	-1.6653305053710937e+001	LREAL
3	_AX03_CPOS	-1.6653121948242188e+001	LREAL
4	_AX04_CPOS	0.0000000000000000e+000	LREAL
5	LinIntPosition	ARRAY[0..5] OF LREAL	
6	LinIntPosition[0]	1.0000000000000000e+002	LREAL
7	LinIntPosition[1]	2.0000000000000000e+002	LREAL
8	LinIntPosition[2]	-3.8000000000000000e+002	LREAL
9	LinIntPosition[3]	0.0000000000000000e+000	LREAL
10	LinIntPosition[4]	0.0000000000000000e+000	LREAL
11	LinIntPosition[5]	0.0000000000000000e+000	LREAL

Target position

(b) Timing diagram



6.7.5 Coordinate system relative position time linear interpolation operation

(LS\_MoveLinearTimeRelative)

Motion Function Block		
<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: right;"> <p>BOOL — Execute</p> <p>UINT — AxesGroup</p> <p>UINT — CoordSystem</p> <p>ARRAY[0..5] OF LREAL[ ] — Position</p> <p>UINT — TrajType</p> <p>LREAL — TrajTime</p> <p>UINT — BufferMode</p> <p>UINT — TransitionMode</p> <p>LREAL — TransitionParameter</p> </div> <div style="border: 1px solid black; padding: 5px; text-align: center;"> <p>LS_MoveLinearTimeRelative</p> </div> <div style="text-align: left;"> <p>Done — BOOL</p> <p>AxesGroup — UINT</p> <p>Busy — BOOL</p> <p>Active — BOOL</p> <p>Error — BOOL</p> <p>ErrorID — WORD</p> </div> </div>		
Input-Output		
UINT	AxesGroup	Set the axes group to set the relative position time linear interpolation.(1 ~ 16 : Group 1 ~ Group 16)
Input		
BOOL	Execute	Give the time linear interpolation command on the axes group in the rising Edge.
UINT	CoordSystem	Set the coordinate system type (1:MCS 2:PCS)
LREAL[]	Position	Enter the target position of the end point of the machine.
UINT	TrajType	Enter the operation acc/dec type.(0:Trapezoid 1:Sine1 2:Sine2)
LREAL	TrajTime	Set the time taken to reach the target position.(msec)
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)
UINT	TransitionMode	Specify the route change mode of group operation. (Refer to 6.1.6.TransitionMode )
LREAL	TransitionParameter	Specify the parameter of the route change setting of group operation. (Refer to 6.1.6.TransitionMode )
Output		
BOOL	Done	Indicate the PCS setting is successfully completed.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that machine information setting of the current axis is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block issues relative position/time linear interpolation command based on coordinate system on the axes group designated by AxesGroup input
- (2) When this motion function block is executed, interpolation control is performed in a linear trajectory from the machine

end point of each axes group to the target position.

- (3) TrajType inputs set the type of velocity, acceleration, deceleration of interpolation trajectory. The type can be selected from three types: Trapezoid/Sine1/Sine2.
- (4) TrajTime sets the time taken to reach the target position.

6.7.6 Coordinate System absolute position linear interpolation operation

(LS\_MoveLinearAbsolute)

Motion Function Block		
<p>The diagram shows a central box labeled 'LS_MoveLinearAbsolute'. On the left side, there are inputs: a 'BOOL' input for 'Execute', a 'UINT' input for 'AxesGroup', an 'ARRAY[0..5] OF LREAL[]' input for 'Position', 'LREAL' inputs for 'Velocity', 'Acceleration', 'Deceleration', and 'Jerk', a 'UINT' input for 'CoordSystem', a 'UINT' input for 'BufferMode', a 'UINT' input for 'TransitionMode', and an 'LREAL' input for 'TransitionParameter'. On the right side, there are outputs: a 'BOOL' output for 'Done', a 'UINT' output for 'AxesGroup', 'BOOL' outputs for 'Busy', 'Active', and 'CommandAborted', a 'BOOL' output for 'Error', and a 'WORD' output for 'ErrorID'.</p>		
Input-Output		
UINT	AxesGroup	Set the group to perform absolute position linear interpolation operation. (1 ~ 16: Group 1 ~ Group 16)
Input		
BOOL	Execute	Give absolute position linear interpolation operation command to the relevant group in the rising Edge.
LREAL[]	Position	Specify the target position of each axis.
LREAL	Velocity	Specify the maximum speed of the route. [u/s]
LREAL	Acceleration	Specify the maximum acceleration. [u/s <sup>2</sup> ]
LREAL	Deceleration	Specify the maximum deceleration. [u/s <sup>2</sup> ]
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]
UINT	CoordSystem	Select the coordinate system type (1:MCS 2:PCS)
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)
UINT	TransitionMode	Specify the route change mode of group operation. (Refer to 6.1.6.TransitionMode )
LREAL	TransitionParameter	Specify the parameter of the route change setting of group operation. (Refer to 6.1.6.TransitionMode )
Output		
BOOL	Done	Indicates that the linear interpolation operation of the coordinate system position has been successfully completed.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.



BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block is to give an absolute position linear interpolation command to the axis group specified in AxesGroup input.
- (2) When this motion function block is executed, interpolation control is executed by the trajectory of a straight line from the end point of the current device of each axis group to the target position.
- (3) For Velocity, Acceleration, Deceleration, Jerk input, specify the speed, acceleration, deceleration, and acceleration/deceleration rate of change of interpolation operation respectively.
- (4) Velocity sets the interpolation speed and becomes the speed for the combined distance of the position value (Position[0], Position[1], Position[2]) of the target position. If the position value of the target position is the same as the current position, it becomes the speed for the combined angle of the target position angle value (Position[3], Position[4], Position[4]).
- (5) If the function block is re-executed (Execute input On) before the command is terminated, the changed parameters are applied.
- (6) Only Velocity, Acceleration, Deceleration, Jerk, and Position inputs can be updated.
- (7) Velocity input can be set or changed to 0.
- (8) The version information that can use this motion function block is as follows.

Content Module	Module O/S	XG-PM
<b>XGF-M32E</b>	V1.30	V3.1

6.7.7 Coordinate System relative position linear interpolation operation

(LS\_MoveLinearRelative)

Motion Function Block		
Input-Output		
UINT	AxesGroup	Set the group to perform relative position linear interpolation operation. (1 ~ 16: Group 1 ~ Group 16)
Input		
BOOL	Execute	Give relative position linear interpolation operation command to the relevant group in the rising Edge.
LREAL[]	Distance	Specify the target distance of each axis.
LREAL	Velocity	Specify the maximum speed of the route. [u/s]
LREAL	Acceleration	Specify the maximum acceleration. [u/s <sup>2</sup> ]
LREAL	Deceleration	Specify the maximum deceleration. [u/s <sup>2</sup> ]
LREAL	Jerk	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]
UINT	CoordSystem	Select the coordinate system type (1:MCS 2:PCS)
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)
UINT	TransitionMode	Specify the route change mode of group operation. (Refer to 6.1.6.TransitionMode )
LREAL	TransitionParameter	Specify the parameter of the route change setting of group operation. (Refer to 6.1.6.TransitionMode )
Output		
BOOL	Done	Indicates that the linear interpolation operation of the coordinate system position has been successfully completed.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that the current motion function block is controlling the relevant axis.
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.

BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block is to give an relative position linear interpolation command to the axis group specified in AxesGroup input.
- (2) When this motion function block is executed, interpolation control is executed by the trajectory of a straight line from the end point of the current device of each axis group to the target position.
- (3) For Velocity, Acceleration, Deceleration, Jerk input, specify the speed, acceleration, deceleration, and acceleration/deceleration rate of change of interpolation operation respectively.
- (4) Velocity sets the interpolation speed and becomes the speed for the combined distance of the moving distance value (Distance [0], Distance [1], Distance [2]) of the target position. If the position value of the target position is the same as the current position, it becomes the speed for the combined angle of the moving angle value (Distance[3], Distance [4], Distance [5]) of the target position.
- (5) If the function block is re-executed (Execute input On) before the command is terminated, the changed parameters are applied.
- (6) Only Velocity, Acceleration, Deceleration, Jerk, and Position inputs can be updated.
- (7) Velocity input can be set or changed to 0.
- (8) The version information that can use this motion function block is as follows.

Content Module	Module O/S	XG-PM
<b>XGF-M32E</b>	V1.30	V3.1

6.7.8 Coordinate absolute positioning 2D circular interpolation operation

(MC\_MoveCircularAbsolute2D)

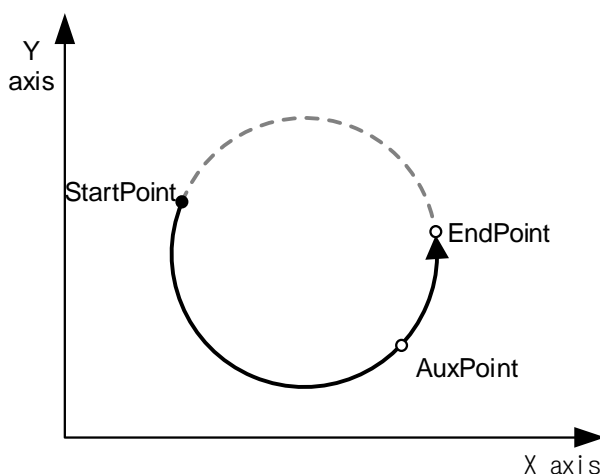
Motion Function Block				
<div style="border: 1px solid black; padding: 10px; margin: 0 auto; width: fit-content;"> <p style="text-align: center; margin: 0;">MC_MoveCircularAbsolute2D</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%; vertical-align: top;">                     BOOL — Execute                      UINT — AxesGroup                      UINT — CircMode                      LREAL[ ] — AuxPoint                      LREAL[ ] — EndPoint                      UINT — PathChoice                      LREAL — Velocity                      LREAL — Acceleration                      LREAL — Deceleration                      LREAL — Jerk                      UINT — CoordSystem                      UINT — BufferMode                      UINT — TransitionMode                      LREAL — TransitionParameter                 </td> <td style="width: 50%; vertical-align: top; border-left: 1px dashed black;">                     Done — BOOL                      AxesGroup — UINT                      Busy — BOOL                      Active — BOOL                      CommandAborted — BOOL                      Error — BOOL                      ErrorID — WORD                 </td> </tr> </table> </div>			BOOL — Execute UINT — AxesGroup UINT — CircMode LREAL[ ] — AuxPoint LREAL[ ] — EndPoint UINT — PathChoice LREAL — Velocity LREAL — Acceleration LREAL — Deceleration LREAL — Jerk UINT — CoordSystem UINT — BufferMode UINT — TransitionMode LREAL — TransitionParameter	Done — BOOL AxesGroup — UINT Busy — BOOL Active — BOOL CommandAborted — BOOL Error — BOOL ErrorID — WORD
BOOL — Execute UINT — AxesGroup UINT — CircMode LREAL[ ] — AuxPoint LREAL[ ] — EndPoint UINT — PathChoice LREAL — Velocity LREAL — Acceleration LREAL — Deceleration LREAL — Jerk UINT — CoordSystem UINT — BufferMode UINT — TransitionMode LREAL — TransitionParameter	Done — BOOL AxesGroup — UINT Busy — BOOL Active — BOOL CommandAborted — BOOL Error — BOOL ErrorID — WORD			
Input-Output				
UINT	AxesGroup	Set the axes group to set the absolute position circular interpolation.(1 ~ 16 : 1 group ~ 16 group)		
Input				
BOOL	Execute	Give the circular interpolation command on the axes group in the rising Edge.		
UINT	CircMode	The way to set the circular interpolation [0: Middle point Aux point, 1: Center point, 2: Radius]		
LREAL[ ]	AuxPoint	The auxiliary point position for circular interpolation is designated as an absolute coordinate.		
LREAL[ ]	EndPoint	Set the circular end point as an absolute coordinate.		
BOOL	PathChoice	Set the circular path. 0: clockwise direction, 1: counter-clockwise direction		
LREAL	Velocity	Set the maximum velocity of the path.. [u/s]		
LREAL	Acceleration	Set the maximum acceleration. [u/s <sup>2</sup> ]		
LREAL	Deceleration	Set the minimum decleration. [u/s <sup>2</sup> ]		
LREAL	Jerk	Set the maximum acc/dec jerk. [u/s <sup>3</sup> ]		
UINT	CoordSystem	Set the coordinate system's type. (1:MCS 2:PCS)		
UINT	BufferMode	the sequential operation of the motion function block. (Refer to 6.1.4 BufferMode)		
UINT	TransitionMode	Unused		
LREAL	TransitionParameter	Unused		
Output				

BOOL	Done	Indicate whether to reach the specified point.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that whether or not motion function block is controlling the group.
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block issues absolute position circular interpolation command based on coordinate system on the axis group designated by AxesGroup input.
- (2) When this motion function block starts, each axis performs circular trajectory interpolation control referring to the auxiliary point input, and the movement direction is determined by Path Choice input. If PathChoice input is set to 0, circular interpolation is operated in a clockwise direction, and if it is set to 1, circular interpolation is operated in a counter-clockwise direction.
- (3) At AuxPoint and EndPoint input, designate the arrangement of the absolute position of auxiliary points to refer to for circular interpolation of each axis. The input corresponds in the order of X, Y, Z, unlike MC\_MoveCircularAbsolute.
- (4) Velocity, Acceleration, Deceleration, Jerk input sets the velocity, acceleration, deceleration, and acceleration/deceleration rate change of the interpolation path, respectively.
- (5) CircMode input sets the circular interpolation method. The circular interpolation methods corresponding to CircMode values are as follows.

(a) Circular Interpolation Using Midpoint Specification (CircMode = 0)

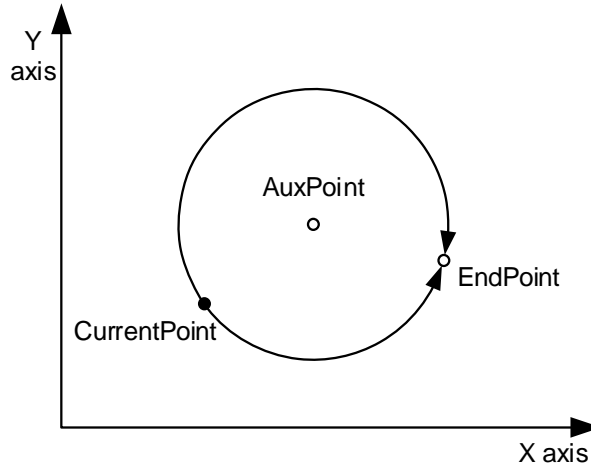
This method performs circular interpolation by starting operation at the start position, passing the designated midpoint, and reaching the target position. In the figure below, the start position corresponds to the axes group coordinate at the start of the command, the midpoint corresponds to the coordinate input for the AuxPoint, and the target position corresponds to the absolute coordinate input for the EndPoint.



(b) Circular Interpolation Using Center Point Specification (CircMode = 1)

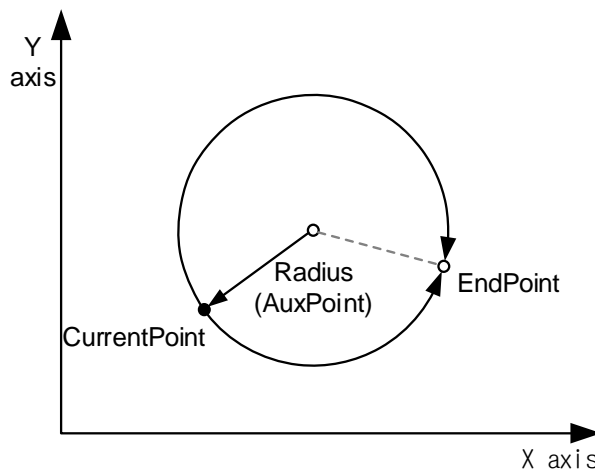
This method performs circular interpolation to the target position by starting operation at the current position,

and following a circular trajectory of which diameter corresponds to the distance to the designated center point. In the figure below, the current position corresponds to the axes group coordinate at the start of the command, the center point corresponds to the coordinate input for the AuxPoint, and the target position corresponds to the absolute coordinate input for the EndPoint.



(c) Circular Interpolation using Radius Speciation (CircMode = 2)

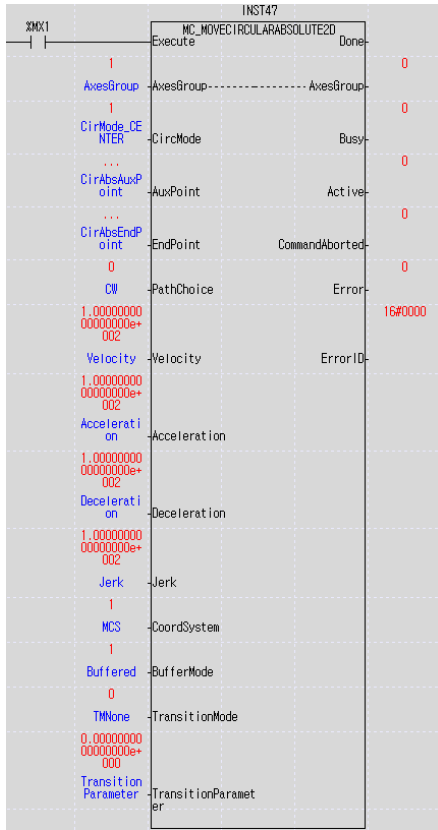
This method performs circular interpolation to the target position by starting operation at the current position, and following a circular trajectory with a designated radius from the current position to the target position. In the figure below, the current position corresponds to the axes group coordinate at the start of the command, the radius corresponds to the X coordinate input for the AuxPoint, and the target position corresponds to the absolute coordinate input for the EndPoint.



- (6) Refer to chapter 8.4.7 circular interpolation control in motion control module's manual for more details.
- (7) The changed parameters are applied by re-executing the function block (Execute input is On) before the command is completed.
- (8) Only, Velocity, Acceleration, Deceleration, Jerk, AuxPoint, Endpoint input can be updated.
- (9) Example program

This example is to set the center point at (0, 75, -580) when the current command position is MCS (0,150,-580), and perform circular interpolation to the target position MCS(0,0,-580) by moving in a clockwise direction.

(a) Function block setting

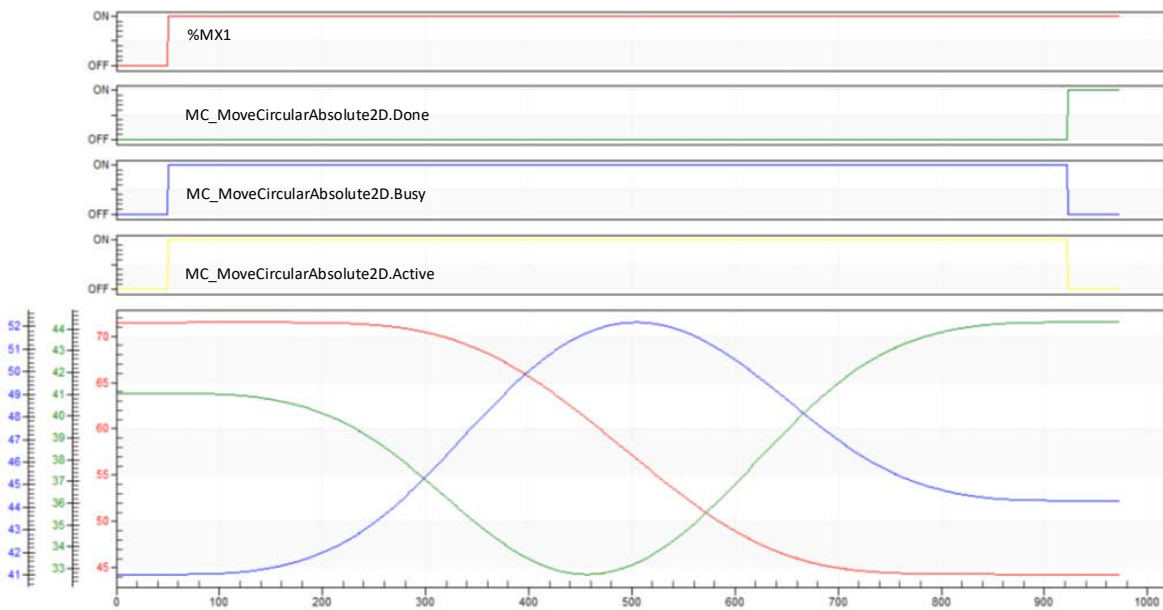


1	_AX01_CPOS	7.1485269050584748e+001	LREAL
2	_AX02_CPOS	4.1026455810822632e+001	LREAL
3	_AX03_CPOS	4.1026455810822632e+001	LREAL
4	CirAbsAuxPoint	ARRAY[0..2] OF LREAL	
5	CirAbsAuxPoint[0]	0.0000000000000000e+000	LREAL
6	CirAbsAuxPoint[1]	7.5000000000000000e+001	LREAL
7	CirAbsAuxPoint[2]	-5.8000000000000000e+002	LREAL
8	CirAbsEndPoint	ARRAY[0..2] OF LREAL	
9	CirAbsEndPoint[0]	0.0000000000000000e+000	LREAL
10	CirAbsEndPoint[1]	0.0000000000000000e+000	LREAL
11	CirAbsEndPoint[2]	-5.8000000000000000e+002	LREAL

CenterPoint

EndPoint

(b) Timing diagram



6.7.9 Coordinate relative positioning 2D circular interpolation operation

(MC\_MoveCircularRelative2D)

Motion Function Block																																												
<div style="border: 1px solid black; padding: 10px; margin: 0 auto; width: fit-content;"> <p style="text-align: center; margin: 0;">MC_MoveCircularRelative2D</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%; text-align: right;">BOOL — Execute</td> <td style="width: 40%;"></td> <td style="width: 30%; text-align: left;">Done — BOOL</td> </tr> <tr> <td style="text-align: right;">UINT — AxesGroup</td> <td style="text-align: center;">-----</td> <td style="text-align: left;">AxesGroup — UINT</td> </tr> <tr> <td style="text-align: right;">UINT — CircMode</td> <td></td> <td style="text-align: left;">Busy — BOOL</td> </tr> <tr> <td style="text-align: right;">LREAL[ ] — AuxPoint</td> <td></td> <td style="text-align: left;">Active — BOOL</td> </tr> <tr> <td style="text-align: right;">LREAL[ ] — EndPoint</td> <td></td> <td style="text-align: left;">CommandAborted — BOOL</td> </tr> <tr> <td style="text-align: right;">UINT — PathChoice</td> <td></td> <td style="text-align: left;">Error — BOOL</td> </tr> <tr> <td style="text-align: right;">LREAL — Velocity</td> <td></td> <td style="text-align: left;">ErrorID — WORD</td> </tr> <tr> <td style="text-align: right;">LREAL — Acceleration</td> <td></td> <td></td> </tr> <tr> <td style="text-align: right;">LREAL — Deceleration</td> <td></td> <td></td> </tr> <tr> <td style="text-align: right;">LREAL — Jerk</td> <td></td> <td></td> </tr> <tr> <td style="text-align: right;">UINT — CoordSystem</td> <td></td> <td></td> </tr> <tr> <td style="text-align: right;">UINT — BufferMode</td> <td></td> <td></td> </tr> <tr> <td style="text-align: right;">UINT — TransitionMode</td> <td></td> <td></td> </tr> <tr> <td style="text-align: right;">LREAL — TransitionParameter</td> <td></td> <td></td> </tr> </table> </div>			BOOL — Execute		Done — BOOL	UINT — AxesGroup	-----	AxesGroup — UINT	UINT — CircMode		Busy — BOOL	LREAL[ ] — AuxPoint		Active — BOOL	LREAL[ ] — EndPoint		CommandAborted — BOOL	UINT — PathChoice		Error — BOOL	LREAL — Velocity		ErrorID — WORD	LREAL — Acceleration			LREAL — Deceleration			LREAL — Jerk			UINT — CoordSystem			UINT — BufferMode			UINT — TransitionMode			LREAL — TransitionParameter		
BOOL — Execute		Done — BOOL																																										
UINT — AxesGroup	-----	AxesGroup — UINT																																										
UINT — CircMode		Busy — BOOL																																										
LREAL[ ] — AuxPoint		Active — BOOL																																										
LREAL[ ] — EndPoint		CommandAborted — BOOL																																										
UINT — PathChoice		Error — BOOL																																										
LREAL — Velocity		ErrorID — WORD																																										
LREAL — Acceleration																																												
LREAL — Deceleration																																												
LREAL — Jerk																																												
UINT — CoordSystem																																												
UINT — BufferMode																																												
UINT — TransitionMode																																												
LREAL — TransitionParameter																																												
Input-Output																																												
UINT	AxesGroup	Set the group to do relative position circular interpolation operation. (1 ~ 16: Group 1 ~ Group 16)																																										
Input																																												
BOOL	Execute	Give relative position circular interpolation operation command on the group in the rising Edge.																																										
UINT	CircMode	Circular interpolation method setting [0: Midpoint, 1: Central point, 2: Radius]																																										
LREAL[ ]	AuxPoint	Specify the position of auxiliary point depending on the circular interpolation method in a relative coordinate.																																										
LREAL[ ]	EndPoint	Specify the end point of the circular trajectory as a relative coordinate from the start point.																																										
BOOL	PathChoice	Set the circular path. 0: clockwise direction, 1: counter-clockwise direction																																										
LREAL	Velocity	Set the maximum velocity of the path. [u/s]																																										
LREAL	Acceleration	Set the maximum acceleration. [u/s <sup>2</sup> ]																																										
LREAL	Deceleration	Set the minimum decleration. [u/s <sup>2</sup> ]																																										
LREAL	Jerk	Set the maximum acc/dec jerk. [u/s <sup>3</sup> ]																																										
UINT	CoordSystem	Set the coordinate system's type. (1:MCS 2:PCS)																																										
UINT	BufferMode	the sequential operation of the motion function block. (Refer to the chapter 6.1.4 BufferMode input)																																										
UINT	TransitionMode	Unused																																										
LREAL	TransitionParameter	Unused																																										
Output																																												

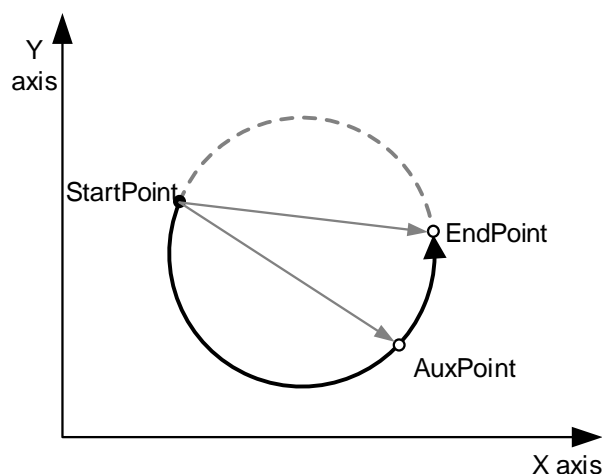


BOOL	Done	Indicate whether to reach the specified point.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that whether or not motion function block is controlling the group.
BOOL	CommandAborted	Indicate that the current motion function block is interrupted while it is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block issues relative position circular interpolation command on the axes group designated by AxesGroup input.
- (2) When this motion function block is executed, each axis performs circular interpolation control referring to the auxiliary point input, and the direction is determined by Path Choice input. If PathChoiceinput is set to 0, circular interpolation is operated in a clockwise direction, and if it is set to 1, circular interpolation is operated in a counter-clockwise direction.
- (3) At AuxPoint and EndPoint input, designate the arrangement of the relative position of auxiliary points to refer to for circular interpolation of each axis. The input arrangement and the axes of the group correspond to the designated axis IDs [ID1, ID2, ID3, ... ], in that order. (Since the number of axes comprising a group to issue circular interpolation command is 3, arrangements of three sizes should be input for the Position input.)
- (4) In Velocity, Acceleration, Deceleration, Jerk inputs, the acceleration, deceleration, change rate of acceleration, velocity of the interpolation path are specified, respectively.
- (5) CircMode input sets the circular interpolation method. The circular interpolation methods corresponding to CircMode values are as follows.

(a) Circular Interpolation Using Midpoint Specification (BORDER, CircMode = 0)

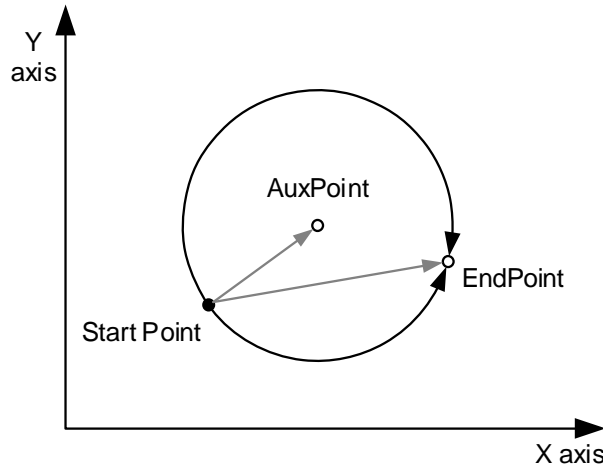
This method is to perform the circular interpolation to the target position through the midpoint position after starting operation at the current position. In the figure below, the current position corresponds to the axes group coordinate at the start of the command, the midpoint corresponds to the coordinate input for the AuxPoint, and the target position corresponds to the relative coordinate input for the EndPoint.



(b) Circular Interpolation Using Center Point Specification (CircMode = 1)

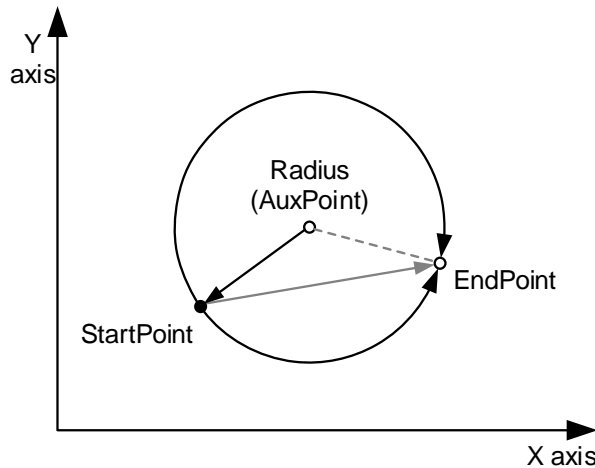
This method is to perform the circular interpolation to the target position by starting operation at the start position, and following a circular trajectory of which diameter corresponds to the distance to the designated center point.

In the figure below, the current position corresponds to the axes group coordinate at the start of the command, the center point corresponds to the coordinate input for the AuxPoint, and the target position corresponds to the relative coordinate input for the EndPoint.



(c) Circular Interpolation using Radius Speciation (CircMode = 2)

This method is to perform the circular interpolation to the target position by starting operation at the current position, passing the designated center point, and reaching the target position. In the figure below, the current position corresponds to the axes group coordinate at the start of the command, the diameter corresponds to the X coordinate input for the AuxPoint, and the target position corresponds to the relative coordinate input for the EndPoint.

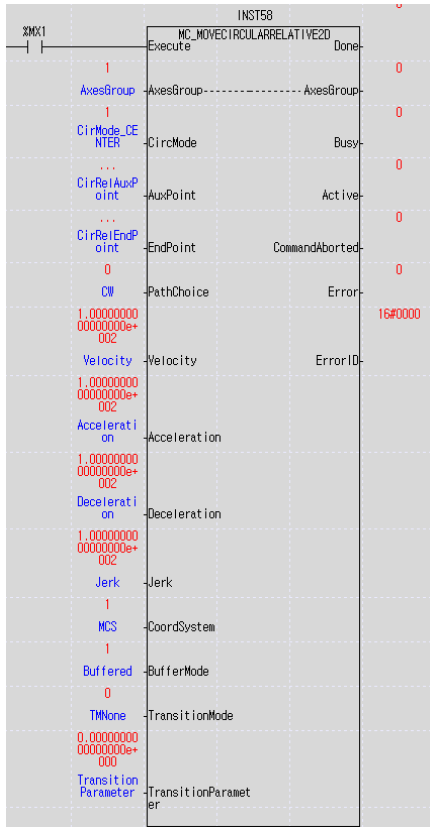


(6) Refer to chapter 8.4.7 circular interpolation control in motion control module's manual for more details.

(7) Example program

This example is to set the center point specification when the current command position is 1000, 1000 (set the relative position from the center point to set from the current position), and move clock-wise to perform circular interpolation to the target position (set the relative position to the target position from the current position: 0, 0).

(a) Function block setting

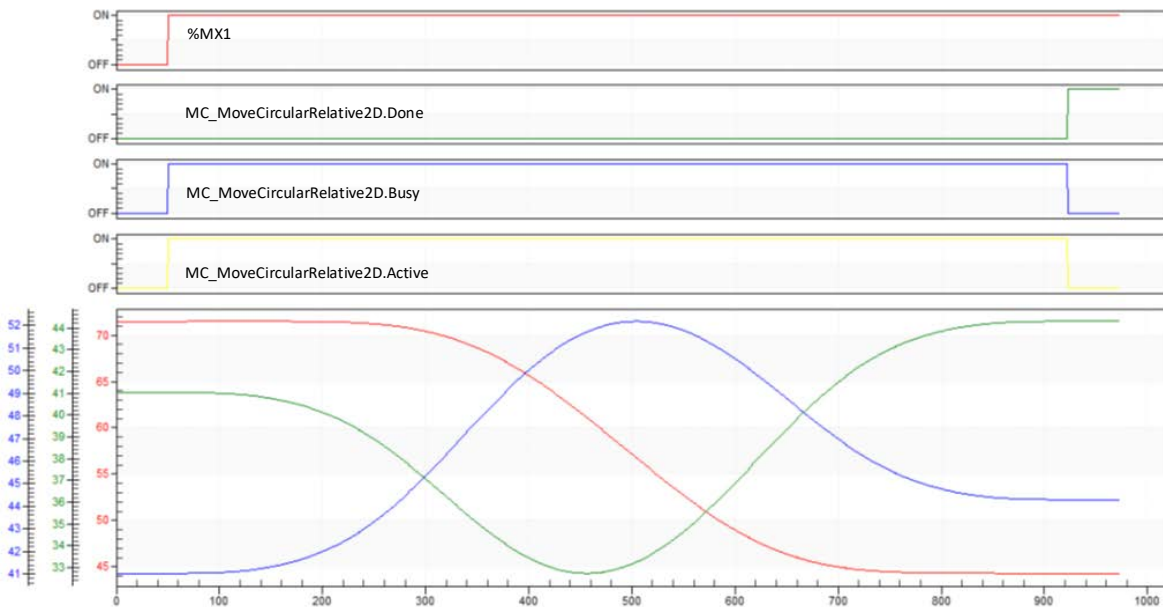


1	_AX01_CPOS	7.1485269050584748e+001	LREAL
2	_AX02_CPOS	4.1026455810822632e+001	LREAL
3	_AX03_CPOS	4.1026455810822632e+001	LREAL
4	CirRelAuxPoint	ARRAY[0..2] OF LREAL	
5	CirRelAuxPoint[0]	0.000000000000000e+000	LREAL
6	CirRelAuxPoint[1]	-7.500000000000000e+001	LREAL
7	CirRelAuxPoint[2]	0.000000000000000e+000	LREAL
8	CirRelEndPoint	ARRAY[0..2] OF LREAL	
9	CirRelEndPoint[0]	0.000000000000000e+000	LREAL
10	CirRelEndPoint[1]	-1.500000000000000e+002	LREAL
11	CirRelEndPoint[2]	0.000000000000000e+000	LREAL

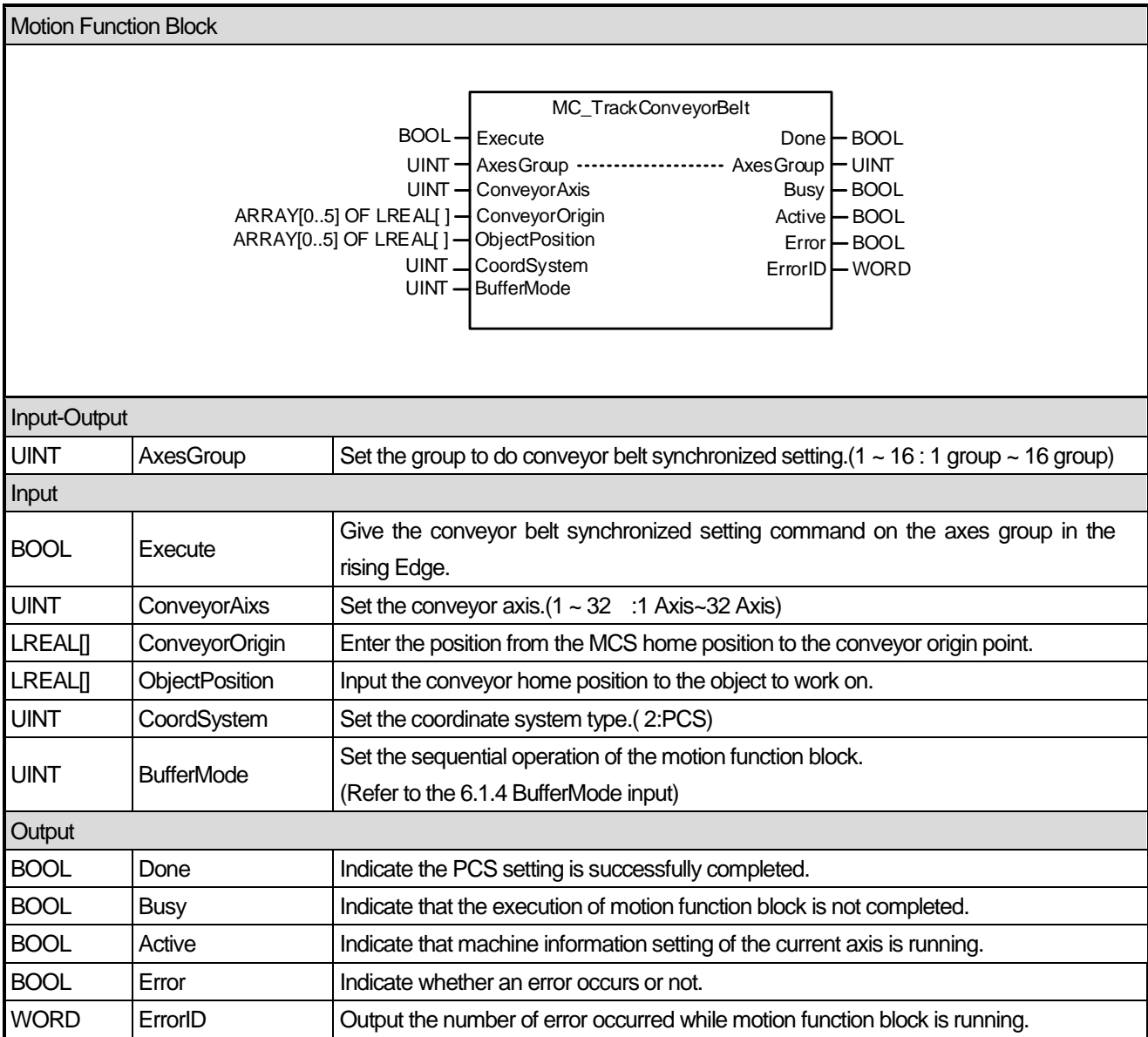
Center point

End point

(b) Timing diagram



6.7.10 Synchronization setting of the conveyor belt (MC\_TrackConveyorBelt)



- (1) This motion function block sets conveyor belt synchronized operation for the axes group designated by AxesGroup input.
- (2) This motion function block is not directly involved in operation. When this function block is executed, the coordinate system operation using the PCS coordinate system is synchronized to the designated conveyor belt axis.
- (3) ConveyorAxis can be set to between 1 and 32. An axis belonging to the axes group set as AxesGroup cannot be designated.
- (4) The operation parameter of the axis designated as ConveyorAxis must be in mm/inch.
- (5) Infinite running repeat must be set for the operation parameter of the axis designated as ConveyorAxis
- (6) Synchronized conveyor operation is terminated by performing coordinate system operation using the PCS coordinate system or performing PCS setting with MC\_SetCartesianTransform function block.
- (7) Refer to chapter 8.4.8 synchronized conveyor operation in motion control module's manual for more details

6.7.11 Synchronization setting of the rotary table(MC\_TrackRotaryTable)

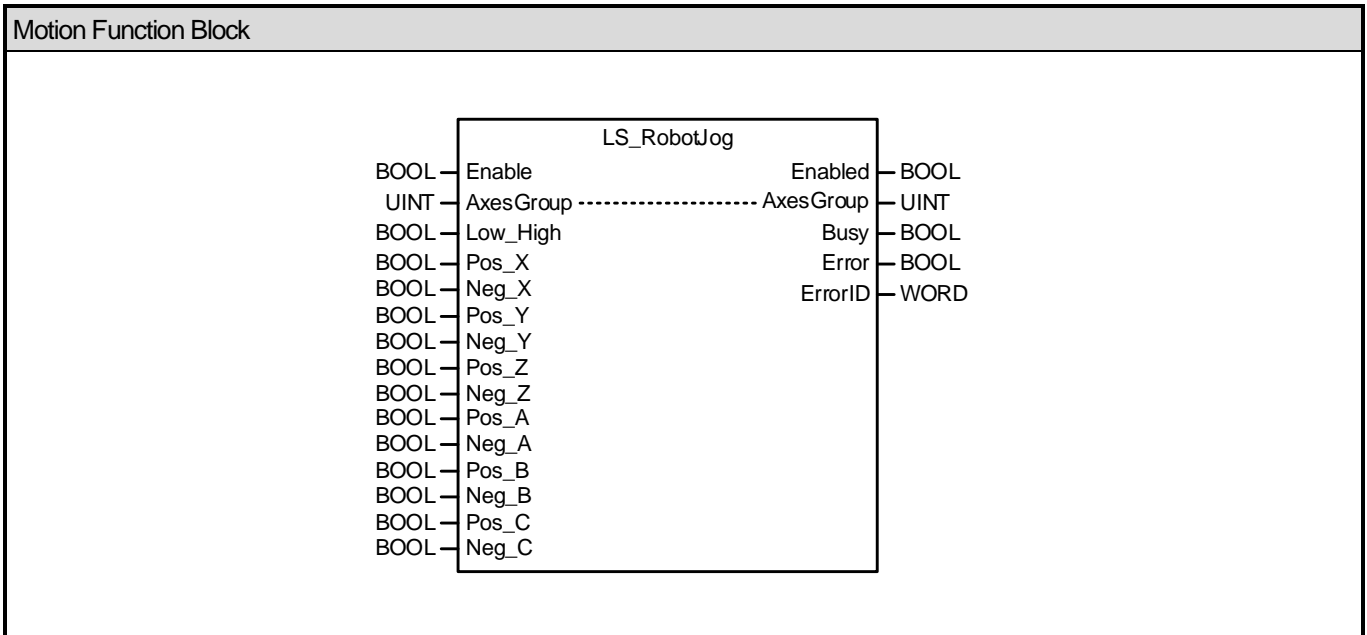
Motion Function Block		
<p style="text-align: center;">MC_TrackRotaryTable</p> <p>           Inputs: BOOL Execute, UINT AxesGroup, UINT RotaryAxis, ARRAY[0..5] OF LREAL[] RotaryOrigin, ARRAY[0..5] OF LREAL[] ObjectPosition, UINT CoordSystem, UINT BufferMode.            Outputs: BOOL Done, UINT AxesGroup, BOOL Busy, BOOL Active, BOOL Error, WORD ErrorID.         </p>		
Input-Output		
UINT	AxesGroup	Set the group to do rotary table synchronized setting.(1 ~ 16: Group 1 ~ Group 16)
Input		
BOOL	Execute	Give the rotary table synchronized setting command on the axes group in the rising Edge.
UINT	RotaryAixs	Set the rotary table axis.(1 ~ 36 : Axis 1~Axis 36)
LREAL[]	RotaryOrigin	Enter the position from the MCS home position to the rotary table origin point.
LREAL[]	ObjectPosition	Input the rotary table home position to the object to work on.
UINT	CoordSystem	Set the coordinate system type.( 2:PCS)
UINT	BufferMode	Specify the sequential operation setting of motion function block. (Refer to 6.1.4.BufferMode)
Output		
BOOL	Done	Indicates that the rotary table synchronization setting has been successfully completed.
BOOL	Busy	Indicate that the execution of motion function block is not completed.
BOOL	Active	Indicate that machine information setting of the current axis is running.
BOOL	Error	Indicate whether an error occurs or not.
WORD	ErrorID	Output the number of error occurred while motion function block is running.

- (1) This motion function block is a function block that sets rotary table synchronous operation to the axis group designated in the AxesGroup input.
- (2) This motion function block does not perform direct operation, and when the function block is executed, the coordinate system operation using the PCS coordinate system is executed in synchronization with the set rotary table axis.
- (3) RotaryAxis can be set from axis 1 to axis 36 and cannot be set as an axis belonging to the axis group set by AxesGroup.
- (4) The operation parameter of the axis set by RotaryAxis must be set to degree.
- (5) Infinite running repeat must be set for the operation parameter of the axis set by RotaryAxis.
- (6) The rotary table synchronous operation is canceled by performing coordinate system operation using MCS coordinate system or by performing PCS setting using MC\_SetCartesianTransform function block.

- (7) For more information, refer to Chapter 8.4.9 Rotary Table Synchronous Operation.
- (8) The version information that can use this motion function block is as follows.

<b>Content</b> <b>Module</b>	<b>Module O/S</b>	<b>XG-PM</b>
<b>XGF-M32E</b>	V1.30	V3.1

6.7.12 JOG operation of the coordinate system(LS\_RobotJog)



Input-Output		
UINT	AxesGroup	Set the axis group to make the command.(1 ~ 16 : Group 1 ~ Group 16)
Input		
BOOL	Enable	While the input is ON, the JOG operation command is sent to the relevant axis group.
BOOL	Low_High	Set the JOG speed in JOG operation. (0: JOG low-speed operation, 1: JOG high-speed operation)
BOOL	Pos_X	Set the linear operation direction at JOG operation.(X-axis + direction)
BOOL	Neg_X	Set the linear operation direction at JOG operation.(X-axis -direction)
BOOL	Pos_Y	Set the linear operation direction at JOG operation.(Y-axis + direction)
BOOL	Neg_Y	Set the linear operation direction at JOG operation.(Y-axis -direction)
BOOL	Pos_Z	Set the linear operation direction at JOG operation.(Z-axis + direction)
BOOL	Neg_Z	Set the linear operation direction at JOG operation.(Z-axis -direction)
BOOL	Pos_A	Set the rotary operation direction at JOG operation. (X-axis counter-clockwise rotation)
BOOL	Neg_A	Set the rotary operation direction at JOG operation. (X-axis clockwise rotation)
BOOL	Pos_B	Set the rotary operation direction at JOG operation. (Y-axis counter-clockwise rotation)
BOOL	Neg_B	Set the rotary operation direction at JOG operation. (Y-axis clockwise rotation)
BOOL	Pos_C	Set the rotary operation direction at JOG operation. (Z-axis counter-clockwise rotation)
BOOL	Neg_C	Set the rotary operation direction at JOG operation. (Z-axis clockwise rotation)

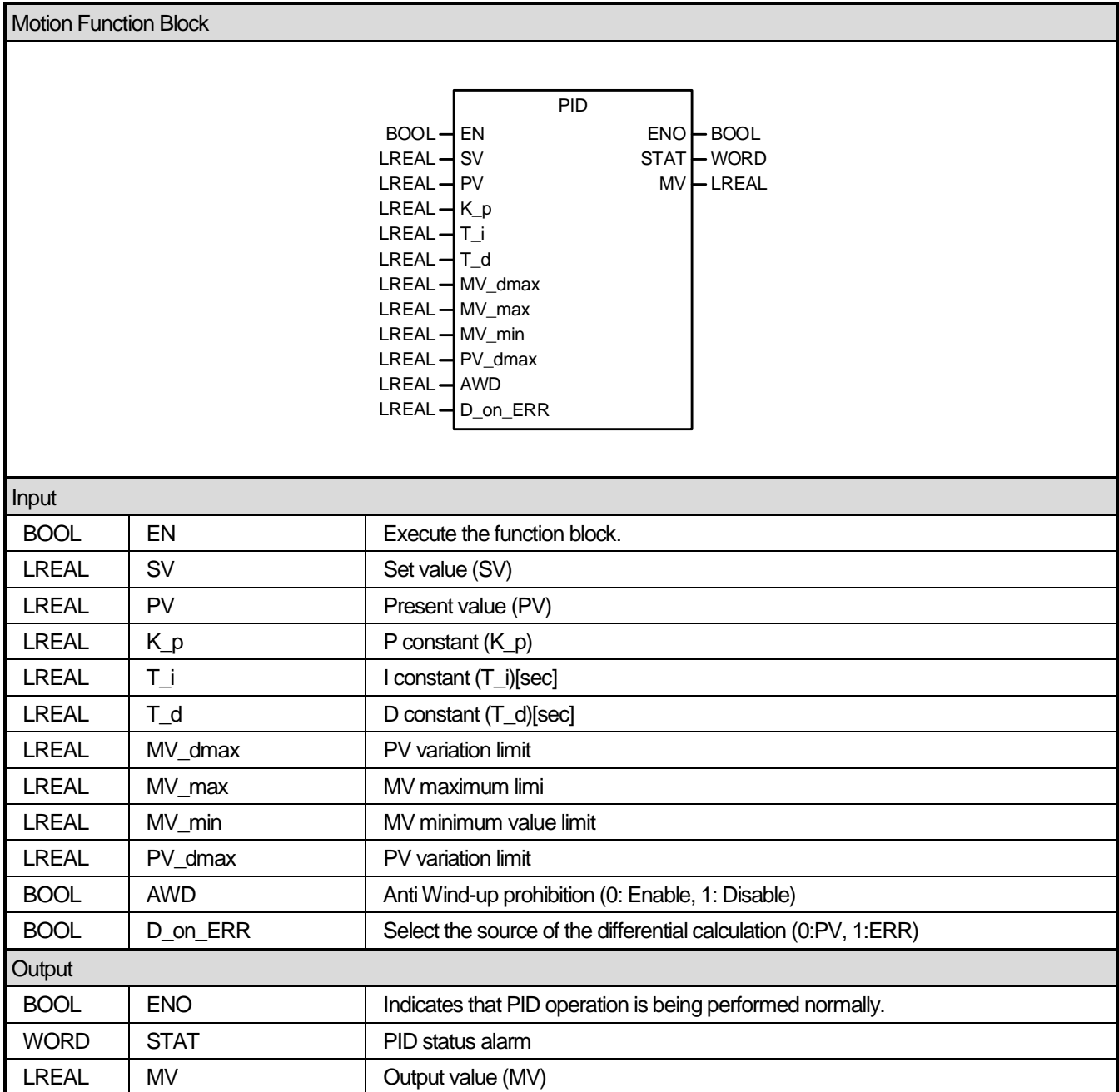
- (1) This motion function block executes the JOG operation of the coordinate system for the corresponding axis group.
- (2) The JOG operation is a manual operation function for testing. It is used for checking system operations, wiring status, and position address for teaching. It can be respectively applied to both high speed and low speed.
- (3) If you change the value set in Low / High when the Enable input is On (JOG operation status), the speed will change without stopping JOG operation.
- (4) If both the forward (Pox\_) / reverse (Neg\_) inputs are set for the same axis, the axis will stop.
- (5) The version information that can use this motion function block is as follows.

<b>Content</b> <b>Module</b>	<b>Module O/S</b>	<b>XG-PM</b>
<b>XGF-M32E</b>	V1.30	V3.1



## 6.8 Other function block

### 6.8.1 PID operation (PID)



- (1) This function block is a function block that receives target value (SV) and current value (PV) of the control object, performs PID operation, and outputs MV.
- (2) The target value SV input is the current state of the control target. This state is expressed as a number, and it must be converted into PV based on the gain of the system and input. For example, in a system where PV is sensed as 5000

when the temperature is 50°C, set SV to 5000 when controlling the temperature as 50°C.

- (3) Current value PV input is an indicator that indicates the current state of the control target. In general, the input from the sensor is saved in the device of the CPU through an input device such as an A/D conversion module, and this value must be input as a PV input.
- (4) K<sub>p</sub> input sets the proportional constant of the current PID operator. K<sub>p</sub> is multiplied by all of the terms P, I, and D (proportional, integral, and derivative) among PID control effects, so when K<sub>p</sub> increases, the proportional and differential effects increase and the integral effect decreases. In particular, PID control is not performed when K<sub>p</sub> input is 0.
- (5) T<sub>i</sub> input sets the integral time constant of the loop. Since T<sub>i</sub> divides the I (integral) term among PID control effects, the integration effect decreases as T<sub>i</sub> increases. When T<sub>i</sub> input is 0, I control is not performed.
- (6) T<sub>d</sub> input sets the derivative time constant of the loop. Since T<sub>d</sub> is multiplied by the term D (differential) among PID control effects, the differential effect increases as T<sub>d</sub> increases. If T<sub>d</sub> input is 0, D control is not performed.
- (7) PV<sub>dmax</sub> input limits the amount of PV change in the loop. In actual control, PV does not always reflect the exact state of the system. Unwanted signals such as sensor malfunction, noise, and disturbance may be mixed and reflected in the PV. In this way, there are cases where PV changes rapidly, causing a large change in PID output. In order to prevent such a phenomenon, if there is a change in PV more than the value set in `_PID[B]_[L]dPV_max`, it first prevents it and prevents the change beyond the set value.

On the other hand, if PV<sub>dmax</sub> is set too small, the system change may be reflected late and the convergence time may take a long time. In particular, when the setting value is set to 0, the PV change amount limiting function does not operate.

- (8) The MV<sub>dmax</sub> input limits the amount of MV change in the loop. If the output of the control system changes rapidly, the system may become unstable, or a large load may be applied to the actuator, resulting in a malfunction or unstable operation. This is an item that limits the amount of change in the output of the controller to prevent this. In particular, if the setting value is set to 0, this function does not work.
- (9) MV<sub>max</sub> input limits the maximum MV value of the loop. By limiting the maximum value of the controller output delivered to the output device, overload is prevented and system errors are blocked in advance. It also prevents the transfer of unwanted values due to overflow.
- (10) M MV<sub>min</sub> input limits the MV minimum value of the loop. Blocks system errors in advance by limiting the minimum value of the controller output delivered to the output device. It also prevents the transfer of unwanted values due to overflow.
- (11) D<sub>on\_ERR</sub> input sets the D operation source of the PID loop to ERR. D operation is calculated by ERR or PV. If D operation is performed using ERR, the D response changes rapidly as soon as SV is changed by the user, so excessive input may be momentarily applied to the actuator side. To prevent this, the method of using PV in D operation is used, and the default value is also set to perform D operation using PV. If ERR is used without such an algorithm, this bit is turned on. When the corresponding bit is Off, PID performs D operation with PV value, and when it is On, it performs D operation with ERR value.
- (12) AWD input is an input that activates or deactivates the Anti Wind-up function. When the corresponding input is turned On, the Anti Wind-up function is deactivated.
- (13) Each bit of STAT output indicates the status or abnormal status of the corresponding PID controller. Each bit is On only when the corresponding operation occurs, and returns to Off when the corresponding operation is released. The lower 8 bits of STAT indicate various abnormal states of the loop, and the upper 8 bits indicate the control state of the

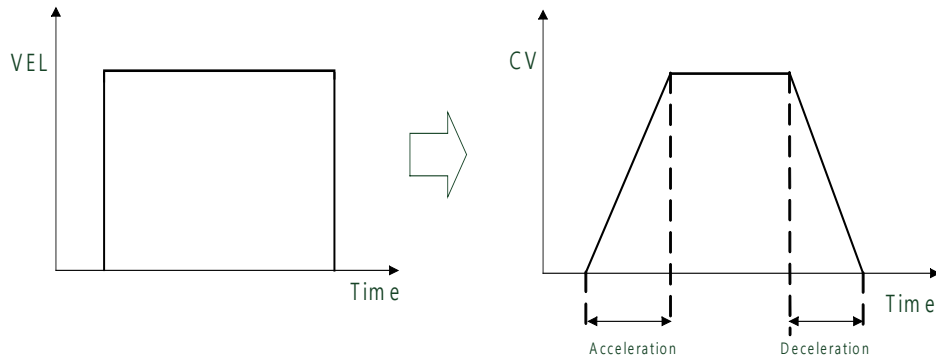
corresponding loop. The allocation of each bit is as follows.

Bit	Status
0	The T <sub>s</sub> setting is too small to indicate that the operation is being skipped.
2	Notifies that the amount of PV change is being limited.
3	Notice that the amount of MV change is being limited.
4	Notifies you that the MV maximum is being limited.
5	Signals that the MV minimum is being limited.
8	Notifies that PID operation is in progress.
15	Notifies that Anti Wind-up is in operation during PID operation.

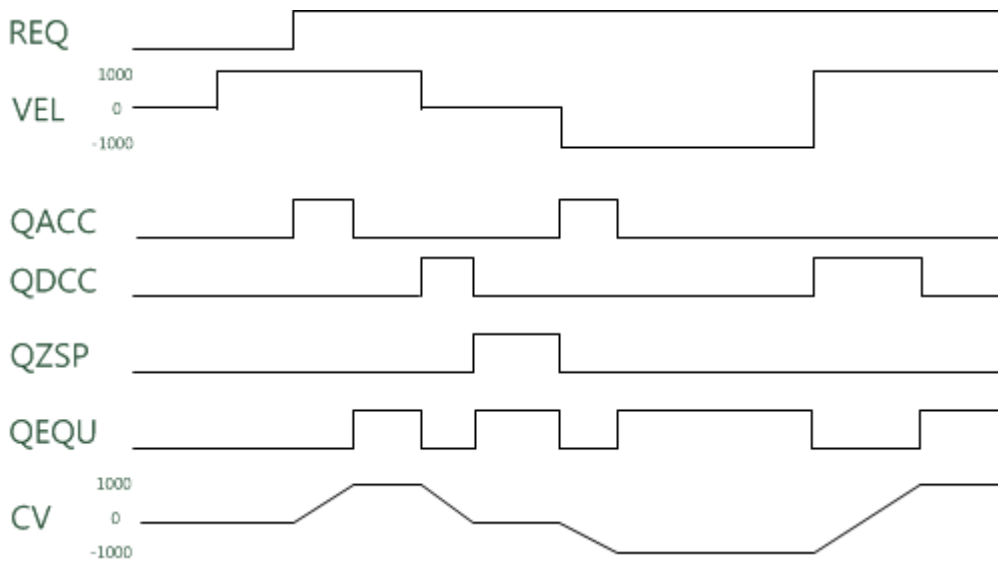
### 6.8.2 Linear Acceleration Command(LINAC)

Motion Function Block																														
<div style="border: 1px solid black; padding: 10px; margin: 0 auto; width: fit-content;"> <p style="text-align: center; margin: 0;">LINAC</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="text-align: right; padding-right: 5px;">BOOL</td> <td style="border-left: 1px solid black; padding-left: 5px;">REQ</td> <td style="border-right: 1px solid black; padding-right: 5px;">DONE</td> <td style="padding-left: 5px;">BOOL</td> </tr> <tr> <td style="text-align: right; padding-right: 5px;">BOOL</td> <td style="border-left: 1px solid black; padding-left: 5px;">QS</td> <td style="border-right: 1px solid black; padding-right: 5px;">QACC</td> <td style="padding-left: 5px;">BOOL</td> </tr> <tr> <td style="text-align: right; padding-right: 5px;">LREAL</td> <td style="border-left: 1px solid black; padding-left: 5px;">VEL</td> <td style="border-right: 1px solid black; padding-right: 5px;">QDCC</td> <td style="padding-left: 5px;">BOOL</td> </tr> <tr> <td style="text-align: right; padding-right: 5px;">LREAL</td> <td style="border-left: 1px solid black; padding-left: 5px;">ACC</td> <td style="border-right: 1px solid black; padding-right: 5px;">QZSP</td> <td style="padding-left: 5px;">BOOL</td> </tr> <tr> <td style="text-align: right; padding-right: 5px;">LREAL</td> <td style="border-left: 1px solid black; padding-left: 5px;">DCC</td> <td style="border-right: 1px solid black; padding-right: 5px;">QEQU</td> <td style="padding-left: 5px;">BOOL</td> </tr> <tr> <td style="text-align: right; padding-right: 5px;">LREAL</td> <td style="border-left: 1px solid black; padding-left: 5px;">QCC</td> <td style="border-right: 1px solid black; padding-right: 5px;">CV</td> <td style="padding-left: 5px;">LREAL</td> </tr> <tr> <td></td> <td></td> <td style="border-right: 1px solid black; padding-right: 5px;">DVDT</td> <td style="padding-left: 5px;">LREAL</td> </tr> </table> </div>			BOOL	REQ	DONE	BOOL	BOOL	QS	QACC	BOOL	LREAL	VEL	QDCC	BOOL	LREAL	ACC	QZSP	BOOL	LREAL	DCC	QEQU	BOOL	LREAL	QCC	CV	LREAL			DVDT	LREAL
BOOL	REQ	DONE	BOOL																											
BOOL	QS	QACC	BOOL																											
LREAL	VEL	QDCC	BOOL																											
LREAL	ACC	QZSP	BOOL																											
LREAL	DCC	QEQU	BOOL																											
LREAL	QCC	CV	LREAL																											
		DVDT	LREAL																											
Input																														
BOOL	REQ	Execute LINAC commands.																												
BOOL	QS	Enter sudden stop																												
LREAL	VEL	Specify the target speed [u/s]																												
LREAL	ACC	Specify the acceleration [u/s <sup>2</sup> ]																												
LREAL	DCC	Specify the deceleration. [u/s <sup>2</sup> ]																												
LREAL	QCC	Specifies the sudden stop deceleration. [u/s <sup>2</sup> ]																												
Output																														
BOOL	DONE	Indicate that the completion status of function block execution.																												
BOOL	QACC	Indicates whether acceleration is in progress.																												
BOOL	QDCC	Indicates whether or not it is deceleration.																												
BOOL	QZSP	Indicates whether the current speed is continuous.																												
BOOL	QEQU	It indicates whether the target speed and the current speed match.																												
LREAL	CV	Indicate current speed.																												
LREAL	DVDT	Indicate current acceleration/deceleration speed.																												

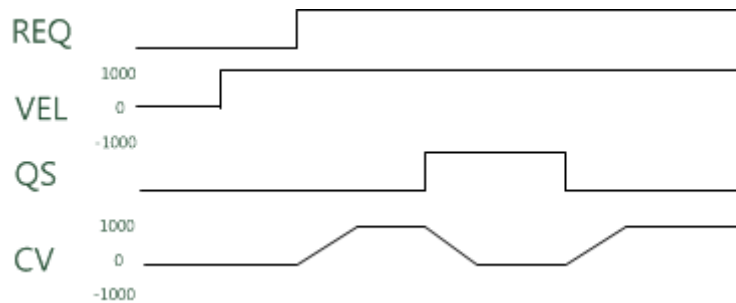
- (1) This function block is a function block that outputs the speed value reached by applying constant acceleration/deceleration up to the input speed.



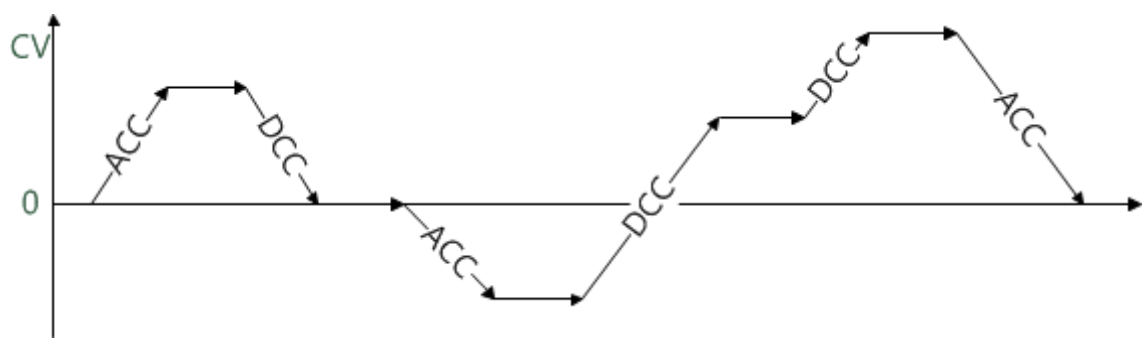
- (2) At the rising edge of REQ input, ACC/DCC/QCC values are used in the function block, and ACC/DCC/QCC values are not changed during operation.
- (3) During operation, QACC/QDCC/QZSP/QEQU output is as follows.



- (4) When the QS value is 1, it decelerates (quick deceleration) with the deceleration set in QCC. When the QS value is changed to 0, deceleration is released and acceleration/deceleration is performed at the input target speed.



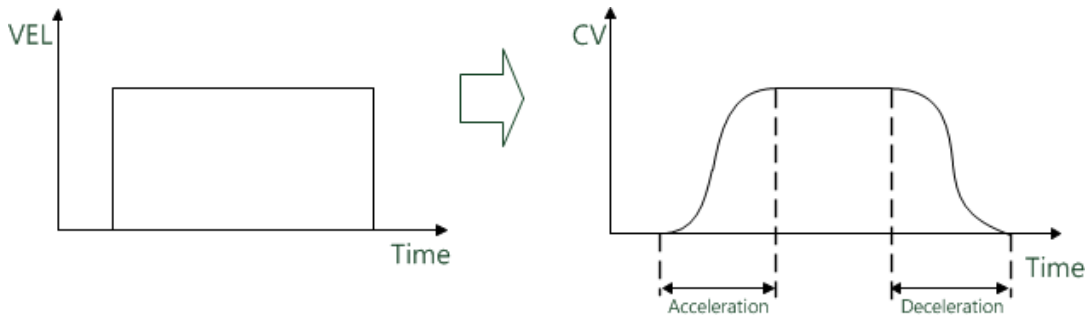
- (5) When the stop speed is 0, it accelerates in the direction of the input target speed and decelerates in the opposite direction. In case of stopping at 0 speed, the direction of acceleration/deceleration is changed.



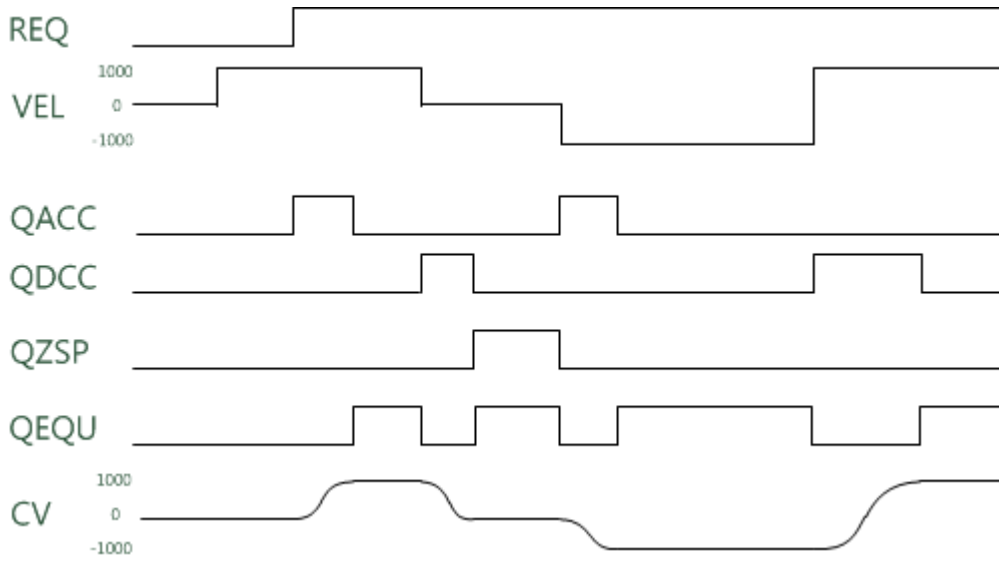
6.8.3 S-Curve Linear Acceleration Command(SLINAC)

Motion Function Block																																		
<table border="1" style="margin: auto; border-collapse: collapse;"> <thead> <tr> <th colspan="4">SLINAC</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">BOOL</td> <td style="text-align: center;">REQ</td> <td style="text-align: center;">DONE</td> <td style="text-align: center;">BOOL</td> </tr> <tr> <td style="text-align: center;">BOOL</td> <td style="text-align: center;">QS</td> <td style="text-align: center;">QACC</td> <td style="text-align: center;">BOOL</td> </tr> <tr> <td style="text-align: center;">LREAL</td> <td style="text-align: center;">VEL</td> <td style="text-align: center;">QDCC</td> <td style="text-align: center;">BOOL</td> </tr> <tr> <td style="text-align: center;">LREAL</td> <td style="text-align: center;">ACC</td> <td style="text-align: center;">QZSP</td> <td style="text-align: center;">BOOL</td> </tr> <tr> <td style="text-align: center;">LREAL</td> <td style="text-align: center;">DCC</td> <td style="text-align: center;">QEQU</td> <td style="text-align: center;">BOOL</td> </tr> <tr> <td style="text-align: center;">LREAL</td> <td style="text-align: center;">QCC</td> <td style="text-align: center;">CV</td> <td style="text-align: center;">LREAL</td> </tr> <tr> <td style="text-align: center;">LREAL</td> <td style="text-align: center;">JERK</td> <td style="text-align: center;">DVDT</td> <td style="text-align: center;">LREAL</td> </tr> </tbody> </table>			SLINAC				BOOL	REQ	DONE	BOOL	BOOL	QS	QACC	BOOL	LREAL	VEL	QDCC	BOOL	LREAL	ACC	QZSP	BOOL	LREAL	DCC	QEQU	BOOL	LREAL	QCC	CV	LREAL	LREAL	JERK	DVDT	LREAL
SLINAC																																		
BOOL	REQ	DONE	BOOL																															
BOOL	QS	QACC	BOOL																															
LREAL	VEL	QDCC	BOOL																															
LREAL	ACC	QZSP	BOOL																															
LREAL	DCC	QEQU	BOOL																															
LREAL	QCC	CV	LREAL																															
LREAL	JERK	DVDT	LREAL																															
Input																																		
BOOL	REQ	Execute SLINAC commands.																																
BOOL	QS	Enter sudden stop																																
LREAL	VEL	Specify the target speed [u/s]																																
LREAL	ACC	Specify the acceleration [u/s <sup>2</sup> ]																																
LREAL	DCC	Specify the deceleration. [u/s <sup>2</sup> ]																																
LREAL	QCC	Specifies the sudden stop deceleration. [u/s <sup>2</sup> ]																																
LREAL	JERK	Specify the change rate of acceleration/deceleration. [u/s <sup>3</sup> ]																																
Output																																		
BOOL	DONE	Indicate that the completion status of function block execution.																																
BOOL	QACC	Indicates whether acceleration is in progress.																																
BOOL	QDCC	Indicates whether or not it is deceleration.																																
BOOL	QZSP	Indicates whether the current speed is continuous.																																
BOOL	QEQU	It indicates whether the target speed and the current speed match.																																
LREAL	CV	Indicate current speed.																																
LREAL	DVDT	Indicate current acceleration/deceleration speed.																																

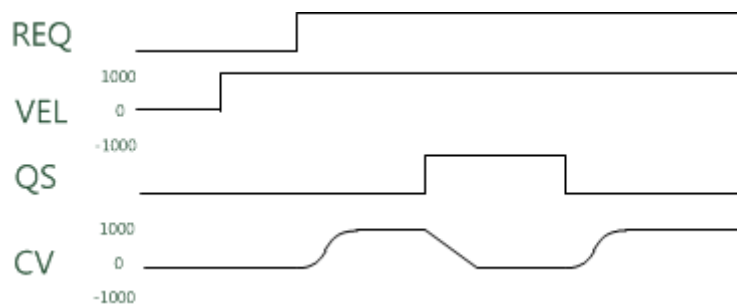
- (1) This function block is a function block that outputs the speed value reached by applying acceleration/deceleration applied JERK up to the input speed.



- (2) At the rising edge of REQ input, ACC/DCC/QCC values are used in the function block, and ACC/DCC/QCC values are not changed during operation.
- (3) During operation, the QACC / QDCC / QZSP / QEQU output is variable as follows.



- (4) If the target speed is changed before reaching the target speed, overshoot or undershoot may occur.
- (5) When the QS value is 1, it decelerates (quick deceleration) with the deceleration set in QCC. When the QS value is changed to 0, deceleration is released and acceleration/deceleration is performed at the input target speed.





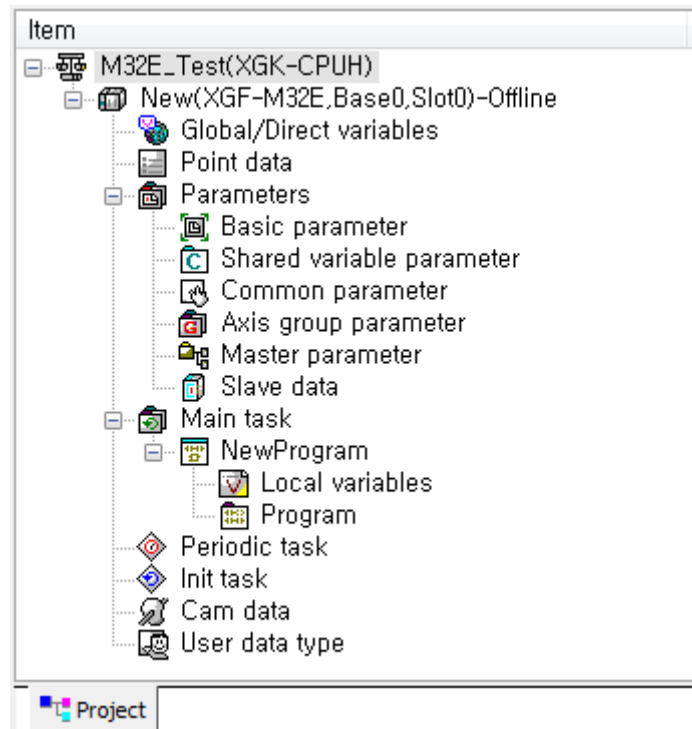
## Chapter 7 Program

### 7.1 Structure of the Program

The program of the motion control module is divided into main task program, periodic task program and initialization task program. The features of each program in execution are as follows.

- (1) Initialization task program: It is executed only once when motion control module enters the RUN.
- (2) Main task program: It is executed in every main task cycle set in the motion control module.  
The main task cycle can be set in "main task period" of the basic parameters, and a period can be set through section among 1ms, 2ms, and 4ms.  
In case the execution time of main task program exceeds the set main task period, error occurs.
- (3) Periodic task program: It is executed in every periodic task period set in the motion control module.  
The cycle of the periodic task can be set "periodic task period" of the basic parameters, and a multiple of the set main task period is to be set.  
The periodic task program is executed the remaining time after executing main task program by main task period in motion control module, and it is executed repeatedly in every periodic task period.

For information about the execution of main task program and periodic task program, refer to "4.3 motion control task".



## 7.2 Status Information Reading

In the program of motion control modules, each axis, status of axis group and operating status of the motion control module can be checked with the flag.

Most of the program examples of chapter 7 is created using flags that indicate axis and status of axis group.

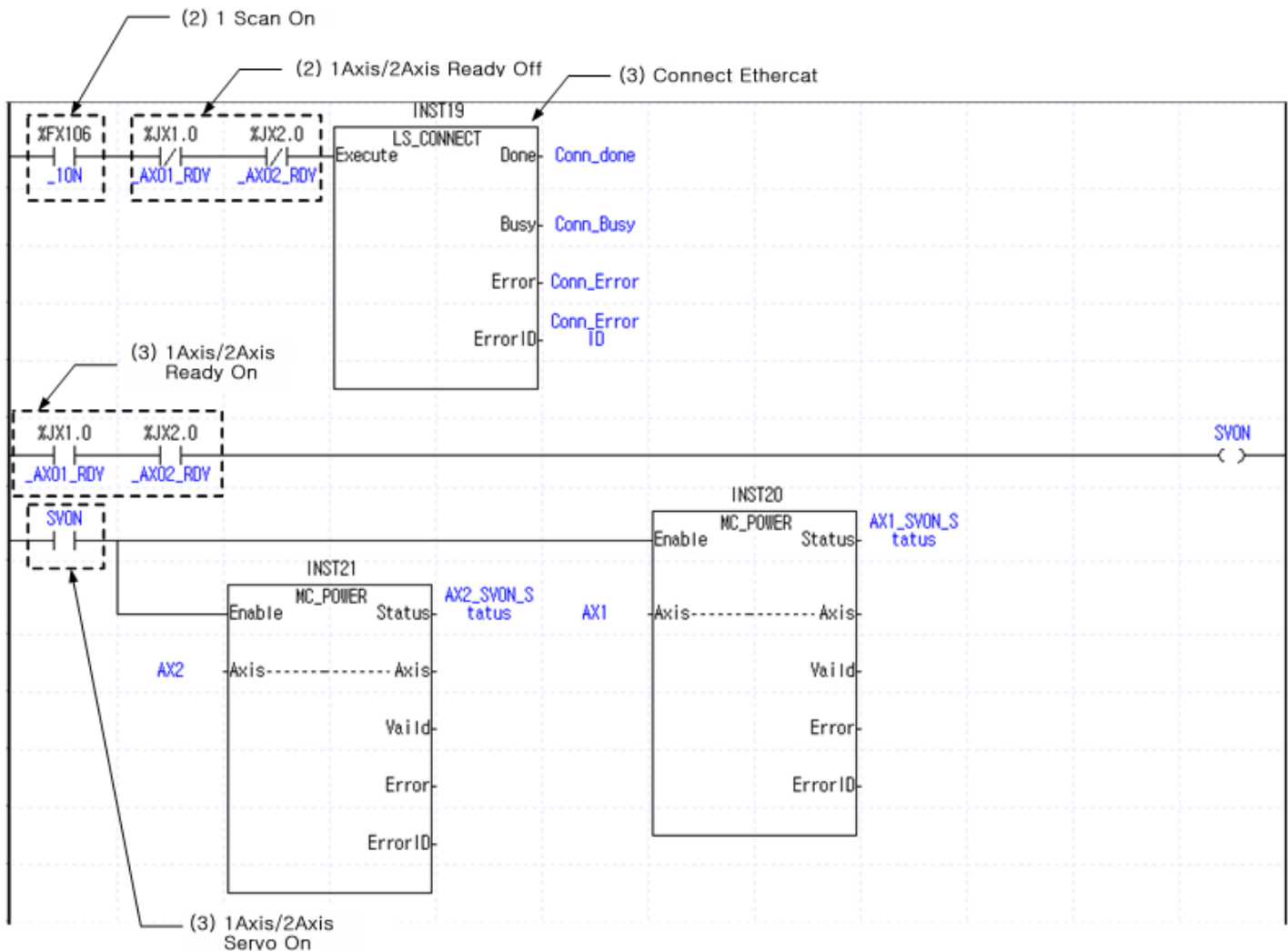
Flags that indicate the status information can be used directly in the program, and can be delivered to PLC CPU by being assigned to a shared device of the motion control module.

For more information on the types and functions of flags, refer to "5.1.1 flag".

## 7.3 Discrete Motion Program

### 7.3.1 Preparation for operation

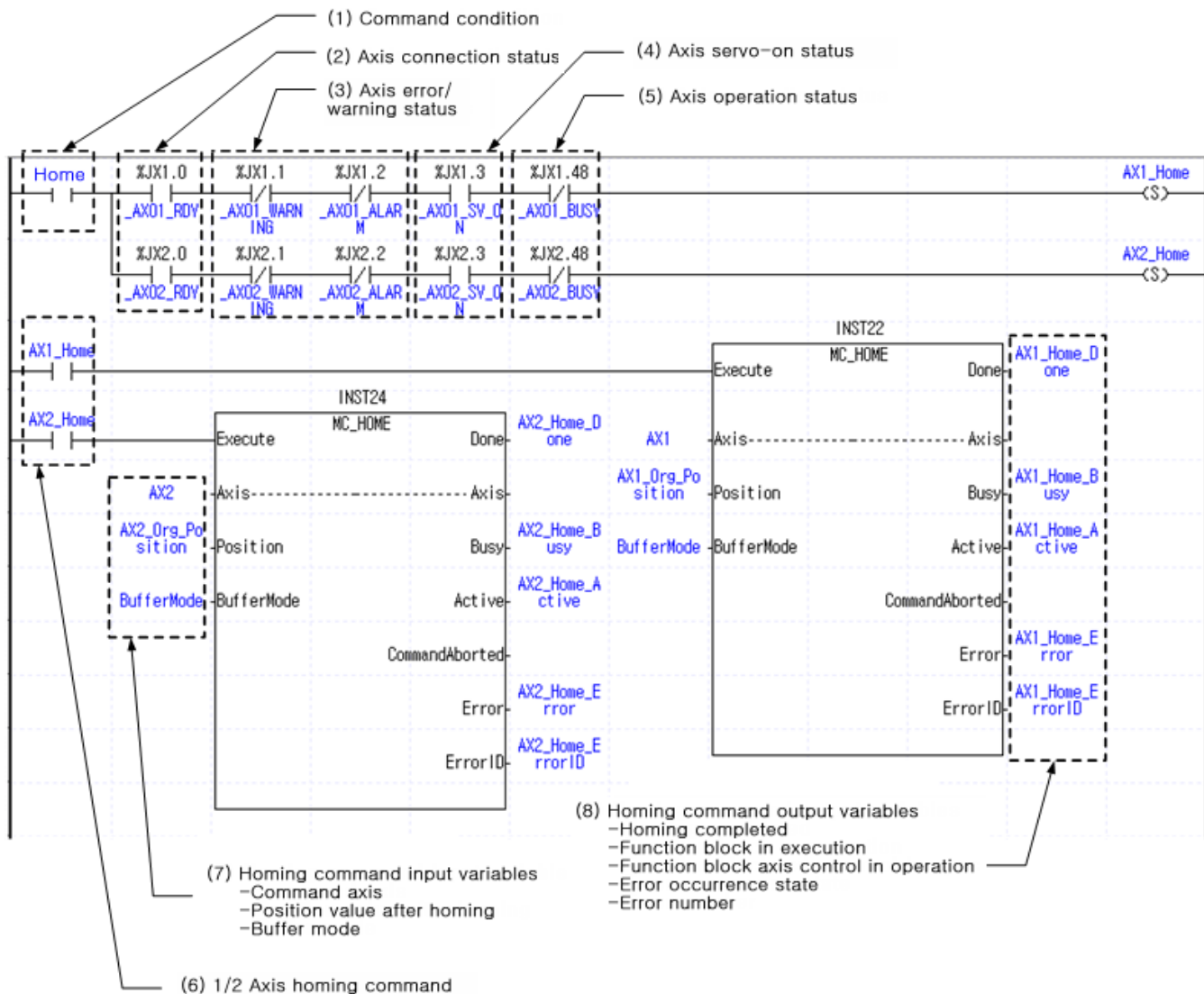
These are example programs that make access to servo drive connected with Ethernet cable and get the connected servo drive to be On to operate EtherCAT servo drive.



- (1) The above examples assume situation in which two axes of 1-axis and 2-axis are connected to the motion control module.
- (2) In case 1-axis and 2-axis are not connected when the motion control module enters the RUN, start the connection of EtherCAT communication between motion control module and servo drive using motion function block for communication connection (LS\_CONNECT).
- (3) If the connection of EtherCAT communication between motion control modules and servo drives is normally performed, servo On/Off (MC\_Power) command is issued to each axis by getting "SVON" contact to be On.
- (4) In case there is no error in servo drive of the connected 1-axis and 2-axis, the servo is normally On, and it is ready to operate 1-axis and 2-axis.

### 7.3.2 Homing operation

Homing is carried out to set the origin of the machine after the power is applied. Since homing is performed in the servo drive, homing methods may vary depending on servo drive manufacturers. In motion control module, the completion of homing command and error situation is monitored, and the position of the origin after homing is applied to control.



(1) Command condition

: It is a condition to make the axis perform homing operation.

(2) Axis connection state flag

: In case the axis to be operated is connected to motion control module, and EtherCAT communication with motion control module is normally performed, it is On.

(3) Axis error/Warning status flag

: If there are errors and warnings in the axis, it is On.

(4) Axis servo-on status flag

: If the axis is in servo-on state, it is On, and servo-off state, it becomes Off.

(5) Axis operation status flag

: If the axis is in operation, it is On.

(6) 1/2 axis homing command

: In example programs, homing (MC\_Home) motion function block is performed under the following conditions.

- Homing condition is On
- The axis is normally connected
- There should be no errors and warnings
- Servo-on state
- Not in operation

Conditions to perform motion function block may vary depending on systems.

(7) Homing command input variables

: These are input variables to perform homing (MC\_Home) motion function block.

- Command-axis: It sets the axis in which motion function block is performed.
- Position value after homing: It sets the position value when homing is completed.
- Buffer mode: It sets the point of time when motion function block is executed. That is, it sets whether to execute immediately or execute after the completion of commands which are currently being performed. For more details on Function Block execution mode, refer to "6.1.4 Buffer Mode input".

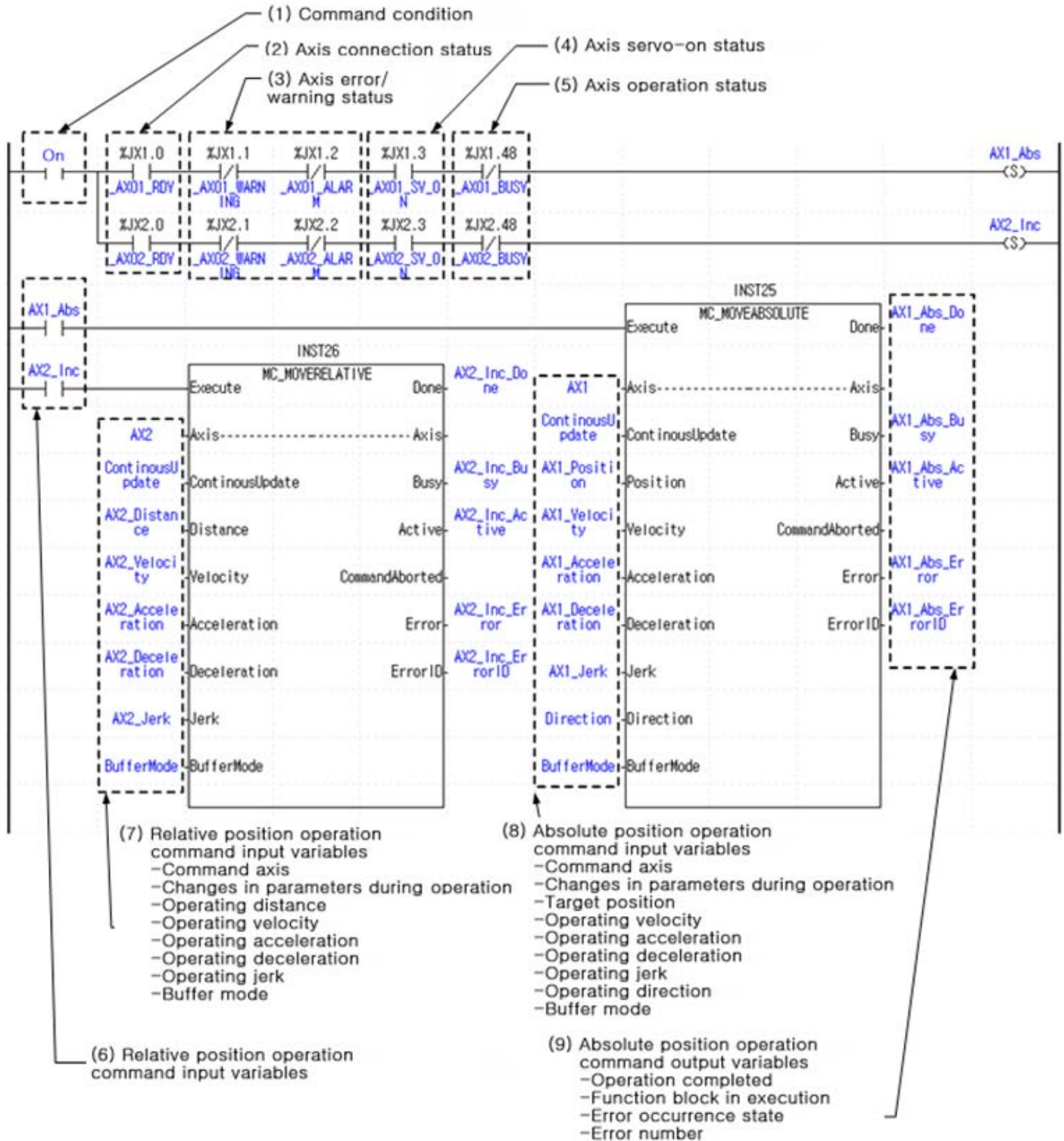
(8) Homing command output variable

: It is a variable to store output value generated when homing (MC\_Home) motion function block is executed.

- Homing completed: If homing operation is completed, it is On.
- Function Block in execution: If motion function block is being performed, it is On, and homing completion is On, it is Off.
- Function Block axis control in operation: In case motion function block controls the axis, it is On.
- Error occurrence state: In case error occurs while motion function block is being executed, it is On.
- Error number: In case error occurs, the number that corresponds to error is generated.
- For more details on the output of motion function block, refer to "Edge operation motion function block" of "6.1.3 basic I/O variable".

### 7.3.3 Absolute Position/Relative Position Operation

It is a program for absolute position and relative position operation using motion control module. The absolute position is based on the origin and, and relative position the current position.



- (1) Command condition  
: It is a condition to make the axis perform position control operation.
- (2) Axis connection state flag  
: If the axis to be operated is connected to motion control module, and EtherCAT communication with motion control module is normally performed, it is On.
- (3) Axis error/Warning status flag  
: If there are errors and warnings in the axis, it is On.
- (4) Axis servo-on status flag  
: If the axis is in servo-on state, it is On, and servo-off state, it becomes Off.
- (5) Axis operation status flag  
: If the axis is in operation, it is On.
- (6) 1-axis absolute position operation / 2-axis relative position operation commands  
: In example programs, absolute position operation (MC\_MoveAbsolute) is performed in 1-axis, and relative position operation (MC\_MoveRelative) in 2-axis under the following conditions.
  - The axis operation condition is On.
  - The axis is normally connected.
  - There should be no errors and warnings.
  - Servo-on state
  - Not in operation.

Conditions to perform motion function block may vary depending on systems.

- (7) Relative position operation command input variables  
: These are input variables to perform relative position operation (MC\_MoveRelative) motion function block.
  - Command-axis: It sets the axis in which motion function block is performed.
  - Changes in parameters during operation: It sets whether to apply to the operation by changing the input variables of motion function block.  
For more information, refer to “6.1.5 Changes in parameters during execution of motion function block”.
  - Operating distance: It sets distance to perform relative coordinate operation. Based on the current position, + value means forward direction, and – value means reverse direction value.
  - Operating velocity: It sets velocity to perform relative coordinate operation.
  - Operating acceleration, operating deceleration, operating jerk: It sets values to be applied in relative coordinate operation respectively.
  - Buffer mode: It sets the point of time when motion function block is executed. That is, it sets whether to execute immediately or execute after the completion of commands which are currently being performed. For more details, refer to “6.1.4 Buffer Mode input”.
- (8) Absolute position operation command input variables  
: These are input variables to perform absolute position operation (MC\_MoveAbsolute) motion function block.
  - Command-axis: It sets the axis in which motion function block is performed.
  - Changes in parameters during operation: It sets whether to apply to the operation by changing the input variables of motion function block.  
For more information, “6.1.5 Changes in parameters during execution of motion function block”.
  - Target position: It sets the position that moves to absolute coordinate operation.
  - Operating velocity: It sets the velocity when absolute position operation is performed to the target position.
  - Operating acceleration, operating deceleration, operating jerk: It sets values to be applied in absolute coordinate operation respectively.
  - Operating direction: It sets direction when moving to the target position. In case of 1, movement to the target position is made through forward direction operation, in case of 2, operation is made in the direction that can reach the target area in the shortest distance based on the current position, in case of 3, reverse direction, and in case of 4, movement to the target position is made through operation in the direction of the current operation.

