REVISIONS

*The manual number is given on the bottom left of the back cover.

Print Date	*Manual Number	Revision
Nov., 1995	IB (NA) 66589-A	First edition
May, 1996	IB (NA) 66589-B	Overall, revision, additions/modifications made. Addition 3.4.7, 3.6.6, APPENDIX 4 to APPENDIX 6 Correction CONTENTS, 1.3, 2.1, 2.5, 3.3.1, 3.3.2, 3.3.3, 3.3.4, 3.3.5, 3.3.8, 3.3.9, 3.3.10, 3.3.11, 3.3.12, 3.3.15, 3.3.18, 3.3.19, 3.3.21, 3.3.23, 3.3.24, 3.4.5, 3.5.2, 3.6.1, 3.6.2, 3.6.4, 5.1, Program example of Chapter 6 to Chapter 11, 13.1

SAFETY CAUTIONS

(You must read these cautions before using the product)

In connection with the use of this product, in addition to carefully reading both this manual and the related manuals indicated in this manual, it is also essential to pay due attention to safety and handle the product correctly.

The safety cautions given here apply to this product in isolation. For information on the safety of the PC system as a whole, refer to the CPU module User's Manual.

These **SAFETY CAUTIONS** are classified into two grades: "DANGER" and "CAUTION".

DANGER	Safety caution given when incorrect handling could result in hazardous situations involving the possibility of death or serious injury.
CAUTION	Safety caution given when incorrect handling could result in hazardous situations involving the possibility of moderate or light injury or damage to property.

Note that, depending on the circumstances, failing to follow a **CAUTION** may also have very serious consequences.

Both of these classes of safety caution are very important and must be observed.

Store this manual carefully in a place where it is accessible for reference whenever necessary, and forward a copy of the manual to the end user.

[Cautions on Design]

DANGER

- To ensure that the system as a whole will continue to operate safety even if there is a fault in the external power supply or in the PC itself, provide a safety circuit external to the PC. Otherwise, accidents may be caused by erroneous outputs and malfunctions.

  (1) Construct interlock circuitry to prevent damage to the machine, such as an emergency stop circuit, positioning upper/lower limit interlock, etc., external to the PC.

  (2) Home position return operations are controlled by two data: the home position return direction and the home position return speed, and deceleration starts when the near-point dog comes ON. Consequently, if an incorrect home position return direction is set, motion may continue without deceleration. To prevent damage to the machine if this happens, construct a circuit such as an interlock circuit external to the PC.

  (3) When the module detects as error, a normal deceleration to stop or emergency stop is executed in accordance with the setting for stop group n in the parameters. Match the parameter settings to the system specifications.
  Also, set home position return data and positioning data with values no greter than the values specified in the porameters.

CAUTION

- Do not bundle the control wire and communication cable with the main circuit or power line or keep them close to one another.
  Keep the control wire and the communicaiton cable at least 100 mm away from the main circuit or power line: otherwise, noise or malfunctions will occur.

[Cautions on Installation]

DANGER

- Use the PC in the environment specified in the General Specifications section in this manual. Using it in an environment which does not meet the general specifications could cause electric shock, fire or malfunctions, and damage or deterioration of the module.
- Install the module by engaging the module mounting projections on the lower part of the module in the mounting holes of the base unit. Incorrect installation could result in malfuncitons, failure of detachment.
- Engage the drive unit connector and peripheral device connector securely with the connectors on the module: you will hear a click on engagement. Failure to engage the connectors properly could result in a faulty connection, leading to erroneous inputs and outputs.
- If no drive unit is connected, be sure to fit the cover on the connector. Failure to fit the cover could result in malfunctions.

[Cautions on Wiring]

CAUTION

- Carry out wiring to the module correctly, checking the terminal arrangement.
- Take all possible measures to prevent chips or wire scraps from entering the module. Entry of foreign material will cause fire, failure of malfunctions.

[Cautions on Start-Up and Maintenance]

DANGER

- Switch the power off before cleaning the module. If the power is left on, the module will break down or malfunction.

CAUTION

- Do not disassemble or tamper with the module. This will cause failure, malfunctions, injuries or fire.
- Switch the power OFF before installing or removing the module. If the power is left on, the module will break down or malfunction.
- For test operation, set lower speed restriction values in the parameters and make sure that motion can be stopped immediately in the event of any hazard before starting the operation.

[Cautions on Method of Use]

CAUTION

- When specifying the speed for the reference axis in an interpolation operation, note that the speed for the corresponding axis (second axis) may be greater than the set speed (i.e. greater than the speed restriction).

[Cautions on Disposal]

CAUTION

- Dispose of this product as industrial waste.

INTRODUCTION

Thank you for choosing the Mitsubishi MELSEC-A Series of General Purpose Programmable Controllers. Please read this manual carefully so that the equipment is used to its optimum. A copy of this manual should be forwarded to the end User.

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About Manuals

The manuals related to this positioning module are listed below.
Please order those you require.

Related Manuals

Manual Title	Manual No. (Type Code)
AD75P1/P2/P3 Type Positioning Module User's Manual (Hardware) Describes the performance specifications, I/O interface, nomenclature and start-up procedure of the AD75P1/P2/P3 type positioning modules. (Packed with the module)	IB-66585
A1SD75P1/P2/P3 Type Positioning Module User's Manual (Hardware) Describes the performance specifications, I/O interface, nomenclature and start-up procedure of the A1SD75P1/P2/P3 type positioning modules. (Packed with the module)	IB-66584
SW0IVD-AD75P Type Positioning Module Software Package Operating Manual Describes how to use the above software package to create and transmit data (parameters, positioning data, etc.) to a positioning module, and perform positioning monitoring and testing. (Packed with each software package)	IB-66596

Manual Organization

This manual contains the general description, specifications, and details on functions and their use, connection to external devices, and the programming method, for the positioning modules indicated in Chapter 1.

(1) Chapter 1
Gives a general description of each positioning function, and the features of the positioning module.

(2) Chapter 2
Describes the system configuration and devices required for positioning, and gives the precautions on system configuration.

(3) Chapter 3
Describes the specifications and functions of the positioning module, and I/O signals from/to the PC CPU and buffer memory.

(4) Chapter 4
Describes the start-up procedure, handling and operation of the positioning module, and wiring with external devices.

(5) Chapters 5 to 11
These sections describe the software settings and programming required to use each function, including home position return and positioning.

(6) Chapter 12
Describes the program to set clock data, parameters, home position return data, positioning data and start information, from a sequence program.

(7) Chapter 13
Describes error and warning codes displayed when errors occur, and troubleshooting.

(8) APPENDICES
Describe the processing time of the positioning module, examples of connections to external devices, etc.

POINT

This manual describes the functions and method of use of the AD75P3 and A1SD75P3, both of which control three axes.
When using a positioning module controlling two axes or one axis, ignore the descriptions relating to these modules.
(Example) When using an AD75P1 or A1SD75P1, ignore the information relating to the following:
- Interpolation operation, simultaneous start
- I/O signals and buffer memory for controlling second and third axes
- Positioning parameters and data for controlling second and third axes

1. GENERAL DESCRIPTION

This manual describes the specifications, start-up procedure, positioning functions and their use, and programming method of the positioning modules indicated below (hereafter called the AD75).

Number of Controllable Axes	Module Type	
	For Building Block Type	For Compact Building Block Type
1 axis	AD75P1	A1SD75P1
2 axes	AD75P2	A1SD75P2
3 axes	AD75P3	A1SD75P3

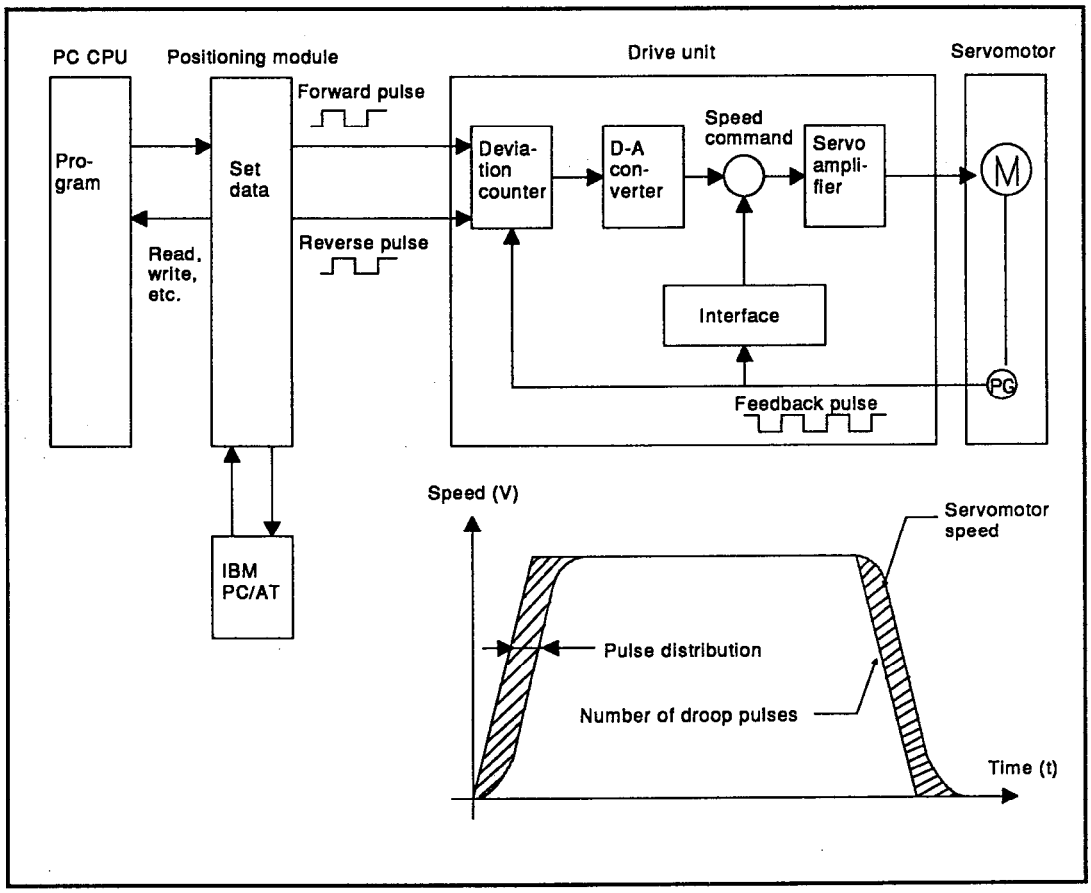


Fig. 1.1 Positioning Control Block Diagram

1.1 Features

The AD75 has the following features:

(1) Wide variety of positioning modules for 1-axis to 3-axis control

(a) A wide variety of positioning modules (six types) are available for 1-axis to 3-axis control.
The most suitable positioning module for the PC CPU type and the number of axes to be controlled can be selected.

(b) Two or more AD75s can be mounted at the same base unit slot, and the number of PC CPU I/O points occupied by each module is 32.
Any number of modules can be mounted provided the number of occupied I/O points they require exceeds the number of points available at the PC CPU.

(2) Diverse positioning control functions

(a) The AD75 incorporates diverse functions that enable the positioning system to control positioning to any specified position and execute fixed-pitch feed control, constant speed control, etc.
Section 1.2 outlines each of the positioning control functions.

1) Up to 600 data items, including positioning addresses, control method and operation pattern, can be set per axis.
This positioning data is used to position each axis in "independent operation" and "multi-axis (simultaneous) operation".

2) Linear control can be performed during positioning of each axis (simultaneous linear control of three axes is possible), and positioning can be executed on the basis of a single positioning data setting or by consecutively processing two or more data settings.

3) In multi-axis positioning, linear interpolation control and circular interpolation control can be performed with two axes. Positioning on each axis can be executed on the basis of a single positioning data setting or by consecutively processing two or more data settings.

(b) Position control, speed control or speed/position switching control can be specified as the control method for positioning data.

(c) The operation pattern set by the user as positioning data allows continuous positioning on each axis or on two or more axes on the basis of multiple positioning data settings.
These multiple positioning data settings are contained in a "block", and continuous positioning extending over more than one block is possible.

(d) Improved home position return control

1) Six home position return methods - near-zero point dog (one type), stopper (three types) and count (two types) - are available.

2) A home position return retry function is provided for positioning from any position to the machine home position.

(e) Either automatic trapezoidal acceleration/deceleration or S-pattern acceleration/deceleration can be selected as the acceleration/deceleration method.

(3) Faster start processing

Faster processing at the start of positioning has reduced the start processing time to 20 ms.
There is no delay between the axes when a simultaneous start is executed (independent operation, interpolation operation).

(4) Faster pulse output and longer distance between the module and the drive unit

(a) The AD75 is equipped with a differential driver pulse output interface and an open collector pulse output interface.
Connect the drive unit to the correct interface for the type of drive unit.

(b) Connecting the AD75 to a differential driver increases the pulse output speed and the possible communication distance.

- When connecting the AD75 to a differential driver
  : 400 kpps, max. 30 m
- When connecting the AD75 to an open collector
  : 200 kpps, max. 3 m

(5) Easy maintenance

The following points facilitate the maintenance of the AD75:

(a) Positioning data, parameters and other data are stored in the internal flash ROM of the AD75.
The data can therefore be retained without a battery.

(b) A 17-segment display shows errors, mechanical system input status and zero point input status.

(c) Errors are categorized to improve primary diagnosis performance.

(d) Since up to 16 of latest errors or warnings can be stored for each axis, it is easy to identify any error or warning which has occurred.

1.2 General Description of Positioning Control Functions

This section describes the AD75's positioning control functions.

1.2.1 Positioning control

Positioning on the basis of the positioning data is described below.

(1) Linear positioning control

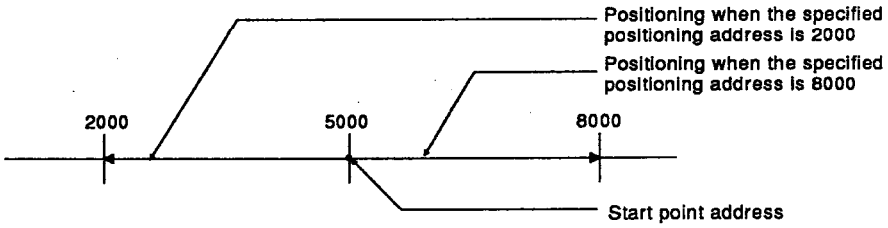
(a) 1-axis linear positioning control

This function controls positioning of a selected axis from the start point address (present stop position) to the specified position.

Control by absolute data method

1) This method controls positioning from the start point address to the specified positioning address.
2) The travel direction depends on the start point and specified positioning addresses.

[Example]
The figure below shows positioning control when the start point address is 5000 and the specified positioning addresses are 2000 and 8000.

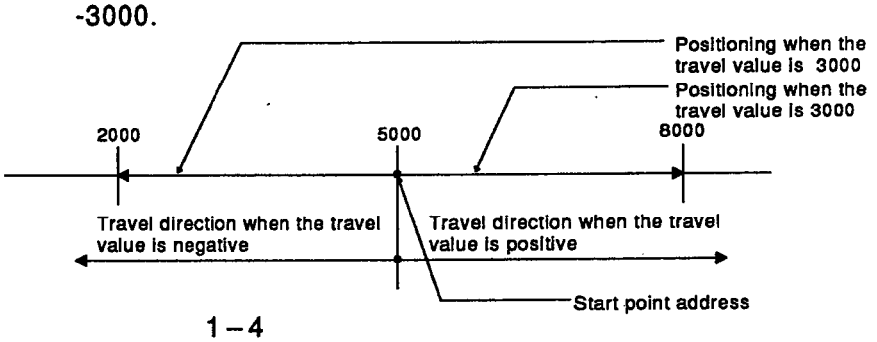


Control by incremental method

1) This method controls positioning for the specified travel value from the start point address.
2) The travel direction depends on the travel value sign.

- + travel direction ..... Positioning in forward direction (direction in which addresses increase)
- – travel direction ..... Positioning in reverse direction (direction in which addresses decrease)

[Example]
The figure below shows positioning control when the start point address is 5000 and the specified travel values are 3000 and -3000.



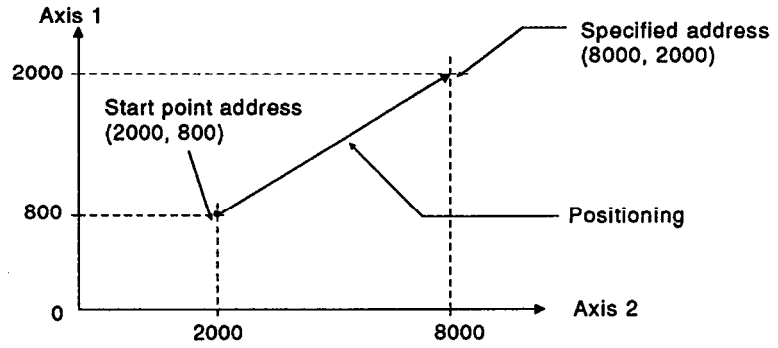
(b) 2-axis linear interpolation control *

This function performs linear interpolation control from the start point address (present stop position) using two specified axes.

Control by absolute data method

1) This method uses two axes to perform linear interpolation from the start point address to the specified positioning address.
2) The travel direction depends on the start point and specified positioning addresses of each axis.

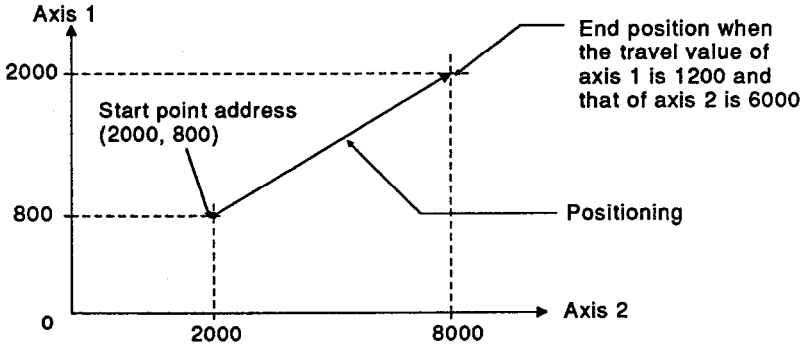
[Example]
The figure below shows positioning control when the start point address and specified positioning address of axis 1 are 800 and 2000 and those of axis 2 are 2000 and 8000.



Control by incremental method

1) This method controls positioning from the start point address to the position determined by the travel direction and distance specified for each axis.
2) The travel direction of each axis depends on the travel value sign.
   • + travel value ..... Positioning in forward direction (direction in which addresses increase)
   • - travel value ..... Positioning in reverse direction (direction in which addresses decrease)

[Example]
The figure below shows positioning control when the start point address and specified travel value of axis 1 are 800 and 2000 and those of axis 2 are 2000 and 8000.



REMARK

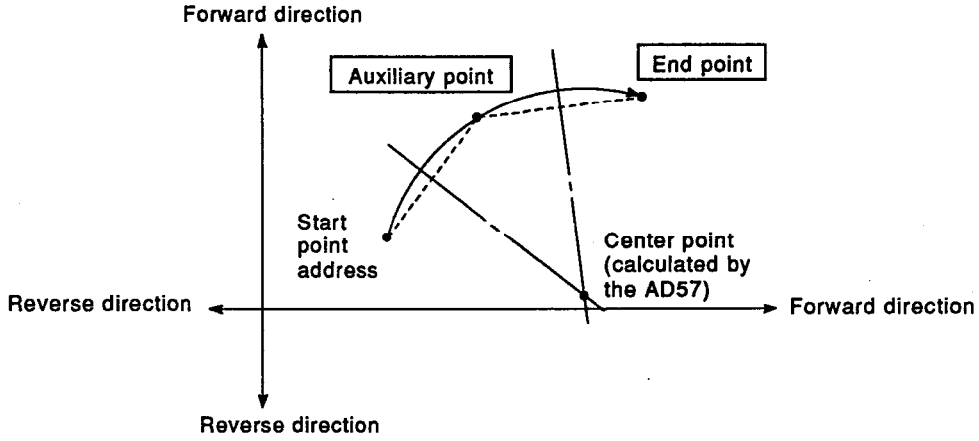
The interpolation speed for linear interpolation can be designated as either the "resultant speed" or "reference axis speed" in the extended parameter settings.
(For details on the extended parameters, See Section 3.4.2.)

(2) Circular interpolation positioning control *

Circular interpolation positioning control is classified into circular interpolation by designating an auxiliary point, and circular interpolation by designating a center point.

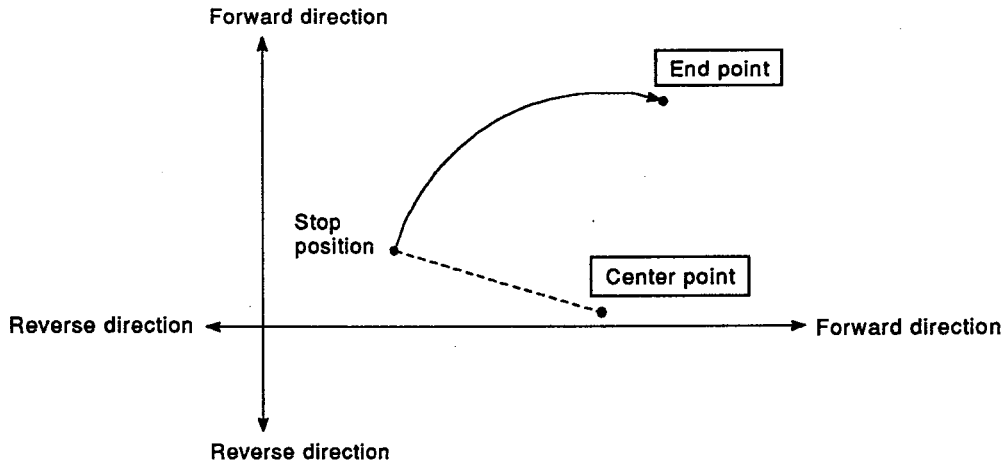
(a) Circular interpolation control by specifying an auxiliary point

This circular interpolation control is performed by designating an end point and an auxiliary point (pass point) for circular interpolation.
The absolute data method or incremental method can be used.



(b) Circular interpolation control by designating a center point

This circular interpolation control is performed by designating the end point and center point of a circle for circular interpolation.
The absolute dada method or incremental method can be used.
The clockwise or counter-clockwise direction can be selected.



REMARK

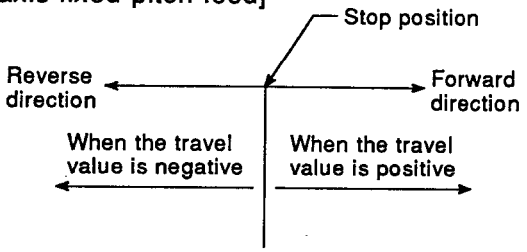
The interpolation speed for arc interpolation can be designated as either the "resultant speed" or "reference axis speed" in the extended parameter settings.
(For details on the extended parameters, See Section 3.4.2.)

(3) Fixed-pitch feed control

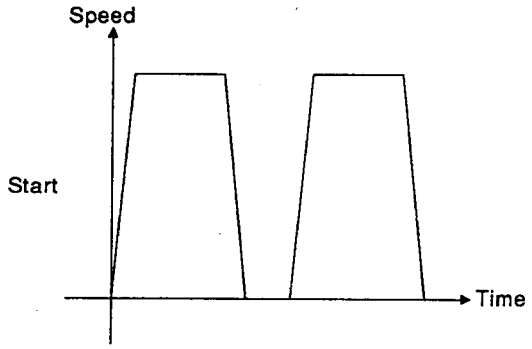
This function controls positioning for a specified travel value.
One-axis fixed-pitch feed control and fixed-pitch feed control by 2-axis linear interpolation are available.

Positioning direction

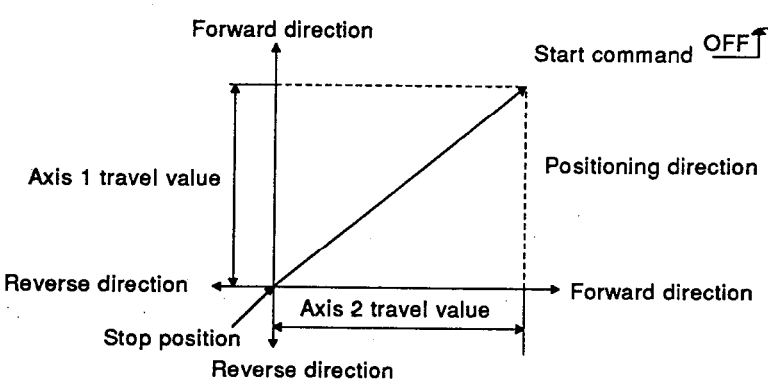
[1-axis fixed-pitch feed]

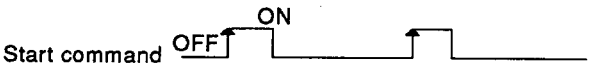


Operation timing



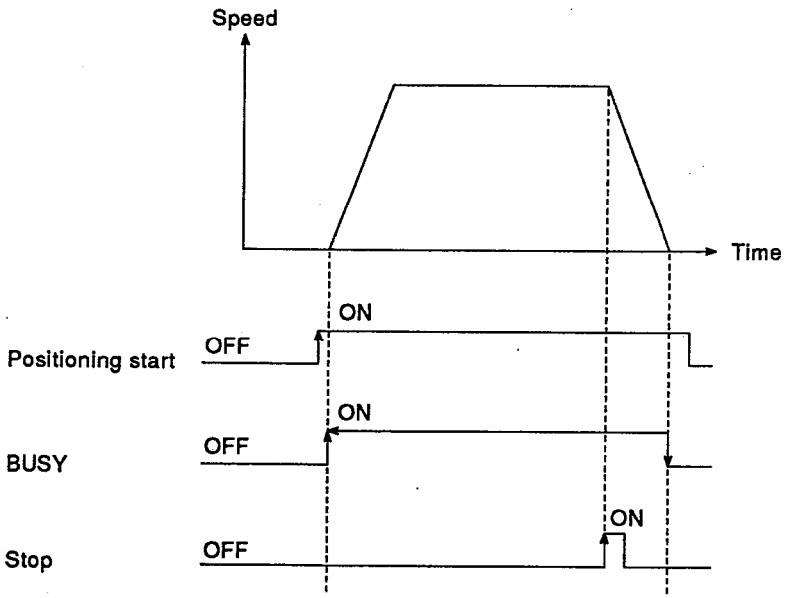
[2-axis fixed-pitch feed]





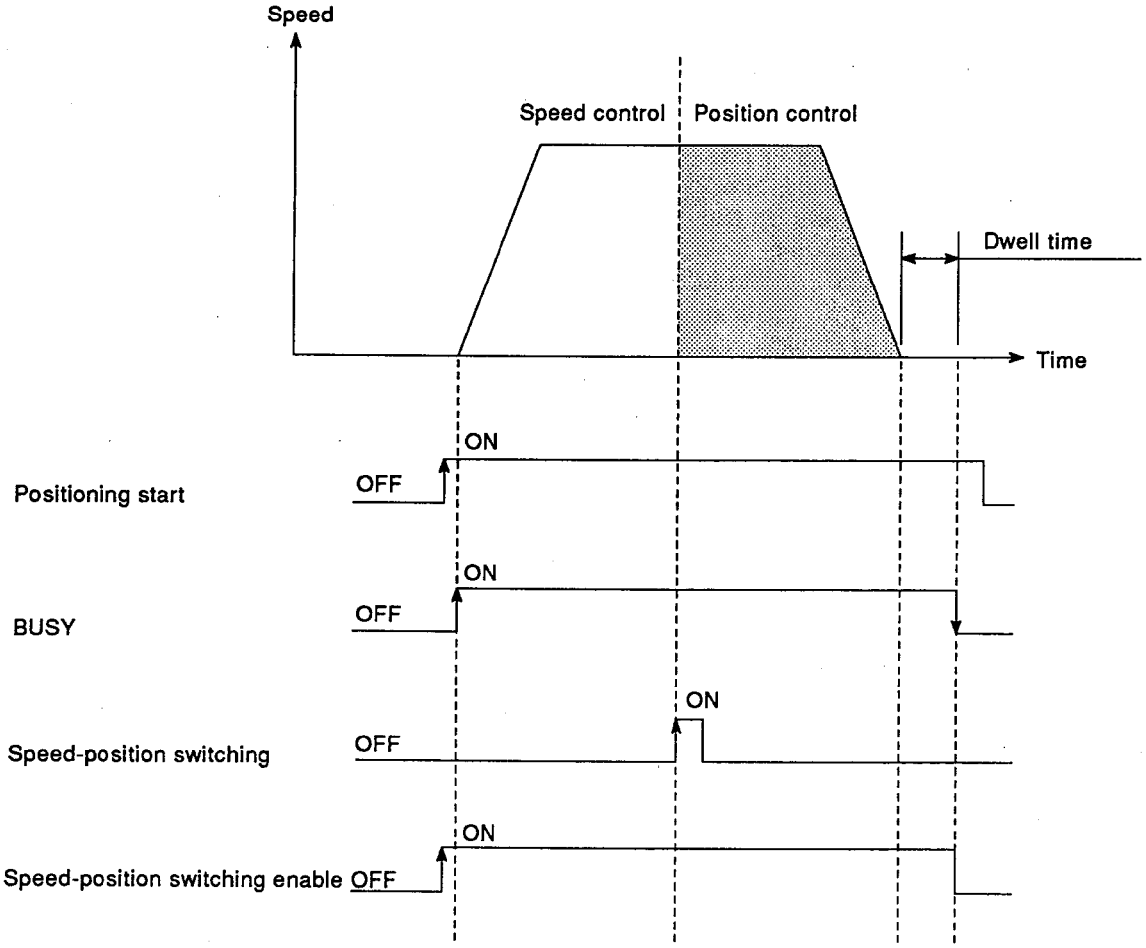
(4) Speed control

Positioning control is performed at the command speed until a stop command is issued after execution of an instruction



(5) Speed-position switching control

When a speed-position switching signal is input during speed control positioning, the control mode switches to position control to perform positioning for a specified travel value.



1.2.2 Individual positioning/continuous positioning control

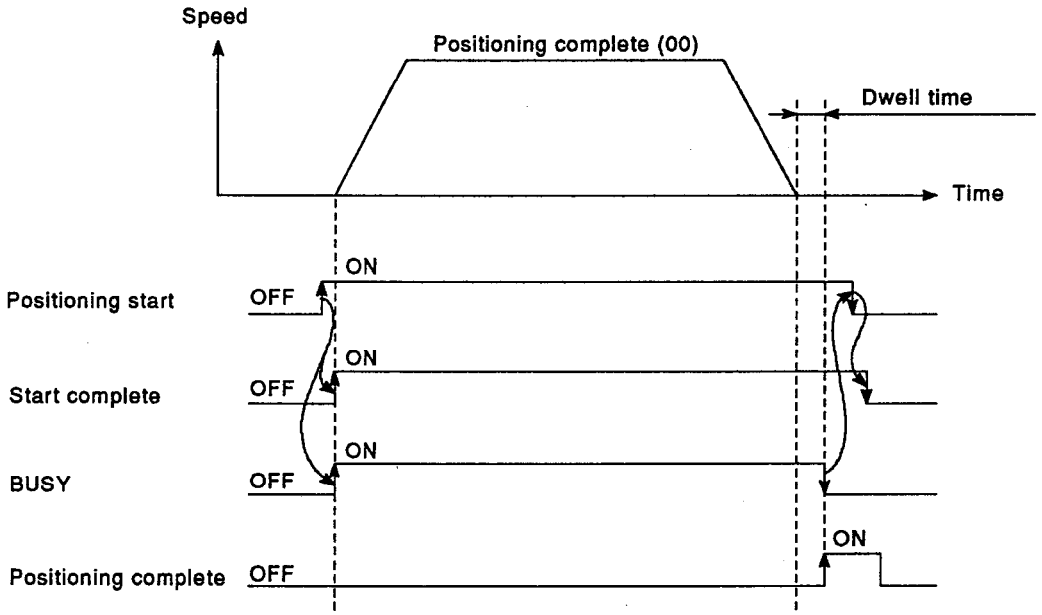
The AD75 performs positioning control according to a set of positioning data set by the user, including control method (position control, speed control or speed-position switching control), positioning addresses and operation pattern.

Up to 600 positioning data can be stored per axis in positioning data Nos. 1 to 600 of the AD75.

Whether positioning according to single positioning data setting or continuous positioning using multiple positioning data settings is performed depends on the operation pattern set by the user as positioning data.

(1) Individual positioning control
(operation pattern = 00: positioning complete)

On completion of positioning in accordance with the specified positioning data, the system stops positioning.
Individual positioning control is also used as the operation pattern for the final positioning data in continuous positioning and continuous locus positioning on completion of positioning in accordance with this operation pattern.

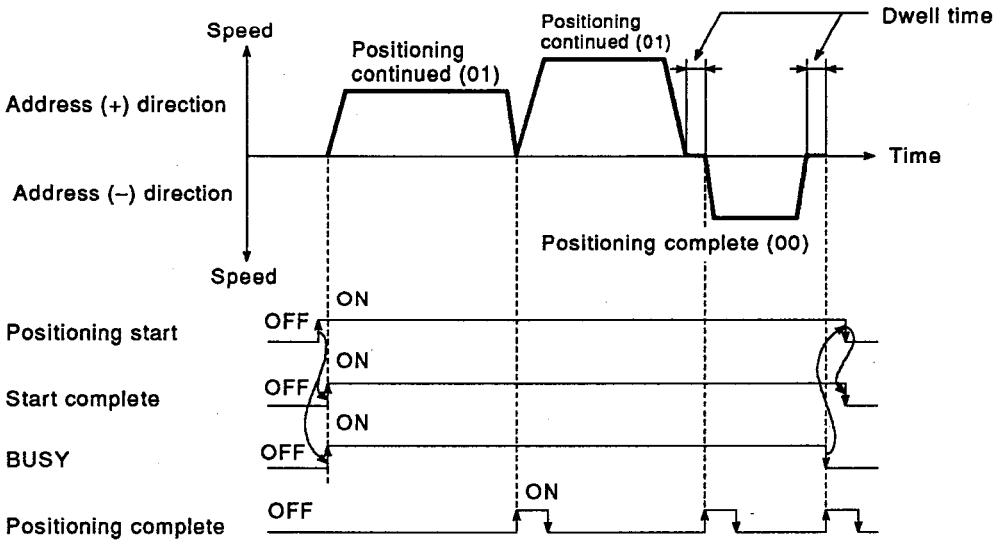


REMARK

Up to 100 positioning data (positioning data No.1 to 100) per axis can be set in the AD57 buffer memory with the sequence program.

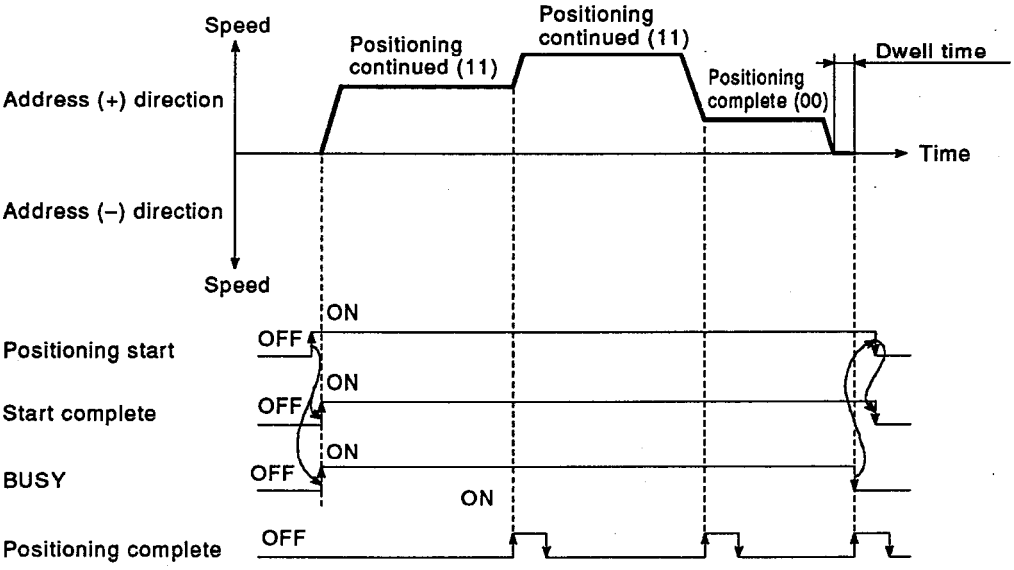
(2) Continuous positioning control
(operation pattern = 01: positioning continued)

The system temporarily stops positioning on completion of positioning using specified positioning data, then restarts positioning based on the data of the next positioning data number.
This mode is selected to perform continuous positioning with direction changes, based on multiple positioning data settings with consecutive numbers.



(3) Continuous locus positioning control
(operation pattern = 11: positioning continued)

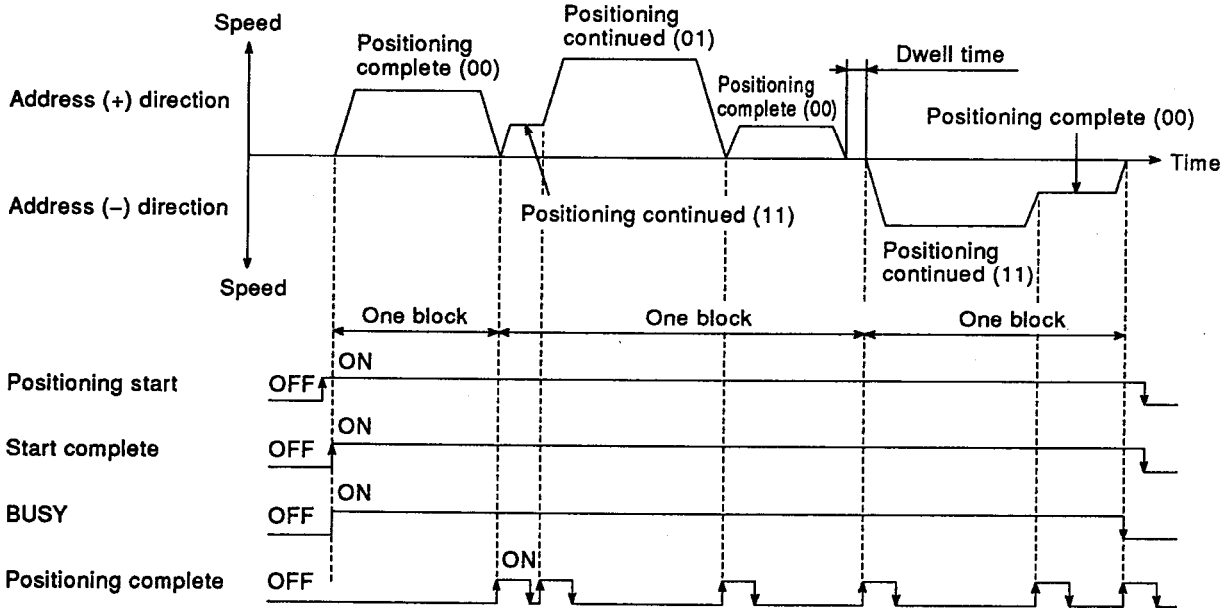
After executing positioning using specified positioning data, the system continues positioning at the speed specified for the next positioning data number.
This mode is selected to perform continuous positioning at a specified speed, based on multiple positioning data settings with consecutive numbers.



1.2.3 Block positioning control

The block positioning control function allows consecutive execution of a number of specified blocks.
A "block" is a single positioning control sequence up to "positioning complete" (operation pattern = 00) in the individual positioning or continuous positioning control mode.
Up to 50 blocks can be specified per axis.

This function allows complicated positioning control to be performed with only one start command from the ACPU or an external device.
To execute block positioning control, the positioning start number and its information must be written to the buffer memory.



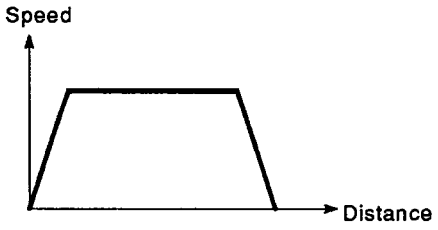
1.2.4 Acceleration/deceleration processing

During positioning, manual pulse generator operation, home position return or JOG operation, acceleration/deceleration processing takes place according to the user-specified method and acceleration and deceleration times.

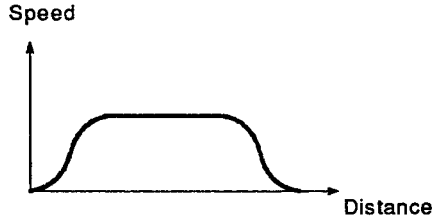
(1) Acceleration/Deceleration method

There are two acceleration/deceleration methods, "automatic trapezoidal acceleration/deceleration" and "S-pattern acceleration/deceleration": the method used is selected in the detailed parameter settings. The specified acceleration/deceleration processing method applies to acceleration/deceleration in all of the following operations: positioning, home position return, JOG operation start and end, speed change, etc.

(a) Automatic trapezoidal acceleration/deceleration method
This method performs linear acceleration and deceleration based on the user-set acceleration and deceleration times and the speed control limit.