- Buffer mode: It sets the point of time when motion function block is executed. That is, it sets whether to execute immediately or execute after the completion of commands which are currently being performed. For more details, refer to “6.1.4 Buffer Mode input”.

(9) Absolute position operation command output variable

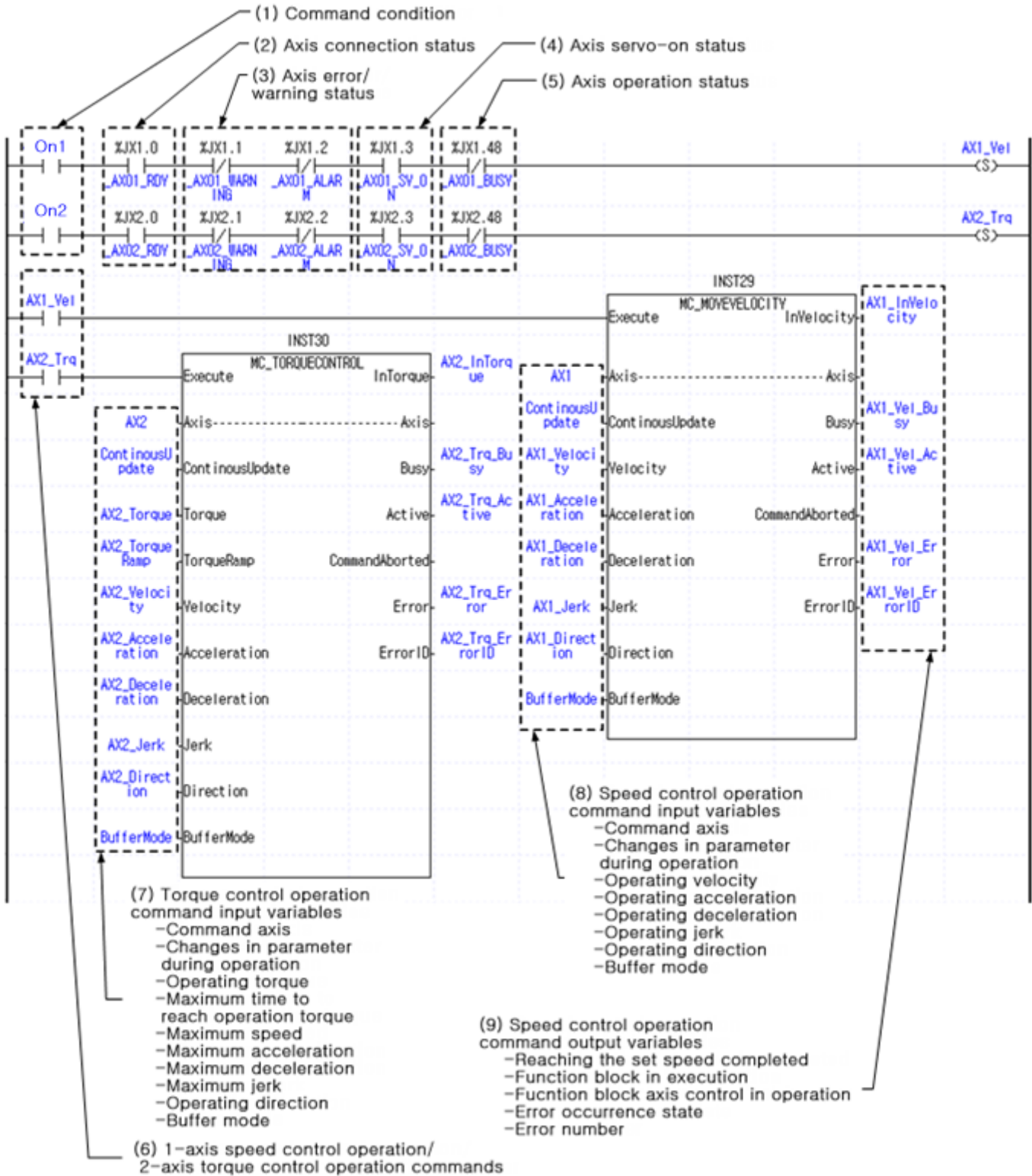
: It is a variable to store output values generated when absolute position operation (MC\_MoveAbsolute) motion function block is executed.

- Operation completed: When absolute coordinate operation is completed, it is On.
- Function Block in execution: When motion function block is executed, it is On, and if operation completed is On, it is Off.
- Function Block axis control in operation: In case motion function block is controlling the axis, it is On.
- Error occurrence state: In case error occurs when motion function block is executed, it is On.
- Error number: In case error occurs, the number that corresponds to error is generated.
- For more details on the output of motion function, refer to “Edge operation motion function block” of “6.1.3 basic input and output variables”.



### 7.3.4 Speed/Torque Control Operation

These are example programs for speed control and torque control operation using motion control modules. In case of the torque control, torque control of servo drive is used, and in motion control module, command for executing torque control is issued, and execution completion and status is monitored.



- (1) Command condition  
: It is a condition to make the axis perform speed control/torque control operations.
- (2) Axis connection state flag  
: In case the axis to be operated is connected to motion control module, and EtherCAT communication with motion control module is normally performed, it is On.
- (3) Axis error/Warning status flag  
: If there are errors and warnings in the axis, it is On.
- (4) Axis servo-on status flag  
: If the axis is in servo-on state, it is On, and servo-off state, it becomes Off.
- (5) Axis operation status flag  
: If the axis is in operation, it is On.
- (6) 1-axis speed control operation/ 2-axis torque control operation commands  
: In example programs, specified velocity operation (MC\_MoveVelocity) motion function block is executed in 1-axis, and torque control operation (MC\_TorqueControl) motion function block is executed in 2-axis under the following conditions.
- The axis operation condition is On.
  - The axis is normally connected.
  - There should be no errors and warnings.
  - Servo-on state
  - Not in operation
- Conditions to perform motion function block may vary depending on systems.
- (7) Torque control operation command input variables  
: These are input variables to execute torque control operation (MC\_TorqueControl) motion function block.
- Command axis: It sets the axis in which motion function block is executed.
  - Changes in parameters during operation: It sets whether to apply to the operation by changing input variable values of the motion function block. For details, refer to “6.1.5 Changes in parameters during the execution of motion function block”.
  - Operation torque: It sets torque values in torque control operation.
  - The maximum time to reach operation torque: It sets the maximum slope from the current torque until changed to the set torque. Its unit is [Unit/s].
  - Maximum speed, maximum acceleration, maximum deceleration, maximum jerk: It sets values to be applied to respective torque control operation.
  - Operating direction: It sets direction to be operated with torque control. In case of 1, it operates in forward direction, in case of 3, in reverse direction, and in case of 4, it operates in current operation direction.
  - Buffer mode: It sets the point of time when motion function block is executed. That is, it sets whether to execute immediately or execute after the completion of commands which are currently being performed. For details, refer to “6.1.4 Buffer Mode input”.
- (8) Speed control operation command input variables  
: These are input variables to execute specified velocity operation (MC\_MoveVelocity) motion function block.
- Command axis: It sets the axis in which motion function block is executed.
  - Changes in parameters during operation: It sets whether to apply to the operation by changing input variable values of the motion function block. For details, refer to “6.1.5 Changes in parameters during execution of motion function block”.
  - Operating velocity: It sets velocity in speed control operation.
  - Operating acceleration, operating deceleration, operating jerk: It sets values to be applied in speed control operation respectively.
  - Operating direction: It sets directions in speed control operation. In case of 1, it operates in forward direction, in case of 3, in reverse direction, and in case of 4, it operates in direction of the current operation.
  - Buffer mode: It sets the point of time when motion function block is executed. That is, it sets whether to execute immediately or execute after the completion of commands which are currently being performed. For details, refer to “6.1.4 Buffer Mode input”.

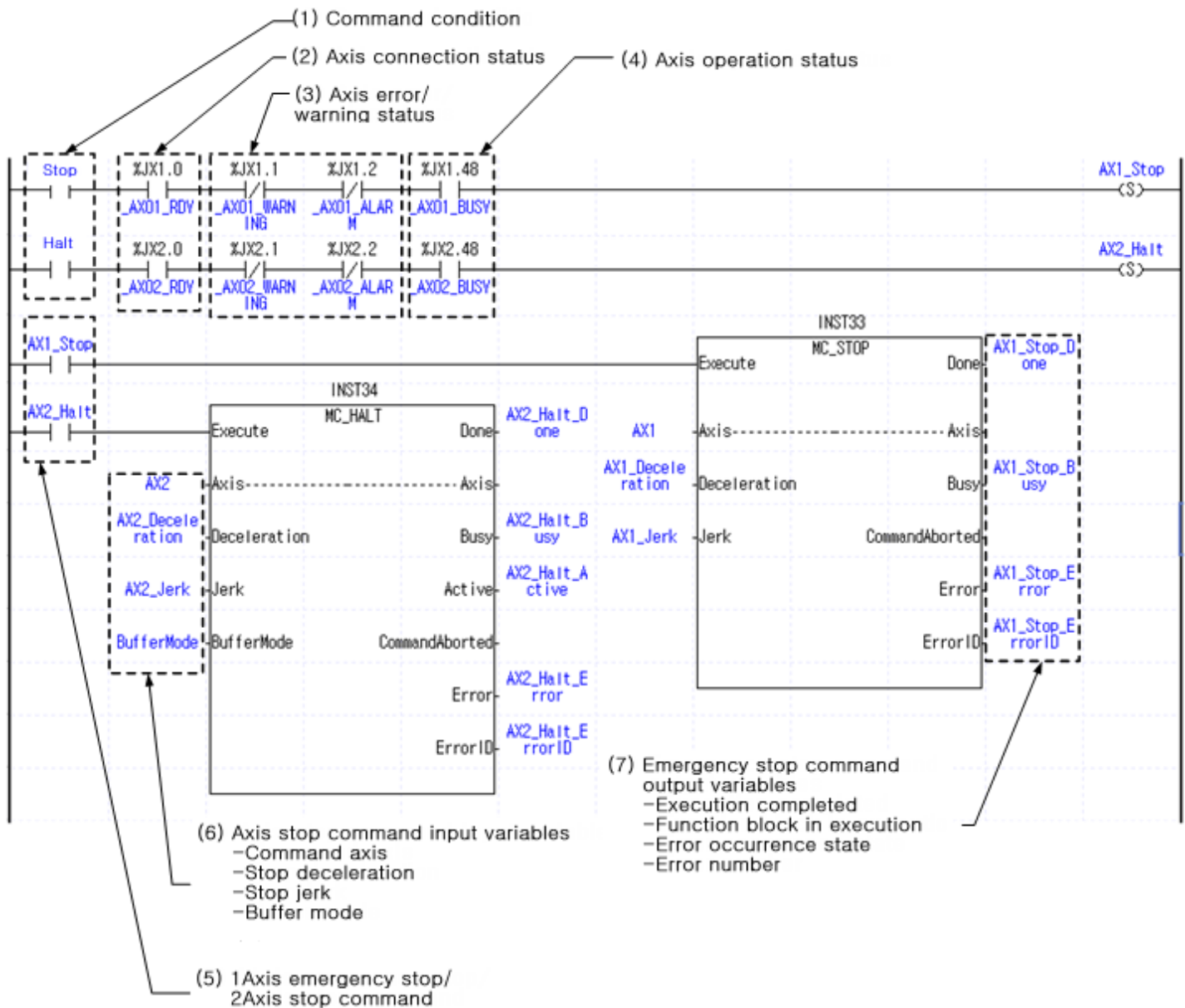
(9) Speed control operation command output variable

: It is a variable to store output values generated when specified velocity operation (MC\_MoveVelocity) motion function block is executed.

- Reaching the set speed completed: When the set speed is reached through speed control operation, it is On.
- Function Block in execution: If motion function block is being performed, it is On, and operation is completed, it becomes Off.
- Function Block axis control in operation: In case motion function block controls the axis, it is On.
- Error occurrence state: In case error occurs while the motion function block is being executed, it is On.
- Error number: In case error occurs, the number that corresponds to error is generated.
- For more details on the output of function block, refer to “Edge operation motion function block” of “6.1.3 Basic input and output variables”.

### 7.3.5 Axis Stop

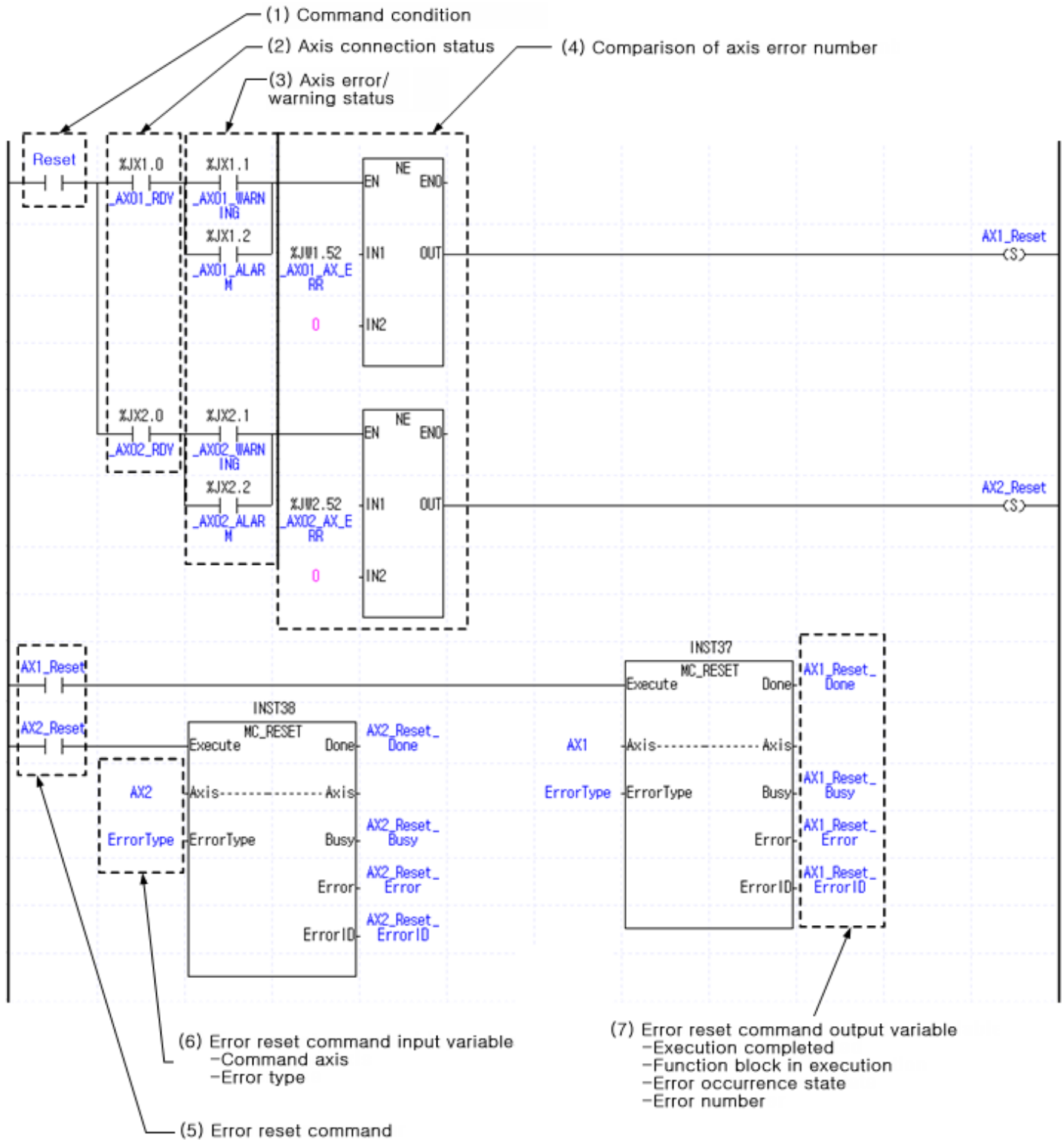
It is an example program to stop the axis in operation. The motion function block to stop the axis in operation includes “Immediate Stop (MC\_Stop)” and “Halt (MC\_Halt)”. As a command to implement emergency stop of the axis, “Immediate Stop (MC\_Stop)” performs “Immediate Stop (MC\_Stop)”, and other motion function blocks cannot be executed during the stop. As a command to stop the axis, “Halt (MC\_Halt)” performs “Halt (MC\_Halt)”, the stop status is aborted by other motion function blocks during the stop, and other motion function blocks can be executed. For more details, refer to “Chapter 6 Command”.



- (1) Command condition  
: It is a condition to give emergency stop/axis stop commands to the axis.
- (2) Axis connection state flag  
: In case the axis to be operated is connected to motion control module, and EtherCAT communication with motion control module is normally performed, it is On.
- (3) Axis error/warning status flag  
: If there are errors and warning in the axis, it is On.
- (4) Axis operation status flag  
: If the axis is in operation, it is On.
- (5) 1-axis emergency stop / 2-axis axis stop commands  
: In example programs, immediate stop (MC\_Stop) motion function block is executed in 1-axis, and halt (MC\_Halt) motion function block is executed in 2-axis under the following conditions.
  - The axis stop condition is On.
  - The axis is normally connected.
  - There should be no errors and warnings.
  - In operationConditions to perform motion function block may vary depending on systems.
- (6) Axis stop command input variables  
: These are input variables to execute Halt (MC\_Halt) motion function block.
  - Command axis: It sets the axis in which motion function block is executed.
  - Stop deceleration: Its sets deceleration from operating speed at the time of axis stop to a stop.
  - Stop jerk: it sets the jerk at the stop time.
  - Buffer mode: It sets the point of time when motion function block is executed. That is, it sets whether to execute immediately or execute after the completion of commands which are currently being performed. For details, refer to "6.1.4 Buffer Mode input".
- (7) Emergency stop command output variables  
: It is a variable to store output values generated when Immediate Stop (MC\_Stop) motion function block is executed.
  - Execution completed: In case the axis stop, it is On.
  - Function Block in execution: If motion function block is being performed, it is On, and execution is completed, it becomes Off.
  - Error occurrence state: In case error occurs while the motion function block is being executed, it is On.
  - Error number: In case error occurs, the number that corresponds to error is generated.
  - For more details on the output of motion function block, refer to "Edge operation motion function block" of "6.1.3 Basic I/O Variable.

### 7.3.6 Error Processing

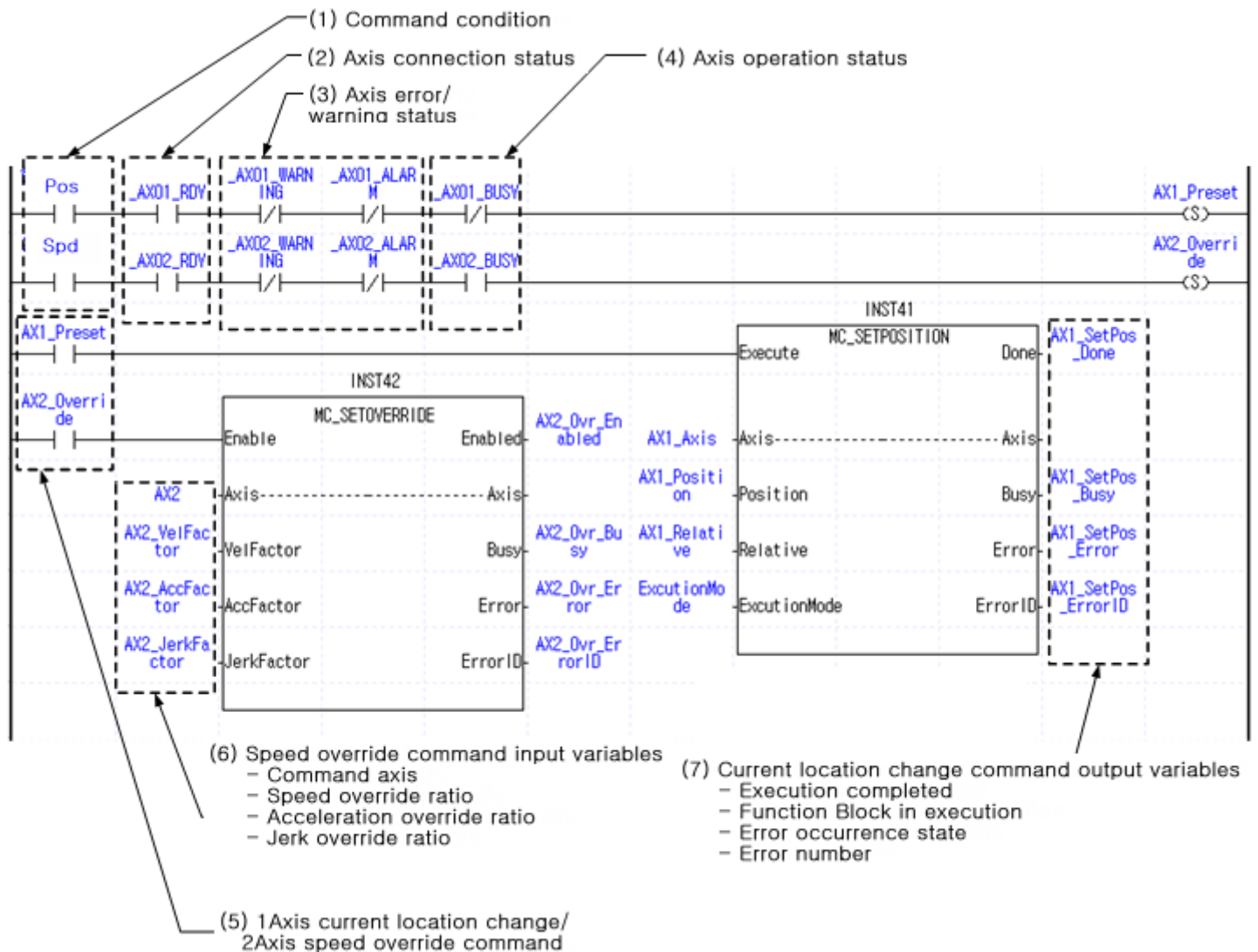
It is an example program to check the errors that occurred on the axis and conduct error reset.



- (1) Command condition  
: It is a condition to give error reset commands to the axis.
- (2) Axis connection status flag  
: In case the axis to be operated is connected to motion control module, and EtherCAT communication with motion control module is normally performed, it is On.
- (3) Axis error/Warning status flag  
: If there are errors and warnings in the axis, it is On.
- (4) Comparison of axis error number  
: In example programs, a case where the value of error number flag on the axis is not 0 is determined to be error reset condition through a comparison.
- (5) Error reset command  
: In example programs, axis error reset (MC\_Reset) motion function block is executed under the following conditions.
  - The axis operation condition is On.
  - The axis is normally connected.
  - There should be error and warnings.
  - Error number is not 0.Conditions to perform motion function block may vary depending on systems.
- (6) Error reset command input variables  
: These are input variables to execute axis error reset (MC\_Reset) motion function block.
  - Command axis: It sets the axis in which motion function block is executed.
  - Error type: The type of error for error reset is set. 0 represents axis error, and 1 common error.
- (7) Error reset command output variables  
: It is a variable to store output values generated when axis error reset (MC\_Reset) motion function block is executed.
  - Execution completed: The execution of motion function block is completed, it is On.
  - Function Block in execution: If motion function block is being performed, it is On, and execution is completed, it becomes Off.
  - Error occurrence state: In case error occurs while the motion function block is being executed, it is On.
  - Error number: In case error occurs, the number that corresponds to error is generated.
  - For details on the output of motion function block, refer to "Edge operation motion function block" of "6.1.3 Basic I/O Variable".

### 7.3.7 Change in Operation

It is an example program to change the current location of the axis and speed in operation.



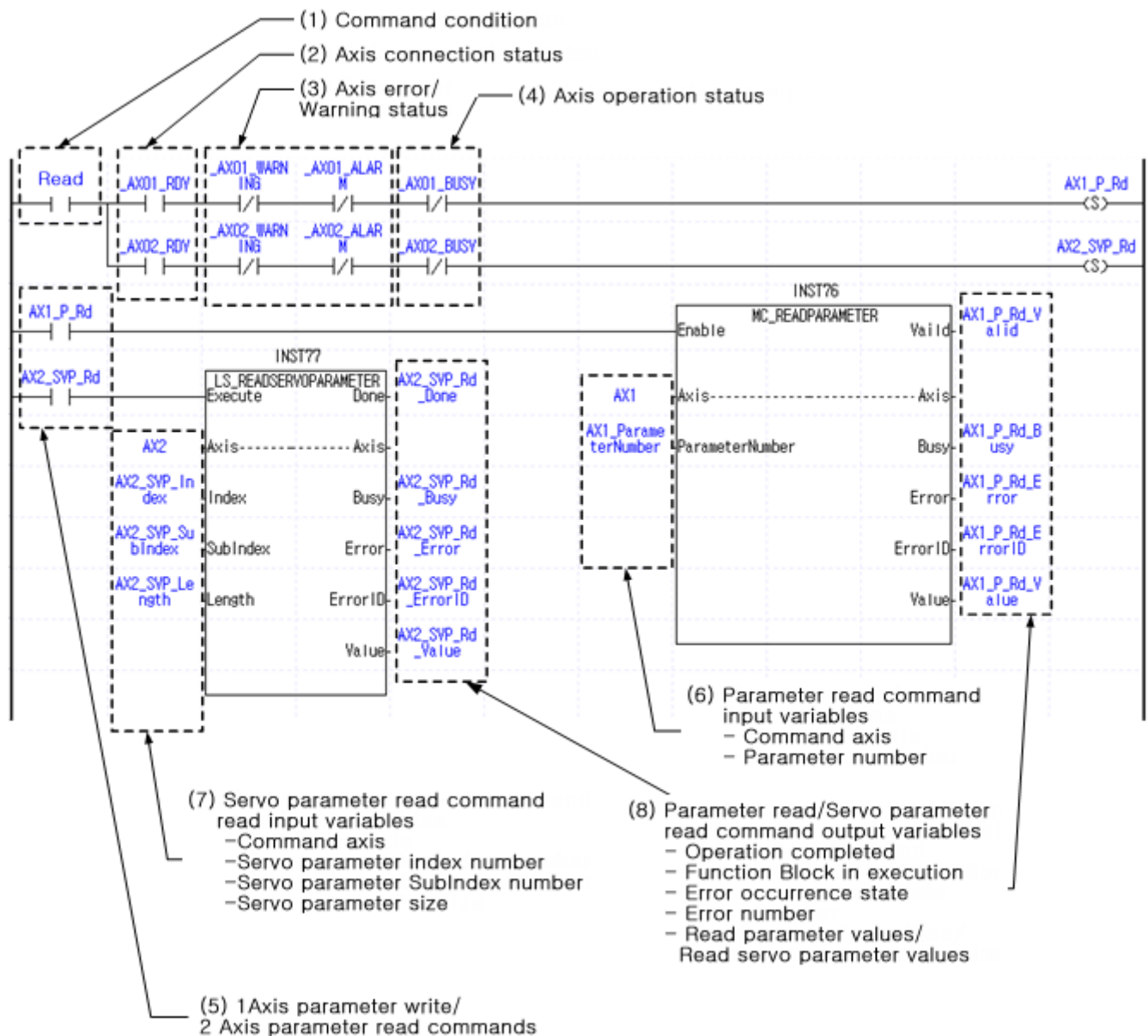


- (1) Command condition
  - : It is a condition to give current location change/operating speed change commands to the axis.
- (2) Axis connection state flag
  - : In case the axis is to be operated is connected to motion control module, and EtherCAT communication with motion control module is normally performed, it is On.
- (3) Axis error/Warning status flag
  - : If there are errors and warnings in the axis, it is On.
- (4) Axis operation status flag
  - : If the axis is in operation, it is On.
- (5) 1-axis current location change/2-axis speed override command
  - : In the example program, the current location setting (MC\_SetPosition) motion function block is executed under the following conditions.
    - The current location change condition is On.
    - The axis is normally connected.
    - There should be no errors and warnings.
    - The axis is not in operation.In addition, speed/acceleration override (MC\_SetOverride) motion function block is executed under the following conditions.
    - The operating speed change condition is On.
    - The axis is normally connected.
    - There should be no errors and warnings.
    - The axis is in operation.Conditions to execute motion function block may vary depending on systems.
- (6) Speed override command input variables
  - : These are input variables to execute speed/acceleration override (MC\_SetOverride) motion function block.
    - Command axis: It set the axis in which motion function block is executed.
    - Speed override ratio: It sets the ratio of the speed to change in comparison with operating speed that is currently set.
    - Acceleration override ratio: It sets the ratio of the acceleration to change in comparison with acceleration value which is currently set.
    - Jerk override ratio: It sets the ratio of the jerk to change in comparison with jerk value that is currently set. That is, if 2 is set to the value of the ratio, double the currently set value is set. .
- (7) Current location change command output variables
  - : These are variables to store output values generated when the current location setting (MC\_SetPosition) motion function block is executed.
    - Execution completed: If the execution of motion function block is completed, it is On.
    - Function Block in execution: When motion function block is executed, it is On, and the execution is completed, It becomes Off.
    - Error occurrence state: In case error occurs while the motion function block is being executed, it is O.
    - Error number: In case error occurs, the number that corresponds to error is generated.
    - For details on the output of motion function block, refer to “Edge operation motion function block” of “6.1.3 Basic input and output variables.

### 7.3.8 Parameter Write/Read

Parameter read/write commands include “Parameter Write (MC\_WriteParameter)” and Parameter Read (MC\_ReadParameter)” as well as “Servo Parameter Write (LS\_WriteServoParameter)” and “Servo Parameter Read (LS\_ReadServoParameter)”. “Parameter Write (MC\_WriteParameter)” and “Parameter Read (MC\_ReadParameter)” are commands to read or write operation parameters of the axis, and “Servo Parameter Write (LS\_WriteServoParameter)” and “Servo Parameter Read (LS\_ReadServoParameter)” are commands to read or write parameters of the connected servo drive. The following shows examples of programs to read or change operation parameters and servo parameters using parameter read/write commands.

■ Parameter Read



- (1) Command condition  
: It is a condition to read parameters and serve parameters of the axes.
- (2) Axis connection state flag  
: In case the axis to be operated is connected to motion control module, and EtherCAT communication with motion control module is normally performed, it is On.

(3) Axis error/Warning status flag

: If there are errors and warnings in the axis, it is On.

(4) Axis operation status flag

: If the axis is in operation, it is On.

(5) 1-axis parameter write/ 2-axis servo parameter read commands

: In example programs, Parameter Read (MC\_ReadParameter) motion function block is executed in 1-axis, and Servo Parameter Read (LS\_ReadServoParameter) motion function block is executed in 2-axis under the following conditions.

- Parameter read condition is On.
- The axis is normally connected.
- There should be no errors and warnings.
- Not in operation

Conditions to execute motion function block may vary depending on systems.

(6) Parameter read command input variables

: These input variables to execute Parameter Read (MC\_ReadParameter) motion function block.

- Command axis: It sets the axis in which motion function block is executed.
- Parameter number: It sets the parameter numbers to read with motion function block.

Numbers by parameter are as follows.

Number	Parameter	Item	Settings
0	Basic Parameter	Unit	0:pulse, 1:mm, 2:inch, 3:degree
1		Pulses per rotation	[pulse]
2		Travel per rotation	[Unit]
3		Speed command unit	0:Unit/Time, 1:rpm
4		Speed limit	[Unit/s, rpm]
5		Emergency stop deceleration	[Unit/s <sup>2</sup> ]
6		Encoder select	0:Incremental Encoder, 1:Absolute Encoder
7		Gear ratio(Motor)	1 ~ 65,535
8		Gear ratio(Machine)	1 ~ 65,535
9		Operation mode of the reverse rotation	0:Disable, 1:Enable
26		Velocity control operation mode	0: CSP (Cyclic Sync. Position) 1: CSV (Cyclic Sync. Velocity)
28		Position Control range expansion	0: No 1: Use
10		Extended Parameter	S/W upper limit
11	S/W lower limit		[Unit]
12	Infinite running repeat position		[Unit]
13	Infinite running repeat		0:Disable, 1:Enable
14	Command inposition range		[Unit]
15	Tracking error over-range value		[Unit]
16	Current position compensation amount		0 or LREAL Positive number [Unit]
17	Current speed filter time constant		0 ~ 100
18	Error reset monitoring time		[ms]
19	S/W limit during speed control		0:Don't detect, 1:Detect
20	Tracking error level		0:Warning, 1:Alarm
21	JOG high speed		[Unit/s]
22	JOG low speed	[Unit/s]	

23		JOG Acceleration	[Unit/s <sup>2</sup> ]
24		JOG Deceleration	[Unit/s <sup>2</sup> ]
25		JOG Jerk	[Unit/s <sup>3</sup> ]
27		The Sync method depending on the direction of master axis operation	0: Sync to bi-direction operation of master axis 1: Sync to forward direction operation of master axis 2: Sync to reverse direction operation of master axis
100	Common Parameter	Encoder1 unit	0: pulse, 1: mm, 2: inch, 3:degree
101		Encoder1 pulse per rotation	1 ~ 4294967295
102		Encoder1 travel per rotation	0.000000001 ~ 4294967295
103		Encoder1 pulse input	0:CW/CCW 1 multiplier, 1:PULSE/DIR 1 multiplier 2:PULSE/DIR 2 multiplier, 3:PHASE A/B 1 multiplier 4:PHASE A/B 2 multiplier, 5: PHASE A/B 4multiplier
104		Encoder2 unit	0: pulse, 1: mm, 2: inch, 3:degree
105		Encoder2 pulse per rotation	1 ~ 4294967295
106		Encoder2 travel per rotation	0.000000001 ~ 4294967295
107		Encoder2 pulse input	0:CW/CCW 1 multiplier, 1:PULSE/DIR 1 multiplier 2:PULSE/DIR 2 multiplier, 3:PHASE A/B 1 multiplier 4:PHASE A/B 2 multiplier, 5: PHASE A/B 4multiplier
108		Encoder1 max. value	LREAL numbers
109		Encoder1 min. value	
110		Encoder2 max. value	
111		Encoder2 min. value	
112		Override	0: Specified by ratio, 1: Specified by unit
113		Encoder1 Position filter time constant	0~1000 ms
114		Encoder2 Position filter time constant	0~1000 ms
115		Encoder1 Speed unit	0: Unit/sec, 1: rpm, 2: Unit/min
116	Encoder2 Speed unit	0: Unit/sec, 1: rpm, 2: Unit/min	

## (7) Servo parameter read command read input variables

: These are input variables to execute Servo Parameter Read (LS\_ReadServoParameter) motion function block.

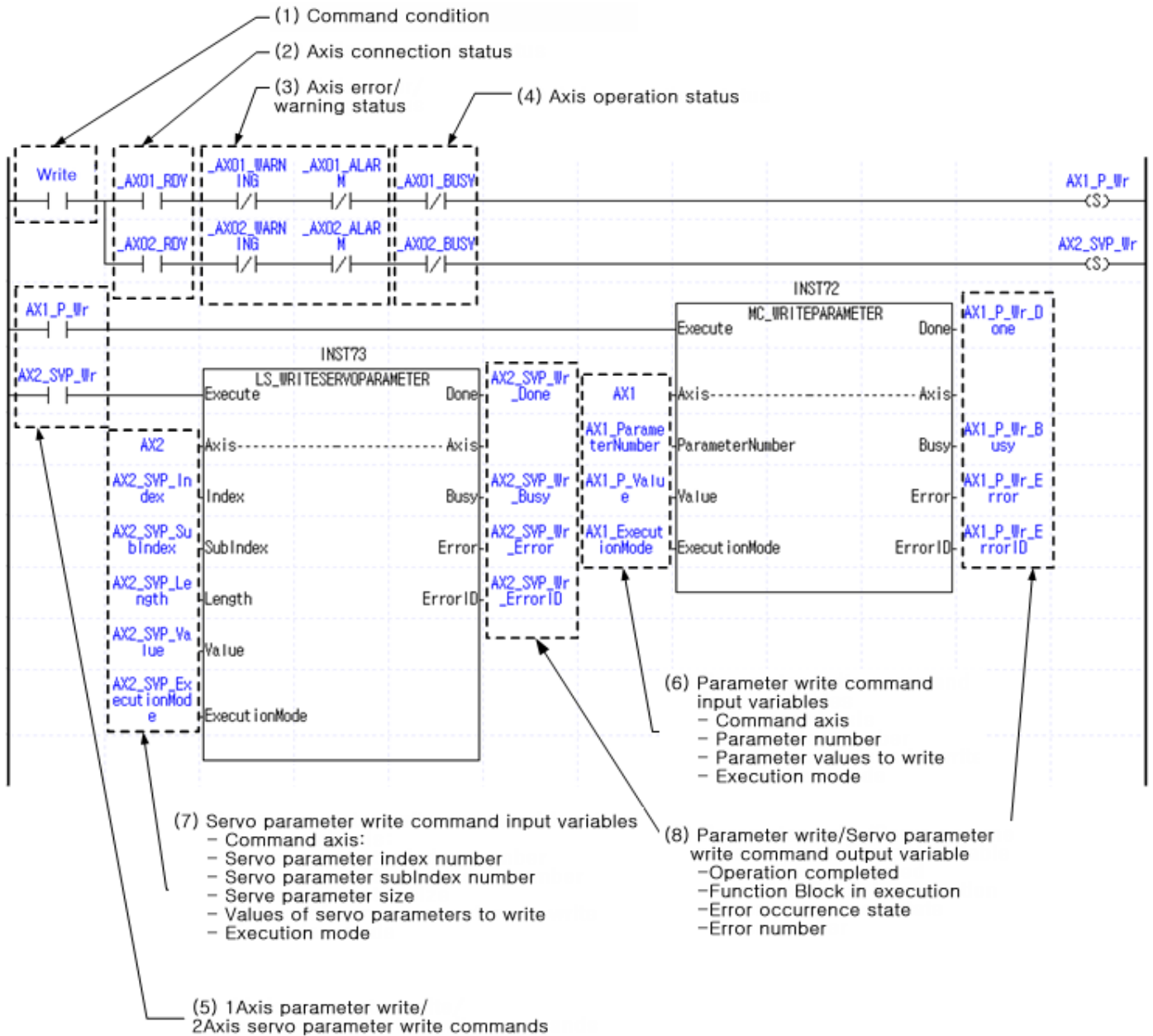
- Command axis: It sets the axis in which motion function block is executed.
- Servo parameter index number, SubIndex number, size: Each value is set in servo parameters to read. Refer to the instruction manual of the servo drive for index number, subindex number and size of servo parameters.

## (8) Parameter read/Servo parameter read command output variables

: These are variables to store output values generated when Parameter Read (MC\_ReadParameter) and Servo Parameter Read (LS\_ReadServoParameter) motion function block is executed.

- Operation completed: If values of parameters and servo parameters is read, it is On.
- Function Block in execution: When motion function block is executed, it is On, and the operation completion is On, it becomes Off.
- Error occurrence state: In case error occurs while the motion function block is being executed, it is On.
- Error number: In case error occurs, the number that corresponds to error is generated.
- Read parameter values/Read servo parameter values: Values of parameters and servo parameters read by the execution of motion function block is stored.

■ Parameter Write

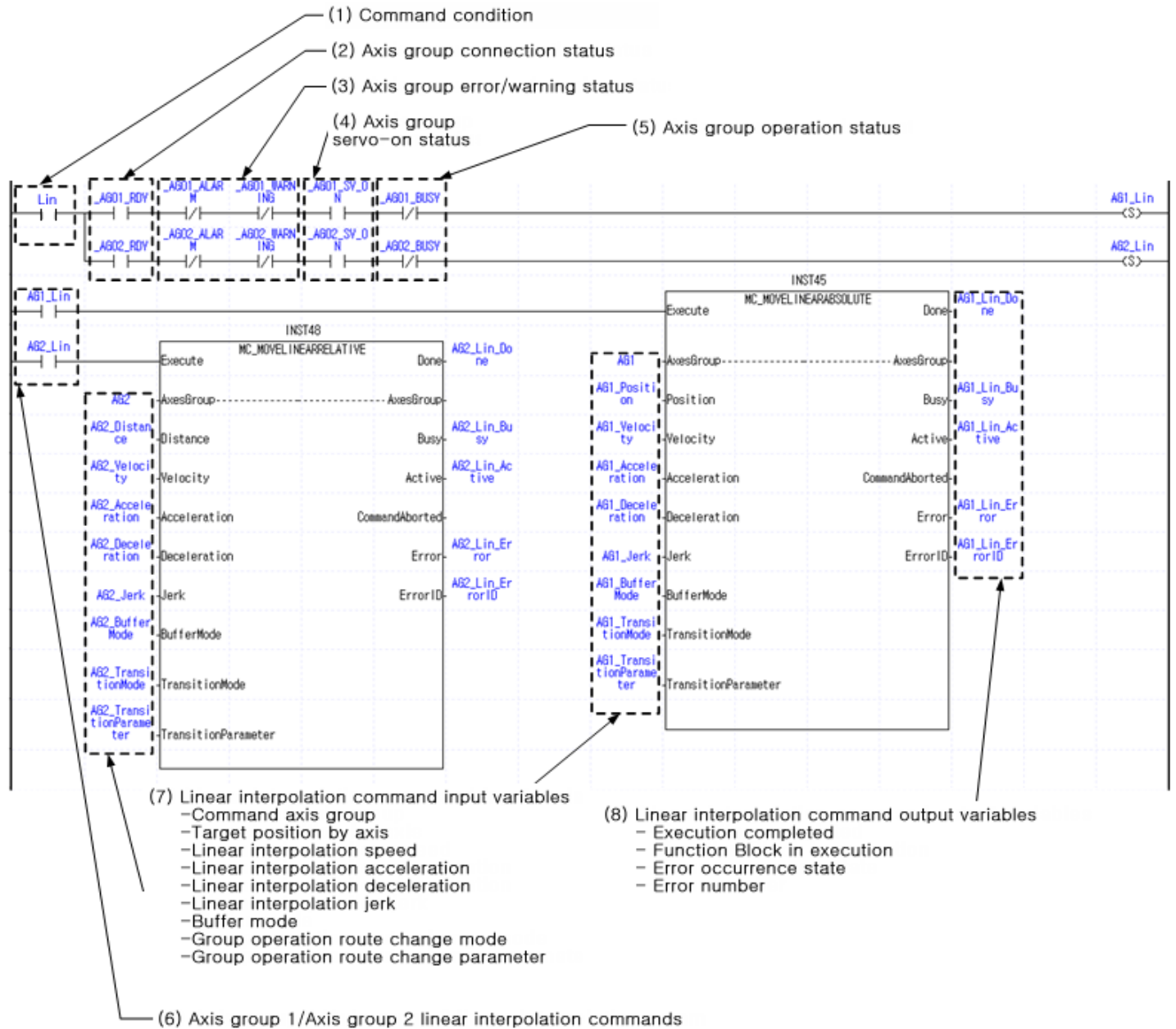


- (1) Command condition  
: It is a condition to write parameters and servo parameters of the axes.
- (2) Axis connection state flag  
: In case the axis to be operated is connected to motion control module, and EtherCAT communication with motion control module is normally performed, it is On.
- (3) Axis error/Warning status flag  
: If there are errors and warnings in the axis, it is On.
- (4) Axis operation status flag  
: If the axis is in operation, it is On.
- (5) 1-axis parameter write/ 2-axis servo parameter write commands  
: In example programs, Parameter Write (MC\_WriteParameter) motion function block is executed in 1-axis, and Servo Parameter Write (LS\_WriteServoParameter) motion function block is executed in 2-axis under the following conditions.
- Parameter write condition is On
  - The axis is normally connected.
  - There should be no errors and warnings.
  - Not in operation
- Conditions to execute function block may vary depending on systems.
- (6) Parameter write command input variables  
: These are input variables to execute Parameter Write (MC\_WriteParameter) motion function block.
- Command axis: It sets the axis in which motion function block is executed.
  - Parameter number: It set parameter numbers to write with the motion function block.
  - Parameter values to write: Values to write in the parameters are set.
  - Execution mode: It specifies the point of time when parameters are written. If it sets 0, it changes parameter values upon executing motion function block. If it sets 1, it is changed to the same point of time with "Buffered" of BufferMode. (Refer to 6.1.4 BufferMode)
- (7) Servo parameter write command input variables  
: These are input variables to execute Servo Parameter Write (LS\_WriteServoParameter) motion function block.
- Command axis: It sets the axis in which motion function block is executed.
  - Servo parameter index number, subIndex number, size: Each value is set according to servo parameters to write. Refer to instruction manual of the servo drive for index number, subindex number and size of servo parameters.
  - Values of servo parameters to write: Values to be written in the servo parameters is set.
  - Execution mode: it certifies the point of time when parameters are written. It sets 0, it changes parameter values upon executing motion function block. If it sets 1, it is changed to the same point o time with 'Buffered' of BufferMode. (Refer to 6.1.4 BufferMode)
- (8) Parameter write/Servo parameter write command output variable  
: It is a variable to store output values generated when Parameter Write (MC\_WriteParameter) and Servo Parameter Write (LS\_WriteServoParameter) motion function block is executed.
- Operation completed: If values of the parameters and servo parameters are written, it is On.
  - Function Block in execution: When motion function block is executed, it is On, and operation completion is On, it becomes Off.
  - Error occurrence state: In case error occurs while motion function block is being executed, it is On. As for error number, the number that corresponds to error is generated in case error occurs.

## 7.4 Multi-Axis Operation Program

### 7.4.1 Linear Interpolation Operation

It is an example program to operate linear interpolation with axes set to the same group. In the example program, 1-axis and 2-axis are assumed to be included in the same axis group. Refer to the example program of “7.4.5 Axis group processing” to include an axis in axis group or remove the axis from axis group.



- (1) Command condition  
: It is a condition to give linear interpolation command to the axis group.
- (2) Axis group connection state flag  
: In case axes of the axis group to be operated are connected to motion control module, and EtherCAT communication with motion control module is normally performed, it is On.
- (3) Axis group error/Warning status flag  
: If there are errors and warnings in axes included in the axis group, it is On.
- (4) Axis group servo-on status  
: If axes included in the axis group are in servo-on state, it is On.
- (5) Axis group operation status flag  
: If axes of the axis group are in operation, it is On.
- (6) Axis group 1 absolute position linear interpolation/Axis group 2 relative position linear interpolation commands  
: In example programs, absolute position linear interpolation operation (MC\_MoveLinearAbsolute) is executed in axis group 1, and relative position linear interpolation operation (MC\_MoveLinearRelative) motion function block in axis 2 under the following conditions.
- Linear interpolation operation condition is On.
  - Axes included in the axis group are normally connected.
  - There should be no errors and warnings.
  - Axes of the axis group are not in operation.
- Conditions to execute motion function block may vary depending on systems.
- (7) Linear interpolation command input variables  
: These are input variables to execute absolute position linear interpolation operation (MC\_MoveLinearAbsolute) and relative position linear interpolation operation (MC\_MoveLinearRelative) motion function block.
- Command axis group: It sets axis group in which motion function block is executed.
  - Target position by axis: Array variables are set, and linear interpolation operation target position of axes included in axis group is set in order.
  - Linear interpolation speed: It sets target speed to execute linear interpolation, when the speed refers to the interpolation speed.
  - Linear interpolation acceleration, deceleration, jerk: they set values to be applied when performing linear interpolation.
  - Buffer mode: It sets the point of time when motion function block is executed. That is, it sets whether to execute immediately or execute after the completion of commands which are currently being performed. For details, refer to “6.1.4 Buffer Mode Input”.
  - Group operation route change mode and group operation route change parameter: It specifies in which way the axis group in operation is connected to the trace the existing commands describe when linear interpolation command is given. Refer to “6.1.6 Group operation route change settings”.
- (8) Linear interpolation command output variable  
: It is a variable to store output values generated when absolute position linear interpolation operation (MC\_MoveLinearAbsolute) and relative position linear interpolation operation (MC\_MoveLinearRelative) motion function block is executed.
- Execution completed: When the execution of function block is completed, it is On.
  - Function Block in execution: When motion function block is executed, it is On, and the execution is completed, it becomes Off.
  - Error occurrence state: In case error occurs as the motion function block is executed, it is On.
  - Error number: In case error occurs, the number that corresponds to error is generated.
  - For details on the output of motion function block, refer to “Edge operation motion function block” of “6.1.3 Basic I/O Variable”.



### 7.4.2 Circular Interpolation Operation

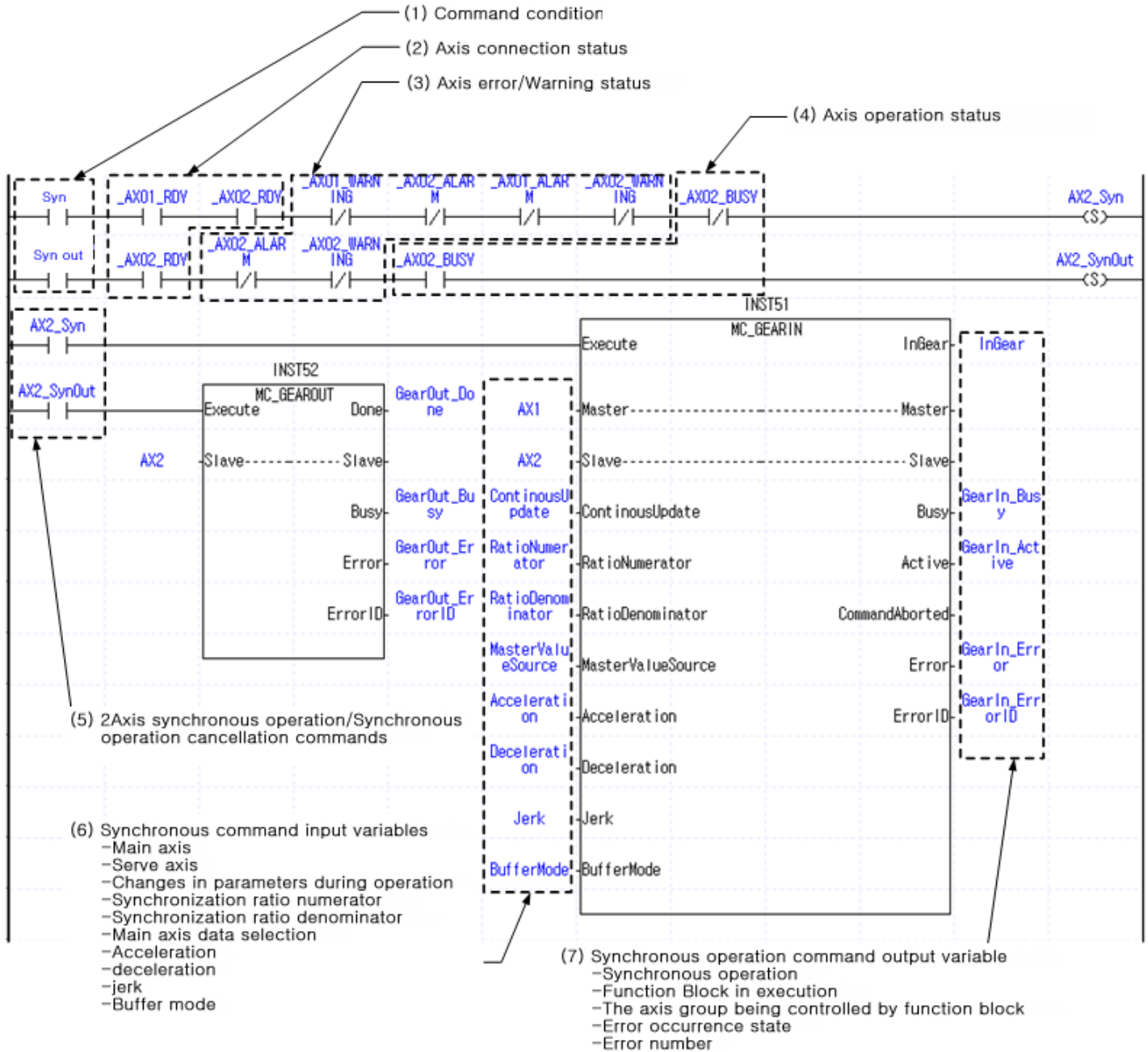
It is an example program to operate circular interpolation operation with axes set to the same group. In the example program, 1-axis and 2-axis are assumed to be included in the same axis group. Refer to “7.4.5 Axis group processing” to include an axis in axis group or remove axis from axis group.



- (1) Command condition  
: It is a condition to give circular interpolation command to the axis group.
- (2) Axis group connection state flag  
: In case axes of the axis group to be operated is connected to motion control module, and EtherCAT communication with motion control module is normally performed, it is On.
- (3) Axis group error/Warning status flag  
: If there are errors and warnings in axes included in the axis group, it is On.
- (4) Axis group servo-on status  
: If axes included in the axis group are in servo-on state, it is On.
- (5) Axis group operation status flag  
: If axes of the axis group are in operation, it is On.
- (6) Axis group 1 absolute position circular interpolation/Axis group 2 relative position circular interpolation commands  
: In example programs, absolute position circular interpolation operation (MC\_MoveCircularAbsolute) is executed in axis group 1, and relative position circular interpolation operation (MC\_MoveCircularRelative) motion function block in axis 2 under the following conditions.
- Circular interpolation operation condition is On.
  - Axes included in the axis group are normally connected.
  - There should be no errors and warnings.
  - Axes of the axis group are not in operation.
- Conditions to execute motion function block may vary depending on systems.
- (7) Circular interpolation command input variables  
: These are input variables to execute absolute position circular interpolation operation (MC\_MoveCircularAbsolute) and relative position circular interpolation operation (MC\_MoveCircularRelative) motion function block.
- Command axis group: It sets axis group in which motion function block is to be executed.
  - Target position by axis: Array variables are set, and linear interpolation operation target position of axes included in axis group is set in order.
  - Circular interpolation method: It sets a method to execute circular interpolation through selection among mid-point method, center point method and radius method.
  - Axis-specific circular interpolation auxiliary point: It takes a form of array and sets auxiliary point required for circular interpolation in the order of axes included in axis group.
  - Axis-specific circular interpolation target point: It takes a form of array and sets target position in the order of axes included in axis group.
  - Circular interpolation velocity: It sets target speed to execute circular interpolation, when the speed refers to interpolation speed.
  - Circular interpolation acceleration, deceleration, jerk: Values to be applied when circular interpolation is performed are set.
  - Buffer mode: It sets the point of time when motion function block is executed. That is, it set whether to execute immediately or execute after the completion of commands which are currently being performed. For details, refer to "6.1.4 Buffer Mode Input".
- (8) Circular interpolation command output variable  
: It is a variable to store output values generated when absolute position circular interpolation operation (MC\_MoveCircularAbsolute) and relative position circular interpolation operation (MC\_MoveCircularRelative) motion function block is executed.
- Execution completed: When the execution of motion function block is completed, it is On.
  - Function Block in execution: When motion function block is executed, it is On, and the execution is completed, it becomes Off.
  - The axis group being controlled by function block: When motion function block controls the axis group, it is On.
  - Error occurrence state: In case error occurs as the motion function block is executed, it is On.
  - Error number: In case error occurs, the number that corresponds to error is generated.
  - For details on the output of motion function block, refer to "Edge motion commands" of "6.1.3 Basic I/O Variable".

### 7.4.3 Synchronous Operation

It is an example program on the synchronous operation in which serve axis moves in synchronization ratio set in the main axis.



- (1) Command condition  
: It is a condition to give synchronous operation/synchronous operation cancellation commands to the axis.
- (2) Axis connection state flag  
: When axis to be operated is connected to motion control module, and EtherCAT communication with motion control module is normally performed, it is On.
- (3) Axis error/Warning state flag  
: If there are errors and warning in the axis, it is On.
- (4) Axis operation status flag  
: If the axis is in operation, it is On.
- (5) 2Axis synchronous operation/Synchronous operation cancellation commands  
: In the example program, electronic gear operation (MC\_GearIn) motion function block is executed under the following conditions.
- Synchronous operation condition is On.
  - The axis and main axis is normally connected.
  - There should be no errors and warnings.
  - The axis is not in operation.
- In addition, electronic gear cancellation (MC\_GearOut) motion function block is executed under the following conditions.
- Synchronous operation cancellation condition is On.
  - The axis is normally connected.
  - There should be no errors and warnings.
  - The axis is in operation.
- Conditions to execute motion function block may vary depending on systems.
- (6) Synchronous command input variables  
: These are input variables to execute electronic gear operation (MC\_GearIn) motion function block.
- Main axis: It sets serve axis of synchronous operation.
  - Serve axis: It sets the axis in which synchronous operation is to be performed.
  - Changes in parameters during operation: It sets whether to apply to the operation by changing input variable values of the function block. For details, refer to “6.1.5 Changes in parameters during execution of motion function block”.
  - Synchronization ratio numerator: It sets numerator value among synchronization ratio to be operated by synchronization of the operation of main axis.
  - Synchronization ratio denominator: It sets denominator among synchronization ratio to be operated by synchronization of the operation of main axis.
  - The speed of serve axis in a state of gear operation (InGear) is set as follows.

$$\text{Serve axis speed} = \text{Main axis speed} \times (\text{Synchronization ratio numerator} / \text{Synchronization denominator})$$

- Main axis data selection: It selects whether the data of main axis is set to command speed or current speed.  
In case command speed is set, synchronization is achieved based on the speed of main axis calculated in motion control module.  
In case current speed is set, synchronization is achieved by using speed data of main axis servo drive transmitted through the communication.
- Acceleration, deceleration, jerk: Each value is set in synchronous operation.
- Buffer mode: It sets the point of time when motion function block is executed. That is, it sets whether to execute immediately or execute after the completion of commands which are currently being performed. For details, refer to “6.1.4 Buffer Mode Input”.

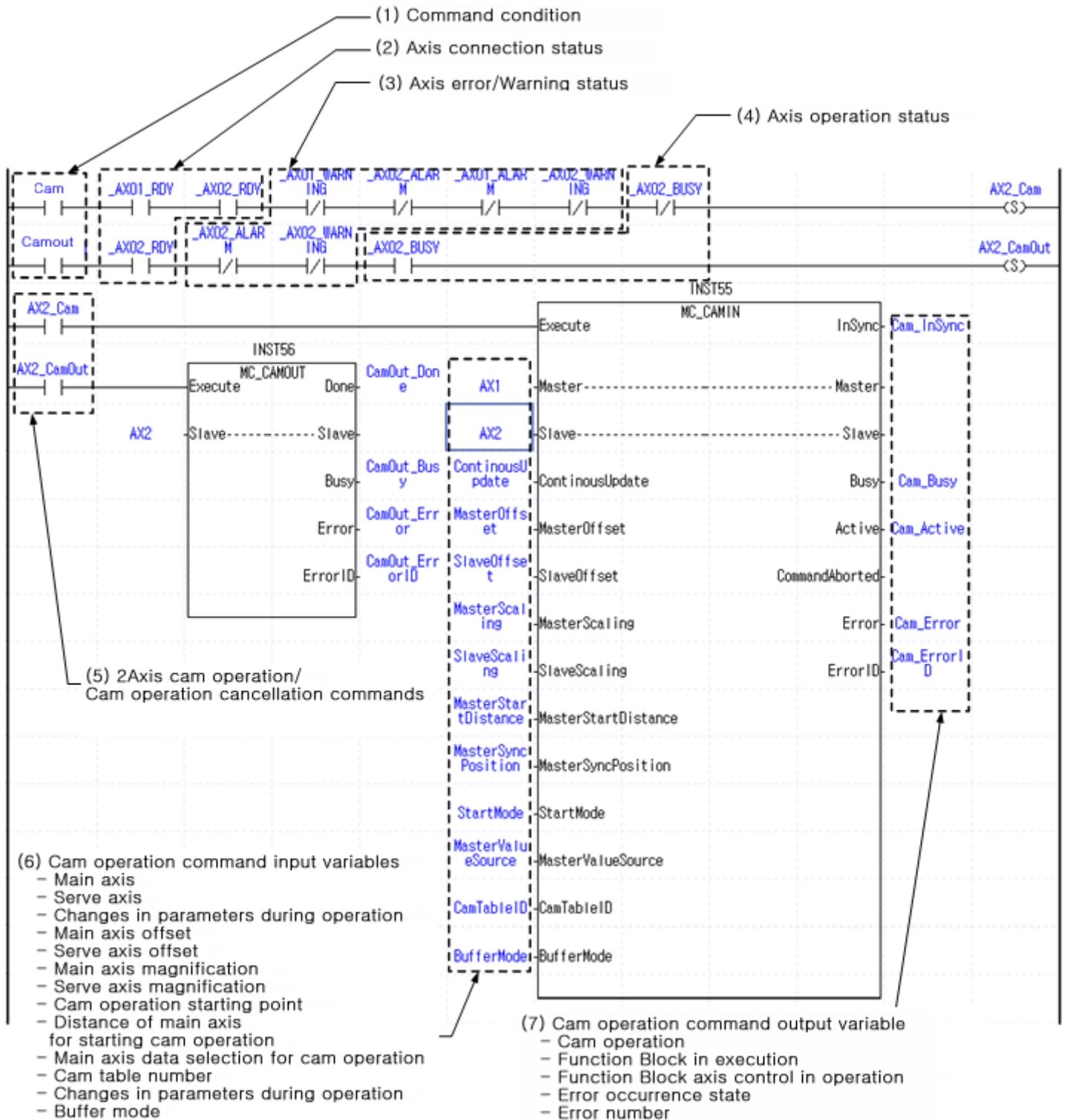
(7) Synchronous operation command output variable

: It is a variable to store output values generated when electronic gear operation (MC\_GearIn) motion function block is executed.

- Synchronous operation: When serve axis is normally synchronized in main axis after the execution of motion function block, it is On.
- Function Block in execution: When motion function block is executed, it is On, and the execution is completed, it becomes Off.
- The axis group being controlled by function block: When motion function block controls the axis group, it is On.
- Error occurrence state: In case error occurs as the motion function block is executed, it is On.
- Error number: In case error occurs, the number that corresponds to error is generated.
- For details on the output of motion function block, refer to "Edge motion commands" of "6.1.3 Basic I/O Variable".

### 7.4.4 CAM Operation

It is an example program on the cam operation that moves in synchronization based on cam (CAM) profile in which serve axis is set.



(1) Command condition

: It is a condition to give cam operation/cam operation cancellation commands to the axis.

(2) Axis connection state flag

: When the axis to be operated is connected to motion control module, and EtherCAT communication with motion control module is normally performed, it is On.

(3) Axis error/Warning status flag

: If there are errors and warnings in the axis, it is On.

(4) Axis operation status flag: If the axis is in operation, it is On.

(5) 2-axis cam operation/Cam operation cancellation commands

: In the example program, cam operation (MC\_CamIn) motion function block is executed under the following conditions.

- Cam operation condition is On.
- The axis and main axis are normally connected.
- There should be no errors and warnings.
- The axis is not in operation.

In addition, cam operation cancellation (MC\_CamOut) motion function block is executed under the following conditions.

- Cam operation cancellation condition is On.
- The axis is normally connected.
- There should be no errors and warnings.
- The axis is in operation.

Conditions to execute motion function block may vary depending on systems.

(6) Cam operation command input variables

: These are input variables to execute cam operation (MC\_CamIn) motion function block.

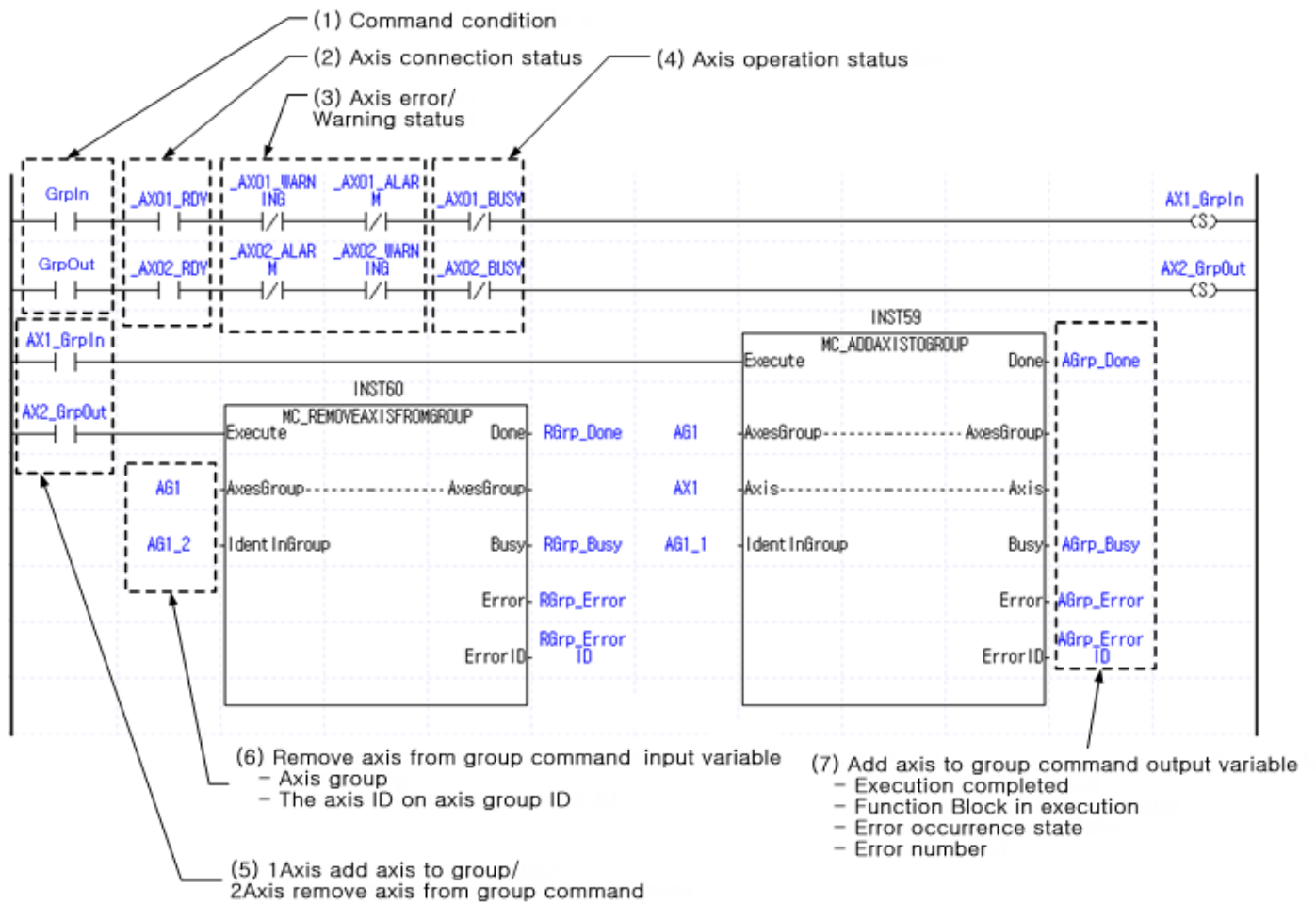
- Main axis: It sets main axis of cam operation.
- Serve axis: It sets the axis in which cam operation is executed.
- Changes in parameters during operation: It sets whether to apply to the operation by changing input variable values of the function block. For details, refer to "6.1.5 Changes in parameters during execution of motion function block".
- Main axis offset: It sets offset values of main axis data to be used when cam table data is applied.
- Serve axis offset: It sets offset values of serve axis data to be used when cam table data is applied.
- Main axis magnification: It sets magnification of main axis data to be used when cam table data is applied.
- Serve axis magnification: It sets magnification of serve axis data to be used when cam table data is applied.
- Cam operation starting point: It sets the position of main axis which will be the starting point of cam table.
- Distance of main axis for starting cam operation: It sets the distance of main axis in which actual cam operation starts.
- Main axis data selection for cam operation: It selects main axis data which will be a basis of cam operation among main axis command position and main axis current position.
- Cam table number: It sets cam data number to conduct cam operation.
- For details on cam operation command input variables, refer to "6.4.1 Cam operation (MC\_CamIn)".
- Changes in parameters during operation: It sets whether to apply to the operation by changing input variable values of the function block. For details, refer to "6.1.5 Changes in parameters during execution of motion function block".
- Buffer mode: It sets the point of time when motion function block is executed. That is, it sets whether to execute immediately or execute after the completion of commands which are currently being performed. For details, refer to "6.1.4 Buffer Mode Input".

(7) Cam operation command output variable

: It is a variable to store output values generated when cam operation (MC\_CamIn) motion function block is executed.

- Cam operation: It is on when serve axis is synchronized in main axis according to cam data after the execution of motion function block.
- Function Block in execution: When motion function block is executed, it is On, and the execution is completed, it becomes Off.
- Function Block axis control in operation: In case motion function block controls the axis, it is On.
- Error occurrence state: In case error occurs as the motion function block is executed, it is On.
- Error number: In case error occurs, the number that corresponds to error is generated.
- For details on the output of motion function block, refer to "Edge motion commands" of "6.1.3 Basic I/O Variable".

### 7.4.5 Axis Group Processing

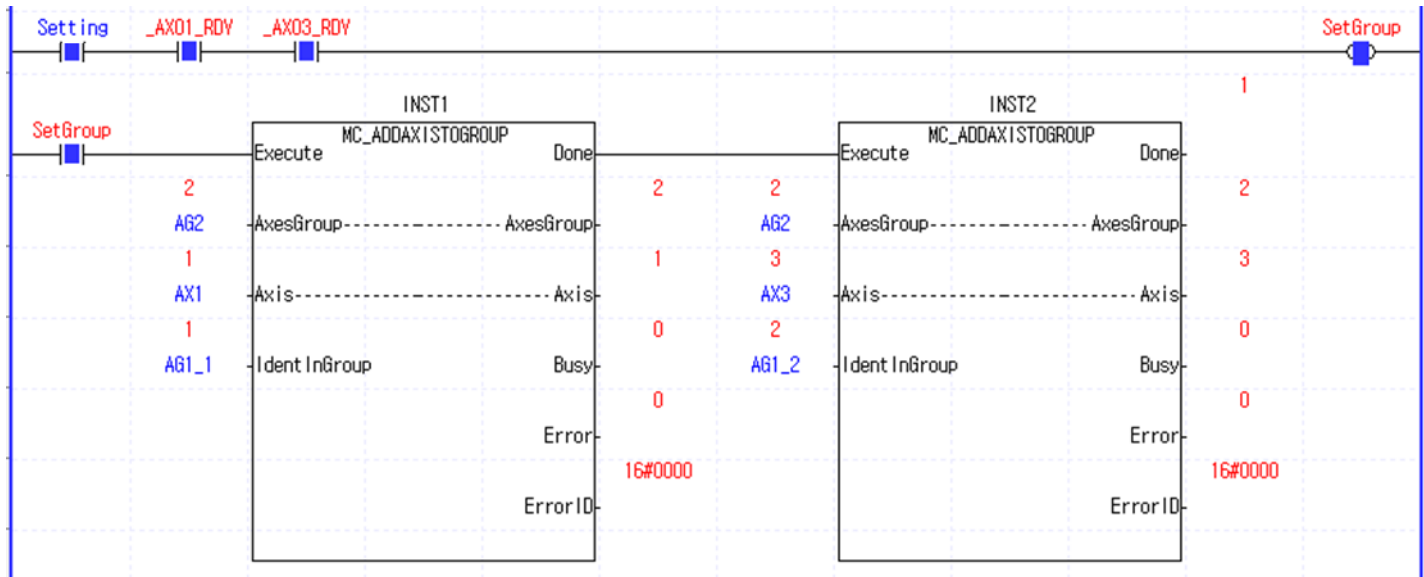




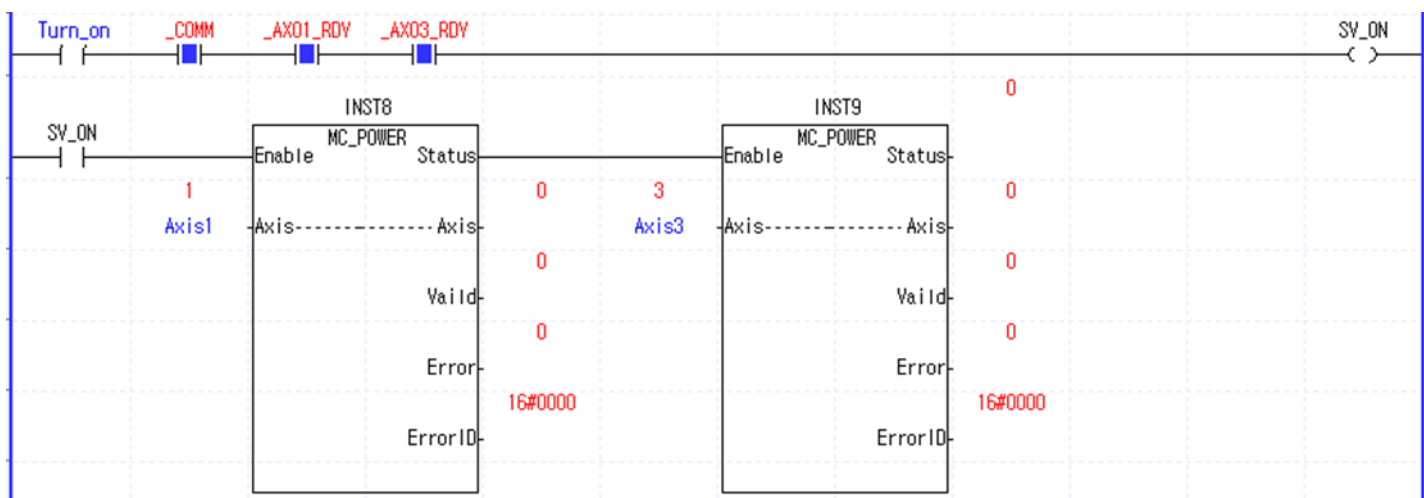
- (1) Command condition  
: It is a condition to give add axis to group/remove axis from group commands to the axis.
- (2) Axis connection status flag  
: In case the axis to be operated is connected to motion control module, and EtherCAT communication with motion control module is normally performed, it is On.
- (3) Axis error/Warning status flag  
: If there are errors and warnings in the axis, it is On.
- (4) Axis operation status flag  
: If the axis is in operation, it is On.
- (5) 1-axis add axis to group/2-axis remove axis from group commands  
: In the example program, add axis to group (MC\_AddAxisToGroup) motion function block is executed under the following conditions.
  - Add axis to group condition is On.
  - The axis is normally connected.
  - There should be no errors and warnings.
  - The axis is not in operation.In addition, group axis exclusion (MC\_RemoveAxisFromGroup) motion function block is executed under the following conditions.
  - Remove axis from group condition is On.
  - The axis is normally connected.
  - There should be no errors and warnings.
  - The axis is not in operation.Conditions to execute motion function block may vary depending on systems.
- (6) Remove axis from group command input variables  
: These are variables to execute group axis exclusion (MC\_RemoveAxisFromGroup) motion function block.
  - Axis group: It sets the group to exclude the axis.
  - The axis ID on axis group ID: It sets ID values granted when the axis is included in axis group.
- (7) Add axis to group command output variable  
: It is a variable to store output values generated when add axis to group (MC\_AddAxisToGroup) motion function block is executed.
  - Execution completed: When motion function block is normally executed, it is On.
  - Function Block in execution: When motion function block is executed, it is On, and the execution is completed, it becomes Off.
  - Error occurrence state: In case error occurs as the motion function block is executed, it is On.
  - Error number: In case error occurs, the number that corresponds to error is generated.
  - For details on the output of motion function block, refer to "Edge motion commands" of "6.1.3 Basic I/O Variable".

### 7.4.6 Example of axis group operation

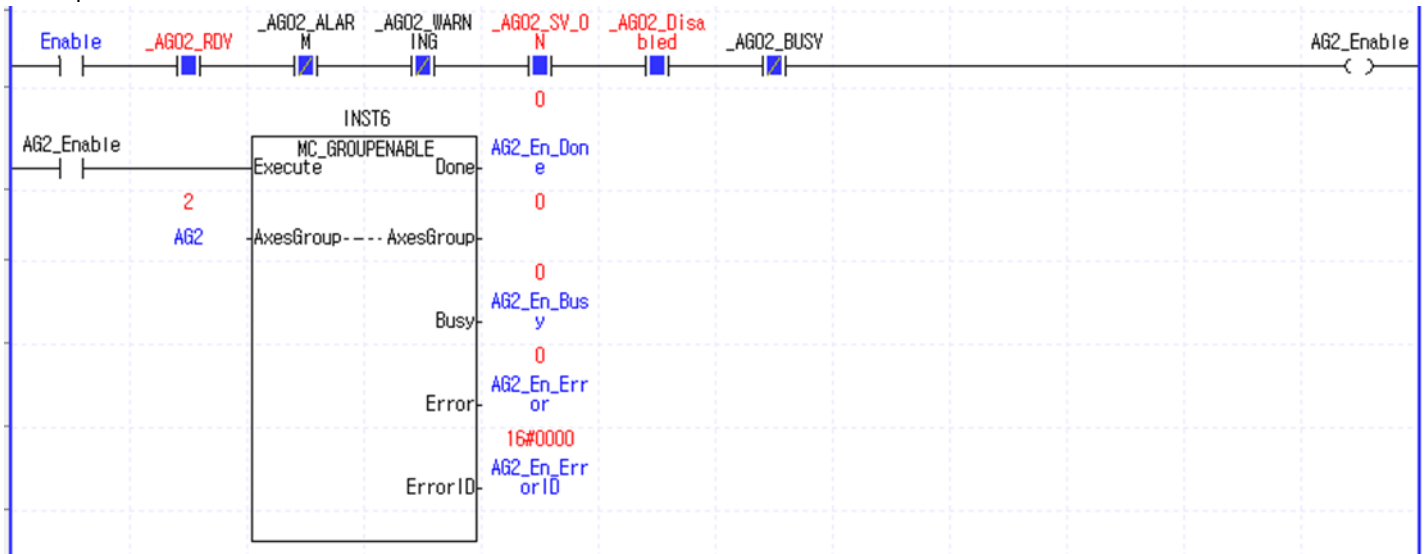
#### 1. Group setting



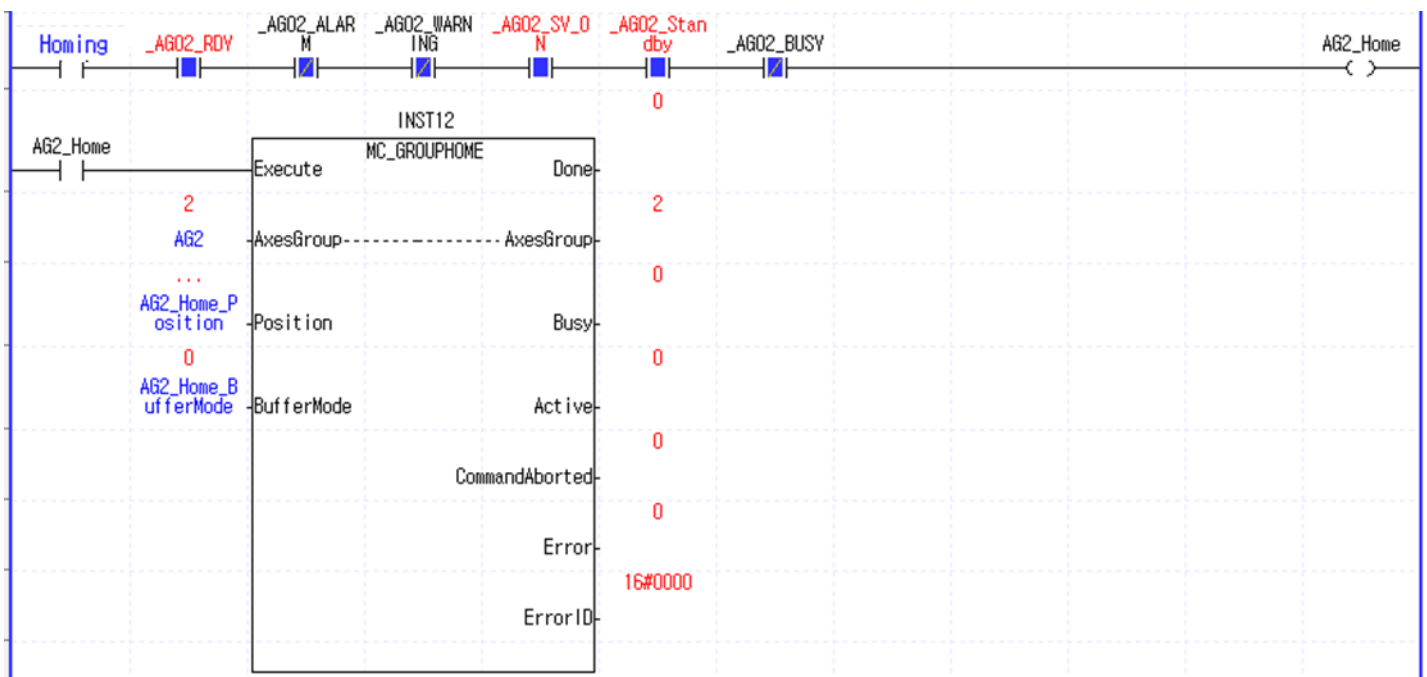
#### 2. Servo on



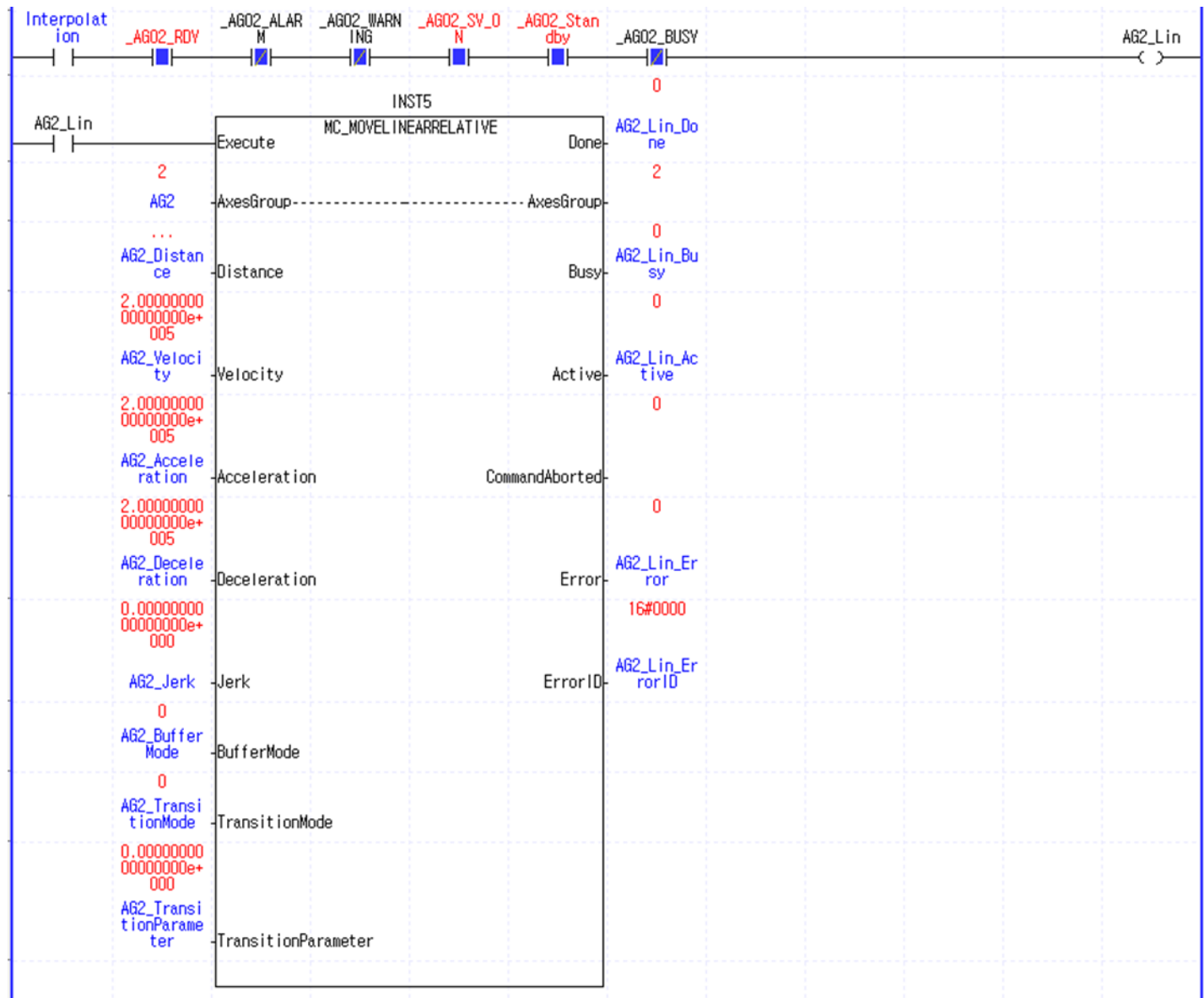
3. Group enable



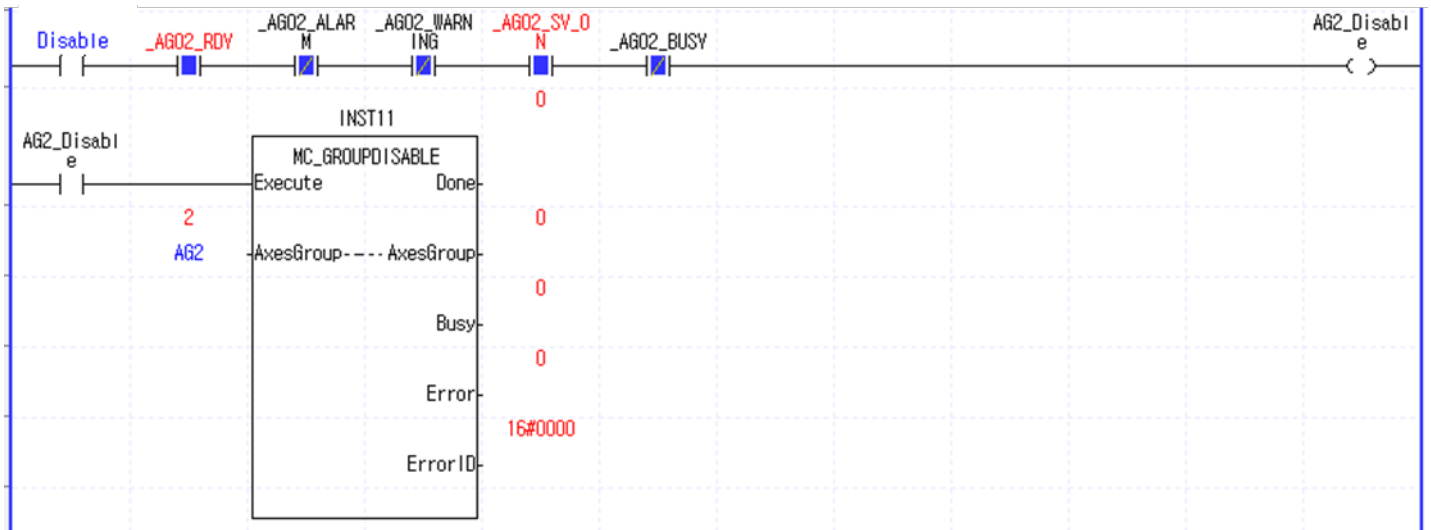
4. Group homing



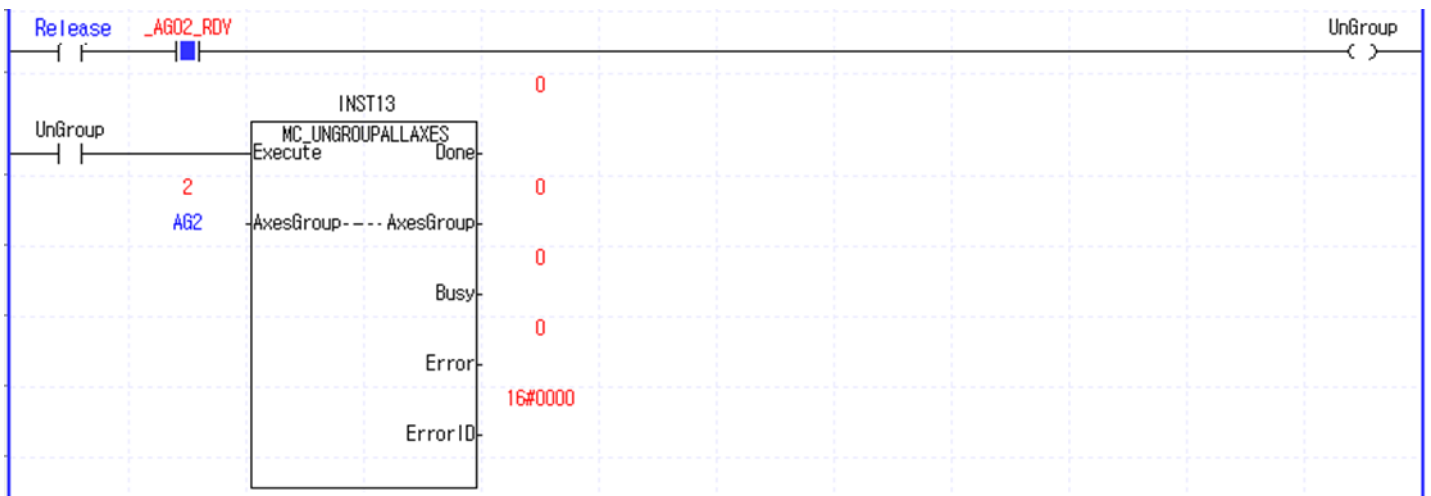
5. Group linear interpolation



6. Group disable



7. Ungroup axis



## 7.5 I/O Processing Program

Motion control module has the input of 8 points and output of 8 points internal, and it can expand input and output points using external EtherCAT input/output modules. EtherCAT input and EtherCAT output modules possible to be mounted on the outside can be expanded up to 4 stations and up to 256points.

### 7.5.1 Input Signal Processing

Internal input signals and signals inputted in external input module can be used in the program using an internal flag of the motion control module.

For details on the kinds and functions of flags, refer to "5.1.1 Flag".

### 7.5.2 Output Signal Processing

Internal output signals and signals inputted in external output module can be used in the program using an internal flag of the motion control module.

For details on the kinds and functions of flags, refer to "5.1.1 Flag".

## Chapter 8 Function

### 8.1 Origin Determination

In case the position control function of motion control module is used, the origin must be determined first to execute commands based on the absolute coordinate position. The position value of absolute coordinates is the distance based on the predetermined origin(0 position). The origin determination means setting the origin of the machine for position control using absolute coordinates.

#### 8.1.1 Origin Determination

##### 1. Methods to determine the origin

There are two methods to determine the origin of the machine as below.

###### (1) Homing

It is a method to determine the origin of the machine by moving the machine using a sensor connected to servo drive with homing (MC\_Home) motion function block.