(b) S-pattern acceleration/deceleration method
This method reduces the load on the motor when it starts and stops. Gradual acceleration/deceleration is performed based on the user-set acceleration and deceleration times, speed control limit and S-curve ratio (1 to 100%).



(2) Acceleration time, deceleration time, rapid stop/deceleration time

(a) Up to four acceleration times (1 to 65535 ms) and deceleration times (1 to 65535 ms) for positioning control can be specified when setting basic parameters and extended parameters.

- Acceleration time ..... Time required to accelerate from 0 to the speed control limit.
- Deceleration time ..... Time required to decelerate from the speed control limit to 0.

(b) Specify the rapid stop deceleration time (1 to 65535 ms) when setting the extended parameters.

1.2.5 Restart

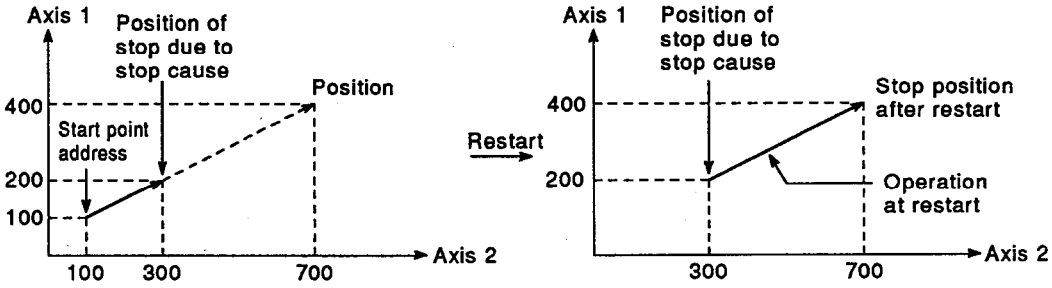
The restart command enables the machine to restart and move to the end point of the positioning data if the machine comes to a stop during positioning control due to a stop cause.

(1) When there is a restart command in the buffer memory

(a) When the axis is at a stop, positioning restarts from the present axis position and continues to the end point of the positioning data regardless of whether the absolute data method or incremental method is selected.

(b) When the axis in a state other than stopped or on standby, a restart disabled warning (error code: 104) is triggered and the restart command is ignored.

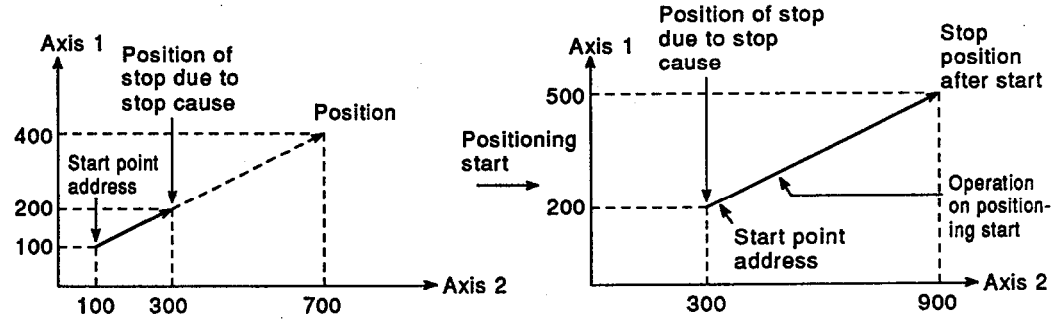
[Incremental method]
Operation when the axis 1 travel vale is 300 and the axis 2 travel value is 600.



(2) When a positioning start signal (Y10 to Y12) or external start signal is turned ON

When the axis is on standby or at a stop, positioning restarts from the beginning of the positioning start data regardless of whether the absolute data method or incremental method is selected (same as regular positioning).

[Incremental method]
Operation when the axis 1 travel value is 300 and the axis 2 travel value is 600.



1.2.6 Home position return

The home position return function is used to confirm that the machine is at the home position when the power is switched on, etc.

There are six home position return methods.

(1) Near-zero point dog method (one type)

This method stops axis motion in response to a zero-point signal after the near-zero point dog has gone OFF.

(2) Stopper method (three types)

(a) Stopper (1) (on lapse of dwell time)

In this method home position return is completed on elapse of the dwell time after axis motion has been decelerated by turning ON the near-zero point dog, then stopped by the stopper.

(b) Stopper (2) (by zero-point signal issued when the machine contacts the stopper)

In this method home position return is completed on receipt of the zero-point signal after axis motion has been decelerated by turning ON the near-zero point dog, then stopped by the stopper.

(c) Stopper (3) (method without a near-zero point dog)

In this method home position return is completed on receipt of the zero-point signal after travel at the creep speed and stopping of axis motion by the stopper.

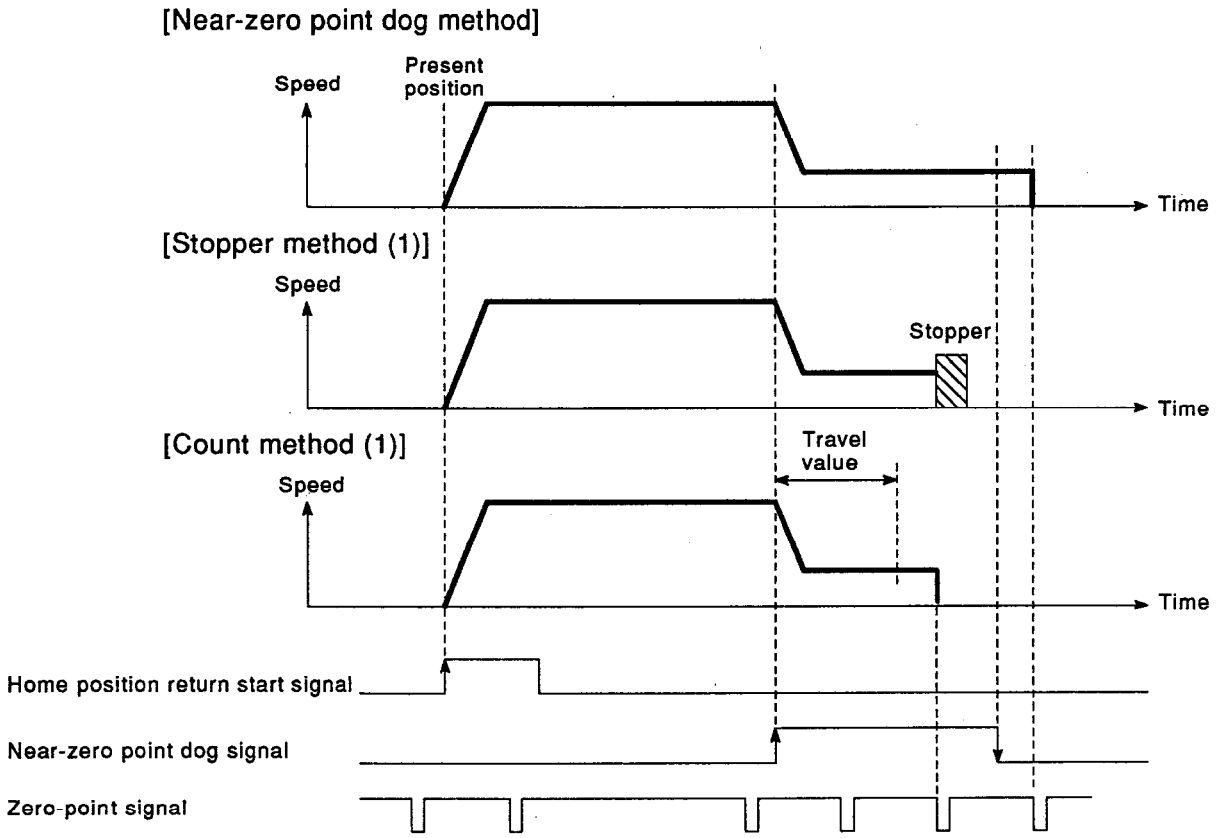
(3) Count method (two types)

(a) Count method (1) (using a zero-point signal)

In this method, axis motion is stopped by a zero-point signal which is issued after travelling for the specified travel value after the near-zero point dog has come ON.

(b) Count method (2) (not using a zero-point signal)

In this method, axis motion is stopped as soon as the machine has traveled for the specified travel value after the near-zero point dog has come ON.



REMARKS

1) Home position return can be performed by the home position return retry function using upper and lower limit switches.

2) After the home position has been established by using the home position return function, it is possible to travel until the machine feed value is equal to the home position address. (This process is the same as positioning to the home position.)

1.3 Comparison with Conventional Positioning Modules

Table 1.1 shows a comparison of specifications between the AD75 and the conventional positioning modules AD71(S1), AD71S2 and A1SD71S2.

Table 1.1 Comparison between AD75 and Conventional Positioning Modules

Specification \ Type	A1SD75P1 AD75P1	A1SD75P2 AD75P2	A1SD75P3 AD75P3	AD71(S1)	A1SD71S2 AD71S2
Number of controlled axes	1 axis	2 axes	3 axes	2 axes	
Number of sets of positioning data	600/axis *1			400/axis	
Interpolation function	——			——	
2-axis linear interpolation	O			O	
2-axis circular interpolation	O			X	
Positioning method	——			——	——
Position control	O			O	O
Speed control	O			X	O
Speed-position switching control	O			X	O
Home position return function	O (6 ways)			O	
JOG operation function	O			O	
Manual pulse generator operation	O			O	X
Acceleration/Deceleration processing	——			——	
Automatic trapezoidal acceleration/deceleration	O			O	
Automatic S-pattern acceleration/deceleration	O			X	
Acceleration/Deceleration time	Acceleration and deceleration times can be set (four patterns each).			The acceleration and deceleration times are the same.	
Compensation	Electronic gear, backlash compensation			Backlash compensation	
Error display	17-segment display			Error LED	
Past data storage (starts, errors, warnings)	Possible (4 types * 16/axis)			Impossible	
Data storage memory	Flash ROM (backup without battery)			Buffer memory (battery backup)	
Number of I/O points	32			32	32 (48) *2
Number of points occupied by module	1			1	1 (2) *3
Peripheral device (data setting, etc.)	——			——	
AD71TU	X			O	
A6GPP, A6PHP	X			O	
IBM PC/AT	X			X	

O: Enable X: Disable

REMARKS

1) *1: The positioning data that can be set using the AD75 buffer memory is positioning data 1 to 100 (i.e. 100 data items) for each axis.
Note that the positioning data in the buffer memory is not backed up.
2) *2: The number of I/O points for an A1SD71S2 is 48.
3) *3: An A1SD71S2 occupies two slots.

1.4 Generic Names, Abbreviations and Terms Used in This Manual

Generic Name/Abbreviation/Term	Description
• Peripheral device	Generic name for IBM PC/ATs which can run the AD75Ps indicated below (differentiated from the "peripheral device for GPP" described below).
• Drive unit (servo amplifier)	Common name of a pulse input processing drive unit (servo amplifier).
• Manual pulse generator	Common name of a manual pulse generator (prepared by the user).
• Data link system	Common name of the MELSECNET (II) or MELSECNET/B data link system.
• Network system	Common name of the MELSECNET/10 network system.
• ACPU	Generic name of an A series PC CPU in which an AD75 can be loaded.
• AD75	Generic name for the AD75P1, AD75P2, AD75P3, A1SD75P1, A1SD75P2 and A1SD75P3 positioning modules. The individual model name is used when referring to a specific module type.
• AD75P	Generic name for SW[ ]IVD-AD75P software packages (the number corresponding to the software package function is indicated in the square brackets [ ]).
• H/W	Abbreviation for hardware.
• I/F	Abbreviation for interface.
• GPP function peripheral device	Generic name of an A6GPP, IBM PC/AT, etc. in which a GPP function software package has been installed (differentiated from "peripheral device" above).
• S/W	Abbreviation for software package.
• 17-segment LED	A 17-segment display on the upper part of the front of the AD75.

1.5 Packed Components

The following table shows the components packed with the AD75.

When unpacking, confirm that all of the following are contained in the package.

Component	Quantity					
AD75P1 type positioning module	1					
AD75P2 type positioning module		1				
AD75P3 type positioning module			1			
A1SD75P1 type positioning module				1		
A1SD75P2 type positioning module					1	
A1SD75P3 type positioning module						1
External wiring connector (made by Sumitomo 3M)	—	—	—	—	—	—
Connector (10136-300VE)	1	2	3	1	2	3
Connector cover (10336-56F0-008)	1	2	3	1	2	3

MEMO

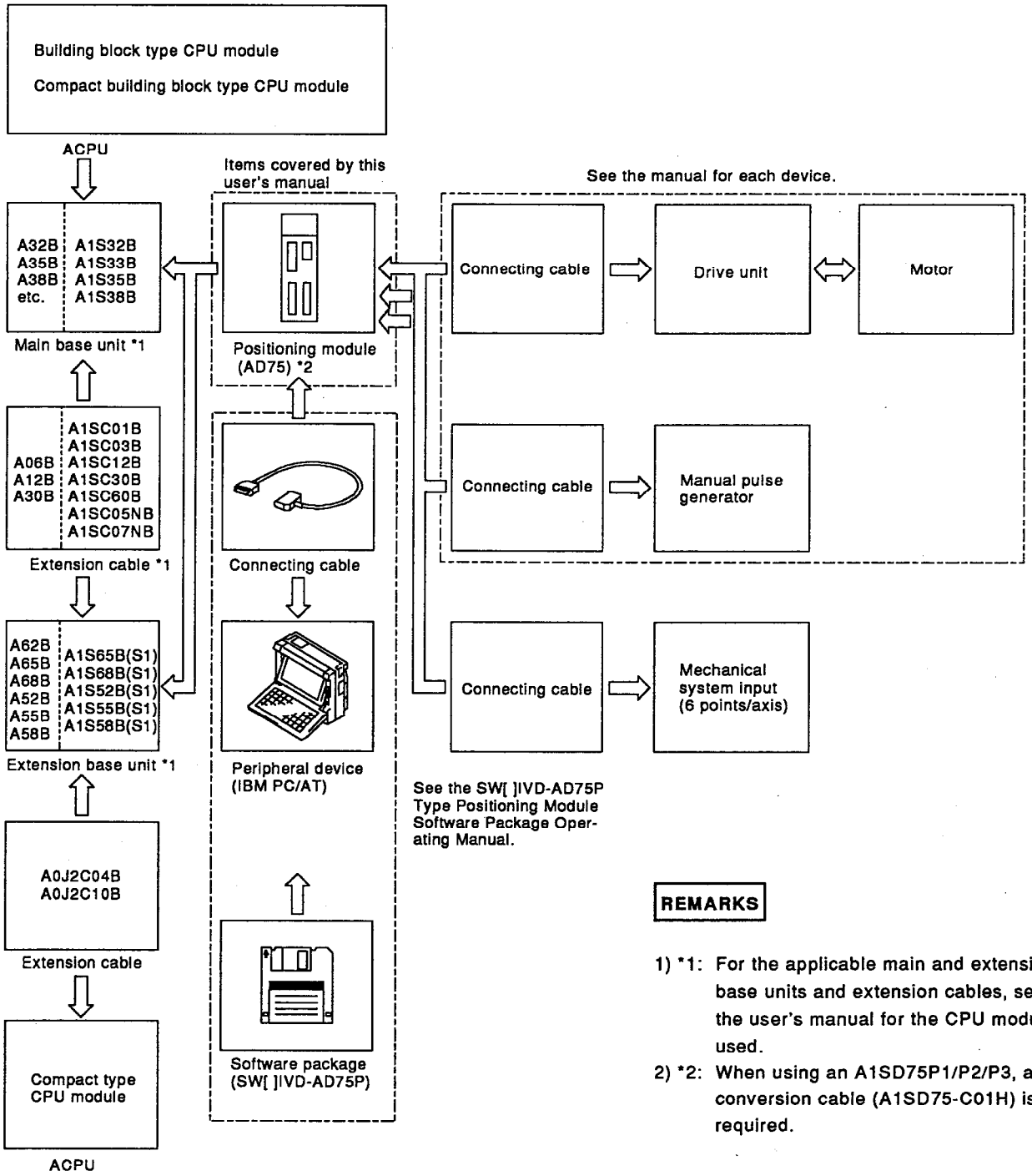
2. SYSTEM CONFIGURATION

This chapter describes the system configuration and system components required for positioning by the AD75.

For details of system configuration using an AD75, see the SW[ ]IVD-AD75P Positioning Module Software Package Operating Manual.

2.1 Overall Configuration

The following figure shows the overall configuration, including an AD75, a PC CPU module and peripheral devices.



REMARKS

1) *1: For the applicable main and extension base units and extension cables, see the user's manual for the CPU module used.
2) *2: When using an A1SD75P1/P2/P3, a conversion cable (A1SD75-C01H) is required.

2.2 Applicable Systems

This section describes PC systems compatible with the AD75, and precautions on system configuration.

(1) PC CPUs

(a) AD75P1(P2/P3)

The AD75P1(P2/P3) type positioning module can be used with the following PC CPUs (including those with a link function):

• A0J2CPU	• A0J2HCPU	• A1CPU	• A2(S1)CPU	• A3CPU
• A1NCPU	• A2N(S1)CPU	• A3NCPU	• A3MCPU	• A3HCPU
• A2A(S1)CPU	• A3ACPU	• A2U(S1)CPU	• A3UCPU	• A4UCPU
• A73(S3)CPU	• A81CPU	• A52GCPU		
• A1SCPU(S1)	• A1SJCPU	• A2SCPU(S1)	• A2AS(S1/S30)CPU	
• Q2A(S1)CPU	• Q3ACPU	• Q4ACPU		

* The A73(S3)CPU and A373CPU can be mounted on an extension base unit.

(b) A1SD75P1(P2/P3)

The A1SD75P1(P2/P3) type positioning module can be used with the following PC CPUs (including those with a link function):

• A1SCPU(S1) • A1SJCPU • A2SCPU(S1) • A2AS(S1/S30)CPU • A52GCPU

(2) Remote I/O station (MELSECNET/10, MELSECNET (II), MELSECNET/B)

The AD75P1(P2/P3) and A1SD75P1(P2/P3) type positioning modules can be used at remote I/O stations of data link systems or network systems, except for the A0J2P25/R25 (remote I/O station).

POINT

One AD75 requires one slot of the base unit, and occupies 32 I/O points of the PC CPU.
Any number of AD75s can be loaded unless the number of occupied I/O points exceeds that of the PC CPU.

2.3 Precautions on System Configuration

The AD75 can be loaded in any slot of a main or extension base unit, but note the following points:

(1) When mounting the AD75 to an extension base unit without a power supply, give careful consideration to the power supply capacity and voltage drop.

(2) The AD75P1(P2/P3) cannot be loaded in the final slot of the seventh extension stage of the A3CPU.

(3) The AD75P1(P2/P3) cannot be mounted on the main base unit of an A73(S3)CPU. Note also that simultaneous starting or interpolation operation with axes controlled by the A73(S3)CPU is not possible.

(4) The A1SD75P1/P2/P3 cannot be mounted next to the extension power supply module of an extension base unit.

(5) The AD75 cannot be mounted at an A0J2P25/R25 (remote I/O station).

(6) For details on mounting the AD75 on a PC CPU or base unit, see the user's manual for the PC CPU used.

2.4 Precautions on Using a Stepping Motor

The following functions of the AD75 are not available when a stepping motor is used:

- S-pattern deceleration processing
- Circular interpolation control

2.5 List of System Components

Table 2.1 shows the components that can be used in a positioning system using an AD75.

Table 2.1 System Components

Component Name	Type	Remarks	
Positioning module	AD75P1 AD75P2 AD75P3 A1SD75P1 A1SD75P2 A1SD75P3	A[ ]D75P[ ] ↑ └—— Number of controllable axes	
Software package for AD75	SW[ ]IVD-AD75P	Software package for IBM PC/AT	
Peripheral device for AD75P	IBM PC/AT	(Prepared by user) For details, see the AD75P Operating Manual.	
Conversion cable	A1SD75-C01H	Length 10 cm	Cable to connect an RS-422 cable and A1SD75P [ ].
Connecting cable (converter)	—	The RS-232C cable and RS-232C/RS-422 converter connected between the AD75 and the IBM PC/AT (prepared by the user). For details, see the AD75P Operating Manual.	
Drive unit	—	(Prepared by user)	
Manual pulse generator	—	(Prepared by user) Recommendation: MR-HDP01	
Connecting cable	—	The cable to connect the AD75 and the drive unit or manual pulse generator. (Prepared by the user) For details, see the manual for the device to be connected.	
Connecting cable	—	The connecting cable for mechanical system input signals to the AD75. (Prepared by the user) For details, see the manual for the device to be connected.	
User's floppy disk	SW0S-USER	2HD type	For storing user programs and set data (3.5-inch fomatted)

3. SPECIFICATIONS

This chapter describes the AD75's specifications, functions, set data, buffer memory, I/O signals and I/O interface with an external device.