When homing command is executed, the origin determination becomes the origin indetermination status, and homing is successfully completed, it becomes the origin determination status.

###### (2) Current position setting

After moving the machine to a certain position by using JOG operation (LS\_Jog) or relative coordinate position control (MC\_MoveRelative) motion function block, the position can be set to the specific position with the current position location setting (MC\_Setposition) motion function block. In this case, the position is recognized as an absolute coordinate and becomes origin determination status.

The origin determination status of axis can be identified with motion axis flag AXxx\_HOME\_CMOL (%JXxx.67) . (xx: axis number)

##### 2. Origin determination when using absolute encoders

In case of using absolute encoder in servo drive, absolute data value is maintained by battery backup even if the power is off. Motion control module can continue to maintain the origin determination status by reading the current position from the value of absolute encoder and calculating absolute coordinate position when it is connected to servo drive.

In order to use the absolute coordinate system by applying the absolute encoder, the following three conditions must be satisfied.

- Servo motor uses absolute encoder
- Set the servo drive's absolute encoder setting to 'Use absolute encoder'
- Set encoder selection to 'Absolute Encoder' in the axis parameter of the motion control module

In the absolute coordinate system, even if the power of the motion control module and servo drive is turned off after the origin determination is completed, the current absolute coordinate position is calculated when the power is reapplied and the servo drive is connected. The origin determination status (\_AXxx\_HOME\_CMPL) value maintains the origin determination completion state before power off. In this case, if there is movement of the servo motor before the motion control module and servo drive are connected, the movement amount is reflected in the command position (\_AXxx\_CPOS) and displayed.

In absolute coordinate system using absolute encoder as above, the absolute coordinate position can be controlled without

the origin determination even after power off/on.

### 3. Change to the origin indetermination status

The absolute position control operation cannot be performed since motion control module becomes the origin indetermination status in the following cases.

- (1) In case of re-connection after servo drive power off when using an incremental encoder
- (2) In case of re-connection after PLC power off/on when using an incremental encoder
- (3) In case homing is not normally completed after the execution of homing command

In case of the origin indetermination status as above, the origin determination should be executed for absolute coordinate position control operation.

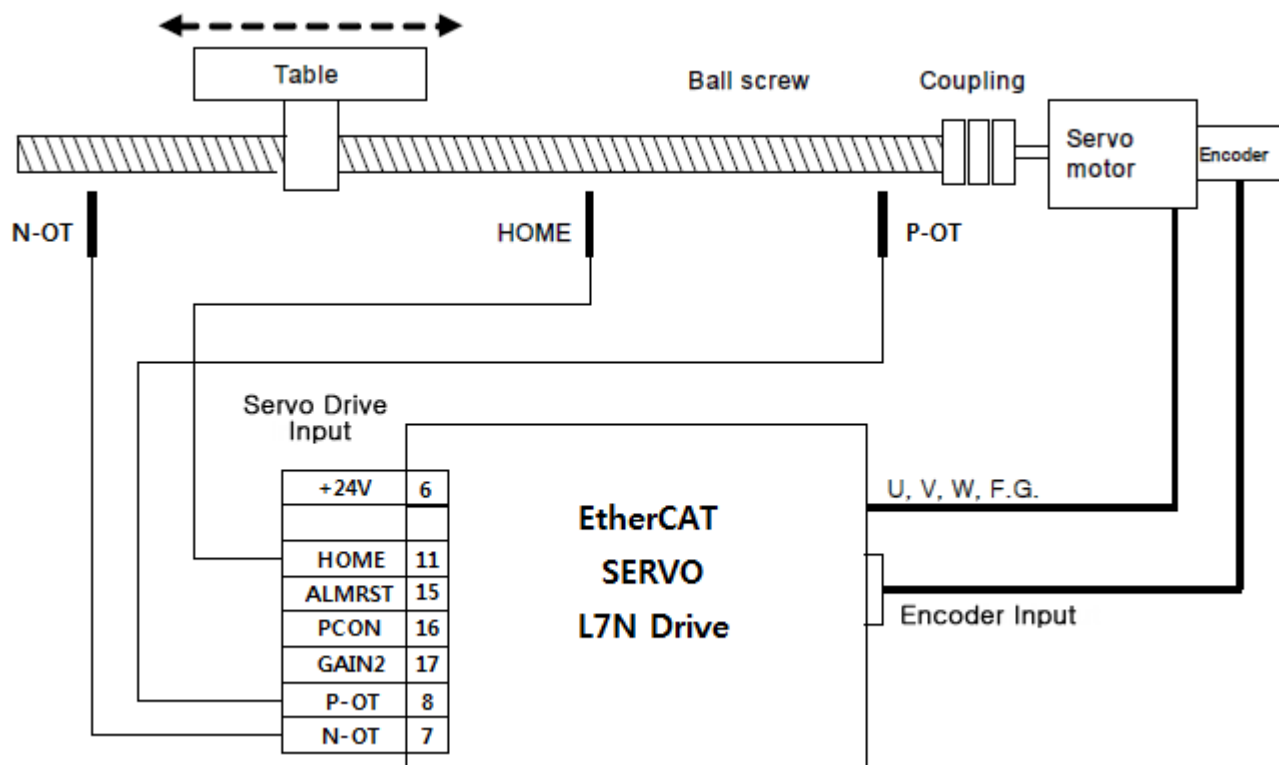
## 8.1.2 Homing

### 1. Operation

Homing is performed to establish the origin of the machine after the power is applied. Before performing the homing, parameters related to the homing of servo drive must be set in each axis. When the origin position is determined by homing, the origin detection signal is not recognized during the motion control operation.

The contact performed at the time of homing is entered through connector of servo drive (EtherCAT CoE support servo drive).

Typical wiring is as follows.



For the performance of homing, a method suitable for the system of users for homing operation mode (EtherCAT CoE support drives: Refer to instruction manual for the relevant drive) should be selected.

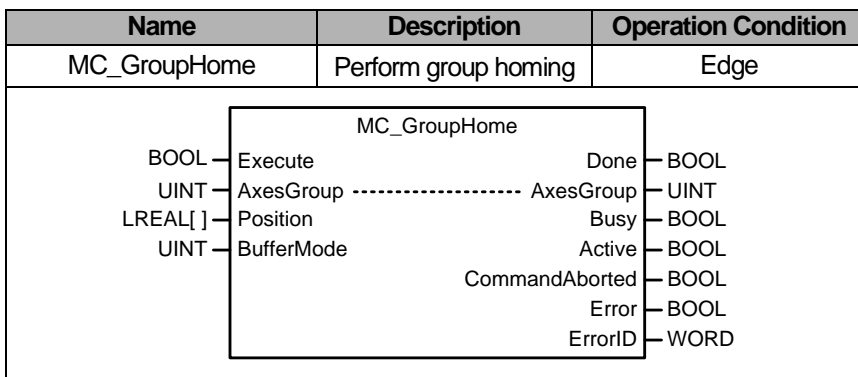
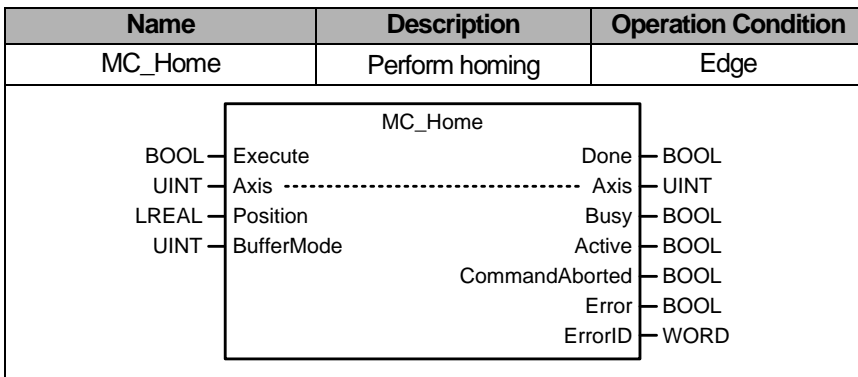
In motion control module, actual operation after starting homing is performed in servo drive, and homing method to support complies with servo drive. Before setting the homing, homing-related parameters are to be set in servo parameters of the axis.



■ Example of setting homing parameters

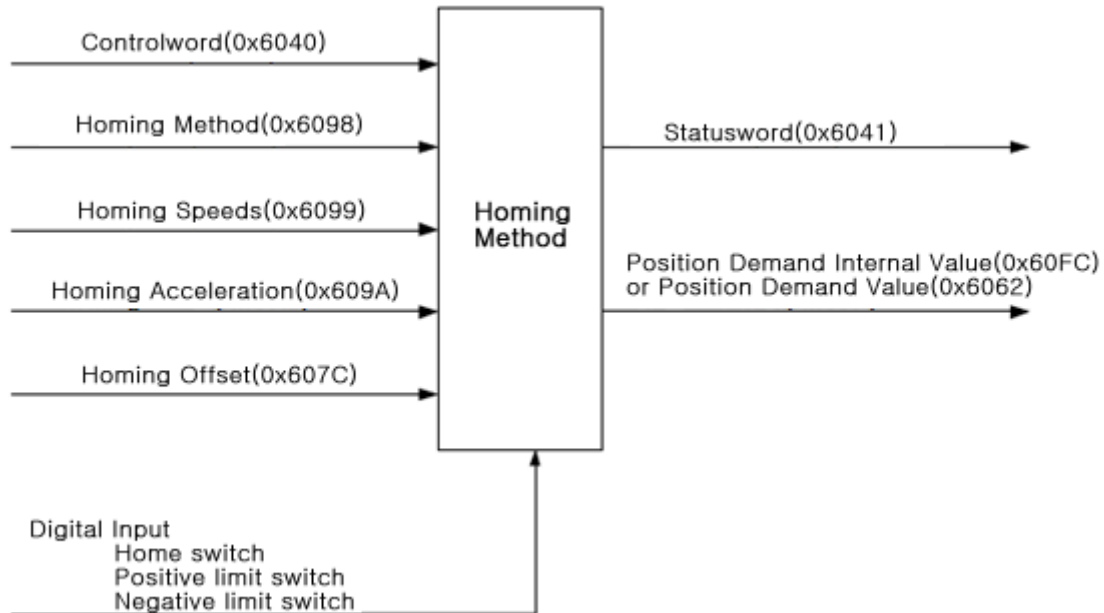
Index	Name	Unit	Current Value	Initial Value	Access
6098	Homing Method	-	0x22	0x22	rw
6099:00	Homing Speeds	-	0x02	0x02	rw
6099:01	Speed during search for switch	Vel,Unit	0x000000A0	0x000000A0	rw
6099:02	Speed during search for zero	Vel,Unit	0x00000020	0x00000020	rw
609A	Homing Acceleration	Acc,Unit	0x0000C350	0x0000C350	rw

■ Relevant motion function block



2. XDL- N Series servo drive homing parameters and operation

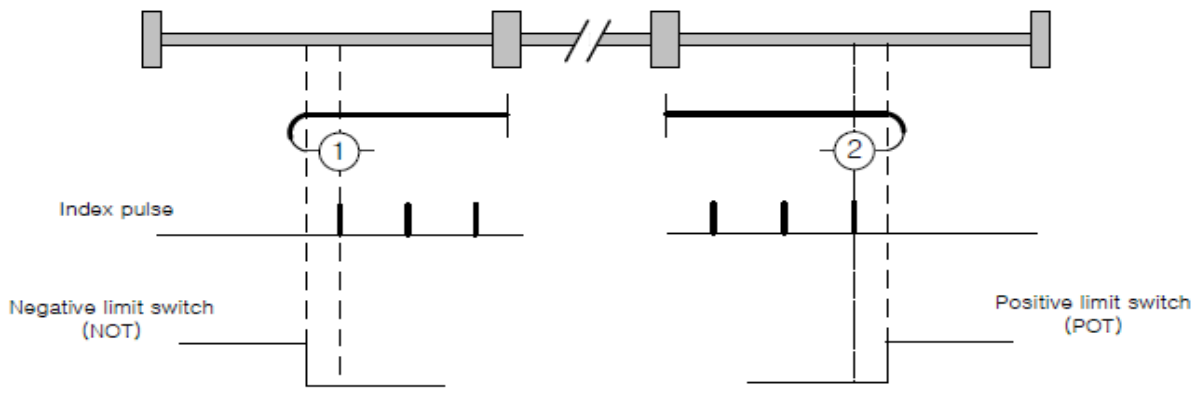
The following figure shows input and output definitions of homing-related XDL N series servo drive parameters. The velocity, acceleration and homing methods can be specified. Here, the origin (Home) offset gets the origin of user coordinate system applied as the origin.



(1) Parameter related to homing

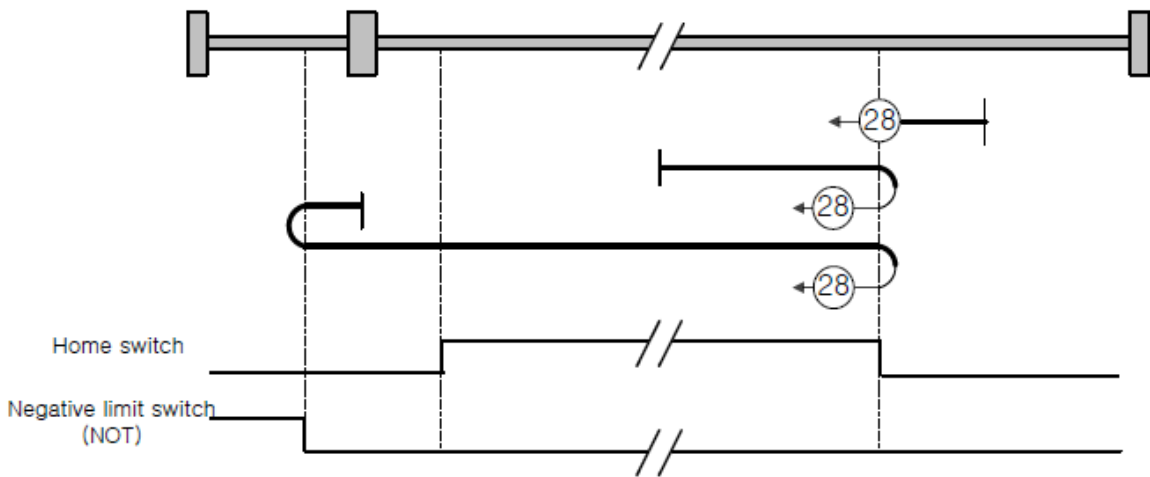
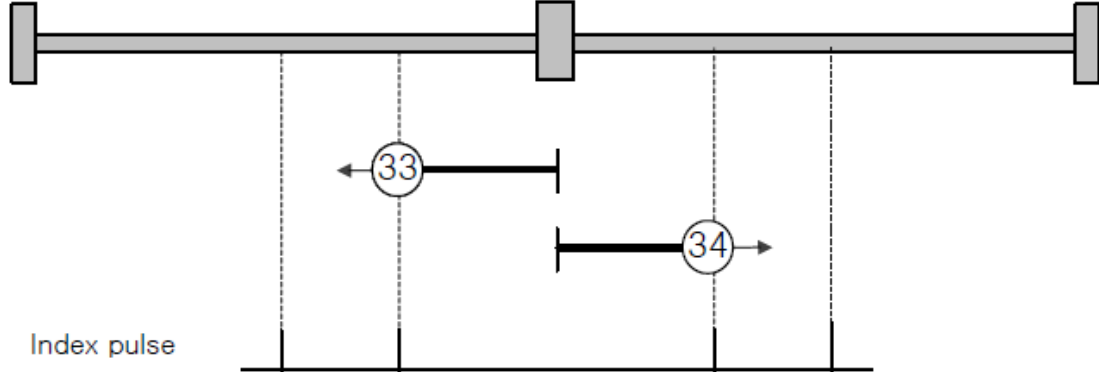
Index	Sub	Name	Data Type	Unit
0x6040	-	Controlword	UINT	-
0x6041	-	Statusword	UINT	-
0x607C	-	Homing Offset	DINT	[pls]
0x6098	-	Homing Method	SINT	-
0x6099	-	Homing Speeds	-	-
	0	Item Number	USINT	-
	1	Speed during search for switch	UDINT	[pls/s]
	2	Speed during search for zero	UDINT	[pls/s]
0x607D	-	Software Position Limit	-	-
	0	Item Number	USINT	-
	1	Min position limit	DINT	[pls]
	2	Max position limit	DINT	[pls]
0x609A	-	Homing acceleration	UDINT	[pls/s <sup>2</sup> ]

(2) Homing Method(0x6098)

Value	Description
0	No Homing
1, 2	<p>(1) If NOT switch is Off, the initial movement direction becomes forward direction CW. If NOT switch is On, change of direction is made. The location that meets the first index pulse during operation in reverse direction CCW after NOT switch is On becomes the Home position.</p> <p>(2) If POT switch is Off, the initial movement direction becomes reverse direction CCW. If POT switch is On, change of direction is made. The location that meets the first index pulse during operation in forward direction CW after POT switch is On becomes the Home position.</p>  <p>The diagram illustrates a linear axis with a carriage. On the left, there is a Negative Limit Switch (NOT) and an Index pulse signal. On the right, there is a Positive Limit Switch (POT) and an Index pulse signal. Two scenarios are shown: (1) The carriage moves right (CW) until it hits the NOT switch, then reverses to find the first index pulse. (2) The carriage moves left (CCW) until it hits the POT switch, then reverses to find the first index pulse.</p>
7~10	<p>Through (7) to (10) methods, the origin position is determined by the Home switch and POT switch.</p> <p>(7) Upper figure: If POT switch is Off, operation is made at switch search velocity, and the initial movement direction becomes reverse direction CCW. If the Home switch is On, change of direction is made. Afterwards, the location that meets the first index pulse during operation in forward direction CW becomes the Home position, and operation is made at Zero search velocity.</p> <p>(7) Middle figure: If POT switch is Off, and the Home switch is On, operation is made at switch search velocity, and the initial movement direction becomes forward direction CW. If the Home switch is Off, the speed is changed to Zero search velocity. Afterwards, the location that meets the index pulse first during operation in forward direction CW becomes the Home position.</p> <p>(7) Lower figure: If POT switch is Off, and the Home switch is On, operation is made at switch search speed, and the initial movement direction becomes reverse direction CCW. If POT switch is On, change of direction is made. When the Home switch is changed from On to Off, operation is made at Zero search velocity, and the location where that meets index pulse first during continuous operation in forward direction CW becomes the Home position.</p> <p>(8) to (10) methods have the same positioning concept in homing with the above (7) method except for the initial operational direction and motions according to the Home switch polarity. Refer to the figure below.</p>

Value	Description
7~10	<p>The diagram illustrates three methods for determining the home position using a Home switch and a NOT switch. Each method shows a mechanical setup with a motor shaft and a home switch, and a corresponding timing diagram for the Index pulse, Home switch, and Positive limit switch (POT). The timing diagrams are labeled with 7, 8, 9, and 10, indicating specific points in the search process.</p> <p>Index pulse Home switch Positive limit switch (POT)</p>
11~14	<p>The methods described for 11 to 14 determines the Home position using the Home switch and the NOT switch.</p> <p>(11) Upper figure: If the NOT switch is Off, then the drive operates at switch search speed and rotates CW. If the Home switch is turned on at this time, it changes the direction of rotation, and the position that the first index pulse encounters while driving CCW at zero search speed becomes the Home position.</p> <p>(11) Middle figure: If the NOT switch is Off and the Home switch is On, then the drive operates at switch search speed and rotates CCW. If the Home switch is turned off at this time, it transfers to zero search speed. After the Home switch is turned off, the position that the first index pulse encounters while driving in the CCW direction becomes the Home position.</p> <p>(11) Lower figure: If the NOT switch is Off, then the drive operates at switch search speed and rotates CW. If the NOT switch is turned on at this time, it changes the direction and continues to drive CCW at switch search speed. If the Home switch is changed from On to Off, then it transfers to zero search speed, and the position that the first index pulse encounters becomes the Home position.</p> <p>The methods from 12 to 14 are identical to the methods for 11 in terms of how they determine the Home position. The only differences are the initial driving direction and Home switch polarity. Refer to the following figure.</p>

Value	Description
	<p>Index pulse</p> <p>Home switch</p> <p>Negative limit switch (NOT)</p>
24	<p>(8) The Home position is determined as in (8) method, but index pulse is not used. In addition, the point where the Home switch is On/Off becomes the Home position.</p> <p>Home switch</p> <p>Positive limit switch (POT)</p>

Value	Description
28	<p>(12) The Home position is determined as in (12) method, but index pulse is not used. In addition, the point where the Home switch is On/Off becomes the Home position.</p>  <p>Home switch</p> <p>Negative limit switch (NOT)</p>
33, 34	<p>The location that meets index pulse first during movement in the reverse direction CCW/forward direction CW becomes the Home position.</p>  <p>Index pulse</p>
35	<p>Homing operation starting point becomes the Home position.</p>

Note) — : Speed during search for switch (0x6099:01), → : Speed during search for zero (0x6099:02)

## 8.2 Type of Control Operation

Motion control modules execute control through programs set in motion control program. Kinds of motion control operations include speed position control, speed velocity control, speed torque control, interpolation control, switching control between position/velocity, switching control between position/torque, and switching control between velocity/torque.

### 8.2.1 Single-axis Position Control

It conducts position control of the axis specified after the execution by motion function block (「Relative position operation (MC\_MoveRelative)」 and 「Absolute position operation (MC\_MoveAbsolute)」) from starting position (current stop position) to target position (position of the point to move)

#### 1. Control by absolute coordinate method (「Absolute position operation (MC\_MoveAbsolute)」)

- (1) It conducts position control from starting position to target position (location specified in 'Position' of absolute position operation command).
- (2) The position control is carried out based on the position (the origin position) specified in the homing.
- (3) In direction (Direction) input, the direction to be operated is specified. It is valid only if operation parameter 「Infinite running repetition」 setting is '1: Enable'.

- Setting value: 0-Not specified, 1-Forward direction, 2-Shortest distance direction, 3-Reverse direction, 4-Current direction
- When the shortest direction distance is specified, the operation is made by selecting the direction that can go to the shortest direction automatically depending on the form of the axis.
- Motions according to the direction (Direction) input are as follows.

#### (a) 0- Not specified

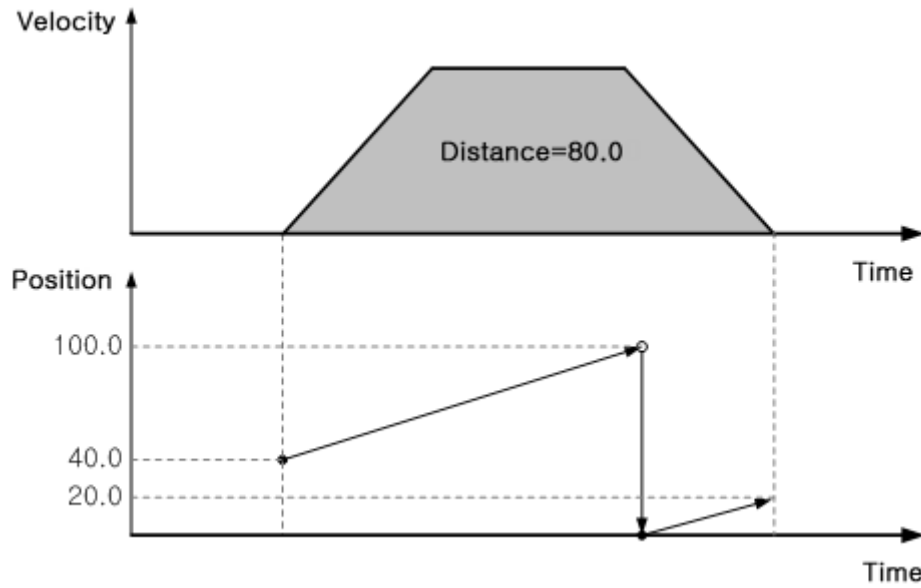
The position value that exceeds repetitive length repetition position can be specified. In case of setting the position value that exceeds the infinite running repetition position, the difference from target position to current position becomes positioning distance. The command position after the absolute position operation is calculated by the following equation.

$$\text{Command position} = \text{Target position} - (\text{Infinite running repetition position} \times n)$$

(n: Integer value in which infinite running repetition position x n does not exceed the target position)

[Example] The absolute position operation is executed with the following settings.

- Infinite running repetition position: 100.0
- Starting position: 40.0
- Target position: 120.0
- Command position after the absolute position operation =  $120.0 - (100.0 \times 1) = 20.0$

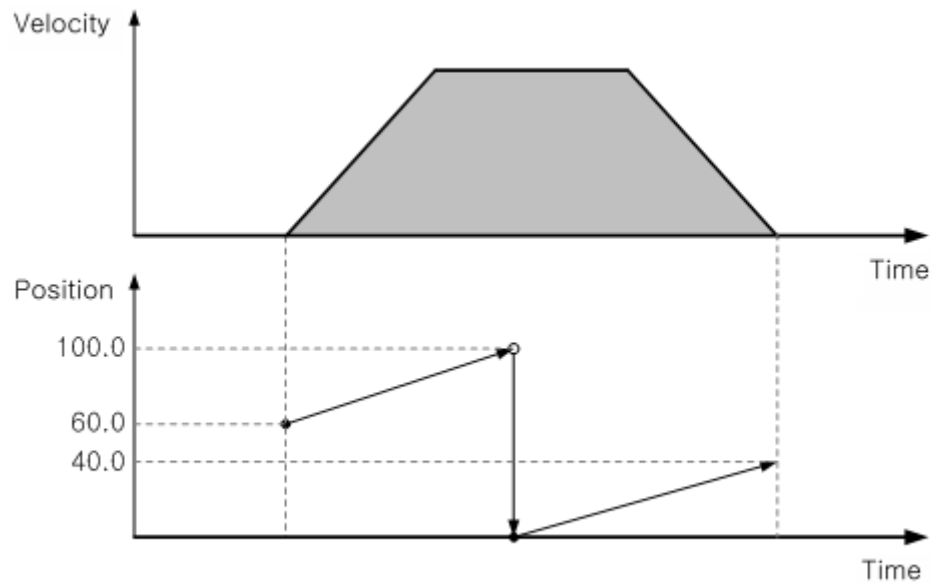


## (b) 1-Forward direction

Positioning is executed toward the absolute position of forward direction. In case the target position is set with the range that exceeds infinite running repetition position, error (error code: 0x1081) occurs.

[Example] The absolute position operation is executed with the following settings.

- Infinite running repetition position: 100.0
- Starting position: 60.0
- Target position: 40.0





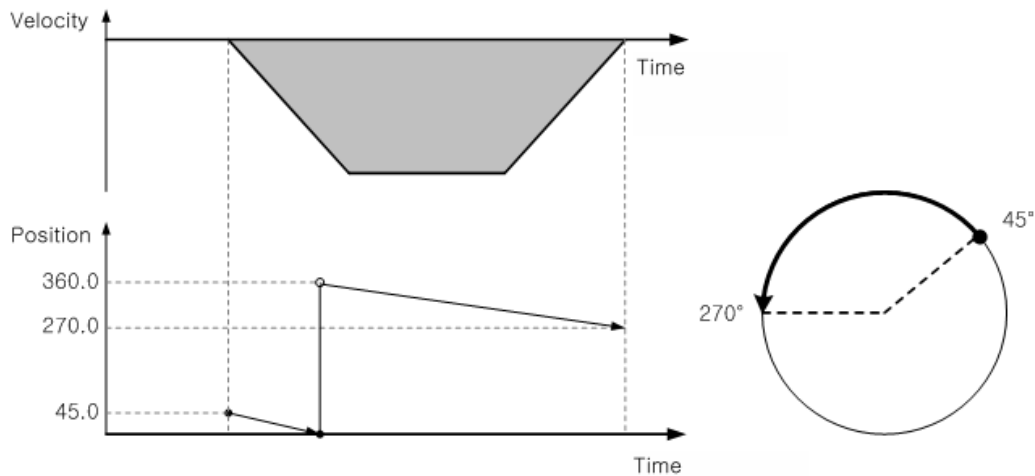
(c) 2-Shortest distance direction

Positioning is executed by automatically determining the direction of rotation possible to move through shorter distance from the starting position to target position. That is, positioning toward closer direction to target position based on the starting position is carried out.

In case the target position is set with the range that exceeds infinite running repetition position, error (error code: 0x1081) occurs.

[Example] The absolute position operation is executed with the following settings.

- Infinite running repetition position: 360.0
- Starting position: 45.0
- Target position: 270.0
- Since the movement distance is 225.0° in case of the operation in forward direction, and 135.0° in case of the operation in reverse direction, operation is made in reverse direction, the shortest distance direction.

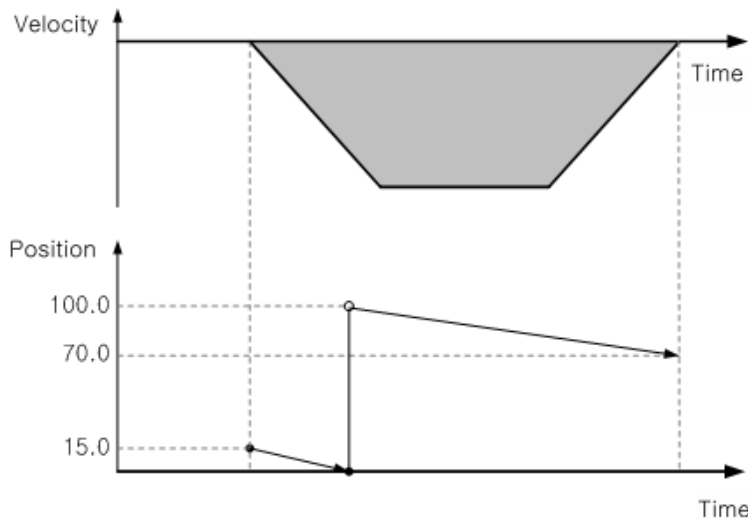


(d) 3-Reverse direction

Positioning is executed toward the absolute position of reverse direction. In case the target position is set with the range that exceeds infinite running repetition position, error (error code: 0x1081) occurs.

[Example] The absolute position operation is executed with the following settings.

- Infinite running repetition position: 100.0
- Starting position: 15.0
- Target position: 70.0



(e) 4- Current direction

Positioning is executed depending on the current operating direction.

In case the current operating direction is forward, operation is made in the same way as in Direction='1-forward direction' setting.

In case the current operating direction is reverse, operation is made in the same way as in Direction='3 reverse direction' setting.

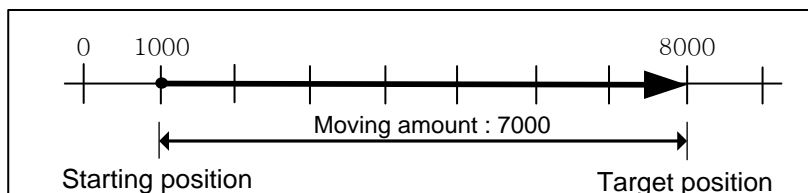
(4) In case operation parameter 「Infinite running repetition」 setting is '0: disable', operating direction is determined as follows.

- Starting position < target position: Positioning operation in forward direction
- Starting position > target position: Positioning operation in reverse direction

**[Example]** Executes Absolute coordinate, single-axis position control with the following setting

- ▷ Start position: 1000,
- ▷ Target position: 8000

The moving amount to forward direction is 7000 (7000=8000-1000).

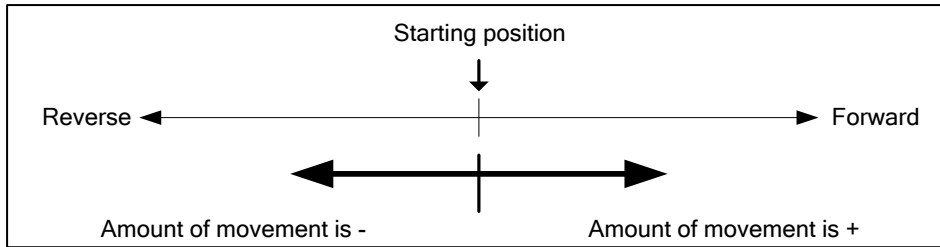


■ Relevant motion function block

Name	Description	Operation Condition
MC_MoveAbsolute	Absolute positioning operation	Edge
MC_MoveAbsolute		
BOOL	Execute	Done
UINT	Axis	Axis
BOOL	ContinuousUpdate	Busy
LREAL	Position	Active
LREAL	Velocity	CommandAborted
LREAL	Acceleration	Error
LREAL	Deceleration	ErrorID
LREAL	Jerk	
UINT	Direction	
UINT	BufferMode	

**2. Control by Incremental method ( 「Relative positioning operation(MC\_MoveRelative)」 )**

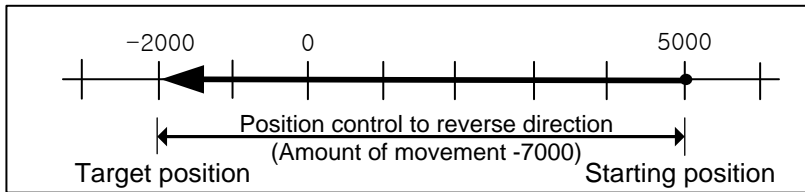
- (1) It moves the object as much as the target moving amount from start position. Unlike the target position of the absolute coordinate, the value specified on target position is not position value. That is a transfer amount from the starting position.
- (2) Transfer direction is determined by the sign of moving amount.
  - ▷ Transfer direction (+) or no sign: forward direction positioning (starting position increases)
  - ▷ Transfer direction (-) : reverse direction positioning (starting position decreases)



**[ Example ]** Executes Absolute coordinate, single-axis position control with the following setting

- ▷ Start position: 5000,
- ▷ Target position: -7000

It goes to reverse direction and stops at the -2000.



■ Relevant motion function block

Name	Description	Operation Condition
MC_MoveRelative	Relative positioning operation	Edge

MC_MoveRelative			
BOOL	Execute	Done	BOOL
UINT	Axis	Axis	UINT
BOOL	ContinuousUpdate	Busy	BOOL
LREAL	Distance	Active	BOOL
LREAL	Velocity	CommandAborted	BOOL
LREAL	Acceleration	Error	BOOL
LREAL	Deceleration	ErrorID	WORD
LREAL	Jerk		
UINT	BufferMode		

## 8.2.2 Single-axis Speed Control

Execution is made by motion function block(「Specified velocity operation (MC\_MoveVelocity)」), and operation is performed at the set velocity until stop condition is inputted.

### 1. Features of Control

- (1) Speed control operation of the specified axis is executed using specified velocity and acceleration/deceleration. The velocity control is executed through a method to transmit the target position value that corresponds to the target velocity using position control of servo drive.
- (2) In direction input, the direction to operate is specified.  
(However, the forward direction is based on the operating direction specified with the target velocity (Velocity) input. For example, if a negative value is specified in target velocity (Velocity) value, and reverse direction in direction (Direction) input, the axis is finally operated in forward direction.)
  - Setting value: 1-Forward, 2-Reverse, 3-Curent direction
- (3) Negative number can be set for target velocity (Velocity) input value. In case the target velocity setting value is negative number, operating direction becomes the opposite direction of the previously specified direction.
  - Forward operation
    - Velocity > 0, Direction=1: Forward
    - Velocity < 0, Direction=2: Reverse
  - Reverse operation
- (4) After reaching the target velocity, InVelocity output of the function block is On (On). If there is a pending command, the pending command is executed after InVelocity output is On.
- (5) The speed control which is currently being executed is stopped with halt (MC\_Halt) or immediate stop (MC\_Stop) motion function block.

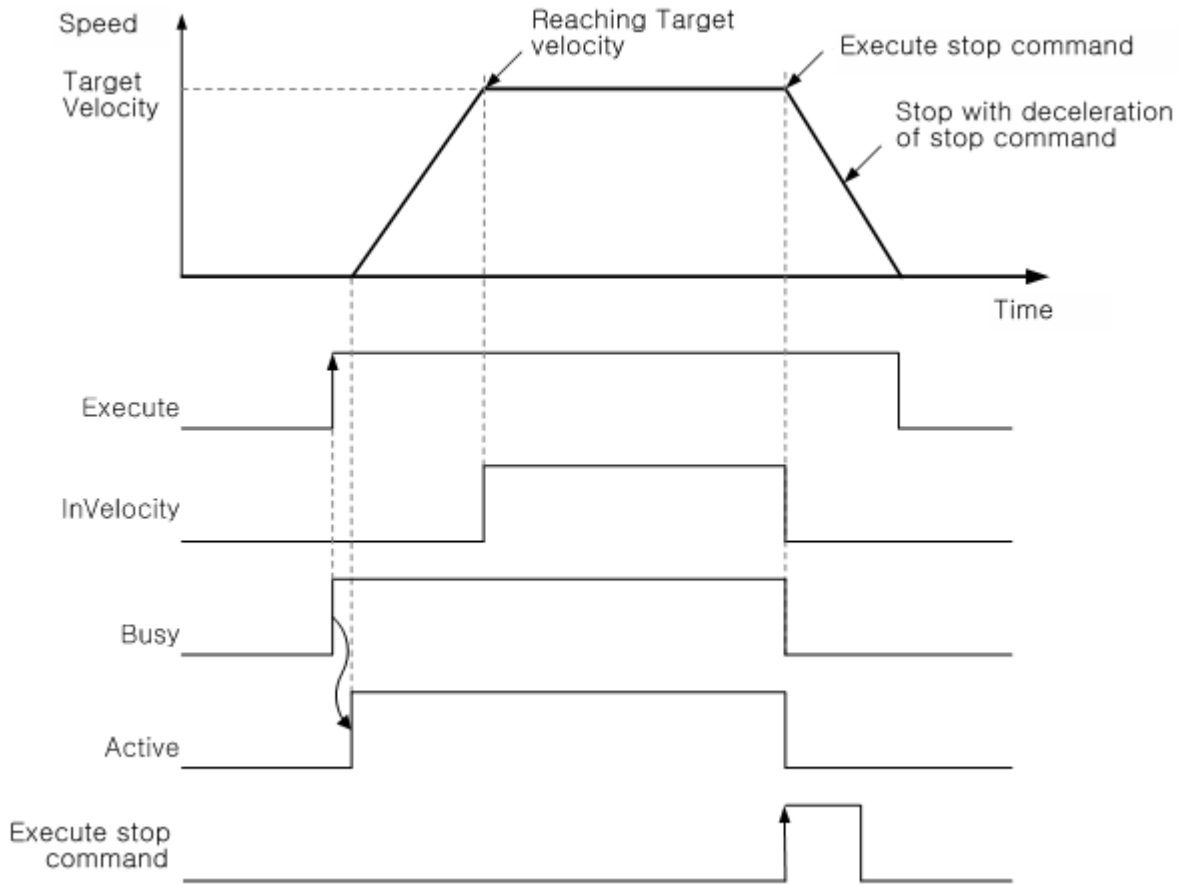
### 2. Relevant motion function block

Name	Description	Operation Condition
MC_MoveVelocity	Specified velocity operation	Edge

MC_MoveVelocity	
BOOL — Execute	InVelocity — BOOL
UINT — Axis	Axis — UINT
BOOL — ContinuousUpdate	Busy — BOOL
LREAL — Velocity	Active — BOOL
LREAL — Acceleration	CommandAborted — BOOL
LREAL — Deceleration	Error — BOOL
LREAL — Jerk	ErrorID — WORD
UINT — Direction	
UINT — BufferMode	

3. Operation Timing



### 8.2.3 Single-axis Torque Control

If motion function block(「Torque control(MC\_TorqueControl)」) is executed, torque control of the axis is made with the set torque value.

#### 1. Features of Control

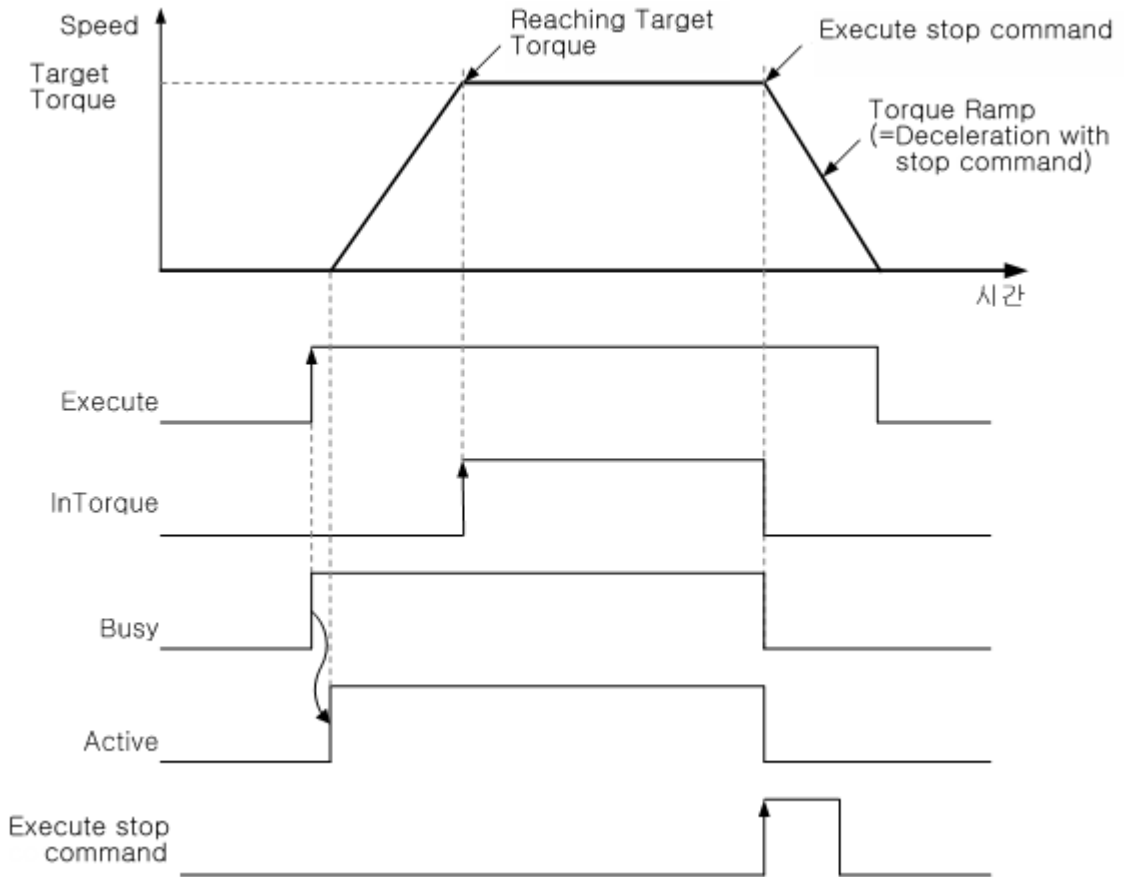
- (1) Torque control of the specified axis is made using target torque value and torque rising slope.
- (2) Torque rising slope (TorqueRamp) is the rate of change in torque per second to the target torque, and time to reach the target torque can be calculated as follows.  

$$\text{Time to reach the target torque(s)} = \text{target torque (Torque)} / \text{torque rising slope (TorqueRamp)}$$
- (3) Torque control mode is executed using torque control mode of servo drive.
- (4) Target torque values are rounded to two decimals and reflected in [0.1%] unit.
- (5) In Direction input, the direction to be operated is specified.  
 (However, the forward direction is based on the operating direction specified with the Torque input. For example, if a negative value is specified in Torque value, and reverse direction in direction (Direction) input, the axis is finally operated in forward direction.)
  - Setting value: 1-Forward, 2-Reverse, 3-Current direction
- (6) Negative number can be set for Torque (target torque) input value. In case the target torque setting value is negative number, operating direction becomes the opposite direction of the previously specified direction.
  - Forward operation
    - Torque > 0, Direction=1: Forward
    - Torque < 0, Direction=2: Reverse
  - Reverse operation
    - Torque > 0, Direction=2: Reverse
    - Torque < 0, Direction=1: Forward
- (7) The setting range of the torque values are as follows.  
 -1000.0 % ~ 1000 %
- (8) After reaching the target torque, InTorque output of function block is On. In case there is a pending command, the pending command is executed after InTorque output is On.
- (9) Torque control which is currently being executed is stopped with halt(MC\_Halt) or immediate stop (MC\_Stop) motion function block.

2. Relevant motion function block

Name	Description	Operation Condition
MC_TorqueControl	Torque Control	Edge
MC_TorqueControl		
BOOL	Execute	InTorque
UINT	Axis	Axis
BOOL	ContinuousUpdate	Busy
LREAL	Torque	Active
LREAL	TorqueRamp	CommandAborted
LREAL	Velocity	Error
LREAL	Acceleration	ErrorID
LREAL	Deceleration	
LREAL	Jerk	
UINT	Direction	
UINT	BufferMode	

3. Operation Timing



### 8.2.4 Specified Velocity Operation after Position Operation

Speed control of the axis specified after being executed by motion function block (「Specified speed operation after relative position operation (MC\_MoveContinuousRelative)」 and 「Specified speed operation after absolute position operation (MC\_MoveContinuousAbsolute)」) is carried out after the execution of position control that ends with end rate specified from starting position (current stop position) to target position (position of point to move) at the rate specified in end velocity (EndVelocity) if there are no pending commands.

#### 1. Features of Control

- (1) Position control that ends with end rate specified from starting position to target position is carried out. .
- (2) Position control is executed based on position (the origin position) specified in the homing.
- (3) In case of 「Specified speed operation after the absolute position operation (MC\_MoveContinuousAbsolute)」, the direction to operate is specified in Direction input, which is valid only if operation parameter 「Infinite running repetition」 is set to '1: Enable'.
  - Setting value: 0-Not specified, 1-Forward, 2-Shortest distance direction, 3-Reverse, 4-Current direction
- (4) The end rate is reached after the completion of position control operation to target position, InEndVelocity output of function block is On. If there is a pending command, the pending command is executed after InEndVelocity output is On.

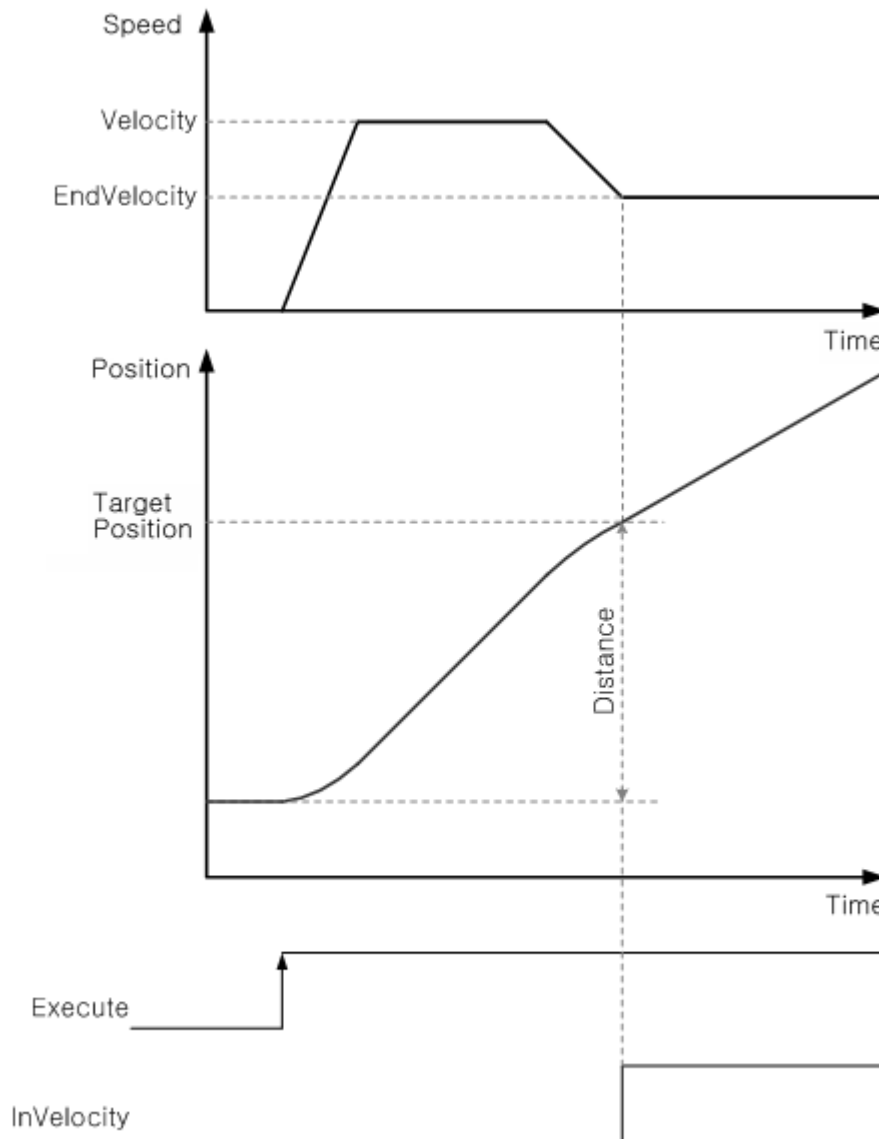
#### 2. Relevant motion function block

Name	Description	Operation Condition
MC_MoveContinuousAbsolute	Specified velocity operation after Absolute position operation	Edge
MC_MoveContinuousAbsolute		
BOOL	Execute	InEndVelocity
UINT	Axis	Axis
BOOL	ContinuousUpdate	Busy
LREAL	Position	Active
LREAL	EndVelocity	CommandAborted
LREAL	Velocity	Error
LREAL	Acceleration	ErrorID
LREAL	Deceleration	
LREAL	Jerk	
UINT	Direction	
UINT	BufferMode	



Name	Description	Operation Condition																																												
MC_MoveContinuousRelative	Specified velocity operation after Relative position operation	Edge																																												
<table border="1"> <thead> <tr> <th colspan="4">MC_MoveContinuousRelative</th> </tr> </thead> <tbody> <tr> <td>BOOL</td> <td>Execute</td> <td>InEndVelocity</td> <td>BOOL</td> </tr> <tr> <td>UINT</td> <td>Axis</td> <td>Axis</td> <td>UINT</td> </tr> <tr> <td>BOOL</td> <td>ContinuousUpdate</td> <td>Busy</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Distance</td> <td>Active</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>EndVelocity</td> <td>CommandAborted</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Velocity</td> <td>Error</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Acceleration</td> <td>ErrorID</td> <td>WORD</td> </tr> <tr> <td>LREAL</td> <td>Deceleration</td> <td></td> <td></td> </tr> <tr> <td>LREAL</td> <td>Jerk</td> <td></td> <td></td> </tr> <tr> <td>UINT</td> <td>BufferMode</td> <td></td> <td></td> </tr> </tbody> </table>			MC_MoveContinuousRelative				BOOL	Execute	InEndVelocity	BOOL	UINT	Axis	Axis	UINT	BOOL	ContinuousUpdate	Busy	BOOL	LREAL	Distance	Active	BOOL	LREAL	EndVelocity	CommandAborted	BOOL	LREAL	Velocity	Error	BOOL	LREAL	Acceleration	ErrorID	WORD	LREAL	Deceleration			LREAL	Jerk			UINT	BufferMode		
MC_MoveContinuousRelative																																														
BOOL	Execute	InEndVelocity	BOOL																																											
UINT	Axis	Axis	UINT																																											
BOOL	ContinuousUpdate	Busy	BOOL																																											
LREAL	Distance	Active	BOOL																																											
LREAL	EndVelocity	CommandAborted	BOOL																																											
LREAL	Velocity	Error	BOOL																																											
LREAL	Acceleration	ErrorID	WORD																																											
LREAL	Deceleration																																													
LREAL	Jerk																																													
UINT	BufferMode																																													

3. Operation Timing



## 8.2.5 Switching Control

In motion control module, switching control means real-time control switch between position control / velocity control / torque control. In case the control mode that is currently being executed (position control, velocity control, torque control) are intended to change to a different control mode immediately, BufferMode of commands is to be set to Aborting, and relevant motion function block is to be executed.

### 1. Position-velocity switching control

When specified speed operation (MC\_MoveVelocity) is executed in the axis in absolute/relative position operation, the position control is switched to velocity control. The velocity at the time of being changed to velocity control is operated continuously from the velocity operated with the previous position control to the target velocity of the current velocity control. The next operation can be continued by conducting halt (MC\_Halt) during operation with velocity control, performing operation stop with immediate stop (MC\_Stop) motion function block or executing other motion function block. .

### 2. Velocity-position switching control

When absolute/relative/additive position control (MC\_MoveAbsolute, MC\_MoveRelative, MC\_MoveAdditive) motion function block is executed in the axis in specified speed operation during velocity control, the velocity control is switched to position control. The velocity at the time of being changed to position control is operated continuously from the velocity operated with the previous velocity control to the target velocity of the current position control. The next operation can be continued by conducting halt (MC\_Halt) during operation with position control, performing operation stop with immediate stop (MC\_Stop) motion function block or executing other motion function block.

### 3. Position-torque switching control

When torque control (MC\_TorqueControl) motion function block is executed in the axis in absolute/relative position operation during position control, the position control is switched to torque control. The torque at the time of being changed to torque control is operated continuously from the current torque value operated with the previous position control to the target torque of the torque control. The next operation can be continued by conducting halt (MC\_Halt) during operation with torque control, performing operation stop with immediate stop (MC\_Stop) motion function block or executing other motion function block.

### 4. Torque-position switching control

When absolute/relative/additive position control (MC\_MoveAbsolute, MC\_MoveRelative, MC\_MoveAdditive) motion function block is executed in the axis in torque control operation, the torque control is switched to position control, when torque value is reduced to 0, and position control continues to operate after a stop. The next operation can be continued by conducting halt (MC\_Halt) during operation with position control, performing operation stop with immediate stop (MC\_Stop) motion function block or executing other motion function block.

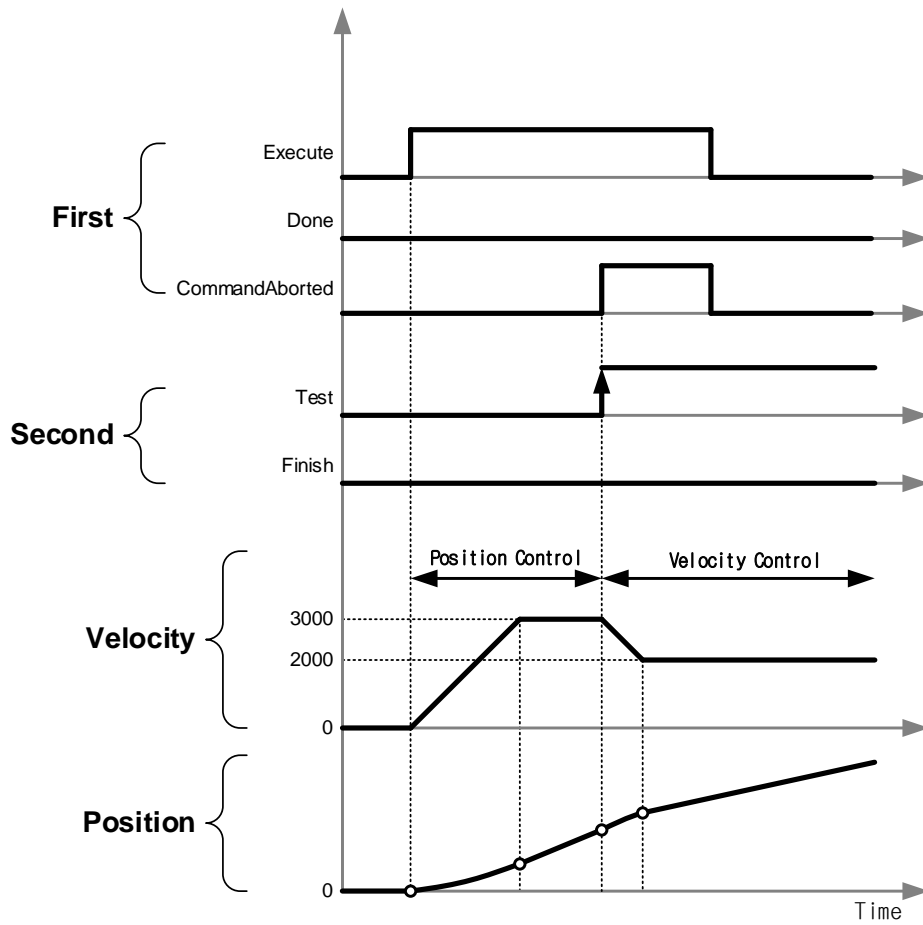
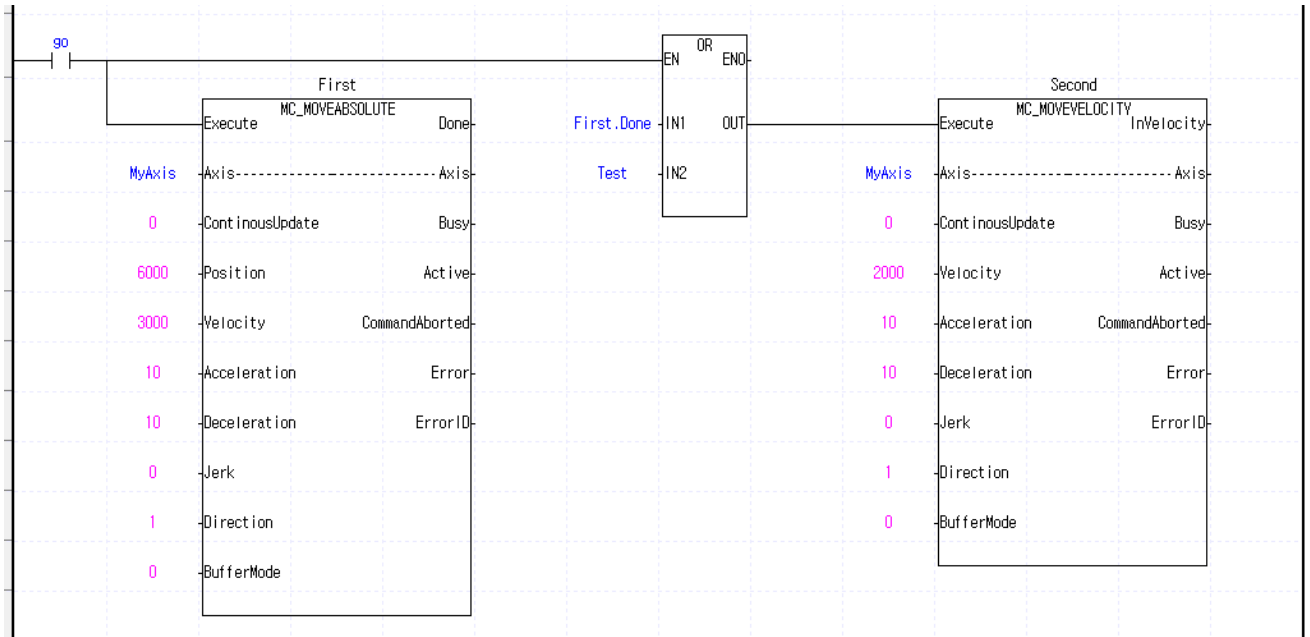
### 5. Velocity –torque switching control

When torque control (MC\_TorqueControl) motion function block is executed in the axis in specified speed operation during velocity control, the velocity control is switched to torque control. The torque at the time of being changed to torque control is operated continuously from the current torque value operated with the previous velocity control to the target torque of the torque control. The next operation can be continued by conducting halt (MC\_Halt) during operation with torque control, performing operation stop with immediate stop (MC\_Stop) motion function block or executing other motion function block.

### 6. Torque- velocity switching control

When specified speed operation (MC\_MoveVelocity) motion function block is executed in the axis in torque control operation during speed control, the torque control is switched to velocity control, when torque value is reduced to 0, and velocity control continues to operate after a stop. The next operation can be continued by conducting halt (MC\_Halt) during operation with velocity control, performing operation stop with immediate stop (MC\_Stop) motion function block or executing other motion function block.

7. Example of using switching control



### 8.2.6 Axis Group Control

Axis group control is a function to control the trajectory of moving objects by setting involved multiple axes into one axis group. For axis group control, axis group is to be set.

Axis group operation includes linear interpolation, circular interpolation and helical interpolation.

As for coordinate system in which axis group control is operated, only Cartesian coordinate system is supported

#### 1. Axis group settings

For axis group control, axis group should be set and enabled prior to the execution of operation.

Configuration axis can be specified, and axis group is set using XG-PM. In addition, the use of motion function block makes it possible to add axes to axis group or remove them from it.

When axis group is configured, axis group operation can be executed after enabling the axis group.

##### (1) Add axis to group

It means adding an axis to the axis group. The configuration axis specified into IdentInGroup is added to the axis group specified in AxesGroup input.

It can be executed only in case where the axis group is in group disablement (GroupDisabled) and group standby (GroupStandBy) state.

Name	Description	Operation Condition														
MC_AddAxisToGroup	Add axis to group	Edge														
<table border="1" style="margin: auto;"> <thead> <tr> <th colspan="2">MC_AddAxisToGroup</th> </tr> </thead> <tbody> <tr> <td>BOOL Execute</td> <td>Done</td> </tr> <tr> <td>UINT AxesGroup</td> <td>Axis</td> </tr> <tr> <td>UINT Axis</td> <td>Axis</td> </tr> <tr> <td>UINT IdentInGroup</td> <td>Busy</td> </tr> <tr> <td></td> <td>Error</td> </tr> <tr> <td></td> <td>ErrorID</td> </tr> </tbody> </table>			MC_AddAxisToGroup		BOOL Execute	Done	UINT AxesGroup	Axis	UINT Axis	Axis	UINT IdentInGroup	Busy		Error		ErrorID
MC_AddAxisToGroup																
BOOL Execute	Done															
UINT AxesGroup	Axis															
UINT Axis	Axis															
UINT IdentInGroup	Busy															
	Error															
	ErrorID															

##### (2) Remove axis from group

It means removing an axis from the axis group. The configuration axis specified into IdentInGroup is removed from the axis group specified in AxesGroup input.

It can be executed only in case where the axis group is in group disablement (GroupDisabled) and group standby (GroupStandBy) state.

In case there are no remaining axes in the axis group, the axis group is changed to disabled state.

Name	Description	Operation Condition												
MC_RemoveAxisToGroup	Remove axis from group	Edge												
<table border="1" style="margin: auto;"> <thead> <tr> <th colspan="2">MC_RemoveAxisFromGroup</th> </tr> </thead> <tbody> <tr> <td>BOOL Execute</td> <td>Done</td> </tr> <tr> <td>UINT AxesGroup</td> <td>Axis</td> </tr> <tr> <td>UINT IdentInGroup</td> <td>Busy</td> </tr> <tr> <td></td> <td>Error</td> </tr> <tr> <td></td> <td>ErrorID</td> </tr> </tbody> </table>			MC_RemoveAxisFromGroup		BOOL Execute	Done	UINT AxesGroup	Axis	UINT IdentInGroup	Busy		Error		ErrorID
MC_RemoveAxisFromGroup														
BOOL Execute	Done													
UINT AxesGroup	Axis													
UINT IdentInGroup	Busy													
	Error													
	ErrorID													

##### (3) Remove all axes from group

It means removing all axes from the axis group.

Name	Description	Operation Condition																		
MC_UngroupAllAxes	Remove all axes from group	Edge																		
<table border="1" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th colspan="3">MC_UngroupAllAxes</th> </tr> </thead> <tbody> <tr> <td>BOOL</td> <td>Execute</td> <td>Done</td> </tr> <tr> <td>UINT</td> <td>AxesGroup</td> <td>----- AxesGroup</td> </tr> <tr> <td></td> <td></td> <td>Busy</td> </tr> <tr> <td></td> <td></td> <td>Error</td> </tr> <tr> <td></td> <td></td> <td>ErrorID</td> </tr> </tbody> </table>			MC_UngroupAllAxes			BOOL	Execute	Done	UINT	AxesGroup	----- AxesGroup			Busy			Error			ErrorID
MC_UngroupAllAxes																				
BOOL	Execute	Done																		
UINT	AxesGroup	----- AxesGroup																		
		Busy																		
		Error																		
		ErrorID																		

(4) Enable Group

It changes the status to enabled state in which axis group command can be executed.

The axis group cannot be enabled in the following cases.

- In case there is no axis group configuration axis, or axes included in the axis group is not connected to network
- In case the configuration axis of the axis group to be enabled belongs to other enabled axis group
- In case there is an axis in operation among configuration axes in the axis group
- In case the 'unit' of configuration axes in the axis group is not the same

Name	Description	Operation Condition																		
MC_GroupEnable	Enable group	Edge																		
<table border="1" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th colspan="3">MC_GroupEnable</th> </tr> </thead> <tbody> <tr> <td>BOOL</td> <td>Execute</td> <td>Done</td> </tr> <tr> <td>UINT</td> <td>AxesGroup</td> <td>----- AxesGroup</td> </tr> <tr> <td></td> <td></td> <td>Busy</td> </tr> <tr> <td></td> <td></td> <td>Error</td> </tr> <tr> <td></td> <td></td> <td>ErrorID</td> </tr> </tbody> </table>			MC_GroupEnable			BOOL	Execute	Done	UINT	AxesGroup	----- AxesGroup			Busy			Error			ErrorID
MC_GroupEnable																				
BOOL	Execute	Done																		
UINT	AxesGroup	----- AxesGroup																		
		Busy																		
		Error																		
		ErrorID																		

(5) Disable Group

It changes the axis group to be group disabled state.

In case the axis group is in operation, the axis group is changed to be disabled state after the immediate stop.

Name	Description	Operation Condition																		
MC_GroupDisable	Disable group	Edge																		
<table border="1" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th colspan="3">MC_GroupDisable</th> </tr> </thead> <tbody> <tr> <td>BOOL</td> <td>Execute</td> <td>Done</td> </tr> <tr> <td>UINT</td> <td>AxesGroup</td> <td>----- AxesGroup</td> </tr> <tr> <td></td> <td></td> <td>Busy</td> </tr> <tr> <td></td> <td></td> <td>Error</td> </tr> <tr> <td></td> <td></td> <td>ErrorID</td> </tr> </tbody> </table>			MC_GroupDisable			BOOL	Execute	Done	UINT	AxesGroup	----- AxesGroup			Busy			Error			ErrorID
MC_GroupDisable																				
BOOL	Execute	Done																		
UINT	AxesGroup	----- AxesGroup																		
		Busy																		
		Error																		
		ErrorID																		

## 8.2.7 Linear Interpolation Control

Interpolation of multiple axes from starting point (current stop position) to target position is performed with linear trajectory by using relevant axes set in the axis group.

Linear interpolation can be performed up to 4 axes.

### 1. Linear interpolation control with absolute coordinates

( 「Absolute positioning linear interpolation operation(MC\_MoveLinearAbsolute)」 )

- (1) Executes linear interpolation from starting position to the target position designated on positioning data. Positioning control is carried out based on the position specified from homing.
- (2) The direction of movement depends on the starting position and the target position for each axis.
  - Starting position < target position: Positioning operation in forward
  - Starting position > target position: Positioning operation in reverse

오류! 편집 중 필드 코드에서는 개체를 만들 수 없습니다.

- (3) Interpolation that is currently being executed is stopped with group halt (MC\_GroupHalt) or group immediate stop (MC\_GroupStop) motion function block.
- (4) The speed value set in absolute position liner interpolation operation (MC\_MoveLinearAbsolute) motion function block means synthesis rate of axes that make up the axis group.

Speed of each-axis and operating speed are as follows.

$$\text{Interpolating speed } (F) = \text{Operationspeedsetinpositiondata}$$

$$\text{Interpolatingmovingamount } (S) = \sqrt{S_x^2 + S_y^2 + S_z^2}$$

$$\text{Mainaxis speed } (V_x) = \text{Interpolatingspeed } (F) \times \frac{\text{Main axis moving amount } (S_x)}{\text{Interpolatingmovingamount } (S)}$$

$$\text{Sub - axis1 speed } (V_y) = \text{Interpolatingspeed } (F) \times \frac{\text{Sub - axis1 moving amount } (S_y)}{\text{Interpolatingmovingamount } (S)}$$

$$\text{Sub - axis2 speed } (V_z) = \text{Interpolatingspeed } (F) \times \frac{\text{Sub - axis2 moving amount } (S_z)}{\text{Interpolatingmovingamount } (S)}$$

(5) Relevant motion function block

Name	Description	Operation Condition																						
MC_MoveLinearAbsolute	Absolute positioning linear interpolation operation	Edge																						
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2">MC_MoveLinearAbsolute</th> </tr> </thead> <tbody> <tr> <td>BOOL - Execute</td> <td>Done - BOOL</td> </tr> <tr> <td>UINT - AxesGroup</td> <td>----- AxesGroup - UINT</td> </tr> <tr> <td>LREAL[] - Position</td> <td>Busy - BOOL</td> </tr> <tr> <td>LREAL - Velocity</td> <td>Active - BOOL</td> </tr> <tr> <td>LREAL - Acceleration</td> <td>CommandAborted - BOOL</td> </tr> <tr> <td>LREAL - Deceleration</td> <td>Error - BOOL</td> </tr> <tr> <td>LREAL - Jerk</td> <td>ErrorID - WORD</td> </tr> <tr> <td>UINT - BufferMode</td> <td></td> </tr> <tr> <td>UINT - TransitionMode</td> <td></td> </tr> <tr> <td>LREAL - TransitionParameter</td> <td></td> </tr> </tbody> </table>			MC_MoveLinearAbsolute		BOOL - Execute	Done - BOOL	UINT - AxesGroup	----- AxesGroup - UINT	LREAL[] - Position	Busy - BOOL	LREAL - Velocity	Active - BOOL	LREAL - Acceleration	CommandAborted - BOOL	LREAL - Deceleration	Error - BOOL	LREAL - Jerk	ErrorID - WORD	UINT - BufferMode		UINT - TransitionMode		LREAL - TransitionParameter	
MC_MoveLinearAbsolute																								
BOOL - Execute	Done - BOOL																							
UINT - AxesGroup	----- AxesGroup - UINT																							
LREAL[] - Position	Busy - BOOL																							
LREAL - Velocity	Active - BOOL																							
LREAL - Acceleration	CommandAborted - BOOL																							
LREAL - Deceleration	Error - BOOL																							
LREAL - Jerk	ErrorID - WORD																							
UINT - BufferMode																								
UINT - TransitionMode																								
LREAL - TransitionParameter																								

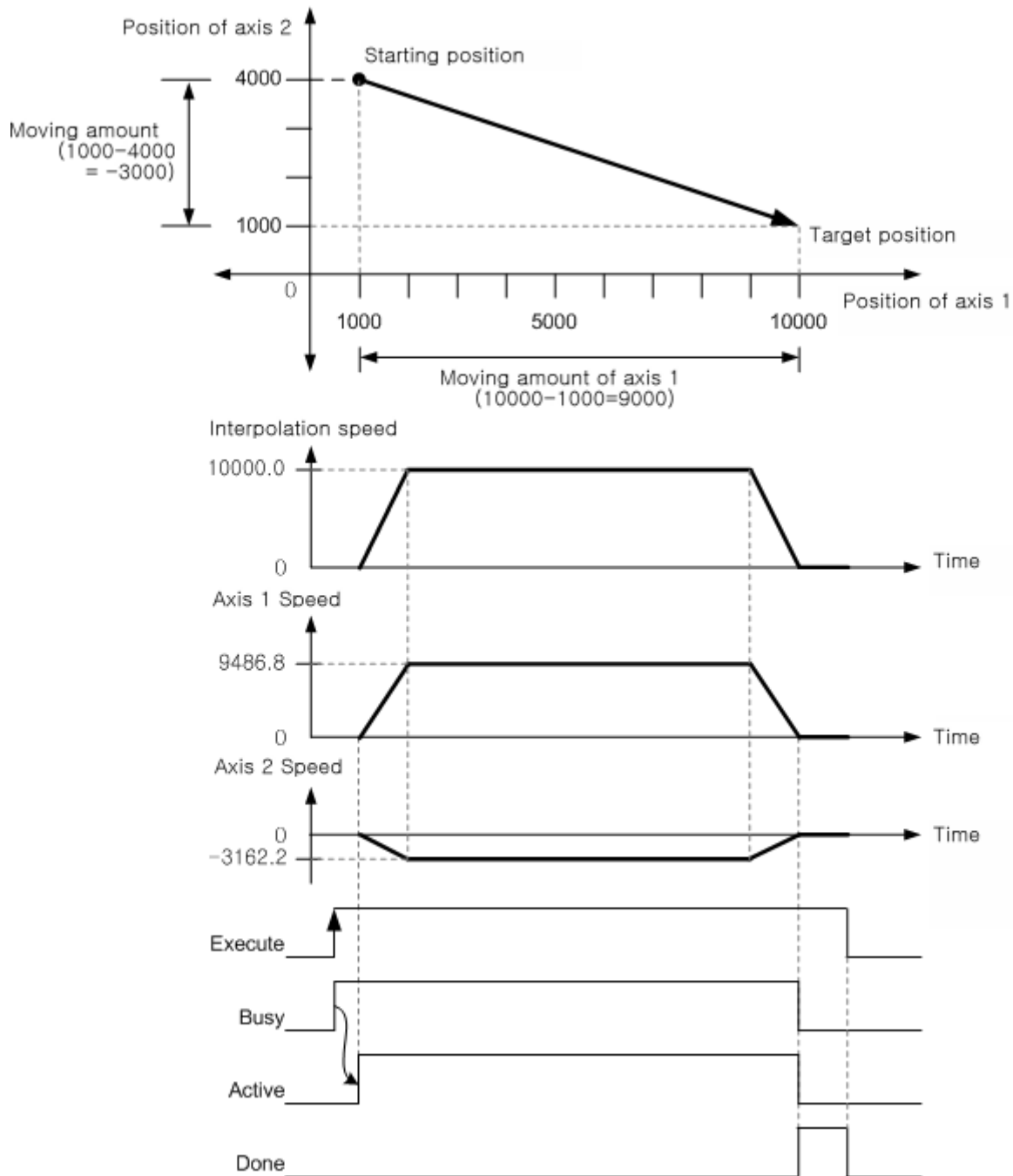
(6) Restrictions

Linear interpolation by absolute coordinate system cannot be executed in the following cases.

- In case there is an axis which is in the origin indetermination state among configuration axes (error code: 0x2090)
- In case the operation speed of configuration axis exceeds the speed limit of each axis (error code: 0x2091)
- In case there is an axis in infinite running repetition operation among configuration axes (error code: 0x2094)

(7) Operation Timing

- Starting position: (1000.0, 4000.0)
- Target position: (10000.0, 1000.0)
- Target velocity: 10000.0



※ Velocity of each configuration axis is approximate estimate.



2. Linear interpolation control with relative coordinates

( 「Relative positioning interpolation operation (MC\_MoveLinearRelative)」 )

- (1) Linear interpolation is executed from starting position to movement direction targeted by each axis and position that includes movement direction. Positioning control is based on the current stop position.
- (2) Movement direction is determined by the sign set in the target position (movement distance) of each axis.
  - When the sign of movement distance is positive (+ or no sign): Positioning operation in forward direction (starting position increase direction)
  - When the sign of movement distance is negative ( - ):Positioning operation in reverse direction (starting position decrease direction)
- (3) Interpolation that is currently being executed is stopped with group halt (MC\_GroupHalt) or group immediate stop (MC\_GroupStop) motion function block.
- (4) The speed value set in relative position liner interpolation operation (MC\_MoveLinearRelative) motion function block means interpolation speed.

오류! 편집 중 필드 코드에서는 개체를 만들 수 없습니다.

The operation speed of each configuration axis is calculated as follows.

$$\text{Interpolating speed } (F) = \text{Operationspeedsetinpositiondata}$$

$$\text{Interpolatingmovingamount}(S) = \sqrt{S_x^2 + S_y^2 + S_z^2}$$

$$\text{Mainaxis speed}(V_x) = \text{Interpolatingspeed } (F) \times \frac{\text{Main axis moving amount}(S_x)}{\text{Interpolatingmovingamount}(S)}$$

$$\text{Sub - axis1 speed}(V_y) = \text{Interpolatingspeed } (F) \times \frac{\text{Sub - axis1 moving amount}(S_y)}{\text{Interpolatingmovingamount}(S)}$$

$$\text{Sub - axis2 speed}(V_z) = \text{Interpolatingspeed } (F) \times \frac{\text{Sub - axis2 moving amount}(S_z)}{\text{Interpolatingmovingamount}(S)}$$

(5) Relevant motion function block

Name	Description	Operation Condition																																												
MC_MoveLinearRelative	Relative positioning linear interpolation operation	Edge																																												
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: center;">MC_MoveLinearRelative</th> </tr> </thead> <tbody> <tr> <td style="width: 15%;">BOOL</td> <td style="width: 35%;">Execute</td> <td style="width: 35%;">Done</td> <td style="width: 15%;">BOOL</td> </tr> <tr> <td>UINT</td> <td>AxesGroup</td> <td>----- AxesGroup</td> <td>UINT</td> </tr> <tr> <td>LREAL[]</td> <td>Distance</td> <td>Busy</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Velocity</td> <td>Active</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Acceleration</td> <td>CommandAborted</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Deceleration</td> <td>Error</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>Jerk</td> <td>ErrorID</td> <td>WORD</td> </tr> <tr> <td>UINT</td> <td>BufferMode</td> <td></td> <td></td> </tr> <tr> <td>UINT</td> <td>TransitionMode</td> <td></td> <td></td> </tr> <tr> <td>LREAL</td> <td>TransitionParameter</td> <td></td> <td></td> </tr> </tbody> </table>			MC_MoveLinearRelative				BOOL	Execute	Done	BOOL	UINT	AxesGroup	----- AxesGroup	UINT	LREAL[]	Distance	Busy	BOOL	LREAL	Velocity	Active	BOOL	LREAL	Acceleration	CommandAborted	BOOL	LREAL	Deceleration	Error	BOOL	LREAL	Jerk	ErrorID	WORD	UINT	BufferMode			UINT	TransitionMode			LREAL	TransitionParameter		
MC_MoveLinearRelative																																														
BOOL	Execute	Done	BOOL																																											
UINT	AxesGroup	----- AxesGroup	UINT																																											
LREAL[]	Distance	Busy	BOOL																																											
LREAL	Velocity	Active	BOOL																																											
LREAL	Acceleration	CommandAborted	BOOL																																											
LREAL	Deceleration	Error	BOOL																																											
LREAL	Jerk	ErrorID	WORD																																											
UINT	BufferMode																																													
UINT	TransitionMode																																													
LREAL	TransitionParameter																																													

(6) Restrictions

Linear interpolation by relative coordinate system cannot be executed in the following cases.

- In case there is an axis in infinite running repetition operation among configuration axes (error code: 0x2094)
- In case the operation speed of configuration axis exceeds the speed limit of each axis (error code: 0x2091)

## 8.2.8 Circular Interpolation Control

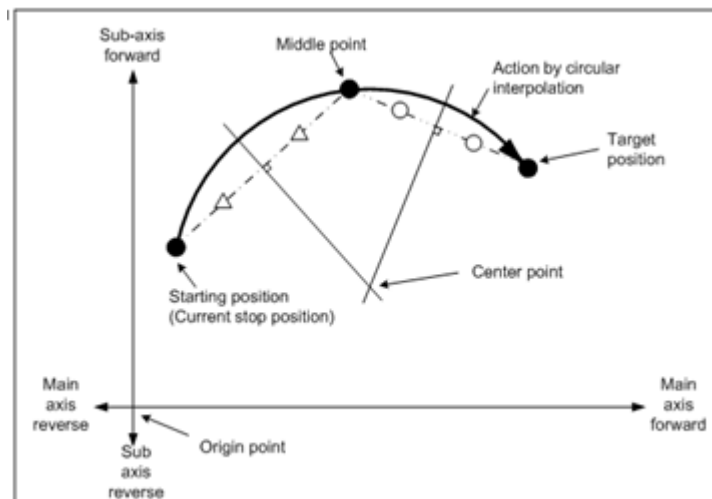
Interpolation operation is performed along the trajectory of the circle in the direction of axis progress set by using two axes set in the axis group.

There are three kinds of methods for circular interpolation such as midpoint method that passes through the position specified in auxiliary point, center point method that considers the position specified in auxiliary point as center point and radius method that takes the value specified in auxiliary point as the radius of an arc depending on 'CircMode' settings and auxiliary points.

The interpolation that is currently being executed is stopped with group halt (MC\_GroupHalt) or group immediate stop (MC\_GroupStop) motion function block.

### 1. Circular interpolation using midpoint specification method

- (1) Circular interpolation is executed from starting position to target position through midpoint position set in auxiliary point.
- (2) The trajectory of the arc that takes an intersecting point caused by the vertical bisection of starting position and midpoint position, and midpoint position and target position is created.
- (3) Movement direction is automatically determined in accordance with the set target position and auxiliary point of circular interpolation.

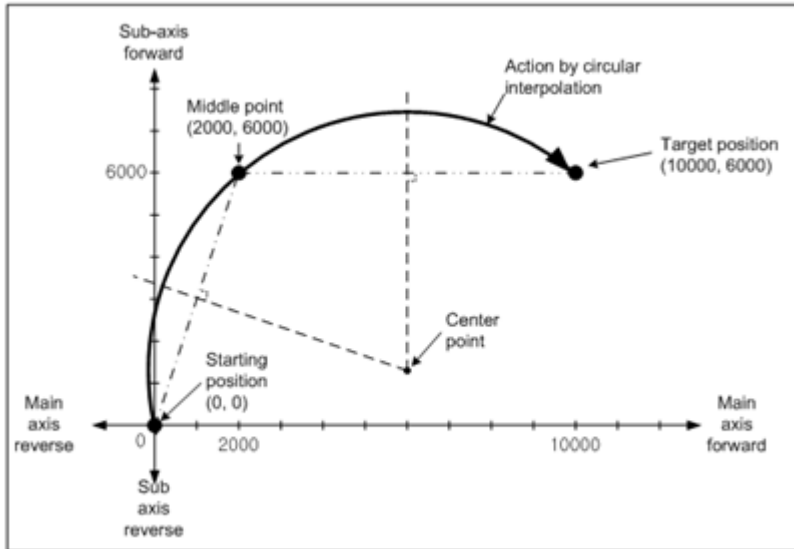


### (4) Restrictions

Circular interpolation by midpoint specification method cannot be executed in the following cases.

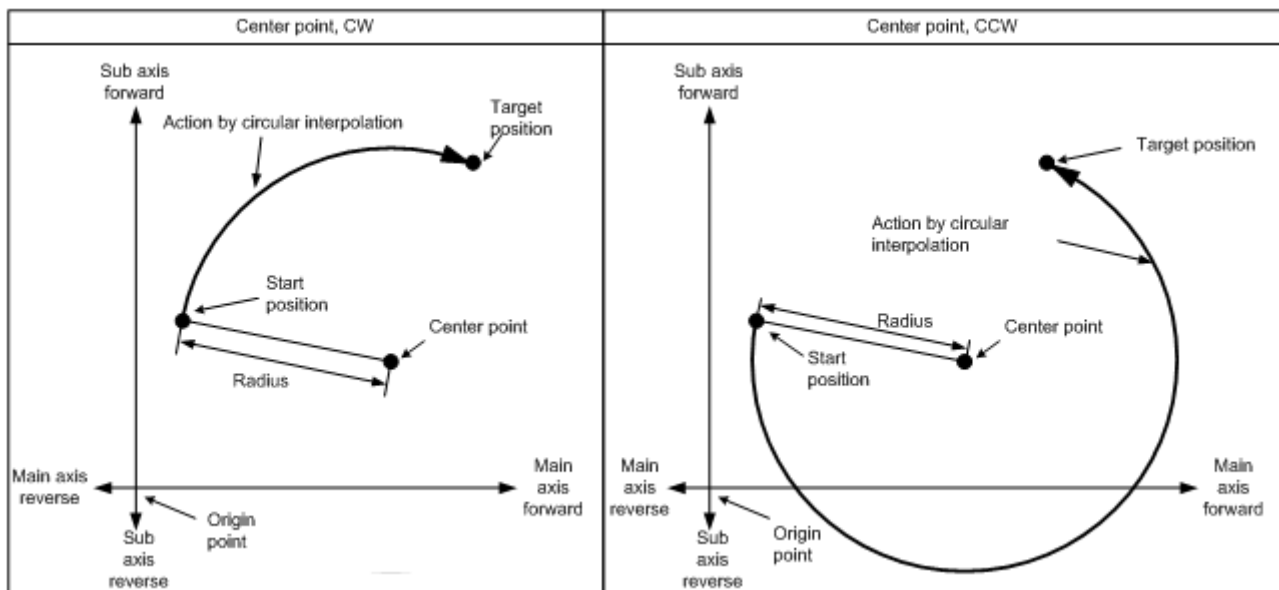
- In case there is an axis which is in the origin undetermined state among configuration axes at the time of absolute coordinate circular interpolation operation (error code: 0x20A0)
- In case the midpoint specified as auxiliary point is the same as the starting position or target position (error code: 0x20A4)
- In case starting position is the same as the target position (error code: 0x20A5)
- In case the calculated radius of the arc exceeds 2147483647pls (error code: 0x20A6)
- In case starting position, auxiliary point position and target position are in a straight line (error code: 0x20A7)
- In case there is an axis in infinite running repetition operation among configuration axes (error code: 0x20A8)
- In case the number of configuration axes in the axis group is four (error code: 0x20A9)
- In case axis group configuration settings are not set in order (error code: 0x20AA)

- (5) Operation pattern
- Starting position: (0.0, 0.0)
  - Target position: (10000.0, 6000.0)
  - Middle point: (2000.0, 6000.0)
  - Method(CircMode): Mid point(0)
  - Direction(PathChoice): - (Ignored in mid point method)



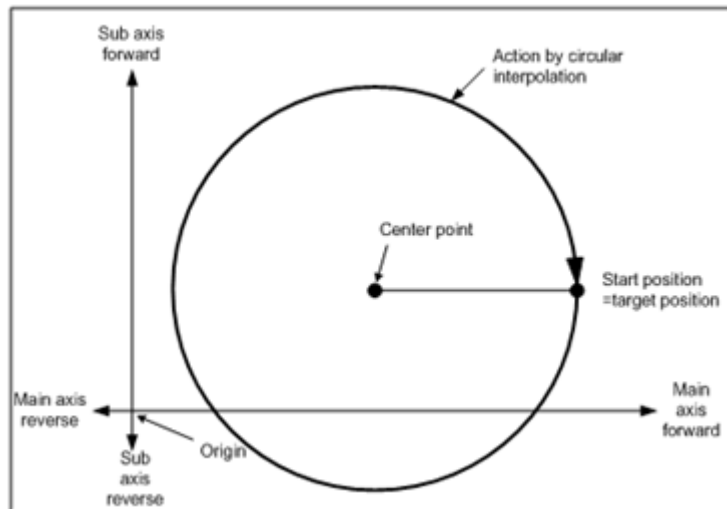
**2. Circular interpolation using center point specification method**

- (1) Circular interpolation is performed from starting position to target position along the trajectory of the arc that takes the distance to the specified center point position as radius.
- (2) Movement direction is determined by the direction set in "PathChoice" of absolute position circular interpolation operation (MC\_MoveCircularAbsolute) or relative position circular interpolation operation (MC\_MoveCircularRelative) motion function block.
  - 0: 「CW」 - Circular interpolation is executed from the starting position in a clockwise direction.
  - 1: 「CCW」 - Circular interpolation is executed from the starting position in a counterclockwise direction.



- (3) If target position is same as start position, you can execute circular interpolation whose circle radius is distance

from center point to starting position.



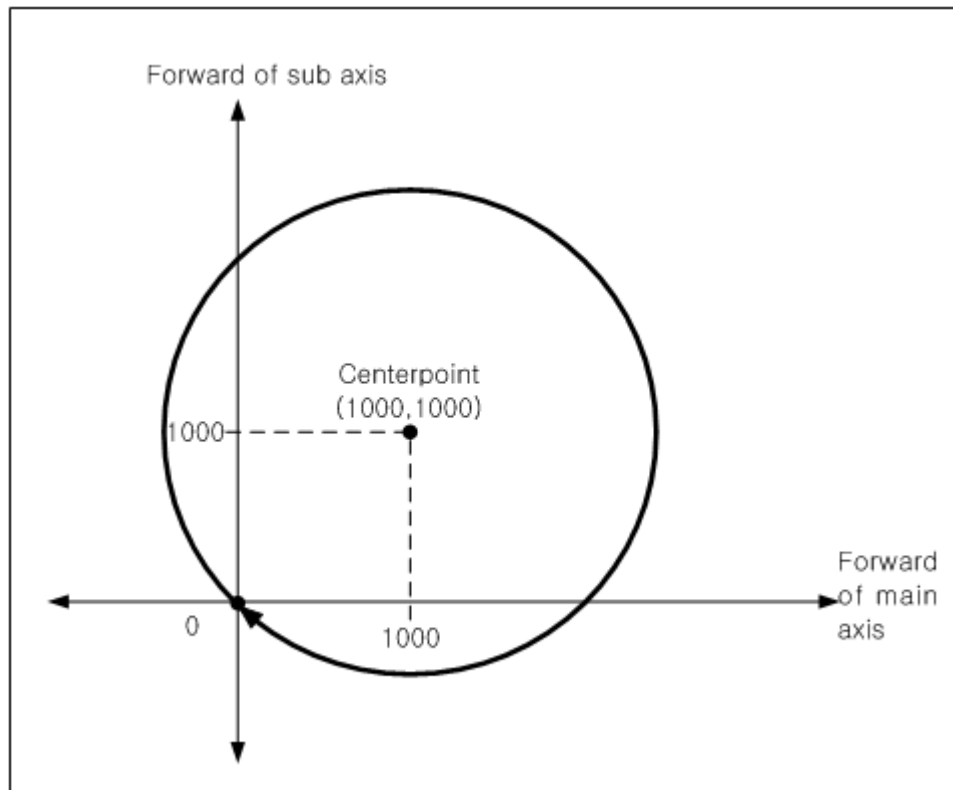
#### (4) Restrictions

Circular interpolation by center point specification method cannot be executed in the following cases.

- In case there is an axis which is in the origin undetermined state among configuration axes at the time of absolute coordinate circular interpolation operation (error code: 0x20A0)
- In case the midpoint specified as auxiliary point is the same as the starting position or target position (error code: 0x20A4)
- In case starting position is the same as the target position (error code: 0x20A5)
- In case the calculated radius of the arc exceeds 2147483647pls (error code: 0x20A6)
- In case starting position, auxiliary point position and target position are in a straight line (error code: 0x20A7)
- In case there is an axis in infinite running repetition operation among configuration axes (error code: 0x20A8)
- In case the number of configuration axes in the axis group is four (error code: 0x20A9)
- In case axis group configuration settings are not set in order (error code: 0x20AA)

## (5) Operation pattern

- Starting position: (0.0, 0.0)
- Target position: (0.0, 0.0)
- Serve position: (1000.0, 1000.0)
- Method(CircMode): Center point(1)
- Direction(PathChoice): CW(0)



### 3. Circular interpolation using radius specification method

- (1) Circular interpolation is performed from starting position to target position along the trajectory of the arc that takes the value set in circular interpolation auxiliary point. The arc that has center point depending on the sign of radius ((+): arc angle  $<180^\circ$ , (-): arc angle  $\geq 180^\circ$ ) is drawn.

오류! 편집 중 필드 코드에서는 개체를 만들 수 없습니다.

- (2) In circular interpolation of radius specification method, the target position cannot be set the same as starting position.
- (3) Movement direction and the size of the arc is determined by the sign of auxiliary point and directions (CW, CCW) set in "PathChoice" of absolute position circular interpolation operation (MC\_MoveCircularAbsolute) or relative position interpolation operation (MC\_MoveCircularRelative) motion function block
- (4) Restrictions

Circular interpolation by radius specification method cannot be executed in the following cases.

- In case there is an axis which is in the origin undetermined state among configuration axes at the time of absolute coordinate circular interpolation operation (error code: 0x20A0)
- In case starting position is the same as the target position (error code: 0x20A5)
- In case the calculated radius of the arc exceeds 2147483647pls (error code: 0x20A6)
- In case starting position, auxiliary point position and target position are in a straight line (error code: 0x20A7)
- In case there is an axis in infinite running repetition operation among configuration axes (error code: 0x20A8)
- In case the number of configuration axes in the axis group is four (error code: 0x20A9)
- In case axis group configuration settings are not set in order (error code: 0x20AA)

- (5) Operation patterns

- Starting position: (1000.0, 1000.0)
- Target position: (9000.0, 1000.0)
- Serve position: (5000.0, 0.0)
- Method(CircMode): Radius(2)
- Direction(PathChoice): CW(0)

오류! 편집 중 필드 코드에서는 개체를 만들 수 없습니다.

4. Relevant motion function block

(1) Absolute positioning circular interpolation operation

Name	Description	Operation Condition
MC_MoveCircularAbsolute	Absolute positioning circular interpolation operation	Edge

MC_MoveCircularAbsolute		
BOOL	Execute	Done
UINT	AxesGroup	----- AxesGroup
UINT	CircMode	Busy
LREAL[ ]	AuxPoint	Active
LREAL[ ]	EndPoint	CommandAborted
UINT	PathChoice	Error
LREAL	Velocity	ErrorID
LREAL	Acceleration	
LREAL	Deceleration	
LREAL	Jerk	
UINT	BufferMode	
UINT	TransitionMode	
LREAL	TransitionParameter	

(2) Relative positioning circular interpolation operation

Name	Description	Operation Condition
MC_MoveCircularRelative	Relative positioning circular interpolation operation	Edge

MC_MoveCircularRelative		
BOOL	Execute	Done
UINT	AxesGroup	----- AxesGroup
UINT	CircMode	Busy
LREAL[ ]	AuxPoint	Active
LREAL[ ]	EndPoint	CommandAborted
USINT	PathChoice	Error
LREAL	Velocity	ErrorID
LREAL	Acceleration	
LREAL	Deceleration	
LREAL	Jerk	
UINT	BufferMode	
UINT	TransitionMode	
LREAL	TransitionParameter	



5. Helical interpolation

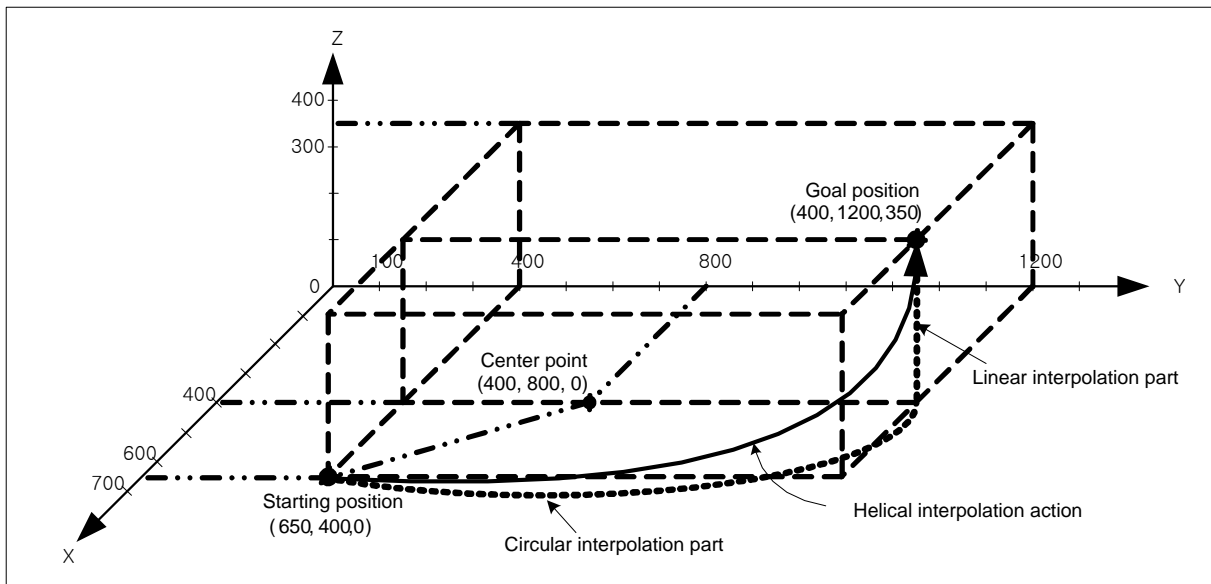
- (1) Three axes are used in the execution of circular interpolation commands(「Absolute positioning circular interpolation operation (MC\_MoveCircularAbsolute)」, 「Relative positioning circular interpolation operation (MC\_MoveCircularRelative)」). That is, two axes move the trajectory of the arc depending on circular interpolation settings, and one axis performs linear interpolation in synchronization with circular interpolation motion.
- (2) Linear axis is the third axis of the circular interpolation axis group.
- (3) For the execution of helical interpolation, the axis group of circular interpolation command needs to be set to 3-axis, and linear interpolation target position is to be set in the third axis of 'EndPoint'.  
오류! 편집 중 필드 코드에서는 개체를 만들 수 없습니다.

(4) Restrictions

The restrictions of helical interpolation are the same as those of circular interpolation according to the set circular interpolation modes.

(5) Operation pattern

- Starting position: (650.0, 400.0, 0)
- Target position: (400.0, 1200.350)
- Center position: (400.0, 800.0, 0)
- Method(CircMode): Center point(1)
- Direction(PathChoice): CCW(1)



### 8.2.9 Axis Control Buffer mode

Cancellation of the existing axis motions and continued or continuous operation of them can be carried out by executing other motion function block while the axis is in operation. The motions are specified by entering buffer mode (BufferMode) in motion function block. In axis control the maximum number of runs that can be queued in the buffer is 100. In case of executing commands with buffer mode which has more than that, error (error code: 0x1022) occurs.

When operating using the buffer mode, the status of the command buffer can be checked using the following flags.

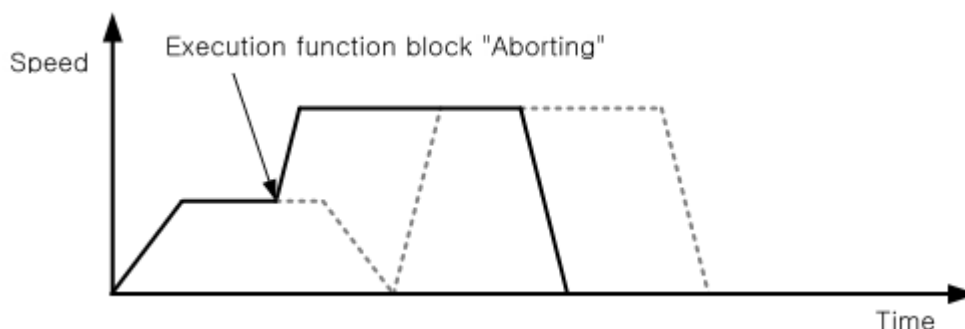
Flags	Type	Description
_AXxx_CMDBUF_FULL	BOOL	Axis xx Buffered Command Buffer Full
_AXxx_CMDBUF_QUEUED	UINT	Axis xx Buffered Command Queued Count
_AXxx_CMDBUF_FREE	UINT	Axis xx Buffered command execution count

Values that can be set in Buffer Mode are as follows.

Buffer Mode	Descripton
Aborting	It executes commands immediately. The existing commands in operation are aborted.
Buffered	It executes commands after the completion of the existing command in operation.
BlendingLow	It conducts a combination operation that helps blend into side with lower velocity by comparing the velocity of the existing command and the command to make.
BlendingPrevious	It conducts a combination operation that makes the combination with velocity of the existing commands.
BlendingNext	It conducts a combination operation that makes the combination with velocity of commands to make.
BlendingHigh	It conducts a combination operation that helps blend into side with higher velocity by comparing the velocity of the existing command and the command to make.

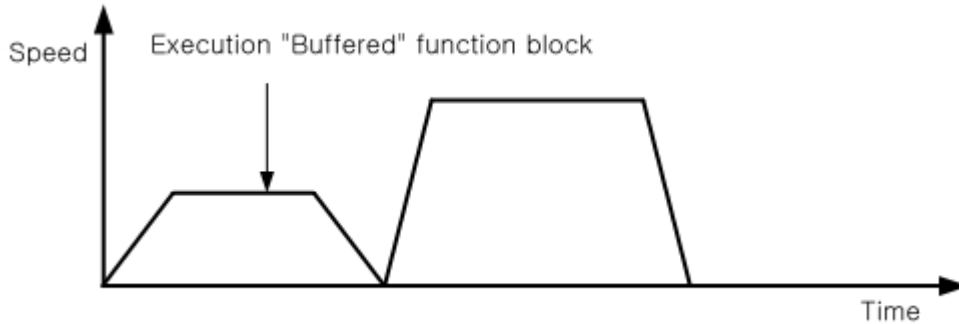
#### 1. Buffer Mode “Aborting”

It aborts the existing commands in execution immediately and executes the next command. CommandAborted output of the existing motion function blocks is On.



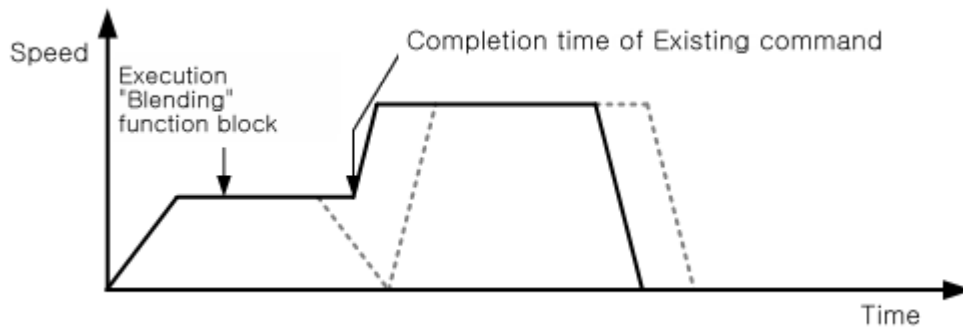
**2. Buffer Mode “Buffered”**

It execute the next command after the completion of the existing commands in execution (Done output is On).



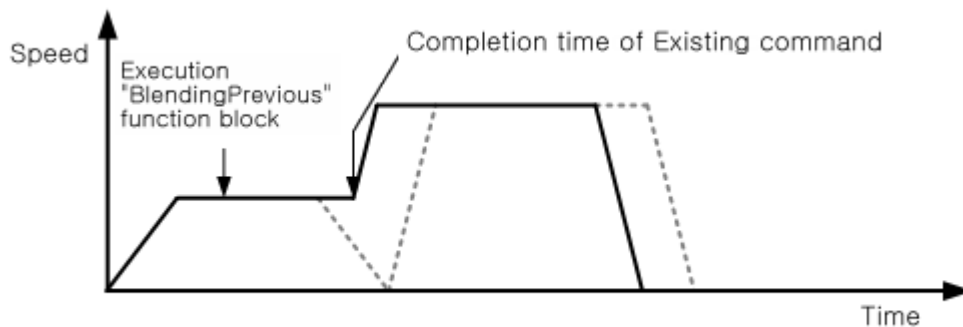
**3. Buffer Mode “BlendingLow”**

It combines operation so that operation can be made at lower velocity in a comparison between the target velocity of the existing commands in execution at the time of command completion and that of buffered command.



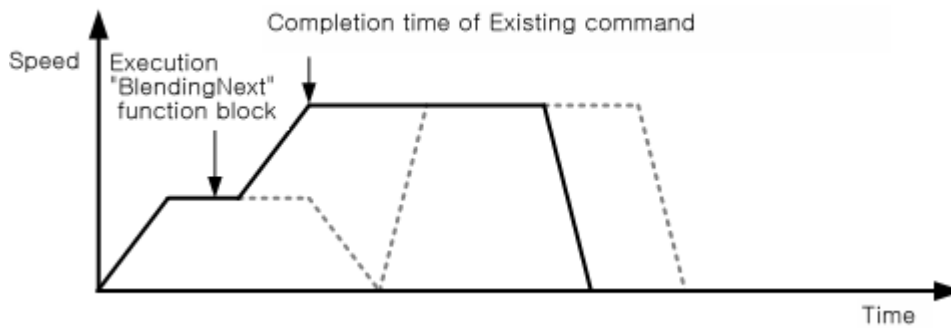
**4. Buffer Mode “BlendingPrevious”**

It executes the next command after acceleration/deceleration of the velocity to the target velocity of the next command buffered after maintaining the velocity of commands in execution at the point of time when the exiting commands are competed.



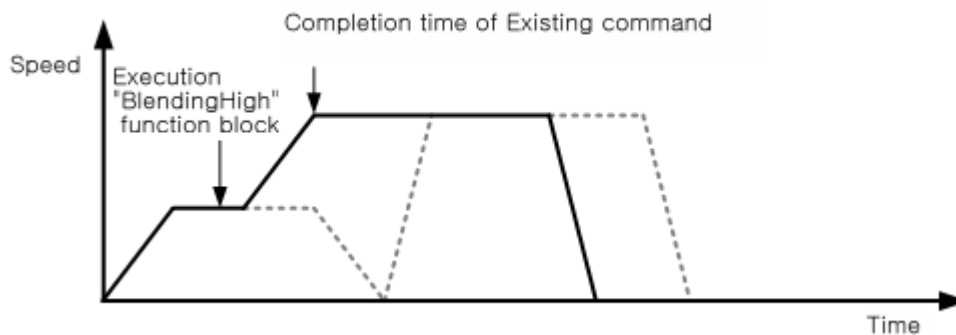
### 5. Buffer Mode "BlendingNext"

It executes the next command after acceleration/deceleration so that operation can be performed at the target velocity of the next command at the point of time when the existing commands in execution are completed.



### 6. Buffer Mode "BlendingHigh"

It combines operation so that operation can be made at higher velocity in a comparison between the target velocity of the existing commands in execution at the time of command completion and that of buffered command.



### 8.2.10 Axis Group Control Buffer Mode and Transition Mode

In axis group control as in speed control, motion commands can be executed continuously by using buffer mode, and the maximum number of runs that can be queued in the buffer is 10. In case of executing commands with buffer mode which is more than that, error (error code: 0x2022) occurs.

In addition, operation is possible by inserting curve between the two linear trajectories using transition mode.

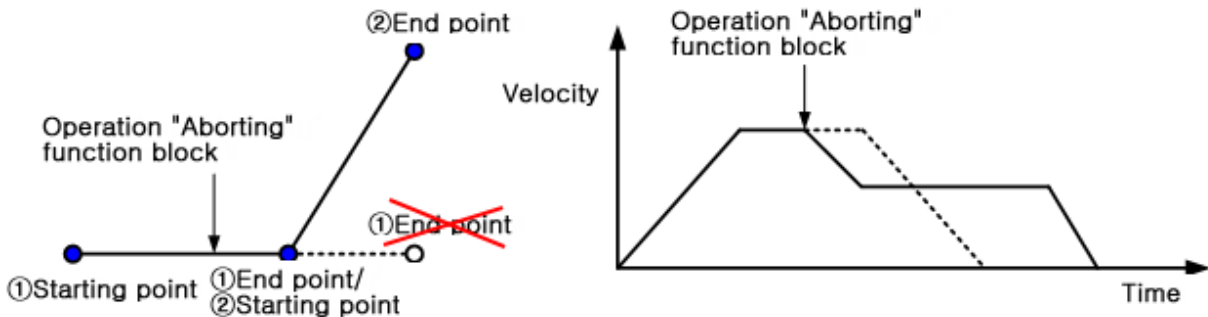
When operating using the buffer mode, the status of the command buffer can be checked using the following flags.

Flags	Type	Description
_AGxx_CMDBUF_FULL	BOOL	Axis group yy Buffered Command Buffer Full
_AGxx_CMDBUF_QUEUED	UINT	Axis group yy Buffered Command Queued Count
_AGxx_CMDBUF_FREE	UINT	Axis group yy Buffered command execution count

#### 1. 'BufferMode'

##### (1) Aborting

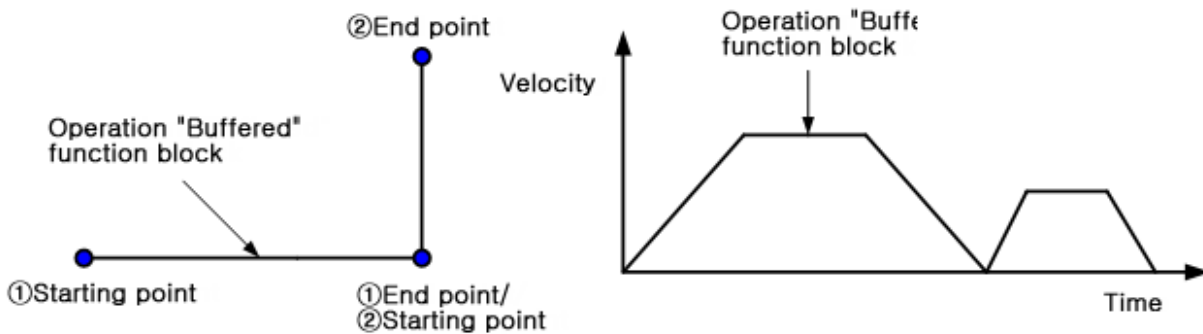
It aborts the motion that is currently running, and executes a new motion immediately.



##### (2) Buffered

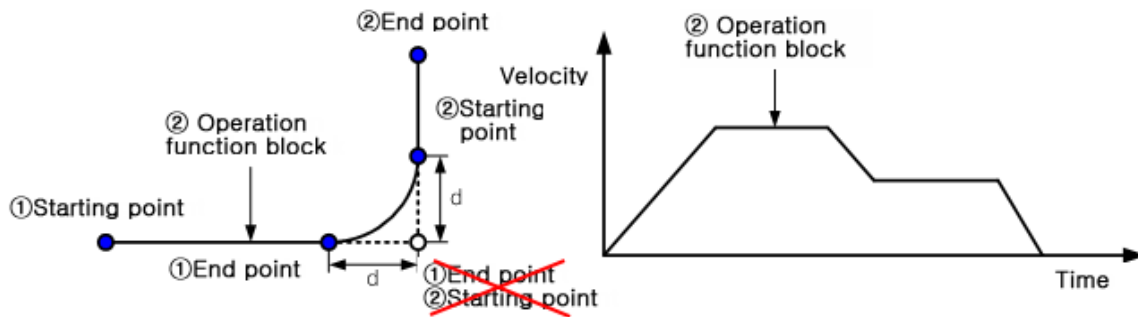
It executes the next command after completing motion operation that is being currently executed.

'TransitionMode' is not reflected.



##### (3) Blending

There is no stop between the two operations since the current motion is mixed with the next motion. The velocity may vary depending on blending modes (BlendingLow, BendingPrevious, BlendingNext, BlendingHigh).



※ Motions in case of the BlendingNext

## 2. 'TransitionMode'

### (1) TMNone

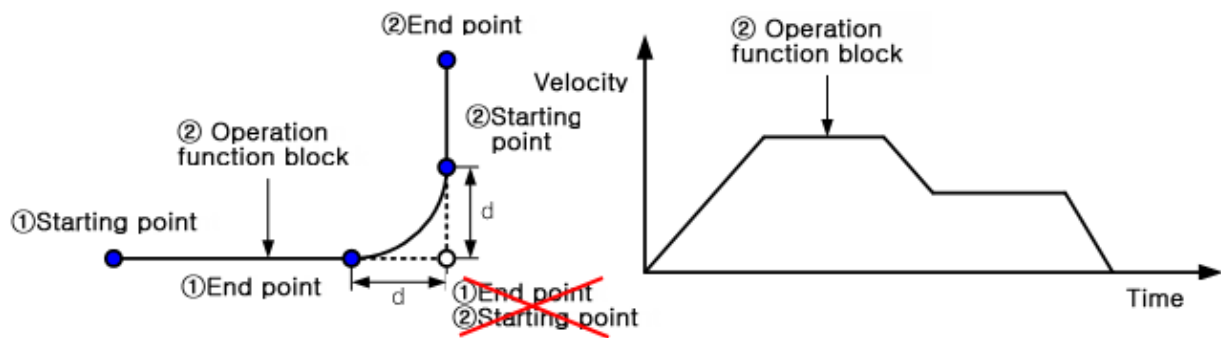
Motion trajectory is not changed, and curve is not inserted between the two operations.

In case buffer mode is Blending in this setting, Buffered mode is operated.

Motions according to the buffer mode are the same as the above Aborting and Buffered.

### (2) TMCornerDistance

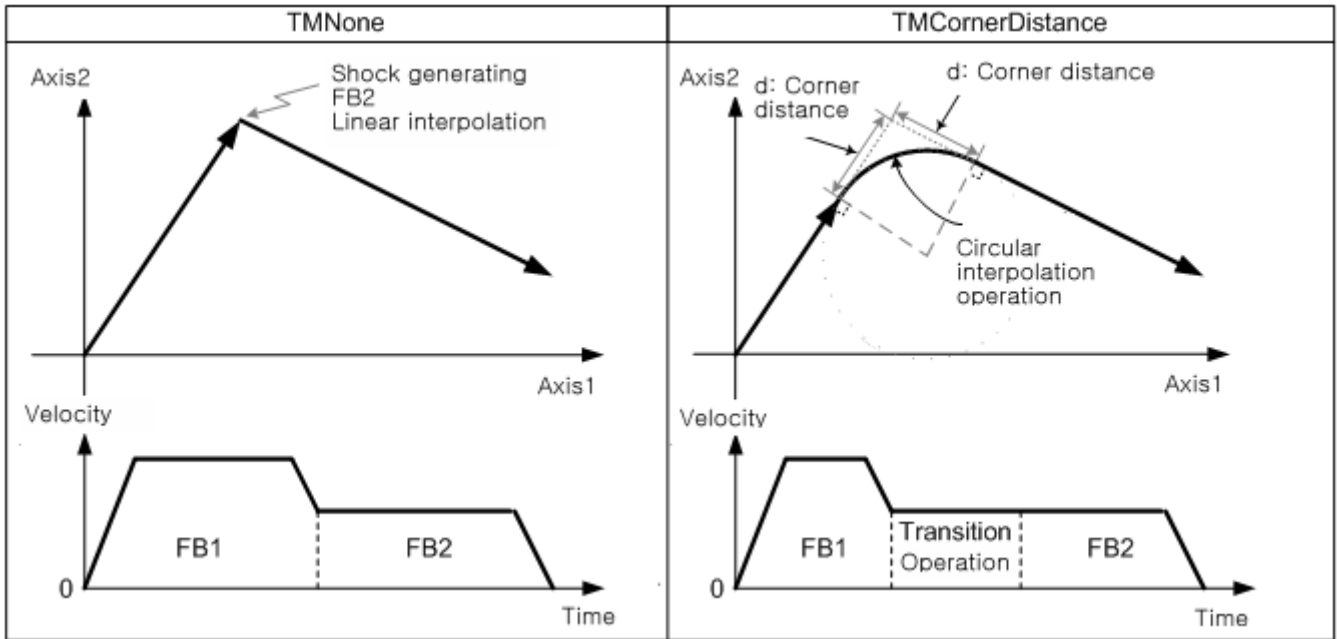
The curve can be inserted by specifying the distance of two motion block corners. The conversion velocity is specified by the BufferMode.



※ Motions in case of the BlendingNext

※ d: Curve insertion distance at the corner

(3) TransitionMode Comparison



8.2.11 Synchronous Control

1. Gear operation

- (1) Gear operation makes speed synchronization of main axis (or encoder) and serve axis depending on the set ratio.
- (2) Gear operation can be aborted with gear operation cancellation command.
- (3) Gear ratio (=velocity synchronization ratio) is calculated as follows.

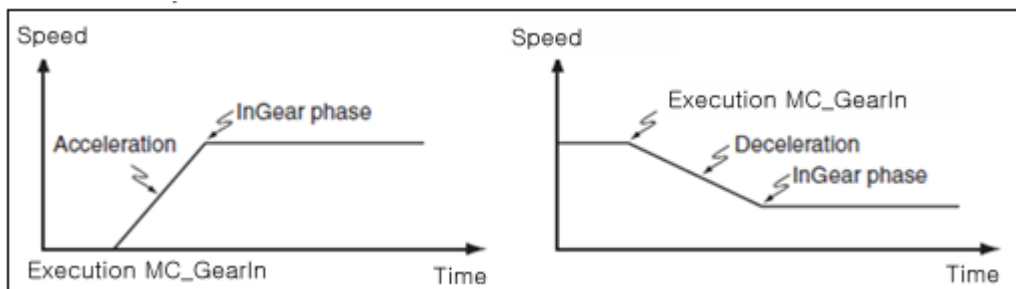
$$\text{Gear ratio} = \text{Main axis ratio} / \text{Serve axis ratio}$$

※ Main axis ratio < serve axis ratio can also be set.

- (4) Rotation direction of serve axis is based on the forward direction of the main axis. In case gear ratio is positive (>0), rotation is made in forward direction, and that is negative (< 0), in reverse direction.
- (5) The final operating velocity of serve axis is calculated as follows.

$$\begin{aligned} \text{Operation speed of serve axis} \\ &= \text{Operation speed of main axis} \times \text{Gear ratio} \\ &= \text{Operation speed of main axis} \times \text{Main axis ratio} / \text{Serve axis ratio} \end{aligned}$$

- (6) Acceleration/deceleration from the start of gear operation to target velocity can be set by using Acceleration and Deceleration input.



(7) Relevant motion function block

Name	Description	Operation Condition																																				
MC_GearIn	Gearing run	Edge																																				
<table border="1"> <thead> <tr> <th colspan="3">MC_GearIn</th> </tr> </thead> <tbody> <tr> <td>BOOL</td> <td>Execute</td> <td>InGear</td> </tr> <tr> <td>UINT</td> <td>Master -----</td> <td>Master</td> </tr> <tr> <td>UINT</td> <td>Slave -----</td> <td>Slave</td> </tr> <tr> <td>BOOL</td> <td>ContinuousUpdate</td> <td>Busy</td> </tr> <tr> <td>INT</td> <td>RatioNumerator</td> <td>Active</td> </tr> <tr> <td>UINT</td> <td>RatioDenominator</td> <td>CommandAborted</td> </tr> <tr> <td>UINT</td> <td>MasterValueSource</td> <td>Error</td> </tr> <tr> <td>LREAL</td> <td>Acceleration</td> <td>ErrorID</td> </tr> <tr> <td>LREAL</td> <td>Deceleration</td> <td></td> </tr> <tr> <td>LREAL</td> <td>Jerk</td> <td></td> </tr> <tr> <td>UINT</td> <td>BufferMode</td> <td></td> </tr> </tbody> </table>			MC_GearIn			BOOL	Execute	InGear	UINT	Master -----	Master	UINT	Slave -----	Slave	BOOL	ContinuousUpdate	Busy	INT	RatioNumerator	Active	UINT	RatioDenominator	CommandAborted	UINT	MasterValueSource	Error	LREAL	Acceleration	ErrorID	LREAL	Deceleration		LREAL	Jerk		UINT	BufferMode	
MC_GearIn																																						
BOOL	Execute	InGear																																				
UINT	Master -----	Master																																				
UINT	Slave -----	Slave																																				
BOOL	ContinuousUpdate	Busy																																				
INT	RatioNumerator	Active																																				
UINT	RatioDenominator	CommandAborted																																				
UINT	MasterValueSource	Error																																				
LREAL	Acceleration	ErrorID																																				
LREAL	Deceleration																																					
LREAL	Jerk																																					
UINT	BufferMode																																					

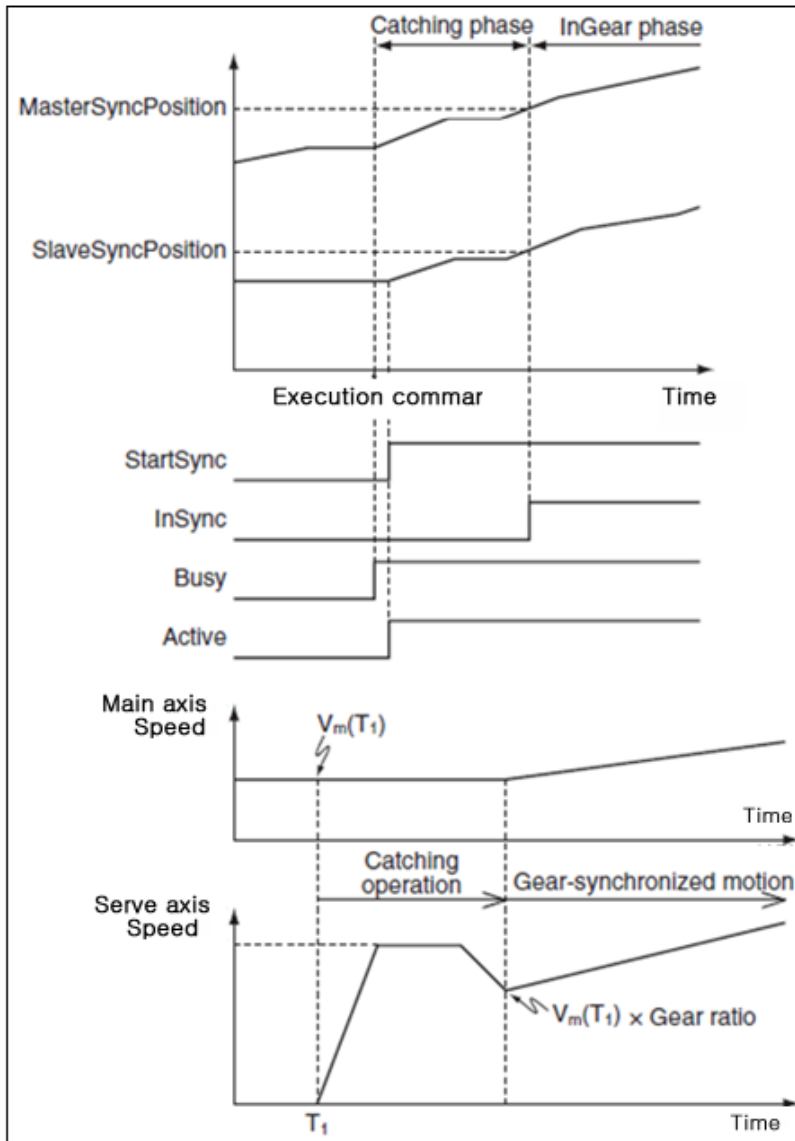
Name	Description	Operation Condition																		
MC_GearOut	Gearing disengage	Edge																		
<table border="1"> <thead> <tr> <th colspan="3">MC_GearOut</th> </tr> </thead> <tbody> <tr> <td>BOOL</td> <td>Execute</td> <td>Done</td> </tr> <tr> <td>UINT</td> <td>Slave -----</td> <td>Slave</td> </tr> <tr> <td></td> <td></td> <td>Busy</td> </tr> <tr> <td></td> <td></td> <td>Error</td> </tr> <tr> <td></td> <td></td> <td>ErrorID</td> </tr> </tbody> </table>			MC_GearOut			BOOL	Execute	Done	UINT	Slave -----	Slave			Busy			Error			ErrorID
MC_GearOut																				
BOOL	Execute	Done																		
UINT	Slave -----	Slave																		
		Busy																		
		Error																		
		ErrorID																		

**2. Positioning gear operation**

- (1) Positioning gear operation makes speed synchronization of main axis (or encoder) and serve axis depending on the ratio set the same as in gear operation basically.
- (2) The starting position in which main axis and serve axis are synchronized can be specified.



(3) Methods for operation are as follows.



(4) Relevant motion function block

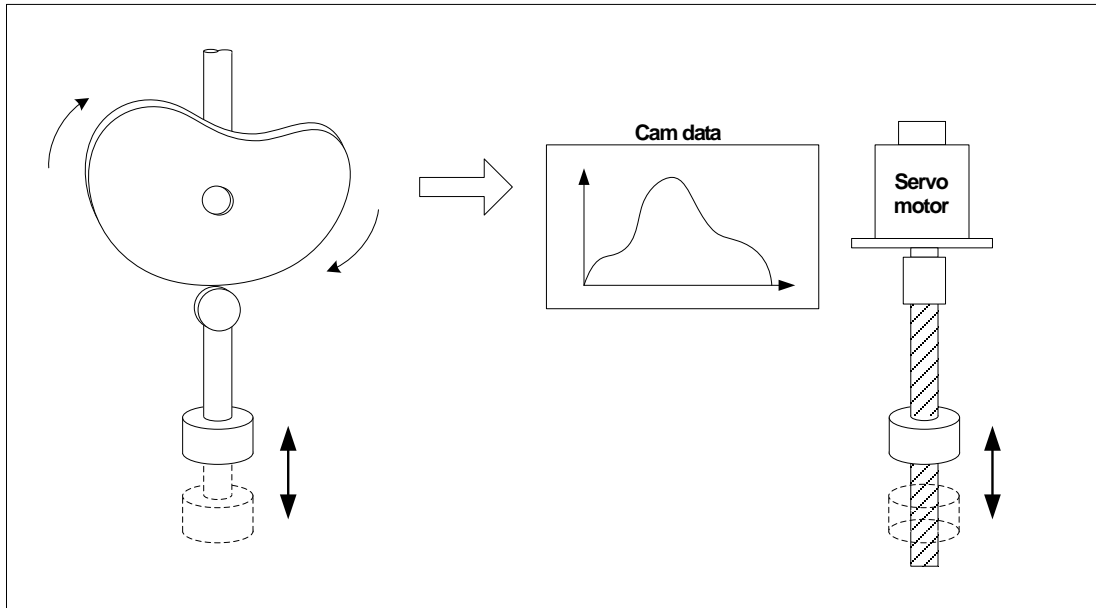
Name	Description	Operation Condition
MC_GearInPos	Gearing by specifying the position	Edge

MC_GearInPos	
BOOL Execute	InSync UINT
UINT Master	Master UINT
UINT Slave	Slave BOOL
INT RatioNumerator	StartSync BOOL
UINT RatioDenominator	Busy BOOL
UINT MasterValueSource	Active BOOL
LREAL MasterSyncPosition	CommandAborted BOOL
LREAL SlaveSyncPosition	Error BOOL
UINT SyncMode	ErrorID WORD
LREAL MasterStartDistance	
LREAL Velocity	
LREAL Acceleration	
LREAL Deceleration	
LREAL Jerk	
UINT BufferMode	

3. Cam operation

- (1) CAM operation controls cams by converting mechanical cam motion to the cam data set at the cam profile and synchronizing the data to the position of the motor designated as the main-axis.
- (2) Mechanical cam operation in the past can be replaced with software cam motion using the cam data at the cam profiles.

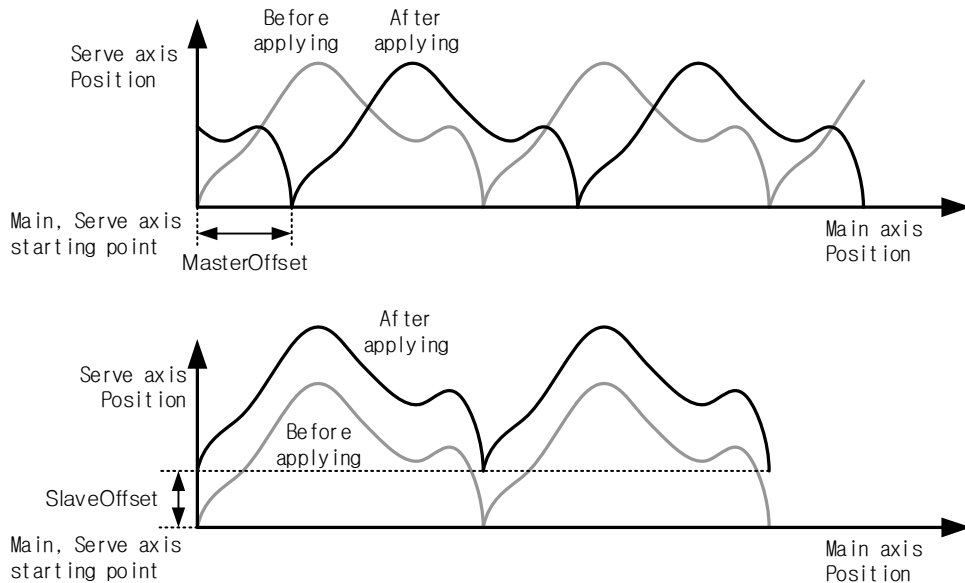


- (3) A total of 32 cam profiles can be generated, each of which can be applied to each axis regardless of their order.
- (4) Each cam profile consists of 100 cam data.
- (5) To halt cam operation, MC\_CamOut command should be issued on the sub-axis, or another motion function block should be operated (in case of Aborting).

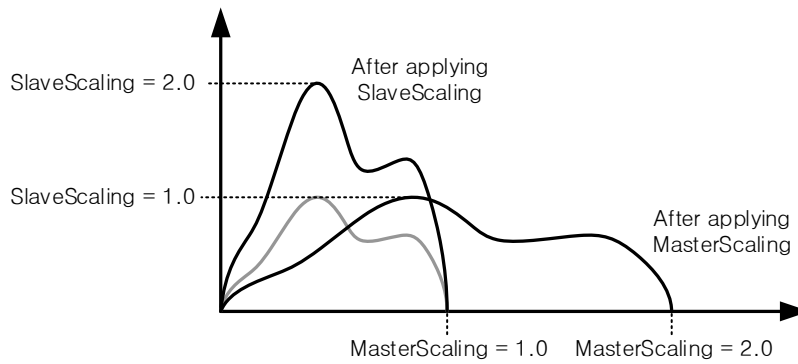
(6) Cam operation command's secondary data

Variable	Description
Master	Set the master Axis (1~32: Real Axis, 37~40: Virtual Axis, 41~42: Encoder),
MasterOffset	Set the master Axis offset value.
SlaveOffset	Set the offset value of the slave cam table.
MasterScaling	Specify the magnification of the main axis.
SlaveScaling	Specify the magnification of the serve axis cam table.
MasterStartDistance	Specify the position of the main-axis where the cam operation of the main-axis starts.
MasterSyncPosition	When cam operation starts, specify the start position at the cam table.
StartMode	Set the cam operation mode. 0 : Cam table is applied as an absolute value. (mcAbsolute) 1 : Cam table is applied as a relative value based on the command start position. (mcRelative)
MasterValueSource	Select the source of the main axis for cam operation. 0 : Synchronized in the target value of the main axis. 1 : Synchronized in the current value of the serve axis.
CamTableID	Specify the cam table to operate.

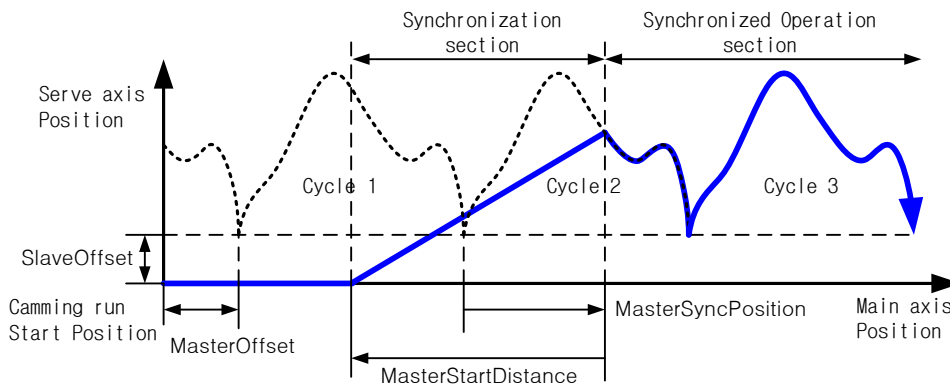
(a) At MasterOffset and SlaveOffset, set the cam table offset to apply. MasterOffset determines the offset from the main-axis start point, and Slaveoffset determines the offset from the sub-axis start point. Please refer to the figure below. Using offset may change the start position for cam operation, causing an abrupt operation. In such a case, MasterSyncPosition, MasterStartDistance should be used.



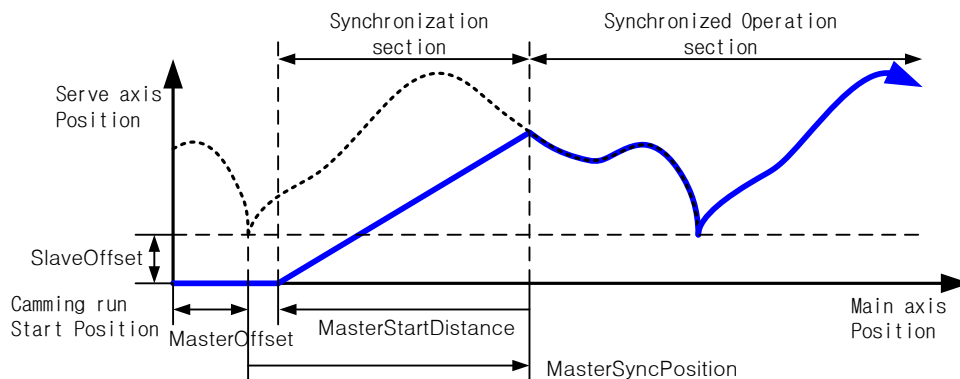
(b) At MasterScaling and SlaveScaling, set the scale rate of the cam data to apply. MasterScaling determines the scale rate of the main-axis data, and SlaveScaling determines the scale rate of the sub-axis data. Please refer to the figure below.



- (c) MasterSyncPosition input specifies the position of the main axis within the table where the synchronization of actual cam operation is completed, and MasterStartDistance input specifies the relative position of the main axis where the synchronization starts. If unable to start synchronized operation at Cycle 1 as shown below (if the distance from the start position to the synchronized operation start position is shorter than MasterStartDistance), synchronized operation starts at Cycle 2.



In case MasterScaling is 1.0



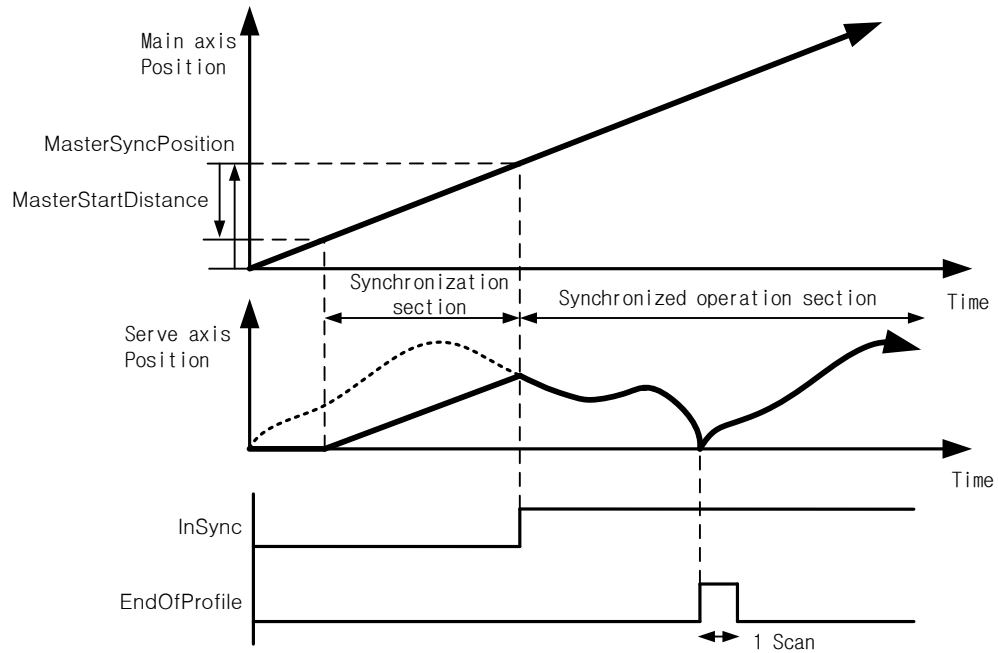
In case MasterScaling is 2.0

MasterSyncPosition position is based on the position within the cam table, and actual synchronization position is decided by considering MasterOffset and MasterScale parameters.

The serve axis starts moving to the synchronization position from the distance of the input value away based on the position where MasterSyncPosition is actually applied. If it is before starting moving, the serve axis waits at the relevant position in stop

state, and if the serve axis is already in the section to move to the synchronization position at the beginning of the command, take back the position of the synchronization starting point by the length of a table until it escapes the MasterStartDistance range. Actual synchronization position can vary depending on MasterScaling and SlaveScaling because MasterSyncPosition is a value based on the inside of cam table, but MasterOffset and MasterStartDistance value remain unaffected.

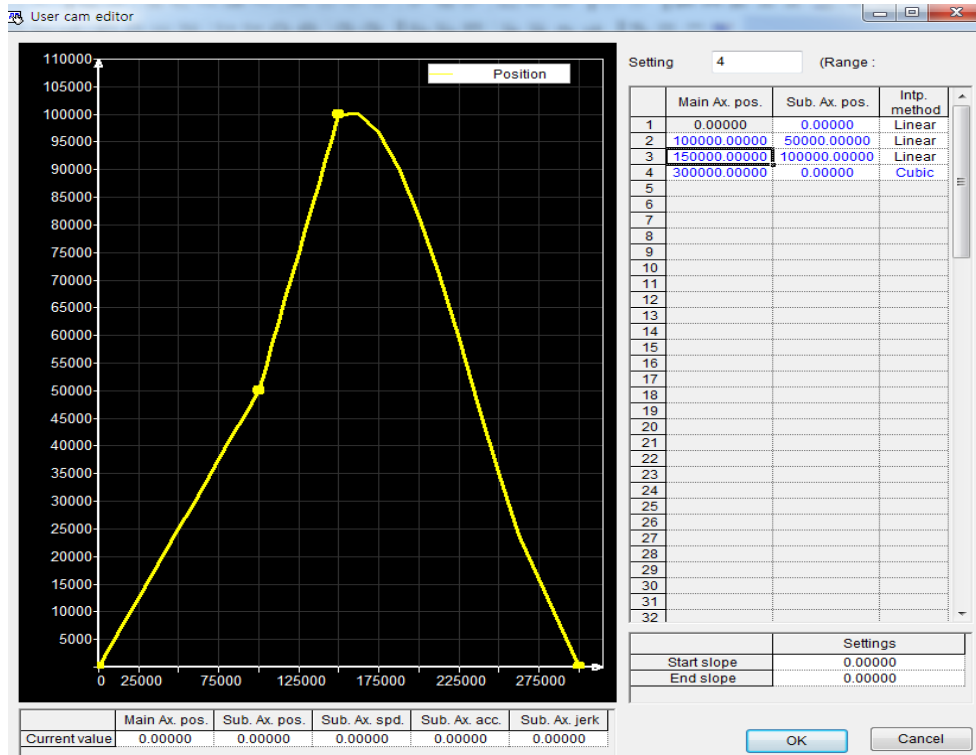
- (d) InSyncoutput is on when cam operation starts the synchronization. 1 scan of EndOfProfileoutput is on whenever a single cam table operation is completed.



- (e) At StartMode, the cam operation mode is set. The setting range is either 0 or 1. If the input value exceeds the setting range, an error occurs. If it is set to 0, the cam table start position is set to the main-axis position of 0. If it is set to 1, the cam table start position is set to the current position of the main-axis.
- (f) MasterValueSource selects the source for the main-axis to synchronize. If set to 0, sub-axis performs the cam operation based on the main-axis command position calculated by the motion control module, and if set to 1, it performs the cam operation based on the current position received through the communication from the main-axis servo drive.
- (g) CamTableID sets the number of the cam table to be applied to the cam operation. The setting range is from 1 to 32. If the input value exceeds the setting range, an error "0x1115" occurs at the motion function block.

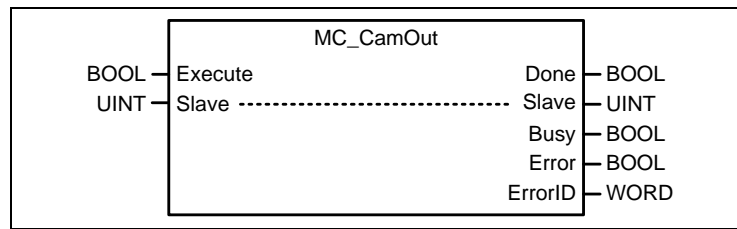
(7) Cam profile

Parts		Description
CAM data	Main axis position	Set the sub-axis cam position corresponding to the main-axis
	Slave axis position	
	Interpolation type	Set the characteristic curve between the cam data. (Linear, Cubic)
Start slope	If the interpolation type for the first or the last section is set to 'Cubic', set the start inclination and the end inclination for the Cubic operation.	
End slope		



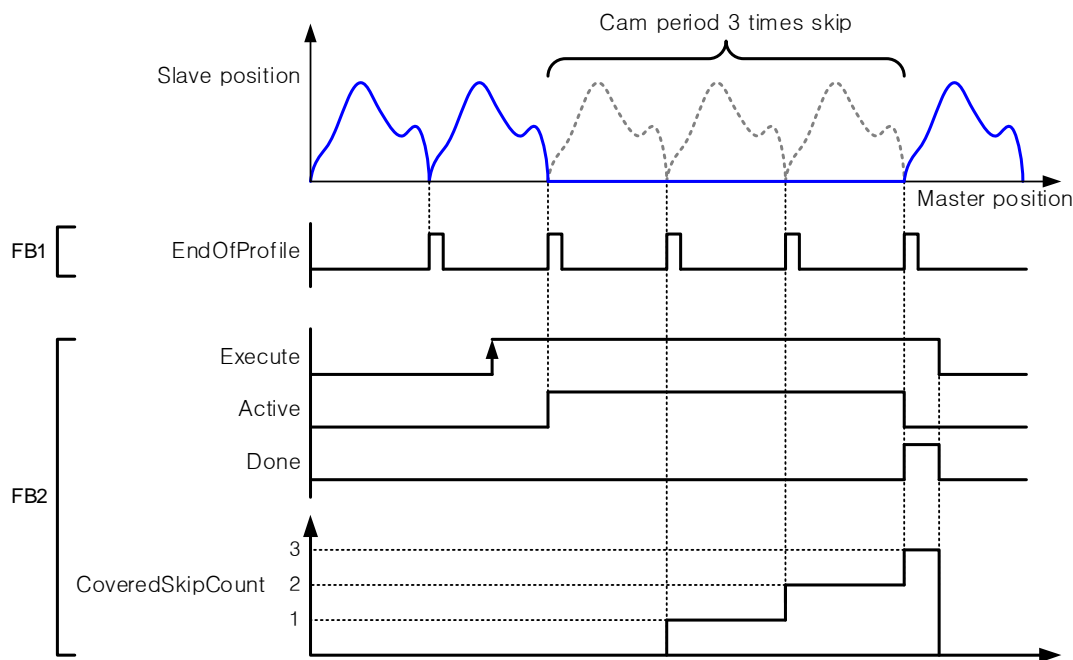
(8) Motion function block

Function block	Description	Operation condition																																																												
MC_CamIn	Cam operation	Edge																																																												
<table border="1"> <thead> <tr> <th colspan="4">MC_CamIn</th> </tr> </thead> <tbody> <tr> <td>BOOL</td> <td>Execute</td> <td>InSync</td> <td>BOOL</td> </tr> <tr> <td>UINT</td> <td>Master</td> <td>Master</td> <td>UINT</td> </tr> <tr> <td>UINT</td> <td>Slave</td> <td>Slave</td> <td>UINT</td> </tr> <tr> <td>LREAL</td> <td>ContinousUpdate</td> <td>Busy</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>MasterOffset</td> <td>Active</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>SlaveOffset</td> <td>CommandAborted</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>MasterScaling</td> <td>Error</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>SlaveScaling</td> <td>ErrorID</td> <td>WORD</td> </tr> <tr> <td>LREAL</td> <td>MasterStartDistance</td> <td>EndOfProfile</td> <td>BOOL</td> </tr> <tr> <td>LREAL</td> <td>MasterSyncPosition</td> <td></td> <td></td> </tr> <tr> <td>UINT</td> <td>StartMode</td> <td></td> <td></td> </tr> <tr> <td>UINT</td> <td>MasterValueSource</td> <td></td> <td></td> </tr> <tr> <td>UINT</td> <td>CamTableID</td> <td></td> <td></td> </tr> <tr> <td>UINT</td> <td>BufferMode</td> <td></td> <td></td> </tr> </tbody> </table>			MC_CamIn				BOOL	Execute	InSync	BOOL	UINT	Master	Master	UINT	UINT	Slave	Slave	UINT	LREAL	ContinousUpdate	Busy	BOOL	LREAL	MasterOffset	Active	BOOL	LREAL	SlaveOffset	CommandAborted	BOOL	LREAL	MasterScaling	Error	BOOL	LREAL	SlaveScaling	ErrorID	WORD	LREAL	MasterStartDistance	EndOfProfile	BOOL	LREAL	MasterSyncPosition			UINT	StartMode			UINT	MasterValueSource			UINT	CamTableID			UINT	BufferMode		
MC_CamIn																																																														
BOOL	Execute	InSync	BOOL																																																											
UINT	Master	Master	UINT																																																											
UINT	Slave	Slave	UINT																																																											
LREAL	ContinousUpdate	Busy	BOOL																																																											
LREAL	MasterOffset	Active	BOOL																																																											
LREAL	SlaveOffset	CommandAborted	BOOL																																																											
LREAL	MasterScaling	Error	BOOL																																																											
LREAL	SlaveScaling	ErrorID	WORD																																																											
LREAL	MasterStartDistance	EndOfProfile	BOOL																																																											
LREAL	MasterSyncPosition																																																													
UINT	StartMode																																																													
UINT	MasterValueSource																																																													
UINT	CamTableID																																																													
UINT	BufferMode																																																													
Function block	Description	Operation condition																																																												
MC_CamOut	Cam operation out	Edge																																																												



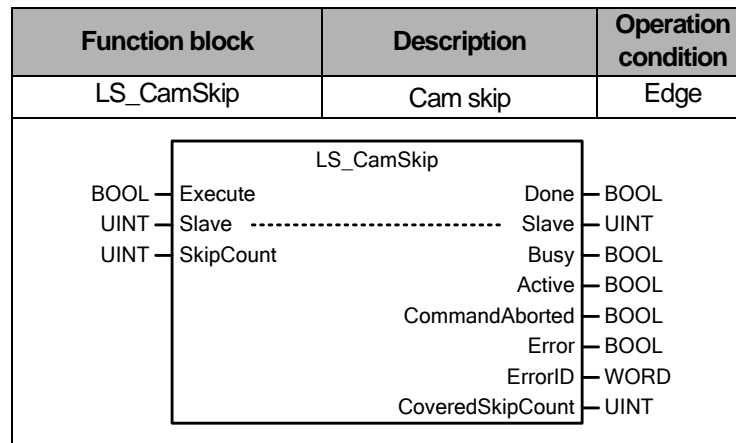
**4. Cam skip**

- (1) This function skips the cam operation as many as the number of cam operation cycles that user wants in the axis where cam operation is underway.
- (2) When Cam Skip command is issued on a sub-axis where cam operation is underway, the current cam cycle ends, and the skip operation starts. The sub-axis is in stand-by at the end position of the cam table in the cam skip motion.



- (3) After the execution of cam motion by MC\_CamIn command (FB1), if three cycles are skipped using LS\_CamSkip command (FB2), the output of each function block FB1 and FB2 and the motion of the cam sub-axis are as displayed as shown in the figure below
- (4) If Cam Skip command is re-executed during cam skip motion, or cam skip motion is aborted by another Cam Skip command, the SkipCount of the latter Cam Skip command applies, and a new cam skip motion starts from the beginning. In such a case, the number of cycles skipped at the time of re-execution is included in the cycles skipped after the re-execution. Therefore, the CoveredSkipCount value is 1 point larger than the SkipCount set by the user.
- (5) Even if the execute contact point is off before the end of the executed cam skip motion, the active contact point is on until the operation is completed. Done and CoveredSkipCount are only applied for the scans performed after completing the operation.

(6) Motion function block



**5. Prohibit driving in the opposite direction during synchronous driving**

- (1) When the main axis operates in the opposite direction to the synchronous operation direction referenced by the sub axis while the synchronous control command such as CAM and Gear is executed, the sub axis stops synchronous control.
- (2) After the main axis starts operation in the direction allowing synchronous operation again, and passes the position where it previously started to operate in the opposite direction, the sub axis starts synchronous control again.
- (3) The operation direction of the main axis referenced during synchronous operation can be set in the extended setting of the axis parameter.

Group	Parameter	Value
Extended parameter	The Sync method depending on the direction of master axis operation	0: Sync to bi-direction operation of master axis 1: Sync to forward direction operation of master axis 2: Sync to reverse direction operation of master axis

- (4) Operation according to parameter setting
  - (a) 0: Sync to bi-direction operation of master axis
 

It performs synchronous control operation according to the synchronous command executed on the sub axis according to the operation direction of the main axis. Separately, there is no restriction on the synchronous control operation according to the main axis operation direction.
  - (b) 1: Sync to forward direction operation of master axis
    - When the main axis operates in the reverse direction at the start of synchronous control
 

The subordinate axis does not start synchronous control and maintains the stop state. After the main axis is changed to forward operation, the sub axis starts synchronous control operation when the position of the main axis passes the position at which the synchronous control started.
    - When the main axis operates in the forward direction at the start of synchronous control
 

According to the operation direction of the main axis, the sub axis performs synchronous control operation according to the synchronous command executed on the sub axis. When the main axis changes to reverse operation, the sub axis stops synchronous control.

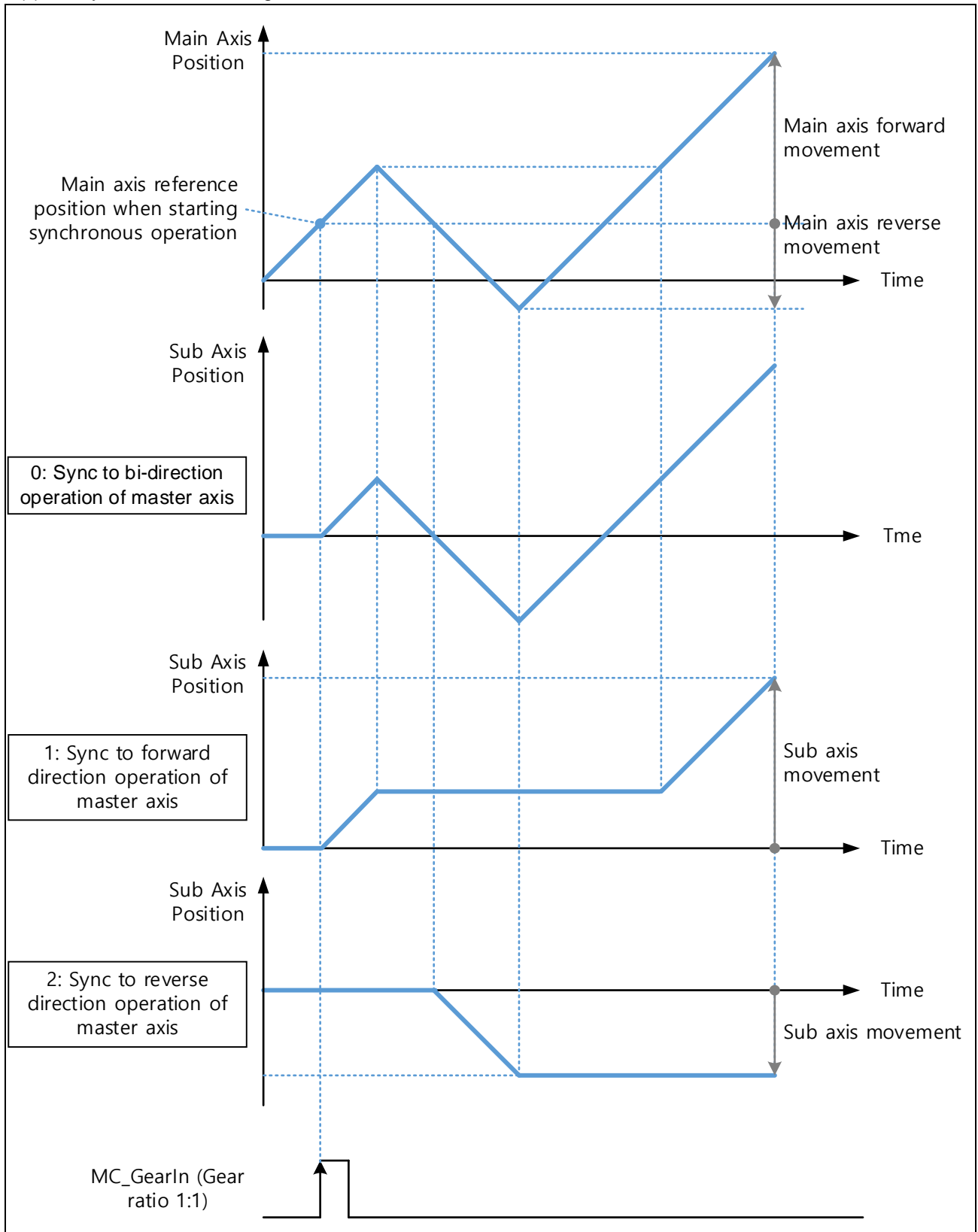
After the main axis is changed to forward operation again, if the position of the main axis passes the previously operated position in the opposite direction, the sub axis starts synchronous control again.



- (c) 2: Sync to reverse direction operation of master axis
  - When the main axis operates in the forward direction at the start of synchronous control  
The subordinate axis does not start synchronous control and maintains the stop state. After the main axis is changed to reverse operation, the sub axis starts synchronous control operation when the position of the main axis passes the position at which synchronous control started.
  - When the main axis operates in the reverse direction at the start of synchronous control  
According to the operation direction of the main axis, the sub axis performs synchronous control operation according to the synchronous command executed on the sub axis. When the main axis changes to forward operation, the sub axis stops synchronous control.  
After the main axis is changed to reverse operation again, if the position of the main axis passes the position previously operated in the opposite direction, the sub axis starts synchronous control again.
  
- (5) Check the main axis operation direction according to MasterValueSource
  - (a) 0 : Synchronized in the target value of the main axis.
    - If the command position value increases, it is judged as the main axis forward operation.
    - If the command position value decreases, it is judged as main axis reverse operation.
  - (b) 1 : Synchronized in the current value of the serve axis.
    - If the current position value increases, it is judged as the main axis forward operation.
    - If the current position value decreases, it is judged as the main axis reverse operation.
  - ※ When the main axis is an 'encoder' or a variable designation synchronous control command, there is no separate command position or current position, so the operation according to the MasterValueSource input value is the same. That is, regardless of MasterValueSource value, if the encoder position or variable value increases, it is judged as forward operation, and if it decreases, it is judged as reverse operation.

(6) Operation timing

(a) 0 : Synchronized in the target value of the main axis.



- (7) Application synchronous control command
  - (b) Cam operation  
MC\_CamIn, LS\_VarCamIn, LS\_OnOffCam
  - (c) Gear operation  
MC\_GearIn, LS\_VarGearIn, MC\_GearInPos, LS\_VarGearInPos
- (8) The version information that can use this motion function block is as follows.

Module	1. Content	Module O/S	XG-PM
XGF-M32E		V1.30	V3.1

### 8.2.12 Manual Control

#### 1. Jog operation

- (1) Jog operation makes positioning control by manual jog commands of users.
- (2) Jog operation is possible even in the state in which the origin of the axis is not determined.
- (3) Jog commands are executed even in the origin determined or undetermined status, which makes it possible to monitor changes in position values of the axis.
- (4) Acceleration/deceleration processing and jog speed

For processing acceleration and deceleration, acceleration and deceleration control is made based on the value set in Jog Acceleration/Deceleration/Jerk among [Operation parameter – expansion parameter] setting items.

Jog speed is set in Jog high-speed and Jog low-speed among [Operation parameter – expansion parameter] setting items.

Jog high-speed should be set to at the speed limit or less or at least Jog low-speed among [Operation parameter – basic parameter] setting items.

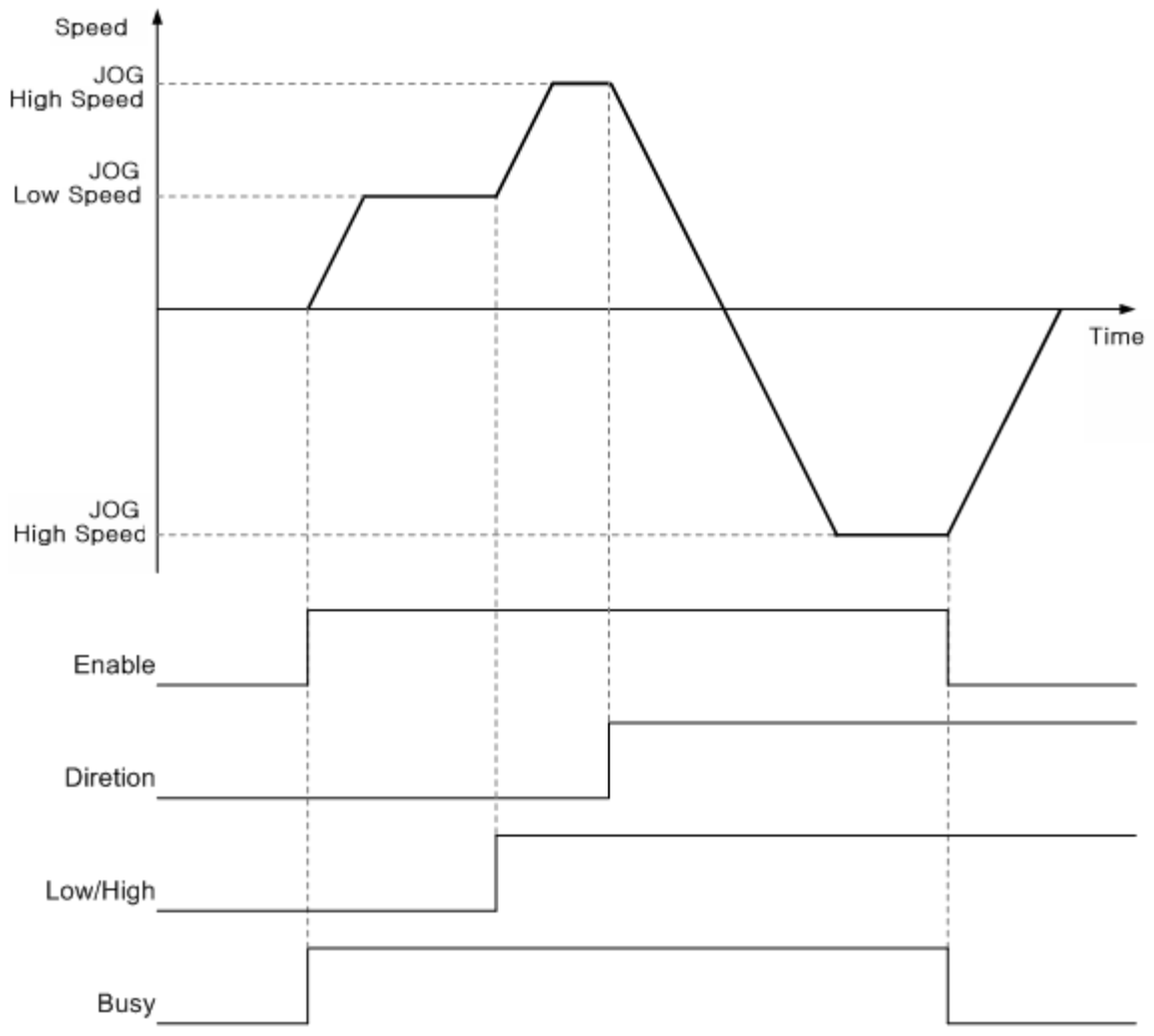
- (5) Parameter setting

Item	Settings	Initial Value
JOG High Speed	Long Real(LREAL) Positive number	100000 pls/s
JOG Low Speed		10000 pls/s
JOG Acceleration	0 or Long Real(LREAL) Positive number	100000 pls/s <sup>2</sup>
JOG Deceleration		100000 pls/s <sup>2</sup>
JOG jerk		0 pls/s <sup>3</sup>

- (6) Motion function block

Name	Description	Operation Condition
MC_Jog	JOG operation	Level
	LS_Jog	
BOOL	Enable	Enabled
UINT	Axis	Axis
BOOL	Direction	Busy
BOOL	Low/High	Error
		ErrorID

(7) Operation Timing



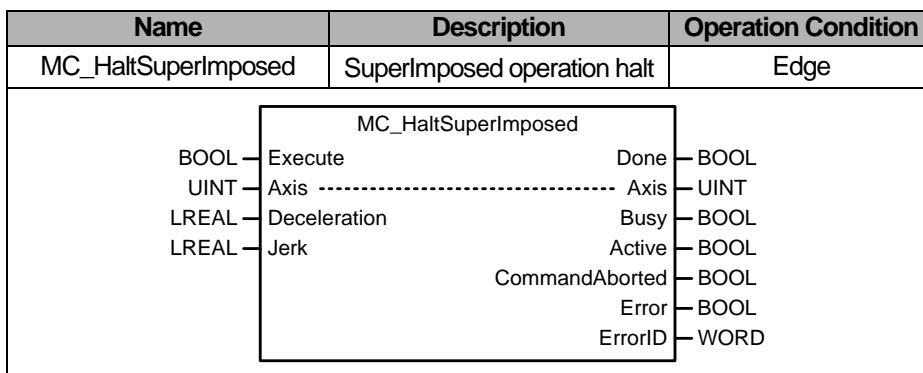
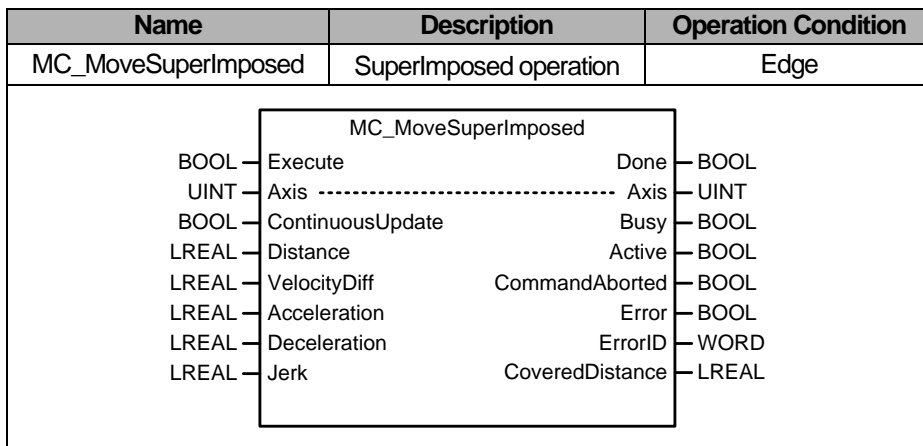
### 8.2.13 SuperImposed operation

SuperImposed operation executes the positioning control additionally as much as the moving distance designated in the current motion operation.

#### 1. Features of control

- (1) When SuperImposed operation command is executed, the axis moves from the point at the time of command execution to the target distance specified in the Distance input.
- (2) The moving distance is determined depending on the signs of the target distance specified in the Distance input, and if the moving direction is positive (+ or no sign), it means forward movement, and if it is negative (-), it means reverse movement.
- (3) The existing motion is not canceled, but its operation overlaps with SuperImposed operation.
- (4) Even when the existing motion is completed, SuperImposed operation continues unless the amount of movement does not reach the one specified in the SuperImposed operation.
- (5) If the axis is not in operation, but in "StandStill" status, SuperImposed operation works the same way as MC\_MoveRelative operation.
- (6) The current SuperImposed operation can be halted with the MC\_HaltSuperImposed command. After executing the command, SuperImposed operation decelerates and stops at the given acceleration and jerk. The existing motion which is currently being executed is not affected.

#### 2. Motion function block

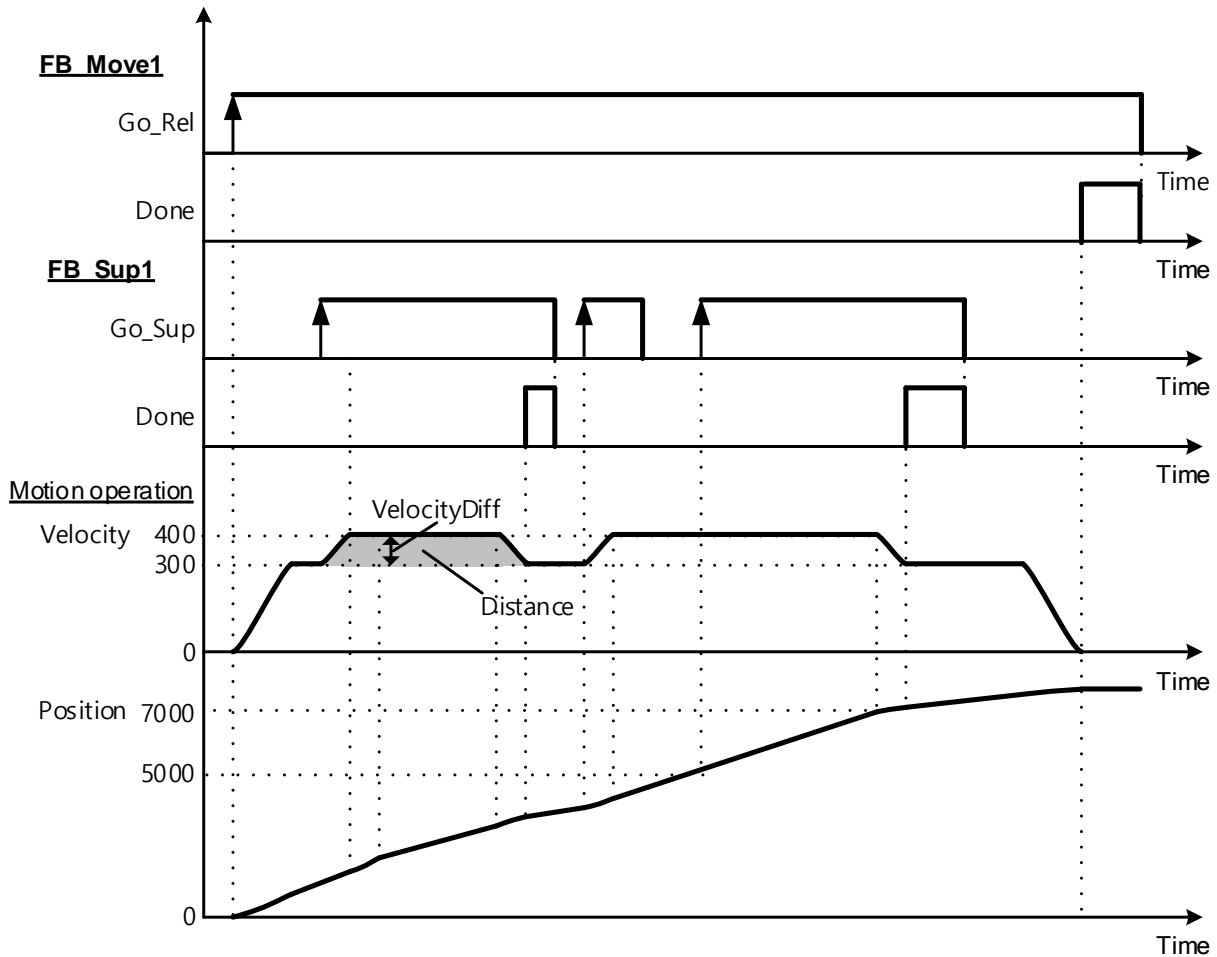
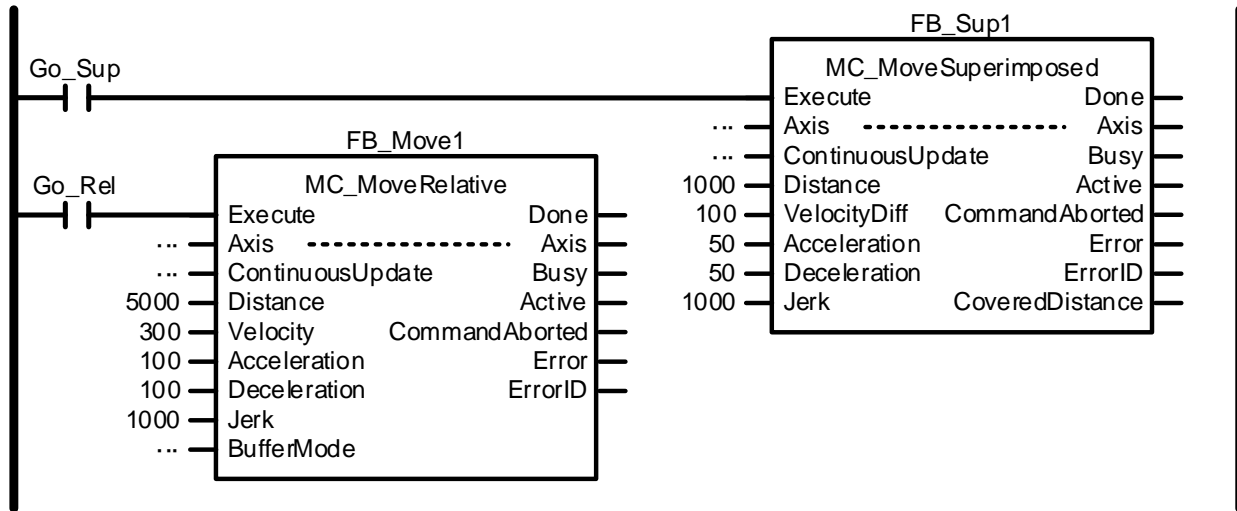


3. Restrictions

In the following cases, SuperImposed operation cannot be performed due to errors.

- (1) SuperImposed command is executed during velocity control or torque control operation (Error Code: 0x1082)
- (2) MC\_HaltSuperImposed command is executed when SuperImposed operation is not being performed (Error Code: 0x1083)

4. Operation timing



### 8.2.14 Phase correction control

Phase correction control performs phase correction for the main-axis of the axes during synchronization control operation. It performs a virtual movement of the position of the main-axis which the sub-axis refers to in synchronization control operation, and the sub-axis performs synchronized operation to the moved main-axis position.

#### 1. Control features

- (1) Phase correction order can be executed with respect to the axes where synchronized operation is underway as in gear operation or cam operation.
- (2) Phase correction does not change the actual command position or current position of the main-axis, and phase correction is performed on the main-axis position referred to by sub-axis in synchronous control operation. In other words, the main-axis does not know that phase correction is executed by the sub-axis. Phase correction velocity is relative to the velocity of the current main-axis operation.
- (3) If the main-axis is encoder, when phase correction control is executed, the operation uses the velocity limit of the sub-axis.
- (4) The main-axis position which the sub-axis refers to during synchronized operation is "actual main-axis position + phase correction control position."
- (5) If the command is re-executed during the phase correction operation, phase correction is performed again from the current position. In other words, PhaseShift is operated in a relative value.
- (6) If re-executing phase correction by setting PhaseShift to 0 during the phase correction operation, the existing phase correction operation stops immediately.

#### 2. Motion function block

Name	Description	Operation Condition
MC_Phasing	Phase correction	Edge
MC_Phasing		
BOOL	Execute	Done
UINT	Master	Master
UINT	Slave	Slave
LREAL	PhaseShift	Busy
LREAL	Velocity	Active
LREAL	Acceleration	CommandAborted
LREAL	Deceleration	Error
LREAL	Jerk	ErrorID
	CoveredPhaseShift	LREAL

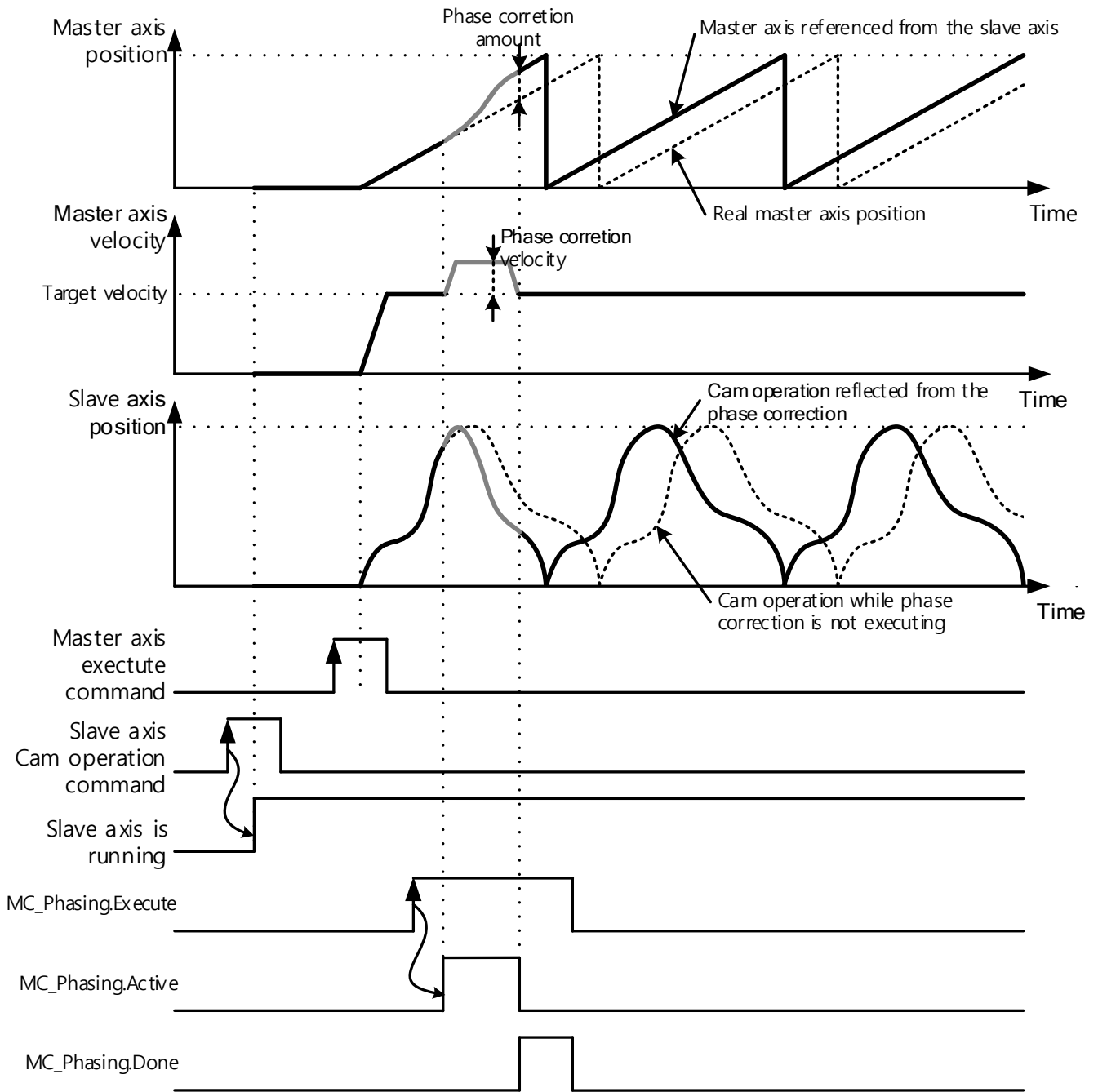
#### 3. Restrictions

In the following cases, Phase correction cannot be performed due to errors.

- (1) Sub-axis is not performing synchronization control operation (Error Code: 0x1130)
- (2) The designated main-axis is the main-axis of the actual synchronized operation (Error Code: 0x1131)
- (3) PhaseShift is outside the pulse unit position expression range (INT) (Error Code: 0x1132)
- (4) Velocity setting is less than 0, or exceeds the velocity limit for the main-axis (Error Code: 0x1133)
- (5) Acceleration setting is less than 0 (Error Code: 0x1014)
- (6) Deceleration setting is less than 0 (Error Code: 0x1015)
- (7) Jerk setting is less than 0 (Error Code: 0x1016)



4. Operation timing



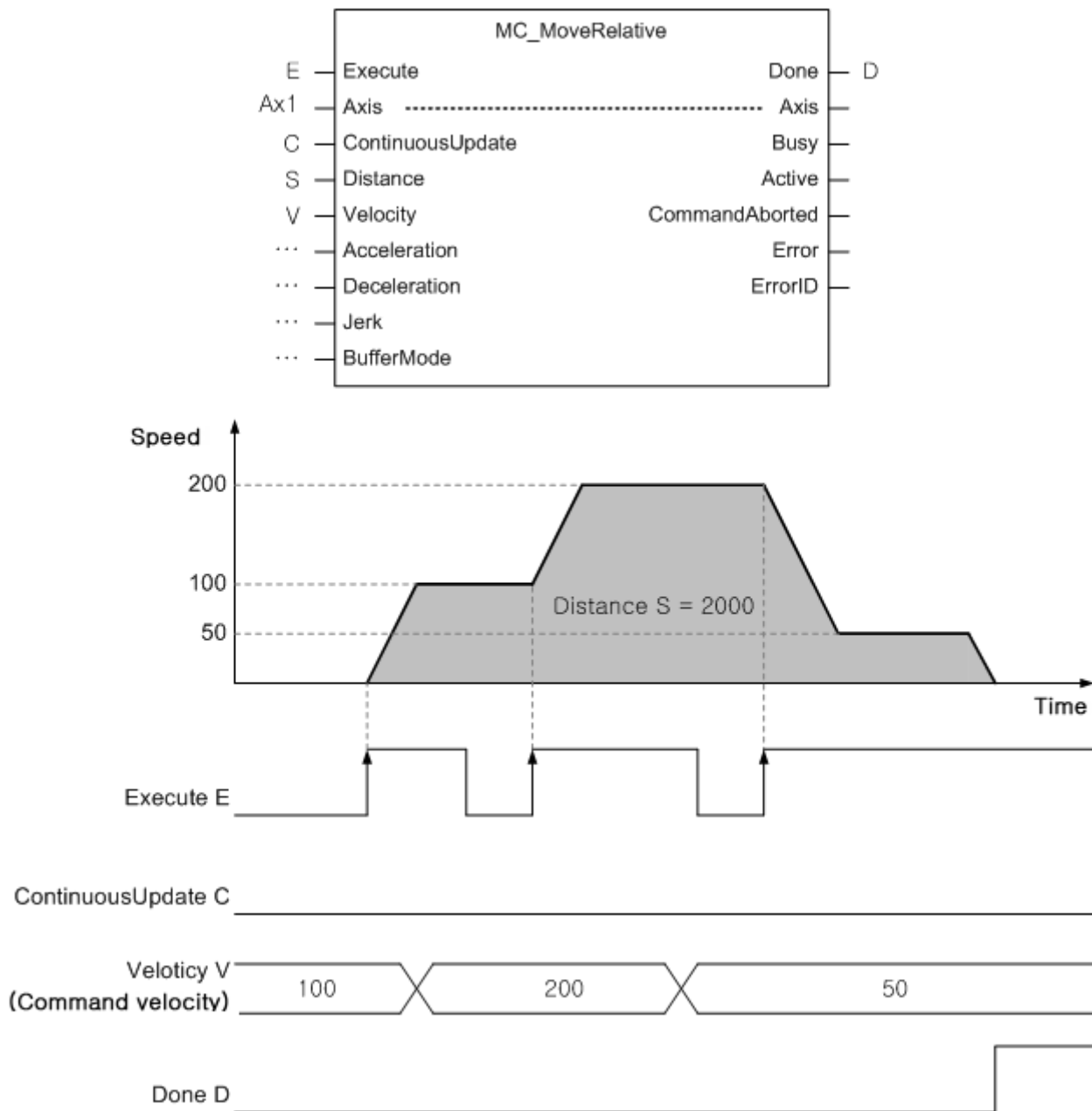
### 8.3 Other Functions

#### 8.3.1 Functions to change control

##### 1. Changes in input variables of motion function block in execution

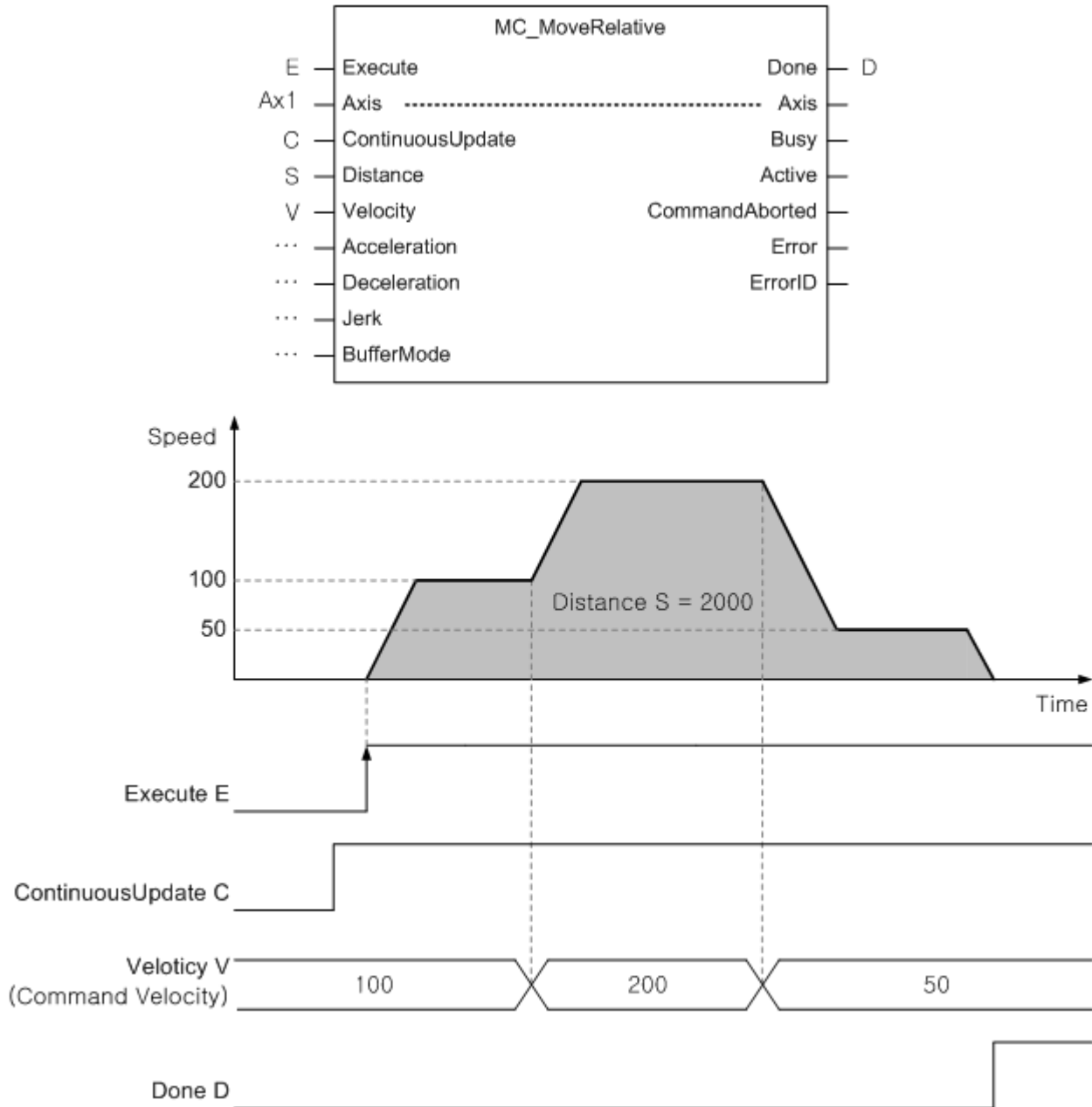
- (1) In case there is no ContinuousUpdate input in motion function block, or execution (Execute input enabled) is made when ContinuousUpdate input is Off, the motion function block is operated with the input at the time when Execute input is On(rising Edge) applied. To operate by changing the input of the motion function block during operation, get the Execute input to be On after changing input value, and the changed value is immediately applied for operation.