3.1 General Specifications

The following table shows the general specifications of the AD75.

Table 3.1 General Specifications

<table>
<tr><th>Item</th><th colspan="5">Specification</th></tr>
<tr><td>Operating ambient temperature</td><td colspan="5">0 to 55 °C</td></tr>
<tr><td>Storage ambient temperature</td><td colspan="5">-20 to 75 °C</td></tr>
<tr><td>Operating ambient humidity</td><td colspan="5">10 to 90 % RH, no dewing</td></tr>
<tr><td>Storage ambient humidity</td><td colspan="5">10 to 90 % RH, no dewing</td></tr>
<tr><td rowspan="8">Vibration resistance</td><td rowspan="8">Conforms to JIS B 3501 and IEC 1131-2. *1</td><td colspan="4">In case of intermittent vibration</td></tr>
<tr><td>Frequency</td><td>Acceleration</td><td>Amplitude</td><td>Sweep count</td></tr>
<tr><td>10 to 57Hz</td><td>——</td><td>0.075 mm (0.003 inch)</td><td rowspan="5">10 times in each of X, Y and Z directions (for 80 minutes)</td></tr>
<tr><td>57 to 150Hz</td><td>9.8 m/s^2 (1G)</td><td>——</td></tr>
<tr><td colspan="3">In case of continuous vibration</td></tr>
<tr><td>Frequency</td><td>Acceleration</td><td>Amplitude</td></tr>
<tr><td>10 to 57Hz</td><td>——</td><td>0.035 mm (0.0014 inch)</td></tr>
<tr><td>57 to 150Hz</td><td>4.9 m/s^2 (0.5G)</td><td>——</td></tr>
<tr><td>Shock resistance</td><td colspan="5">Conforms to JIS B 3501 and IEC 1131-2. (147 m/s^2 (15 G), 3 times in each of 3 directions)</td></tr>
<tr><td>Operating atmosphere</td><td colspan="5">The operating atmosphere shall not contain corrosive gas.</td></tr>
<tr><td>Operating altitude</td><td colspan="5">2000 m or lower</td></tr>
<tr><td>Installation site</td><td colspan="5">Inside control panel</td></tr>
<tr><td>Overvoltage category *2</td><td colspan="5">11 or lower</td></tr>
<tr><td>Contamination level *3</td><td colspan="5">2 or lower</td></tr>
</table>

*1 JIS: Japanese Industrial Standard

*2 The value indicates the power distribution unit between the public distribution network and the in-plant machinery to which the device is assumed to be connected.
Category II applies to devices powered by fixed equipment.
The surge voltage withstand capability of devices whose rated voltage is 300 V or lower is 2500 V.

*3 This is an index which gives a measure of the incidence of conductive materials in the environment in which the device is used.
A contamination level of "2" indicates an environment in which there is only contamination by non-conducting materials, but, due to occasional condensation, conductivity may occur.

3.2 Performance Specifications

The following table shows the performance specifications of the AD75.

3.2.1 Performance specifications

Table 3.2 Performance Specifications

Item \ Model		A1SD75P1 AD75P1	A1SD75P2 AD75P2	A1SD75P3 AD75P3
Number of controllable axes		Axis 1	Axis 2	Axis 3
Interpolation function		Not available	2-axis linear interpolation 2-axis circular interpolation	2-axis linear interpolation 2-axis circular interpolation
Control method		PTP (Point To Point) control, locus control (both linear and circular modes can be set), speed control, speed/position switching control		
Control unit		mm, inch, degree, pulse		
Positioning data		Peripheral device : 600 data (positioning data No.: 1 to 600)/axis PC program : 100 data (positioning data No.: 1 to 100)/axis only		
Peripheral device		IBM PC/AT: SW0IVD-AD75P		
Backup		Parameters and positioning data are stored in a flash ROM (without a battery).		
Positioning	Positioning method	PTP control : Incremental method/Absolute data method Speed/position switching control : Incremental method Locus control : Incremental method/Absolute data method		
	Positioning range	In absolute data method • -214748364.8 to 214748364.7 (μm) • -21474.83648 to 21474.83647 (inch) • 0 to 359.99999 (degree) • -2147483648 to 2147483647 (pulse) Incremental method • -214748364.8 to 214748364.7 (μm) • -21474.83648 to 21474.83647 (inch) • -21474.83648 to 21474.83647 (degree) • -2147483648 to 2147483647 (pulse) Speed-position switching control • 0 to 214748364.7 (μm) • 0 to 21474.83647 (inch) • 0 to 21474.83647 (degree) • 0 to 2147483647 (pulse)		
	Speed command	0.01 to 6000000.00 (mm/min) 0.001 to 600000.000 (inch/min) 0.001 to 600000.000 (degree/min) 1 to 400000 (pulse/s)		
	Output variation	1 pulse/3.5 ms		
	Acceleration/Deceleration processing	Automatic trapezoidal acceleration/deceleration, automatic S-pattern acceleration/deceleration		
	Acceleration/Deceleration time	1 to 65535 (ms) Four patterns each can be set for acceleration time and deceleration time.		
	Rapid stop deceleration time	1 to 65535 (ms)		
Compensation		With electronic gear and backlash compensation		
Home position return method		Near-zero point dog method, count method, stopper method		
JOG operation function		Equipped		
Manual pulse generator operation function		Available		
M code output function		Equipped (Either WITH or AFTER mode can be selected.)		
Error display		Indicated by the 17-segment display.		
I/O display		Indicated by the 17-segment display and LED indicators.		
Internal current consumption (5 VDC)		A1SD75P[ ] : 0.7 A or lower AD75P[ ] : 0.7 A or lower		
Number of occupied I/O points		32 points (In I/O allocation: Special function module 32 points)		
Size mm [inch]		A1SD75P[ ] : 130 [5] (H) *34.5 [1.3] (W) *93.6 [3.7] (D) AD75P[ ] : 250 [9.7] (H) *37.5 [1.5] (W) *106 [4.1] (D)		
Weight kg [lb]		A1SD5P[ ] : 0.35 [0.77] AD75P[ ] : 0.45 [0.99]		

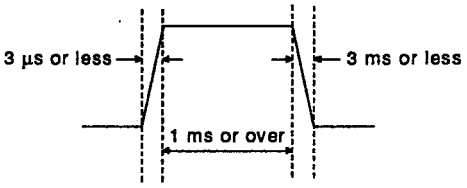
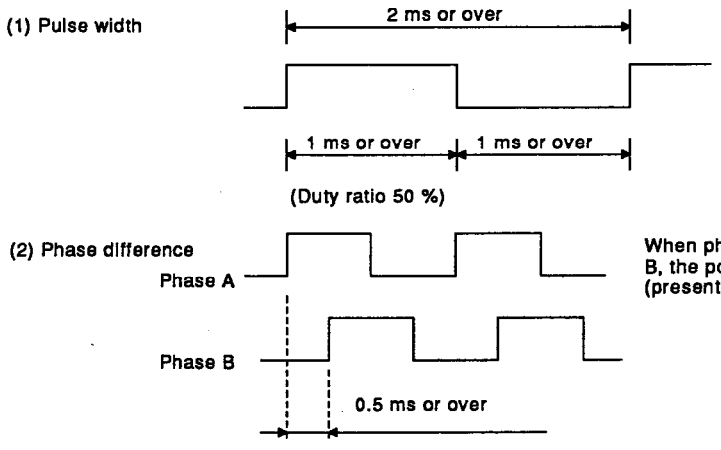
3.2.2 Specifications of I/O interface with external device

This section describes the I/O interface of the AD75 with an external device.

(1) Electrical specifications of the AD75

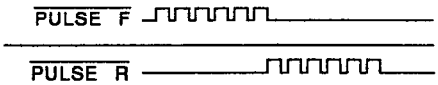
The following table shows the electrical specifications of I/O signals from/to an external device.

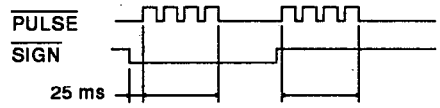
(a) Input specifications

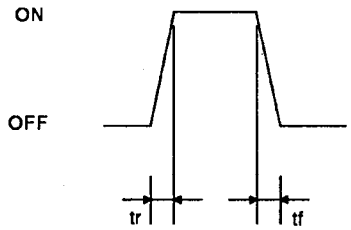
Signal Name	Rated Input Voltage/ Current	Operating Voltage Range	ON Voltage/ Current	OFF Voltage/ Current	Input Resistance	Response Time
Drive unit ready (READY) in-position signal	24 VDC/5 mA	19.2 to 26.4 VDC	17.5 VDC or over/3.5 mA or over	7 VDC or lower/1.7 mA or lower	Approx. 4.7 kΩ	4 ms or less
Zero point signal (PGO)	5 VDC/5 mA	4.5 to 6.1 VDC	2.5 VDC or over/2 mA or over	0.5 VDC or lower/0.5 mA or lower	Approx. 0.5 kΩ	1 ms or less
	24 VDC/5 mA	19.2 to 26.4 VDC	17.5 VDC or over/2 mA or over	7 VDC or lower/0.5 mA or lower	Approx. 8.5 kΩ	1 ms or less
						
Manual pulse generator phase A (PULSER A) Manual pulse generator phase B (PULSER B)	5 VDC/5 mA	4.5 to 6.1 VDC	2.5 VDC or over/3.5 mA or over	1 VDC or lower/1 mA or lower	Approx. 1.5 kΩ	1 ms or less
						
Near-zero point signal (DOG) Stop signal (STOP) Upper limit (FLS) Lower limit (RLS) External start Speed-position switching signal	24 VDC/5 mA	19.2 to 26.4 VDC	17.5 VDC or over/3.5 mA or over	7 VDC or lower/1.7 mA or lower	Approx. 4.7 kΩ	4 ms or less

(b) Output specifications

<table>
<tr><th>Signal Name</th><th>Rated Load Voltage</th><th>Operating Load Voltage Range</th><th>Maximum Load Current/Rush Current</th><th>Maximum Voltage Drop at ON</th><th>Leak Current at OFF</th><th>Response Time</th></tr>
<tr><td rowspan="5">Pulse output (CW/PULSE/PHASE A)

Pulse sign (CCW/SIGN/PHASE B)</td><td colspan="6">Am26LS31 or equivalent differential driver/open collector</td></tr>
<tr><td>CW/CCW type</td><td>PULSE/SIGN type</td><td>PHASE A/ PHASE B type</td><td rowspan="3">Select the CW/CCW, PULSE/SIGN or PHASE A/ PHASE B type when setting driver unit parameters.
• CW/CCW type
 

• PULSE/SIGN type
Forward/Reverse feed pulse
The operating direction can be identified from the direction sign (SIGN).
 

• PHASE A/PHASE B type
When phase A leads phase B, the positioning address increases.
When phase B leads phase A, the positioning address decreases.</td><td rowspan="2"></td><td rowspan="2"></td></tr>
<tr><td>Forward feed pulse
$\overline{\text{PULSE F}}$</td><td>Feed pulse
$\overline{\text{PULSE}}$</td><td>Phase A
$\overline{\text{A}\phi}$</td></tr>
<tr><td>Reverse feed pulse
$\overline{\text{PULSE R}}$</td><td>Direction sign
$\overline{\text{SIGN}}$</td><td>Phase B
$\overline{\text{B}\phi}$</td><td></td><td></td><td></td></tr>
<tr><td colspan="6">*The rise time/fall time and duty ratio for the open collector system are shown in the table below.
 
</td></tr>
<tr><td>5 to 24 VDC</td><td>4.75 to 30 V</td><td>50 mA/point /200 mA and 10 ms or less</td><td>0.5 VDC (TYP)</td><td>0.1 mA or lower</td><td>——</td></tr>
<tr><td>Deviation counter clear ($\overline{\text{CLEAR}}$)</td><td>5 to 24 VDC</td><td>4.25 to 30 V</td><td>0.1 A/point /0.4 A and 10 ms or less</td><td>1 VDC (TYP)
2.5 VDC (MAX)</td><td>0.1 mA or lower</td><td>2 ms or lower (resistance load)</td></tr>
</table>

Pulse rise time/fall time of the AD75 (Unit: tr, tf: μs Duty: %)
....At room temperature

1) When the load voltage is 26.4 V

Cable Length (m)		1			3		
Load Current (mA)	Pulse Speed (kpuls/s)	tf (Rise)	tr (Fall)	Duty	tf (Rise)	tr (Fall)	Duty
2	200	0.04	1.70	30	0.06	2.04	27
	100	0.08	3.00	33	0.07	3.49	29
	10	0.07	3.20	48	0.08	6.80	46
5	200	0.06	1.10	39	0.07	1.83	33
	100	0.07	1.24	43	0.08	2.50	36
	10	0.07	1.20	49	0.08	2.70	49
20	200	0.07	0.42	46	0.08	0.72	43
	100	0.07	0.40	48	0.11	0.74	47
	10	0.07	0.40	50	0.08	0.79	50
50	200	0.08	0.28	48	0.09	0.37	47
	100	0.08	0.27	48	0.13	0.37	48
	10	0.09	0.27	50	0.09	0.37	50

2) When the load voltage is 4.75 V

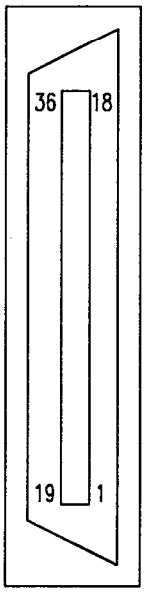
Cable Length (m)		1			3		
Load Current (mA)	Pulse Speed (kpuls/s)	tf (Rise)	tr (Fall)	Duty	tf (Rise)	tr (Fall)	Duty
2	200	0.04	0.63	43	0.04	1.08	38
	100	0.06	0.64	47	0.04	1.28	42
	10	0.04	0.64	49	0.06	1.30	49
5	200	0.04	1.26	48	0.04	0.92	46
	100	0.05	1.26	48	0.06	0.44	47
	10	0.05	1.30	50	0.06	0.44	50
20	200	0.06	0.22	47	0.06	0.22	49
	100	0.08	0.24	50	0.06	0.24	50
	10	0.06	0.24	50	0.06	0.24	50
50	200	0.08	0.20	47	0.10	0.18	50
	100	0.08	0.22	49	0.12	0.20	51
	10	0.08	0.22	50	0.12	0.20	50

(2) Specifications of I/O interface with external device

This section describes the specifications of the AD75's I/O interface with an external device.

(a) Connector signal pin layout

The following table shows the signal pin layout of the AD75's connector for external device (for one axis).
(The signal pin layout of the connector for connection to external devices is the same for axes 1 to 3.)

Pin Layout	Pin No.	Signal Name		Signal Direction AD75 - External Device	Connecting Device
	36	Common	COM	<---->	Drive unit
	35	Common	COM	<---->	Drive unit
	34	Unused			
	33	Unused			
	32	Unused			
	31	Unused			
	30	Unused			
	29	Unused			
	28	Manual pulse generator	Phase B–	<-----	Manual pulse generator
	27	Manual pulse generator	Phase A–	<-----	Manual pulse generator
	26	Common	COM	<---->	Drive unit
	25	Zero point signal common	COM	<-----	Drive unit
	24	Zero point signal	+5 V	<-----	Drive unit
	23	Deviation counter clear common	COM	<---->	Drive unit
	22	Pulse sign (differential-)	CCW/SIGN/Bϕ	----->	Drive unit
	21	Pulse output (differential-)	CW/PULSE/Aϕ	----->	Drive unit
	20	Pulse sign common (open collector)	CCW/SIGN/Bϕ	<---->	Drive unit
	19	Pulse output common (open collector)	CW/PULSE/Aϕ	<---->	Drive unit
	18	Unused			
	17	Unused			
	16	External start (*1)	START	<-----	(External device)
	15	Speed-position switching signal		<-----	(External device)
	14	Stop signal	STOP	<-----	(External device)
	13	Lower limit	RLS	<-----	Limit switch
	12	Upper limit	FLG	<-----	Limit switch
	11	Near-zero point signal	DOG	<-----	Near-zero point dog
	10	Manual pulse generator	Phase B+	<-----	Manual pulse generator
	9	Manual pulse generator	Phase A+	<-----	Manual pulse generator
	8	In-position	INPOS	<-----	Drive unit
	7	Drive unit ready	READY	<-----	Drive unit
	6	Zero point signal	+24 V	<-----	Drive unit
	5	Deviation counter clear	CLEAR	----->	Drive unit
	4	Pulse sign (differential+)	CCW/SIGN/Bϕ	----->	Drive unit
	3	Pulse output (differential+)	CW/PULSE/Aϕ	----->	Drive unit
	2	Pulse sign (open collector)	CCW/SIGN/Bϕ	----->	Drive unit
	1	Pulse output (open collector)	CW/PULSE/Aϕ	----->	Drive unit

REMARK

*1: The signal application depends on the selection of the external start function of extended parameters #2.

(b) Description of connector signals

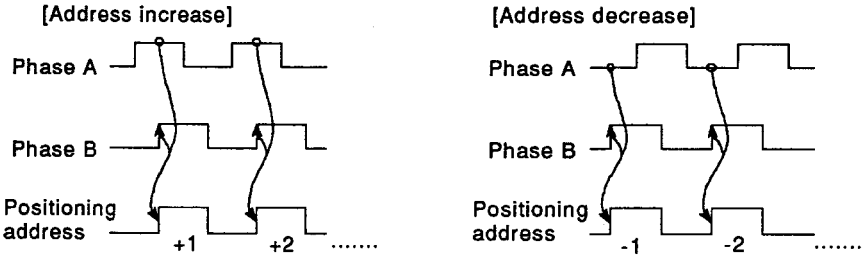
Details of the signals exchanged through the AD75's connector for external device (for one axis) are given below.

1) Common ... (Pin Nos. 36 and 35)

- Common for near-zero point signal, lower and upper limits, stop signal, control switching signal and external start.

2) Manual pulse generator (phase B–), manual pulse generator (phase A–) ... (Pin Nos. 28 and 27)
Manual pulse generator (phase B+), manual pulse generator (phase A+) ... (Pin Nos. 10 and 9)

- Phase A and phase B signals of the manual pulse generator or rotary encoder are inputted.
- When phase A leads phase B, the positioning address increases.
- When phase B leads phase A, the positioning address decreases.



3) Common ... (Pin No. 26)

- Common for drive unit ready and in-position.

4) Common ... (Pin No. 25)

- Common for deviation counter clear.

5) Zero point signal common ... (Pin No. 25)

- Common for zero point signals (+5 V and +24 V)

6) Zero point signal (+5 V), zero point signal (+24 V) ... (Pin Nos. 24 and 6)

- The home position signal is input in home position return. The zero point grid signal from a general pulse encoder is used.
- These signals are also used when the stopper stop method is selected for home position return and a home position return completed signal is input from the external device.
- The home position is detected at the trailing edge of the pulse.

7) Pulse sign, pulse output (differential–) ... (Pin Nos. 22 and 21)
Pulse sign, pulse output (differential+) ... (Pin Nos. 4 and 3)

- A positioning pulse and a pulse sign are output to the drive unit for the differential driver.

8) Pulse sign common, pulse output common (open collector) ... (Pin Nos. 20 and 19)
Pulse sign, pulse output (open collector) ... (Pin Nos. 2 and 1)

- A positioning pulse and a pulse sign are output to the drive unit for the open collector.

9) External start ... (Pin No. 16)

- This signal is used as an external input signal for positioning start, speed change request or skip request.
- The function which will perform an external start depends on the external start function selection of detailed parameter 2.

10) Speed-position switching signal ... (Pin No. 15)

- A control switching signal is input in speed/position switching control.

11) Stop signal ... (Pin No. 14)

- This signal is input to discontinue positioning.
- As soon as this signal is turned ON, the AD75 discontinues the ongoing positioning, and turns OFF the start signal. Thereafter, axis motion will not start even if this signal is turned OFF.

12) Lower limit ... (Pin No. 13)

- The limit switch mounted at the lower stroke end issues this signal.
- Turning OFF this signal discontinues positioning.
- This signal indicates the lower limit for detecting a near-zero point signal when home position return is performed.

13) Upper limit ... (Pin No. 12)

- The limit switch mounted at the upper stroke end issues this signal.
- Turning OFF this signal discontinues positioning.
- This signal indicates the upper limit for detecting a near-zero point signal when home position return is performed.

14) Near-zero point signal ... (Pin No. 11)

- This signal is used to detect the near-zero point dog in home position return.
- The near-zero point dog status switching from OFF to ON is detected at the leading edge of the pulse.
- The near-zero point dog status switching from ON to OFF is detected at the trailing edge of the pulse.