[Example] Input variable update of motion control command by re-execution of Execute



- (2) In case ContinuousUpdate input is On in Edge operation motion function block, the input at the time when Execute input is On (rising Edge) is applied to the motion function block if Execute input is On, and the motion function block makes a motion to reflect the change if the input is changed while ContinuousUpdate input is On. However, changes in input are no longer reflected after the operation of the motion function block is completed or stopped (Busy output disabled).

[Example]Input variable update of the motion control command when ContinuousUpdate is On

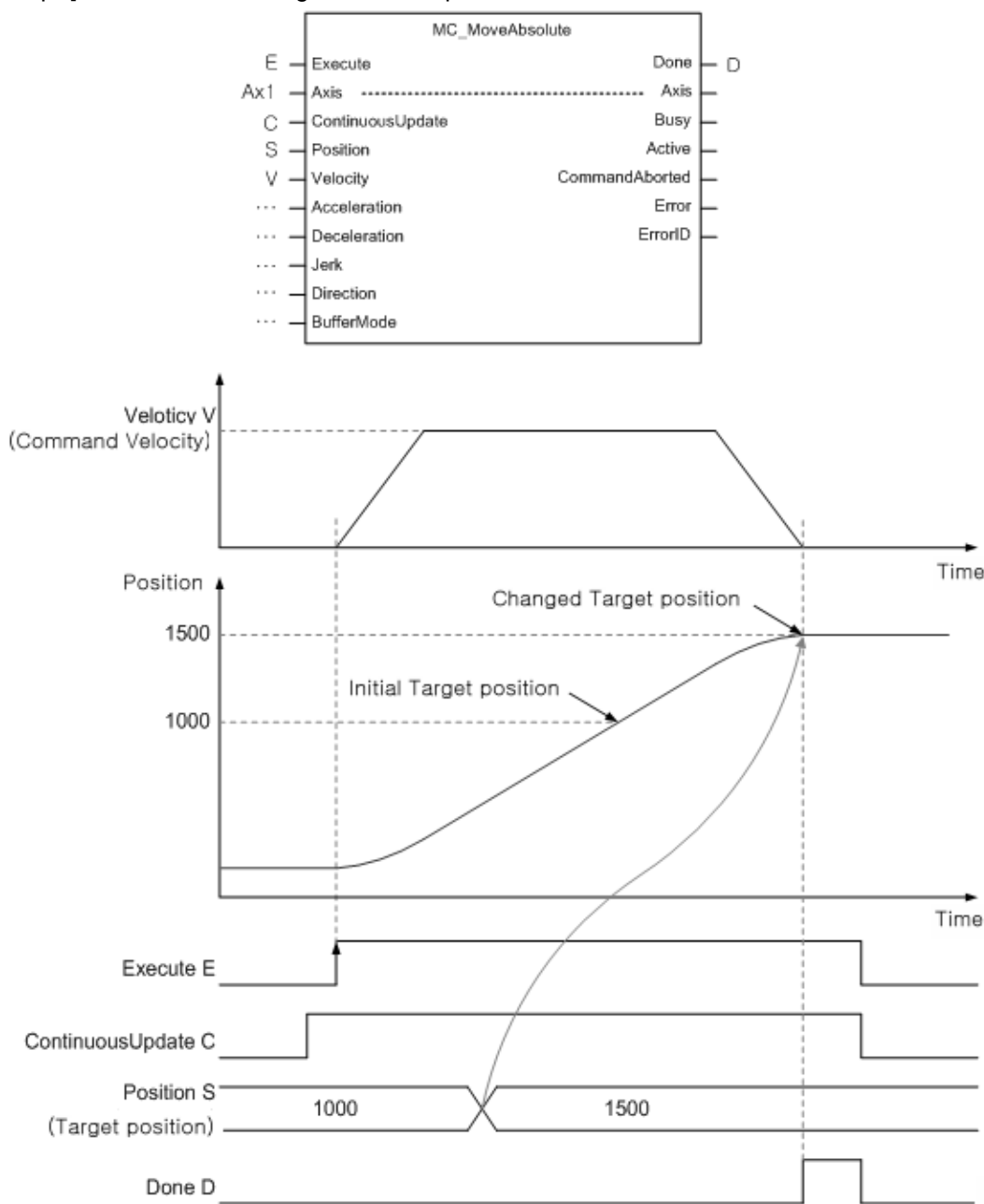


- (3) In case of the level operation motion function block, input variables at the time when Enable input is On (rising Edge) are applied to operate, and input variables can be changed continuously while Enable input is On.

**2. Position override**

- (1) It is a function to override the target position of the axis in position operation. Override function is enabled by using ContinuousUpdate input of the position operation motion function block. When the position operation motion function block is being executed, the position operation to reflect changed objectives is performed by turning Execute input On again by changing the target position after turning ContinuousUpdate input of the motion function block On.
- (2) In case the target position changed at the point in time when changes in the target position are reflected is greater than the position in case of the velocity being reduced to stop from the current velocity, positioning is made in the direction of the current movement. On the contrary, in case the changed position is smaller than the position in case of the velocity being reduced to stop from the current velocity, positioning is made in the direction of the target position by operating to the opposite direction after deceleration stop.

[Example] Position override using ContinuousUpdate



**3. Velocity, Acceleration/Deceleration, Jerk override**

- (1) It is a function to conduct velocity, acceleration/deceleration and jerk override of the specified axis
- (2) It can override velocity, acceleration/deceleration, jerk to absolute value using ContinuousUpdate input of the motion function block in operation. When the operation motion function block is being executed, the operation to reflect changed velocity and acceleration is performed by tuning Execute input On again by changing the velocity and acceleration after turning ContinuousUpdate input of the motion function block On.
- (3) For the execution of speed override operation at the rate on the current command speed, not an absolute value override (MC\_SetOverride) motion function block is used for the override.
  - In case the value is 1.0, the current operating speed, acceleration/deceleration, jerk is the same as before.
  - In case VelFactor value specified is 0.0, the axis comes to a stop, but it cannot be changed to 'StandStill' state.
  - If AccFactor value is 0.0, the changed velocity value is immediately applied without acceleration/deceleration.
  - If JerkFactor value is 0.0, the acceleration/deceleration rate is immediately applied, and therefore the command velocity linearly accelerates/decelerates.
  - The meaning of Factor value specified of override (MC\_SetOverride) motion function block differs depending on the override item value of common parameters.

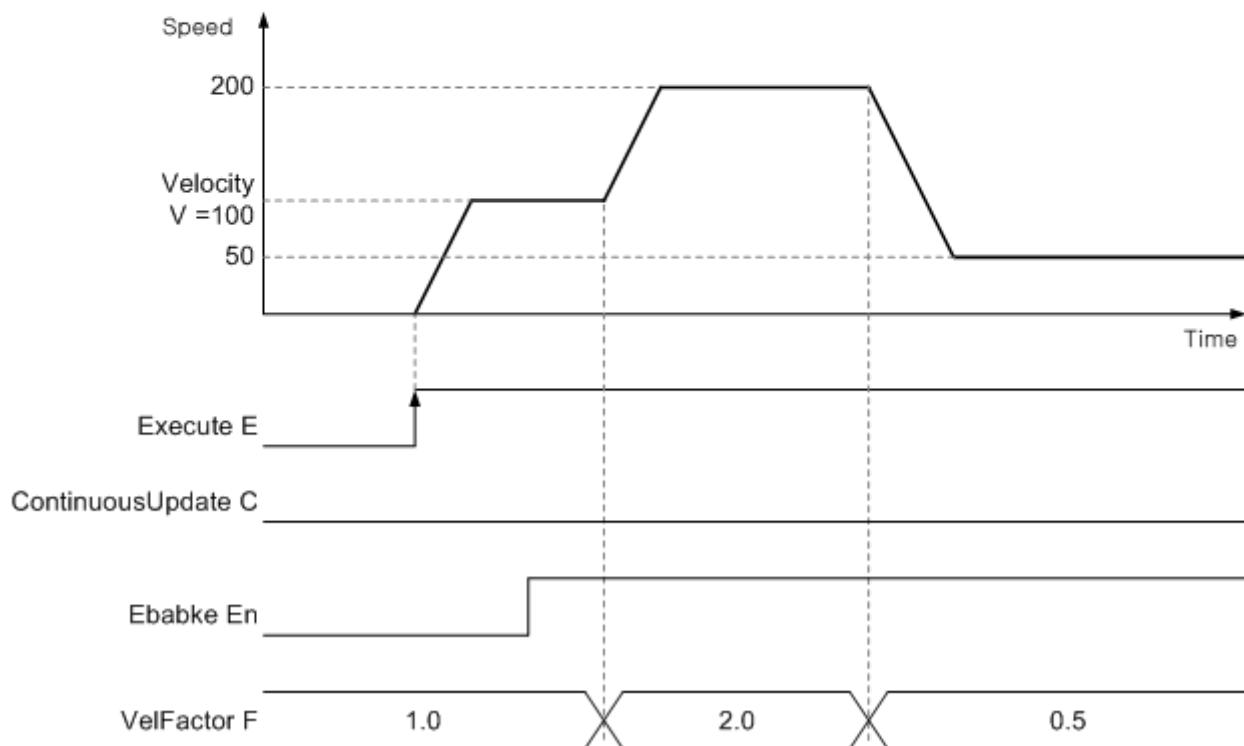
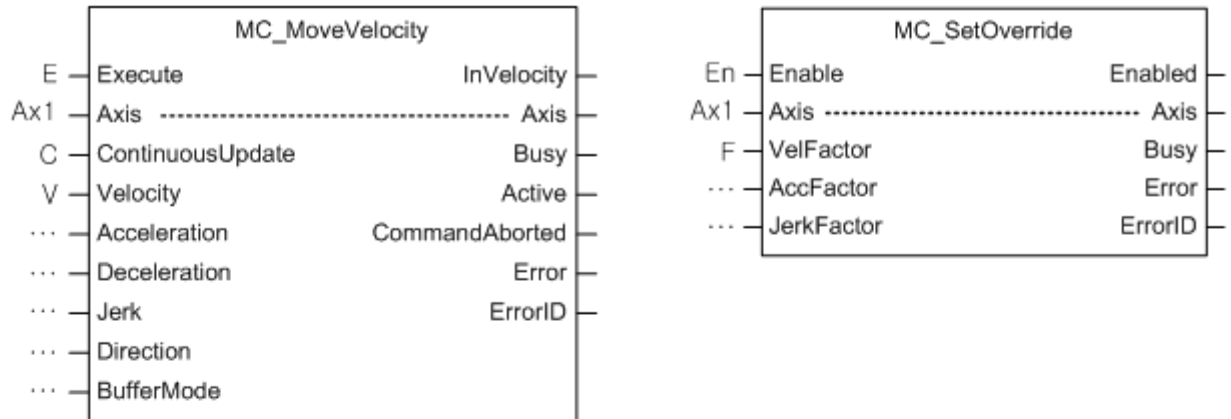
0: percentage specified – Factor value operates at the rate on the current command speed

1: unit value specified – Factor value is an absolute unit specified value of the set item

(4) Motion function block

Name	Description	Operation Condition
MC_SetOverride	Velocity override	level
MC_SetOverride		
BOOL	Enable	Enabled
UINT	Axis	Axis
LREAL	VelFactor	Busy
LREAL	AccFactor	Error
LREAL	JerkFactor	ErrorID
		BOOL
		UINT
		BOOL
		BOOL
		WORD

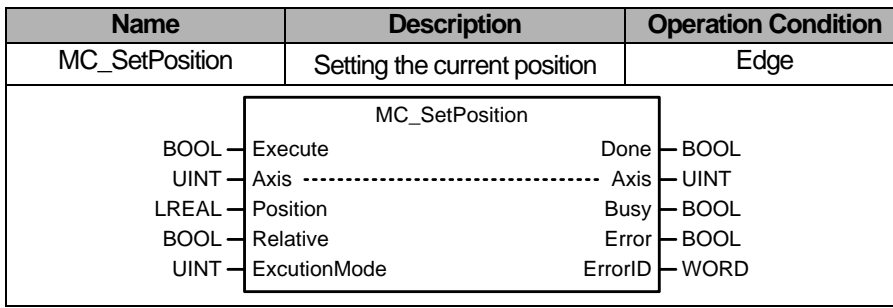
[Example] Changes in velocity using override (MC\_SetOverride) motion function block



**4. Changes in the current position**

- (1) It is a function to change the current position of the axis to the value specified by users.
- (2) In Position input, the position is specified. In case Relative input is Off state when command is executed, the position of the axis is replaced with the Position input value, and in case Relative input is On state, Position input value is added to the current position of the axis.
  - 0: Absolute coordinate position
  - 1: Relative coordinate position
- (3) Set point can be specified with ExcutionMode input. When the input value is 0, the set value is set immediately after the execution of commands, and in case it is 1, it is set in the same time with 'Buffered' in a sequential operation setting.
  - 0: Position value applied immediately
  - 1: Applied in the same time with 'Buffered' of Buffermode

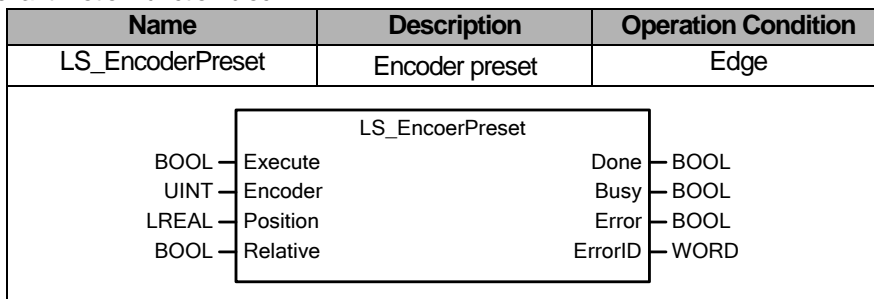
(4) Relevant motion function block



**5. Encoder preset**

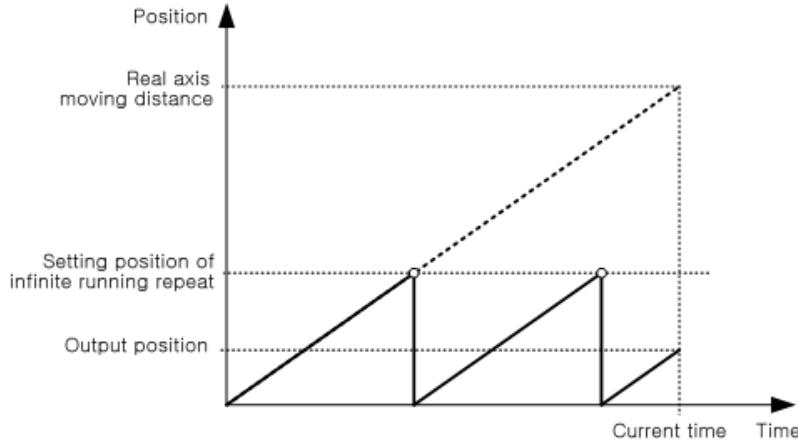
- (1) It is a function to change the current encoder position value to any position value specified by users.
- (2) In Encoder input, encoder to be changed is specified.
  - 1: Encoder 1
  - 2: Encoder 2
- (3) In Position input, the encoder position is specified. In case Relative input is Off state when command is executed, the encoder position of the axis is replaced with the Position input value, and in case Relative input is On state, Position input value is added to the current position of the encoder.
  - 0: Absolute coordinate position
  - 1: Relative coordinate positionEncoder

(4) Relevant motion function block



**6. Infinite running operation**

- (1) Infinite running repetition function is to perform periodic updates on the display values of the command position and current position automatically with values set in 'infinite running repetition position' among expansion parameters of operating parameters. The use of infinite running repetition positioning function makes it possible to determine the position with repeated position value on the same direction.



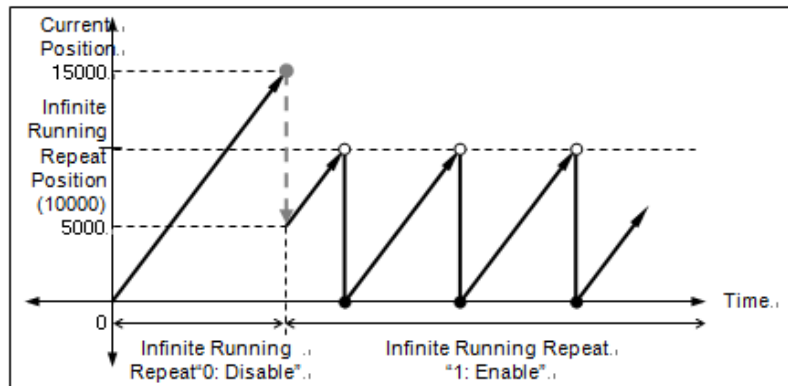
- (2) The instant 'infinite running repetition' parameter among expansion parameters of operating parameters is set to Allow, the current position is automatically changed to value within the infinite running repetition position in case it is the value other than the range of infinite running repetition position.

[Example 1] In case the current position is -32100 and infinite running repetition position 10000

When infinite running repetition "1: Allow" is set, the current position becomes 7900.

[Example 2] In case the current position is 15000, and infinite running repetition position 10000

When infinite running repetition "1: Allow" is set, the current position becomes 5000.



- (3) Infinite running repetition setting of driving axis can be made by using software package or axis parameter change function.
- (4) Relevant parameter setting

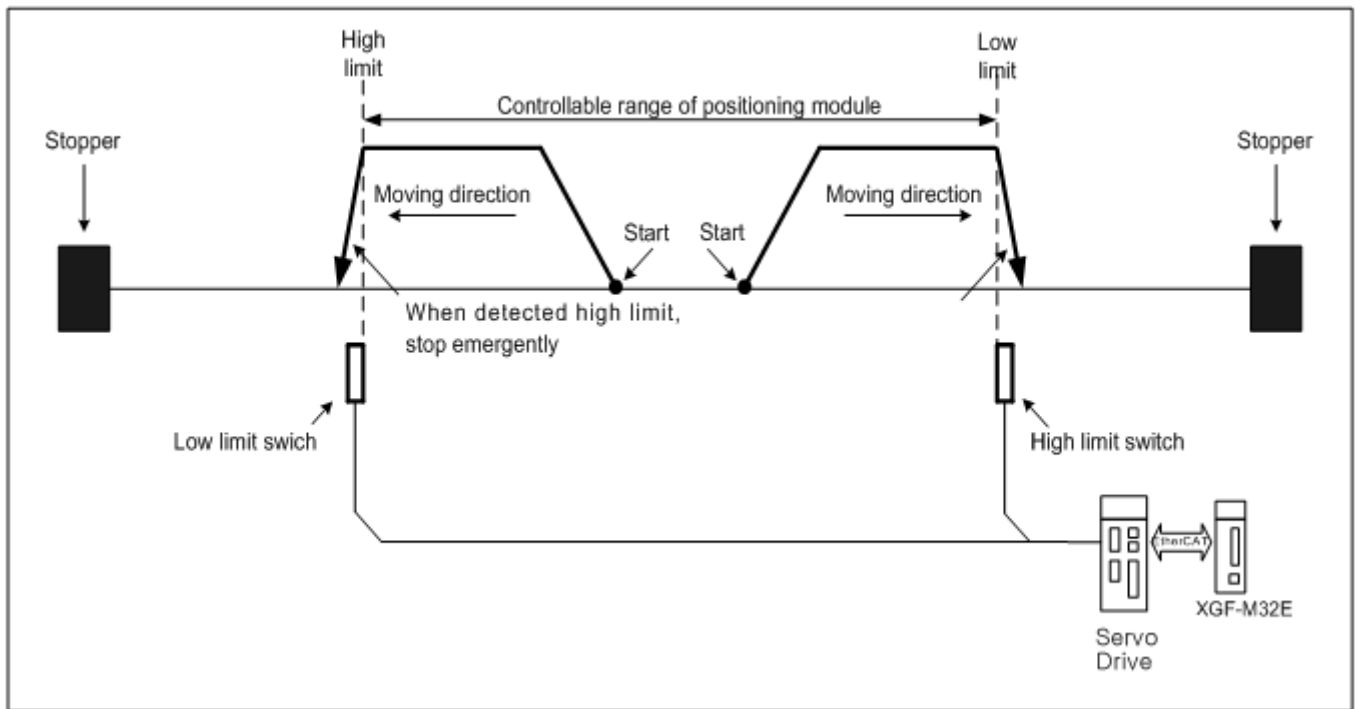
Item	Description	Settings	Initial Value
Infinite running repetition position	Set repeated position range value in case of being used as infinite running repetition mode	Long Real (LREAL) Positive	360 pls
Infinite running repetition	Set whether to allow infinite running repetition operation function	0: Disable 1: Enable	0: prohibited



### 8.3.2 Auxiliary Function of Control

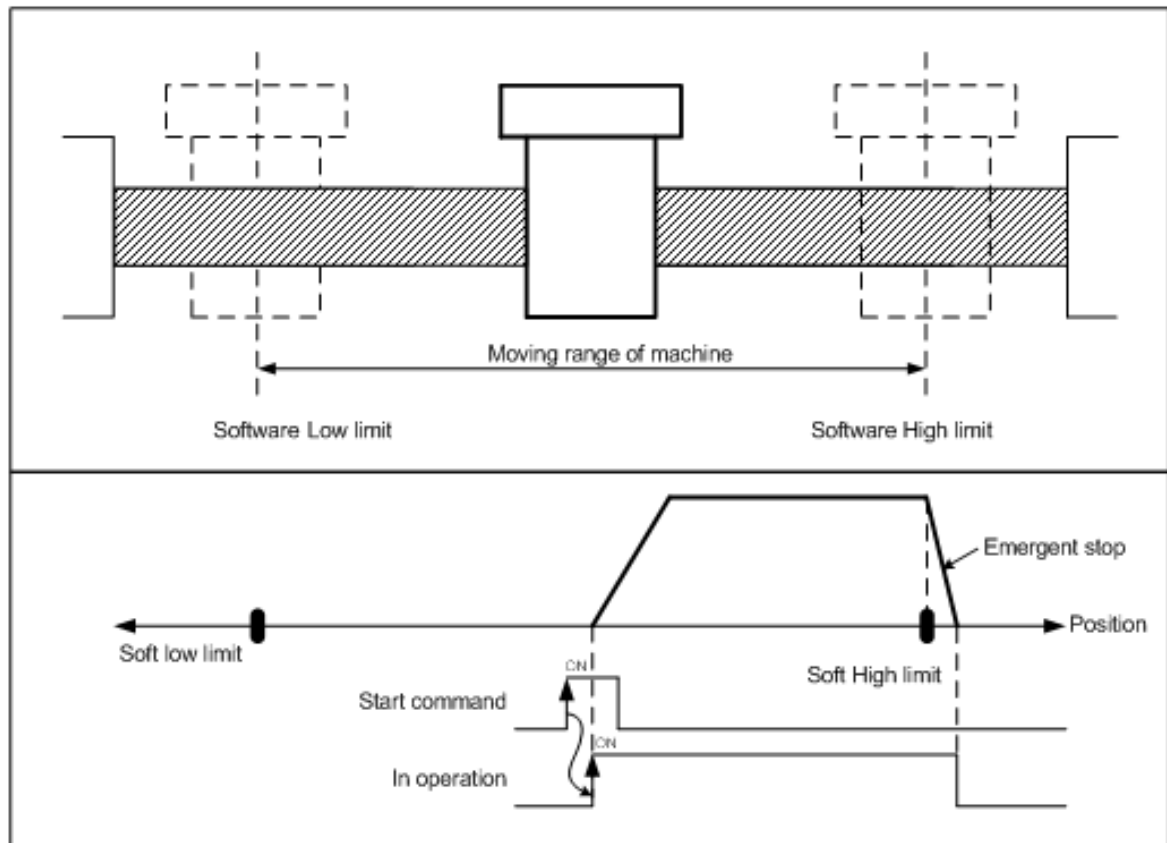
#### 1. Hardware high/low limit

- (1) It is used to make a sudden stop of servo drive before reaching lower limit/upper limit of the machine side by installing high/low limit switch in the inside of the high/low limit, the physical operating range of the machine side. In this case, the range is out of the upper limit, error '0x1200' occurs, and lower limit, error '0x1201'.
- (2) Input of hardware high/low limit switch is connected to each servo drive, and operation is stopped by servo drive at the time of high/low limit detection, and module immediately terminates the motion which is currently being operated.
- (3) In case of the stop due to the detection of hardware high/low limit signals, it is required to move inside the controllable range of motion control module with jog operation of the opposite direction of the detected signals.
- (4) Hardware high/low limit motions are as follows.



**2. Soft high/low limit**

- (1) Software stroke high/low limit is a function that does not perform the operation in out of the range of soft high/low limit set by users.
- (2) Software stroke high/low limit of each driving axis can be set by using software package or axis parameter change function.
- (3) If the axis is outside the range of stroke, axis error occurs.
- (4) When the axis is positioned outside the range of stroke, operation of the axis is impossible except for jog. Operation can be resumed by moving it inside the range of stroke through jog operation or resetting the current position to the inside the stroke range.



(5) Software high/low limit are don't detecte in the following cases.

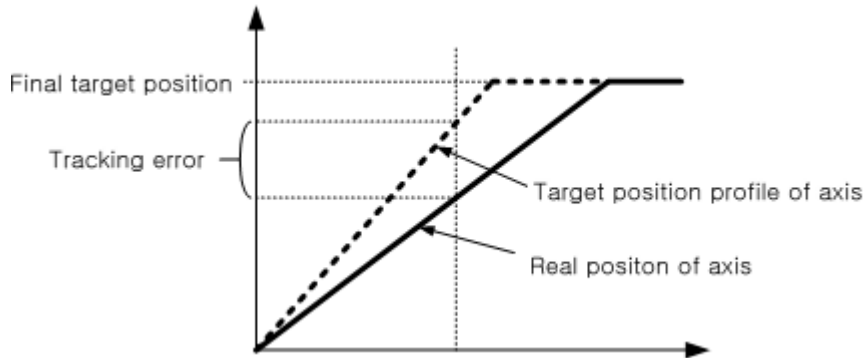
- In case soft upper limit value and lower limit value are set to the initial value ( upper limit: 2147483647, lower limit: -2147483648)
- Software upper limit value and lower limit value are set to the same value (software upper limit = software lower limit)
- In case of the operation with speed control when expansion parameter "S/W limits during speed control" is set to " 0: Don't detect"

(6) Relevant parameter setting

Item	Description	Settings	Initial Value
S/W upper limit	Set the range of software limit function	Long Real(LREAL)	2147483647 pls
S/W lower limit			-2147483648 pls

3. Position tracking error

- (1) It is a function to output an error when driving axis is in position operation, or the actual position read from the axis is further beyond tracking tolerance than the target position of the position operation instruction profile.
- (2) Position tracking tolerance of each driving axis can be set by using software package or axis parameter change function



- (3) Whether to set abnormality to a warning or an alarm in case of the occurrence of tracking error can be set in Tracking Error Level of expansion parameter.

Motions according to the set value are as follows.

- '0: warning'  
When tracking error occurs, 「Above deviation alarm(\_AXxx\_DEV\_WARN)」 flag becomes On, and tracking error warning error (error code: 0x101D) occurs. The axis continues to operate without stopping.
- '1: alarm'  
When tracking error occurs, 「Above deviation alarm(\_AXxx\_DEV\_ERR)」 flag becomes On, and tracking error alarm error (error code: 0x101C) occurs. The axis makes a sudden stop at 「Sudden stop deceleration」.

- (4) Inspection on tracking error is not performed in the following cases.

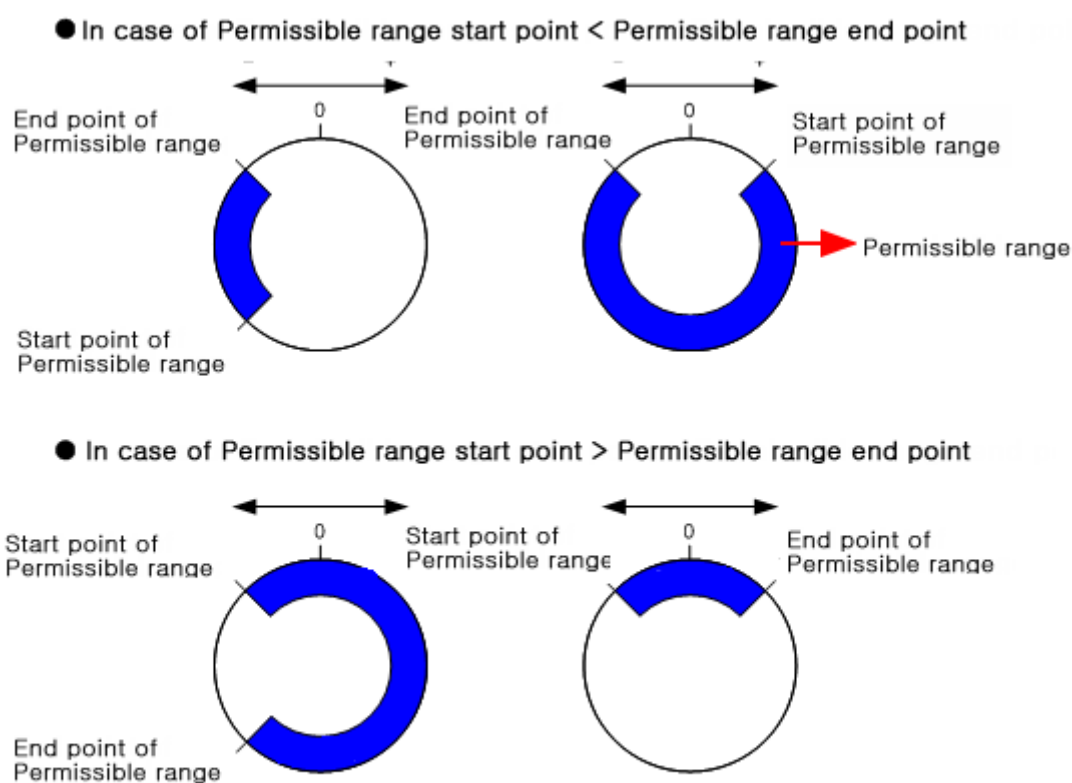
- In case 「Tracking error exceeding value」 is 0
- In case of operation with homing or torque control

- (5) Relevant parameter setting

Item	Description	Settings	Initial Value
Tracking error exceeding value	Set the value to detect more than the position deviation	0 or Long Real(LREAL) Positive	0
Tracking error level	Set the above deviation error level	0: warning 1: alarm	0: warning

#### 4. Latch(Touch Probe)

- (1) It is a function to record the position of the axis when specific situation (Trigger event) occurs in the axis.
- (2) Touch probe 1 and 2 can be selected to use according to trigger input (TriggerInput) settings.
  - Trigger input (TriggerInput)=0 : Latch function is performed when touch probe 1 signal is Off->On .
  - Trigger input (TriggerInput)=1 : Latch function is performed when touch probe 2 signal is Off->On .
- (3) The area in which latch (touch probe) function is operated can be specified.
  - When permitted area is specified, operation can be made only within the specified area.
  - In case of the infinite running repetition operation (rotary axis), the relationship of latch (touch probe) operating area according to the beginning and end of the permitted area is as follows.

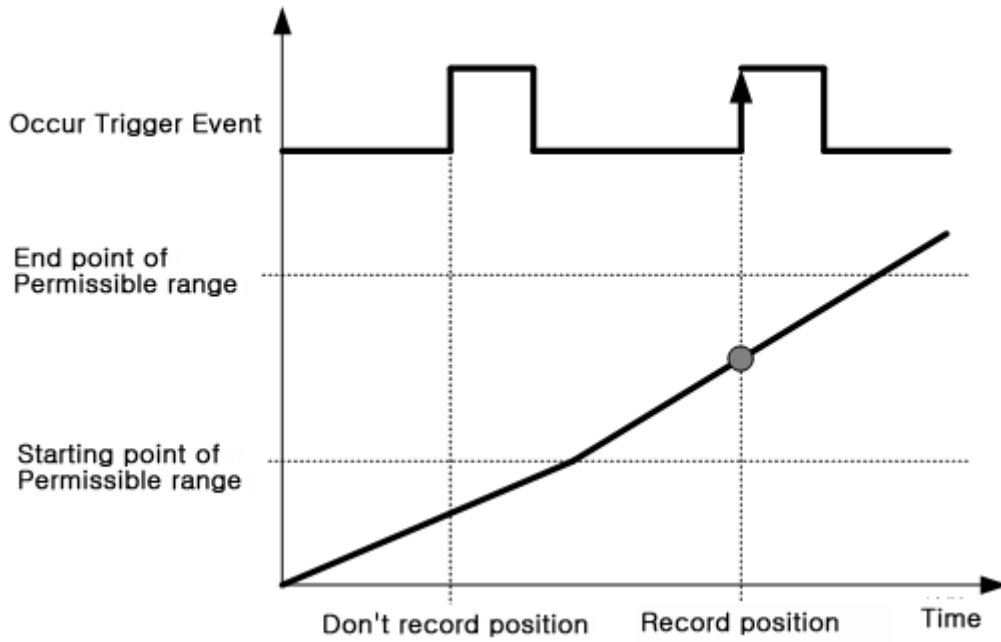


- (4) For the use of latch (touch probe) function, the following objects should be included in PDO setting of slave parameter.

Trigger input	RxPDO	TxPDO
Touch Probe1	0x60B8:0 Touch probe function	0x60B9:0 Touch probe status 0x60BA:0 Forward direction position value of touch probe1
Touch Probe2	0x60B8:0 Touch probe function	0x60B9:0 Touch probe status 0x60BC:0 Forward direction position value of touch probe1

In case there are not above objects, an error (error code: 0x10E0) occurs when latch (touch probe) command is used.

(5) Operation timing



(6) Relevant motion function block

Name	Description	Operation Condition																		
MC_TouchProbe	Touch probe	Edge																		
<table border="1"> <thead> <tr> <th colspan="2">MC_TouchProbe</th> </tr> </thead> <tbody> <tr> <td>BOOL Execute</td> <td>Done</td> </tr> <tr> <td>UINT Axis</td> <td>Axis</td> </tr> <tr> <td>UINT TriggerInput</td> <td>TriggerInput</td> </tr> <tr> <td>BOOL WindowOnly</td> <td>Busy</td> </tr> <tr> <td>LREAL FirstPosition</td> <td>CommandAborted</td> </tr> <tr> <td>LREAL LastPosition</td> <td>Error</td> </tr> <tr> <td></td> <td>ErrorID</td> </tr> <tr> <td></td> <td>RecordedPosition</td> </tr> </tbody> </table>			MC_TouchProbe		BOOL Execute	Done	UINT Axis	Axis	UINT TriggerInput	TriggerInput	BOOL WindowOnly	Busy	LREAL FirstPosition	CommandAborted	LREAL LastPosition	Error		ErrorID		RecordedPosition
MC_TouchProbe																				
BOOL Execute	Done																			
UINT Axis	Axis																			
UINT TriggerInput	TriggerInput																			
BOOL WindowOnly	Busy																			
LREAL FirstPosition	CommandAborted																			
LREAL LastPosition	Error																			
	ErrorID																			
	RecordedPosition																			

Name	Description	Operation Condition														
MC_AbortTrigger	Abort trigger	Edge														
<table border="1"> <thead> <tr> <th colspan="2">MC_AbortTrigger</th> </tr> </thead> <tbody> <tr> <td>BOOL Execute</td> <td>Done</td> </tr> <tr> <td>UINT Axis</td> <td>Axis</td> </tr> <tr> <td>UINT TriggerInput</td> <td>TriggerInput</td> </tr> <tr> <td></td> <td>Busy</td> </tr> <tr> <td></td> <td>Error</td> </tr> <tr> <td></td> <td>ErrorID</td> </tr> </tbody> </table>			MC_AbortTrigger		BOOL Execute	Done	UINT Axis	Axis	UINT TriggerInput	TriggerInput		Busy		Error		ErrorID
MC_AbortTrigger																
BOOL Execute	Done															
UINT Axis	Axis															
UINT TriggerInput	TriggerInput															
	Busy															
	Error															
	ErrorID															

## 5. Error reset monitoring

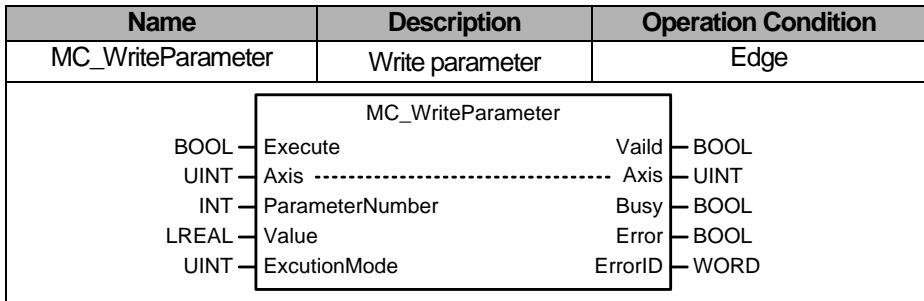
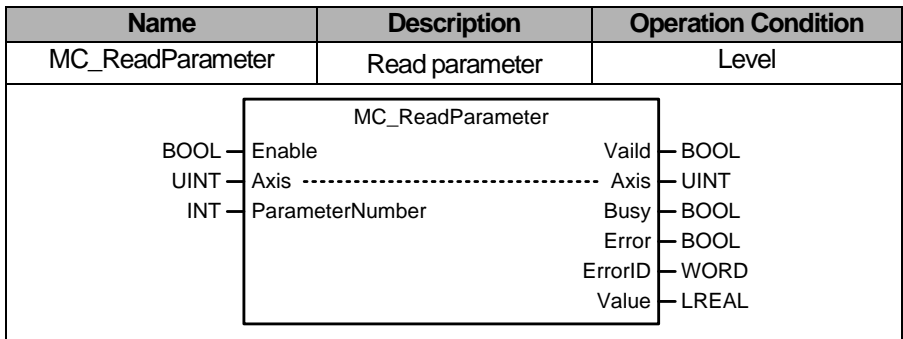
- (1) In case an error occurs in servo drive at the time of resetting error that occurs in the axis due to error reset commands, whether servo drive error is properly reset can be verified by setting error reset monitoring time.
- (2) If monitoring time is exceeded, error reset is not executed any more even if the error of the drive is not reset..
- (3) Error reset monitoring time of each driving axis can be set by using software package or axis parameter change function.
- (4) Relevant parameter setting

Item	Description	Settings	Initial Value
Error reset monitoring time	Set the monitoring time in case of resetting error that occurs in servo drive	1 ~ 1000 ms	100 ms

### 8.3.3 Data Management Function

#### 1. Parameter management

- (1) It is a function to read or change axis parameters stored in the module.
- (2) It can change desired parameter values by specifying axis number and corresponding parameter number.
- (3) Parameter value modified with parameter-write function is automatically stored in backup.ram in case there is no error.
- (4) For parameters to be set in "ParameterNumber", refer to the motion function block item.
- (5) Relevant motion function block



#### 2. Changes in position data

- (1) Position data can be changed in the way that downloads modules by setting position data in XG-PM or directly writes position data variables in user program.
- (2) In case of the position data, outage is directly maintained without data storage command.
- (3) The addressing range of position data variables available is as follows.

Variable Type	Selecting range of Variable address
LREAL	%PL0 ~ %PL6399

### 3. Cam data management

It is able to read and change the cam data in program by the cam data Cam data reading/writing command

(1) Cam data reading

- CmDataRead command reads the cam profile data designated by CamTable ID when Enable input is enabled, and saves the data to the data area specified as MasterPoint and SlavePoint.
- The first address of the variables to store "Main-axis Position" and "Sub-axis Position" read from the camp profile is set at the MasterPoint and the SlavePoint. For example, to save the "Main-axis Position" to the array vairable called MainAxPos[100], and "Sub-axis Position" value to SubAsPos[100] array variable, MainAxPos[0] should be set at MasterPoint of the function block, and SubAsPos[0] should be set at SlavePoint.
- At CamCurveSel[4], the interpolation typesof the applicable points for each bit are stored.

CamCurveSel[0]	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Point 8	Point 7	Point 6	Point 5	Point 4	Point 3	Point 2	Point 1
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Point 16	Point 15	Point 14	Point 13	Point 12	Point 11	Point 10	Point 9
	Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16
	Point 24	Point 23	Point 22	Point 21	Point 20	Point 19	Point 18	Point 17
	Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24
CamCurveSel[1]	Point 32	Point 31	Point 30	Point 29	Point 28	Point 27	Point 26	Point 25
	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Point 40	Point 39	Point 38	Point 37	Point 36	Point 35	Point 34	Point 33
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Point 48	Point 47	Point 46	Point 45	Point 44	Point 43	Point 42	Point 41
	Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16
	Point 56	Point 55	Point 54	Point 53	Point 52	Point 51	Point 50	Point 49
CamCurveSel[2]	Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24
	Point 64	Point 63	Point 62	Point 61	Point 60	Point 59	Point 58	Point 57
	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Point 72	Point 71	Point 70	Point 69	Point 68	Point 67	Point 66	Point 65
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Point 80	Point 79	Point 78	Point 77	Point 76	Point 75	Point 74	Point 73
	Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16
CamCurveSel[3]	Point 88	Point 87	Point 86	Point 85	Point 84	Point 83	Point 82	Point 81
	Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24
	Point 96	Point 95	Point 94	Point 93	Point 92	Point 91	Point 90	Point 89
	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Not used				Point 100	Point 99	Point 98	Point 97
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Not used							
Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16	
Not used								
Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24	
Not used								



(2) Cam data writing

- CamDataWrite command writes the value set in StartSlope and EndSlope of the cam profile designated by CamTable ID and the device value set in MasterPoint and SlavePoint in the number designated by CamPointNum as "Main-axis Position" and "Sub-axis Position" when Execute input is on.
- At CamCurveSel[4], the interpolation types of the applicable points for each bit can be set.

CamCurveSel[0]	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Point 8	Point 7	Point 6	Point 5	Point 4	Point 3	Point 2	Point 1
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Point 16	Point 15	Point 14	Point 13	Point 12	Point 11	Point 10	Point 9
	Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16
	Point 24	Point 23	Point 22	Point 21	Point 20	Point 19	Point 18	Point 17
	Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24
CamCurveSel[1]	Point 32	Point 31	Point 30	Point 29	Point 28	Point 27	Point 26	Point 25
	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Point 40	Point 39	Point 38	Point 37	Point 36	Point 35	Point 34	Point 33
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Point 48	Point 47	Point 46	Point 45	Point 44	Point 43	Point 42	Point 41
	Bit 23	Bit 22	Bit 21	Bit 20	Bit 1...09	Bit 18	Bit 17	Bit 16
	Point 56	Point 55	Point 54	Point 53	Point 52	Point 51	Point 50	Point 49
CamCurveSel[2]	Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24
	Point 64	Point 63	Point 62	Point 61	Point 60	Point 59	Point 58	Point 57
	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Point 72	Point 71	Point 70	Point 69	Point 68	Point 67	Point 66	Point 65
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Point 80	Point 79	Point 78	Point 77	Point 76	Point 75	Point 74	Point 73
	Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16
CamCurveSel[3]	Point 88	Point 87	Point 86	Point 85	Point 84	Point 83	Point 82	Point 81
	Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24
	Point 96	Point 95	Point 94	Point 93	Point 92	Point 91	Point 90	Point 89
	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
	Not used				Point 100	Point 99	Point 98	Point 97
	Bit 15	Bit 14	Bit 13	Bit 12	Bit 11	Bit 10	Bit 9	Bit 8
	Not used							
Bit 23	Bit 22	Bit 21	Bit 20	Bit 19	Bit 18	Bit 17	Bit 16	
Not used								
Bit 31	Bit 30	Bit 29	Bit 28	Bit 27	Bit 26	Bit 25	Bit 24	
Not used								

- CamTableID input can set the range of 1~32. The setting value outside the setting range causes error "16#000B"
- CamPointNum can set the range of 1~100. The setting value outside the setting range causes error "16#000B"

(3) Motion function block

■ Cam data reading

Name	Description	Operation Condition
LS_ReadCamData	Cam data reading	Level
LS_ReadCamData		
BOOL—Enable	Done	BOOL
UINT—Axis	Axis	UINT
UINT—CamTable ID	Busy	BOOL
LREAL—MasterPoint	Error	BOOL
LREAL—SlavePoint	ErrorID	WORD
	StartSlope	LREAL
	EndSlope	LREAL
	CamPointNum	UINT
	CamCurveSel	Array [4] of DWORD

■ Cam data writing

Name	Description	Operation Condition
LS_WriteCamData	Cam data writing	Edge
LS_WriteCamData		
BOOL—Execute	Done	BOOL
UINT—Axis	Axis	UINT
UINT—CamTable ID	Busy	BOOL
LREAL—StartSlope	Error	BOOL
LREAL—EndSlope	ErrorID	WORD
UINT—CamPointNum		
Array[4] of DWORD—CamCurveSel		
LREAL—MasterPoint		
LREAL—SlavePoint		
UINT—ExecutionMode		

4. SDO parameter management

- (1) This function reads or changes SDO parameters of slave devices connected via network.
- (2) Parameter values for a certain axis number and the corresponding object number can be read or changed. Parameter number is specified by Index and SubIndex. Parameter size is specified by Length
- (3) Index input can be set as follows. If it is not set as the setting value, "Error 0x1F12" occurs.

설정값	내용
16#0000 ~ 16#0FFF	Data Type Description
16#1000 ~ 16#1FFF	Communication objects
16#2000 ~ 16#5FFF	Manufacturer Specific Profile Area
16#6000 ~ 16#9FFF	Standardized Device Profile Area

- (4) In Subindex, values ranging from 0 to 255 can be entered, and if set outside the range, "Error 0x1F12." occurs.
- (5) In Length, values ranging from 1 to 4 can be entered, which mean 1 to 4 bytes. Setting the value outside the above range will cause "Error 0x1F12."
- (6) The parameter values changed by servo parameter write function are not automatically stored to the ROM of the slave device. In order to store the changed parameters to the servo drive EEPROM, please use ServoParameterSave command.
- (7) Motion function block

■ Servo parameter reading

Name	Description	Operation Condition														
MC_ReadServoParameter	Servo parameter reading	Level														
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2">MC_ReadServoParameter</th> </tr> </thead> <tbody> <tr> <td>BOOL — Execute</td> <td>Done — BOOL</td> </tr> <tr> <td>UINT — Axis .....</td> <td>Axis — UINT</td> </tr> <tr> <td>UINT — Index</td> <td>Busy — BOOL</td> </tr> <tr> <td>UINT — SubIndex</td> <td>Error — BOOL</td> </tr> <tr> <td>UINT — Length</td> <td>ErrorID — WORD</td> </tr> <tr> <td></td> <td>Value — DINT</td> </tr> </tbody> </table>			MC_ReadServoParameter		BOOL — Execute	Done — BOOL	UINT — Axis .....	Axis — UINT	UINT — Index	Busy — BOOL	UINT — SubIndex	Error — BOOL	UINT — Length	ErrorID — WORD		Value — DINT
MC_ReadServoParameter																
BOOL — Execute	Done — BOOL															
UINT — Axis .....	Axis — UINT															
UINT — Index	Busy — BOOL															
UINT — SubIndex	Error — BOOL															
UINT — Length	ErrorID — WORD															
	Value — DINT															

■ Servo parameter writing

Name	Description	Operation Condition																
MC_WriteServoParameter	Servo parameter writing	Edge																
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2">MC_WriteServoParameter</th> </tr> </thead> <tbody> <tr> <td>BOOL — Execute</td> <td>Done — BOOL</td> </tr> <tr> <td>UINT — Axis .....</td> <td>Axis — UINT</td> </tr> <tr> <td>UINT — Index</td> <td>Busy — BOOL</td> </tr> <tr> <td>UINT — SubIndex</td> <td>Error — BOOL</td> </tr> <tr> <td>UINT — Length</td> <td>ErrorID — WORD</td> </tr> <tr> <td>DINT — Value</td> <td></td> </tr> <tr> <td>UINT — ExecutionMode</td> <td></td> </tr> </tbody> </table>			MC_WriteServoParameter		BOOL — Execute	Done — BOOL	UINT — Axis .....	Axis — UINT	UINT — Index	Busy — BOOL	UINT — SubIndex	Error — BOOL	UINT — Length	ErrorID — WORD	DINT — Value		UINT — ExecutionMode	
MC_WriteServoParameter																		
BOOL — Execute	Done — BOOL																	
UINT — Axis .....	Axis — UINT																	
UINT — Index	Busy — BOOL																	
UINT — SubIndex	Error — BOOL																	
UINT — Length	ErrorID — WORD																	
DINT — Value																		
UINT — ExecutionMode																		

■ Servo parameter saving

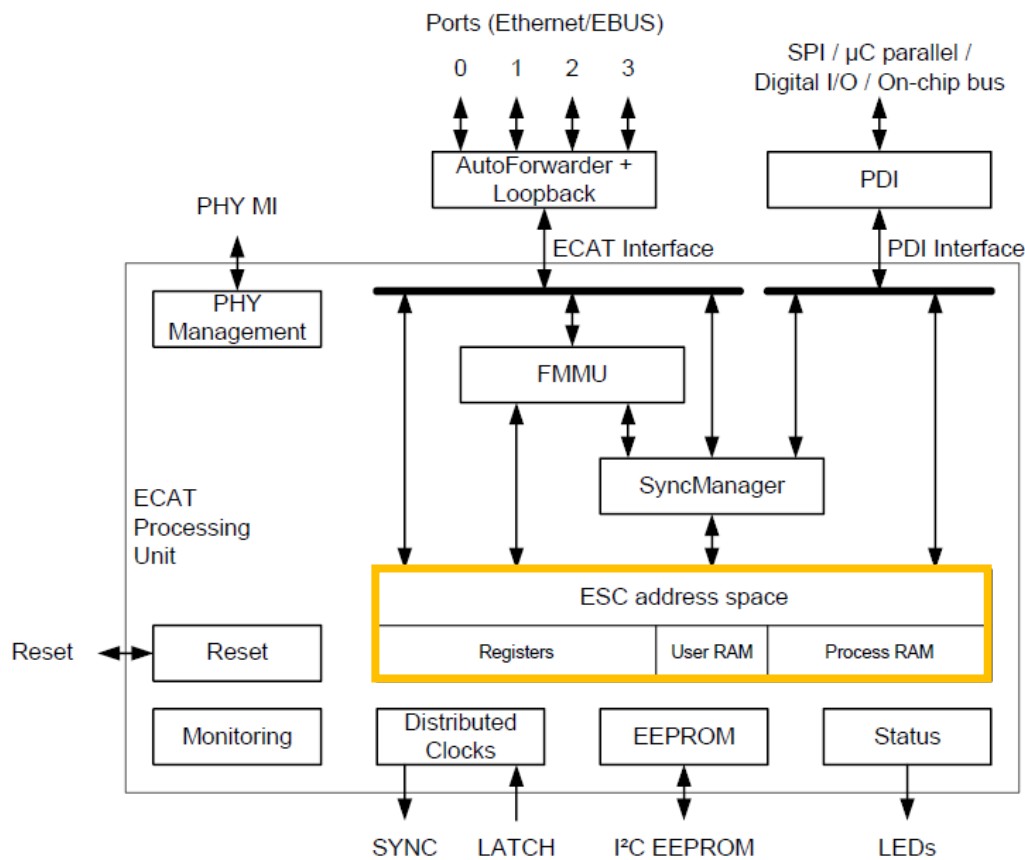
Name	Description	Operation Condition												
MC_SaveServoParameter	Servo parameter saving	Edge												
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2">LS_SaveServoParameter</th> </tr> </thead> <tbody> <tr> <td>BOOL — Execute</td> <td>Done — BOOL</td> </tr> <tr> <td>UINT — Axis .....</td> <td>Axis — UINT</td> </tr> <tr> <td>UINT — ExecutionMode</td> <td>Busy — BOOL</td> </tr> <tr> <td></td> <td>Error — BOOL</td> </tr> <tr> <td></td> <td>ErrorID — WORD</td> </tr> </tbody> </table>			LS_SaveServoParameter		BOOL — Execute	Done — BOOL	UINT — Axis .....	Axis — UINT	UINT — ExecutionMode	Busy — BOOL		Error — BOOL		ErrorID — WORD
LS_SaveServoParameter														
BOOL — Execute	Done — BOOL													
UINT — Axis .....	Axis — UINT													
UINT — ExecutionMode	Busy — BOOL													
	Error — BOOL													
	ErrorID — WORD													

### 8.3.4 EtherCAT communication diagnosis function

EtherCAT slave devices perform EtherCAT communication using ASIC, FPGA, or EtherCAT Slave Controller (ESC) included in the standard micro controller. The communication diagnosis function of EtherCAT reads and writes the ECS (EtherCAT Slave Controller) registers and memories of the slave device, allowing the user to check EtherCAT communication status and errors. EtherCAT communication diagnosis function can be used whether communication is normal or disconnected.

#### 1. EtherCAT Slave Controller (ESC)

(1) ECS is configured as follows. Diagnosis function commands can be used to read and write in the ESC address spaces shown in the block diagram below.



(2) ESC address space is configured as follows.

Address	Define	Remarks
0x0000	ESC Register	ESC Information, FMMU, SyncManager, Distributed Clocks(DC).
:		
0x0FFF		
0x1000	Process Data RAM	Digital I/O Input Data, Process Data RAM (1KB ~ 60KB)
:		
0xFFFF		

※ Please refer to EtherCAT Slave Controller (ESC) data sheet for detailed information on register and Process RAM.

2. ESC reading

- (1) This function reads data in ESC of the slave devices connected via network.
- (2) Adp(Address position) is designating the address of the EtherCAT slave device. The following values can be set depending on the EcatCmd setting. If EcatCmd setting is 7(BRD), Adp input value is ignored

EcatCmd	Adp range
1 (APRD)	0x0000: The first slave connected 0xFFFF: The second slave connected 0xFFFE: The third slave connected : 0xFFDD: 36th slave connected
4 (FPRD)	1001 ~ 1036: Slave 1 ~ Slave 36
7 (BRD)	-

- (3) In Length, values ranging from 1 to 4 can be entered, which means 1-4 bytes.
- (4) At EcatCmd, the type of command to use when reading ESC (EtherCAT Slave Controller) is specified. The following three commands can be used:

(a) 1- APRD(Auto Increment Physical Read)

This command is used when reading the slave device data following the order of physical connection before normal communication connection by the master. The slave device receiving Adp with 0 value will read the data of the size designated by Length. Adp of each slave device increases when EtherCAT frame is received. . For example, if EcatCmd is 1, and Adp is set to 0xFFFF, when executing ESC read function block, reading is not performed because the Adp at the time of receiving EtherCAT frame from the first slave device is not 1, only increasing Adp by 1. When the second slave device receives EtherCAT frame, reading is performed because the Adp value of the first slave value increased by 1 to 0. The Adp values depending on the slave device connection order are as follows

Slave controller	Setting value
The first slave connected	0
The second slave connected	0xFFFF
:	:
36th slave connected	0xFFDD

(b) 4 - FPRD (Configured Address Physical Read)

This order is used to read the data by designating the station address of the slave device after normal communication connection by the master. If the Station Address of the slave device set by EtherCAT master matches the transmitted Adp, the slave device reads data of the size designated by Length in the Ado area. The Station Address of slave device set by the master are as follows.

Slave controller	Setting value
Slave 1	1001
Slave 2	1002
:	:
Slave 36	1036

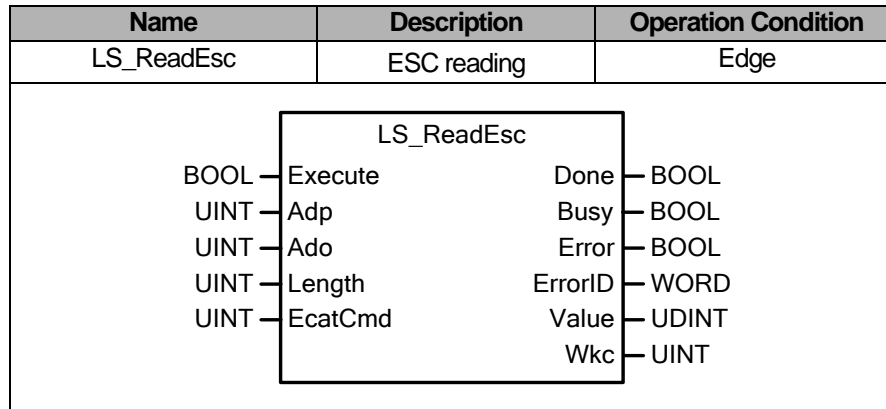
(c) 7 - BRD (Broadcast Read)

All connected slave devices read data of the size set by Length in the Ado area, and saves the result after Bitwise-OR. The designated address value at Adp is ignored, and Wkc increase by 1 due to all slaves that performed normal read operation

- (5) Value and Wkc is displayed as 0 when the motion function block is executed. When the execution is completed (Done

output is on), the read data value is displayed at Value, and the Working Counter value is displayed at Wkc.

- (6) Wkc stands for Working Counter. If data is successfully written at the designated slave device, it increases by 1. If EcatCmd is 7(BRD), it increases by 1 due to all slaves that performed normal reading operation.
- (7) After the execution of ESC read command, if normal data read operation is executed from the designated slave device, Doneoutput is on.
- (8) ESC read comand and ESC write command cannot be simultaneously executed. If they are executed at the same time, the command of the program last executed is executed, and an error (0x1021) occurs in the preceding command.
- (9) Function block



(10) In the following cases, ESC reading cannot be performed due to errors, properly.

- 1) No slave device is connected to module (Error Code: 0x0F09)
- 2) Adp setting value is outside the range (Error Code: 0x0F60)
- 3) Length setting value is outside the range (Error Code: 0x0F61)
- 4) EcatCmd setting value is outside the range (Error Code: 0x0F62)
- 5) No response to ESC read command (Error Code: 0x0F63)

### 3. ESC writing

- (1) This function writes data in ESC of the slave devices connected via network.
- (2) Adp input specifies the EtherCAT slave device address, and the following values can be set depending on EcatCmdsettings. If EcatCmd setting is 8(BWR), Adp input value is ignored

EcatCmd	Adp range
2 (APWR)	0x0000: The first slave connected 0xFFFF: The second slave connected 0xFFFE: The third slave connected : 0xFFDD: 36th slave connected
5 (FPWR)	1001 ~ 1036: Slave 1 ~ Slave 36
8 (BWR)	-

- (3) Adp input specifies the EtherCAT slave device address, and the following values can be set depending on EcatCmd settings. If EcatCmd setting is 8(BWR), Adp input value is ignored.
- (4) At EcatCmd, the type of command to use when readingESC (EtherCAT Slave Controller) is specified. The following three read commands can be used:
  - (a) 2- APWR(Auto Increment Physical Write)  
This command is used when reading the slave device data following the order of physical connection before normal communication connection by the master. A slave device receiving Adp with 0 value will read data of the size

designated by Length. Adp of each slave device increases when EtherCAT frame is received. . For example, if EcatCmd is 2, and Adp is set to 0xFFFF, when executing ESC read function block, reading is not performed because the Adp at the time of receiving EtherCAT frame from the first slave device is not 0, only increasing Adp by 1. When the second slave device receives EtherCAT frame, writing is performed because the Adp value of the first slave value increased by 1 to 0. The Adp values depending on the slave device connection order are as follows.

Slave controller	Setting value
The first slave connected	0
The second slave connected	0xFFFF
:	:
36th slave connected	0xFFDD

(b) 5 – FPWR(Configured Address Physical Write)

This order is used to write the data by designating the station address of the slave device after normal communication connection by the master. If the Station Address of the slave device set by EtherCAT master matches the transmitted Adp, the slave device writes data of the size designated by Length in the Ado area. The Station Address of slave device set by the master is as follows.

Slave controller	Setting value
Slave 1	1001
Slave 2	1002
:	:
Slave 36	1036

(c) 8 – BWR(Broadcast Write)

All connected slave devices write data of the size set by Length in the Ado area. The designated address value at Adp is ignored, and Wkc increase by 1 due to all slaves that performed normal write operation.

- (5) Wkc value is displayed as 0 when the motion function block is executed, and the Working Counter value is displayed when execution is completed (Done output is on). Wkc increases by 1 through each slave device specified in EcatCmd and Adp.
- (6) Wkc stands for Working Counter. If data is successfully written at the designated slave device, it increases by 1. If EcatCmd is 8(BWR), it increases by 1 through each slave device that performed normal write operation.
- (7) After the execution of ESC write command, if normal data write operation is executed in the specified slave device, Done output is on.
- (8) Slave devices use ESC to perform EtherCAT communication. Therefore, changing ESC register values while executing connection/disconnection command or during normal EtherCAT communication may prevent the slave device from maintaining existing motions or cause communication errors. Therefore, using the following ESC Register causes an error without executing write motion. (Error Code: 0x0F74)

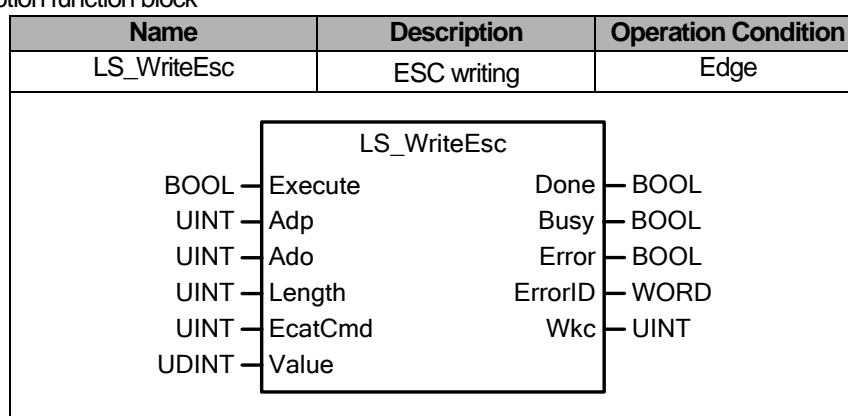
Ado range	Define
0x0010 ~ 0x0011	Configured Station Address
0x0020 ~ 0x0021	Write Protection
0x0030 ~ 0x0031	
0x0040	ESC Reset ECAT
0x0100 ~ 0x0103	DL Control

0x0120 ~ 0x0121	AL Control
0x0600 ~ 0x06FF	FMMU
0x0800 ~ 0x087F	SyncManager
0x0900 ~ 0x09FF	Distributed Clocks

※ 0x0120 (AL Control) register can be written after the connection of normal communication, not the execution of connection/disconnection command.

(9) ESC read command and ESC write command cannot be simultaneously executed. If they are executed at the same time, the command of the program last executed is executed, and an error (0x1021) occurs for the preceding command

(10) Motion function block



(11) In the following cases, ESC writing cannot be performed due to errors, properly

- 1) No slave device is connected to module (Error Code: 0x0F09)
- 2) Adp setting value is outside the range (Error Code: 0x0F70)
- 3) Length setting value is outside the range (Error Code: 0x0F71)
- 4) EcatCmd setting value is outside the range (Error Code: 0x0F72)
- 5) No response to ESC read command (Error Code: 0x0F73)
- 6) Ado setting value is not correct (Error Code: 0x0F74)

#### 4. Ado(Address offset)

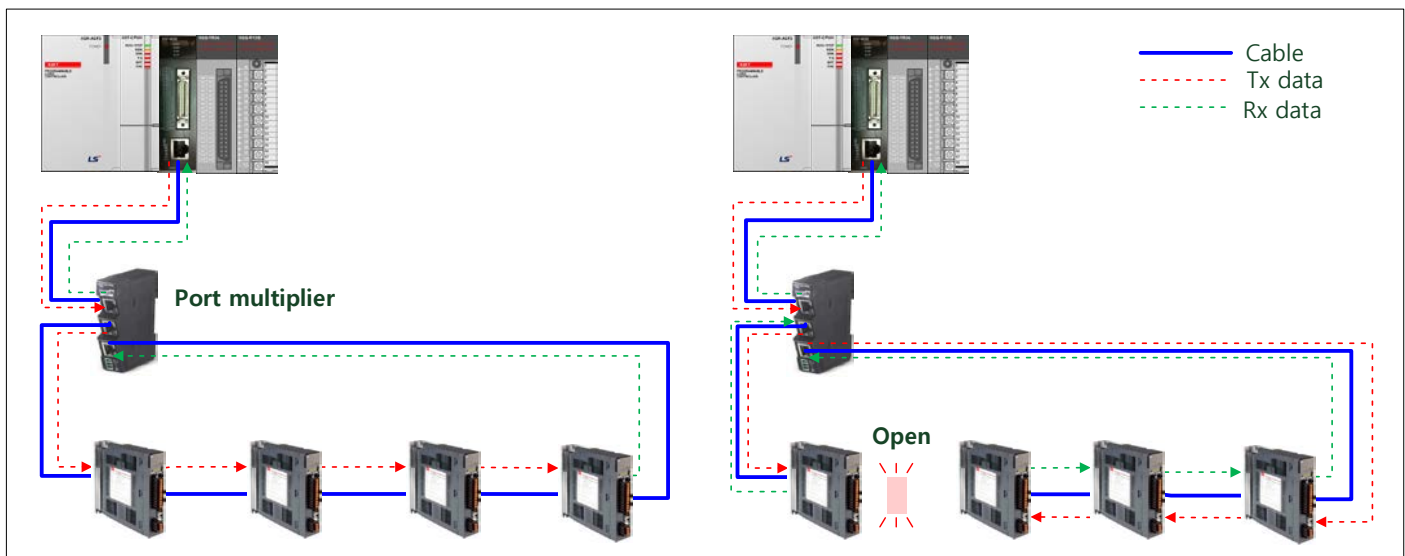
Address	Define
0x0110:0x0111	ESC DL Status
0x0300	CRC A
0x0302	CRC B
0x0304	CRC C
0x0306	CRC D
0x0308	Forw. CRC A/B
0x030A	Forw. CRC C/D
0x030C	Proc. CRC/PDI Err



0x0310	Link Lost A/B
0x0312	Link Lost C/D
0x0130	AL Status
0x0134	AL Status Code

### 8.3.5 Cable duplication function

It provides cable duplication function using port multiplier. Constructing a ring topology using port multiplier will prevent the network between slaves from disconnecting even in case of a cable disconnection on one side. When the disconnected cable is re-connected, it is recovered to the original communication method.



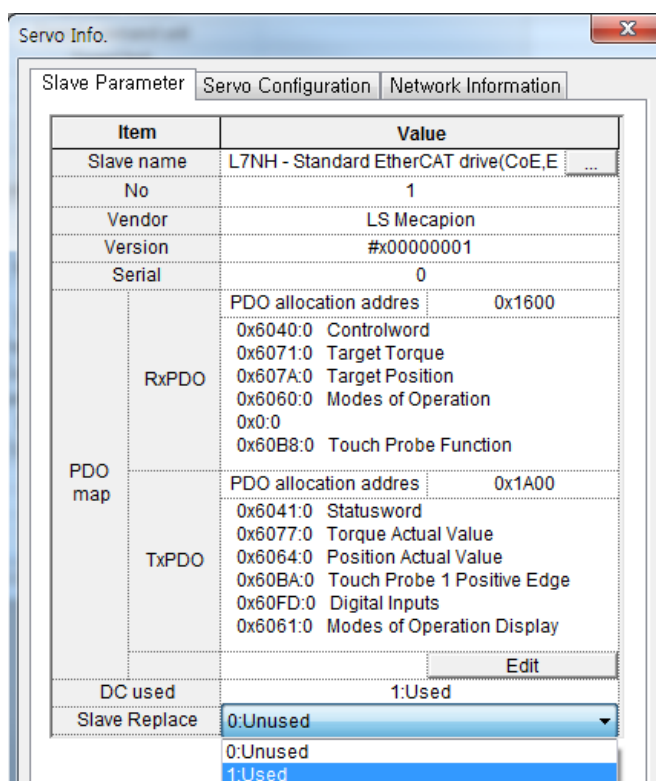
※ Port multiplier of up to 1 can be used. In case of using a port multiplier, it occupies an IO slave number. Therefore, a caution is required when using since the use of the port multiplier reduces the number of IO slaves available.

### 8.3.6 Replace function during connection

While using the cable duplication function, if a slave device previously not in operation due to network disconnection or a failure is restored and connected to the network, this function detects the connection and connects to the network of the individual slave device without having to reconnect the overall network.

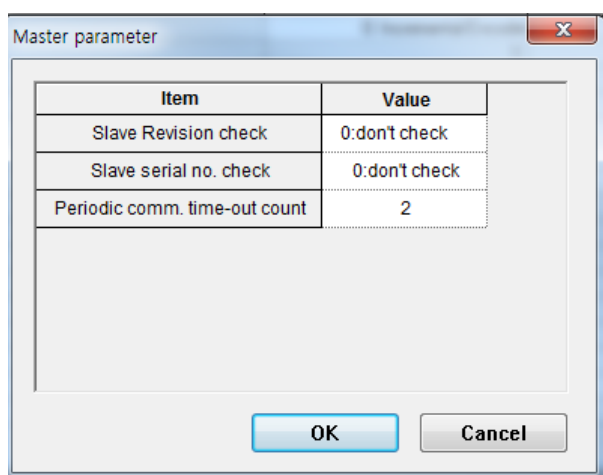
#### 1. Replace function during connection setting

To set the slave device to use the function to replace slaves during connection, the "In-connection Replacement Function" at the slave information should be set to Enabled. In case of a slave for which the replacement function is not set to use, if the slave is removed from the network, the removal is regarded as a network error, which stops the entire network.



## 2.Master parameter setting

When using the in-connection replacement function, the slaves being replaced should be identical to the replacing slave. To determine whether the slaves being replaced are identical, check whether the manufacturer/product codes match. In addition, check whether the revision/serial numbers are identical, depending on the master parameter settings.



## 3.The way of slave exchange during connection

- (1) Remove the input/output cable of the slave to be replaced during the network connection.
- (2) Shut off the power of the slave.
- (3) Apply the power to the slave to be replaced.
- (4) Connect the cable of one side of the port.
- (5) Connect the cable of one side of the port.  
(The simultaneous connection of input/output cables may prevent normal replacement.)
- (6) When the slave communication is restored, connect the cable of the other side.

### 8.3.7 Position control range expansion

When executing position control among motion functions, the target position value can be basically set in the integer 32-bit range based on the pulse position. However, if the resolution of the motor encoder is high or the distance of the machine is long, position control may be necessary to a position outside the range of 32 bits of integer type.

The 'Position control range extension' function enables position control by extending the range of position control to an integer 48-bit range in this case.

#### 1. Parameter setting

In order to use the 'Position control range extension' function, the 'Axis parameter-Basic setting-Position control range extension' parameter must be set. This parameter sets whether to use the 'Expand position control range' function as follows.

Parameter	Setting	Initial Value
Position control range expansion	0: No 1: Use	0: No

#### 2. Position control range

When designating the target position in the motion control command, an error occurs when the position after converting the unit position set by LREAL into pulse units is out of the position control range.

The position control range is as follows depending on whether or not the 'position control range extension' function is used.

Parameter	Setting	Range
Position control range expansion	0: No	INT 32bit → $-2^{31} \sim 2^{31}-1$ (-2,147,483,648 ~ 2,147,483,647)
	1: Use	INT 48bit → $-2^{47} \sim 2^{47}-1$ (-140,737,488,355,328 ~ 140,737,488,355,327)

When using the 'Expand position control range' function, the position control range is expanded by 65,536 times compared to the previous one.

#### 3. Software upper/lower limit

When the 'SW upper/lower limit' parameter is set to the initial value (SW upper limit = 2147483647, SW lower limit = -2147483648), the operation varies according to the 'Position control range extension' parameter as follows.

- (a) 'Position control range expansion' = '0: No'
  - If the SW upper limit is 2147483647 and the soft lower limit is -2147483648, the SW upper/lower limit is not detected.
- (b) 'Position control range expansion' = '1: Use'
  - If the SW upper limit is 2147483647 and the SW lower limit is -2147483648, the SW upper/lower limit is checked with this value, and if the position control exceeds this value, the axis is suddenly stopped after a SW upper/lower limit error occurs.
  - ※ When the soft upper and lower limits are set to the same value, the software upper/lower limits are not detected regardless of the 'Extended position control range' setting.

#### 4. Restrictions

For the following items, when specifying the position value, the position range after conversion to pulse units is limited to the 'integer 32 bit' value.

- (a) Travel distance per rotation
- (b) Infinite running repeat position
- (c) Command in-position range
- (d) Tracking error over-range value

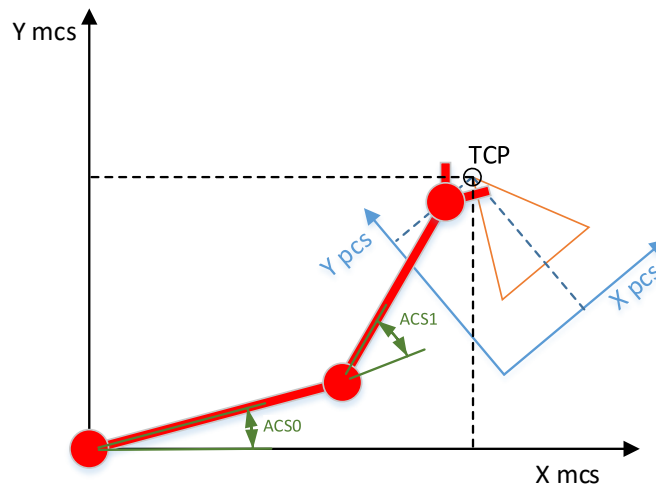
- (e) Current position compensation amount
- (f) Phase correction amount of phase compensation command
- (g) Target distance of SuperImposed command
- (h) TransionParameter value when the linear interpolation TransitionMode is TMCornerDistance

## 8.4 Coordinate systems operation function

### 8.4.1 Summary of the coordinate systems operation

Different coordinate systems define various ways specifying certain positions or directions in the space. The figure below shows how to represent a certain TCP through each coordinate system. In the ACS coordinate system, TCP is represented as the rotation angle of a robot joint consisting of two links. In the MCS coordinate system, TCP position is represented based on the home position of MCS. In the PCS coordinate system, TCP position is represented based on the home position of TCP

TCP represented as PCS/MCS cannot be delivered to the motor connected to the robot for operation. To operate the motor connected to the robot, the values converted to ACS should be used, as it represents the actual movement of the motor. Therefore, for operation in a coordinate system, convert PCS to MCS coordinates through the Cartesian coordinate conversion, and convert the MCS coordinates to ACS coordinates through inverse kinematics conversion, and deliver the CA values to each motor to begin operation.



### 8.4.2 ACS/MCS/PCS/TCP

ACS: Axes Coordinate System (ACS) represents the actual movement of the physical motors.

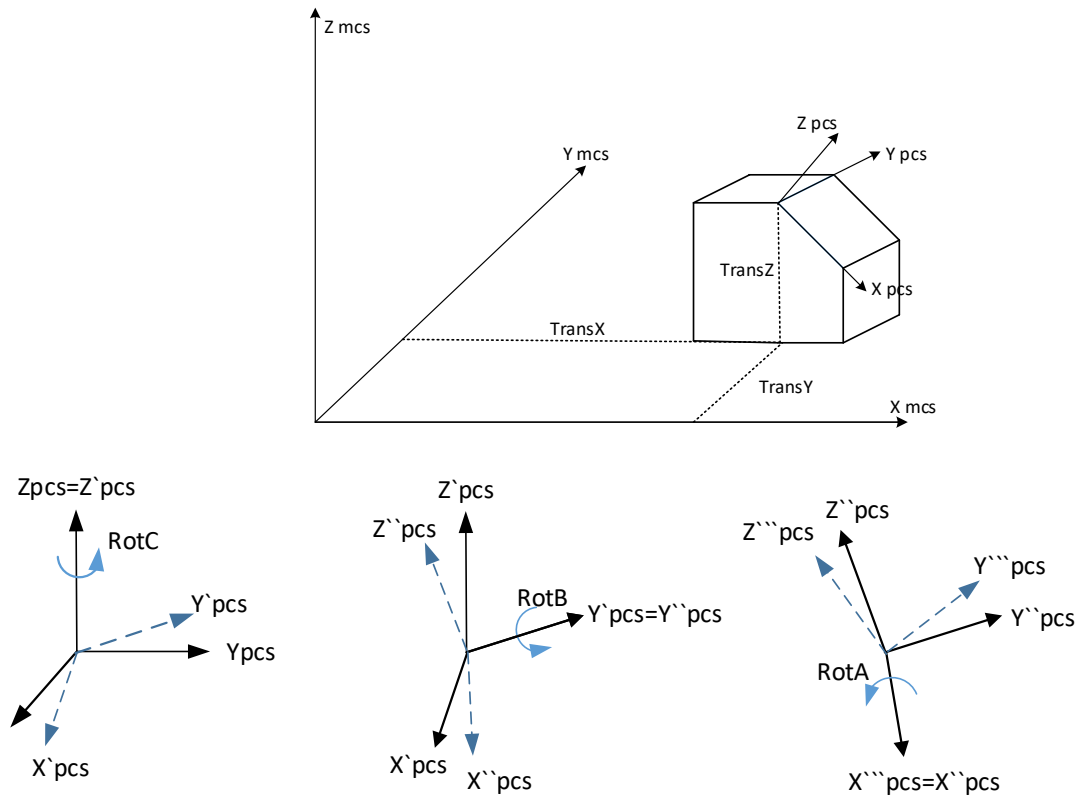
MCS: Machine Coordinate System (MCS) is related with machines (robots). It is the fixed home position of the mechanical system represented as the Cartesian coordinate system.

PCS: Product Coordinate System based on MCS represents the position of products being moved or rotated. PCS is linked to the products through a program, and a user can be changed.

TCP: Tool Center Point is the center or end point of the tool as a position to which a machine (robot) is moved by the command. In case of operation using MCS or PCS, the target position is represented by TCP. TCP consists of 6 RotC data: Px,Py,Pz, representing movement along XYZ axes; RotA representing rotation along X axis; RotB representing rotation along Y axis; and RotC representing rotation along Z axis.

### 8.4.3 PCS setting

PCS represents TCP on the work stand. TCP is defined by rotation and movement from the origin point. The parameter to convert PCS into MCS can be set using MC\_SetCartesianTransform function block or setting axes group parameter. In MC\_SetCartesianTransform, TransX/TransY/TransZ represent the distance of movement from the MCS origin point to the PCS origin point. RotA/RotB/RotC are rotation values for PCS. RotA represents PCS rotation along X-axis. RotB represents PCS rotation along Y-axis. RotC represents PCS rotation along Z-axis. PCS rotation is performed in the following order: RotC->RotB->RotA



#### 1. Function block

Name	Description	Operation Condition
MC_SetCartesianTransform	PCS설정	Edge

MC_SetCartesianTransform			
BOOL	Execute	Done	BOOL
UINT	AxesGroup	----- AxesGroup	UINT
LREAL	TransX	-----	Busy
LREAL	TransY	-----	Active
LREAL	TransZ	-----	CommandAborted
LREAL	RotAngleA	-----	Error
LREAL	RotAngleB	-----	ErrorID
LREAL	RotAngleC	-----	WORD

### 8.4.4 Machine information setting

To operate the robot using coordinate system operation, the type of the robot (machine) and the machine parameters should be set at the axes group parameter in advance. Machine parameters can be set using MC\_SetKinTransform function block. XG-PM axes group parameters can be set using the same.

#### 1. Machine information, machine type setting

In the machine type settings, select the type of machine (robot) to perform coordinate system operation. Either XYZ or Delta3 can be selected as the robot type.

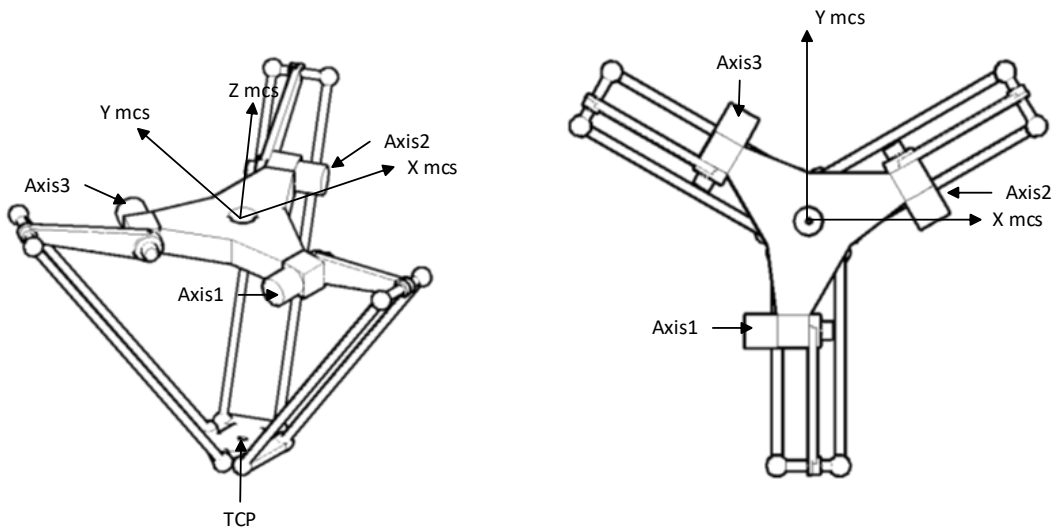
##### (1) XYZ(Cartesian coordinates) robot

XYZ is a robot type with servo motors connected to X/Y/Z axes, which can perform the operation in Cartesian coordinates, and it does not require additional kinematic analysis between ACS and MCS.

##### (2) Delta3

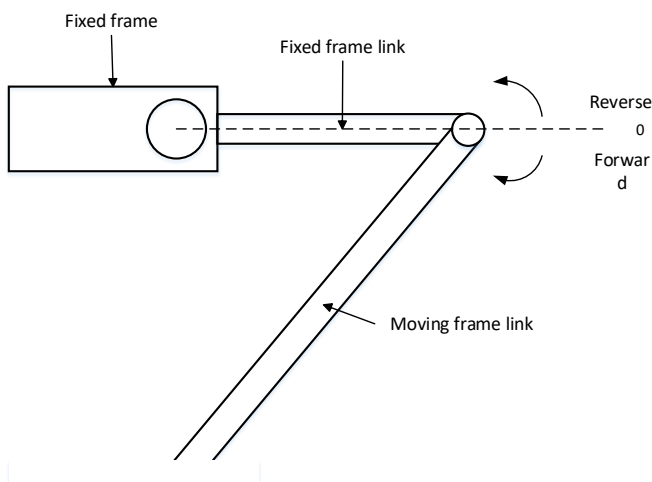
MCS of the Delta robot

In case of a Delta robot, the center of Fixed Frame is defined as MCS, and the relationship between each axis connected to Delta and MCS are as shown below.



##### ACS of the Delta robot

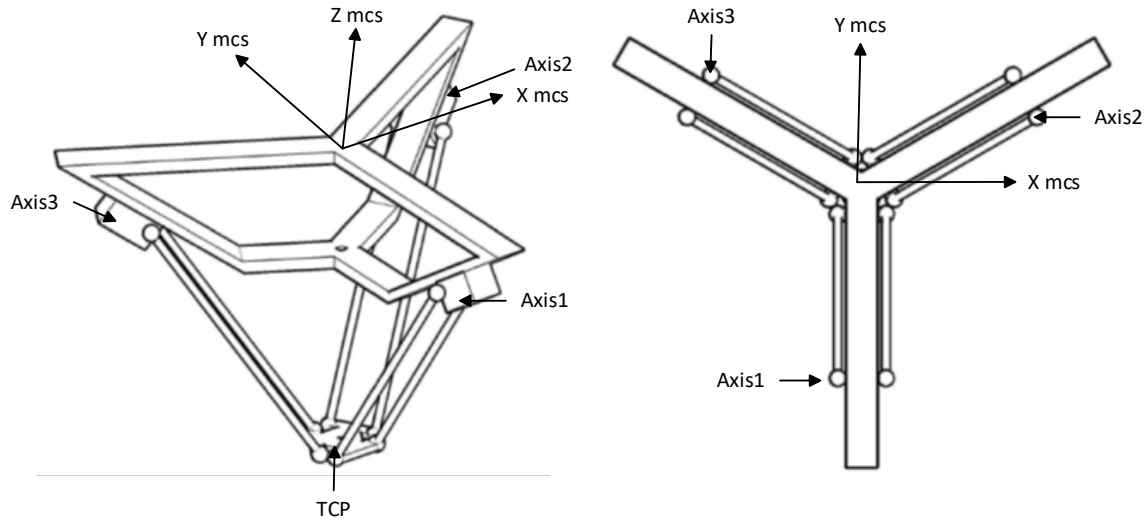
The direction of the link connected to Delta's fixed frame facing the floor is defined as the forward direction of the axis operating the link, and the other direction is defined as the opposite direction.



(3) LinearDelta3

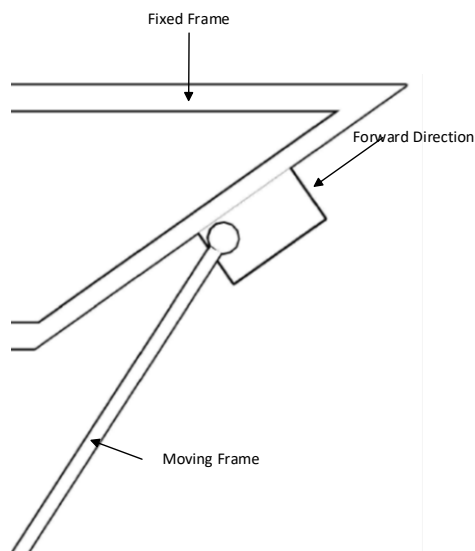
LinearDelta Robot MCS

LinearDelta robot defines the center of FixedFrame, which is a part that does not move in the robot, as MCS. The relationship between each axis connected to LinearDelta and MCS is as follows.



LinearDelta Robot ACS

Define the position where the linear axis of the LinearDelta robot is moved as much as possible toward the ceiling as 0, the direction in which the linear axis goes toward the floor as the forward direction, and the opposite direction as the reverse direction.

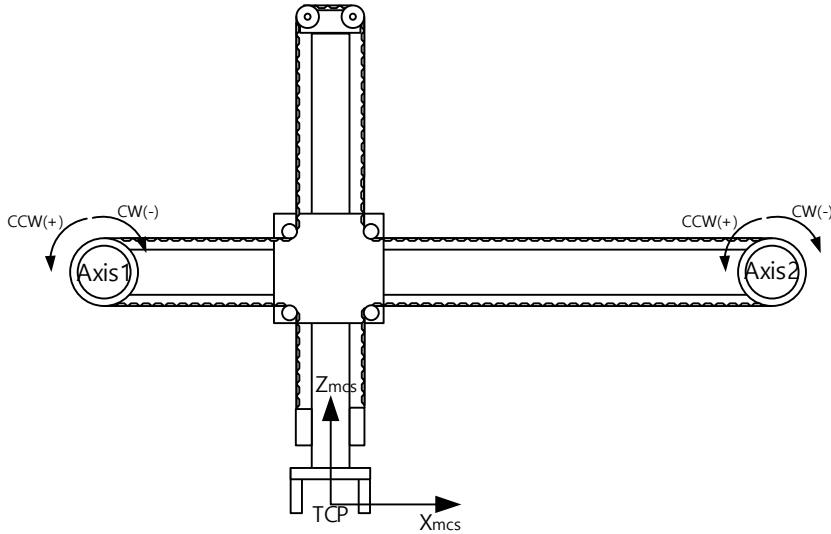




(4) T-Gantry

MCS of T-Gantry Robot

The MCS of the T-Gantry robot defines the position of the end point of the tool when the positions of Axis1 and Axis2 are 0 as the origin of the MCS (0,0). The relationship between the axis connected to the T-Gantry and the MCS is as follows.



ACS of T-Gantry Robot

When the structure of the T-Gantry robot is as above, the counterclockwise operation is defined as the forward direction and the opposite direction is defined as the reverse direction.

2. Machine information, machine parameter setting

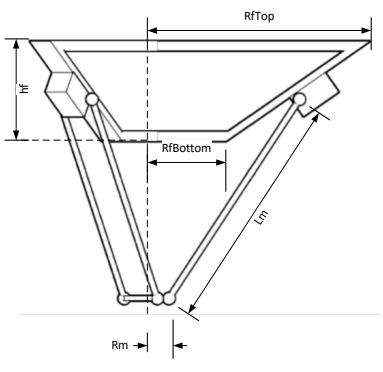
(1) XYZ

XYZ robot does not require separate machine parameters, as the position of each axis matches the XYZ coordinates of TCP.

(2) Delta3/Delta3R

<p>The diagram shows a Delta3/Delta3R robot configuration. It consists of a fixed frame at the top and a moving frame at the bottom. The fixed frame has three links of length <math>L_f</math> extending from a central point to three joints. The moving frame has three links of length <math>L_m</math> extending from three joints to a central point. The distance from the center of the fixed frame to the joints is <math>R_f</math>, and the distance from the center of the moving frame to the joints is <math>R_m</math>.</p>	Parameter	Description
	KinParam[0]	Lf: Link length of the fixed frame(mm)
	KinParam[1]	Lm: Link length of the moving frame(mm)
	KinParam[2]	Rf: Length from the center of the fixed frame to the link of the fixed frame(mm)
KinParam[3]	Rm: Length from the center of the moving frame to the link of the moving frame(mm)	

(3) LinearDelta3/LinearDelta3R

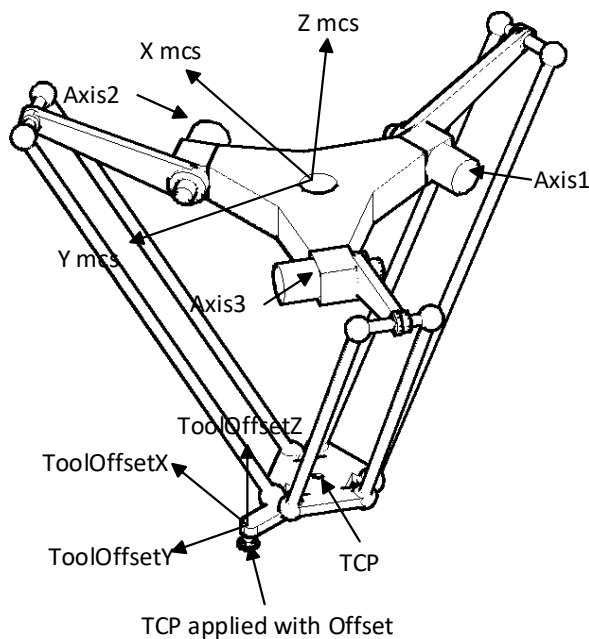
	Parameter	Description
	KinParam[0]	Lm: Link length of moving frame (mm)
	KinParam[1]	Hf: Fixed frame height (mm)
	KinParam[2]	RfTop: Radius of upper fixing frame (mm)
	KinParam[3]	RfBottom: Radius of lower fixing frame (mm)
KinParam[4]	Rm: Distance from the center of the moving frame to the link of the moving frame (mm)	

(4) T-Gantry/T-GantryR

In the case of the T-Gantry robot, it is not necessary to set a separate instrument parameter.

3. Machine information, tool offset setting

A tool offset function is provided in addition to the machine information, as additional equipment may be connected to the end of the robot's TCP. Activating tool offset applies the offset to the TCP target position applied to the coordinate system operation.

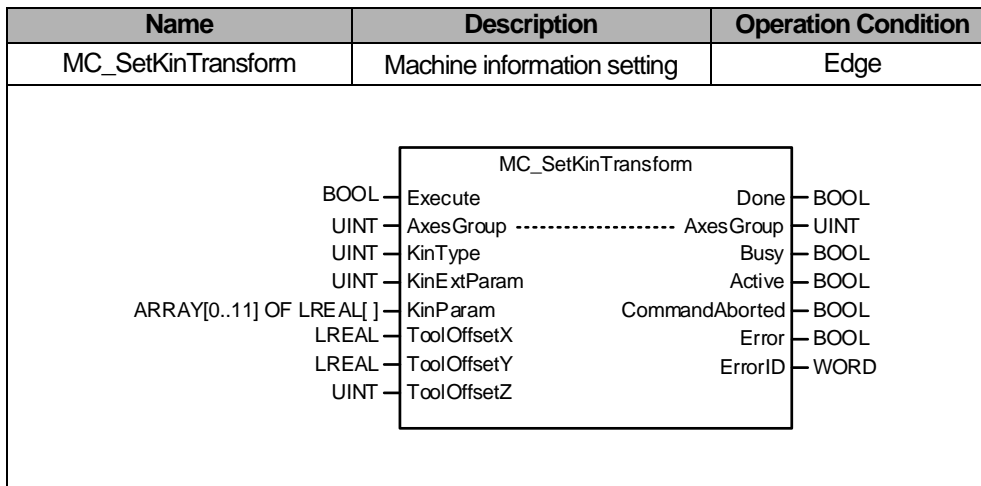


4. Axis group, axis configuration setting

To perform coordinate system operation, the axes should be set to suit the machine type. Coordinate system operation is not performed if the number of axes or the axis unit does not match.

Machine Type	Axis Number (ea)	Unit			
		Axis1	Axis2	Axis3	Axis4
XYZ	3	mm	mm	mm	-
Delta3	3	degree	degree	degree	-
Delta3R	4	degree	degree	degree	degree
LinearDelta3	3	mm	mm	mm	-
LinearDelta3R	4	mm	mm	mm	degree
T-Gantry	2	mm	mm	-	-
T-GantryR	3	mm	mm	degree	-

5. Function block

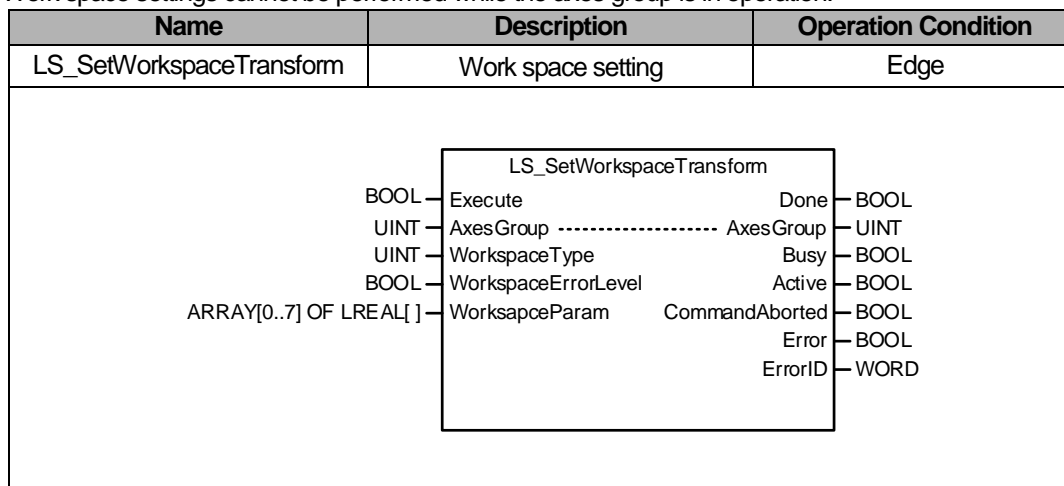


### 8.4.5 Work space setting

For coordinate system operation, in order to prevent machine damage or safety accident caused by the robot performing impossible motion, a work space function is provided to prevent the robot from going out of the preset work space. Coordinate system operation is not performed if the robot's current position or target position is outside the work space. Work space setting can be performed using LS\_SetWorkspaceTransform function block. XG-PM axes group parameters can be set using the same

#### 1. Work space setting

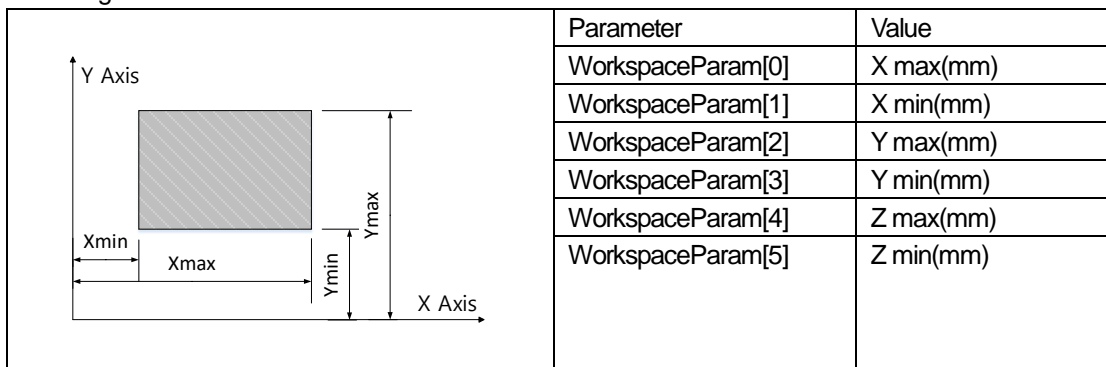
Perform work space settings, and the occurrence of work space error can be set. Set the workspace type set in the WorkspaceType as the work space parameter set in the WorkspaceParam in the axis group specified in the set AxesGroup input If WorksaceErrorLevel value is set to 0, the operation continues without errors even when it goes out of the work space. Work space settings cannot be performed while the axes group is in operation.



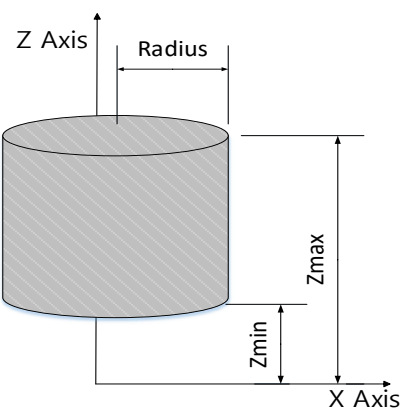
#### 2. Work space type and parameter

The work space type supports 4 types of Rectangle/Cylinder/Delta/Sector.

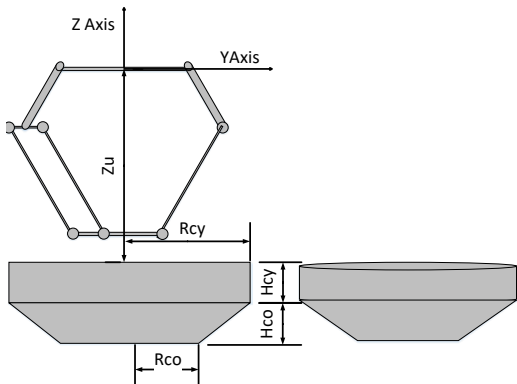
##### Rectangle



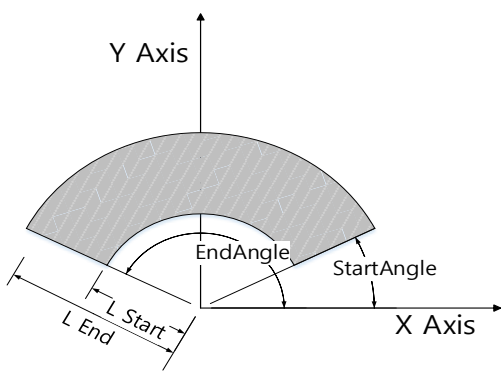
Cylinder

 <p>The diagram shows a cylinder in a 3D coordinate system with X and Z axes. The radius is indicated by a horizontal dimension line from the Z-axis to the cylinder's edge. The vertical height is divided into Zmax (total height) and Zmin (height from the X-axis to the bottom of the cylinder).</p>	Parameter	Value
	WorkspaceParam[0]	Radius(mm)
	WorkspaceParam[1]	Z max(mm)
	WorkspaceParam[2]	Z min(mm)

Delta

 <p>The diagram illustrates a delta robot arm mechanism. It shows a top-down view of the arm with dimensions Zu (vertical distance from Z-axis to the end effector), Rcy (horizontal distance from Z-axis to the end effector), and a side view showing Hco (height of the base), Hcy (height of the arm), and Rco (radius of the base).</p>	Parameter	Value
	WorkspaceParam[0]	Zu(mm)
	WorkspaceParam[1]	Hcy(mm)
	WorkspaceParam[2]	Hco(mm)
	WorkspaceParam[3]	Rcy(mm)
	WorkspaceParam[4]	Rco(mm)
WorkspaceParam[5]	-	

Sector

 <p>The diagram shows a sector in a 2D coordinate system with X and Y axes. The length of the sector is defined by L End and L Start. The angular extent is defined by EndAngle and StartAngle.</p>	Parameter	Value
	WorkspaceParam[0]	L end (mm)
	WorkspaceParam[1]	L start(mm)
	WorkspaceParam[2]	Z max(mm)
	WorkspaceParam[3]	Z min(mm)
	WorkspaceParam[4]	EndAngle(degree)
WorkspaceParam[5]	StartAngle(degree)	

### 8.4.6 Coordinate system position time linear interpolation operation

Use the related axes set in the axes group to perform interpolation control by moving the TCP from the current position to the target position in the set time in a linear trajectory.

1. Perform linear interpolation from the start position to the target position (position designated by the positioning data). Positioning control is based on the position designated at return to origin point.
2. Set Position[] to define the TCP target position.

Variable	Define	Unit
Position[0]	X Axis position	mm
Position[1]	Y Axis position	mm
Position[2]	Z Axis position	mm
Position[3]	X Axis rotation amount	degree
Position[4]	Y Axis rotation amount	degree
Position[5]	Z Axis rotation amount	degree

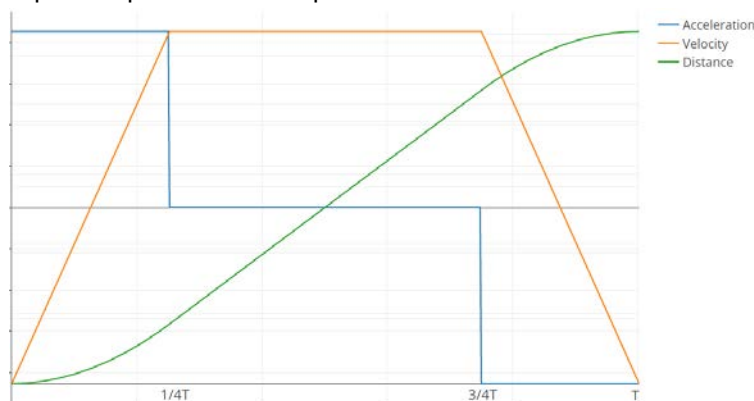
3. Depending on the robot type, some Position variable areas may not be applied. Data input in the unapplied areas is not reflected in coordinate system operation.

Variable	Machine Type				
	XYZ	Delta3/LinearDelta3	Delta3R/LinearDelta3R	T-Gantry	T-GantryR
Position[0]	Applied	Applied	Applied	Applied	Applied
Position[1]	Applied	Applied	Applied	Not applied	Not applied
Position[2]	Applied	Applied	Applied	Applied	Applied
Position[3]	Not applied	Not applied	Not applied	Not applied	Not applied
Position[4]	Not applied	Not applied </td <td>Not applied</td> <td>Not applied</td> <td>Not applied</td>	Not applied	Not applied	Not applied
Position[5]	Not applied	Not applied	Applied	Not applied	Applied

4. Perform linear interpolation to reach the target TCP in the time set in TrajTime.
5. TrajType input determines the type of acceleration/deceleration for reaching the interpolation trajectory. Three types of 0: Trapezoid/Sine1/Sine2 are available.

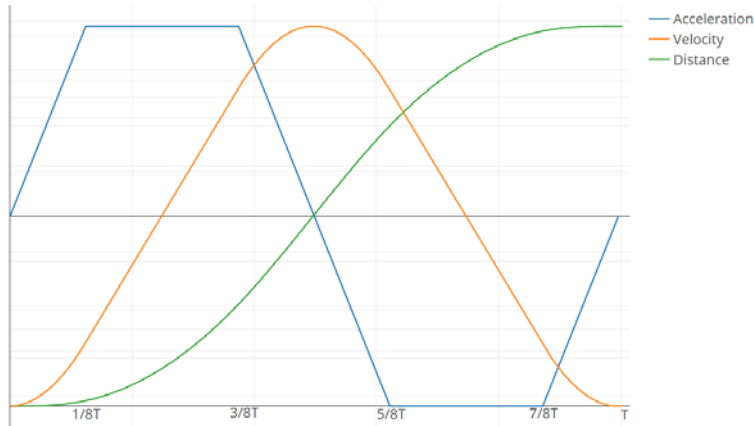
#### Trapezoid

Operation profile of basic trapezoidal linear acceleration/deceleration



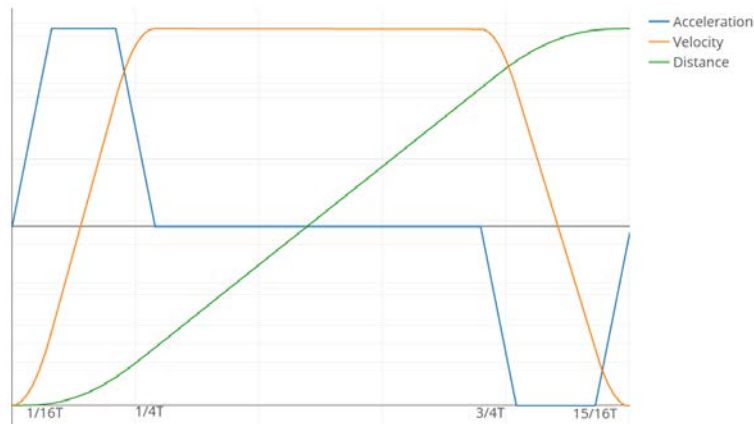
Sine1

The velocity profile of this operation type consists of sine curves. It is suitable for low-load high-velocity operation, and reduces impact on the motor caused by load changes.



Sine2(Sine With Constant)

This velocity profile of this operation type consists of sine curves and constant speed sections. It is suitable for high-load, medium-velocity operation.



6. When CoordSystem input is set to 1, the robot operates using the Position values as MCS coordinates. When it is set to 2, the robot operates using the Position values as PCS coordinate system.
7. To stop the current interpolation control, use MC\_GroupHalt or MC\_GroupStop motion function block.

8. Function block

Name	Description	Operation Condition																				
MC_MoveLinearTimeAbsolute	Coordinate system absolute position time linear interpolation operation	Edge																				
<div style="text-align: center;"> <table border="1" style="margin: auto;"> <thead> <tr> <th colspan="2">LS_MoveLinearTimeAbsolute</th> </tr> </thead> <tbody> <tr> <td>BOOL</td> <td>Execute</td> </tr> <tr> <td>UINT</td> <td>AxesGroup</td> </tr> <tr> <td>UINT</td> <td>CoordSystem</td> </tr> <tr> <td>ARRAY[0..5] OF LREAL</td> <td>Position</td> </tr> <tr> <td>UINT</td> <td>TrajType</td> </tr> <tr> <td>LREAL</td> <td>TrajTime</td> </tr> <tr> <td>UINT</td> <td>BufferMode</td> </tr> <tr> <td>UINT</td> <td>TransitionMode</td> </tr> <tr> <td>LREAL</td> <td>TransitionParameter</td> </tr> </tbody> </table> </div>			LS_MoveLinearTimeAbsolute		BOOL	Execute	UINT	AxesGroup	UINT	CoordSystem	ARRAY[0..5] OF LREAL	Position	UINT	TrajType	LREAL	TrajTime	UINT	BufferMode	UINT	TransitionMode	LREAL	TransitionParameter
LS_MoveLinearTimeAbsolute																						
BOOL	Execute																					
UINT	AxesGroup																					
UINT	CoordSystem																					
ARRAY[0..5] OF LREAL	Position																					
UINT	TrajType																					
LREAL	TrajTime																					
UINT	BufferMode																					
UINT	TransitionMode																					
LREAL	TransitionParameter																					

Name	Description	Operation Condition																				
MC_MoveLinearTimeRelative	Coordinate system relative position time linear interpolation operation	Edge																				
<div style="text-align: center;"> <table border="1" style="margin: auto;"> <thead> <tr> <th colspan="2">LS_MoveLinearTimeAbsolute</th> </tr> </thead> <tbody> <tr> <td>BOOL</td> <td>Execute</td> </tr> <tr> <td>UINT</td> <td>AxesGroup</td> </tr> <tr> <td>UINT</td> <td>CoordSystem</td> </tr> <tr> <td>ARRAY[0..6] OF LREAL</td> <td>Position</td> </tr> <tr> <td>UINT</td> <td>TrajType</td> </tr> <tr> <td>LREAL</td> <td>TrajTime</td> </tr> <tr> <td>UINT</td> <td>BufferMode</td> </tr> <tr> <td>UINT</td> <td>TransitionMode</td> </tr> <tr> <td>LREAL</td> <td>TransitionParameter</td> </tr> </tbody> </table> </div>			LS_MoveLinearTimeAbsolute		BOOL	Execute	UINT	AxesGroup	UINT	CoordSystem	ARRAY[0..6] OF LREAL	Position	UINT	TrajType	LREAL	TrajTime	UINT	BufferMode	UINT	TransitionMode	LREAL	TransitionParameter
LS_MoveLinearTimeAbsolute																						
BOOL	Execute																					
UINT	AxesGroup																					
UINT	CoordSystem																					
ARRAY[0..6] OF LREAL	Position																					
UINT	TrajType																					
LREAL	TrajTime																					
UINT	BufferMode																					
UINT	TransitionMode																					
LREAL	TransitionParameter																					

9. Restrictions

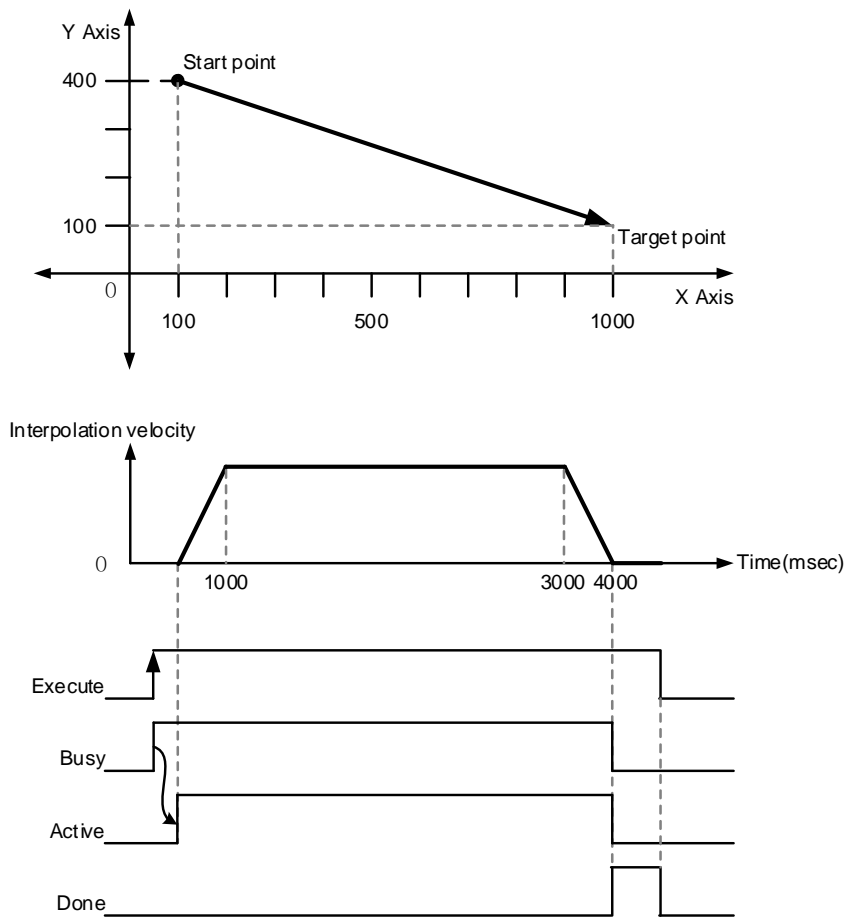
Coordinate system absolute position time linear interpolation control cannot be performed in case of the following errors

- CoordSystem input is set to a value other than 1 or 2 (Error Code: 0x20BC)
- The operation parameter unit of the component axes is not compatible with the coordinate system type (Error Code: 0x2063)
- Of the component axes, an axis where the home position is not determined exists (Error Code: 0x20B0)
- The operation velocity of the component axes exceeds the velocity limit of each axis (Error Code: 0x20B9)
- Of the component axes, there is an axis being executed with the infinite running repeat operation (Error Code: 0x20BA)

10. Operation timing

- Start point: (100.0, 400.0, 0.0)
- Target point: (1000.0, 100.0, 0.0)
- Target time: 4000msec
- Operation type : 0





### 8.4.7 Coordinate system circular interpolation operation

Coordinate system-based circular interpolation operation is performed, where the TCP moves in a circular trajectory on the XY plane using the designated axis in the axes group. Coordinate system absolute position circular interpolation control involves the same setting and motion except that it is based on a coordinate system. There are three types of circular interpolation: center point method, where the TCP passes the position designated by the auxiliary point following the CircMode setting and the auxiliary point; center point method where the position designated by the auxiliary point is the center point; and diameter method where the value set as the auxiliary point is the diameter of the arc. To stop the current interpolation control use MC\_GroupHalt or MC\_GroupStop motion function block.

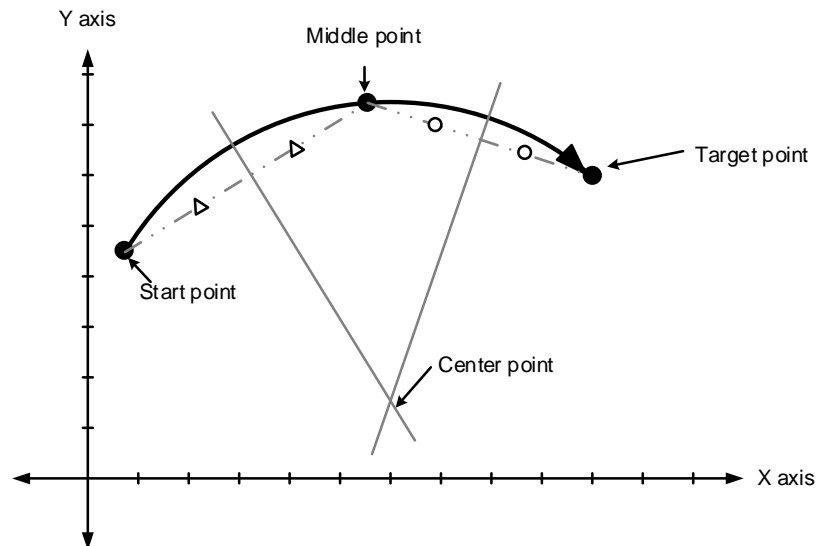
1. EndPoint/AuxPoint

In case of coordinate system circular interpolation control, enter the Px,Py,Pz of TCP to EndPoint/AuxPoint. The RotA, RotB, RotC values, which determine the TCP posture, is not entered, instead maintaining the values at the start position.

2. Circular interpolation using midpoint specification

- (1) Circular interpolation is performed by starting at the start position, passing the center point set as the auxiliary point, and moving to the target position
- (2) A circular trajectory is created of which the center point is the crossing point of the perpendicular bisectors between the start position and the mid position, and the mid position and the target position.

- (3) The movement direction is automatically determined by the set target position and the auxiliary point for circular interpolation



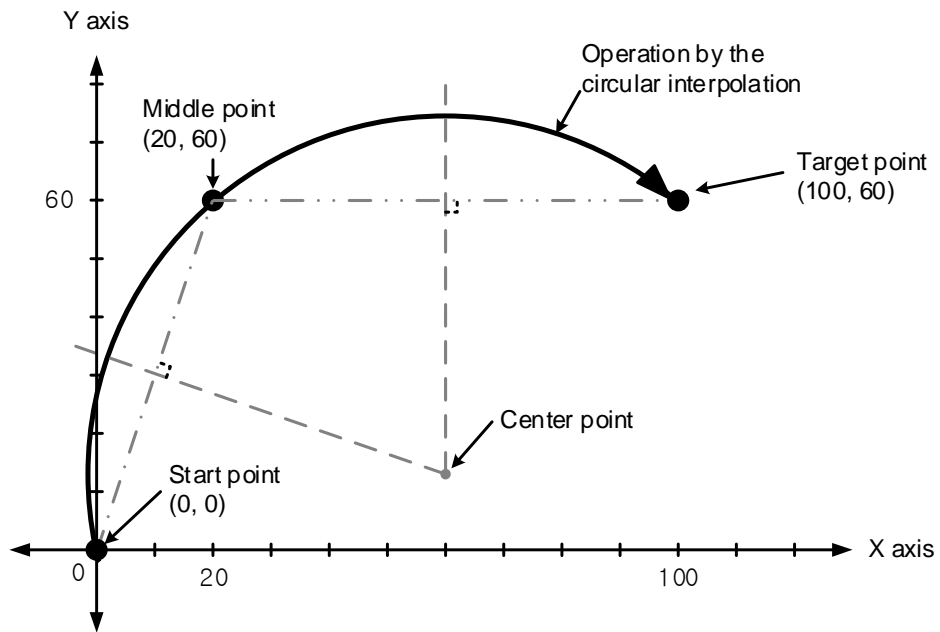
#### (4) Restrictions

Circular interpolation control using mid-point specification method cannot be performed in case of the following errors.

- During absolute coordinate circular interpolation, home position has not been determined in one or more of the component axes (Error Code: 0x20A0)
- The midpoint specified as the auxiliary point is the same as the start or target position (Error Code: 0x20A4)
- The start point is the same as the target point (Error Code: 0x20A5)
- The calculated radius of the arc exceeds 2147483647pls (Error Code: 0x20A6)
- The start point, the auxiliary point, and the target point are on the same straight line (Error Code: 0x20A7)
- One or more of the component axes is performing the infinite running repeat operation (Error Code: 0x20A8)

(5) Operation pattern

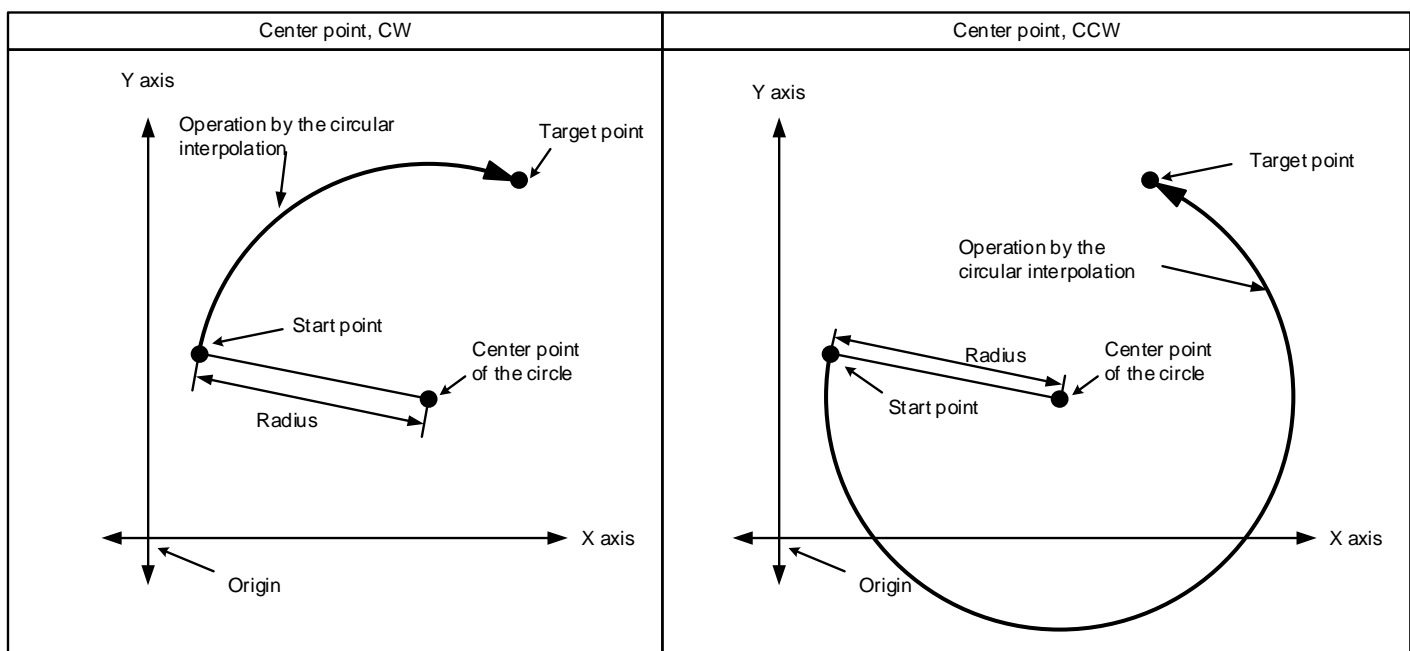
- Start point: (0.0, 0.0,0.0)
- Target point: (100.0, 60.0,0.0)
- Mid point: (20.0, 60.0)
- CircMode: Mid point(0)
- PathChoice: - (Ignore in the circular Interpolation using midpoint)



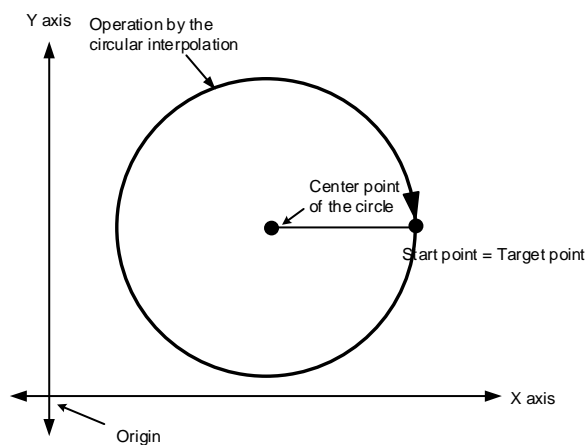
3. Circular interpolation using center point specification

- (1) Circular interpolation is performed by starting at the start position, and reaching the target position in a circular trajectory of which the diameter is the distance to the designated center point.
- (2) The movement direction is determined as the direction set in the absolute position circular interpolation operation (MC\_MoveCircularAbsolute2D), the relative position circular interpolation operation (MC\_MoveCircularRelative2D), or "PathChoice" of the motion function block.

- 0: 「CW」 - perform circular interpolation in the clockwise direction from the start position.
- 1: 「CCW」 - perform circular interpolation in the counter-clockwise direction from the start position.



- (3) Setting the target position to be the same as the start position creates a proper circle trajectory for the circular interpolation, of which the diameter is the distance between the start position and the center point of the circle.



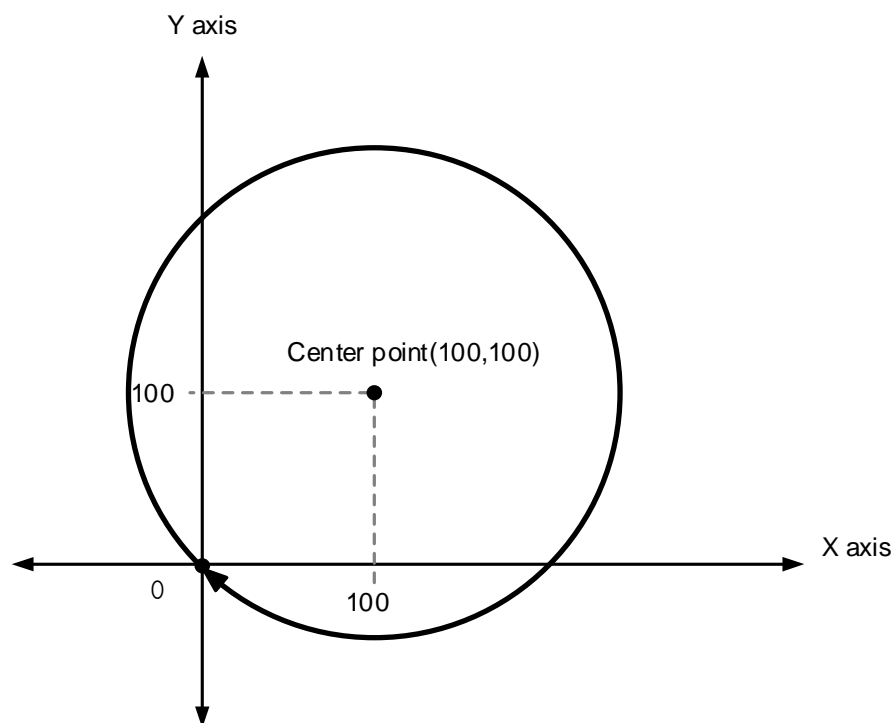
### (4) Restrictions

Circular interpolation control using center point specification method cannot be performed in case of the following errors.

- During absolute coordinate circular interpolation, home position has not been determined in one or more of the component axes (Error Code: 0x20A0)
- The center point set as the auxiliary point is the same as the start or target position (Error Code: 0x20A4)
- The calculated radius of the arc exceeds 2147483647pls (Error Code: 0x20A6)
- The start position, the auxiliary point, and the target position are on the same straight line (Error Code: 0x20A7)
- One or more of the component axes is performing infinite running repeat operation (Error Code: 0x20A8)

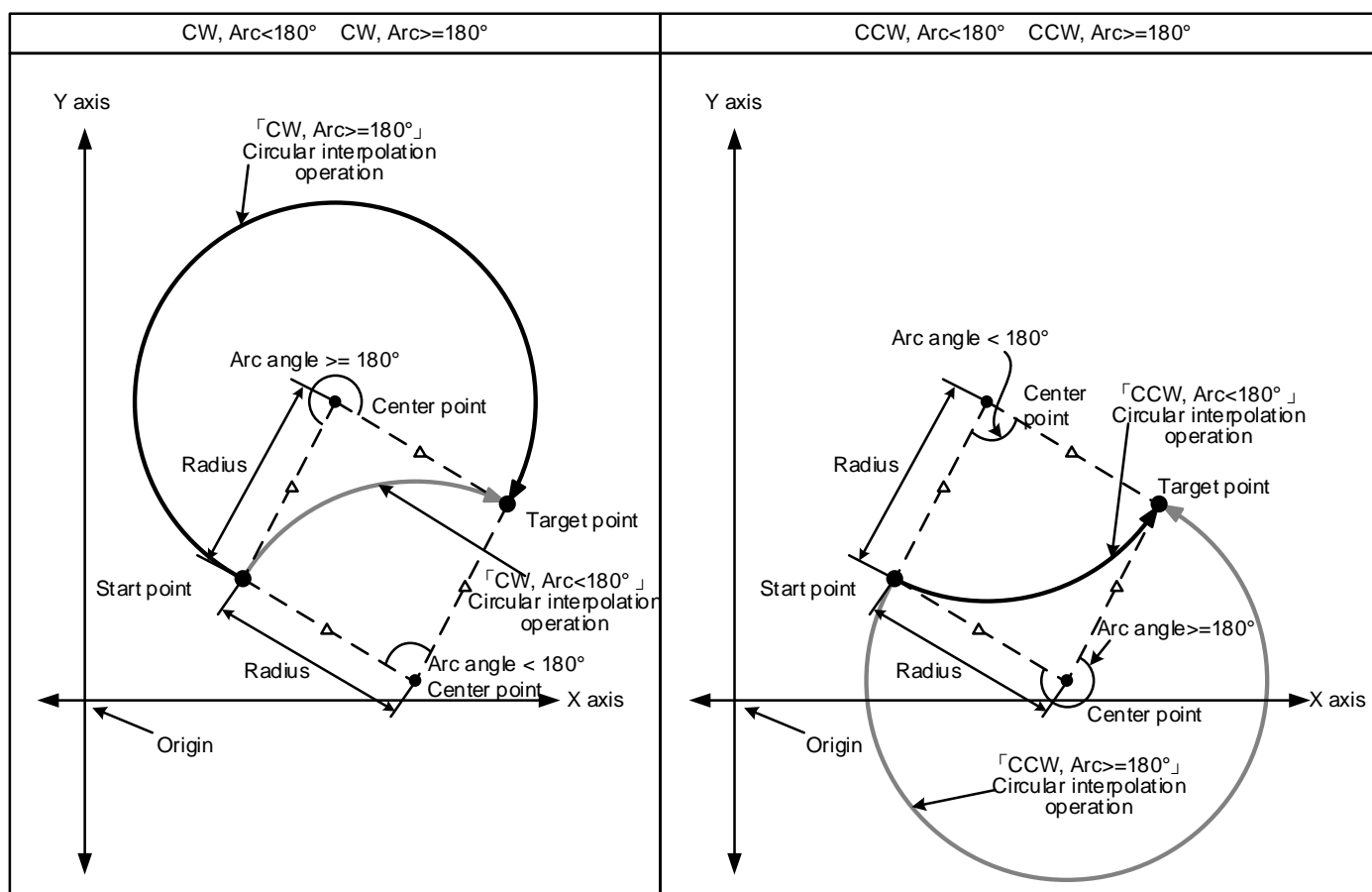
### (5) Operation pattern

- Start point: (0.0, 0.0, 0.0)
- Target point: (0.0, 0.0, 0.0)
- Aux point: (100.0, 100.0, 0.0)
- CircMode: Center point(1)
- PathChoice: - CW(0)



## 4. Circular interpolation using radius specification

(1) Circular interpolation is performed by starting at the start point, and reaching the target point in a circular trajectory of which the diameter is the distance set by the auxiliary point for the circular interpolation. The center point arc varies depending on the positivity/negativity of radius ((+): arc angle  $<180^\circ$ , (-): arc angle  $\geq 180^\circ$ ).



(2) In case of designating the diameter, the target position cannot be identical to the start position.

(3) The movement direction and the size of the arc are determined by the signs of the auxiliary point and the direction set in the absolute position coordinate system circular interpolation operation (MC\_MoveCircularAbsolute2D), the relative position coordinate system circular interpolation operation (MC\_MoveCircularRelative2D), or "PathChoice" of the motion function block.

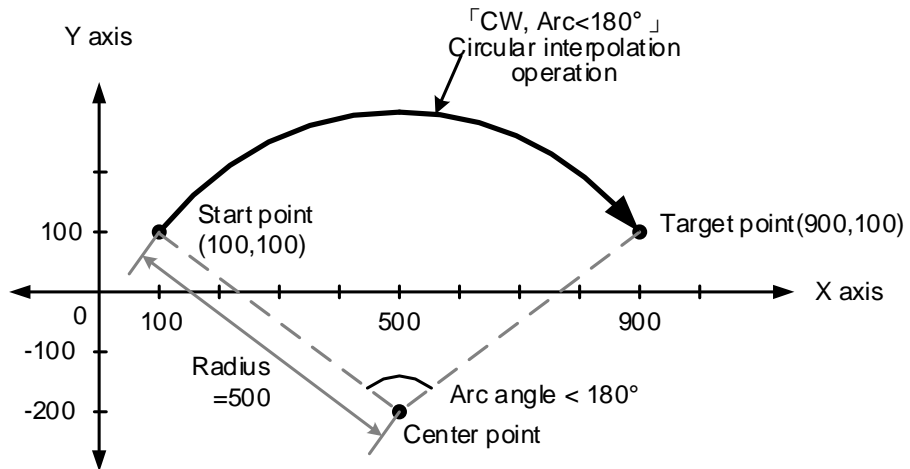
## (4) Restriction

Circular interpolation control by radius specification method cannot be performed in case of the following errors.

- During absolute coordinate circular interpolation, home position has not been determined in one or more of the component axes (Error Code: 0x20A0)
- The start position is the same as the target position (Error Code: 0x20A5)
- The calculated radius of the arc exceeds 2147483647pls (Error Code: 0x20A6)
- The start position, the auxiliary point, and the target position are on the same straight line (Error Code: 0x20A7)
- One or more of the component axes is performing infinite running repeat operation (Error Code: 0x20A8)

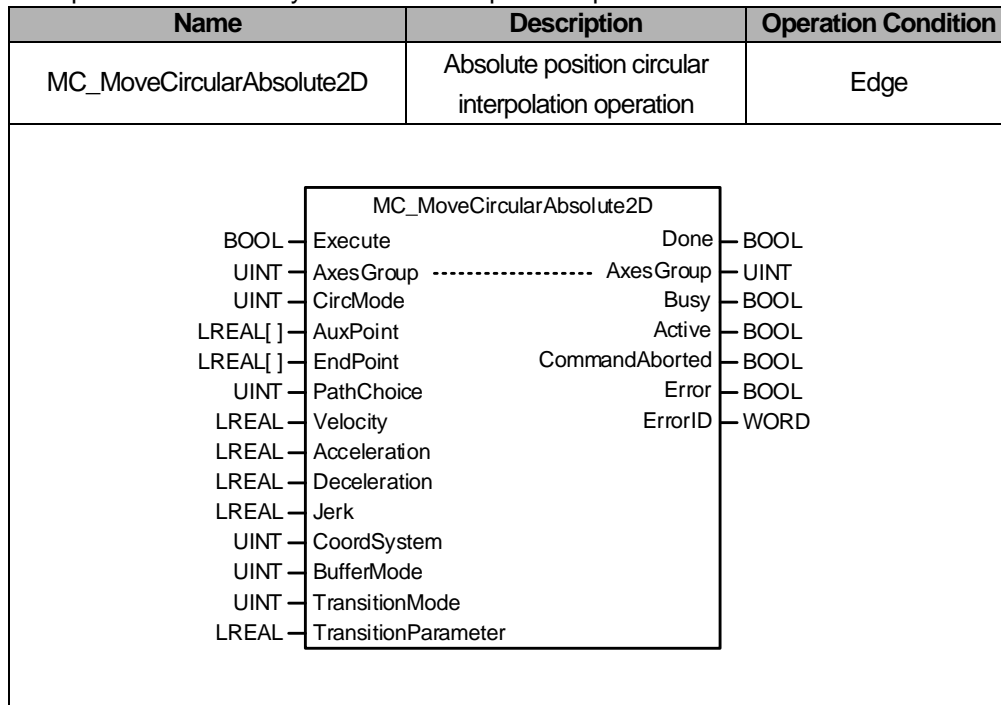
### (5) Operation pattern

- Start point: (100.0, 100.0, 0.0)
- Target point: (900.0, 100.0)
- Aux point: (500.0, 0.0)
- CircMode: Radius(2)
- PathChoice: - CW(0)

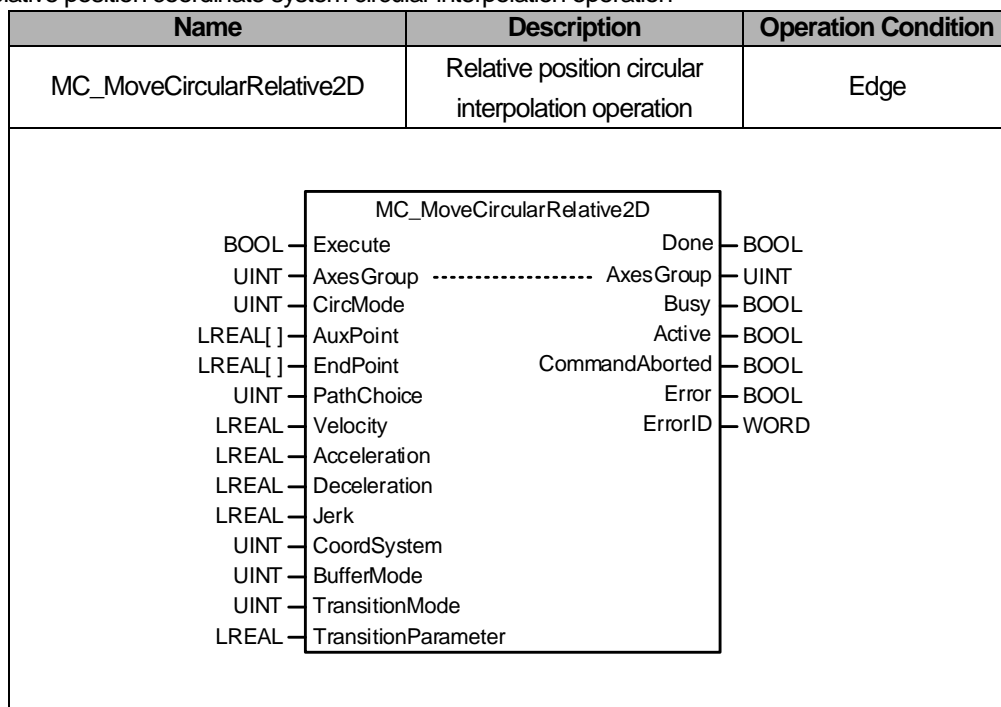


5. Function block

(1) Absolute position coordinate system circular interpolation operation



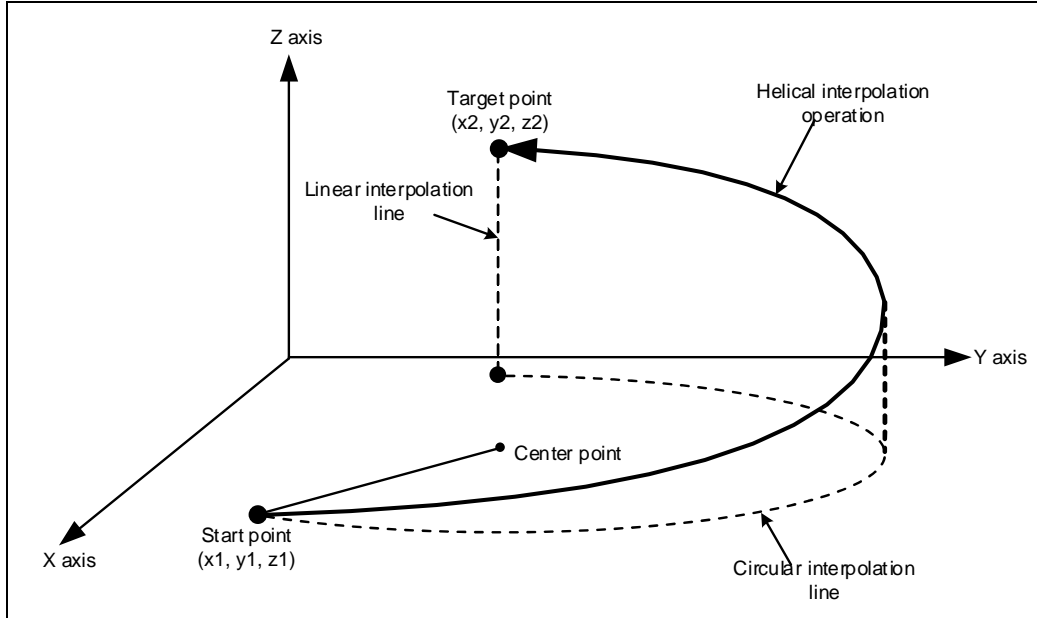
(2) Relative position coordinate system circular interpolation operation





6. Helical interpolation

- (1) When circular interpolation commands (absolute position coordinate system circular interpolation operation (MC\_MoveCircularAbsolute2D), relative position coordinate system circular interpolation operation (MC\_MoveCircularRelative2D)) are executed, circular interpolation is performed by moving in a circular trajectory on the XY plane, while linear interpolation synchronized to the circular interpolation motion is performed with respect to Z-axis
- (2) To perform helical interpolation, set the target position for linear interpolation at Pz of 'EndPoint'.

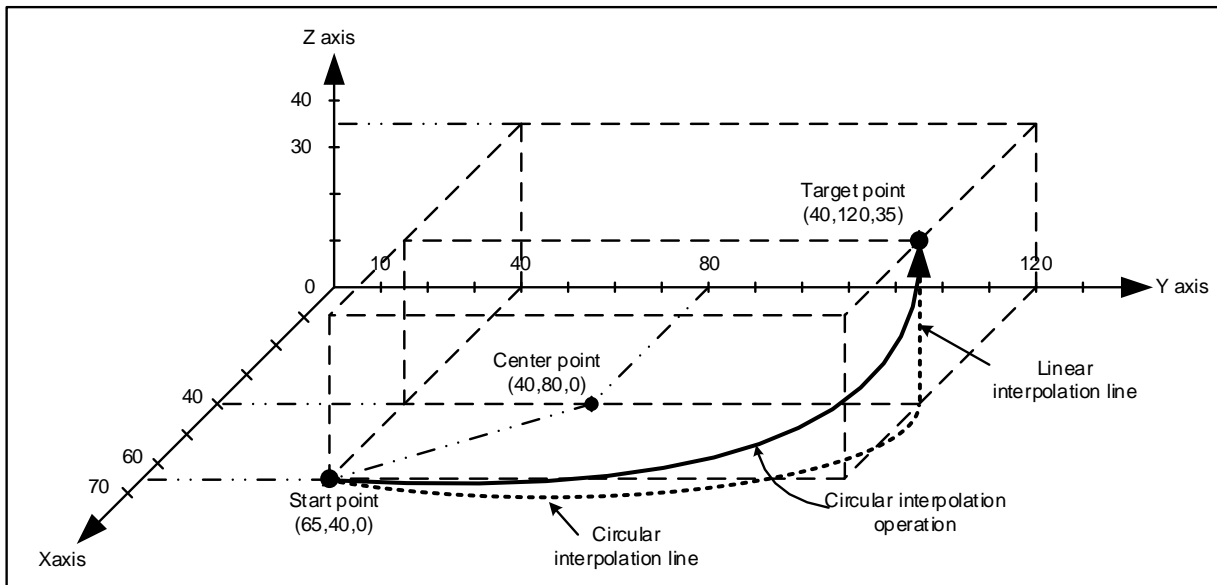


(3) Restrictions

The restrictions for the circular interpolation mode designated for helical interpolation also apply to the helical interpolation.

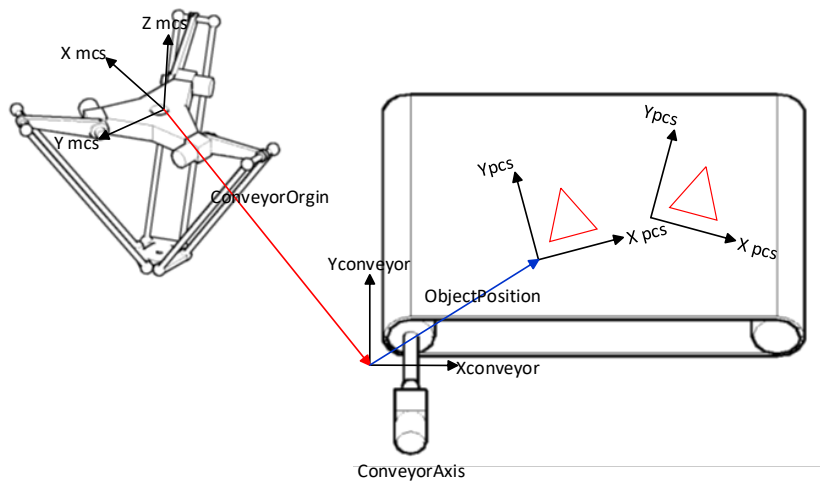
(4) Operation pattern

- Start point: (65.0, 40.0, 0.0)
- Target point: (40.0, 120.0, 35.0)
- Center point: (40.0, 80.0, 0.0)
- CircMode: Center point(1)
- PathChoice: - CCW(1)



### 8.4.8 Conveyor belt synchronized operation

In a coordinate-based operation, one of the axes group is designated as the conveyor axis, and the objects moving on the conveyor in a straight line are tracked.



#### 1. Setting and disable of the conveyor belt synchronized operation

MC\_TrackConveyorBelt function block performs the setting for conveyor belt synchronized operation. It is not directly involved in operation. After performing the setting for conveyor belt synchronization with MC\_TrackConveyorBelt function block, coordinate system-based motion function blocks where the CoordSystem performed after the setting is set to PCS are synchronized to the conveyor belt for operation. After completing synchronized conveyor belt operation, to perform PCS operation which does not perform conveyor belt synchronized operation, the synchronized conveyor belt operation should be disabled. In order to disable synchronized conveyor belt operation by performing MCS operation or using MC\_TrackConveyorBelt function block, the PCS coordinate system should be reset using MC\_SetCartesian function block.

#### 2. Function block

##### (1) Conveyor belt synchronized setting

Name	Description	Operation Condition																																
MC_TrackConveyorBelt	Conveyor belt synchronized setting	Edge																																
<table border="1" style="margin: auto;"> <thead> <tr> <th colspan="4">MC_TrackConveyorBelt</th> </tr> </thead> <tbody> <tr> <td>BOOL</td> <td>Execute</td> <td>Done</td> <td>BOOL</td> </tr> <tr> <td>UINT</td> <td>AxesGroup</td> <td>AxesGroup</td> <td>UINT</td> </tr> <tr> <td>UINT</td> <td>ConveyorAxis</td> <td>Busy</td> <td>BOOL</td> </tr> <tr> <td>ARRAY[0..5] OF LREAL[ ]</td> <td>ConveyorOrigin</td> <td>Active</td> <td>BOOL</td> </tr> <tr> <td>ARRAY[0..5] OF LREAL[ ]</td> <td>ObjectPosition</td> <td>Error</td> <td>BOOL</td> </tr> <tr> <td>UINT</td> <td>CoordSystem</td> <td>ErrorID</td> <td>WORD</td> </tr> <tr> <td>UINT</td> <td>BufferMode</td> <td></td> <td></td> </tr> </tbody> </table>			MC_TrackConveyorBelt				BOOL	Execute	Done	BOOL	UINT	AxesGroup	AxesGroup	UINT	UINT	ConveyorAxis	Busy	BOOL	ARRAY[0..5] OF LREAL[ ]	ConveyorOrigin	Active	BOOL	ARRAY[0..5] OF LREAL[ ]	ObjectPosition	Error	BOOL	UINT	CoordSystem	ErrorID	WORD	UINT	BufferMode		
MC_TrackConveyorBelt																																		
BOOL	Execute	Done	BOOL																															
UINT	AxesGroup	AxesGroup	UINT																															
UINT	ConveyorAxis	Busy	BOOL																															
ARRAY[0..5] OF LREAL[ ]	ConveyorOrigin	Active	BOOL																															
ARRAY[0..5] OF LREAL[ ]	ObjectPosition	Error	BOOL																															
UINT	CoordSystem	ErrorID	WORD																															
UINT	BufferMode																																	

(2) Conveyor belt synchronized setting disable(PCS setting)

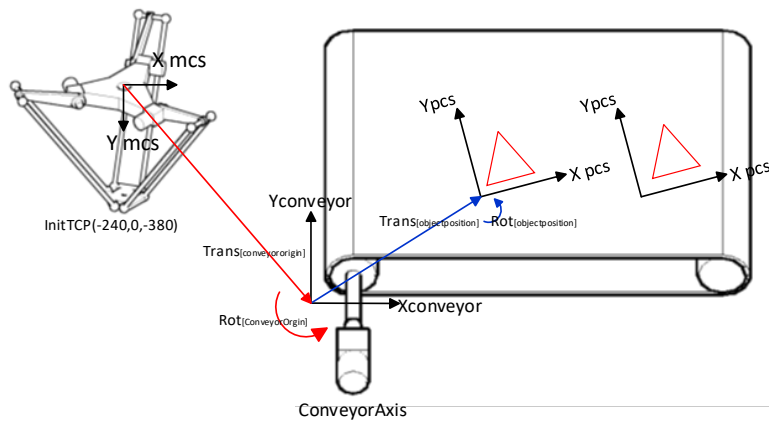
Name	Description	Operation Condition
MC_SetCartesianTransform	PCS setting	Edge

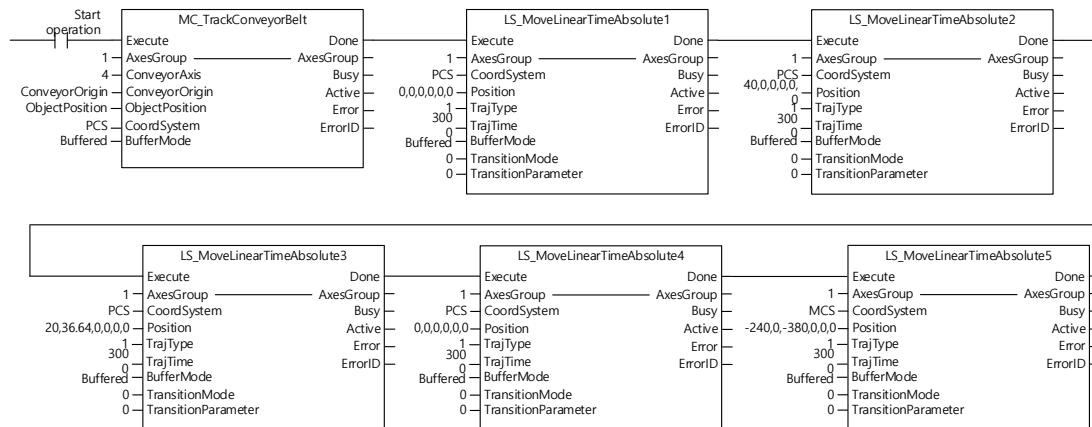
MC_SetCartesianTransform			
BOOL	Execute	Done	BOOL
UINT	AxesGroup	----- AxesGroup	UINT
LREAL	TransX	Busy	BOOL
LREAL	TransY	Active	BOOL
LREAL	TransZ	CommandAborted	BOOL
LREAL	RotAngleA	Error	BOOL
LREAL	RotAngleB	ErrorID	WORD
LREAL	RotAngleC		

3. Conveyor belt synchronized function operation example

The conveyor belt synchronization function begins with setting conveyor synchronization using MC\_TrackConveyorBelt function block. For MC\_TrackConveyorBelt function block, enter conveyor axis value at the ConveyorAxis input, enter the conveyor belt position from the robot's origin point at the ConveyorAxisinput, and enter the position of the product origin point from the conveyor origin point at the ConveyorOrigin input. Once MC\_TrackConveyorBelt function block setting is complete, LS\_MoveLinearTimeAbsolute function block where the subsequently applied CoordSystem input is set to PCS is operated in sync with the conveyor. Synchronized conveyor operation performs an operation of drawing a triangle on a product. After synchronized conveyor belt operation is completed, execute LS\_MoveLinearTimeAbsolute function block where the CoordSystem is set to MCS to return to the previous status where the conveyor work is not yet performed.



FunctionBlock	CoordSystem	Position[]	Description
MoveLinearTimeAbsolute1	PCS	0,0,0	Move to ConveyorOrigin
MoveLinearTimeAbsolute2	PCS	40,0,0	Draw a triangle1
MoveLinearTimeAbsolute3	PCS	20,36.64,0	Draw a triangle2
MoveLinearTimeAbsolute4	PCS	0,0,0	Draw a triangle3
MoveLinearTimeAbsolute5	MCS	-240,0,-380	Move the robot to its initial position



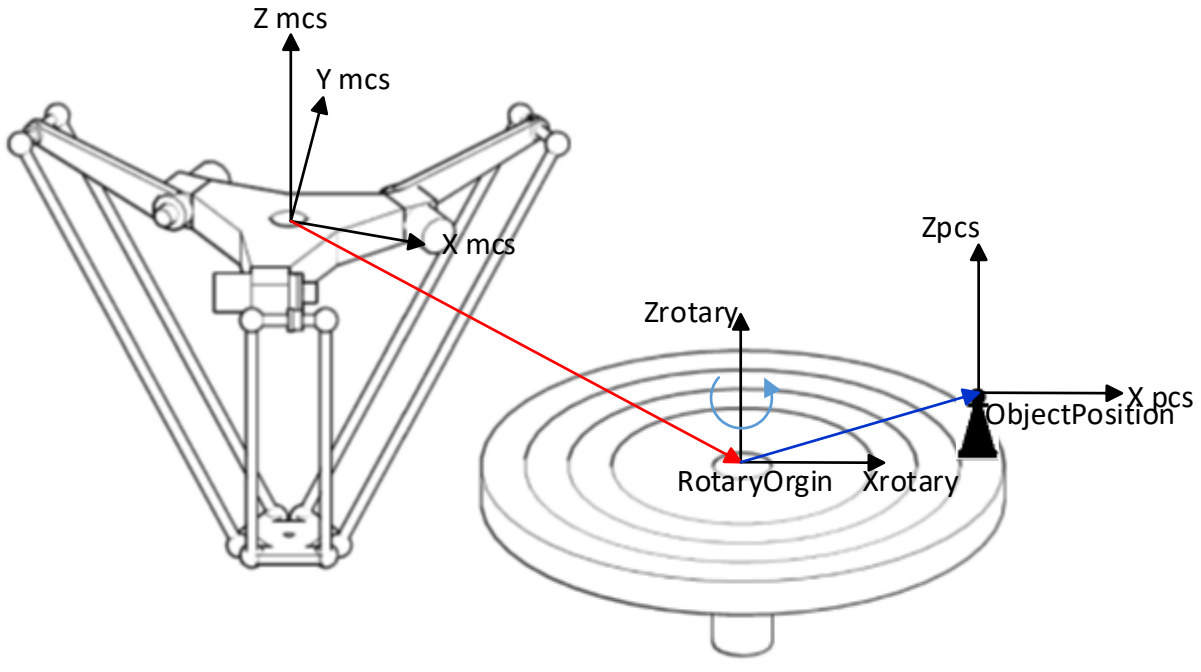
#### 4. Restrictions

Conveyor belt synchronization cannot be set in the case of the following errors.

- Value other than 2 is set in CoordSystem and performed (Error Code: 0x20BC)
- Axis set in ConveyorAxis is not connected (Error Code: 0x20C3)
- The unit of operation parameter of the axis set in ConveyorAxis is not mm/inch(Error Code: 0x20C2)
- Axis set in ConveyorAxis is not set as the infinite running repeat operation (Error Code: 0x20C6)
- Axis set in ConveyorAxis is the component axis in the applicable axis group (Error Code: 0x20C1)
- Of component axes, an axis where home position is not determined exists (Error Code 0x20B0)
- Of component axes, there is an axis being executed in infinite running repeat operation (Error Code: 0x20BA)

### 8.4.9 Rotary table synchronized operation

In coordinate system-based operation, the rotary table axis is set in the axis group and the object on the rotary table is followed.



1. Setting and disable of the conveyor belt synchronized operation

The MC\_TrackRotaryTable function block is a function block that sets the rotary table synchronous operation and does not directly perform operation. If rotary table synchronization is set with the MC\_TrackRotaryTable function block, the coordinate system-based motion function block in which the CoordSystem executed after setting is set to PCS performs operation in synchronization with the rotary table. In order to perform PCS operation that does not perform rotary table synchronous operation after completing rotary table synchronous operation, the rotary table synchronous operation must be canceled. To cancel rotary table synchronization, perform MCS coordinate system operation or reset the PCS coordinate system using MC\_SetCartesian function block in order to cancel rotary table synchronization operation set using MC\_TrackRotaryTable function block.

2. Function block

(1) Synchronization setting of the rotary table

Name	Description	Operation Condition																
MC_TrackRotaryTable	Synchronization setting of the rotary table	Edge																
<table border="1" style="margin: auto;"> <thead> <tr> <th colspan="2">MC_TrackRotaryTable</th> </tr> </thead> <tbody> <tr> <td>BOOL — Execute</td> <td>Done — BOOL</td> </tr> <tr> <td>UINT — AxesGroup</td> <td>----- AxesGroup — UINT</td> </tr> <tr> <td>UINT — RotaryAxis</td> <td>Busy — BOOL</td> </tr> <tr> <td>ARRAY[0..5] OF LREAL[ ] — RotaryOrigin</td> <td>Active — BOOL</td> </tr> <tr> <td>ARRAY[0..5] OF LREAL[ ] — ObjectPosition</td> <td>Error — BOOL</td> </tr> <tr> <td>UINT — CoordSystem</td> <td>ErrorID — WORD</td> </tr> <tr> <td>UINT — BufferMode</td> <td></td> </tr> </tbody> </table>			MC_TrackRotaryTable		BOOL — Execute	Done — BOOL	UINT — AxesGroup	----- AxesGroup — UINT	UINT — RotaryAxis	Busy — BOOL	ARRAY[0..5] OF LREAL[ ] — RotaryOrigin	Active — BOOL	ARRAY[0..5] OF LREAL[ ] — ObjectPosition	Error — BOOL	UINT — CoordSystem	ErrorID — WORD	UINT — BufferMode	
MC_TrackRotaryTable																		
BOOL — Execute	Done — BOOL																	
UINT — AxesGroup	----- AxesGroup — UINT																	
UINT — RotaryAxis	Busy — BOOL																	
ARRAY[0..5] OF LREAL[ ] — RotaryOrigin	Active — BOOL																	
ARRAY[0..5] OF LREAL[ ] — ObjectPosition	Error — BOOL																	
UINT — CoordSystem	ErrorID — WORD																	
UINT — BufferMode																		

(2) Release rotary table synchronization setting (PCS setting)

Name	Description	Operation Condition
MC_SetCartesianTransform	PCS setting	Edge

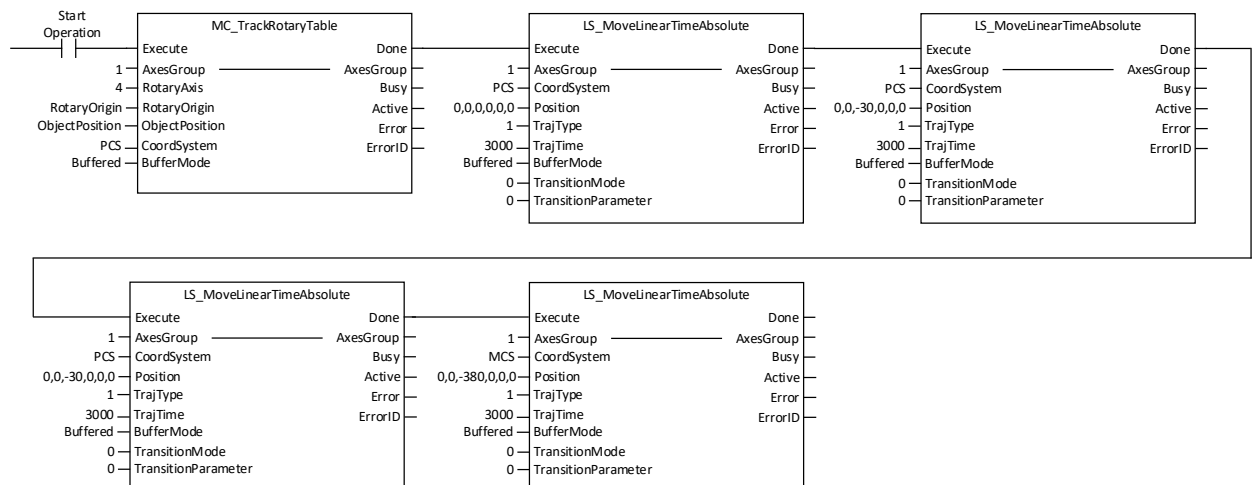
  

MC_SetCartesianTransform			
BOOL	Execute	Done	BOOL
UINT	AxesGroup	AxesGroup	UINT
LREAL	TransX	Busy	BOOL
LREAL	TransY	Active	BOOL
LREAL	TransZ	CommandAborted	BOOL
LREAL	RotAngleA	Error	BOOL
LREAL	RotAngleB	ErrorID	WORD
LREAL	RotAngleC		

3. Rotary table synchronization function operation example

The rotary table synchronization function starts with setting the rotary table synchronization using the MC\_Track RotaryTable function block. In the MC\_TrackRotaryTable function block, input the rotary table axis number to the RotaryAxis input, and the position from the robot origin to the center of the rotary table to RotaryOrigin. Input the position from the rotary table origin to the work object in ObjectPosition. When the MC\_TrackRotaryTable function block is set, the LS\_MoveLinearTimeAbsolute function block in which the CoordSystem input applied later is set to PCS is operated in synchronization with the rotary table. With rotary table synchronous operation, it follows the work on the rotary table, drives in the -direction of the Z axis and operates in the +direction. When the rotary table synchronous operation is completed, the LS\_MoveLinearTimeAbsolute function block whose CoordSystem input is set to MCS is executed to restore the state prior to the rotary table synchronous operation.

FunctionBlock	CoordSystem	Position[]	Description
MoveLinearTimeAbsolute1	PCS	0,0,0	Move to Object Center
MoveLinearTimeAbsolute2	PCS	0,0,-30	Object following operation 1
MoveLinearTimeAbsolute4	PCS	0,0,30	Object following operation 2
MoveLinearTimeAbsolute5	MCS	0,0,-380	Move the robot to the initial position



### 4. Restrictions

In the following cases, an error occurs and the rotary table synchronization cannot be set.

- When executing after setting a value other than 2 in CoordSystem (error code: 0x20BC)
- When the axis set in RotaryAxis is not connected (Error code: 0x20C3)
- When the unit of operation parameter of the axis set in RotaryAxis is not degree (error code: 0x20C2)
- When the axis set in RotaryAxis is not set to infinite length repetitive operation (error code: 0x20C6)
- When the axis set in RotaryAxis is a component axis in the corresponding axis group (error code: 0x20C1)
- When there is an axis whose origin is undecided among the constituent axes (error code: 0x20B0)
- In the case of an axis being executed by infinite length repetitive operation among the configuration axes (Error code: 0x20BA)

## 8.5 Rotary knife operation

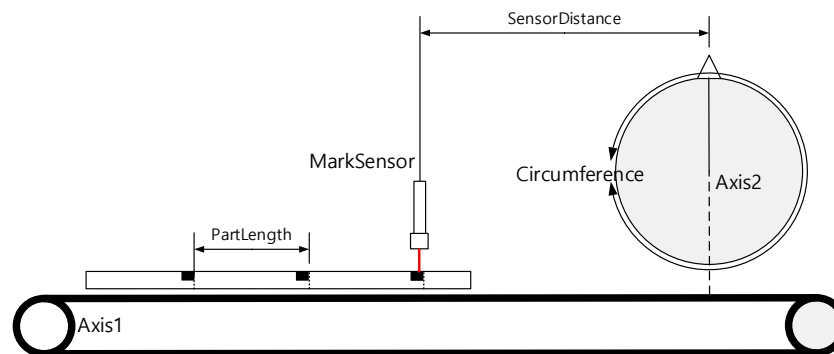
### 8.5.1 Overview of rotary knife operation

Rotary Knife operation is a function that cuts the workpiece moving through the conveyor using a rotating cutter without stopping the conveyor. In addition to cutting motion, it can be used for operations that follow the work piece synchronized with the main axis such as sealing or labeling.

### 8.5.2 Function of rotary knife operation

#### 1. Function of rotary knife operation

For rotary knife operation, the RampIn/Running/RampOut cam profile generated by the LS\_RotaryKnifeCamGen command is operated in the order of RampIn->Running->RampOut using the LS\_OnOffCam operation. Before performing LS\_OnOffCam operation, cam profile generation must be completed using LS\_RotaryKnifeCamGen command.



#### 2. Function block

##### (1) LS\_RotaryKnifeCamGen

Name	Description	Operation Condition
LS_RotaryKnifeCamGen	Generate rotaryknife cam profile	Edge

LS_RotaryKnifeCamGen			
BOOL	Execute	Done	BOOL
UINT	Axis	Axis	UINT
UINT	CamTableID	Busy	BOOL
LREAL	PartLength	Error	BOOL
LREAL	Circumference	ErrorID	WORD
LREAL	CuttingStart		
LREAL	CuttingEnd		
LREAL	CuttingSpdRatio		
UINT	CamType		
UINT	CamCurve		
UINT	CamPointNum		



(2) LS\_CrossSealCamGen

Name	Description	Operation Condition
LS_CrossSealCamGen	Generate crossseal cam profile	Edge

LS\_CrossSealCamGen

BOOL	Execute	Done	BOOL
UINT	Axis .....	Axis	UINT
UINT	CamTableID	Busy	BOOL
LREAL	PartLength	Error	BOOL
LREAL	Circumference	ErrorID	WORD
LREAL	SealStart		
LREAL	SealEnd		
LREAL	SealSpdRatio		
UINT	CamType		
UINT	CamCurve		
UINT	CamPointNum		

(3) LS\_OnOffCam

Name	Description	Operation Condition
LS_OnOffCam	OnOffCam operation	Edge

LS\_OnOffCam

BOOL	Execute	InSync	BOOL
UINT	Master .....	Master	UINT
UINT	Slave .....	Slave	UINT
BOOL	CamOnOff	Busy	BOOL
BOOL	SkipOnCam	Active	BOOL
BOOL	SkipRunCam	CommandAborted	BOOL
UINT	MasterValueSource	Error	BOOL
UINT	OnCam_ID	ErrorID	WORD
UINT	RunCam_ID	EndOfProfile	BOOL
UINT	OffCam_ID	CamState	UINT
UINT	StartMode		
LREAL	StartModeParam		
LREAL	MasterScale		
LREAL	SlaveScale		

3. LS\_RotaryKnifeCamGen function block setting

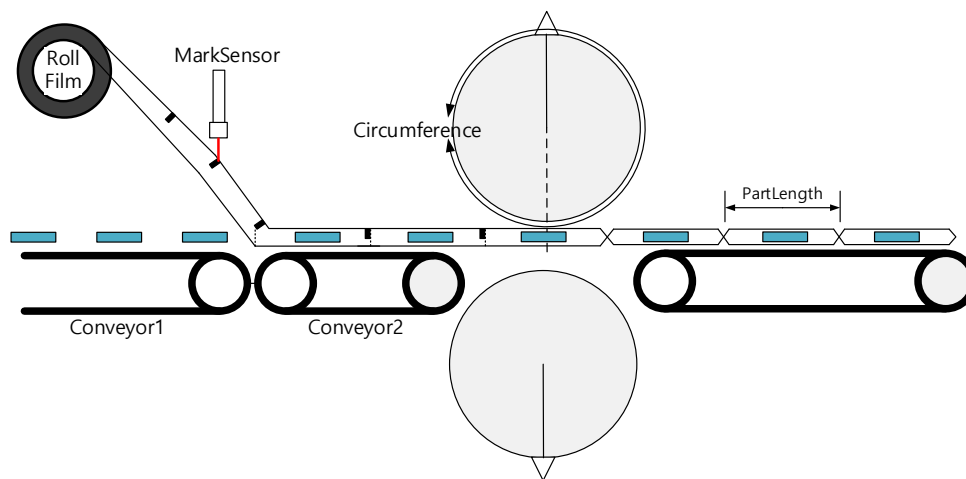
In the PartLength input, enter the length of the object to be cut (the distance between the mark sensors). In Circumference input, enter the circumference value of the rotary knife. If the rotary knife have more than one blade and the gaps between the blades are all the same, enter the distance between the blade and the blade. The rotary cutter cuts between CuttingStart and CuttingEnd. It is recommended that the cutting position be 1/2 of the Circumference. SealSpdRation can control the synchronous speed in the cutting section. In general, by entering 100, the main axis of the conveyor axis and the sub axis of the rotary knife should synchronize 1:1 in the cutting section, but it can be adjusted to push the product after cutting or to change the sealing characteristics in the sealing equipment.

For CamType, you can select 0:All 1:RampIn 2:Running 3:RampOut 4:sAll 5:sRampIn 6:Running 7:sRampOut. 0:All If 4:sAll is selected, 3 RampIn/Running/RampOut profiles are created at once. CamCurve can select 0:Line 1:Cubic.

#### 4. Difference of LS\_RotaryKnifeCamGen and LS\_CrossSealCamGen

The LS\_RotaryKnifeCamGe and LS\_CrossSealCamGen function blocks have many similar functions. LS\_RotaryKnifeCam is a solution that utilizes a rotary knife, and LS\_CrossSealCamGen is a function block developed for use in a rotary sealer solution. In the LS\_CrossSealCamGen function block, the generated Cam-profile is fixed to 0~360 for both main and sub axis profiles and output. In cross sealer operation, the main axis does not use the conveyor axis, but the virtual axis that operates in the range of 0 to 360 is used as the main axis to perform operation. Conveyor 1 axis transfers 1 workpiece to Conveyor 2 when the main axis is operated at 0~360.

Conveyor 2 axis performs gear operation with the 360:PartLength gear ratio with the virtual axis as the main axis, and when the main axis moves from 0 to 360, it moves the workpiece as much as PartLength to the sealer.



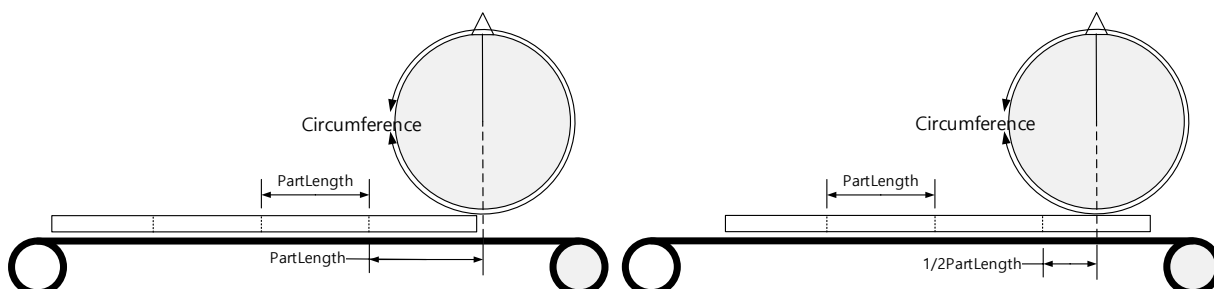
#### 5. LS\_OnOffCam start position when creating Cam-profile with LS\_RotaryKnifeCamGen

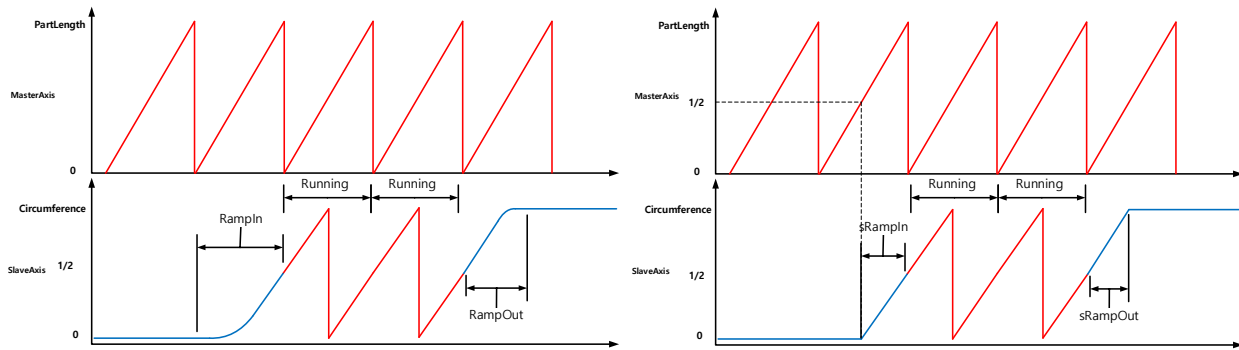
When starting LS\_OnOffCam operation with a cam profile created with LS\_RotaryKinfeCamGen, the operation start position would be changed when performing LS\_OnOffCam operation depending on whether the CamType entered when creating the profile is RampIn/RampOut or sRampIn/sRampIn/sRampOut.

When CamType is RampIn, the Cam-profile created in LS\_RotaryKnifeCamGen function block creates a profile in which the sub axis operates as much as  $1/2$  Circumference when the main axis moves as much as PartLength. Therefore, in the Cam-profile created by setting RampIn/RampOut, the starting position of LS\_OnOffCam operation should be started in front of PartLength from the position to perform cutting.

When CamType is sRampIn, the Cam-profile created in LS\_RotaryKinfeCamGen function block creates a profile in which the sub axis operates as much as  $1/2$ Circumference when the main axis moves as much as  $1/2$ PartLength. Therefore, the starting position of LS\_OnOffCam operation should be started in front of  $1/2$ PartLength from the position to perform cutting.

The initial position of the rotary cutter shaft is 0. In the figure below, the position of the rotary cutter shaft is 0. In general, it is recommended to perform the cutting position at  $1/2$  of the Circumference.





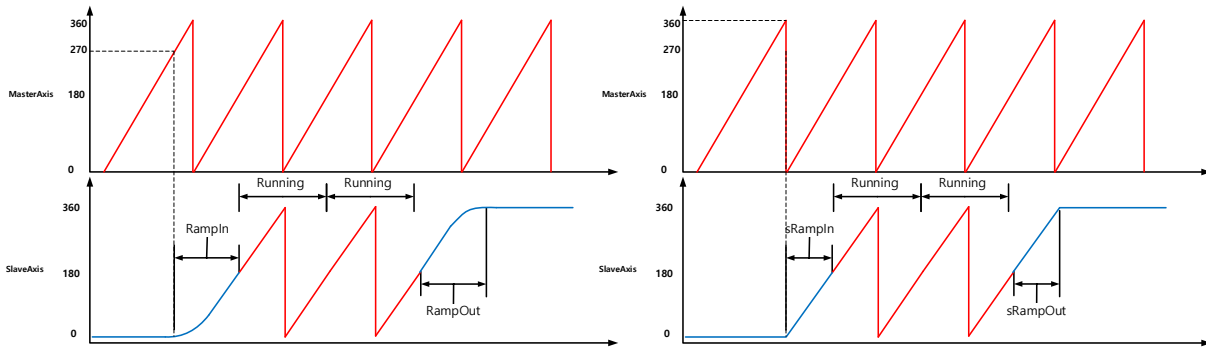
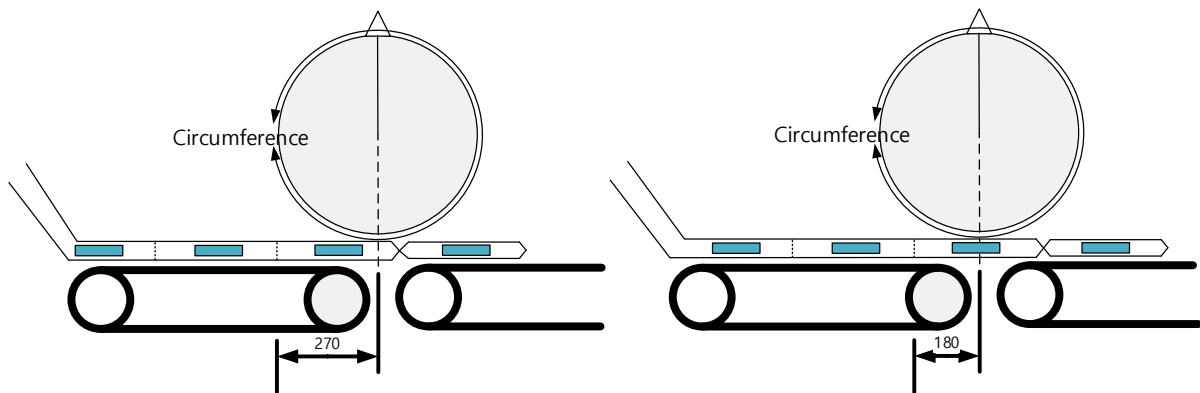
6. LS\_OnOffCam start position when creating a Cam-profile with LS\_CrossSealCamGen

When starting LS\_OnOffCam operation with a Cam-profile created with LS\_CrossSealCamGen, the operation start position should be changed when performing LS\_OnOffCam operation depending on whether the CamType entered when creating the profile is RampIn/RampOut or sRampIn/sRampIn/sRampOut.

When CamType is RampIn, the Cam-profile created in LS\_CrossSealCamGen function block creates a profile in which the sub-axis operates as much as 180 when the main axis moves as much as 270. Therefore, in the Cam-profile created by setting RampIn/RampOut, the starting position of LS\_OnOffCam operation must be started in front of 270 from the position to perform sealing.

When CamType is sRampIn, the Cam-profile created in LS\_CrossSealCamGen function block creates a profile in which the sub-axis operates as much as 180 when the main axis moves 180. Therefore, the starting position of LS\_OnOffCam operation should be started in front of 180 from the position to perform sealing.

The initial position of the sealer shaft is 0. In the figure below, the position of the sealer shaft is 0. It is generally recommended to perform the sealing position at 180.





## Appendix 1 Error Information & Solution

Here describes the information error types and its solutions.

### (1) Function block error information

Error code		Error Description	Solutions
Hex	Dec		
0005	5	Motion Control module does not support this function block.	The relevant command is not performed in the current version of the module. Please contact customer support team of our company after check the version in which the relevant command can be performed.
0006	6	Axis or encoder number of the function block exceeds the range.	Set axis number to be 1 ~ 32 or 37 ~ 40. (Encoder number: 1 ~ 2)
0007	7	Axis group number of the function block (AxisGroup input) exceeds the range.	Set axis group number to be between 1 and 16.
0009	9	The slave number (Slave input) of the function block exceeded the allowable range.	Check the range of slave number and set again.
000B	11	The input of the function block exceeded the allowable range.	Check the input range of the function block and set it again.
000C	12	Array input of function block exceeded the allowable range.	Check the size of the function block array input and set it again.
0012	18	Function block internal execution error was occurred.	The problem can be generated in a version of current module. Please check support version of XG-PM and module.
0013	19	Motion response error was occurred during function block executing.	The problem can be generated in a version of current module. Please check support version of XG-PM and module.
0014	20	The allowable range of the function block's cam ID (CamTableID input) has been exceeded.	Check the cam ID range and set it again.
0015	21	An OS service that is not supported was used.	A function not supported by the current module version was used. Please check the supported version of the module.

### (2) Program operation related error information

Error code		Error Description	Solutions
Hex	Dec		
0020	32	Execution time of main task exceeded that setting time of main task period.	Module let RUN after set <b>main</b> task period of basic parameter to be longer than current setting value.
0021	33	Execution time of periodic task exceeded that setting time of periodic task period.	Module let RUN after set periodic task period of basic parameter to be longer than current setting value.
0022	34	Because abnormal basic parameter or program data, it is not possible to change to the RUN mode.	The problem can be generated in a version of current module. Please check support version of XG-PM and module.
0025	37	Interface error of XG-PM data writing has occurred.	The problem can be generated in a version of current module. Please check support version of XG-PM and module.
0026	38	Interface error of XG-PM data reading has occurred.	The problem can be generated in a version of current module. Please check support version of XG-PM and module.
0027	39	An attempt was made to change the device that can not be changed in XG-PM device monitor.	The problem can be generated in a version of current module. Please check support version of XG-PM and module.
0028	40	Command data value that sent from XG-PM exceeded allowable range.	Please execute the test operation in XG-PM after changing module to STOP status.

Error code		Error Description	Solutions
Hex	Dec		
0029	41	XG-PM test operation function can not execute while module is RUN mode.	The problem can be generated in a version of current module. Please check support version of XG-PM and module.
002A	42	CPU test operation command can not execute while module is RUN mode.	Please execute the test operation in XG-PM after changing module to STOP status.
002B	43	Axis setting value exceeds allowable range of CPU test operation command.	Please set axis number in the range of 1~32, 37~40.
002D	45	Can not be processed EXCEPTION occurred while motion program executing.	Please request A/S if an error repeats after downloading the program again in XG-PM.
002E	46	Can not be processed EXCEPTION occurred while motion is operating.	Please request A/S if an error repeats after downloading the program again in XG-PM.
002F	47	Module is restarted by abnormal termination.	Please take action after checking module error history.

(3) Data-write related error information

Error code		Error Description	Solutions
Hex	Dec		
0030	48	It is not possible to write basic parameter when module is in RUN mode or network connection state.	Please execute writing common parameter after changing module to STOP status and disconnecting network status.
0031	49	It is not possible to write program data when module is in RUN mode.	Please execute writing program data after changing module to STOP status.
0032	50	It is not possible to write position data when module is in RUN mode.	Please execute writing position data after changing module to STOP status.
0033	51	It is not possible to initialize the module when module is in RUN mode.	Please initialize the module after changing module to STOP status.
0034	52	It is not possible to write CAM data when some axis is in operation.	Please write cam data in state that all axis isn't operating status.
0035	53	It is not possible to write common parameter when some axis is in operation.	Please write common parameter in state that all axis isn't operating status.
0036	54	It is not possible to write network parameter when EtherCAT communication is connected.	Please write network data after disconnecting EtherCAT communication.
0037	55	After the data written, backup abnormal error of Flash(BAK_QUEUE_FULL) occurred.	The problem can be generated in a version of current module. Please check support version of XG-PM and module.
0038	56	After the data is written, backup abnormal error of Flash(BAK_INCOMPLETE) occurred.	The problem can be generated in a version of current module. Please check support version of XG-PM and module.

(4) Program data related error information

Error code		Error Description	Solutions
Hex	Dec		
0040	64	Program data(task table, program table, upload table) is abnormal.	Please exchange module, if an error happens again after downloading the data in XG-PM again and reloading.
0043	67	Upload information data is abnormal.	Please request A/S, if an error happens again after downloading the program in XG-PM again.
0044	68	Information data of online editing(CODE_TABLE) is abnormal.	Please request A/S, if an error happens again after downloading the program in XG-PM again.
0045	69	Information data of online editing(FUNC_TABLE) is abnormal.	Please request A/S, if an error happens again after downloading the program in XG-PM again.

## Appendix1 Error Information & Solution

### (5) Basic parameter data related error information

Error code		Error Description	Solutions
Hex	Dec		
0050	80	Basic parameter data is abnormal.	Please exchange module, if an error happens again after downloading the data in XG-PM again and reloading.
0051	81	Main task period of basic parameter exceeded the range.	Please check range of main task period in basic parameter.
0052	82	Periodic task period of basic parameter exceeded the range.	Please check range of periodic task period in basic parameter. Must be set as integer multiple of main task period.