15) In-position ... (Pin No. 8)

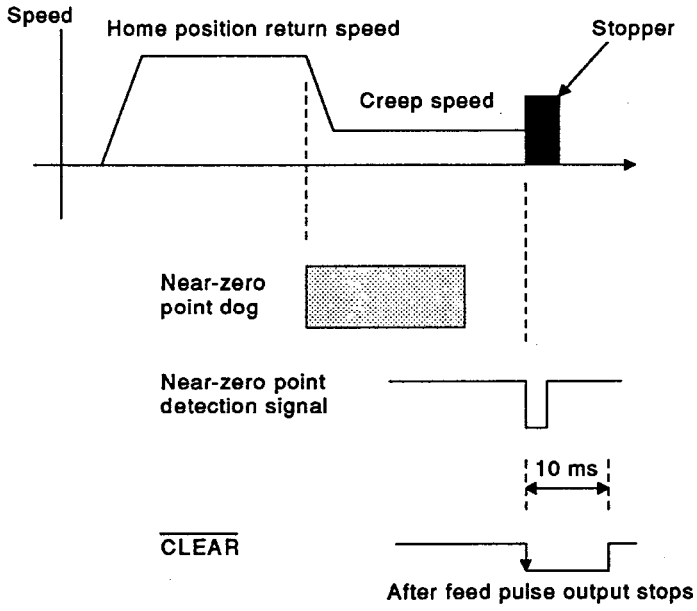
- The drive unit inputs an in-position signal.

16) Drive unit ready ... (Pin No. 7)

- This signal is turned ON when the drive unit is operating normally and is ready to receive feed pulses.
- The AD75 checks the drive unit ready signal, and issues a home position return request if the drive unit is not ready for operation.
- This signal is turned OFF when the drive unit is malfunctioning because of a drive unit control power supply failure.
- If this signal is turned OFF during positioning, axis motion stops. It will not restart even if the signal is turned back ON.
- Turning OFF this signal turns OFF the home position return signal.

17) Deviation counter clear ... (Pin No. 5)

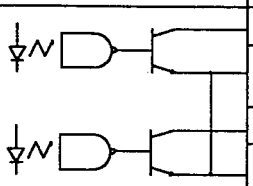
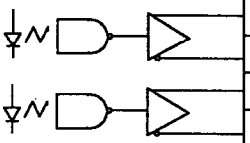
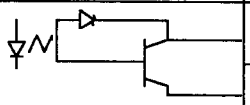
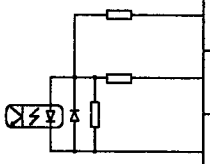
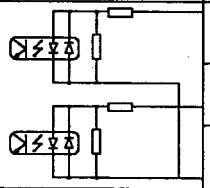
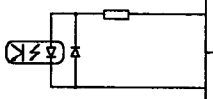
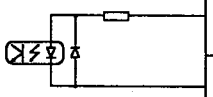
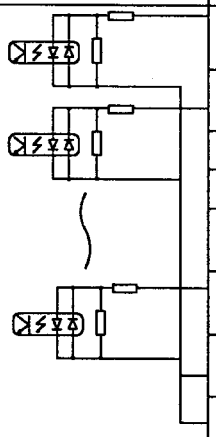
- When performing home position return by stopper stop method (1) or (2), this signal is turned ON after the pulse output has stopped.
  (Example)
  In the case of home position return by stopper stop method (2)



- A deviation counter clear signal is issued for about 10 ms.
- Use a drive unit capable of resetting the number of droop pulses of the internal deviation counter when the AD75 turns ON this signal.

(c) Internal Circuit

The following table shows the schematic circuit diagrams of the internal circuits of the AD75's interface for external devices.

Internal Circuit	Pin No.	Signal Name	Remarks
	1	Pulse output (open collector)	CW/PULSE/Aϕ
	19	Pulse output common (open collector)	
	2	Pulse sign (open collector)	CW/SIGN/Bϕ
	20	Pulse sign common (open collector)	
	3	Pulse output (differential+)	CW/PULSE/Aϕ
	21	Pulse output (differential–)	
	4	Pulse sign (differential+)	CCW/SIGN/Bϕ
	22	Pulse sign (differential–)	
	5	Deviation counter clear	—
	23	Common	
	6	Zero point signal (+24 V)	
	24	Zero point signal (+5 V)	
	25	Zero point signal common	
	7	Drive unit ready	
	8	In-position	
	26	Common	
	9	Manual pulse generator (phase A+)	
	27	Manual pulse generator (phase A–)	
	10	Manual pulse generator (phase B+)	
	28	Manual pulse generator (phase B–)	
	11	Near-zero point signal	
	12	Upper limit	
	13	Lower limit	
	14	Stop signal	
	15	Speed-position switching signal	
	16	External start	
	35	Common	
	36	Common	

(3) Connector specifications

The following tables show the specifications of the AD75's connector for external devices.

(a) AD75 connector

AD Connector (Receptacle)	Lock Type
10236–52A2JL	One-touch lock type

(b) Communicating device connector*

Plug	Applicable Wire Size	Connection Method	Cover	Manufacturer
10136–6000EL	AWG#28 (approx. 0.08 sq.)	Pressure displacement	10336-56F0-008 (right angle plastic cover)	3M
10136–3000VE	AWG#24 to #30 (approx. 0.05 to 0.2 sq.)	Soldering		

REMARK

* The 10136-3000VE (plug) and the 10336-56F0-008 (right angle plastic cover) are packed with the AD75.

3.3 Functions

Table 3.3 shows the functions of the A1SD75P1/P2/P3 and AD75P1/P2/P3.

Table 3.3 Functions of A1SD75P1/P2/P3 and AD75P1/P2/P3

Function Name			Description	Positioning Module		
				AD75P1 A1SD75P1	AD75P2 A1SD75P2	AD75P3 A1SD75P3
Positioning function	Position control	Individual positioning	• This function performs positioning with one start signal according to a single designated positioning data.	o	o	o
		Continuous positioning	• This function performs and completes positioning according to a designated positioning data, then restarts positioning in response to the positioning data of the following data number. • Positioning continues with one start signal until the positioning data containing positioning end as the operation pattern is detected.			
		Continuous locus positioning	After performing and completing positioning according to the designated data, this function continues positioning using the positioning data of the following data number. Positioning is repeated with one start signal until the positioning data containing positioning end as the operation pattern is detected.			
	Speed control		This function starts positioning with one start signal according to single designated positioning data, and completes it on input of a stop signal.			
	Speed/position switching control		This function starts positioning with one start signal according to single designated positioning data, and completes positioning of the designated addresses on input of a speed-position switching stop signal.			
	Block positioning		This function performs positioning on the basis of one "block" of positioning data, which ends with the operation pattern of positioning complete, after which the subsequent positioning takes place. • This positioning is performed with two or more designated blocks. Positioning continues between blocks only when user-designated conditions are fulfilled. • Positioning is repeated in accordance with only one of the plural blocks until user-designated conditions are met. • Positioning in accordance with plural selected blocks is repeated the number of times the user specifies.			
	Interpolation positioning (2-axis linear/circular)		This function performs linear or circular interpolation positioning using one or two of three axes.	x	o	o
Manual pulse generator operation function			This function performs positioning in response to the number of input pulses from the manual pulse generator.	o	o	o
JOG operation function			This function performs positioning while the JOG operation command from the ACPU or peripheral device remains ON.			
Home position return function			The axis returns to the home position on receipt of a home position return command from the ACPU or peripheral device, and this function corrects the present address (feed present value, machine feed value) to the home position address. Home position return is executed by one of the six methods - one near-zero point dog method, two count methods and three stopper stop methods. When the home position return retry function is set, the axis travel direction changes in accordance with the limit switches and near-zero point dog during return to the home position.			

Symbols in table o: Function equipped x: Function not equipped

Table 3.3 Functions of A1SD75P1/P2/P3 and AD75P1/P2/P3 (Continued)

Function Name		Description	Positioning Module		
			AD75P1 A1SD75P1	AD75P2 A1SD75P2	AD75P3 A1SD75P3
Compensation function	Electronic gear	Based on the travel value per pulse, the AD75 outputs the number of pulses corresponding to the designated unit magnification (1/10/100/1000 times) to control the travel value and speed.	o	o	o
	Backlash compensation	During positioning, JOG operation, manual pulse generator operation or home position return, additional feed pulses are output each time the travel direction changes to compensate for the set machine backlash.			
Error compensation function		If there is a difference (mechanical system error) between the designated and actual travel values, additional pulses are output to compensate for the difference.			
M code output function		When positioning using the current positioning data starts (WITH mode) or ends (AFTER mode), this function stores the set M code to the buffer memory, and turns ON the M code ON signal to the ACPU. M code output takes place during individual or continuous positioning.			
Acceleration/deceleration control function		This function performs acceleration and deceleration by the designated acceleration/deceleration method, automatic trapezoidal or automatic S-pattern, in positioning (including speed change during positioning), JOG operation or at the start and end of home position return.			
Software stroke limit function		This function does not execute a positioning command which exceeds the upper or lower limit of the set machine travel range. The user must select a feed present value or machine feed value as the limit.			
Torque control function		This function controls the torque generated by the servomotor so that it will not exceed the set torque limit value. When the torque limit value is changed in the middle of positioning, the new value becomes valid.			
Present value change function		When the present value is changed, this function changes the feed present value to the designated value. The AD75 controls the position (address) with the feed present value and the machine feed value during positioning; when a present value change is executed, the feed present value and machine feed value become different values. • Present feed value..... Becomes the address to which the change was made by the present value change. • Machine feed value..... Address with respect to the machine home position and based on the home position address: not changed by a present value change.			
Teaching function		This function writes the positioning address where positioning was completed manually by JOG operation or manual pulse generator operation to the buffer memory as the positioning data of the ACPU-designated data number.			
Override function		This function adjusts the speed during positioning between 1 % and 300 %.			
Shorter path selection function		When "degrees" is selected as the unit, this function performs positioning in the closer direction to the designated address.			

Symbols in table o: Function equipped x: Function not equipped

3.3.1 Control method

(1) Description of the control method

(a) The control method means the mode (type) of positioning control.

(b) There are 17 control methods as shown below:

1) 1-axis linear control (See Section 3.3.1 (2).)
   - Absolute data method
   - Incremental method

2) 2-axis linear interpolation (See Section 3.3.1 (3).)
   - Absolute data method
   - Incremental method

3) Fixed-pitch feed (See Section 3.3.1 (4).)
   - 1-axis fixed-pitch feed
   - 2-axis fixed-pitch feed

4) Circular interpolation: Cannot be used with a stepping motor (See Section 3.3.1 (5) and (6).)
   - Circular interpolation by designating an auxiliary point (absolute)
   - Circular interpolation by designating an auxiliary point (incremental)
   - Circular interpolation by designating a center point (absolute, clockwise)
   - Circular interpolation by designating a center point (absolute, counterclockwise)
   - Circular interpolation by designating a center point (incremental, clockwise)
   - Circular interpolation by designating a center point (incremental, counterclockwise)

5) Speed control (See Section 3.3.4.)
   - Forward
   - Reverse

6) Speed/position switching control (See Section 3.3.5.)
   - Forward
   - Reverse

7) Present value change (See Section 3.3.18.)

(c) Specify a control method of the positioning data.

Positioning data can be set using the peripheral device or sequence program.
For details of positioning data, see Section 3.4.5.

- Peripheral device: Set positioning data when editing positioning data in the edit mode.
  For operation of the peripheral device, see the SW0IVD-AD75P Operating Manual.
- Sequence program: Write TO/DTO instructions to the designated buffer memory area.
  For details of the buffer memory, see Section 3.6.5.

REMARK

*: Positioning data setting using a peripheral device, and writing of positioning data to the buffer memory using the sequence program use different data numbers.

(1) Peripheral device: Positioning data Nos. 1 to 600 (600 data)

(2) Sequence program: Positioning data Nos. 1 to 100 (100 data)

(2) 1-axis linear positioning control

This function controls positioning of the designated axis from the start point address (present stop position) to the designated position (travel value).

Control by absolute data method (ABS linear 1)

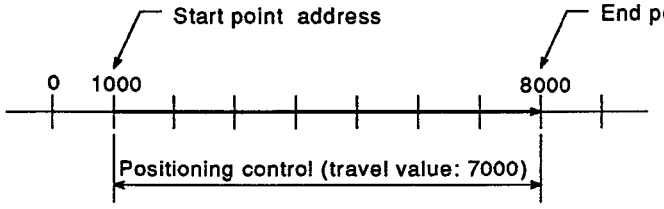
(a) This method controls positioning from the start point address to the end point address (address designated in the positioning data). Positioning control is performed based on the address (home position address) designated for home position return.

(b) The travel direction depends on the start and end addresses.

- Start point address < End point address: Positioning in forward direction
- Start point address > End point address: Positioning in reverse direction

Example

When the start point address is 1000 and the end point address is 8000, the axis travels 7000 (8000 to 1000) in the forward direction.



(c) Designating positioning data *1

The following positioning data can be set with the peripheral device or sequence program:

Data	Necessity of Setting *2
Operation pattern	o
Control method	Select "ABS linear 1".
Acceleration time	o
Deceleration time	o
Positioning address/Travel value	o
Circular interpolation address	—
Commanded speed	o
Dwell time	Δ
M code	Δ

REMARKS

1) *1: For details of positioning data, see Section 3.4.5.

2) *2: Whether or not setting is necessary is indicated by one of the following symbols:

- o : Must be set.
- Δ : May be set as required.
- — : Need not be set.

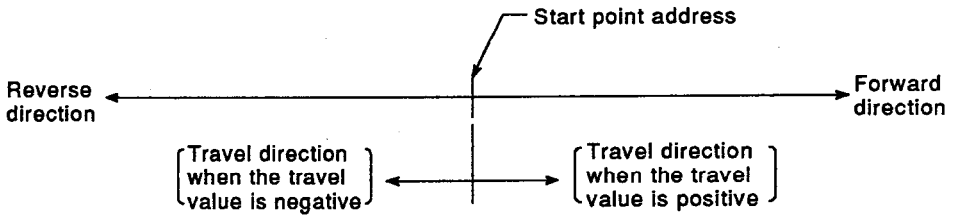
Control by incremental method (INC linear 1)

(a) This method controls positioning for the designated travel value from the start point address.

(b) The travel direction depends on the travel value sign.

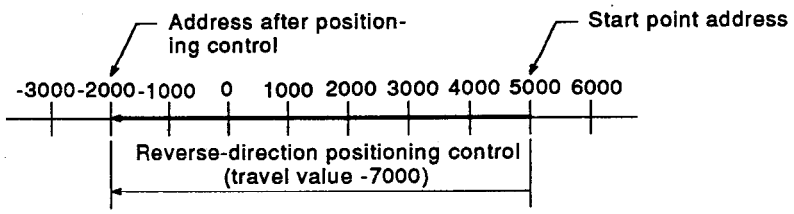
1) + direction..... Positioning in forward direction (address incremental direction)

2) - direction..... Positioning in reverse direction (address decremental direction)



Example

When the start point address is 5000 and the travel value is -7000, the axis travels to the position of -2000.



(c) Designating positioning data *1

The following positioning data can be set with the peripheral device or sequence program:

Data	Necessity of Setting *2
Operation pattern	o
Control method	Select "INC linear 1".
Acceleration time	o
Deceleration time	o
Positioning address/Travel value	o
Circular interpolation address	—
Commanded speed	o
Dwell time	Δ
M code	Δ

REMARKS

1) *1: For details of positioning data, see Section 3.4.5.

2) *2: Whether or not setting is necessary is indicated by one of the following symbols:

- o : Must be set.
- Δ : May be set as required.
- — : Need not be set.

(3) 2-axis linear interpolation control

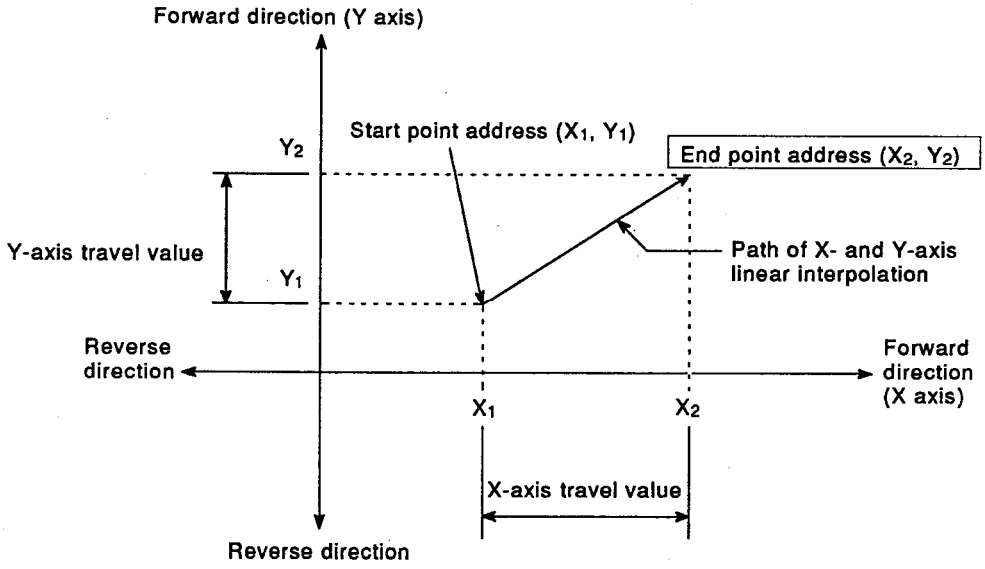
This function performs linear interpolation control from the start point address (present stop position) using two designated axes.

Control by absolute data method (ABS linear 2)

(a) This method performs 2-axis linear interpolation from the start point address to the end point address (address designated in the positioning data).
Positioning control is performed based on the address designated for home position return.

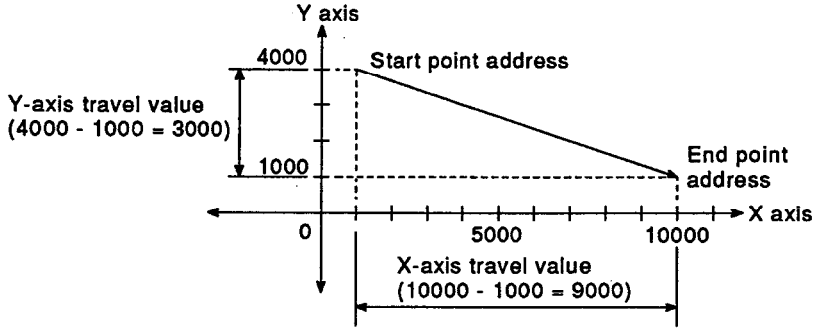
(b) The travel value depends on the start point and designated addresses of each axis.

- Stop point address < End point address:
  Positioning in forward direction
- Stop point address > End point address:
  Positioning in reverse direction



Example

When the start point address is (1000, 4000) and the end point address is (10000, 1000), positioning is performed as shown below:



(c) Travel values of up to 2^{30} are possible for each axis in linear interpolation control.
If the calculated travel value exceeds the range indicated above, an "out of linear travel value range error message (error code 504)" will occur at the start of positioning, and positioning will not begin.

(d) Designating positioning data *1

1) Set the positioning data control method for the reference axis.

2) The following positioning data can be set with the peripheral device or sequence program:

Data	Necessity of Setting *2	
	Reference Axis	Auxiliary Axis
Operation pattern	o	—
Control method	Select "ABS linear 2".	—
Acceleration time	o	—
Deceleration time	o	—
Positioning address/Travel value	o	o
Circular interpolation address	—	—
Commanded speed	o	—
Dwell time	Δ	—
M code	Δ	—

REMARKS

1) *1: For details of positioning data, see Section 3.4.5.

2) *2: Whether or not setting is necessary is indicated by one of the following symbols:

- o : Must be set.
- Δ : May be set as required.
- — : Need not be set.

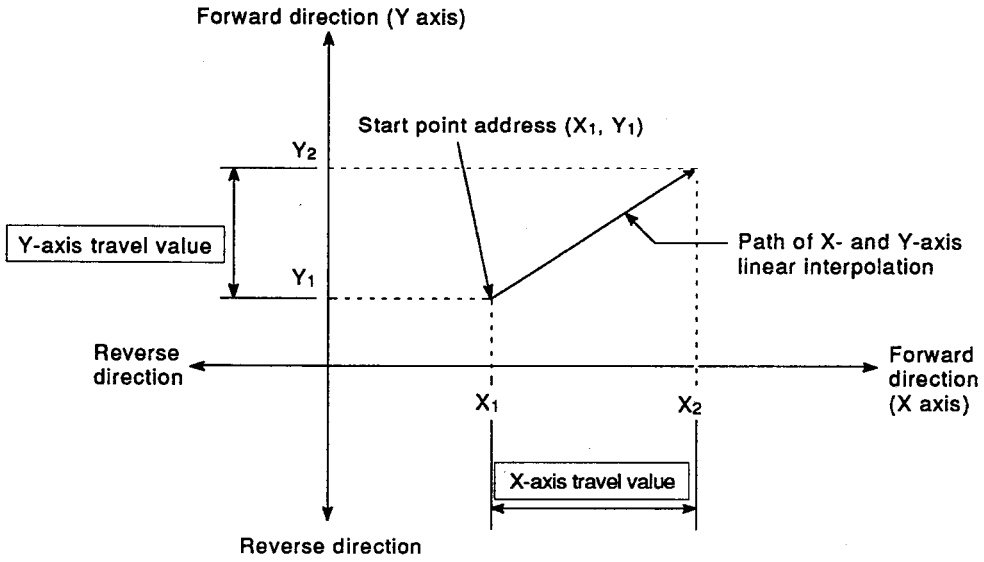
Control by incremental method (INC linear 2)

(a) This method controls positioning from the start point address to the resultant position obtained from the travel direction and distance designated for each axis.

(b) The travel direction of each axis depends on the travel value sign.

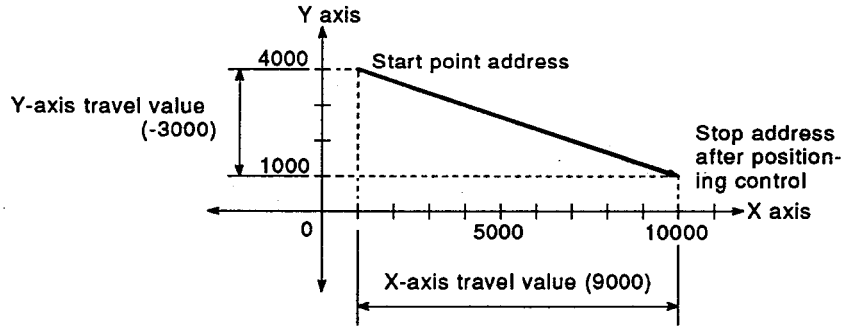
1) + travel value ... Positioning in forward direction (address incremental direction)

2) - travel value ... Positioning in reverse direction (address decremental direction)



Example

When the X-axis travel value is 9000 and the Y-axis travel value is -3000, positioning is performed as shown below:



(c) Travel values of up to 2^{30} are possible for each axis in linear interpolation control.
If the calculated travel value exceeds the range indicated above, an "out of linear travel value range error message (error code 504)" will occur at the start of positioning, and positioning will not begin.

(d) Designating positioning data *1

1) Set the positioning data control method for the reference axis.

2) The following positioning data can be set with the peripheral device or sequence program:

Data	Necessity of Setting *2	
	Reference Axis	Auxiliary Axis
Operation pattern	o	—
Control method	Select "INC linear 2".	—
Acceleration time	o	—
Deceleration time	o	—
Positioning address/Travel value	o	o
Circular interpolation address	—	—
Commanded speed	o	—
Dwell time	Δ	—
M code	Δ	—

REMARKS

1) *1: For details of positioning data, see Section 3.4.5.

2) *2: Whether or not setting is necessary is indicated by one of the following symbols:

- o : Must be set.
- Δ : May be set as required.
- — : Need not be set.

(4) Fixed-pitch feed control

This function controls positioning of a designated axis for a designated travel value from the stop position.
One-axis fixed-pitch feed and 2-axis fixed-pitch feed are available.

POINTS

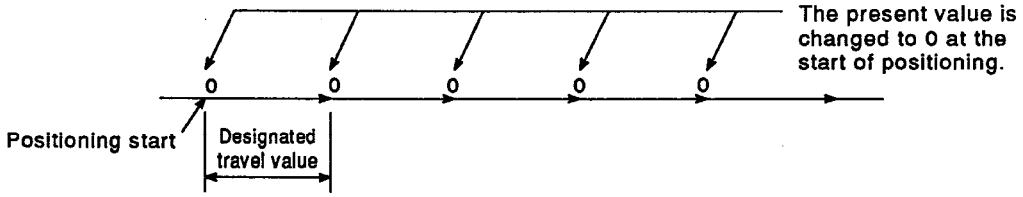
(a) Since fixed-pitch feed matches the number of pulse outputs with the travel value designated in the positioning data, fractions lower than the last digit of the control accuracy are truncated.
(This truncation does not affect the accuracy of regular control.)
When the fraction is truncated, the machine feed value may be compensated.

(b) When continuous locus control is selected as the operation pattern of the positioning data, fixed-pitch feed control cannot be designated.
If continuous locus control and fixed-pitch feed are designated simultaneously, an axis error will occur, and the axis travel will not start.

(c) Fixed-pitch feed control cannot be designated for the next positioning data after a positioning data for which continuous locus control is set as the operation pattern either.
If fixed-pitch feed is designated, an axis error will occur and automatic deceleration will begin.

Control by 1-axis fixed-pitch feed (fixed-pitch feed 1)

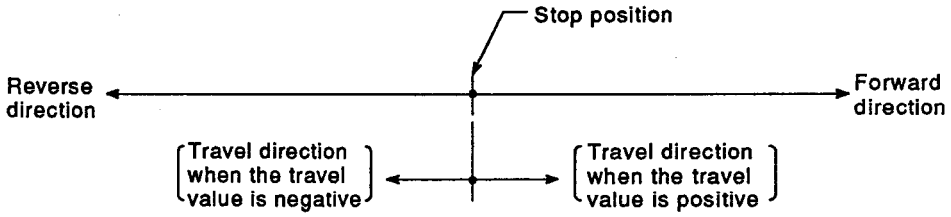
(a) One-axis fixed-pitch feed changes the stop address of the axis designated at the start of positioning to 0, then controls positioning for the designated travel value in the designated direction.



(b) The travel direction depends on the travel value sign.

1) + travel value ... Positioning in forward direction (address incremental direction)

2) - travel value ... Positioning in reverse direction (address decremental direction)



(c) Designating positioning data *1

The following positioning data can be set with the peripheral device or sequence program:

Data	Necessity of Setting *2
Operation pattern	o
Control method	Select "fixed-pitch feed 1".
Acceleration time	o
Deceleration time	o
Positioning address/Travel value	o
Circular interpolation address	—
Commanded speed	o
Dwell time	Δ
M code	Δ

REMARKS

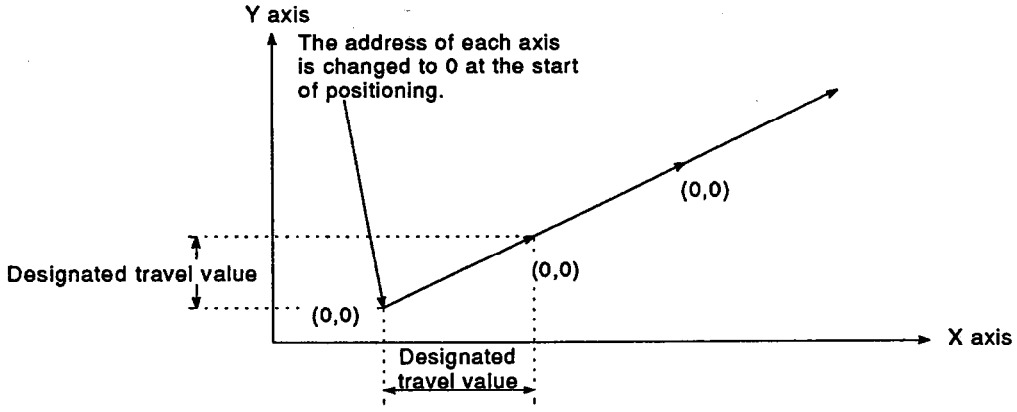
1) *1: For details of positioning data, see Section 3.4.5.

2) *2: Whether or not setting is necessary is indicated by one of the following symbols:

- o : Must be set.
- Δ : May be set as required.
- — : Need not be set.

Control by 2-axis fixed-pitch feed (fixed-pitch feed 2)

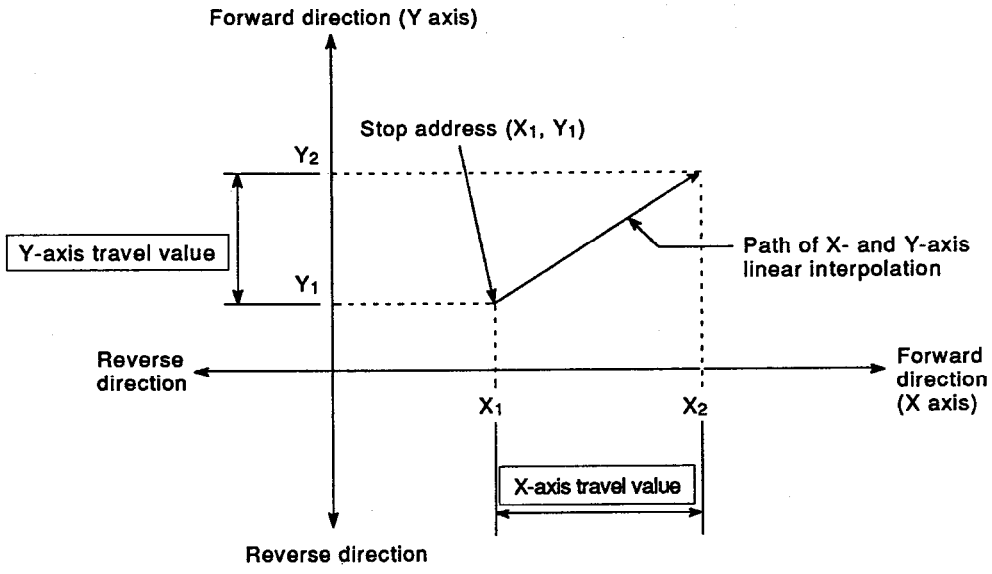
(a) Two-axis fixed-pitch feed changes the stop address of the two axes designated at the start of positioning to 0, then controls positioning to the resultant position of the travel direction and distance designated for each address.



(b) The travel direction of each axis depends on the travel value sign.

1) + travel value ... Positioning in forward direction (address incremental direction)

2) - travel value ... Positioning in reverse direction (address decremental direction)



(c) Travel values of up to 2^{30} are possible for each axis in linear interpolation control.
If the calculated travel value exceeds the range indicated above, an "out of linear travel value range error message (error code 504)" will occur at the start of positioning, and positioning will not begin.

(d) Designating positioning data *1

1) Set the positioning data control method for the reference axis.

2) The following positioning data can be set with the peripheral device or sequence program.

Data	Necessity of Setting *2	
	Reference Axis	Auxiliary Axis
Operation pattern	o	—
Control method	Select "fixed-pitch feed 2".	—
Acceleration time	o	—
Deceleration time	o	—
Positioning address/Travel value	o	o
Circular interpolation address	—	—
Commanded speed	o	—
Dwell time	Δ	—
M code	Δ	—

REMARKS

1) *1: For details of positioning data, see Section 3.4.5.

2) *2: Whether or not setting is necessary is indicated by one of the following symbols:

- o : Must be set.
- Δ : May be set as required.
- — : Need not be set.

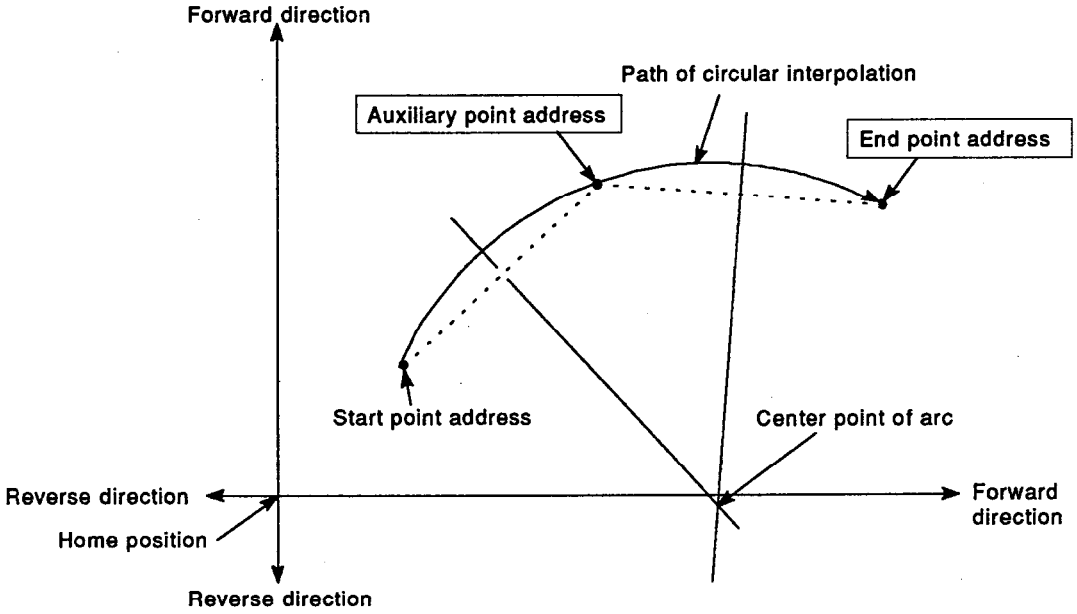
(5) Circular interpolation control by designating an auxiliary point (cannot be used with stepping motors)

This function performs circular interpolation control after designation of an end point and an auxiliary point (passing point).

Control by absolute data method

(a) This method performs circular interpolation from the start point address to the end point address via the designated auxiliary point address.

(b) The center point of the arc is located at the point of intersection of the vertical bisector from the line connecting the start point address and the auxiliary point address and the vertical bisector from the line between the auxiliary point address and the end point address.



(c) Circular interpolation control by designating an auxiliary point can be used even when the operation pattern is continuous locus control.

(d) Circular interpolation control by designating an auxiliary point cannot be used when "degrees" is selected as the unit.

(e) The maximum radius for which circular interpolation control is possible is 2^{29}.
If the calculated radius exceeds the above range, a "radius setting error (error code: 544)" will occur at the start of positioning, and positioning will not begin.
If positioning control is in progress, an immediate stop will occur on detection of the error.

(f) If the calculated center point address is outside the range -2^{31} to $(2^{31} - 1)$, an "auxiliary point setting error (error code: 525)" will occur, and positioning will not begin.
If positioning control is in progress, an immediate stop will occur on detection of the error.

(g) In the following cases an error will occur and positioning will not begin.
If positioning control is in progress, an immediate stop will occur on detection of the error.

1) Start point address = end point address
... End point setting error (error code: 526)
2) Start point address = auxiliary point address
... Auxiliary point setting error (error code: 525)
3) End point address = auxiliary point address
... Auxiliary point setting error (error code: 525)
4) Start point address, auxiliary point address, and end point address lie on a straight line.
... Auxiliary point setting error (error code: 525)

(h) Designating positioning data *1

1) Set the positioning data control method for the reference axis.

2) The following positioning data can be set with the peripheral device or sequence program.

Data	Necessity of Setting *2	
	Reference Axis	Auxiliary Axis
Operation pattern	o	—
Control method	Select "ABS circular interpolation".	—
Acceleration time	o	—
Deceleration time	o	—
Positioning address/Travel value	o	o
Circular interpolation address	o (Set the auxiliary point address.)	o (Set the auxiliary point address.)
Commanded speed	o	—
Dwell time	Δ	—
M code	Δ	—

REMARKS

1) *1: For details of positioning data, see Section 3.4.5.

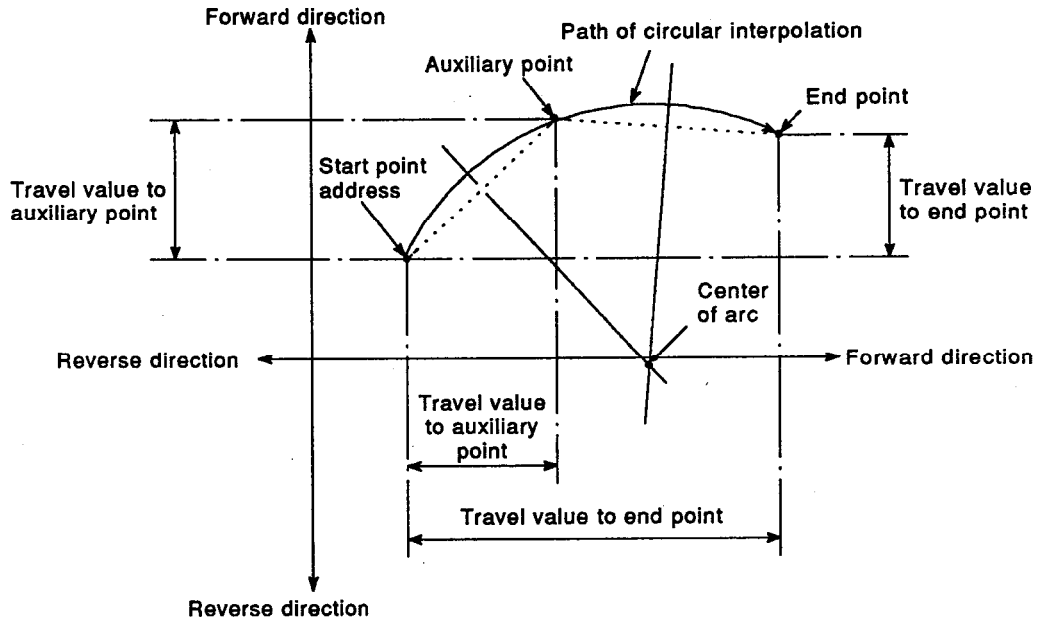
2) *2: Whether or not setting is necessary is indicated by one of the following symbols:

- o : Must be set.
- Δ : May be set as required.
- — : Need not be set.

Control by incremental method

(a) This method performs circular interpolation from the start point address to the end point address via the designated auxiliary point address.

(b) The center point of the arc is located at the point of intersection of the vertical bisector of the auxiliary point address calculated from the travel value from the start point address to the auxiliary point, and the vertical bisector of the end point address calculated from the travel value from the auxiliary point address to the end point.



(c) Circular interpolation control by designating an auxiliary point is available even when the operation pattern is continuous locus control.

(d) Circular interpolation control by designating an auxiliary point cannot be used when "degrees" is selected as the unit.

(e) The maximum radius for which circular interpolation control is possible is 2^{29}.
If the calculated radius exceeds the above range, a "radius setting error (error code: 544)" will occur at the start of positioning, and positioning will not begin.
If positioning control is in progress, an immediate stop will occur on detection of the error.

(f) If the calculated center point address is outside the range -2^{31} to $(2^{31} - 1)$, an "auxiliary point setting error (error code: 525)" will occur, and positioning will not begin.
If positioning control is in progress, an immediate stop will occur on detection of the error.

(g) In the following cases an error will occur and positioning will not begin.
If positioning control is in progress, an immediate stop will occur on detection of the error.

1) Start point address = end point address
... End point setting error (error code: 526)
2) Start point address = auxiliary point address
... Auxiliary point setting error (error code: 525)
3) End point address = auxiliary point address
... Auxiliary point setting error (error code: 525)
4) Start point address, auxiliary point address, and end point address lie on a straight line.
... Auxiliary point setting error (error code: 525)

(h) Designating positioning data *1

1) Set the positioning data control method for the reference axis.

2) The following positioning data can be set with the peripheral device or sequence program.

Data	Necessity of Setting *2	
	Reference Axis	Auxiliary Axis
Operation pattern	o	—
Control method	Select "INC circular interpolation".	—
Acceleration time	o	—
Deceleration time	o	—
Positioning address/Travel value	o	o
Circular interpolation address	o (Set the travel value to the auxiliary point.)	o (Set the travel value to the auxiliary point.)
Commanded speed	o	—
Dwell time	Δ	—
M code	Δ	—

REMARKS

1) *1: For details of positioning data, see Section 3.4.5.

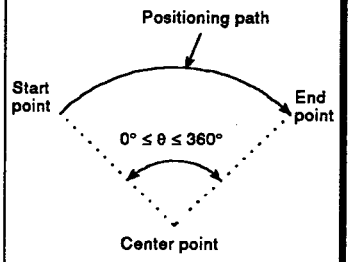
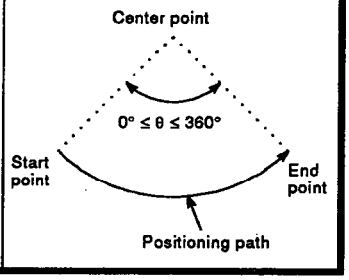
2) *2: Whether or not setting is necessary is indicated by one of the following symbols:

- o : Must be set.
- Δ : May be set as required.
- — : Need not be set.