### (6) Common parameter data related error information

Error code		Error Description	Solutions
Hex	Dec		
0060	96	Common parameter data is abnormal.	Please exchange module, if an error happens again after downloading the data in XG-PM again and reloading.
0061	97	Encoder pulse input type of common parameter exceeded the setting range.	Please set encoder pulse input in common parameter within 0~5.
0062	98	Encoder1 maximum value of common parameter is out of range the expression value of pulse unit.	Please set encoder1 maximum value in common parameter over 1 in pulse unit.
0063	99	Encoder1 minimum value of common parameter is out of range the expression value of pulse unit.	Please set encoder1 minimum value in common parameter over 1 in pulse unit.
0064	100	The encoder1 maximum value, minimum value in common parameter exceeded a range.	Please set encoder1 minimum value in common parameter to less than maximum value. And setting that range of minimum value and maximum value include encoder1 current position.
0065	101	The encoder pulse input type in encoder exceeded a range.	Please set encoder pulse input in common parameter within 0~5.
0066	102	The encoder2 maximum value in common parameter exceeded a range in pulse unit.	Please set encoder2 maximum value in common parameter over 1 in pulse unit.
0067	103	The encoder2 minimum value in common parameter exceeded a range in pulse unit.	Please set encoder2 minimum value in common parameter over 1 in pulse unit.
0068	104	The encoder2 maximum value, minimum value in common parameter exceeded a range.	Please set encoder2 minimum value in common parameter to less than maximum value. And setting that range of minimum value and maximum value include encoder2 current position.
0069	105	It is not possible to set the encoder input because of abnormal encoder setting in common parameter.	Please set the value within range, after checking encoder relevant item in common parameter.
006A	106	Setting value of the encoder1 pulses per rotation in common parameter exceeded a range.	Please set the encoder1 pulses per rotation in common parameter to more than 0 and less than 4294967295.
006B	107	Setting value of the encoder1 travel per rotation in common parameter exceeded a range.	Please set the encoder1 travel per rotation in common parameter to more than 0. 000000001 and less than 4294967295.
006C	108	Setting value of the encoder2 pulses per rotation in common parameter exceeded a range.	Please set the encoder2 pulses per rotation in common parameter to more than 0 and less than 4294967295.
006D	109	Setting value of the encoder2 travel per rotation in common parameter exceeded a range.	Please set the encoder2 travel per rotation in common parameter to more than 0. 000000001 and less than 4294967295.

(7) Network parameter data related error information

Error code		Error Description	Solutions
Hex	Dec		
0070	112	The network parameter data is abnormal.	Please exchange module, if an error happens again after downloading the data in XG-PM again and reloading.
0071	113	The periodic communication time-out count in network parameter exceeded a range.	Please set The periodic communication time-out count in network parameter within 1~8.

(8) Shared variable parameter data related error information

Error code		Error Description	Solutions
Hex	Dec		
0080	128	The shared variable parameter data is abnormal.	Please set the shared variable parameter again in I/O parameter of XG-5000. Please exchange module, if an error happens again.
0081	129	The transmission data size in shared variable parameter exceeded a range.	The transmission data size in shared variable parameter exceeded 2048 word. Please set the transmission data size within 2048 word.
0082	130	The transmission CPU device type in shared variable parameter exceeded a range.	Please set the transmission CPU device type in shared variable parameter in the range of [0:D, 1:M, 2:R, 3:ZR] for XGK, [0:M, 1:R, 2:W] for XGI/R.
0083	131	The transmission module device type in shared variable parameter exceeded a range.	Please set the transmission module device type in shared variable parameter within 0~1[0:D,1:M].
0084	132	The transmission CPU address of the shared variable parameter exceeded a range.	The transmission CPU address in shared variable parameter exceeded module device range. Please set within the value of device address range after checking address range of CPU device which will be shared.
0085	133	The transmission module address of the shared variable parameter exceeded a range.	The transmission module address in shared variable parameter exceeded module device range. Please set within the value of device address range after checking address range of module device which will be shared.
0086	134	The reception data size in shared variable parameter exceeded a range.	The reception data size in shared variable parameter exceeded 2048 word. Please set the reception data size within 2048 word.
0087	135	The reception CPU device type in shared variable parameter exceeded a range.	Please set the reception CPU device type in shared variable parameter in the range of [0:D, 1:M, 2:R, 3:ZR] for XGK, [0:M, 1:R, 2:W] for XGI/R.
0088	136	The reception module device type in shared variable parameter exceeded a range.	Please set the reception module device type in shared variable parameter within 0~1[0:D,1:M].
0089	137	The reception CPU address in shared variable parameter exceeded a range.	The reception CPU address in shared variable parameter exceeded module device range. Please set within the value of device address range after checking address range of CPU device which will be shared.
008A	138	The reception module address in shared variable parameter exceeded a range.	The reception module address in shared variable parameter exceeded module device range. Please set within the value of device address range after checking address range of module device which will be shared.



## Appendix1 Error Information & Solution

### (9) Network connecting command related error information

Error code		Error Description	Solutions
Hex	Dec		
0090	144	It is not possible to execute the connection command because of abnormal network parameter.	Please set again after checking network parameter.
0091	145	Network connect command is operating.	Please check whether network connect command was not entered again during operating network connect command.
0092	146	Network disconnect command is operating.	Please check whether network disconnect command was not entered again during operating network disconnect command.
0093	147	It isn't possible to execute the connect/disconnect command because of change mode.	Please check that network connect/disconnect command was not entered during change mode.

### (10) Encoder preset command related error information

Error code		Error Description	Solutions
Hex	Dec		
00A0	160	It is not possible to execute the encoder preset command because of abnormal common parameter.	By using XG-PM, set a common parameter to the normal value, after checking whether it was set up as the value in the range by confirming the encoder related item of common parameter.
00A1	161	It is not possible to execute preset command because there is axis operating relevant encoder as main axis.	Please check that encoder preset command was entered to relevant encoder when there is axis operating relevant encoder as main axis.
00A2	162	The encoder preset position exceeded a range of maximum or minimum of relevant encoder.	Please set encoder preset position to more than or equal to minimum value of relevant encoder and to less than or equal to maximum value.
00A3	163	The encoder selection of encoder preset command exceeded a range.	Please set encoder selection within 0~1(0: Encoder1, 1:Encoder2).
00B0	176	Encoder 1 maximum value and minimum value of encoder parameters are set not to include the current position of encoder 1.	Set the range of encoder 1 minimum and maximum values of encoder parameters to include the current position of encoder 1.
00B1	177	Encoder 2 maximum value and minimum value of encoder parameters are set not to include the current position of encoder 2.	Set the range of encoder 2 minimum and maximum values of encoder parameters to include the current position of encoder 2.

### (11) EtherCAT communication related error information

Error code		Error Description	Solutions
Hex	Dec		
0F00	3840	Failed to change to the EtherCAT INIT status.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F01	3841	It is EtherCAT INIT status initialization (PORT_INIT) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.

Error code		Error Description	Solutions
Hex	Dec		
0F02	3842	It is EtherCAT INIT status initialization (ESC_RD) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F03	3843	It is EtherCAT INIT status initialization (ST_ADDR_RD) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F04	3844	It is EtherCAT INIT status initialization (FMMU_CLEAR) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F05	3845	It is EtherCAT INIT status initialization (SM_CLEAR) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F06	3846	It is EtherCAT INIT status initialization (DC_INIT) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F07	3847	It is EtherCAT INIT status initialization (AL_CR_WR) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F08	3848	It is EtherCAT INIT status initialization (AL_SR_RD) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F09	3849	There is no EtherCAT slave which is connected module.	Please check whether the connection cable is normally installed between EtherCAT slave and the power is normally supplied, and communication cable is exposed to noise if there is slave which is connected to module.
0F0A	3850	It exceeded maximum connection slave number.	Please check whether number of EtherCAT slave that is connected to the module does not exceed 36.
0F10	3856	Failed to change to the EtherCAT PREOP status.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F11	3857	It is EtherCAT PREOP status initialization (SII_CONFIG) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F12	3858	It is EtherCAT PREOP status initialization (SII_DATA(V)_RD) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.

## Appendix1 Error Information & Solution

Error code		Error Description	Solutions
Hex	Dec		
0F13	3859	It is EtherCAT PREOP status initialization (SII_DATA(P)_RD) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F14	3860	It is EtherCAT PREOP status initialization (SII_DATA(R)_RD) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F15	3861	It is EtherCAT PREOP status initialization (RX_ERR_CLEAR) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F16	3862	It is EtherCAT PREOP status initialization (ST_ADDR_WR) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F17	3863	It is EtherCAT PREOP status initialization (SM0_SET) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F18	3864	It is EtherCAT PREOP status initialization (SM1_SET) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F19	3865	It is EtherCAT PREOP status initialization (AL_CR_WR) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F1A	3866	It is EtherCAT PREOP status initialization (AL_SR_RD) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F1B	3867	It exceeded maximum connection servo drive number.	Please check whether number of EtherCAT servo drive that is connected to the module does not exceed 32.
0F1C	3868	It exceeded maximum connection I/O number.	Please check whether number of EtherCAT I/O that is connected to the module does not exceed 32.
0F1D	3869	There is no information about slave which is connected.	Please check whether information file which is connected to slave is in "I.eng\DriveInfo" or "I.eng\IOInfo" folder of XG-PM installation folder and it was transmitted to a module.
0F1E	3870	There is no network setting data.	Please transmit slave parameter to module by using XG-PM.
0F1F	3871	The slave which was connected with network setting data is different.	Please transmit slave parameter after connecting slave by Network Slave Autoconnect of XG-PM.
0F20	3872	Failed to change to the EtherCAT SAFEOP status.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.

Error code		Error Description	Solutions
Hex	Dec		
0F21	3873	It is EtherCAT SAFEOP status initialization (DRV_MODE_RD) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F22	3874	It is EtherCAT SAFEOP status initialization (PDO_SET) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F23	3875	It is EtherCAT SAFEOP status initialization (DC_START) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F24	3876	It is EtherCAT SAFEOP status initialization (SM2_SET) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F25	3877	It is EtherCAT SAFEOP status initialization (SM3_SET) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F26	3878	It is EtherCAT SAFEOP status initialization (FMMU0_SET) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F27	3879	It is EtherCAT SAFEOP status initialization (FMMU1_SET) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F28	3880	It is EtherCAT SAFEOP status initialization (AL_CR_WR) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F29	3881	It is EtherCAT SAFEOP status initialization (AL_SR_WR) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F30	3888	Failed to change to the EtherCAT OP status.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F31	3889	It is EtherCAT OP status initialization (AL_CR_WR) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.

## Appendix1 Error Information & Solution

Error code		Error Description	Solutions
Hex	Dec		
0F32	3890	It is EtherCAT OP status initialization(AL_SR_RD) error.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F40	3904	Failed to change EtherCAT OP status to INIT status.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F41	3905	It is INIT status initialization(AL_CR_WR) error from EtherCAT OP status.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F42	3906	It is INIT status initialization(AL_SR_RD) error from EtherCAT OP status.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F43	3907	It is INIT status initialization(DC_INIT) error from EtherCAT OP status.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F50	3920	There is no response from communication connection status.	Please check connection status of communication cable and operation status(power-on and error occurrence or not) of slave, and etc. And please check whether communication cable is exposed to noise, too.
0F51	3921	Periodic communication error occurred.(The communication error exceeding the parameter periodic communication time-out number occurred.)	Please check whether power of servo is off in communication, communication cable is normally installed and communication cable is exposed to noise.
0F53	3923	EtherCAT connection command did not complete successfully. (Timeout)	Please request A/S if repetition occurs.

### (12) ECS Read/Write related error information

Error code		Error Description	Solutions
Hex	Dec		
0F60	3936	The slave device address (Adp) setting of the ESC read command exceeds the range.	Please set it to check the range of EtherCAT command code (EcatCmd) slave device address corresponding to the set value (Adp).
0F61	3937	Setting value of the data size of the command to read the ESC is out of range.	Please the data size of the read command ESC to set the setting value to 1~4 (BYTE).
0F62	3938	Read EtherCAT command code of the command ESC (EcatCmd) setting had a well.	Set the EtherCAT command code to one of 1(APRD), 4(FPRD), 7(BRD).
0F63	3939	Read the ESC does not have a response of the slave equipment of command.	Please make sure that if a given slave equipment has been installed correctly, or Ado address value is read-allowed area Adp.
0F70	3952	ESC slave device address of the write command (Adp) setting value is out of range.	Please set it to check the range of EtherCAT command code (EcatCmd) slave device address corresponding to the set value (Adp).

Error code		Error Description	Solutions
Hex	Dec		
0F71	3953	Setting value of the data size of ESC write command is out of range.	Please the data size of the ESC write command to set the setting value to 1~4 (BYTE).
0F72	3954	ESC EtherCAT command code of the write command (EcatCmd) setting had a well.	Set the EtherCAT command code to one of 2 (APWR), 5 (FPWR), or 8 (BWR).
0F73	3955	ESC No response of the slave device of the write command.	Please make sure that it is whether the specified slave device has been successfully installed, or the value of Ado address is allowed to write area in Adp.
0F74	3956	In the communication connection / disconnection command running or communication connection state, you will not be able to write the area specified by ESC address (Ado).	Please set a writable ESC address (Ado) in the write command to the communication connection / disconnection command running or communication connection state.

**Note**

EtherCAT Slave State Classification

1. INIT  
: Initial state. State after EtherCAT Slave is On. Mailbox communication and process data communication cannot be performed.
2. PREOP(Pre-Operational)  
: State before operation. Communication connection is established, but data communication processing is not possible. (Mailbox communication only)
3. SAFEOP(Safe-Operational)  
: Communication connection and data communication processing is possible. Input is possible but output is not. PDO input data (TxPDO) can be read and PDO output data (RxPDO) cannot be received.
4. OP(Operational)  
: Driving condition. Both input/output data are valid. It performs periodic I/O communication and can process PDO output data (RxPDO).

For details, refer to '4.4.3 EtherCAT Status Machine'.

(13) Hardware failure related error information

Error code		Error Description	Solutions
Hex	Dec		
0FF0	4080	It is not possible to execute the normal operation with module H/W problem (ASIC_RESET).	Please request A/S if an error repeats when turning on the power again.
0FF1	4081	It is not possible to execute the normal operation with module H/W problem (ASIC_CRAM).	Please request A/S if an error repeats when turning on the power again.
0FF2	4082	It is not possible to execute the normal operation with module H/W problem (ASIC_HSC).	Please request A/S if an error repeats when turning on the power again.
0FF3	4083	It is not possible to execute the normal operation with module H/W problem (FLASH).	Please request A/S if an error repeats when turning on the power again.
0FF4	4084	It is not possible to execute the normal operation with module H/W problem (ASIC_V_AREA).	Please request A/S if an error repeats when turning on the power again.
0FF5	4085	It is not possible to execute the normal operation with module H/W problem (ASIC_F_AREA).	Please request A/S if an error repeats when turning on the power again.
0FF6	4086	It is not possible to execute the normal operation with module H/W problem (ASIC_R_AREA).	Please request A/S if an error repeats when turning on the power again.

## Appendix1 Error Information & Solution

Error code		Error Description	Solutions
Hex	Dec		
0FF7	4087	It is not possible to execute the normal operation with module H/W problem (FRAM).	Please request A/S if an error repeats when turning on the power again.
0FF8	4088	Fail to read the information (TIME_DATE) from CPU.	Please check whether it is CPU version which a module can support. Please request A/S if an error repeats when turning on the power again in case of CPU which support motion control module.
0FF9	4089	Fail to read the information (SPARAM) from CPU.	Please check whether it is CPU version which a module can support. Please request A/S if an error repeats when turning on the power again in case of CPU which support motion control module.
0FFE	4094	Fail to device backup by abnormal operation(module detachment).	Please operate after checking whether data which should be backed up in the previous operation is normal.
0FFF	4095	Backup ram <b>data</b> was damaged.	Please operate after transmitting data again by XG-PM. Please exchange module if an error happens again.

### (14) Axis status related error information

Error code		Error Description	Solutions
Hex	Dec		
1000	4096	The axis is not ready for operation. (Not connected to the network.)	Please execute command when axis is ready for operation.
1001	4097	It can't be executed in "Disabled" state.	Please execute command in the condition that can operate the relevant command after checking the axis condition that can operate the relevant command.
1002	4098	It can't be executed in "Standstill" state.	Please execute command in the condition that can operate the relevant command after checking the axis condition that can operate the relevant command.
1003	4099	It can't be executed in "Discrete" state.	Please execute command in the condition that can operate the relevant command after checking the axis condition that can operate the relevant command.
1004	4100	It can't be executed in "Continuous" state.	Please execute command in the condition that can operate the relevant command after checking the axis condition that can operate the relevant command.
1005	4101	It can't be executed in "Synchronized" state.	Please execute command in the condition that can operate the relevant command after checking the axis condition that can operate the relevant command.
1006	4102	It can't be executed in "Homing" state.	Please execute command in the condition that can operate the relevant command after checking the axis condition that can operate the relevant command.
1007	4103	It can't be executed in "Stopping" state.	Please execute command in the condition that can operate the relevant command after checking the axis condition that can operate the relevant command.
1008	4104	It can't be executed in "Errorstop" state.	Please execute command in the condition that can operate the relevant command after checking the axis condition that can operate the relevant command.
100A	4106	It is not possible to execute the motion command when assigned axis group is enable state.	Please execute the command after changing axis group to GroupDisabled state by axis group disable command.

100B	4107	It is a command which can't issue to virtual axis.	The relevant command can't be executed in virtual axis. Please check whether the relevant command was not executed in virtual axis.
100E	4110	It is changed to 'run' state during execution of motion test run command, and thus the operation cannot continue.	Check whether the controller was changed to the 'run' state while the axis is running.

(15) Common operation related error information

Error code		Error Description	Solutions
Hex	Dec		
1010	4112	It can't continue a operation because a module is changed to STOP state	Please check whether module was not changed to STOP state while the axis operates.
1011	4113	It can't continue a operation because the network is disconnected.	Please check network disconnection because of slave power disorder, network cable disorder, noise inflow to the network cable while the axis operates.
1012	4114	The position setting value of the command is out of range from pulse unit representation value.	When converting the command position value to the pulse unit, It is out of range from 32 Bit domains. When converting the command position value into the pulse, Please set in -2147483648 ~ 2147483647 ranges.
1013	4115	The operation speed value was 0 or less, or exceeded the maximum speed value.	Please set the operation speed value to the bigger value than 0, or smaller than or equal to the maximum speed value which is set up in the relevant axis.
1014	4116	The acceleration was set up as the negative number.	Please set the acceleration value to more than 0.
1015	4117	The deceleration was set up as the negative number.	Please set the deceleration value over 0.
1016	4118	The jerk was set up as the negative number.	Please set the jerk value over 0.
1017	4119	The direction appointment exceeded a range.	Please set the value within a range, after checking a range of direction setting value of relevant command. (Refer to chapter6. Motion function block)
1018	4120	The torque setting value exceeded a range.	Please set the torque setting value within 1000%.
1019	4121	The torque lamp setting value exceeded a range.	Please set the torque lamp setting value over 0.
101A	4122	Buffer Mode setting value exceeded a input range.	Please set value(0-5) can be set in the Buffer Mode.
101B	4123	Execution Mode setting value exceeded a input range.	Please set value(0~1) can be set in the Execution Mode.
101C	4124	You can't operate continuously because tracking error over-range alarm occurred.	Deviation between command position and current position exceeded 'Tracking error over-range value'. In order that an alarm doesn't happen, tune servo drive or set 'Tracking error over-range value' to more than existing value.
101D	4125	Tracking error over-range warning occurred.	Deviation between command position and current position exceeded 'Tracking error over-range value'. In order that an alarm doesn't happen, tune servo drive or set 'Tracking error over-range value' to more than existing value.
101F	4127	The command position value transmitted to the servo drive is out of range from the pulse unit representation value.	When converting the command position value to the pulse unit, It is out of range from 32 Bit domains. When converting the command position value into the pulse, Please set in -2147483648 ~ 2147483647 ranges.



## Appendix1 Error Information & Solution

### (16) Function block execution related error information

Error code		Error Description	Solutions
Hex	Dec		
1020	4128	It is the axis command that is not defined.	The relevant command is not performed in the current version of the module. Please contact customer support team of our company after check the version in which the relevant command can be performed.
1021	4129	The executed command was canceled because same command was executed.	Please check whether the relevant command was not again performed among the same command operation.
1022	4130	It exceeded the number of commands which can operate Buffered command.	You can't perform a command because the command buffer of the relevant axis group is full. The number of commands which can be operated with Buffered command is 10. Please control the command operation timing.

### (17) Axis parameter-write related error information

Error code		Error Description	Solutions
Hex	Dec		
1030	4144	You can't write axis parameter when the axis is in operation.	Please execute writing parameter when the axis is not operating.

### (18) Axis parameter data related error information

Error code		Error Description	Solutions
Hex	Dec		
1040	4160	Data of the axis parameter is abnormal.	Please exchange module, if an error happens again after downloading the data in XG-PM again and reloading.
1041	4161	It is not possible to execute operation because of parameter error of axis.	Please set again after confirming axis parameter.
1042	4162	You can't set speed limit of axis parameter to the value less than 0.	Please set speed limitation of basic parameter over1 in pulse unit.
1043	4163	Soft upper/lower limit value of axis parameter exceeded a range.	Soft upper limit value of axis parameter is more than or equals to soft lower limit value.
1044	4164	Current speed filter time constant value of axis parameter is out of range.	Please set the parameter setting value to 1~100.
1045	4165	Error reset monitoring time of axis parameter is out of range.	Please set the parameter setting value to 1~1000.
1046	4166	Setting value of travel per rotation exceeded a range.	Please set the parameter setting value to more than 0. 000000001 and less than 4294967295.
1047	4167	Setting value of infinite running repeat position exceeded a range.	Please set the parameter setting value to more than 0 and less than 2147483647 in pulse unit.
1048	4168	Setting value of command inposition range exceeded a range.	Please set the parameter setting value to more than 0 and less than 2147483647 in pulse unit.
1049	4169	Setting value of tracking error over-range exceeded a range.	Please set the parameter setting value to more than 0 and less than 2147483647 in pulse unit.
104A	4170	Setting value of current position compensation amount exceeded a range.	Please set the parameter setting value to more than 0 and less than 2147483647 in pulse unit.
104B	4171	Setting value of jog high speed exceeded a range.	Please set the parameter setting value to more than 0 and jog low speed, less than speed limitation.
104C	4172	Setting value of jog low speed exceeded a range.	Please set the parameter setting value to more than 0 and less than jog high speed and speed limitation.

Error code		Error Description	Solutions
Hex	Dec		
104D	4173	Setting value of jog acceleration exceeded a range.	Please set the parameter setting value over 0.
104E	4174	Setting value of jog deceleration exceeded a range.	Please set the parameter setting value over 0.
104F	4175	Setting value of jog jerk exceeded a range.	Please set the parameter setting value over 0.
1050	4176	Setting value of gear ratio(Motor) exceeded a range.	Please set the parameter setting value to 1~65535.
1051	4177	Setting value of gear ratio(Machine) exceeded a range.	Please set the parameter setting value to 1~65535.
1052	4178	Setting value of pulses per rotation exceeded a range.	Please set the parameter setting value to more than 0 and less than 4294967295 in pulse unit.
1055	4181	The speed command unit setting value exceeded the range.	Set the parameter setting value from '0: unit/sec', '1: rpm'.

(19) Servo On/Off related error information

Error code		Error Description	Solutions
Hex	Dec		
1060	4192	It is not possible to execute the servo on due to error occurrence of servo drive.	Please execute servo-on, after checking the error factor of the servo drive and removing the error of the servo drive.
1061	4193	It execute servo-on perform command again in the middle of processing servo-on.	Please check whether the servo-on command was not performed again in the middle of processing servo-on in program or XG-PM.
1062	4194	It is not possible to complete the servo-on because it can't change servo drive to "ReadyToSwitchON" status.	Please check the status of the servo drive. In certain circumstances, it may be servo-on command is not executed.
1063	4195	It is not possible to complete the servo-on because it can't change servo drive to "Switched on" status.	Please check the status of the servo drive. In certain circumstances, it may be servo-on command is not executed.
1064	4196	It is not possible to complete the servo-on because it can't change servo drive to "Operation enabled" status.	Please check the status of the servo drive. In certain circumstances, it may be servo-on command is not executed.
1065	4197	It is not possible to complete the servo-on because "Quick Stop" function of servo drive is enabled.	Please check the status of the servo drive. In certain circumstances, it may be servo-on command is not executed.
1066	4198	It execute servo-off perform command again in the middle of processing servo-off.	Please check whether the servo-off command was not performed again in the middle of processing servo-off in program or XG-PM.
1067	4199	The servo-off perform command was not completed.	Please check status of servo drive.
1068	4200	Servo off command is executed during operation and operation cannot continue.	Make the command axis servo on with the servo on command and execute the command again.
1069	4201	If the servo off command is executed and processed, no other operation command can be executed.	Make the command axis servo on with the servo on command and execute the command again.

## Appendix1 Error Information & Solution

### (20) Servo error reset related error information

Error code		Error Description	Solutions
Hex	Dec		
1070	4208	It exceeded the servo error reset monitoring time.	The error of the servo drive is not removed while error reset monitoring time which is set in axis parameter goes by. Please execute the error reset command again, after removing error factor of servo drive.

### (21) Position control operation related error information

Error code		Error Description	Solutions
Hex	Dec		
1080	4224	Command that use absolute coordinate can't be executed in absolute coordinate of the state of undetermined origin.	Please execute absolute coordinate operation command after making determined origin state with homing command and setting current position command.
1081	4225	In the state of Infinite running repeat enable, target position is beyond the range of infinite running repeat position from relevant direction appointment.	Please set target position within infinite running repeat position from relevant direction appointment.
1082	4226	SuperImposed command can not be performed if it is operated at a speed control or torque control.	SuperImposed command, please run in a state of not driving at a speed control or torque control.
1083	4227	SuperImposed halt instruction, it can not be performed in a state that does not SuperImposed operation.	SuperImposed halt command, please run in the state during SuperImposed operation.

### (22) Current position change related error information

Error code		Error Description	Solutions
Hex	Dec		
1090	4240	The position value of the current position change command exceeded a range.	Please execute preset current position preset command after setting position setting value to more than soft lower limit value of extended parameter and less than soft upper limit value.
1091	4241	In case it is operating with homing, speed synchronization, cam, torque control it is not possible to execute current position change command.	Please execute current position change command when relevant axis is not one during operation among homing, can, torque control.

### (23) Torque control related error information

Error code		Error Description	Solutions
Hex	Dec		
10A0	4256	The servo drive doesn't support the torque control mode.	By using the servo drive supporting the CST mode of EtherCAT CoE, Execute the torque control.
10A1	4257	There is no target torque object (0x6071) setting that can execute the torque control on RxPDO entry setting in slave data of the EtherCAT parameter.	Set the target torque object (0x6071) that supports torque control to the RxPDO entry of the EtherCAT parameter slave data in XG-PM, and then send it to the controller.

(24) Homing related error information

Error code		Error Description	Solutions
Hex	Dec		
10B0	4272	The servo drive doesn't support homing mode.	By using the servo drive which supports the CST mode of EtherCAT CoE, Execute homing.
10B1	4273	An error occurred during the execution of the homing of the servo drive.	Please execute homing, after checking the error factor of the servo drive and removing the error of the servo drive,
10B2	4274	During the axis operation , you will not be able to perform a origin return command.	Axis please re-execute the homing command in the Standstill state after shutdown.

(25) Override related error information

Error code		Error Description	Solutions
Hex	Dec		
10C0	4288	It is not possible to execute override command if it isn't operated in position/speed control.	Please execute the override command during operation with position control or speed control.
10C1	4289	The override Factor of override command exceeded range.	Please execute the override command after setting the VelFactor, AccFactor, JerkFactor value of override over 0.
10C2	4290	The operation speed value after applying Factor of override command exceeded maximum speed value.	Please execute override in the range that doesn't exceed the maximum speed value of the relevant axis.

(26) Gear operation related error information

Error code		Error Description	Solutions
Hex	Dec		
10D0	4304	The gear ratio denominator value can't become 0 in gear operation.	Please execute the command after setting the gear ratio denominator to a value not 0.
10D1	4305	The MasterValueSource setting value is out of range in gear operation.	Please execute the command after setting the gear ratio numerator to a value not 0.
10D2	4306	The Main axis setting is out of range in gear operation.	Please execute the command after setting the main axis in the range of 1~32, 37~42.
10D3	4307	The main axis setting is identical with the serve axis in gear operation.	Please execute command after setting the main axis to the different axis from serve axis(command axis).
10D4	4308	The main axis was not ready.	Please execute command when main axis is ready state.
10D5	4309	In case the gear operation main axis is set up as an encoder, You will not be able to execute the command with common parameter error occurrence.	By using XG-PM, set a common parameter to the normal value, after checking whether it was set up as the value in the range by confirming the encoder related item of common parameter.
10D6	4310	It is not possible to execute MC_GearInPos command when main axis is operated in the torque control..	Please execute the MC_GearInPos command when main axis is not operating in torque control.
10D7	4311	Serve axis speed of gear operation exceeded speed limitation.	Please lower main axis speed or change gear ratio lest serve axis in gear operation should exceed speed limitation or end point speed that was set on the serve axis.
10D8	4312	It is not possible to execute GEAROUT command if it is not gear operation.	GEAROUT command is available only in case of gear operation.

## Appendix1 Error Information & Solution

Error code		Error Description	Solutions
Hex	Dec		
10D9	4313	You will not be able to execute the command because target speed setting value of MC_GearInPos command is less than current operation speed or gear operation speed.	Please execute the command, after setting target speed setting value of MC_GearInPos command to more than current operation speed or gear operation speed.
10DA	4314	It will not be able to reach the serve axis synchronization position in the time when the main axis operates till the main axis synchronization position during MC_GearInPos operation.	Please execute the command, after increasing the setting value of the target speed of MC_GearInPos command or adjusting MasterStartDistance in order that serve axis moves till serve axis synchronization position in the time when main axis operates till the main axis synchronization position.
10DB	4315	If the main axis homing operation is running, synchronous operation (gears, cams, etc.) command can not be performed	Please run (gear, such as cam) synchronous operation command in a state in which the main axis is not homing operation.

### (27) Touch probe related error information

Error code		Error Description	Solutions
Hex	Dec		
10E0	4320	There is no object set which can execute relevant touch probe to PDO entry set in slave parameter.	Please send to the module, after setting the object to support the touch probe to PDO entry in slave parameter by XG-PM
10E1	4321	The TriggerInput input setting value is out of range.	Please set TriggerInput setting value to 0(Touch Probe1) or 1(Touch Probe2).

### (28) Parameter read/write

Error code		Error Description	Solutions
Hex	Dec		
10F0	4336	The parameter number setting value of command to read/write axis parameter is out of range.	Please execute command after setting parameter setting value of command to read/write axis parameter to 0~ 25.
10F1	4337	Parameter data setting value of command to write axis parameter is out of range.	Please check data setting range of axis parameter which want to set.
10F2	4338	The parameter cannot be changed because the maximum value of encoder 1 is out of the pulse unit expression value when the encoder parameter is changed.	Change the maximum value of encoder 1 in advance to prevent errors when converted in pulse unit, and then change the parameter.
10F3	4339	The parameter cannot be changed because the minimum value of encoder 1 is out of the pulse unit expression value when the encoder parameter is changed.	Change the minimum value of encoder 1 in advance to prevent errors when converted in pulse unit, and then change the parameter.
10F4	4340	The parameter cannot be changed because the maximum value of encoder 2 is out of the pulse unit expression value when the encoder parameter is changed.	Change the maximum value of encoder 2 in advance to prevent errors when converted in pulse unit, and then change the parameter.
10F5	4341	The parameter cannot be changed because the minimum value of encoder 2 is out of the pulse unit expression value when the encoder parameter is changed.	Change the minimum value of encoder 2 in advance to prevent errors when converted in pulse unit, and then change the parameter.

(29) JOG

Error code		Error Description	Solutions
Hex	Dec		
1100	4352	You can't execute jog operation command in case the axis is operating.	Please execute jog command when axis is stop state.

(30) Cam operation

Error code		Error Description	Solutions
Hex	Dec		
1110	4368	There is an error in the MasterScaling input value of CAM operation.	You can't put 0 in the MasterScaling input value.
1111	4369	There is an error in the MasterStartDistance input value of CAM operation.	Set the MasterStartDistance input value to more than 0 values and execute an command.
1112	4370	There is an error in the MasterSyncPosition input value of CAM operation.	Set the MasterSyncPosition input value to more than 0 values and execute a command.
1113	4371	The StartMode input value of CAM operation exceeded range.	Set the StartMode input value to the value between 0~1 and execute a command.
1114	4372	The MasterValueSource input value of CAM operation exceeded range.	Set the MasterValueSource input value to the value between 0~1 and execute a command.
1115	4373	The designated cam table doesn't exist.	Please execute command after adjusting the table number to the effective number.
1116	4374	The main axis setting of CAM operation exceeded range.	Set the main axis to the value between 1~32, 37~42 and execute a command.
1117	4375	The main axis setting of CAM operation is same as serve axis.	Please execute command after setting the main axis to the different axis from serve axis(command axis).
1118	4376	The main axis was not ready.	Please execute command when main axis is ready state.
1119	4377	In case the main axis is set up as an encoder, it can't execute command with common parameter error occurrence.	By using XG-PM, set a common parameter to the normal value, after checking whether it was set up as the value in the range by confirming the encoder related item of common parameter.
111A	4378	Servo speed of CAM operation exceeded speed limitation.	Please operate by decreasing the speed of the main axis or adjusting the CAM table lest speed of serve axis in CAM operating should exceed speed limitation which was set on the serve axis or end point speed.
111B	4379	It can't execute CAMOUT command in case it is not CAM operation.	You can use the CAMOUT command only if CAM is operating.
111C	4380	Setting value of the number of cam data of the cam data write command is out of range.	The setting range of the number of cam data of the cam data write command is more than 1, less or equal to 100.
111D	4381	Specified cam table data of the read command is abnormal.	Reconfigure the cam data, if this situation repeatedly occur, please replace the module.
111E	4382	Cam skip command can not be executed if you do not have a cam drive.	In the state in the cam operation, please run the cam skip command.
111F	4383	The number of skip cam cycle of cam skip command has been set to 0.	Please set the skip number cam cycle of cam skip command set larger than 0.
1121	4385	SkipMode is out of range.	Set the SkipMode to the value between 0~2 and execute a command.
1122	4386	The cam table is not registered.	Register the cam table or set the data again to execute the command.

## Appendix1 Error Information & Solution

1123	4387	The cam data of the cam data write command is abnormal.	Set the data of the cam data write command correctly.
1124	4388	The value of CAM master axis does not exist within the specified range.	Check the MasterStartPos and MasterEndPos value, and run the command again.
1125	4389	StartMode value is invalid.	Execute the command after changing the value of StartMode.
1170	4464	PartLength value is out of range.	PartLength is out of range.
1171	4465	Circumference value is out of range.	Circumference value cannot be set to a value less than 0.
1172	4466	CuttingStart(SealingStart) value is out of range.	CuttingStart(SealingStart) cannot be set smaller than 1/8 of the Circumference.
1173	4467	CuttingEnd(SealingEnd) value is out of range.	CuttingEnd(SealingEnd) cannot be set smaller than the CuttingStart(SealingStart) or greater than 7/8 of the circumference.
1174	4468	CuttingSpdRatio value is out of range.	CuttingSpdRatio(SealingSpdRatio) should be set between 50~200.
1175	4469	ZeroSpdRatio value is out of range.	ZeroSpdRatio should be set between 0~50.
1176	4470	CamType value is out of range.	Please execute command after Changing CamType value.
1177	4471	CamPointNum value is out of range.	Please execute command after Changing CamPointNum value.
1178	4472	CamCurve value is out of range.	Please execute command after Changing CamCurve value.
1179	4473	Difference between CuttingStart(SealingStart) and CuttingEnd(SealingEnd) is too long.	Please execute command after Changing CuttingStart(SealingStart), CuttingEnd(SealingEnd) or CuttingSpdRatio(SealingSpdRatio) Value.

### (31) Phase control

Error code		Error Description	Solutions
Hex	Dec		
1130	4400	If the phase correction command is not the InSync axis or InGear state of synchronous control (cam and gear drive) operation can not be performed.	Please run the phase correction command when the command axis is in the synchronous command state and InSync or InGear state.
1131	4401	There is an error in the axis setting of the phase correction command.	Please run the command, after setting the phase correction command main axis in the same as the actual main axis of the current synchronous operation.
1132	4402	Phase correction of the phase correction command is outside the range of positions represented.	The Phase correction amount range is more than -2147483648, less or equal to 2147483647 for the pulse unit.
1133	4403	Speed setting of the phase correction command is out of range.	The Phase correction command speed range is more than 0, less or equal to main axis speed limit.

### (32) Servo drive operation mode related error information

Error code		Error Description	Solutions
Hex	Dec		
1140	4416	The connected slave device does not support speed control mode.	Perform the velocity control by using the slave device that supports the velocity mode of the EtherCAT CoE.
1150	4432	The connected slave device does not support the position control mode.	Perform the position control by using the slave device that supports the CSP mode of the EtherCAT CoE.

Error code		Error Description	Solutions
Hex	Dec		
1151	4433	The mode of connected slave (0x6060, Mode Of Operation) timeout when requesting SDO read.	Check if the slave is in status for SDO service. Retry command, if the error repeats then, EtherCAT Disconnect – Reconnect EtherCAT using Connect command.
1152	4434	The mode of connected slave (0x6060, Mode Of Operation) failed to SDO read.	Check if the slave is in status for SDO service. Retry command, if the error repeats then, EtherCAT Disconnect – Reconnect EtherCAT using Connect command.

(33) Cyclic Synchronous Velocity (CSV)

Error code		Error Description	Solutions
Hex	Dec		
1160	4448	Connected slave device do not support cyclic synchronous velocity (CSV) mode.	Execute speed control by using slave devices that support cyclic synchronous velocity(CSV) mode of EtherCAT CoE.
1161	4449	The target speed object(0x60FF) that can execute cyclic synchronous velocity(CSV) mode is not configured in RxPDO entry setting in slave parameter.	Set the target speed object(0x60FF) that support cyclic synchronous velocity(CSV) mode to the RxPDO entry setting in EtherCAT parameter slave data in the XG-PM and send it to the controller.
1162	4450	CmdPosMode value exceeded the input range in cyclic synchronous velocity (CSV) mode.	CmdPosMode supports only 0(set current position to command position) value. Execute the command again after set CmdPosMode value to 0.
1180	4480	Since the servo drive does not support the synchronous speed control (CSV) mode, the designated speed operation command (MC_MoveVelocity) whose 'speed control operation mode' is CSV cannot be executed.	Perform speed control using a slave device that supports the synchronous speed control (CSV) mode of EtherCAT CoE.
1181	4481	MC_MoveVelocity whose 'Speed Control Operation Mode' is CSV cannot be executed because there is no object (0x60FF) setting that can execute Synchronous Speed Control (CSV) in the RxPDO entry setting of EtherCAT slave parameters.	Set the target speed object (0x60FF) that supports synchronous speed control (CSV) in the RxPDO entry of the EtherCAT parameter slave data and transfer it to the module.
1182	4482	Since the operation mode of the servo drive cannot be changed to the synchronous speed control (CSV) mode, the designated speed operation command (MC_MoveVelocity) whose 'speed control operation mode' is CSV cannot be executed.	Check if the servo drive supports EtherCAT CoE CSV mode and check the status of the servo drive.

(34) Servo drive input signal related error information

Error code		Error Description	Solutions
Hex	Dec		
1200	4608	The hardware upper limit error occurred.	Please remove error with error reset command after breaking away outside upper limit range by using reverse jog command.
1201	4609	The hardware lower limit error occurred.	Please remove error with error reset command after breaking away outside lower limit range by using forward jog command.
1203	4611	The command can't be executed because of servo drive error occurrence during operation.	Please remove servo error with error reset command after removing an servo error factor.



## Appendix1 Error Information & Solution

Error code		Error Description	Solutions
Hex	Dec		
1204	4612	The command can't be executed because of servo off during operation.	Please re-execute command after changing command axis to servo on state with servo on command.
1205	4613	The software upper limit error occurred.	Please remove error with error reset command after breaking away software upper limit range by using reverse jog command.
1206	4614	The software lower limit error occurred.	Please remove error with error reset command after breaking away software lower limit range by using forward jog command.

### (35) Read motion information

Error code		Error Description	Solutions
Hex	Dec		
1220	4640	The parameter number setting value of the read motion information command is out of range.	Please execute the command after setting parameter number setting value of motion read command in 0 ~ 5.

### (36) Network communication related error information

Error code		Error Description	Solutions
Hex	Dec		
1F00	7936	The periodic communication error occurred.(The communication error exceeding the parameter periodic communication time-out number occurred.)	Please check whether power of servo is off in communication, communication cable is normally installed and communication cable is exposed to noise.

### (37) Servo parameter write/save related error information

Error code		Error Description	Solutions
Hex	Dec		
1F10	7952	SDO command can't be executed any more because of SDO processing fail of servo drive that is executed previously.	Please reset connection after checking whether status of servo drive is normal.
1F11	7953	Writing SDO parameter command can't be executed during operation state.	Please execute command to write SDO parameter when relevant axis isn't operating.
1F12	7954	It is out of range from the value of which data range of the SDO parameter Index, SubIndex and etc. is allowed.	Please execute writing SDO parameter after set SDO parameter Index to 0x0000~0x9FFF, SubIndex to 0x00~0xFF, data size within 4 bytes.
1F13	7955	Abort occurred in the middle of command to write SDO parameter.	It canceled in the middle of writing SDO parameter in servo drive. Please check status of servo drive.
1F14	7956	There is no response of the servo drive about the command to write SDO parameter.	There is no response of servo drive in the middle of writing SDO parameter. Please check status of servo drive.
1F15	7957	SDO parameter write cannot be completed because EtherCAT connection is disconnected while executing SDO parameter write command.	Execute the EtherCAT connection command to enter the EtherCAT cyclic communication status, then execute the command again.
1F16	7958	Abort occurred in the middle of save SDO parameter EEPROM.	It canceled in the middle of saving SDO parameter EEPROM. Please check status of servo drive.
1F17	7959	There is no response of the servo drive about the command to save SDO parameter EEPROM.	There is no response of servo drive in the middle of saving SDO parameter EEPROM. Please check status of servo drive.

Error code		Error Description	Solutions
Hex	Dec		
1F18	7960	SDO parameter EEPROM saving cannot be completed because the EtherCAT connection is disconnected while executing the SDO parameter EEPROM save command.	Execute the EtherCAT connection command to enter the EtherCAT cyclic communication status, then execute the command again.
1F19	7961	It can't execute the other command in the middle of write SDO parameter or save SDO parameter EEPROM.	Please execute other command after saving SDO parameter EEPROM is completed.
1F1A	7962	There is no response from the slave device to the request to write the SDO parameter of XG-PM.	Please reset the SDO processing error with 'Axis error reset' or 'Common error reset' and execute the command again.

(38) Servo parameter read command related error information

Error code		Error Description	Solutions
Hex	Dec		
1F19	7968	The Abort occurred in the middle of command to read the servo parameter.	It canceled in the middle of reading servo parameter in servo drive. Please check state of servo drive.
1F20	7969	There is no response of the servo drive about the command to read servo parameter.	There is no response in the middle of reading servo parameter in servo drive. Please check state of servo drive.
1F22	7970	It can't execute the command to read/write servo parameter in the middle of command to read/write servo parameter.	Please execute the command after the parameter reading which is being performed is completed.
1F23	7971	SDO parameter reading cannot be completed because EtherCAT connection is disconnected while executing SDO parameter read command.	Execute the EtherCAT connection command to enter the EtherCAT cyclic communication status, then execute the command again.
1F24	7972	There is no response from the slave device to the request to write the SDO parameter of XG-PM.	Please reset the SDO processing error with 'Axis error reset' or 'Common error reset' and execute the command again.

(39) EtherCAT state change related error information

Error code		Error Description	Solutions
Hex	Dec		
1F33	7987	It couldn't change the operation mode of servo drive to the position control(CSP) mode.	Please check state of servo drive, after checking that relevant servo drive supports EtherCAT CoE CSP Mode.
1F34	7988	It couldn't change the operation mode of servo drive to the homing(Homing) mode.	Please check state of servo drive, after checking that relevant servo drive supports EtherCAT CoE Homing Mode.
1F35	7989	It couldn't change the operation mode of servo drive to the torque control(CST) mode.	Please check state of servo drive, after checking that relevant servo drive supports EtherCAT CoE CST Mode.
1F36	7990	It failed to change the operation mode of the servo drive to the speed control (CSV) mode.	Confirm whether the servo drive supports the EtherCAT CoE CSV mode and check the status of the servo drive.

(40) Manual tuning related error information

Error code		Error Description	Solutions
Hex	Dec		
1F50	8016	It can't execute manual <b>tuning</b> function of XG-PM in case that module is the RUN state.	Please execute manual <b>tuning</b> of XG-PM after changing module to STOP state.

## Appendix1 Error Information & Solution

### (41) Axis group common related error information

Error code		Error Description	Solutions
Hex	Dec		
2000	8192	The axis group didn't become the operation ready state.	Please execute command when axis group is operation ready state.
2001	8193	The axis group can't be executed in "Disabled" state.	Please execute command in the condition that can operate the relevant command after checking the axis group condition that can operate the relevant command.
2002	8194	The axis group can't be executed in "Standby" state.	Please execute command in the condition that can operate the relevant command after checking the axis group condition that can operate the relevant command.
2003	8195	The axis group can't be executed in "Moving" state.	Please execute command in the condition that can operate the relevant command after checking the axis group condition that can operate the relevant command.
2004	8196	The axis group can't be executed in "Homing" state.	Please execute command in the condition that can operate the relevant command after checking the axis group condition that can operate the relevant command.
2005	8197	The axis group can't be executed in "Stopping" state.	Please execute command in the condition that can operate the relevant command after checking the axis group condition that can operate the relevant command.
2006	8198	The axis group can't be executed in "Errorstop" state.	Please execute command in the condition that can operate the relevant command after checking the axis group condition that can operate the relevant command.
2007	8199	The configuration axis of the axis group is not servo on state.	Please execute command in the condition that can operate the relevant command after checking the axis group condition that can operate the relevant command.

### (42) Axis group function block execution related error information

Error code		Error Description	Solutions
Hex	Dec		
2010	8208	It can't continue a operation because a module is changed to STOP state	Please check whether module was not changed to STOP state while the axis operates.
2011	8209	It can't continue a operation because the network is disconnected.	Please check network disconnection because of slave power disorder, network cable disorder, noise inflow to the network cable while the axis operates.
2012	8210	The position setting value of the command is out of range from pulse unit representation value.	When converting the command position value to the pulse unit, It is out of range from 32 Bit domains. When converting the command position value into the pulse, Please set in - 2147483648 ~ 2147483647 ranges.
2013	8211	The operation speed value was 0 or less, or exceeded the maximum speed value.	Please set the operation speed value to the bigger value than 0, or smaller than or equal to the maximum speed value which is set up in the relevant axis group.
2014	8212	The acceleration was set up as the negative number.	Please set the acceleration value to more than 0.
2015	8213	The deceleration was set up as the negative number.	Please set the deceleration value to more than 0.
2016	8214	The jerk was set up as the negative number.	Please set the jerk value to more than 0.

Error code		Error Description	Solutions
Hex	Dec		
201A	8218	Buffer Mode setting value exceeded a range.	Please set the value which can be set(0~5) in the Buffer Mode.
201B	8219	Execution Mode setting value exceeded a input range.	Please set the value which can be set(0~1) in Execution Mode.
201C	8220	Transition Mode setting value exceeded a range.	Please set the value which can be set(0~1) in Transition Mode in relevant command.
201D	8221	Transition parameter setting value exceeded a range.	Please set the value which can be se in Transition Parameter in relevant command.
201E	8222	The axis group operation was stopped due to the error occurrence of axis group configuration axis.	Please execute command after removing an error factor and removing an error with the axis or the axis group error reset command.
201F	8223	The command position value transmitted to the servo drive is out of range from the pulse unit representation value.	When converting the command position value to the pulse unit, It is out of range from 32 Bit domains. When converting the command position value into the pulse, Please set in - 2147483648 ~ 2147483647 ranges.

(43) Axis group function block related error information

Error code		Error Description	Solutions
Hex	Dec		
2020	8224	It is undefined the axis group command.	The relevant command is not performed in the current version of the module. Please contact customer support team of our company after check the version in which the relevant command can be performed.
2021	8225	The executed command was canceled because same command was executed.	Please check whether the relevant command was not again performed among the same command operation.
2022	8226	It exceeded the number of commands which can operate Buffered command.	You can't perform a command because the command buffer of the relevant axis group is full. The number of commands which can be operated with Buffered command is 10. Please control the command operation timing.

(44) Axis group parameter write related error information

Error code		Error Description	Solutions
Hex	Dec		
2030	8240	You can't write the axis group parameter in case the axis group is operating.	Please execute writing parameter when the axis group is not operating.

(45) Axis group parameter data related error information

Error code		Error Description	Solutions
Hex	Dec		
2040	8256	Data of axis group parameter is abnormal.	Please exchange module, if an error happens again after downloading the data in XG-PM again and reloading.
2041	8257	It is not possible to execute operation because of parameter error of axis group.	Please set again after confirming parameter of axis group
2042	8258	You can't set speed limit of axis group parameter to the value less than 0.	Please set the speed limitation over 1 in pulse unit.
2043	8259	Configuration axis number setting value of axis group parameter exceeded a range.	Please set configuration axis of axis group within 1~32, 37~40 range.

## Appendix1 Error Information & Solution

### (46) Axis group Add/Remove command related error information

Error code		Error Description	Solutions
Hex	Dec		
2051	8273	The axis which you are going to add is already registered in the axis group.	Please set another group after checking whether the axis number is in the relevant axis group.
2052	8274	Now, Axis group is active and the axis which you are going to add is already included in the other activated axis group.	Please execute command after changing the activated axis group in which the relevant axis is included to GroupDisabled status.
2053	8275	The IdentInGroup setting value of axis group add/remove command exceeded a range.	Please set IdentInGroup setting value to range of 1~4.

### (47) Axis group Enable/Disable command related error information

Error code		Error Description	Solutions
Hex	Dec		
2060	8288	There are not axis setting at designed axis group of axis group enable/disable command.	Please execute command after setting axis at least 1 at relevant axis group.
2061	8289	It can't enable axis group because there are axis during operation among current configuration axis of axis group.	Please execute command when it isn't operating all axis belongs to a relevant axis group.
2062	8290	It can't be activate axis group specified because configuration of current axis group is added at another activated axis group.	Please check that axis belongs to a group of the relevant axis group is not added at another axis group activated.
2063	8291	It can't be enabled axis group because unit of axis group configuration axis is different from each other.	Please set same unit of configuration axis belongs to axis group.
2064	8292	The axis group can't be enabled activate because parameter disorder of axis group configuration axis.	Please set parameter of configuration belongs to axis group within normal range.
2065	8293	The axis group cannot be enabled because the speed command units of the axis group configuration axes are different from each other.	Set the same speed command unit for the configuration axes belonging to the axis group.
2066	8294	The axis group cannot be enabled because there is an axis whose speed command unit is rpm among the axis group configuration axes.	The speed command unit of the configuration axes belonging to the axis group cannot be set to rpm. Set it to a value other than rpm.
2067	8295	The coordinate system operation cannot be executed because the unit of the axis group configuration axes is different from the coordinate type.	Set the unit of the configuration axis belonging to the axis group to match the coordinate system type in order to execute the command.

### (48) Axis group homing command related error information

Error code		Error Description	Solutions
Hex	Dec		
2070	8304	The servo drive of configuration axis not support homing mode.	After confirm that relevant servo drive supports EtherCAT CoE CSP mode, confirm servo drive status.
2071	8305	There is axis that is not completed homing normally among configuration axis.	Please execute again after confirm error code of configuration axis and eliminate error factor of relevant axis.
2072	8306	It is not possible to execute axis group homing command if axis group is during operation.	Please execute again homing command in GroupStandby state after axis group stop operation.

(49) Axis group current position setting command related error information

Error code		Error Description	Solutions
Hex	Dec		
2080	8320	There is axis with error among configuration axis in setting current position.	Please execute again after confirm error code of configuration axis and eliminate error factor of relevant axis.

(50) Linear interpolation command related error information

Error code		Error Description	Solutions
Hex	Dec		
2090	8336	It is not possible to execute absolute coordinate linear interpolation command if configuration axis is undetermined origin state.	Please execute command after making determined origin state with homing command and setting current position command.
2091	8337	It exceeded speed limit value of the configuration axis of linear interpolation.	Please execute the command at a lower command speed so as not to exceed the speed limit of the configuration axis.
2092	8338	In case of specified corner distance transition, It is not possible to execute transition operation because moving distance to target distance is bigger than corner distance designation value.	Please set corner distance value at transition parameter to smaller than moving distance to target position
2093	8339	In case of specified corner distance transition, It is not possible to execute transition operation because inserted circular radius exceeds 2147483647pulse.	Please reset target position in order that two lines not located in a straight line, or execute linear interpolation after changing transition mode.
2094	8340	You can't execute linear interpolation when infinite running repeat of main axis and serve axis is "Enable" status.	Please execute command after changing infinite running repeat of main axis and serve axis to "0: Disable".

(51) Circular interpolation command related error information

Error code		Error Description	Solutions
Hex	Dec		
20A0	8352	It is not possible to execute circular interpolation command if configuration axis is undetermined origin state.	Please execute command after making determined origin state with homing command and setting current position command.
20A1	8353	The mode setting value of circular interpolation exceeded a range.	Please set Mode setting of circular interpolation to 0~2(0: serve point, 1: center point, 2: radius)
20A2	8354	The setting value of circular interpolation pass selecting exceeded a range.	Please set pass select setting of circular interpolation to 0~1(0: CW, 1: CCW)
20A3	8355	The radius setting exceeded a range in circular interpolation radius method.	Please set radius setting value of main operation date in circular interpolation to half of the length from the starting point to the end to be more than 80%.
20A4	8356	You can't execute operation if 'starting point =center point(midpoint) or center point(midpoint)=end point' in circular interpolation.	Please execute circular interpolation after setting center point(midpoint) to another location with starting point(or end point).
20A5	8357	For midpoint( or radius) method, Starting point and end point can't be the same in circular interpolation.	If you set circular interpolation to center point(or radius), please execute circular interpolation after setting starting point to another location with end point.

## Appendix1 Error Information & Solution

Error code		Error Description	Solutions
Hex	Dec		
20A6	8358	It is radius error in circular interpolation.	Radius of the circle that Circular interpolation operation can be performed is more than 0 and less than 2147483647pulse. Please execute command after setting input value that can be calculated within setting range.
20A7	8359	It is not possible to execute operation because linear profile occurred in circular interpolation.	For using midpoint method, Please execute circular interpolation after changing that the midpoint of the starting point and end point isn't located on a straight line.
20A8	8360	You can't execute circular interpolation when infinite running repeat of main axis and serve axis is "Enable" status	Please execute command after changing infinite running repeat of main axis and serve axis to "0: Disable".
20A9	8361	You can't circular interpolation if there are 4 configuration axis number of axis group.	Please set up axis group as 2axis in circular interpolation, 3axis in helical interpolation.
20AA	8362	When it is not composed of axis configuration of axis group in regular sequence, you don't execute circular interpolation.	For circular interpolation, Please set configuration axis in regular sequence.
20AB	8363	It exceeded speed limitation of the configuration axis of circular interpolation.	Please execute the command at a lower command speed so as not to exceed the speed limitation of the configuration axis.
20AC	8364	For midpoint( or radius) method, Starting point and mid point must be on the same XY plane.	If you set circular interpolation to center point(or radius), please execute circular interpolation after setting mid point(or center point) to same XY Plane as the starting point.

### (52) Coordinate system operation parameter

Error code		Error Description	Solutions
Hex	Dec		
20B0	8368	The coordinate parameter data is abnormal.	Please exchange module, if an error happens again after downloading the data in XG-PM again and reloading.
20B1	8369	It is not possible to execute operation because of coordinate parameter error.	Please set again after confirming coordinate parameter

### (53) Coordinate system operation parameter

Error code		Error Description	Solutions
Hex	Dec		
20C0	8384	Command that use absolute coordinate can't be executed in absolute coordinate of the state of undetermined origin.	Please execute absolute coordinate operation command after making determined origin state with homing command and setting current position command.
20C1	8385	There is an error in the PCS of axis group parameter.	Please set again to confirm the configuration parameters of the PCS
20C2	8386	There is an error in the COORDINATETYPE of axis group parameter.	Please set again after confirming the COORDINATETYPE parameters .
20C3	8387	There is an error in the COORDINATEPARAM of axis group parameter.	Please set again after confirming the COORDINATEPARAM parameters .
20C4	8388	There is an error in the WORKSPACETYPE of axis group parameter.	Please set again after confirming the WORKSPACETYPE parameters .
20C5	8389	There is an error in the WORKSPACEPARAM of axis group parameter.	Please set again after confirming the WORKSPACEPARAM parameters .

Error code		Error Description	Solutions
Hex	Dec		
20C6	8390	The location is not possible to start the coordinate operation.	Please execute the command after it has been moved to a position where it can start operation .
20C7	8391	The target position can not be reached in the coordinate operation .	Please set again to check if there is any abnormality in the target position .
20C8	8392	Target position does not exist in the workspace area	Please set again to check if there is any abnormality in the target position .
20C9	8393	It can't be enabled axis group because unit of axis group configuration is different from COORDINATETYPE.	Please set unit configuration of axis so as to coincide with COORDINATETYPE.
20CA	8394	It exceeded speed limit value of axis group configuration.	Please execute the command at a lower command speed so as not to exceed the speed limit of the axis group.
20CB	8395	You can't execute this command when infinite running repeat of main axis and serve axis is "Enable" status.	Please execute command after changing infinite running repeat of axis to "0: Disable".
20CC	8396	This operation doesn't support this CoordSystem.	Please execute the command after setting a CoordSystem system that supports.
20CD	8397	This operation doesn't support this Acceleration Type.	Please execute the command after setting a TrajType that supports.

(54) Conveyor belt synchronization function

Error code		Error Description	Solutions
Hex	Dec		
20D0	8400	The conveyorbelt axis setting exceeded range.	Set the conveyorbelt axis to the value between 1~32 and execute a command.
20D1	8401	Conveyor axis is duplicated with the axis group.	Please execute the command in the state of setting the conveyor axis another axis .
20D2	8402	The unit setting of conveyorbelt axis exceeded range.	Set the unit of conveyorbelt axis to mm or inch.
20D3	8403	conveyorbelt axis is not ready for operation. (Not connected to the network.)	Please execute command when conveyorbelt axis is ready for operation.
20D4	8404	If the conveyorbelt axis homing operation is running, conveyorbelt synchronous operation command can not be performed.	Please run conveyorbelt synchronous operation command in a state in which the conveyorbelt axis is not homing operation.
20D5	8405	If the conveyorbelt axis torque control operation is running, conveyorbelt synchronous operation command can not be performed	Please run conveyorbelt synchronous operation command in a state in which the conveyorbelt axis is not torque control operation.
20D6	8406	You can't execute this command when infinite running repeat of conveyorbelt axis is "Disable" status	Please execute command after changing infinite running repeat of conveyorbelt axis to "1: Enable".



## Appendix 2 Setting Example

It describes how to set when using the motion control module at the beginning.

- (1) Install the servo driver.  
Connect the power and motor to the servo driver and connect external signal as necessary.
- (2) Install PLC.  
Install PLC and mount the motion control module. And at the beginning of test-run, for safety's sake, make sure PLC CPU is STOP mode.
- (3) Connect the motion control module and servo driver.  
Connect the motion control module and first servo driver by using Ethernet cable. And connect other servo drivers. At this time, check the I/O direction of communication port of the servo driver distinctly. Below is a list of servo drive which fundamentally has network setting information in the connection and module when servo drive and EtherCAT I/O are connected to Motion control module.



Verdor	Applicable servo drive
LS Mecapion	APD-L7N
Beckhoff Automation GmbH	AX2000-B110 EtherCAT Drive
Danaher Motion GmbH (KOLLMORGEN)	S300/S400/S600/S700 EtherCAT Drive AKD EtherCAT Drive(CoE)
Sanyodenki Co., Ltd	R ADVANCED MODEL with EtherCAT Coe Interface
Yaskawa Electric Corporation	SGDV-E1 EtherCAT(CoE) SERVOPACK Rev1, Rev2, Rev3

**Notes**

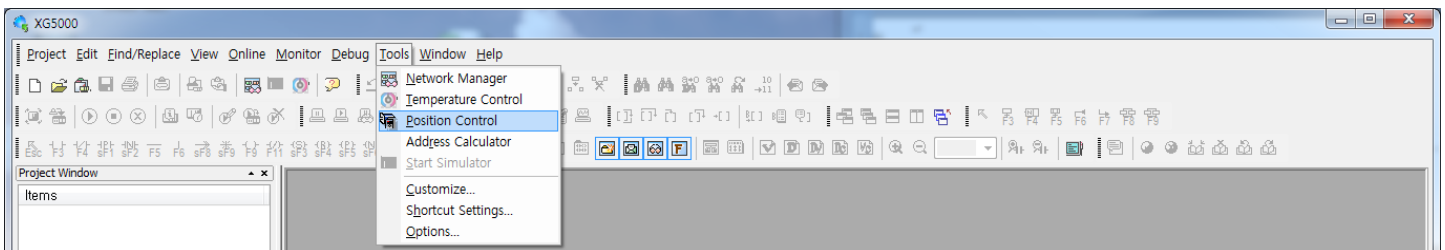
When the installation of servo drive has completed, make sure to check the following points by using dedicated setting TOOL provided by the servo drive manufacturer; failure to meet the standards requires reset to meet the actual user condition.

1. Power supply  
Check if the power connected to servo drive and the allowable power conditions are the same.  
(There are instances where no power setting is in parameter depending on the type of servo drive.)
2. The type of motor and encoder(feedback)  
Set the parameter according to the type of encoder and motor connected to actual servo drive.)
3. Command position unit setting  
If it is possible to set the command position unit by servo drive parameter, make sure to set it by pulse unit (Inc. or Counts), and set the encoder resolution value per motor rotation according to the bit number of encoder used.  
(There are instances where no separate setting item exists depending on the type of servo drive.)

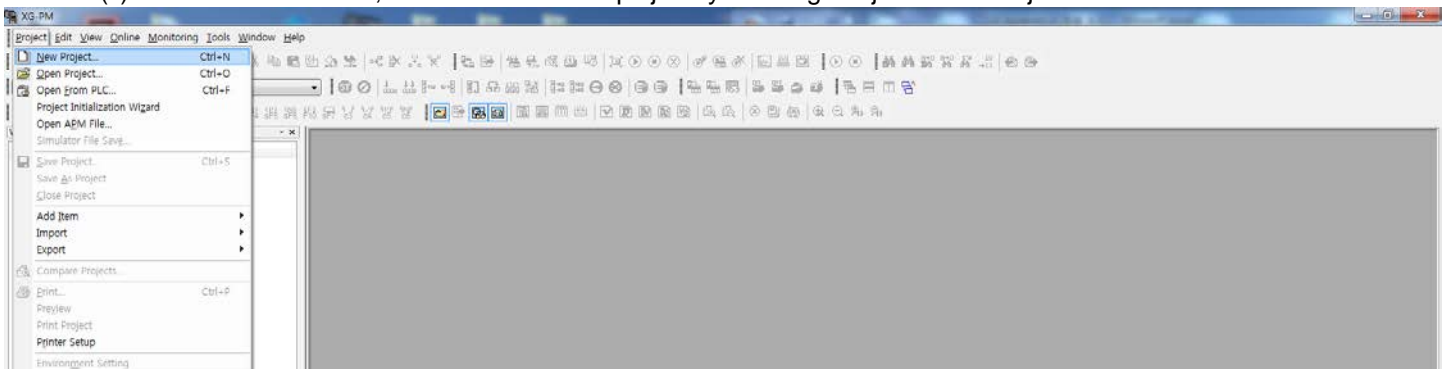
(4) Install XG5000 at the PC.

(5) Execute XG5000 and XG-PM by selecting “Tools – Position control”.

(XG-PM is used to set or monitor the program & operation parameter of initial motion control module and the parameter of servo drive.)

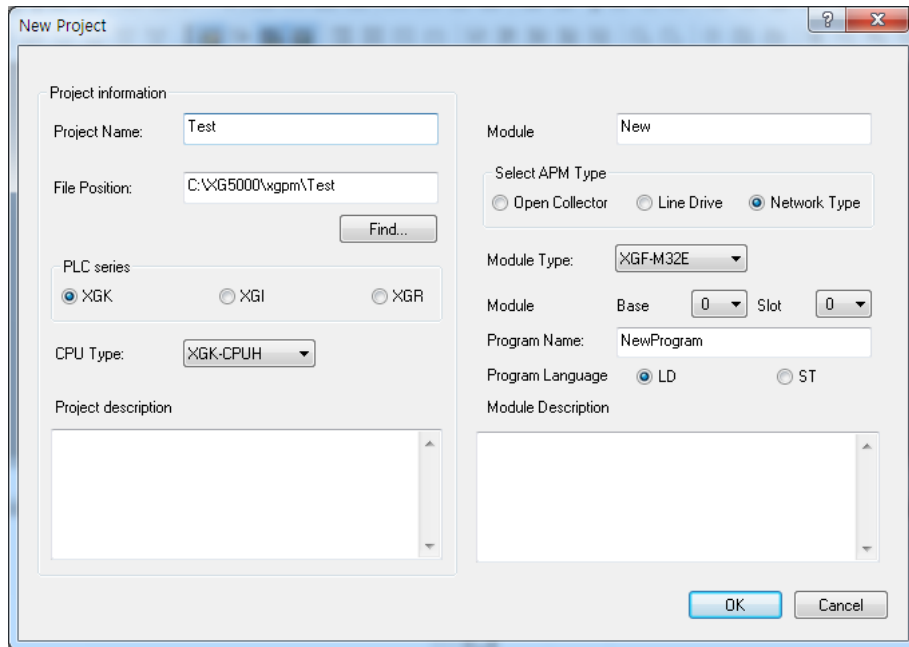


(6) If XG-PM is executed, create motion control project by selecting “Project – New Project”.

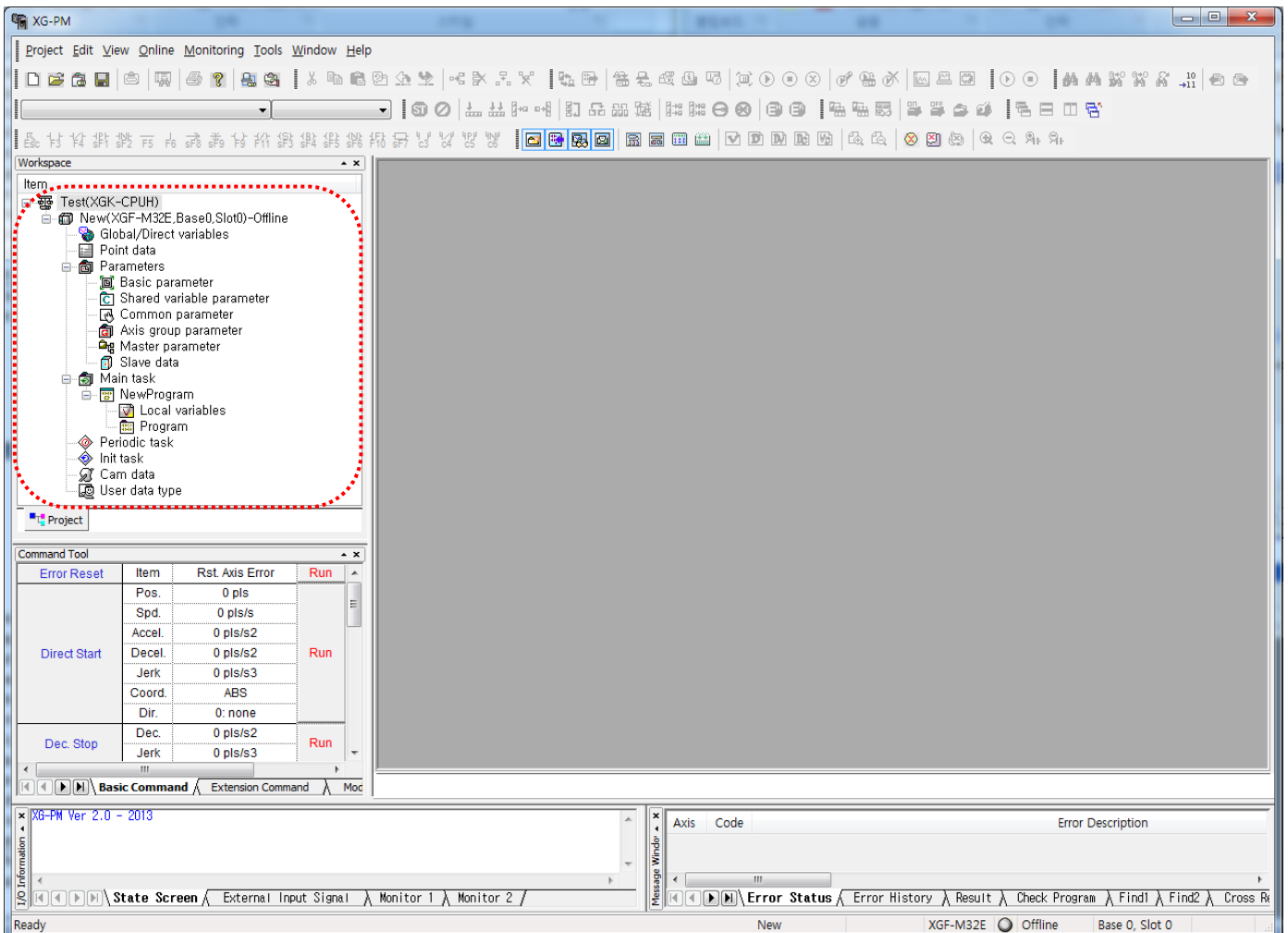


## Appendix2 Setting Example

- (7) In the figure below, set up Project name, PLC series, CPU type, Module name, Module type, Module position to create new project.

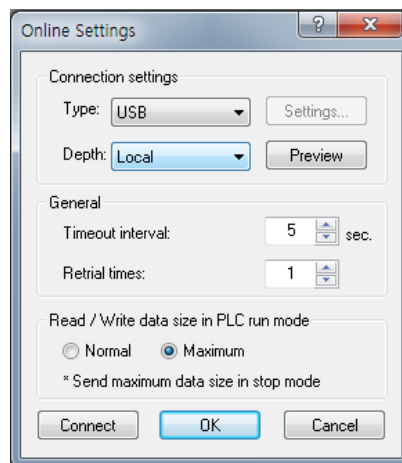
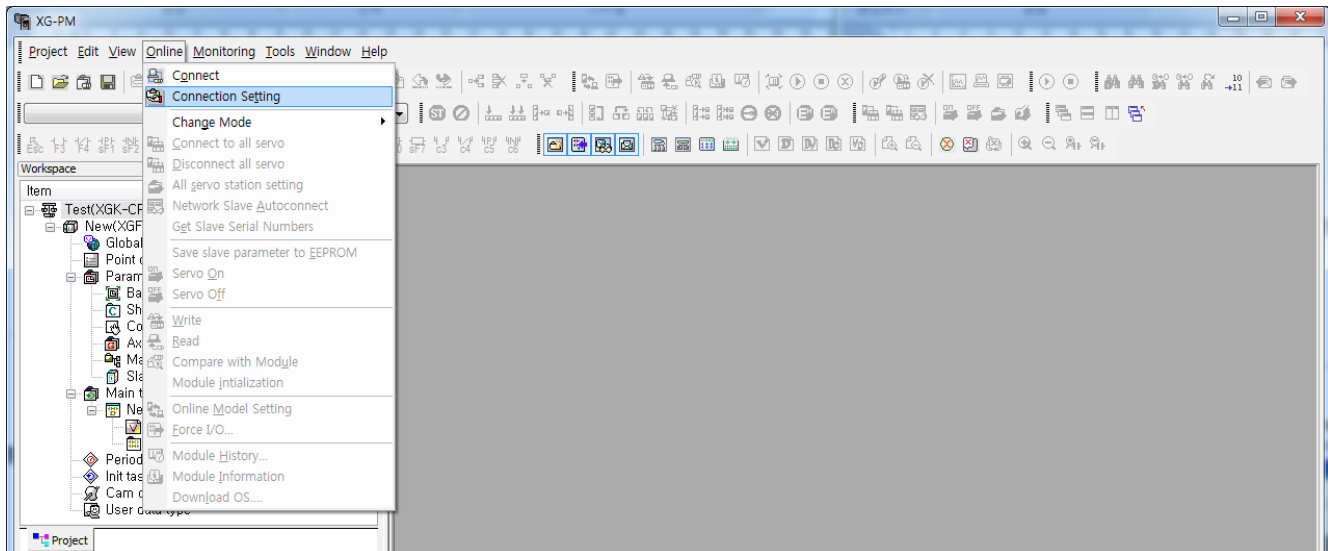


- (8) If you set up as the figure above, the project will be created as follows.



(9) Turn on PLC and servo driver and connect PC with PLC CPU through USB or RS-232C cable.

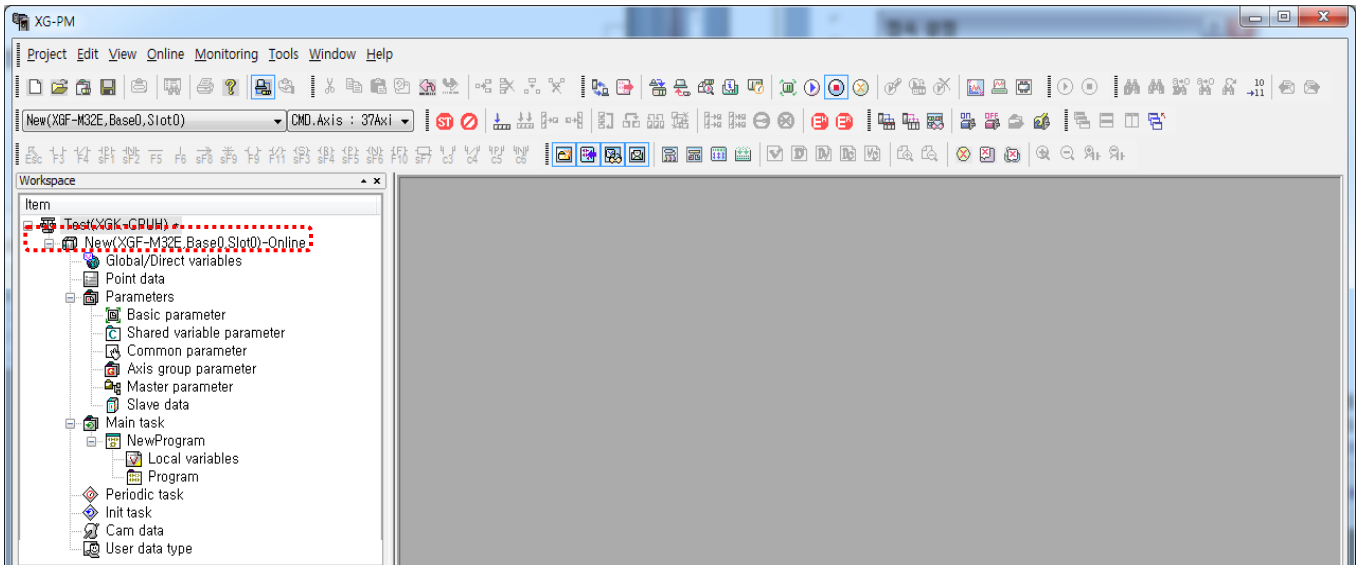
(10) Select “Online- Connection Setting” and set up connection settings.



(11) Select “Online-Connect” to connect PC with PLC CPU.

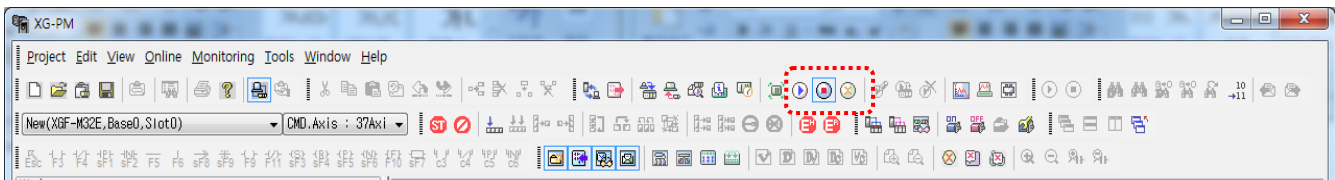
## Appendix2 Setting Example

(12) If connection is complete, the module will be shown in 'Online' as follows.



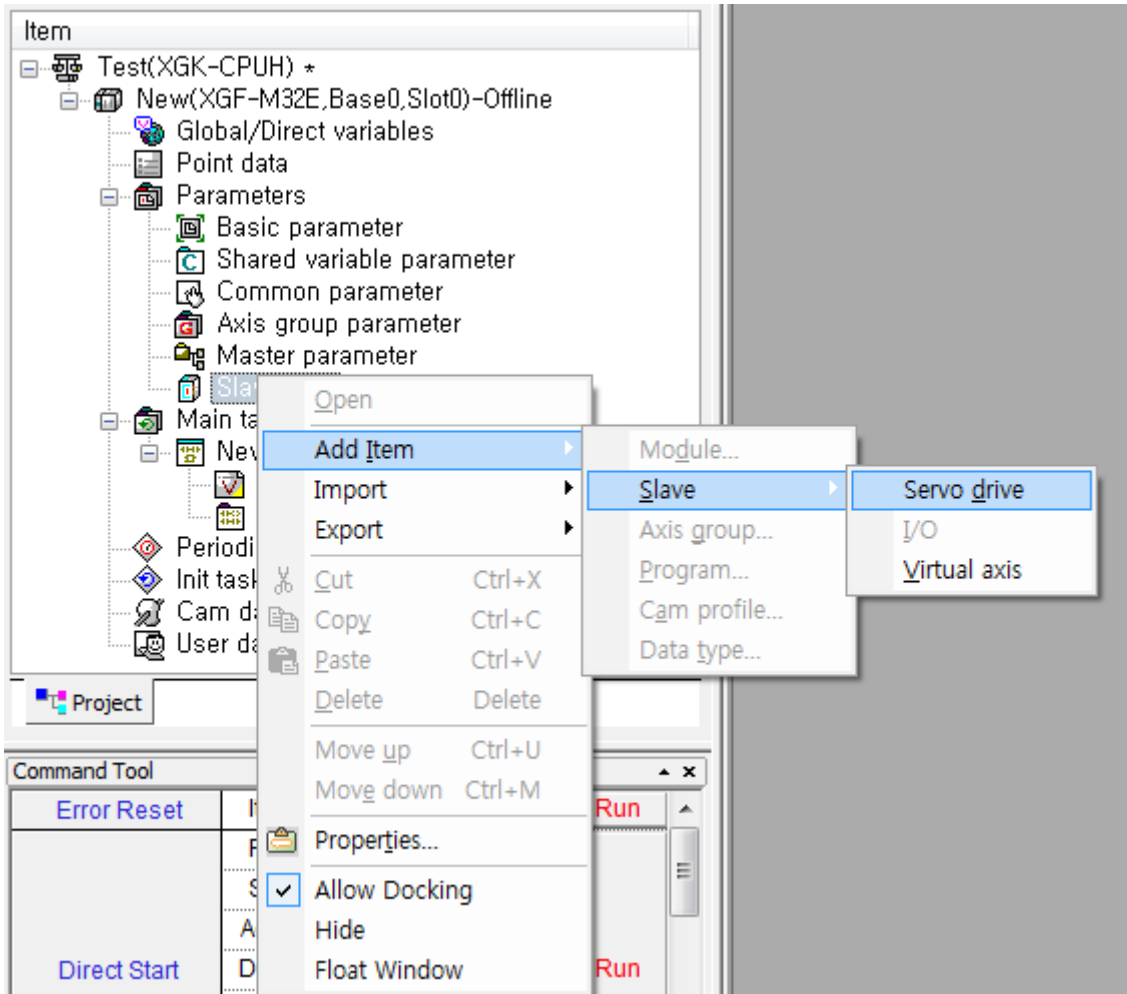
(13) If the module doesn't become "Online" and keeps "Offline", check whether the module is mounted, position or type is correct.

(14) Check if motion control module is in STOP state. If motion control module is in RUN state, change it to STOP state and execute the next steps.

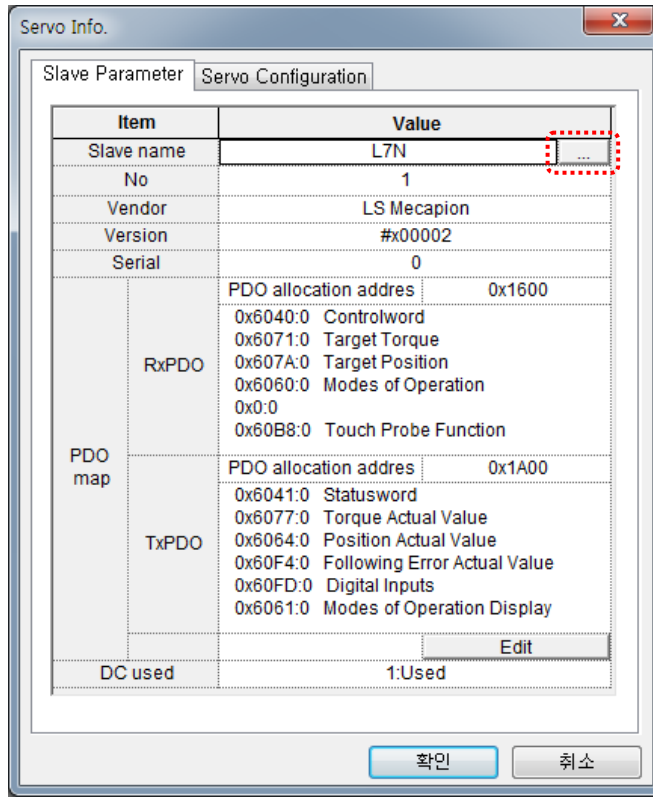


(15) Writing must be executed in the motion control module after setting the servo drive actually connected to the network parameter in order to execute the connection with servo drive. First, check if the relevant module is in off-line state to set network parameter. If it is in on-line state, execute "Online -Disconnect" to change it to off-line state.

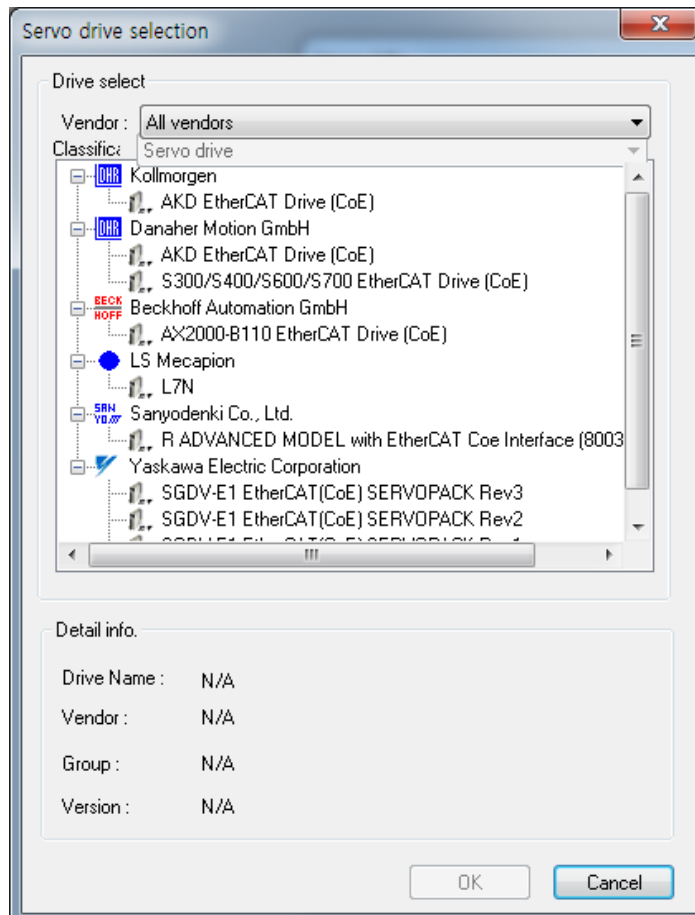
- (16) Right click on a mouse in the slave parameter of the project tree and select "Add item – Slave-servo drive" in order to add servo drive to network parameter.



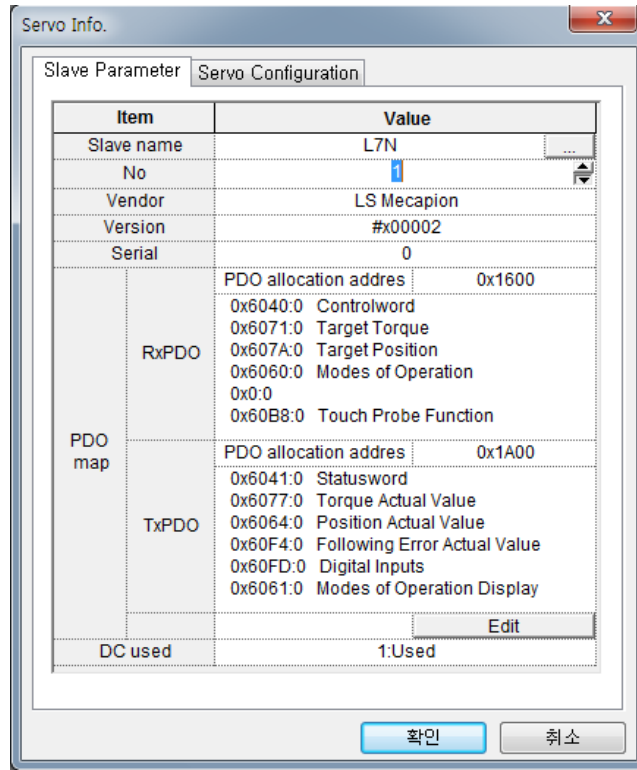
(17) When the slave information window comes up, click the“...” button next to the slave name.



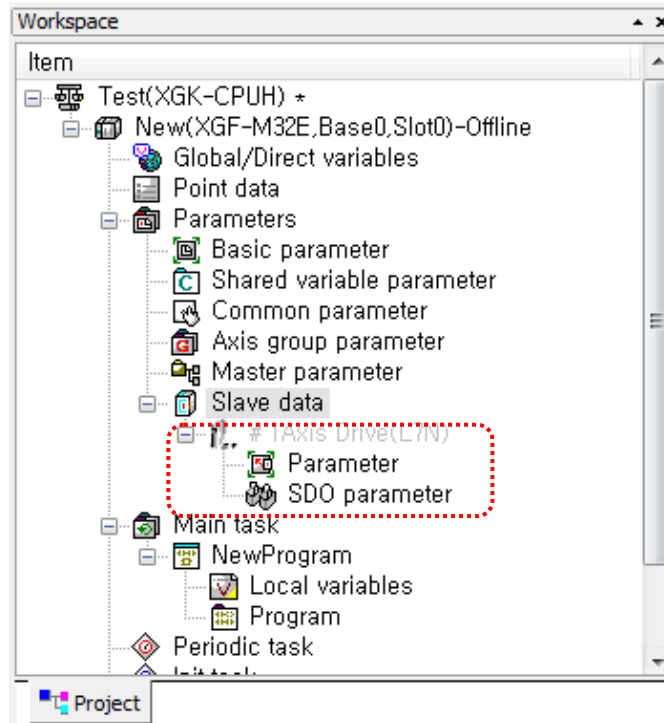
(18) Select the servo drive connected first to motion control module in the servo drive selection window and click OK.



- (19) Set the axis number of servo drive which was selected in the slave information window. Connection order is not associated with the axis number. The axis number set here becomes the command axis of command/function block when making motion program.



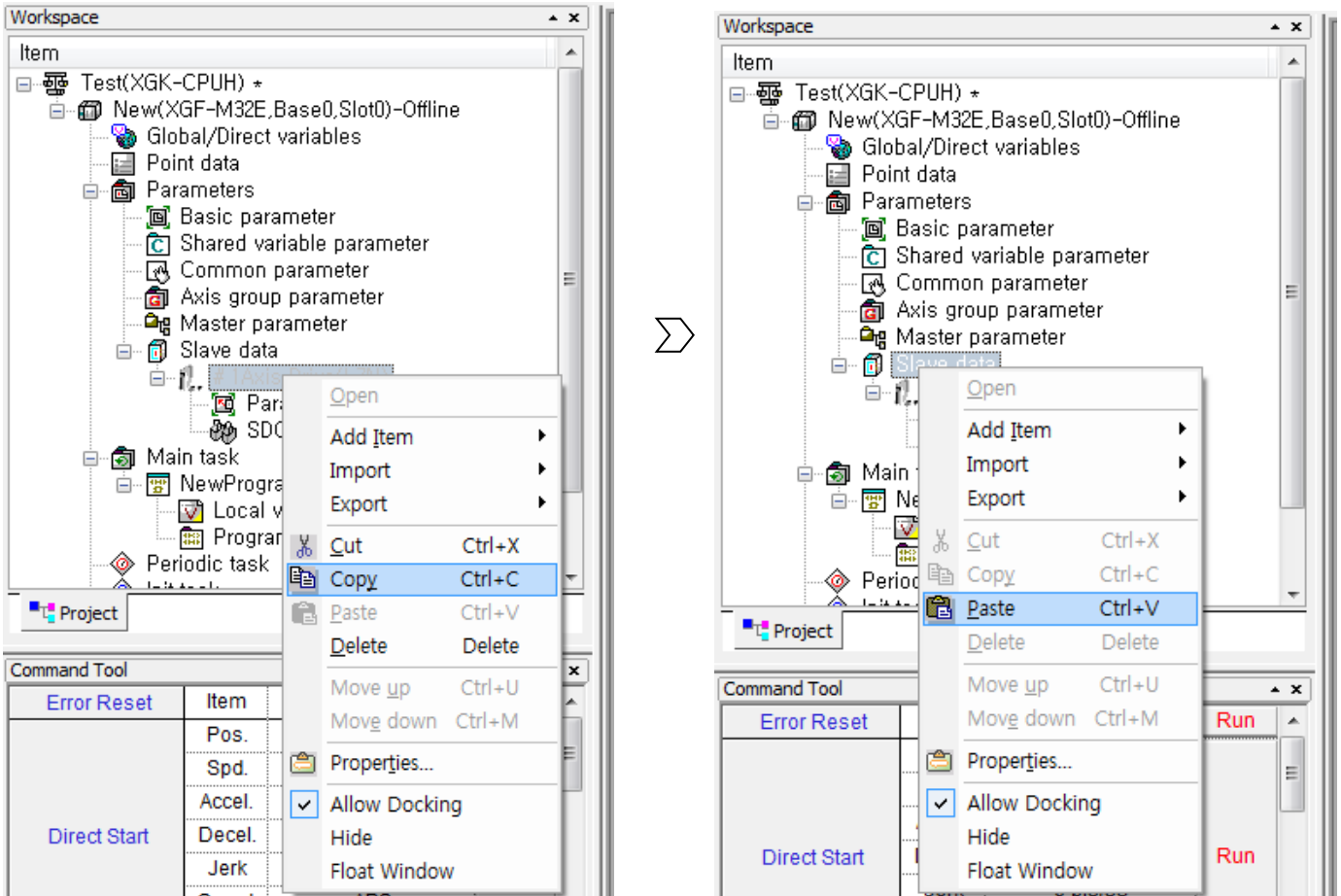
- (20) When the axis number setting is completed, the servo drive added earlier is indicated in network parameter.