(6) Circular interpolation control by designating a center point (cannot be used with stepping motors)

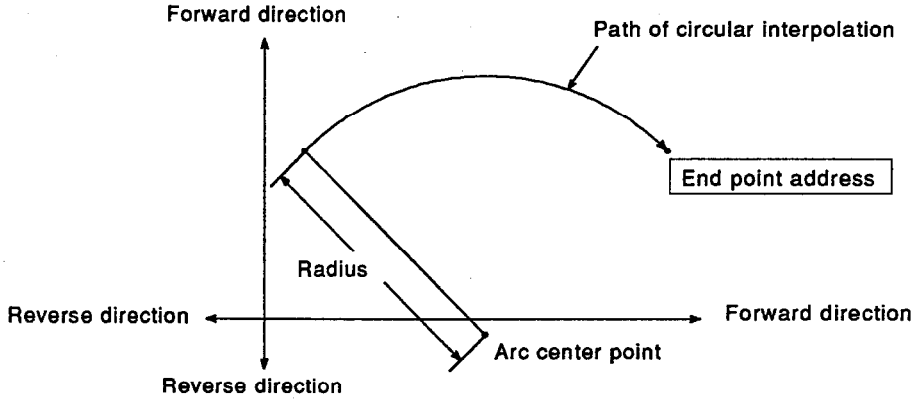
This function performs circular interpolation control after designation of the end point of circular interpolation and the center point of an arc.

The following table shows servomotor directions of rotation, controllable arc center angles and positioning paths.

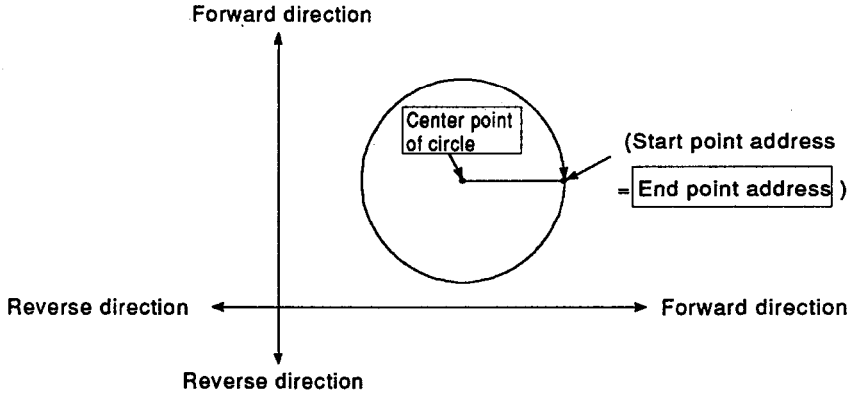
Command	Direction of Rotation	Controllable Arc Center Angle	Positioning Path
ABS circular clockwise	Clockwise	$0° \leq \theta \leq 360°$	
INC circular clockwise			
ABS circular counterclockwise	Counterclockwise		
INC circular counterclockwise			

Control by absolute data method

(a) This method performs circular interpolation from the start point address to the end point address along the arc of the circle whose radius is equivalent to the length from the start point address to the designated center point address.



(b) When the end point address and the start point address are the same, positioning can be performed on a circle which takes the length of the line joining the start point address to the center point of the circle as the radius.



(c) In circular interpolation control by designating a center point, the locus of the arc calculated from the start point address and the center point address may not coincide with the set end point address.

- When the error between the calculated locus of the arc and the end point address is within the allowable error range for circular interpolation set in extended parameters #2, circular interpolation is performed based on the set end point address while the error is compensated for by spiral interpolation.*
- When the error between the calculated locus of the arc and the end point address is outside the allowable error range for circular interpolation, an "out of allowable circular interpolation error range error (error code: 506)" will occur, and positioning will not begin.
  If positioning control is in progress, an immediate stop will occur on detection of the error.

REMARK

*: For spiral interpolation, see Section 3.4.2 (22).

(d) Circular interpolation control by designating a center point is available even when the operation pattern is continuous locus control.

(e) Circular interpolation control by designating a center point cannot be used when degree is selected as the unit.

(f) The maximum radius for which circular interpolation control is possible is 2^{29}.
If the calculated radius exceeds the above range, a "radius setting error (error code: 544)" will occur at the start of positioning, and positioning will not begin.
If positioning control is in progress, an immediate stop will occur on detection of the error.

(g) In the cases shown below, a "center point setting error (error code: 527)" occurs and positioning does not begin.
If positioning control is in progress, an immediate stop will occur on detection of the error.

1) Start point address = center point address

2) End point address = center point address

(h) Designating positioning data *1

1) Set the positioning data control method for the reference axis.

2) The following positioning data can be set with the peripheral device or sequence program.

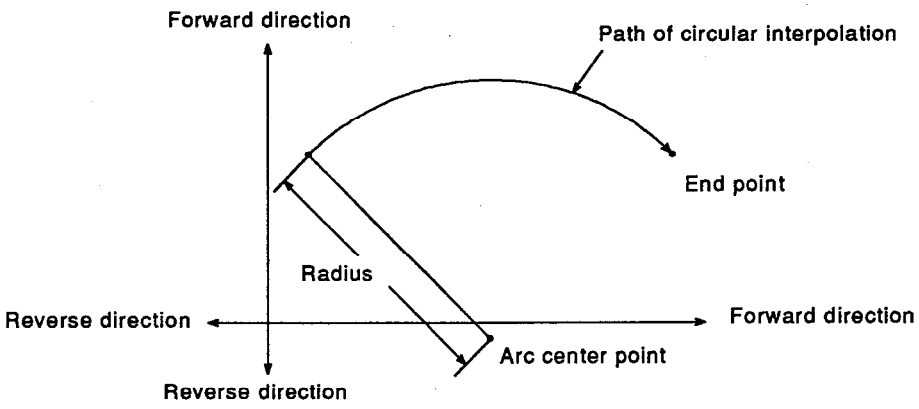
Data	Necessity of Setting *2	
	Reference Axis	Auxiliary Axis
Operation pattern	o	—
Control method *3	Select "ABS circular clockwise" or "ABS circular counterclockwise".	—
Acceleration time	o	—
Deceleration time	o	—
Positioning address/Travel value	o	o
Circular interpolation address	o (Set the center point address.)	o (Set the center point address.)
Commanded speed	o	—
Dwell time	Δ	—
M code	Δ	—

REMARKS

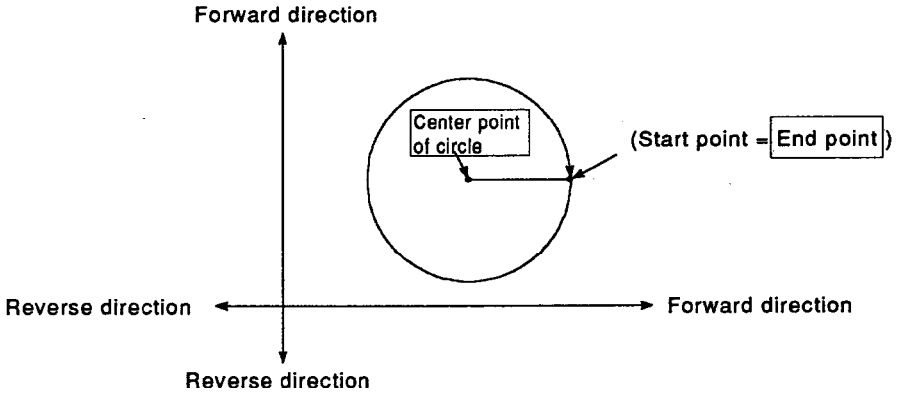
1) *1: For details of positioning data, see Section 3.4.5.
2) *2: Whether or not setting is necessary is indicated by one of the following symbols:
   - o : Must be set.
   - Δ : May be set as required.
   - — : Need not be set.
3) *3: With regard to the control method, select either "ABS circular clockwise" or "ABS circular counterclockwise" according to the direction of rotation of the servomotor.

Control by incremental method

(a) This method performs circular interpolation from the start point address to the end point along the arc of the circle whose radius is equivalent to the length from the start point address to the designated center point address.



(b) By setting the travel value to 0, positioning can be performed on a circle which takes the length of the line joining the start point address to the center point of the circle as the radius.



(c) In circular interpolation control by designating a center point, the locus of the arc calculated from the start point address and the center point address may not coincide with the set end point address.

- When the error between the calculated locus of the arc and the end point address is within the allowable error range for circular interpolation set in extended parameters #2, circular interpolation is performed based on the set end point address while the error is compensated for by spiral interpolation.*
- When the error between the calculated locus of the arc and the end point address is outside the allowable error range for circular interpolation, an "out of allowable circular interpolation error range error (error code: 506)" will occur, and positioning will not begin.
  If positioning control is in progress, an immediate stop will occur on detection of the error.

REMARK

*: For details on spiral interpolation, see Section 3.4.2 (22).

(d) Circular interpolation control by designating a center point is possible even when the operation pattern is continuous locus control.

(e) Circular interpolation control by designating a center point cannot be used when "degrees" is selected as the unit.

(f) The maximum radius for which circular interpolation control is possible is 2^{29}.
If the calculated radius exceeds the above range, a "radius setting error (error code: 544)" will occur at the start of positioning, and positioning will not begin.
If positioning control is in progress, an immediate stop will occur on detection of the error.

(g) If the calculated end point address or center point address is outside the range -2^{31} to $(2^{31}-1)$, the following errors occur and positioning does not begin.
If positioning control is in progress, an immediate stop will occur on detection of the error.

1) For end point address: End point setting error (error code: 526)

2) For center point address:
Center point setting error (error code: 527)

(h) In the cases shown below, a "center point setting error (error code: 527)" occurs and positioning does not begin.
If positioning control is in progress, an immediate stop will occur on detection of the error.

1) Start point address = center point address

2) End point address = center point address

(i) designating positioning data *1

1) Set the positioning data control method for the reference axis.

2) The following positioning data can be set with the peripheral device or sequence program.

Data	Necessity of Setting *2	
	Reference Axis	Auxiliary Axis
Operation pattern	o	—
Control method *3	Select "INC circular clockwise" or "INC circular counterclockwise"	—
Acceleration time	o	—
Deceleration time	o	—
Positioning address/Travel value	o	o
Circular interpolation address	o (Set the center point address.)	o (Set the center point address.)
Commanded speed	o	—
Dwell time	Δ	—
M code	Δ	—

REMARKS

1) *1: For details of positioning data, see Section 3.4.5.

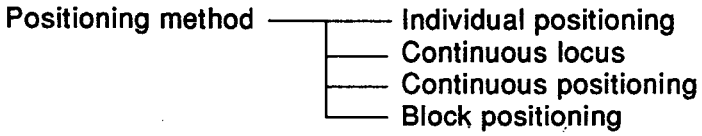
2) *2: Whether or not setting is necessary is indicated by one of the following symbols:

- o : Must be set.
- Δ : May be set as required.
- — : Need not be set.

3) *3: With regard to the control method, select either "INC circular clockwise" or "INC circular counterclockwise" according to the direction of rotation of the servomotor.

3.3.2 Positioning method

There are four positioning methods as shown below:



- Individual positioning
  The individual positioning method performs one-time positioning according to the positioning data.
- Continuous locus positioning
  The continuous locus method performs continuous locus operation in response to one start signal according to the operation pattern set in the positioning data.
- Continuous positioning
  The continuous positioning method performs continuous positioning until a set end pattern in response to one start signal according to the operation pattern set in the positioning data.
  Continuous locus positioning and continuous positioning can be used in combination.
- Block positioning
  The block positioning method can perform the most complicated operation in response to a single start signal, and execute the operation indicated in the positioning information.

(1) Positioning start

This section describes processing started by inputting a positioning start signal.

(a) Start with a positioning start signal

1) As soon as the positioning signal is turned ON, the start completed signal and the BUSY signal are also turned ON to start positioning.
The ON status of the BUSY signal indicates that the axis is in operation.

2) The start completed signal is turned OFF whenever the positioning start signal goes OFF.
When the positioning start signal is ON even after positioning has been completed, the start complete signal remains ON.

3) If the positioning start signal is turned ON again while the BUSY signal is ON, an "in-operation start warning (warning code: 100)" will be issued.

4) The processing after the axis has completed operation depends on whether subsequent positioning must be performed.

i) When subsequent positioning need not be performed

- If a dwell time is set, positioning is delayed until the set time has elapsed.
- When positioning is completed, the BUSY signal goes OFF and the positioning complete signal comes ON. However, the positioning completed signal will not be turned ON during speed control, or when the positioning completed signal ON time is "0".
- The lapse of the positioning completed signal ON time turns OFF the positioning completed signal.

ii) When subsequent positioning must be performed

- When the dwell time is set, the axis waits until the set time elapses.
- The subsequent positioning will begin on elapse of the set dwell time.

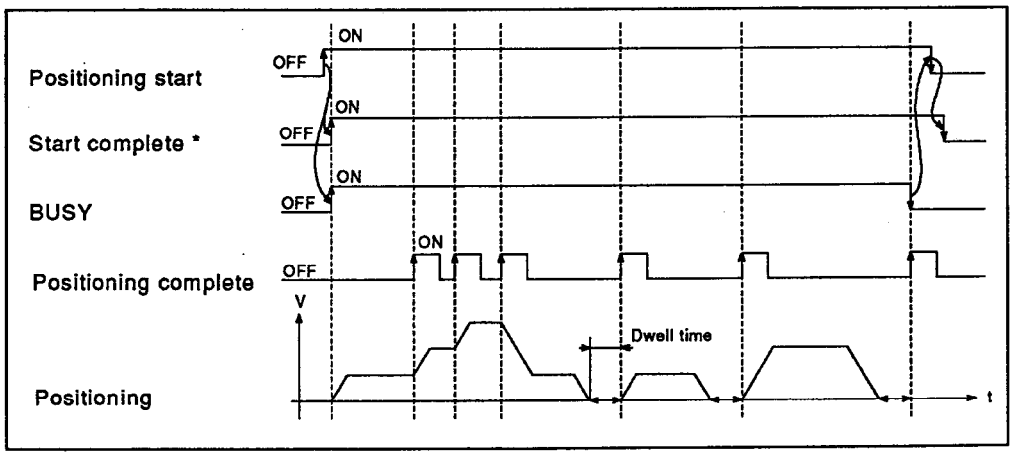


Fig. 3.1 ON/OFF Timing of Signals at Positioning Start

REMARK

* : Does not come ON in the case of a start caused by an external start signal.

(b) External positioning start

1) Positioning can be started by turning ON an external start signal. [The same processing as positioning start with a positioning start signal can be performed. See (1)(a).]

2) To perform positioning with an external start signal, "external positioning start (0)" must be set in the "external start function selection" buffer memory area.

3) To start positioning by external start, "external start enabled (1)" must be set in the "external start valid setting" buffer memory area.
Positioning does not begin if the setting in the external start valid setting buffer memory area is "external start disabled (initial value: 0)".

4) The start complete signal does not come ON in the case of a start caused by an external start signal.

POINT

An external positioning start will be executed in response to an input from an external source provided the start data number has been written by the sequence program in advance.
Because the external input starts positioning by selecting external positioning start, lead time fluctuation due to the sequence scan time can be eliminated by using this method.

REMARK

The buffer memory addresses for the external start function selection area and the external start enable setting area are shown below:

Axis No.	Buffer Memory	
	External Start Function Selection	External Start Valid Setting
Axis 1	62	1171
Axis 2	212	1221
Axis 3	362	1271

(c) Block positioning

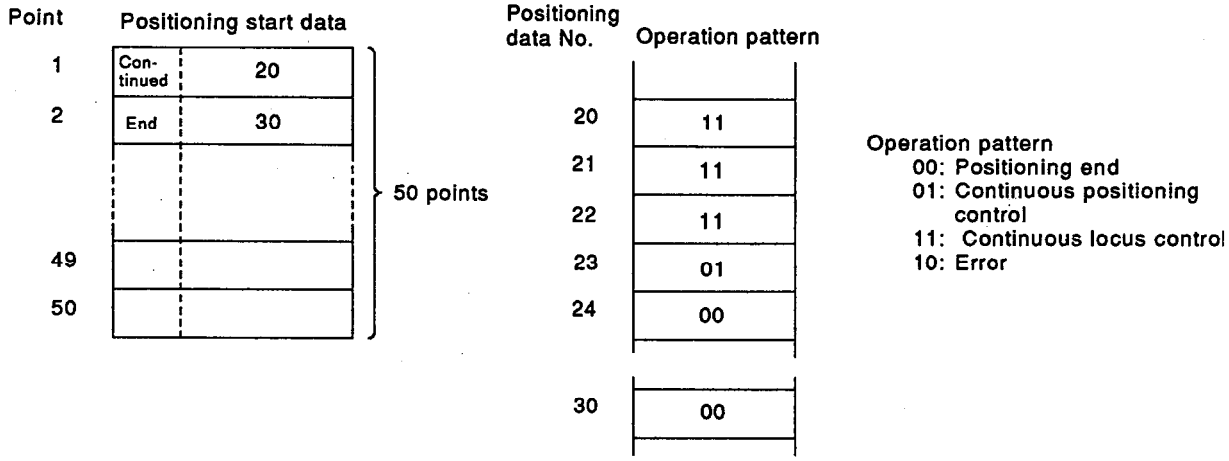
1) When the positioning start signal is turned ON, block positioning starts with the positioning data number of the first point set in the positioning start data.

2) When the operation pattern of the positioning data is positioning continued, the next positioning data will be executed after positioning according to the first point of positioning data.
The "next positioning data" means the positioning data number subsequent to the positioning data number on the basis of which positioning was performed last time. For example, when the previously executed data number is 10, positioning will be executed in accordance with positioning data No. 11.

3) When the operation pattern of the positioning data is "positioning end", positioning stops after the first positioning data has been executed.
Positioning will be terminated when the "positioning end/continued" setting for the first point is "positioning end". (The BUSY signal will be turned OFF.)
When "positioning continued" is selected as the operation pattern for the first point, the point will be updated, and the second point positioning data will be executed.

4) Point updating continues until the positioning data proceeds to the end command.
However, note that updating can be continued for a maximum of 50 points.
If this limit of 50 points is exceeded, positioning is discontinued and the warning "no operation end setting (warning code: 505)" is issued.

[Positioning start data setting]



[Processing sequence]

In the case of the above setting, the positioning data is processed in the following sequence:

- 20 → 21 → 22 → 23 → 24 → 30 → (Positioning end)

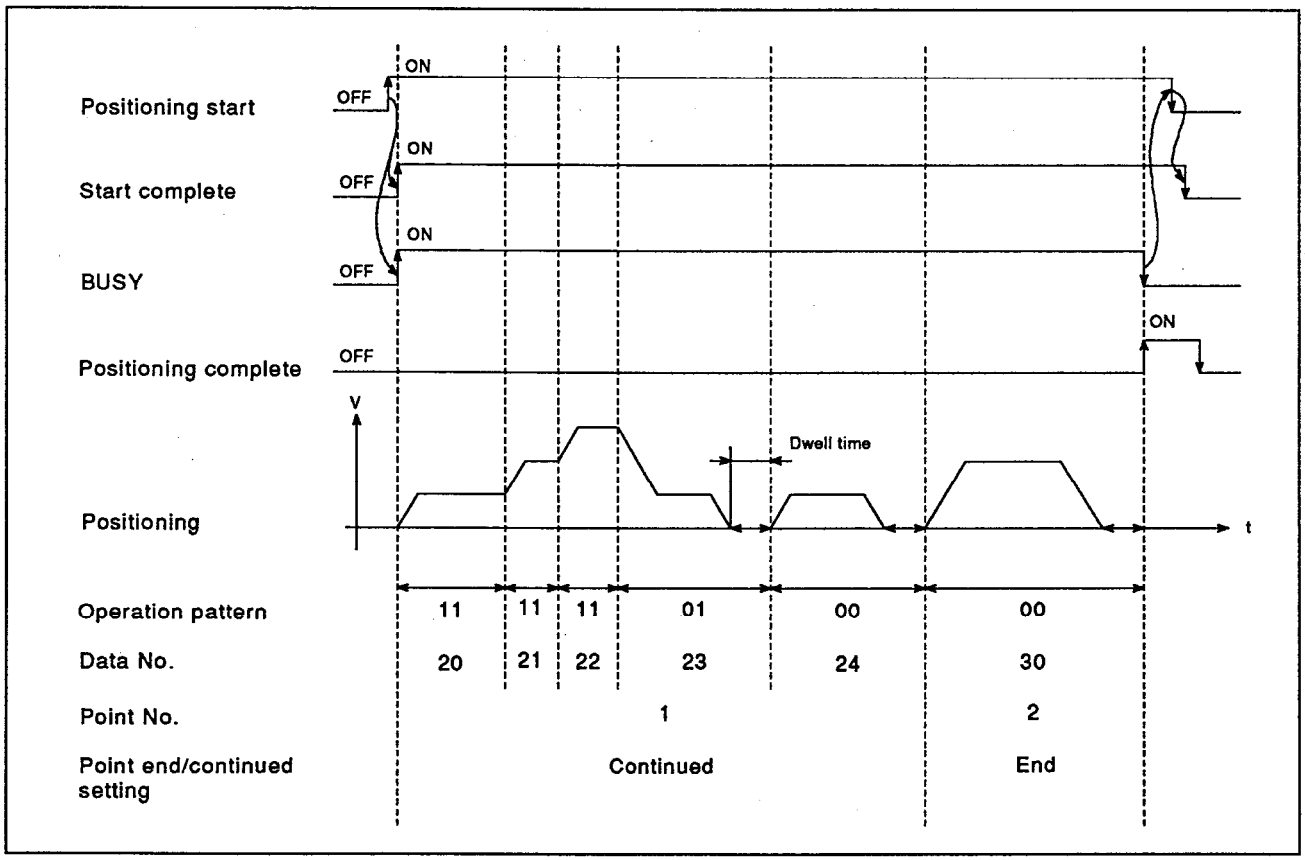


Fig. 3.2 Block Positioning Processing

3.3.3 Positioning stop

This section describes the causes for which axes may be stopped during positioning.