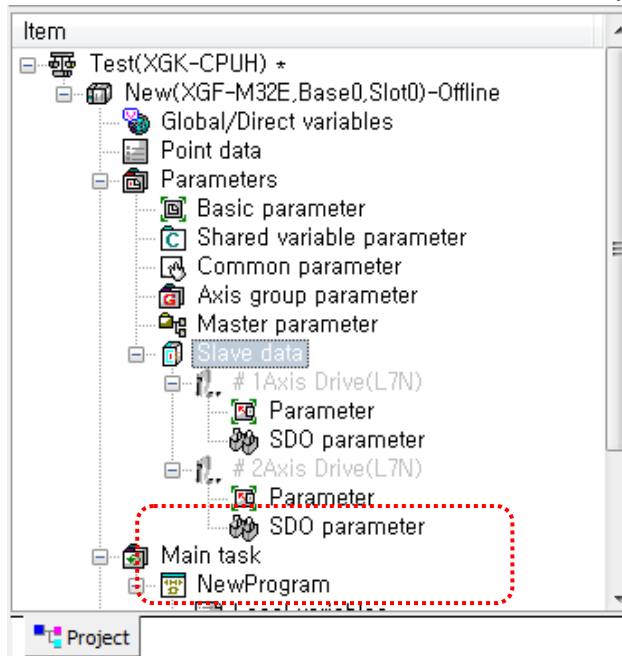


**Notes**

When the types of drive connected to network are the same, "Copy" and "Paste" can be used. While the first drive is added, select the "Copy(C)" menu as follows and right click on a mouse in network parameter to execute "Paste".

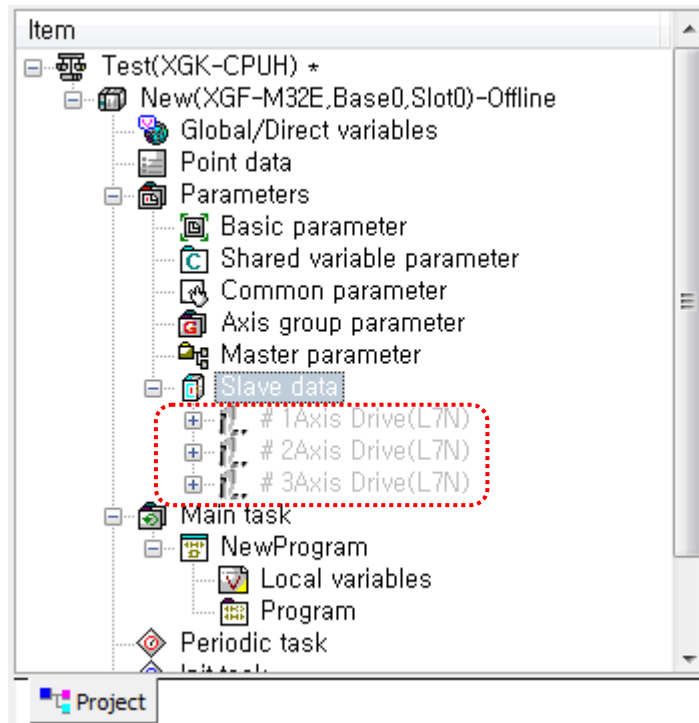


When executing as above, the identical servo drive of which the axis number has increased by 1 is added to slave parameter.



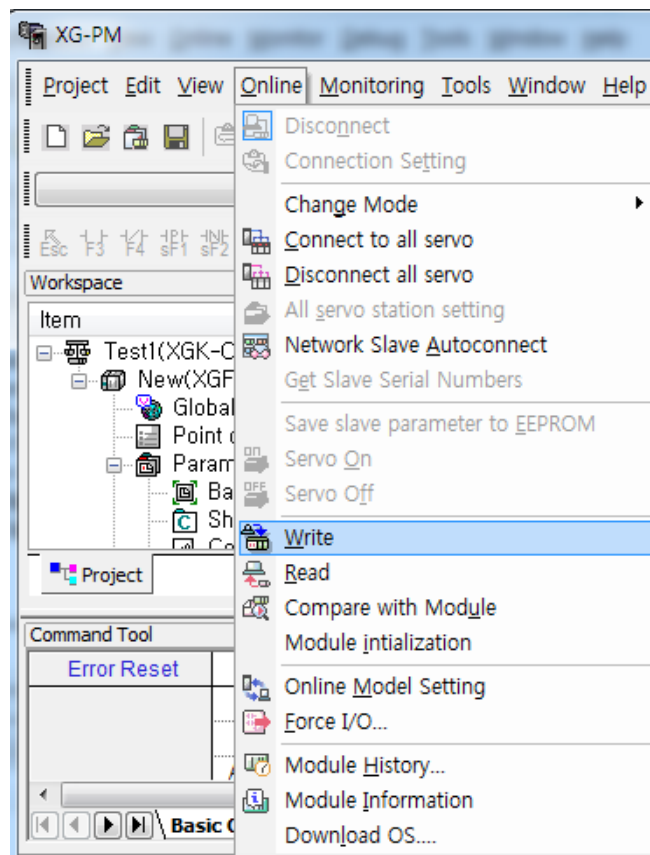
(21) Execute the servo drive addition in the same way for the other servo drives.

This is the screen to show all the servo drives actually connected to slave parameter are added. It is indicated by gray color until whole servo connection command is executed, and positioning module and servo drive are connected normally.



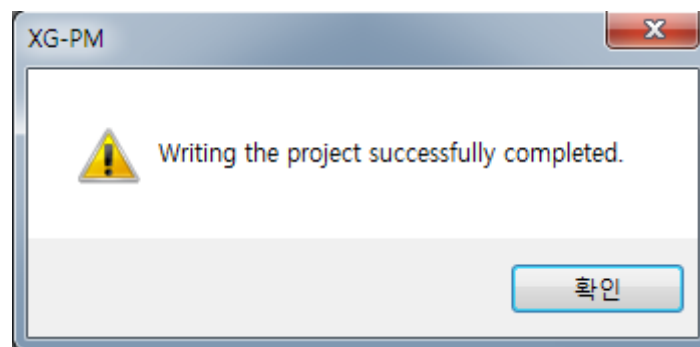
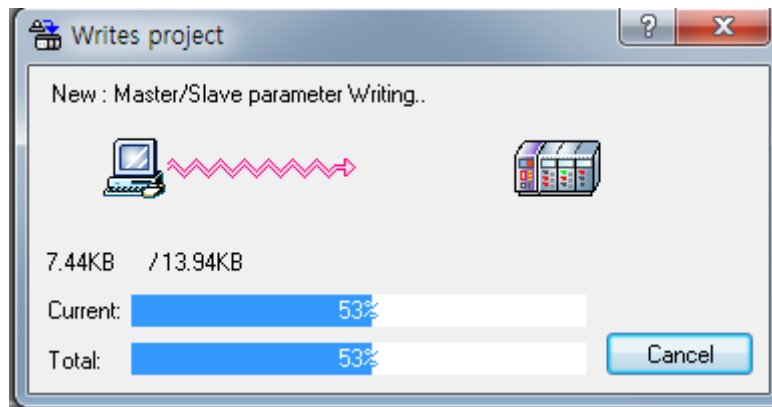
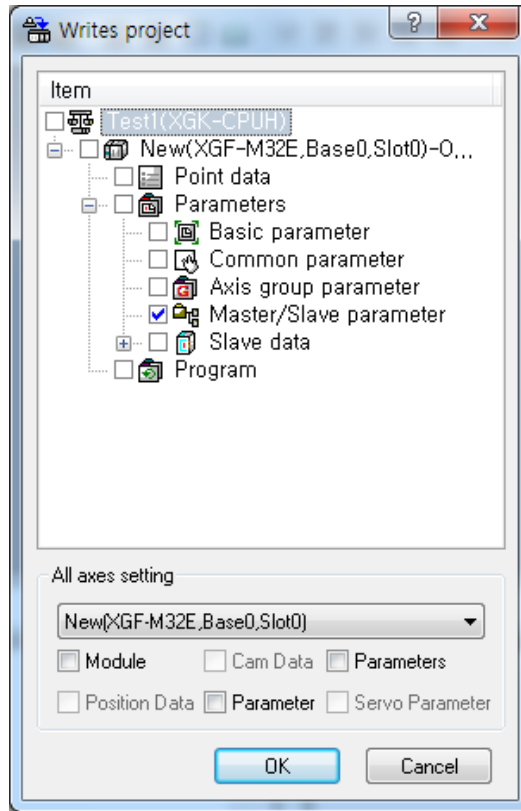
(22) After adding all the servo drives connected to slave parameter, execute "Online-Connection" first and execute "Online-Write" to write network parameter in motion control module.

(Network parameter is not indicated in the project tree.)

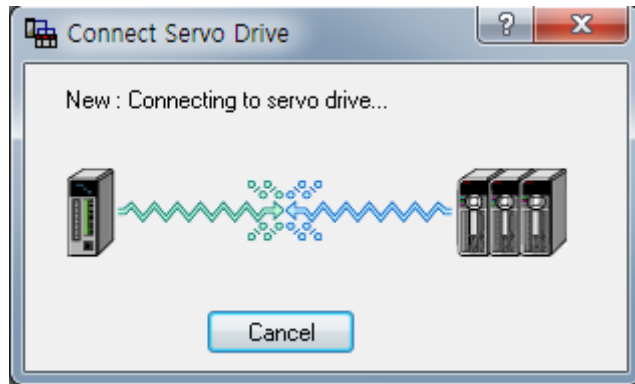


## Appendix2 Setting Example

(23) When the project writing window comes up, check in the network parameter and check OK to execute writing. This is the screen to show the whole execution process of project writing.



(24) Select "Online-Connect to all servo" to execute communication link between motion control module and servo drive.



(25) When the link is completed, the servo drive name of slave parameter is activated to black from gray. Execute the "View-view Network ..." in the menu to check the servo drive connection.

The screenshot shows the XG-PM software interface with the following components:

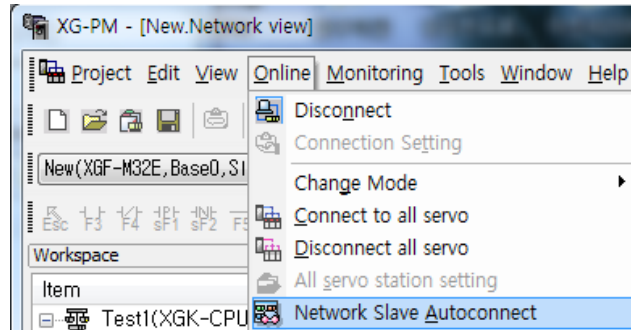
- Workspace:** A tree view on the left showing the project structure. Under 'Slave data', three items are listed: '# 1Axis Drive(L7N)', '# 2Axis Drive(L7N)', and '# 3Axis Drive(L7N)'. These items are now black, indicating they are active.
- Network Diagram:** A central diagram showing the 'New(XGF-M32E,Base0,Slot0)' PLC connected to three EtherCAT drives. The drives are labeled '# 1Axis Drive(L7N)', '# 2Axis Drive(L7N)', and '# 3Axis Drive(L7N)'. A red dashed box highlights the connection between the PLC and the drives.
- Command Tool:** A table at the bottom left showing control parameters and their current values.
 

Item	Rst. Axis Error	Run
Pos.	0 pls	
Spd.	0 pls/s	
Accel.	0 pls/s <sup>2</sup>	
Decel.	0 pls/s <sup>2</sup>	Run
Jerk	0 pls/s <sup>3</sup>	
Coord.	ABS	
Dir.	0: none	
Dec. Stop	0 pls/s <sup>2</sup>	Run
- Status Bar:** At the bottom, it shows 'Ready', 'New', 'L, USB', 'XGF-M32E', 'Online', and 'Base 0, Slot 0'.

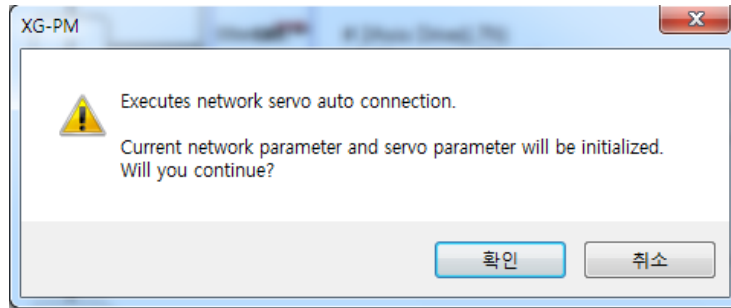
**Notes**

When connecting the network for the first time after the system configuration using XGF-M32E, use "Network slave auto connection" to conveniently execute connection to servo drive without setting the slave parameter.

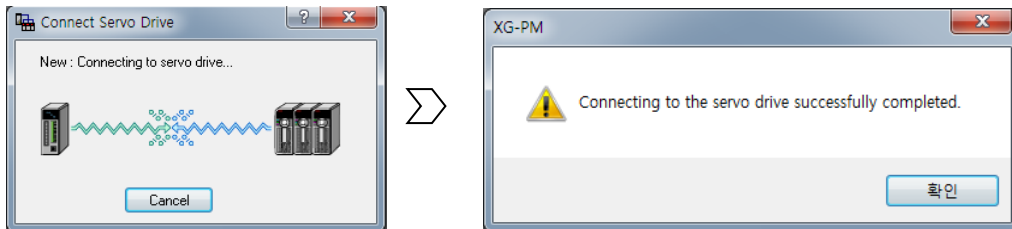
1. Execute the "Online -Network slave auto connection" menu.



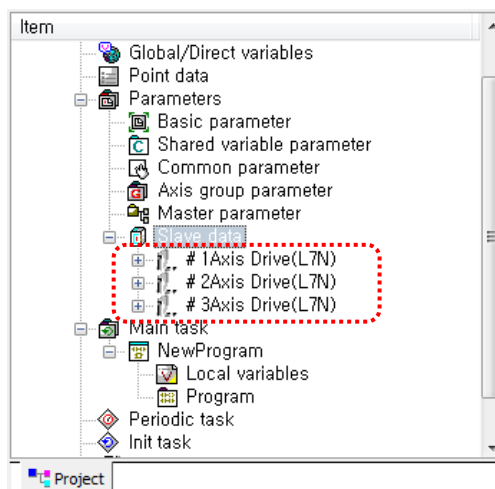
2. Popup notification message appears as follows. This is an alert message notifying when executing network slave auto connection, the network parameter set in the current XG-PM and motion control module is initialized and so the servo parameter in XG-PM is. Check the message and click OK.



3. Slave connection message appears, and if the connection is completed normally, completion message is indicated.

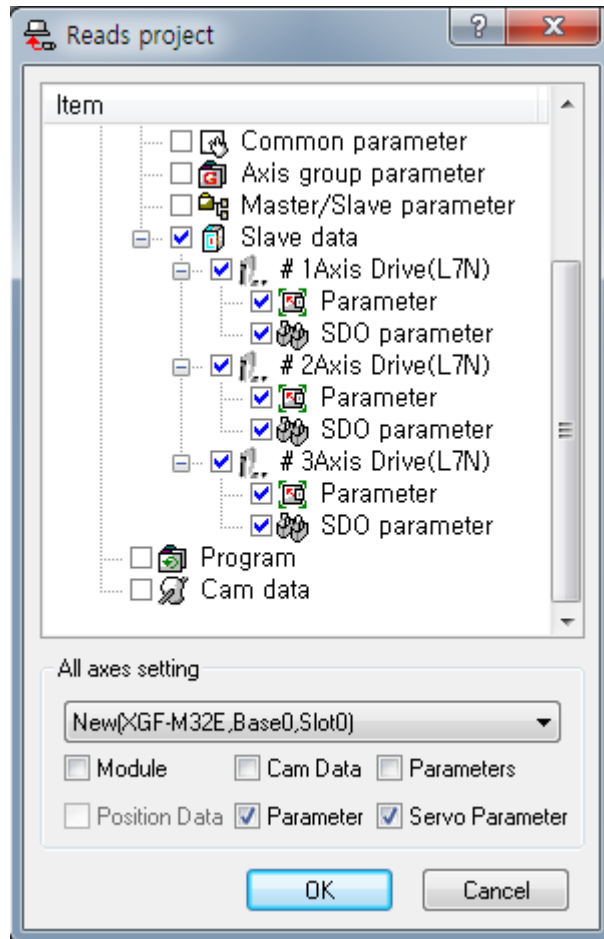


4. When executing the "Network slave auto connection" command, the EtherCAT slave information currently connected to the slave parameter of XG-PM is automatically registered if the connection command is completed normally.



5. When executing the connection with the "Network slave auto connection" command, the axis numbers are automatically allocated in the order of connection to motion control module. In other words, the servo drive primarily connected to motion control module becomes Axis 1, and the other servo drives become Axis 2 to Axis 32 in the order. When wanting to change the axis number, execute network parameter writing by disconnecting the link and change the axis number only in off-line state, and execute the connection with "Online- Connect to all servo" command.

- (26) Read slave parameter to set operation parameter and servo parameter.  
 Select "Online -Read" in the menu and select the item to be read.



## Appendix2 Setting Example

(27) Following is the reading of servo parameter content of L7N servo drive. The content of servo parameter can differ depending on the types of servo drive. Refer to the instruction manuals of each servo drive for details.

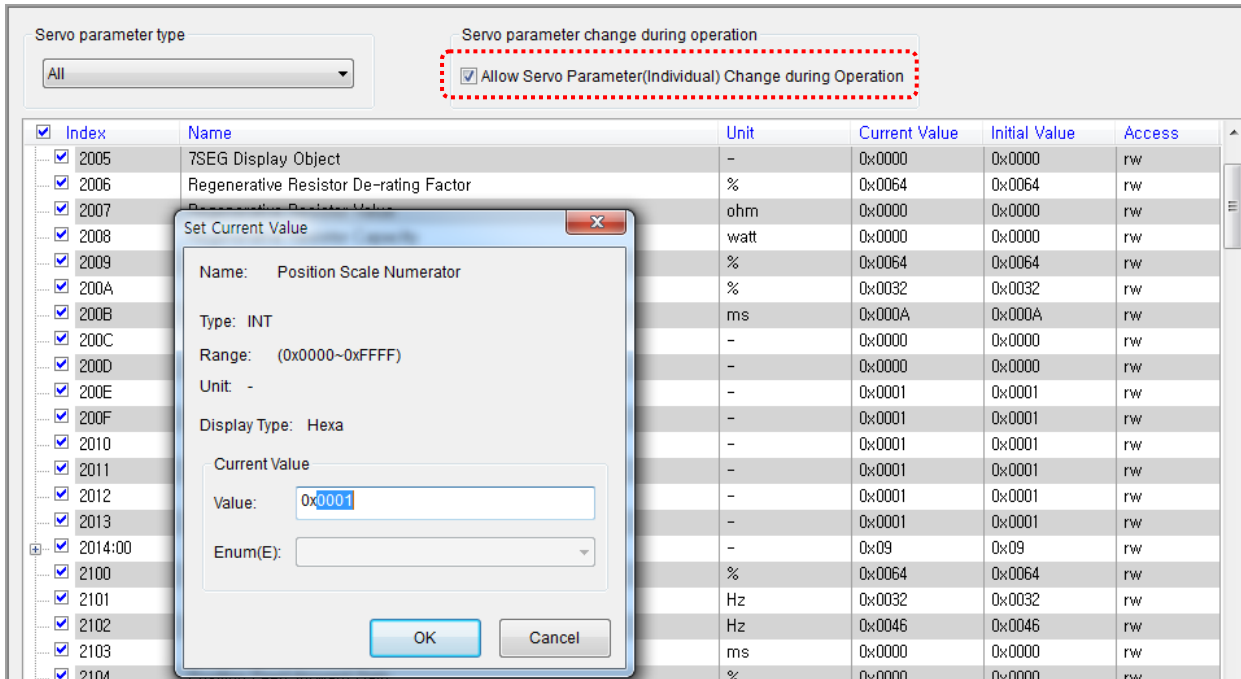
The screenshot shows the XG-PM software interface for configuring a servo drive. The main window displays a list of servo parameters for 'CMD Axis : 1Axis'. The parameters are organized into a table with columns for Index, Name, Unit, Current Value, Initial Value, and Access.

Index	Name	Unit	Current Value	Initial Value	Access
2000	Motor ID	-	0x03E7	0x03E7	rw
2001	Encoder Type	-	0x0000	0x0000	rw
2002	Encoder Resolution	bit	0x0013	0x0013	rw
2003	Power Fail Mode	-	0x0000	0x0000	rw
2004	RST Power Fail Check Time	ms	0x0014	0x0014	rw
2005	7SEG Display Object	-	0x0000	0x0000	rw
2006	Regenerative Resistor De-rating Factor	%	0x0064	0x0064	rw
2007	Regenerative Resistor Value	ohm	0x0000	0x0000	rw
2008	Regenerative Resistor Capacity	watt	0x0000	0x0000	rw
2009	Overload Check Base	%	0x0064	0x0064	rw
200A	Overload Warning Level	%	0x0032	0x0032	rw
200B	PWM OFF Delay	ms	0x000A	0x000A	rw
200C	Dynamic Brake Control Mode	-	0x0000	0x0000	rw
200D	Basic Function Configuration	-	0x0000	0x0000	rw
200E	Position Scale Numerator	-	0x0001	0x0001	rw
200F	Position Scale Denominator	-	0x0001	0x0001	rw
2010	Velocity Scale Numerator	-	0x0001	0x0001	rw
2011	Velocity Scale Denominator	-	0x0001	0x0001	rw
2012	Acceleration Scale Numerator	-	0x0001	0x0001	rw
2013	Acceleration Scale Denominator	-	0x0001	0x0001	rw
2014:00	DAC Output	-	0x09	0x09	rw
2100	Inertia Ratio	%	0x0064	0x0064	rw
2101	Position P Gain 1	Hz	0x0032	0x0032	rw

The interface also includes a 'Workspace' tree on the left, a 'Command Tool' window showing 'Direct Start' and 'Dec. Stop' commands, and a 'Message Window' at the bottom displaying system logs and error status.

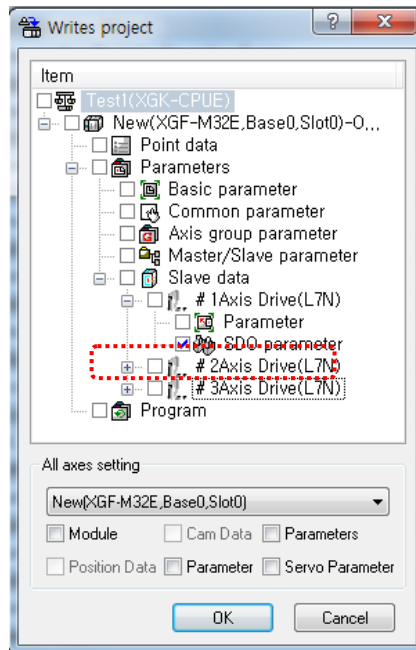
(28) Servo parameter can be set in two ways.

First method is only to change the value of one item of servo parameter (SDO parameter); select the 'Allow Servo Parameter(Individual) Change during Operation' checkbox and set the servo parameter (SDO parameter) value that you want to change, then the set value is applied to servo drive immediately. Reflection of the modified value to the 'current value' column of servo parameter means the value is transmitted normally.



In order to keep the data after turn on/off the power of servo drive, execute the "Online-Save slave parameter to EEPROM" command because modifying the parameter in operation of servo parameter (individual) is only valid when the power is currently on.

Second method is to set all the servo parameter you want to modify and execute 'Online -Write ' to write the whole SDO parameter in servo drive at a time.



When writing the whole SDO parameter, "Save slave parameter to EEPROM" command is automatically executed.



## Appendix2 Setting Example

Therefore, you do not need to execute "Save slave parameter to EEPROM" separately. Refer to the instruction manual of the relevant servo drive because sometimes modified set value is applied after the power is on/off depending on the item of servo parameter.

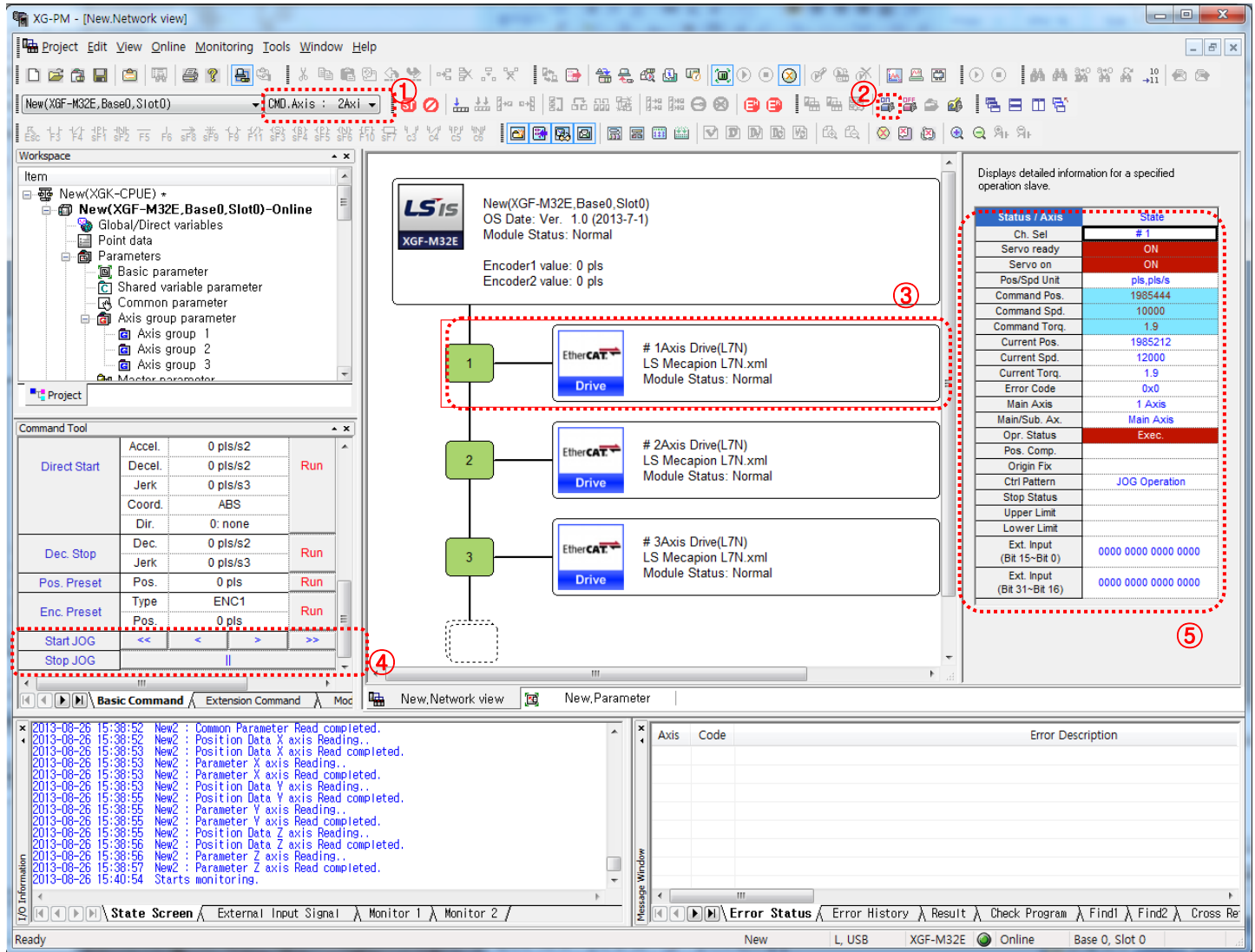
(29) When finishing the servo parameter setting, set the operation parameter of each axis and select the operation parameter of the relevant axis in "Online-Write " to write in module.

The screenshot displays the XG-PM software interface for parameter setting. The main window is titled "XG-PM - [New.Parameter]" and shows a workspace with a tree view of parameters. The "Basic Parameter" section is expanded, showing settings for two axes. The "Extended Parameter" section is also expanded, showing settings for two axes. A "Command Tool" window is open, showing error reset and direct start options. A "Message Window" at the bottom shows a log of connection events.

Item	1 Axis	2 Axis
Unit	1: mm	0: pulse
Pulses per rotation	524288 pls	524288 pls
Travel per rotation	10 mm	10 pls
Speed command unit	0: Unit/Time	0: Unit/Time
Speed limit	20000000 mm/s	20000000 pls/s
Emg. Stop Dec.	0 mm/s <sup>2</sup>	0 pls/s <sup>2</sup>
Encoder select	0: Incremental Encoder	0: Incremental Encoder
Gear ratio(Motor)	1	1
Gear ratio(Machine)	1	1
Operating mode of the reverse rotation	0: E.Stop	0: E.Stop
S/W upper limit	2147483647 mm	2147483647 pls
S/W lower limit	-2147483648 mm	-2147483648 pls
Infinite running repeat. pos.	360 mm	360 pls
Infinite running repeat.	0: Disable	0: Disable
Command Inposition range	0 mm	0 pls
Tracking error over-range value	0	0
Cur. pos. compenstion amount	0	0
Current speed filter time constant	0	0
Error reset monitoring time	100	100
S/W limit during Spd. Control	0: Don't detect	0: Don't detect
Tracking error level	0: Warning	0: Warning
JOG high speed	10000 mm/s	100000 pls/s
JOG low speed	10 mm/s	10000 pls/s
JOG Acc.	10000 mm/s <sup>2</sup>	100000 pls/s <sup>2</sup>
JOG Dec	1000 mm/s <sup>2</sup>	100000 pls/s <sup>2</sup>
JOG Jerk	0 mm/s <sup>3</sup>	0 pls/s <sup>3</sup>

(30) If you turned off the power of servo drive and turned it on again in the step (28), execute "Online-Connect to all servo" again to connect module and servo drive.

(31) After selecting the command axis and turning on the servo of the relevant axis, check if the relevant axis is in servo on state and check the motor operation by operating the motor using jog or others.

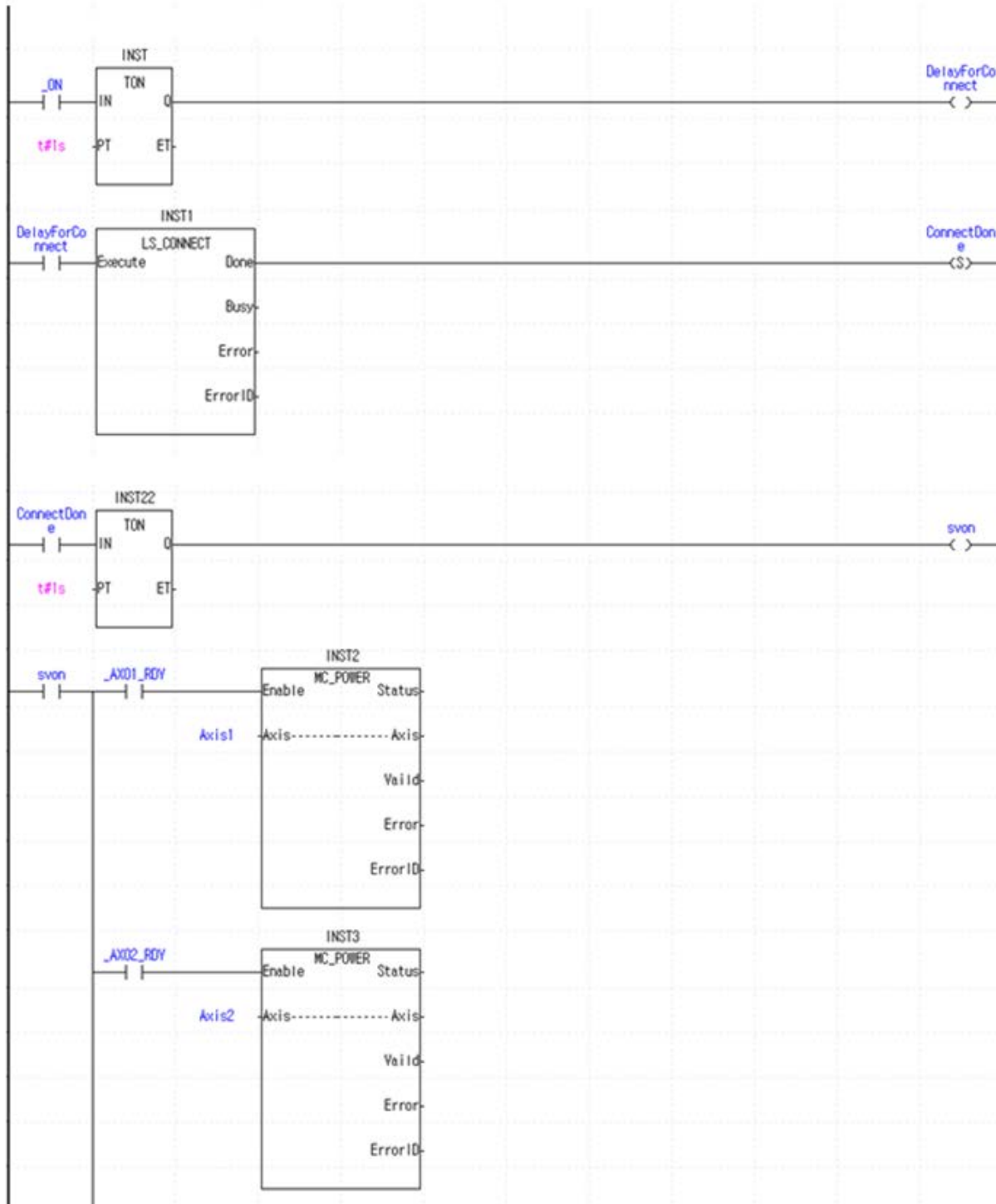


(32) If vibration or noise is generated when motor is operating, adjust the responsibility, inertia ratio, and gain values of servo parameter and transmit them to servo drive. Use the dedicated setting TOOL of servo drive for detailed setting such as auto tuning.

## Appendix2 Setting Example

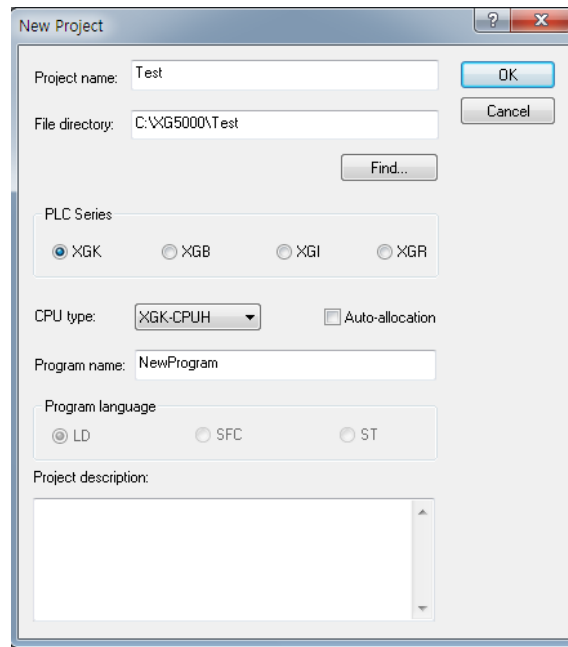
(33) Create motion program.

The exercise below is for the case that 2 servos are set to 1 & 2 axes using XGK CPU, and LS\_CONNECT is used for connection and the connected axis is servo on by using MC\_Power. The rest of the exercise can be added as user's need. Motion task can be divided into main task, periodic task, and initialization task. You can add program to the relevant task of the project tree depending on the character of the program.

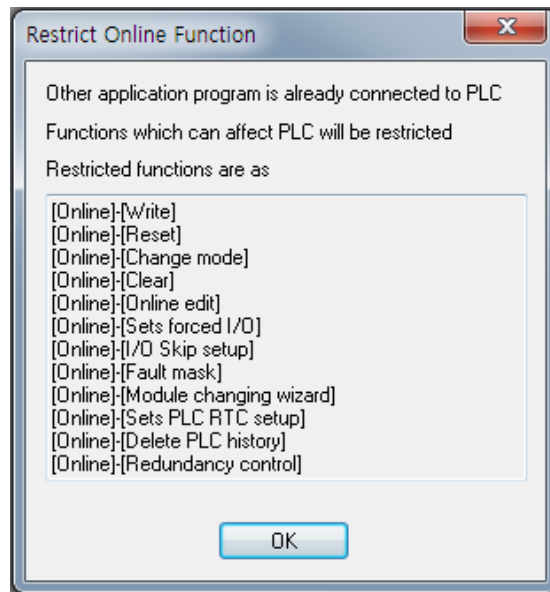


(34) Create PLC Program by using XG5000.

(a) Create new project. Select "Project -New project " in the menu, and set the name of project and others.



(b) Release the online connection between PLC CPU and XG-PM. If XG5000 is connected while XG-PM is linked, a dialog box appears as below and PLC function might be limited. But if you connect XG5000 first and then connect XG-PM, there is nothing to worry about it.

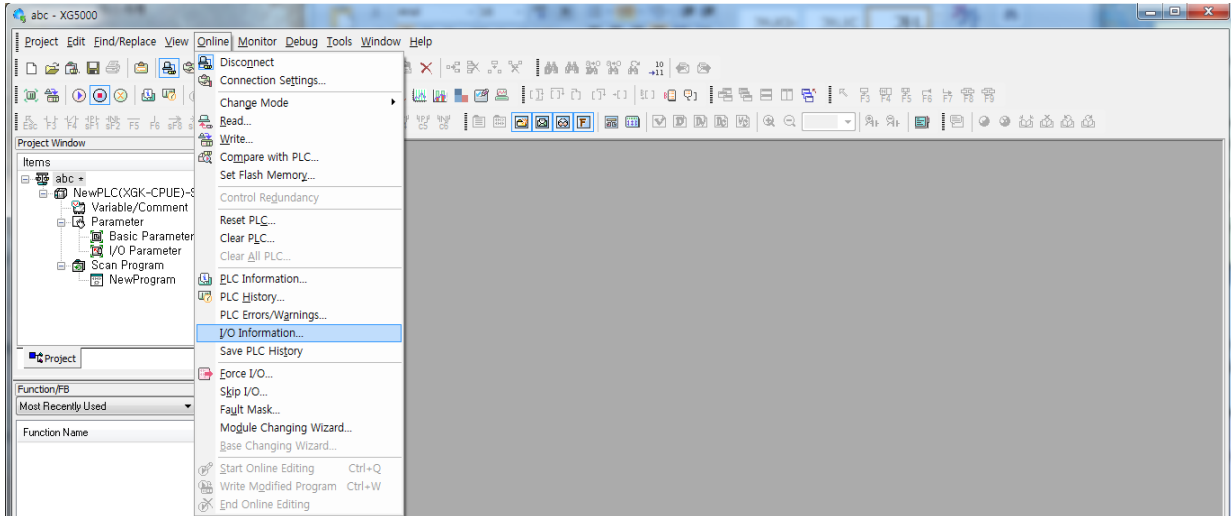


(c) Select "Online -Connection settings" in XG5000 to choose the connection method, and select "Online -Connect" to connect with PLC CPU.

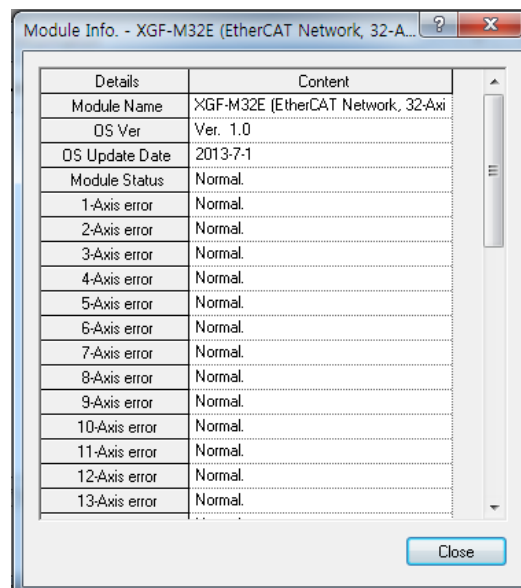
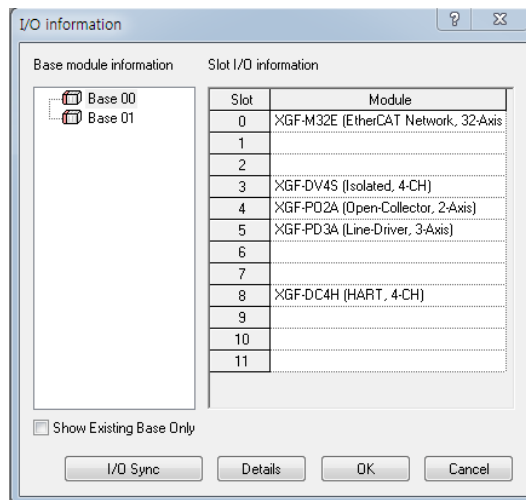
(d) Keep PLC CPU in the "STOP" state.

## Appendix2 Setting Example

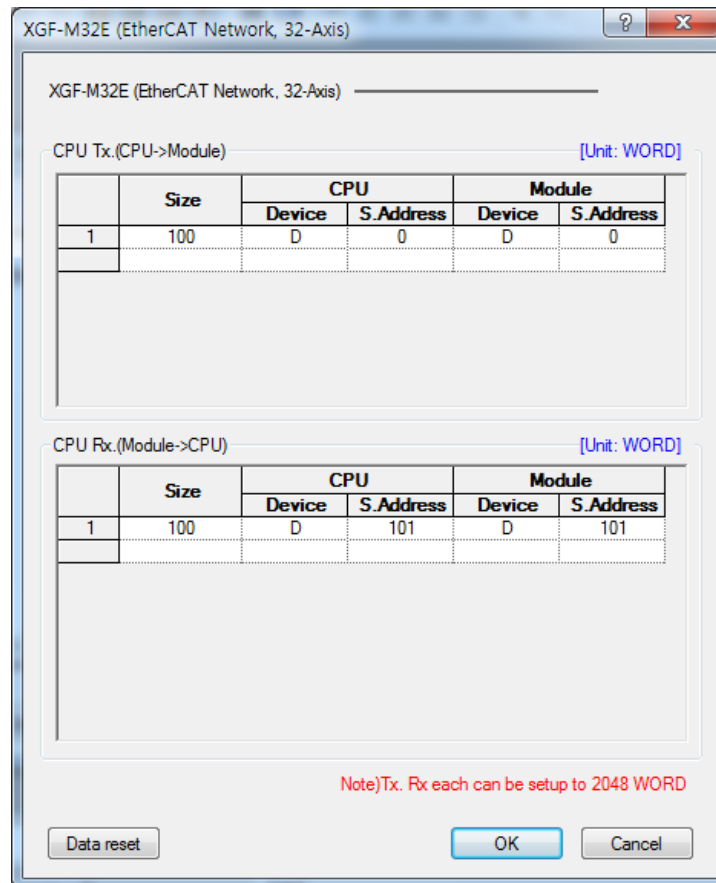
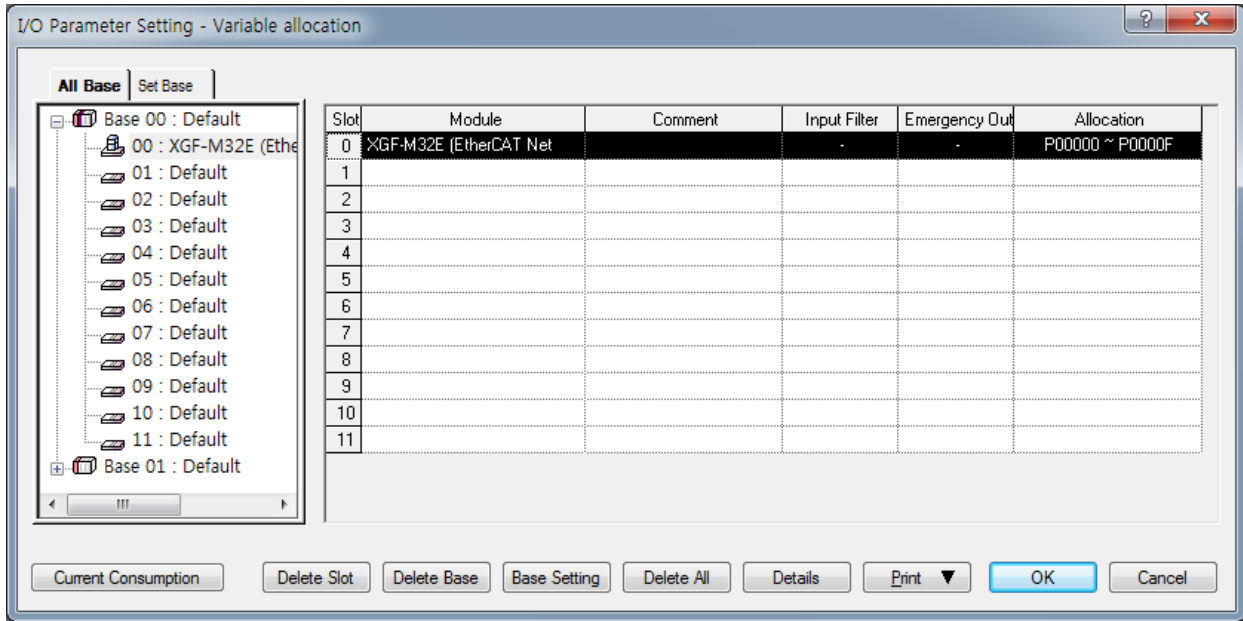
- (e) Select "Online -I/O information" to check the currently built-in I/O information of PLC.



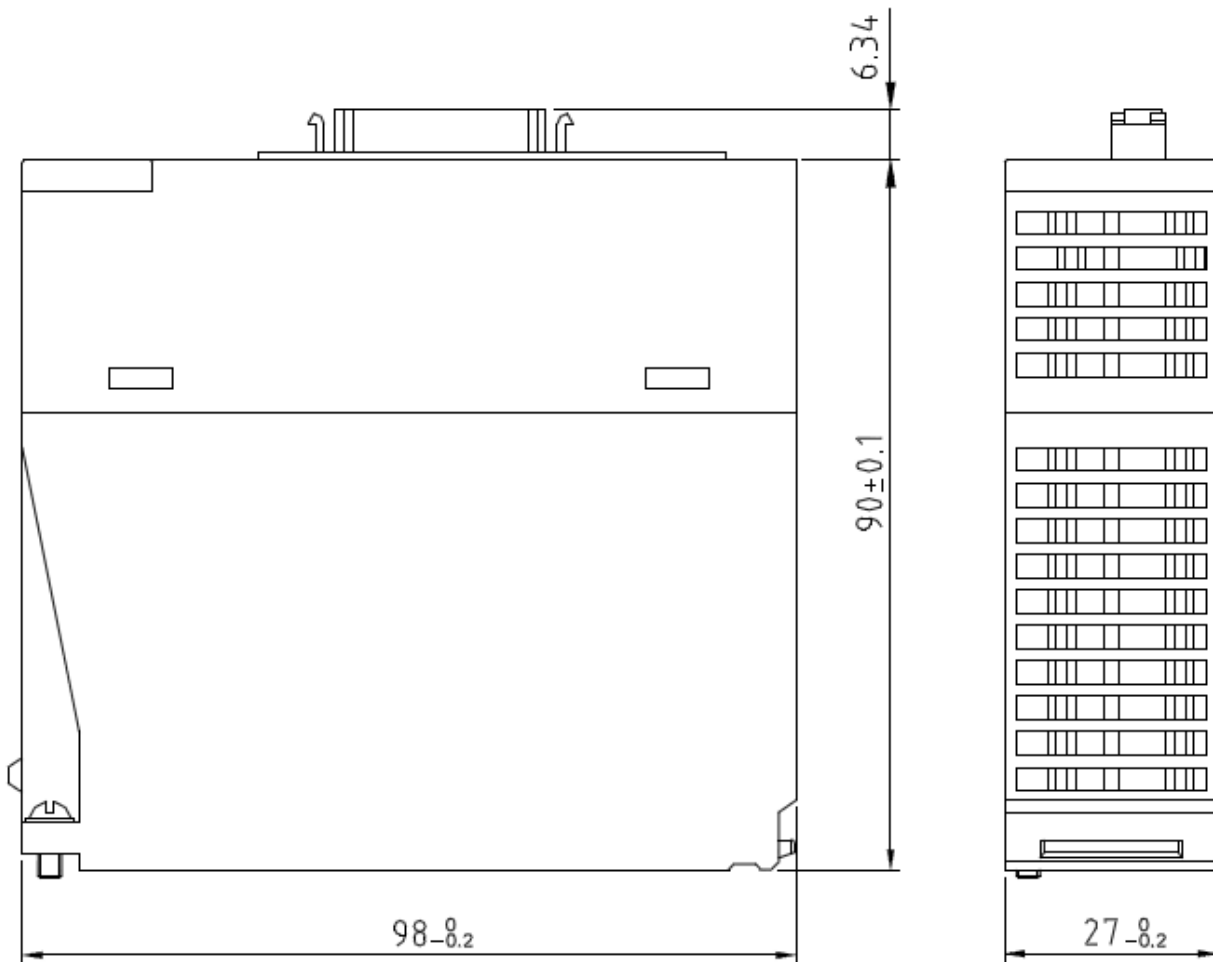
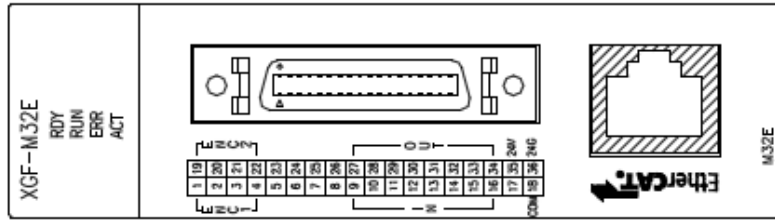
- (f) Check if the installation information of XGF-M32E is correctly displayed on the information window. If you want to view the version information of the relevant module and others, select the relevant module and click the "Details" button.



- (g) Click the "I/O synchronization" button to set I/O parameter.
- (h) Select "Edit –Register U Device" in the menu to register U device automatically.
- (i) Set device sharing between PLC CPU and motion control module as necessary. Device sharing can be set in I/O parameter in the project tree window.



### Appendix 3 Dimension







## Appendix 4 ESC(EtherCAT Slave Controller) Register

This is 'ESC(EtherCAT Slave Controller) Register' related information. For information on the entire area, please refer to the EtherCAT Registers (Section II) data sheet on the BECKHOFF website below.

[http://www.beckhoff.com/english.asp?download/ethercat\\_development\\_products.htm](http://www.beckhoff.com/english.asp?download/ethercat_development_products.htm)

### 1. ESC DL Status(0x0110:0x0111)

Bit	Description	ECAT	PDI	Reset Value
0	PDI operational/EEPROM loaded correctly: 0: EEPROM not loaded, PDI not operational (no access to Process Data RAM) 1: EEPROM loaded correctly, PDI operational (access to Process Data RAM)	r*/-	r/-	0
1	PDI Watchdog Status: 0: Watchdog expired 1: Watchdog reloaded	r*/-	r/-	0
2	Enhanced Link detection: 0: Deactivated for all ports 1: Activated for at least one port NOTE: EEPROM value is only taken over at first EEPROM load after power-on or reset	r*/-	r/-	ET1100/ET1200: 1 until first EEPROM load, then EEPROM ADR 0x0000.9 IP Core with feature: 1 until first EEPROM load, then EEPROM ADR 0x0000.9 or 0x0000[15:12] Others: 0
3	Reserved	r*/-	r/-	0
4	Physical link on Port 0: 0: No link 1: Link detected	r*/-	r/-	0
5	Physical link on Port 1: 0: No link 1: Link detected	r*/-	r/-	0
6	Physical link on Port 2: 0: No link 1: Link detected	r*/-	r/-	0
7	Physical link on Port 3: 0: No link 1: Link detected	r*/-	r/-	0
8	Loop Port 0: 0: Open 1: Closed	r*/-	r/-	0
9	Communication on Port 0: 0: No stable communication 1: Communication established	r*/-	r/-	0
10	Loop Port 1: 0: Open 1: Closed	r*/-	r/-	0

11	Communication on Port 1: 0: No stable communication 1: Communication established	r*/-	r/-	0
12	Loop Port 2: 0: Open 1: Closed	r*/-	r/-	0
13	Communication on Port 2: 0: No stable communication 1: Communication established	r*/-	r/-	0
14	Loop Port 3: 0: Open 1: Closed	r*/-	r/-	0
15	Communication on Port 3: 0: No stable communication 1: Communication established	r*/-	r/-	0

**Table 1-1: Register ESC DL Status (0x0110:0x0111)**

Register 0x0111	Port 3	Port 2	Port 1	Port 0
0x55	No link, closed	No link, closed	No link, closed	No link, closed
0x56	No link, closed	No link, closed	No link, closed	Link, open
0x59	No link, closed	No link, closed	Link, open	No link, closed
0x5A	No link, closed	No link, closed	Link, open	Link, open
0x65	No link, closed	Link, open	No link, closed	No link, closed
0x66	No link, closed	Link, open	No link, closed	Link, open
0x69	No link, closed	Link, open	Link, open	No link, closed
0x6A	No link, closed	Link, open	Link, open	Link, open
0x95	Link, open	No link, closed	No link, closed	No link, closed
0x96	Link, open	No link, closed	No link, closed	Link, open
0x99	Link, open	No link, closed	Link, open	No link, closed
0x9A	Link, open	No link, closed	Link, open	Link, open
0xA5	Link, open	Link, open	No link, closed	No link, closed
0xA6	Link, open	Link, open	No link, closed	Link, open
0xA9	Link, open	Link, open	Link, open	No link, closed
0xAA	Link, open	Link, open	Link, open	Link, open
0xD5	Link, closed	No link, closed	No link, closed	No link, closed
0xD6	Link, closed	No link, closed	No link, closed	Link, open
0xD9	Link, closed	No link, closed	Link, open	No link, closed
0xDA	Link, closed	No link, closed	Link, open	Link, open

**Table 1-2: Decoding port state in ESC DL Status register 0x0111 (typical modes only)**

### 2. RX Error Counter(0x0300:0x0307)

Errors are only counted if the corresponding port is enabled.

Bit	Description	ECAT	PDI	Reset Value
7:0	Invalid frame counter of Port y (counting is stopped when 0xFF is reached).	r/- w(clr)	r/-	0
15:8	RX Error counter of Port y (counting is stopped when 0xFF is reached). This is coupled directly to RX ERR of MII interface/EBUS interface.	r/- w(clr)	r/-	0

**Table 2: Register RX Error Counter Port y (0x0300+y\*2:0x0301+y\*2)**

### 3. Forwarded RX Error Counter (0x0308:0x030B)

Bit	Description	ECAT	PDI	Reset Value
7:0	Forwarded error counter of Port y (counting is stopped when 0xFF is reached).	r/- w(clr)	r/-	0

**Table 3: Register Forwarded RX Error Counter Port y (0x0308+y)**

NOTE: Error Counters 0x0300-0x030B are cleared if one of the RX Error counters 0x0300-0x030B is written. Write value is ignored (write 0).

### 4. ECAT Processing Unit Error Counter (0x030C)

Bit	Description	ECAT	PDI	Reset Value
7:0	ECAT Processing Unit error counter (counting is stopped when 0xFF is reached). Counts errors of frames passing the Processing Unit (e.g., FCS is wrong or datagram structure is wrong).	r/- w(clr)	r/-	0

**Table 4: Register ECAT Processing Unit Error Counter (0x030C)**

NOTE: Error Counter 0x030C is cleared if error counter 0x030C is written. Write value is ignored (write 0).

### 5. Lost Link Counter (0x0310:0x0313)

Bit	Description	ECAT	PDI	Reset Value
7:0	Lost Link counter of Port y (counting is stopped when 0xff is reached). Counts only if port loop is Auto.	r/ w(clr)	r/-	0

**Table 5: Register Lost Link Counter Port y (0x0310+y)**

NOTE: Only lost links at open ports are counted. Lost Link Counters 0x0310-0x0313 are cleared if one of the Lost Link Counters 0x0310-0x0313 is written. Write value is ignored (write 0).

### 6. AL Status (0x0130:0x0131)

Bit	Description	ECAT	PDI	Reset Value
3:0	Actual State of the Device State Machine: 1: Init State 3: Request Bootstrap State 2: Pre-Operational State 4: Safe-Operational State 8: Operational State	r*/-	r/(w)	1
4	Error Ind: 0: Device is in State as requested or Flag cleared by command 1: Device has not entered requested State or changed State as result of a local action	r*/-	r/(w)	0
5	Device Identification: 0: Device Identification not valid 1: Device Identification loaded	r*/-	r/(w)	0
15:6	Reserved, write 0	r*/-	r/(w)	0

**Table 6: Register AL Status (0x0130:0x0131)**

NOTE: AL Status register is only writable from PDI if Device Emulation is off (0x0140.8=0), otherwise AL Status register will reflect AL Control register values.

\* Reading AL Status from ECAT clears ECAT Event Request 0x0210[3].

**7. AL Status Code (0x0134:0x0135)**

Bit	Description	ECAT	PDI	Reset Value
15:0	AL Status Code	r/-	r/w	0

**Table 7: Register AL Status Code (0x0134:0x0135)**

**8. ECAT Event Request (0x0210:0x0211)**

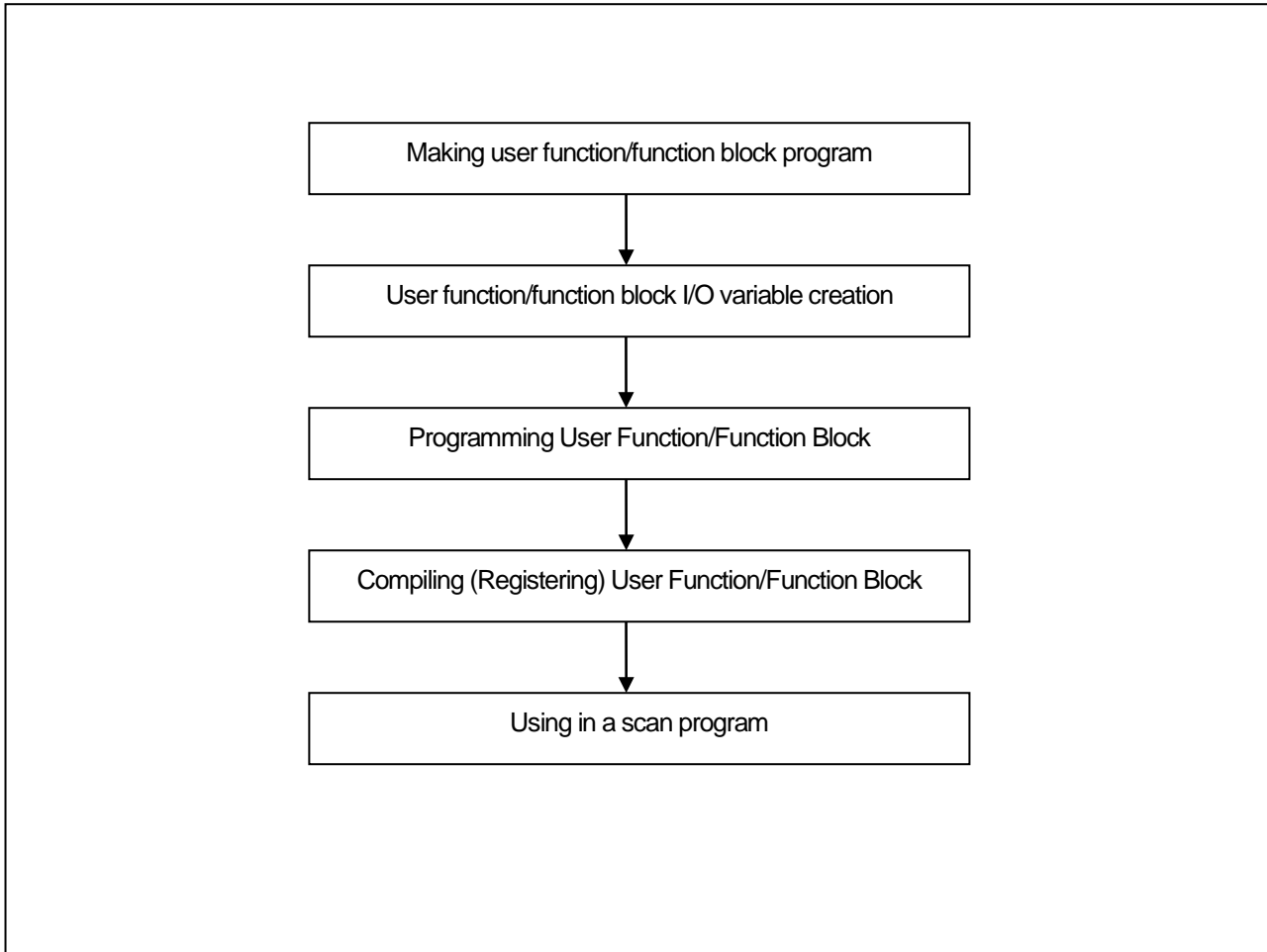
Bit	Description	ECAT	PDI	Reset Value
0	DC Latch event: 0: No change on DC Latch Inputs 1: At least one change on DC Latch Inputs (Bit is cleared by reading DC Latch event times from ECAT for ECAT controlled Latch Units, so that Latch 0/1 Status 0x09AE:0x09AF indicates no event)	r/-	r/-	0
1	Reserved	r/-	r/-	0
2	DL Status event: 0: No change in DL Status 1: DL Status change (Bit is cleared by reading out DL Status 0x0110:0x0111 from ECAT)	r/-	r/-	0
3	AL Status event: 0: No change in AL Status 1: AL Status change (Bit is cleared by reading out AL Status 0x0130:0x0131 from ECAT)	r/-	r/-	0
4 5	Mirrors values of each SyncManager Status: 0: No Sync Channel 0 event 1: Sync Channel 0 event pending 0: No Sync Channel 1 event 1: Sync Channel 1 event pending	r/-	r/-	0
11	0: No Sync Channel 7 event 1: Sync Channel 7 event pending	r/-	r/-	0
15:12	Reserved	r/-	r/-	0

**Table 8: Register ECAT Event Request (0x0210:0x0211)**

## Appendix 5 User Define Function & Function Block

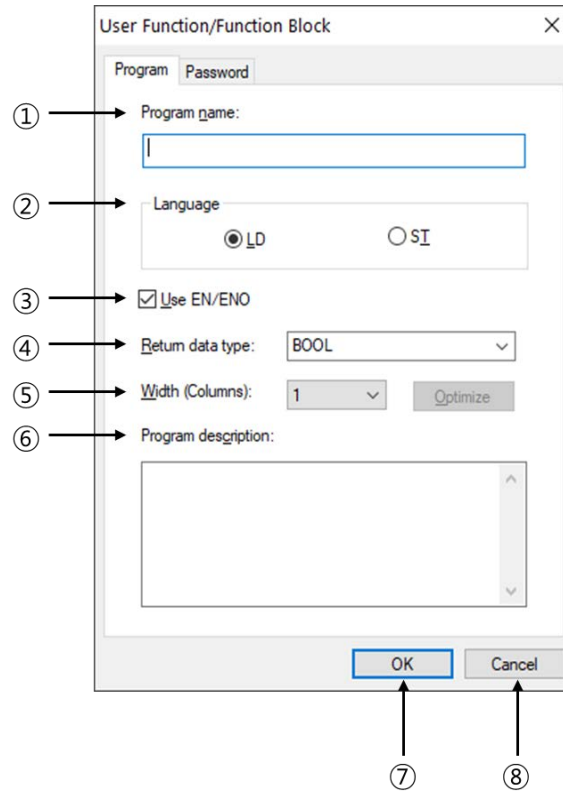
This is a function that allows the user to directly write and use a function or function block that is not supported by motion control. The overall process of using user functions and function blocks is as follows.

### 1. User Define Function & Function Block



## 2. Making user function, function block program

To make a user function or function block, select [Project] - [Add Item] - [Function] or [Project] - [Add Item] - [Function Block].



- ① Program name: Enter the name of the user function or function block. When a user function or function block is registered, it is registered with the name entered.
- ② Language: Select the language to program the user function or function block. User functions can be written in LD language only, and user function blocks can be written in both LD and ST languages.
- ③ Use EN/ENO: Select whether to use EN/ENO, which can be used as a driving condition for user functions and function blocks. If EN/ENO is not selected, the user should directly declare a variable of BOOL type in the first input and first output parameters of the user function and function block.
- ④ Return data type: This is a function to designate the type of the result value after the user function is executed. It is activated only when a user function is used.
- ⑤ Width(columns): The number of width columns of the user function/function block can be adjusted.
- ⑥ Program description: This is the function to input the description of the user function/function block. When not in use, input does not affect operation. After the user function/function block is created, the width optimization function according to the user function/function block can be used through the corresponding registration information.
- ⑦ OK: Saves the contents entered in the dialog box and closes the dialog box.
- ⑧ Cancels the contents entered in the dialog box and closes the dialog box.

3. User function/function block input/output variable creation

- 1) If you double-click the local variable among the items created with the newly entered name in the user function/function block, the following local variable window is created.

	Variable Kind	Variable	Type	Used	Comment
① → 1	VAR_RETURN	USER_Motion	BOOL	<input type="checkbox"/>	
2	[dropdown]			<input type="checkbox"/>	

② →

```

    graph LR
      EN[BOOL-EN] --- USER_Motion[USER_Motion]
      USER_Motion --- ENO[ENO-BOOL]
      USER_Motion --- USER_Motion_OUT[USER_Motion-BOOL]
  
```

- ① VAR\_RETURN: This is a type of variable that indicates the result value of the user function. When creating a user function, it is automatically created as the same variable as the name of the user function with the designated return type.
  - ② Function shape: It automatically shows the shape of the function/function block according to the input variable, input/output variable, and output variable entered in the local variable window. This shape is the same as that when using user function/function block in scan program.
- 2) Add input variables, input/output variables, and output variables to the local variable window. The function/function block shape at the bottom of the local variable window is automatically changed according to the added input/output variables.

	Variable Kind	Variable	Type	Used	Comment
1	VAR_INPUT	Target_Value	INT	<input type="checkbox"/>	
2	VAR_INPUT	EM_Stop	BOOL	<input type="checkbox"/>	
3	VAR_INPUT	Start_Working	BOOL	<input type="checkbox"/>	
4	VAR_RETURN	USER_Motion	BOOL	<input type="checkbox"/>	
5	VAR_OUTPUT	Motor_RUN	BOOL	<input type="checkbox"/>	
6	VAR_OUTPUT	Current_Value	INT	<input type="checkbox"/>	
7	VAR	Workload	INT	<input type="checkbox"/>	

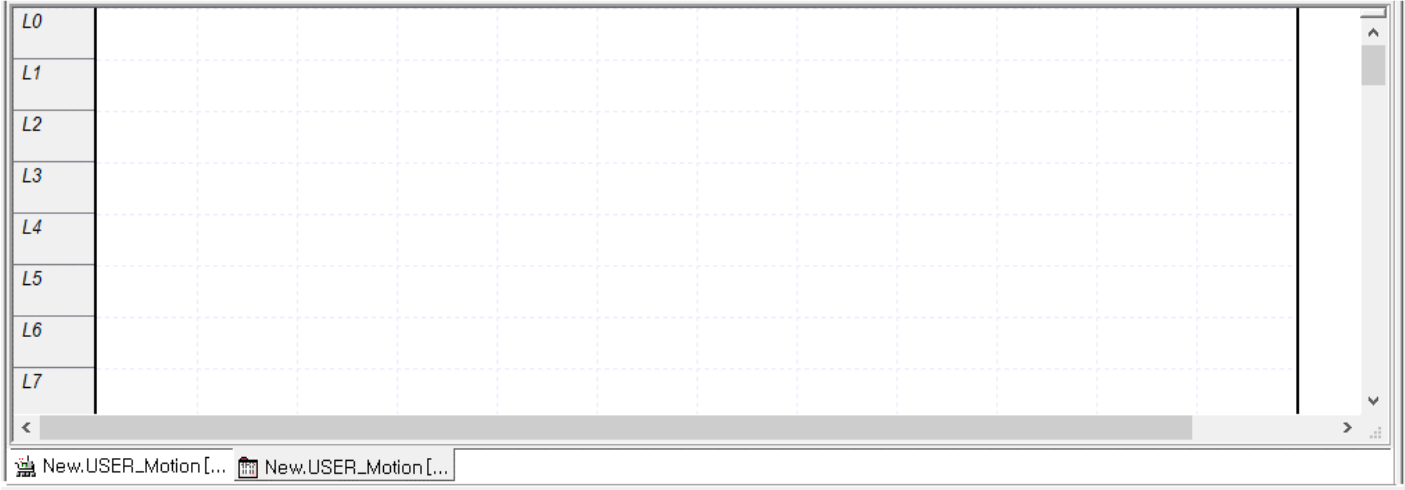
```

    graph LR
      EN[BOOL-EN] --- USER_Motion[USER_Motion]
      USER_Motion --- ENO[ENO-BOOL]
      USER_Motion --- USER_Motion_OUT[USER_Motion-BOOL]
      Target_Value[INT-Target_Value] --- USER_Motion
      EM_Stop[BOOL-EM_Stop] --- USER_Motion
      Start_Working[BOOL-Start_Working] --- USER_Motion
      Motor_RUN[BOOL-Motor_RUN] --- USER_Motion
      Current_Value[INT-Current_Value] --- USER_Motion
      Workload[INT-Workload] --- USER_Motion
  
```

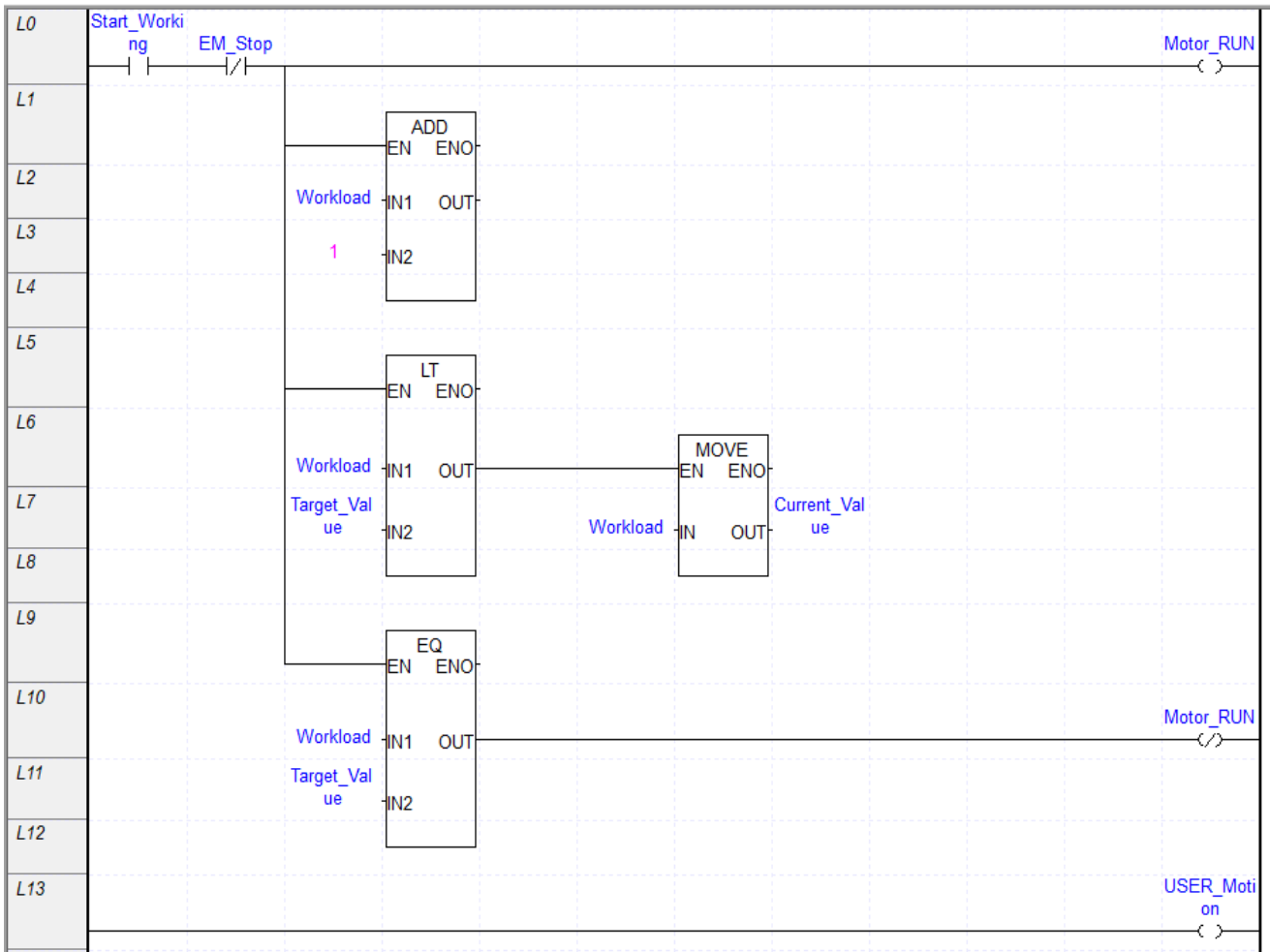
**Note**  
 There must be at least one input variable and one output variable each and cannot exceed 64 maximum.

4. User function/function block programming

1) If you double-click the program among the items created with the newly entered name in the user function/function block, the program window of the previously designated language is created. The window below is created when LD is selected.



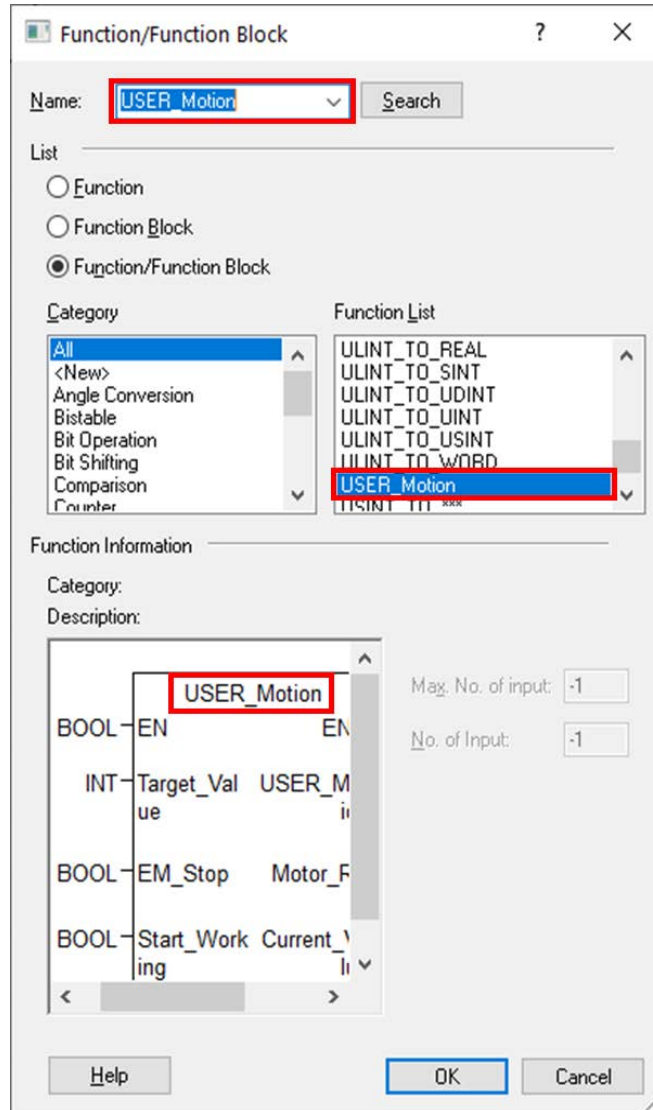
2) Create a program based on the variables entered in the local variable window.





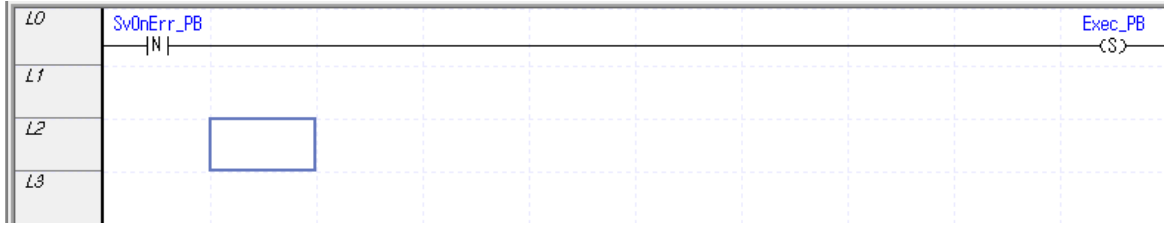
**Note**

After editing the local variable window and editing the program, select the function/function block toolbar command in the scan program and check if the user function/function block that has been edited is registered.

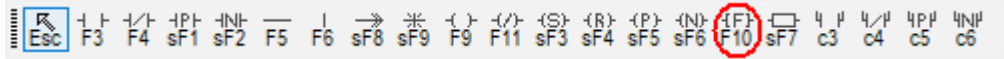


5. Using User Function/Function Block

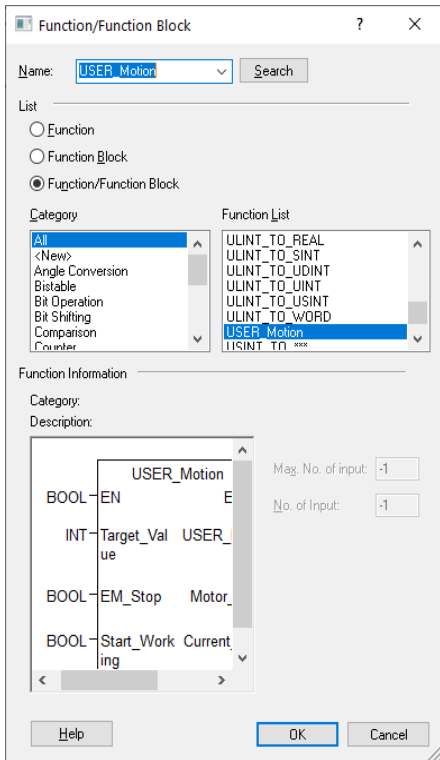
- 1) Open the program to use the user function/function block, and place the cursor at the location to input.



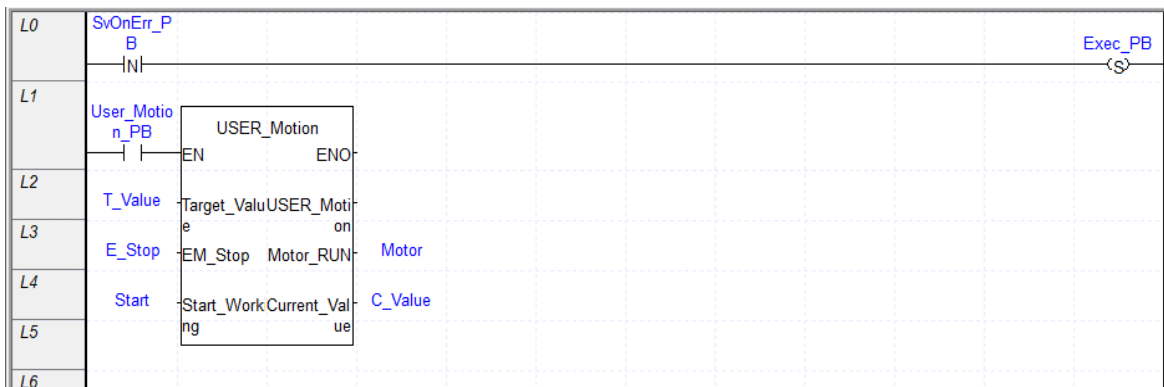
- 2) Select the function/function block toolbar (shortcut key: F10).



- 3) Select the user function/function block to be input in the function/function block window.

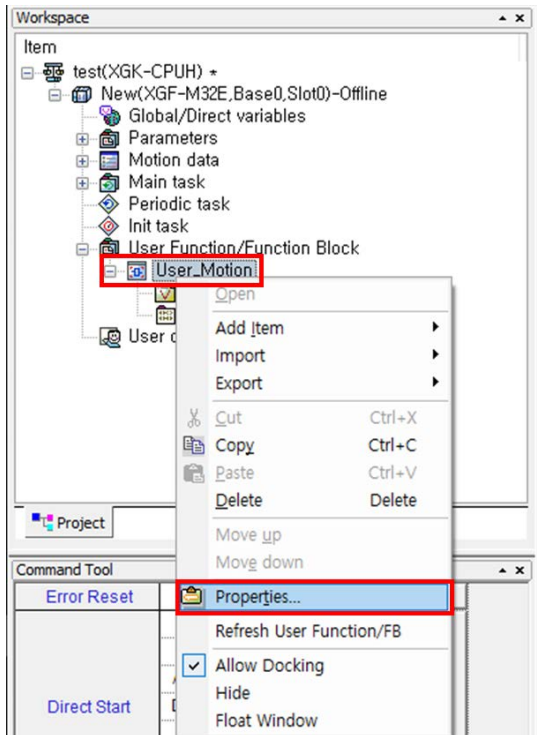


- 4) Input the variable to be used for input and output of function/function block.

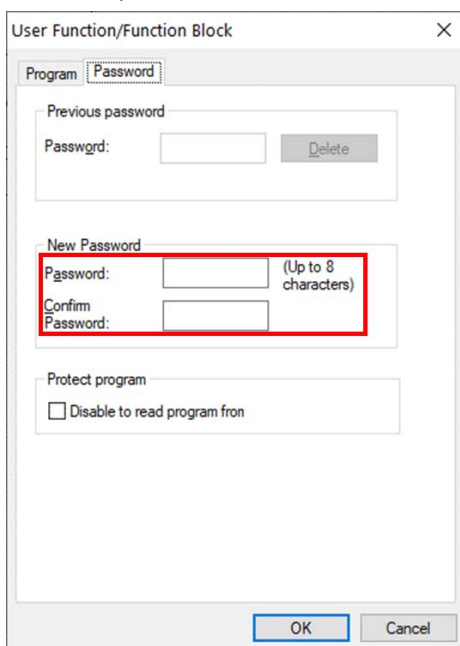


### 6. User function/function block source protection

- 1) Set password for individual user function/function block.
- 2) After selecting the user function/function block item in the project window, select the Properties.



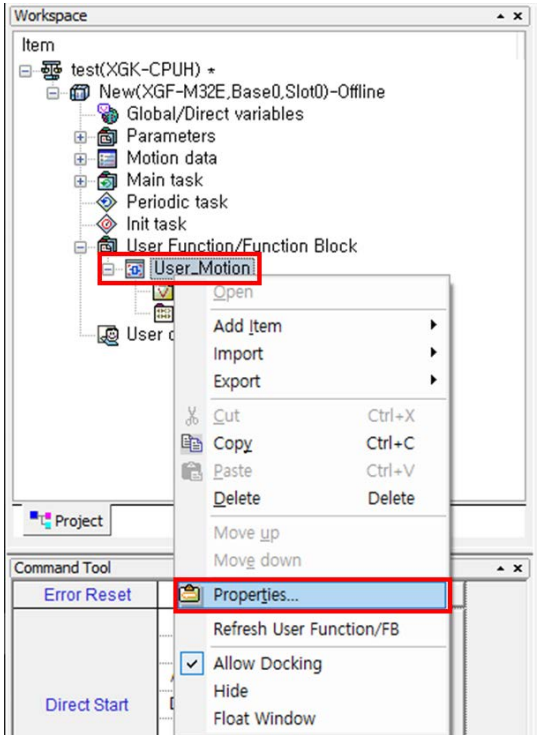
- 3) Select the password tab in the user function/function block window.



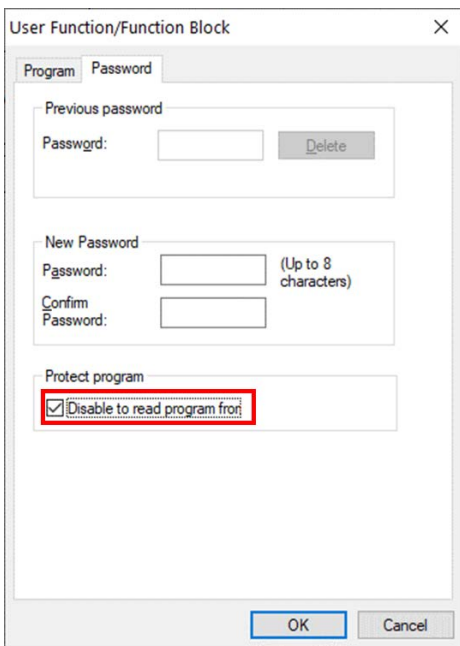
- 4) Enter your password.
- 5) Enter the same password in Confirm Password.
- 6) Click the OK button to set the password and complete.
- 7) If you want to use a user function/function block program with a password set, you can use it only by entering the password.

**Setting that the source cannot be read from PLC**

- 1) After reading from PLC, this function makes it impossible to see the source of the program of the user function/function block.
- 2) After selecting the user function/function block item in the project window, select the Properties.



- 3) Select the password tab in the user function/function block window.



- 4) Check the item that the 'Disable to read program from'
- 5) Click the OK button.
- 6) If Read from PLC after writing to PLC, this user function/function block program cannot be opened.

## Warranty

### 1. Warranty Period

The product you purchased will be guaranteed for 36 months from the date of manufacturing.

### 2. Scope of Warranty

- (1) The initial diagnosis of faults is basically conducted by your company. However, upon your request, our company or our service network can undertake this task for a fee. If the cause of the fault lies with our company, this service will be provided free of charge.
- (2) This warranty only applies if the product is used under normal conditions according to the specifications and precautions described in the handling instructions, user manuals, catalogs, and caution labels.
- (3) Even within the free warranty period, the following cases will be subject to paid repairs:
  - 1) Replacement of consumable and life-limited parts (e.g., relays, fuses, electrolytic capacitors, fans, LCDs, batteries, etc.)
  - 2) Failures or damages caused by improper storage, handling, negligence, or accidents by the customer
  - 3) Failures resulting from the customer's hardware or software design
  - 4) Failures due to modifications without our consent  
(Repairs will be refused, even for a fee, if recognized as modified or repaired outside our company)
  - 5) Failures that could have been avoided if the customer's equipment, in which our product is incorporated, had safety devices required by legal regulations or common industry standards
  - 6) Failures that could have been prevented if maintenance and replacement of consumable parts were performed normally according to the handling instructions or user manuals
  - 7) Failures and damages to the product caused by using connected equipment or inappropriate consumables
  - 8) Failures caused by external factors such as fire, abnormal voltage, force majeure, and natural disasters such as earthquakes, lightning, salt damage, wind, and flood damage
  - 9) Failures due to reasons that could not be predicted with the scientific and technical standards at the time of our shipment
  - 10) Other failures, damages, or defects recognized as the responsibility of your company

## Environmental Policy

LS ELECTRIC Co., Ltd supports and observes the environmental policy as below.

### Environmental Management

LS ELECTRIC considers the environmental preservation as the preferential management subject and every staff of LS ELECTRIC use the reasonable endeavors for the pleasurable environmental preservation of the earth.

### About Disposal

LS ELECTRIC' PLC unit is designed to protect the environment. For the disposal, separate aluminum, iron and synthetic resin (cover) from the product as they are reusable.





[www.ls-electric.com](http://www.ls-electric.com)

## LS ELECTRIC Co., Ltd.

### ■ Headquarter

LS-ro 127(Hogye-dong) Dongan-gu, Anyang-si, Gyeonggi-Do, 14119, Korea

### ■ Seoul Office

LS Yongsan Tower, 92, Hangang-daero, Yongsan-gu, Seoul, 04386, Korea

Tel: 82-2-2034-4033, 4888, 4703 Fax: 82-2-2034-4588

E-mail: [automation@ls-electric.com](mailto:automation@ls-electric.com)

### ■ Overseas Subsidiaries

#### • LS ELECTRIC Japan Co., Ltd. (Tokyo, Japan)

Tel: 81-3-6268-8241 E-Mail: [japan@ls-electric.com](mailto:japan@ls-electric.com)

#### • LS ELECTRIC (Dalian) Co., Ltd. (Dalian, China)

Tel: 86-411-8730-6495 E-Mail: [china.dalian@lselectric.com.cn](mailto:china.dalian@lselectric.com.cn)

#### • LS ELECTRIC (Wuxi) Co., Ltd. (Wuxi, China)

Tel: 86-510-6851-6666 E-Mail: [china.wuxi@lselectric.com.cn](mailto:china.wuxi@lselectric.com.cn)

#### • LS ELECTRIC Middle East FZE (Dubai, U.A.E.)

Tel: 971-4-886-5360 E-Mail: [middleeast@ls-electric.com](mailto:middleeast@ls-electric.com)

#### • LS ELECTRIC Europe B.V. (Hoofddorp, Netherlands)

Tel: 31-20-654-1424 E-Mail: [europartner@ls-electric.com](mailto:europartner@ls-electric.com)

#### • LS ELECTRIC America Inc. (Chicago, USA)

Tel: 1-800-891-2941 E-Mail: [sales.us@lselectricamerica.com](mailto:sales.us@lselectricamerica.com)

#### • LS ELECTRIC Turkey Co., Ltd.

Tel: 90-212-806-1225 E-Mail: [turkey@ls-electric.com](mailto:turkey@ls-electric.com)

### ■ Overseas Branches

#### • LS ELECTRIC Tokyo Office (Japan)

Tel: 81-3-6268-8241 E-Mail: [tokyo@ls-electric.com](mailto:tokyo@ls-electric.com)

#### • LS ELECTRIC Beijing Office (China)

Tel: 86-10-5095-1631 E-Mail: [china.auto@lselectric.com.cn](mailto:china.auto@lselectric.com.cn)

#### • LS ELECTRIC Shanghai Office (China)

Tel: 86-21-5237-9977 E-Mail: [china.auto@lselectric.com.cn](mailto:china.auto@lselectric.com.cn)

#### • LS ELECTRIC Guangzhou Office (China)

Tel: 86-20-3818-2883 E-Mail: [china.auto@lselectric.com.cn](mailto:china.auto@lselectric.com.cn)

#### • LS ELECTRIC Chengdu Office (China)

Tel: 86-28-8670-3201 E-Mail: [china.auto@lselectric.com.cn](mailto:china.auto@lselectric.com.cn)

#### • LS ELECTRIC Qingdao Office (China)

Tel: 86-532-8501-2065 E-Mail: [china.auto@lselectric.com.cn](mailto:china.auto@lselectric.com.cn)

#### • LS ELECTRIC Nanjing Office (China)

Tel: 86-25-8467-0005 E-Mail: [china.auto@lselectric.com.cn](mailto:china.auto@lselectric.com.cn)

#### • LS ELECTRIC Bangkok Office (Thailand)

Tel: 66-90-950-9683 E-Mail: [thailand@ls-electric.com](mailto:thailand@ls-electric.com)

#### • LS ELECTRIC Jakarta Office (Indonesia)

Tel: 62-21-2933-7614 E-Mail: [indonesia@ls-electric.com](mailto:indonesia@ls-electric.com)

#### • LS ELECTRIC Moscow Office (Russia)

Tel: 7-499-682-6130 E-Mail: [info@lselectric-ru.com](mailto:info@lselectric-ru.com)

#### • LS ELECTRIC America Western Office (Irvine, USA)

Tel: 1-949-333-3140 E-Mail: [america@ls-electric.com](mailto:america@ls-electric.com)

### Disclaimer of Liability

LS ELECTRIC has reviewed the information in this publication to ensure consistency with the hardware and software described. However, LS ELECTRIC cannot guarantee full consistency, nor be responsible for any damages or compensation, since variance cannot be precluded entirely. Please check again the version of this publication before you use the product.

© LS ELECTRIC Co., Ltd 2015 All Right Reserved.

2024.06