(1) Stop processing and order of priority

(a) Stop processing

There are three types of stop during positioning: deceleration stop, rapid stop, and immediate stop.

1) Deceleration stop *1

This is a stop made in accordance with deceleration times 1 to 4 in the basic parameters and extended parameters.
Which of deceleration times 1 to 4 is used is determined by the positioning data settings.

2) Rapid stop *1

This is a stop in accordance with the "rapid stop deceleration time" set in the extended parameters.

3) Immediate stop

This is a stop without deceleration processing.
The AD75 stops pulse output immediately but coasts by the amount of droop pulses in the drive unit's deviation counter.

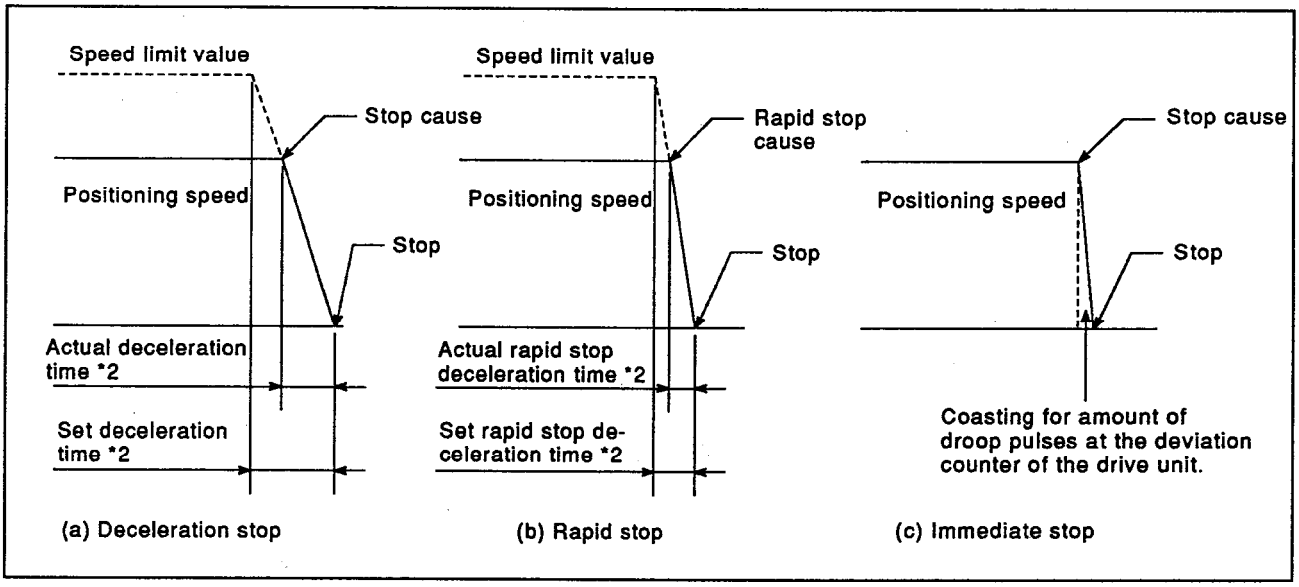


Fig. 3.3 Outline of Stop Processing

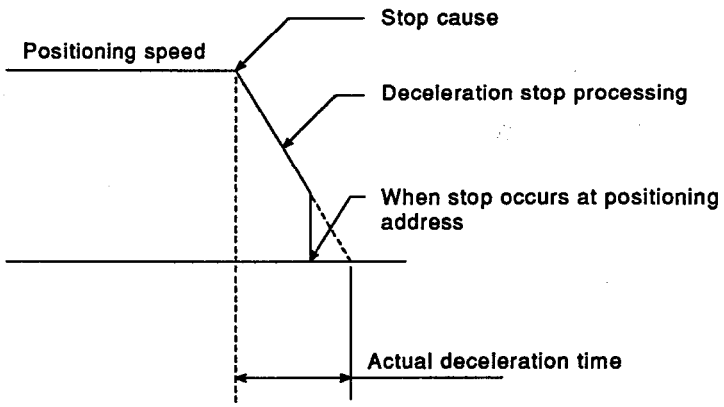
REMARKS

1) *1: Deceleration stop and rapid deceleration stop are selected in the "stop group 1 to 3 rapid stop selections" of the extended parameters. (The default is "normal deceleration stop".)

2) *2: For details on the actual deceleration time, set deceleration time, actual rapid stop deceleration time, and set rapid stop deceleration time, See Section 3.3.15.

POINT

An immediate stop occurs on reaching the set positioning address during a deceleration stop in position control.



(b) Order of priority for stop processing

The order of priority for AD75 stop processing is as follows.

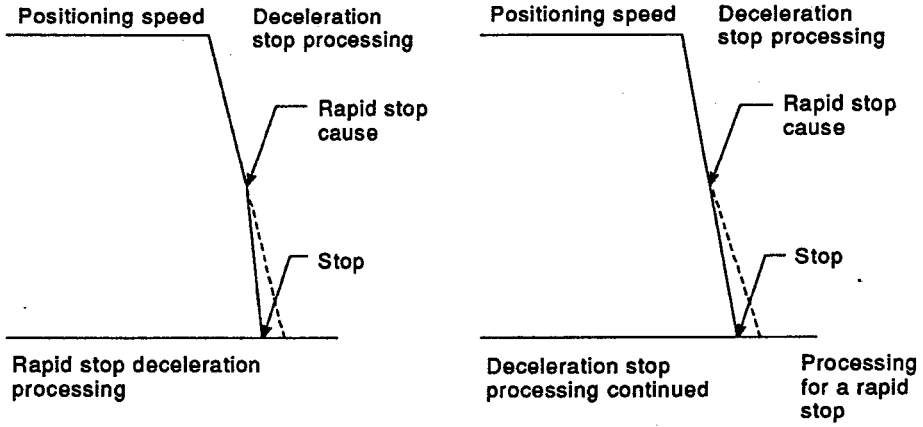
(deceleration stop) < (rapid stop) < (immediate stop)

1) Even if the deceleration stop command comes ON or a deceleration stop cause occurs during deceleration (including automatic deceleration), the current deceleration will remain in effect until the stop.

2) If a stop signal for which rapid stop is designated comes ON - or a stop cause occurs - during deceleration, rapid stop processing commences from that point.
However, if the rapid stop deceleration time is longer than the remaining deceleration time, the current deceleration stop processing will continue even if a rapid stop cause occurs during deceleration stop processing.

Example

The processing when a rapid stop cause occurs during deceleration processing is indicated below.



(2) Stop commands, stop causes

(a) The types of stop command and stop cause are shown in Table 3.4: they are classified into "individual axis stop" and "all-axis simultaneous stop".

1) In the case of a stop command or stop cause for an individual axis, only the axis for which the stop command came ON or the stop caused occurred stops.
However, if during interpolation control, one of the axes is stopped by a stop command or the occurrence of a stop cause, both axes involved in the interpolation control are stopped.

2) In the case of an all-axis simultaneous stop command or stop cause, all axes are stopped when the stop command comes ON or the stop cause occurs.

(b) The stop commands and stop causes that can be selected for deceleration stops and rapid stops are classified into stop groups 1 to 3.
"Deceleration stop" or "rapid stop" can be set for each stop group by using the extended parameters.

1) Stop group 1: Critical stop cause

2) Stop group 2: Emergencies

3) Stop group 3: Intentional stop and relatively minor errors

Table 3.4 Stop Processing According to Stop Cause and Operating Status

Stop Cause		Positio-ning *4	Home Position Return *5	JOG Operation	Manual Pulse Generator Operation	Stop Axis	Axis Operating Status After Stop	M code ON Signal Status
—	Drive unit ready OFF *1 (Servo ready OFF)	Immediate stop			Immediate stop	Individual axes	Error	No change
	When an error occurs in continuous locus positioning *2							
Stop group 1	External upper limit switch ON	Deceleration stop/rapid stop			Immediate stop	Individual axes	Error	No change
	External lower limit switch ON							
Stop group 2	Outside software stroke limit	Deceleration stop/rapid stop			Immediate stop	Individual axes	Error	No change
	[Stop] key input from peripheral device					All axes		
	Sequence ready OFF							Turned OFF
Stop group 3	External stop signal ON *6	Deceleration stop/rapid stop			Immediate stop	Individual axes	Stopped/ Standby	No change
	Axis stop signal (Yn) ON *6							
	Axis error occurrence (other than stop groups 1, 2)						Error	
	Test mode error							

REMARKS

1) *1: This is stop processing by drive unit hardware processing.

2) *2: Whether or not the software stroke limit is effective for JOG operation and manual pulse generator operation can be selected using validating/invalidating the software stroke limit during JOG operation/manual pulse generator operation in the axis control data.

3) *3: Normal operation proceeds up to the positioning data immediately preceding the positioning data at which any of the following errors occurred, then an immediate stop is executed.
Out of linear travel value range(error code: 504)
Excessive arc error(error code: 506)
Travel outside stroke limit +(error code: 511)
Travel outside stroke limit -(error code: 512)
Auxiliary point setting error(error code: 525)
End point setting error(error code: 526)
Center point setting error(error code: 527)
Out of radius range(error code: 544)

4) *4: "Positioning" here means position control, speed control, or speed/position switching control, in accordance with positioning data.

5) *5: Indicates travel at the home position return speed or creep speed during a home position return.

POINT

*6: Positioning will not start even if the external stop signal or axis stop signal (Yn) goes OFF while the start signal is ON.
(The start signal is effective at its leading edge (OFF → ON)).

(3) Stop signal input during deceleration

(a) If a stop signal is input during deceleration (including automatic deceleration), the deceleration continues unaltered before axis motion stops.

(b) When a stop signal is input during deceleration in a home position return, the deceleration continues unaltered before axis motion stops. However, axis motion stops immediately during axis motion at the creep speed.

(c) Rapid stop processing is performed as soon as a stop cause requiring a rapid stop occurs during deceleration, provided that the rapid stop time is shorter than the stop time.

(4) Stop processing during interpolation

(a) During interpolation, both operating axes are stopped by stop signals issued to both axes.

(b) On restarting interrupted positioning (starting when axis motion is stopped), positioning begins from where the axes stopped.
On restarting after positioning operation has been stopped while the system was waiting for conditions to be fulfilled, the waiting for condition fulfillment status is re-established.

(5) M code

When the PC READY signal is turned OFF, a "0" M code is issued.

3.3.4 Operation pattern

Operation patterns represent control patterns for various factors, such as how the positioning data corresponding to two or more data numbers will be executed, or the nature of the acceleration/deceleration between positioning data.

There are three operation patterns - positioning end, continuous positioning control and continuous locus control.

Of these three operation patterns, continuous locus control executes almost the same function as constant speed control.

The categories of operation pattern are shown below:

- Operation pattern
  - Positioning end (00)
  - Positioning continued
    - Continuous positioning control (01)
    - Continuous locus control (11)

(1) Positioning end

Set this operation pattern to execute positioning to the designated address and complete the positioning of the current point. If a dwell time has been designated, positioning is completed after elapse of the designated time.

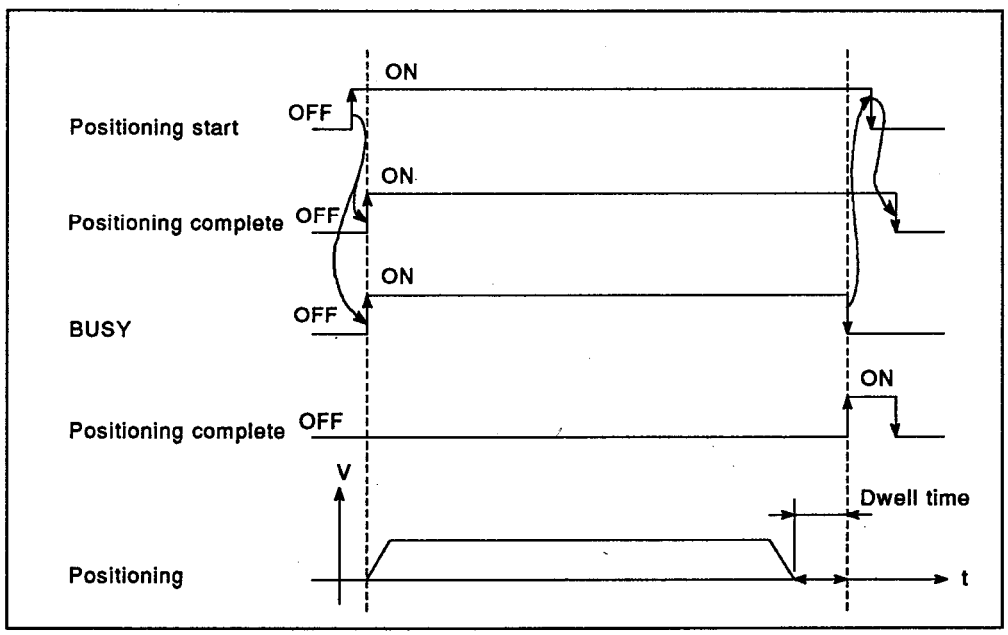


Fig. 3.4 Operation for "Positioning End"

(2) Continuous positioning control

(a) Each time positioning is completed in accordance with a single positioning data, the axis is automatically decelerated to 0, then it is accelerated again to perform positioning based on the next positioning data.

(b) Set operation pattern "00" at the end of positioning by continuous positioning control (01) to terminate positioning.
When "positioning continued" is set as the operation pattern, positioning continues until operation pattern 00 is detected.
If operation pattern 00 is not identified, positioning may proceed to positioning data No. 600.

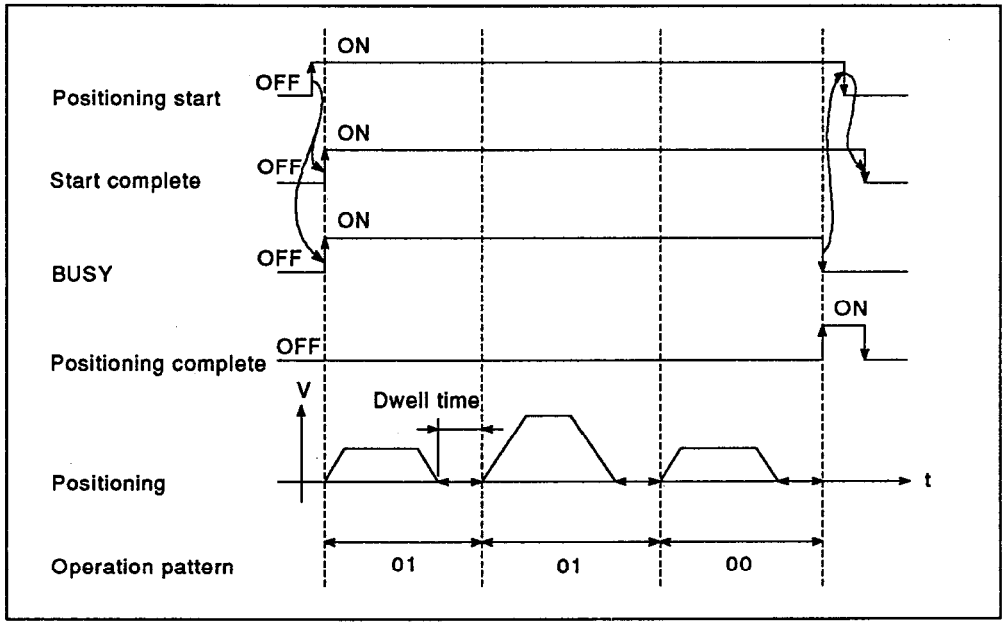


Fig. 3.5 Operation for Continuous Positioning Control

(3) Continuous locus control

(a) The speed of positioning according to the ongoing positioning data is changed to the speed of the positioning data for the next positioning.
The speed will not be changed if the current speed and the speed of the next positioning are the same.

(b) When the set commanded speed is -1, the speed of the previous positioning is valid.

(c) If a dwell time is set, it is ignored.

(d) Set operation pattern "00" at the end of positioning by continuous locus control (11) to terminate positioning.
When positioning continued is set as the operation pattern, positioning continues until operation pattern 00 is detected.
If operation pattern 00 is not identified, positioning may proceed to positioning data No. 600.

(e) As the speed switching pattern, the "advance speed change pattern" which changes the speed at the end of the ongoing positioning, or the "standard speed change pattern" which changes the speed at the start of the next positioning, can be selected.

Continuous locus control ─┬─ Standard speed change mode
                          └─ Advance speed change mode

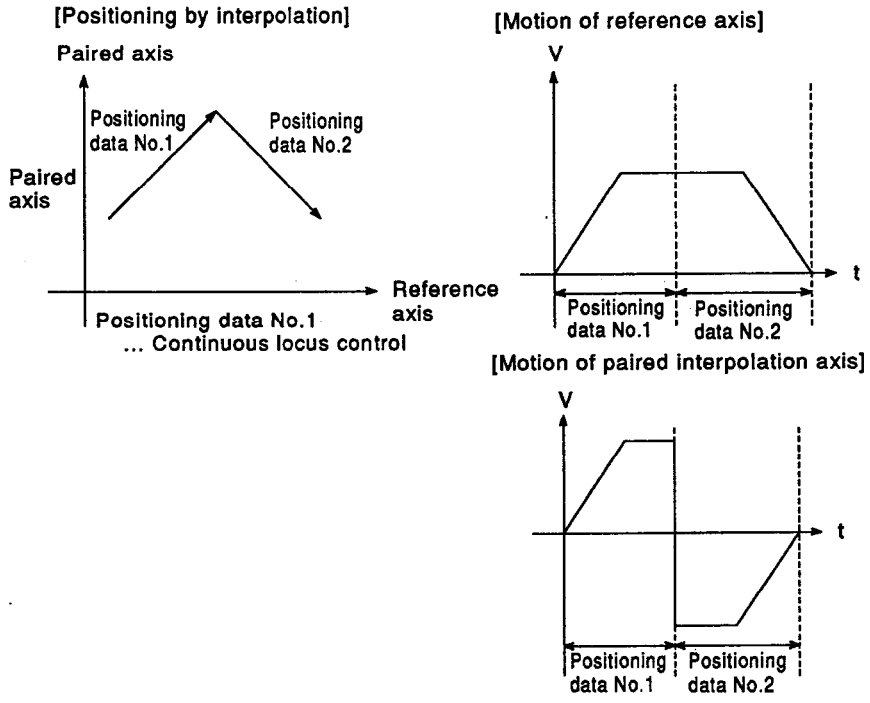
Automatic deceleration conditions

As a rule, automatic deceleration is not executed in continuous locus control. However, under any of the conditions mentioned below, axis motion is decelerated to zero by automatic deceleration:

- When the operation pattern of the current positioning data is "11", and there are different travel values in the current data and the next data. (See POINTS.)
- During step operation (See Section 3.3.21)
- When there is an error in the positioning data to be executed next

POINTS

(1) In interpolation control, only the travel direction of the reference axis is checked. Therefore, automatic deceleration is not performed as long as the travel direction on the reference axis remains unchanged.This may result in sudden direction reversal on the other interpolation axis.
To avoid a sudden direction reversal on the other interpolation axis, program the pass point in continuous positioning control (01) rather than continuous locus control (11).



(2) Automatic deceleration is not performed when circular interpolation control is set for either the current positioning data number or the next data number.

Speed processing

- The commanded speed is set in the setting positioning data, but it may be omitted.
  In such a case, the speed used in the previous positioning remains effective.
- To omit the commanded speed, set "-1" as the commanded speed. The peripheral device displays "-1".
- The AD75 retains the commanded speed set in the positioning data number, and the latest speed set in response to a speed change request as the current speed. When -1 (current speed) is set as the commanded speed, control is performed at the current speed.
- The feed speed may fail to reach the speed change value because of the relationship between the travel value and the change speed. However, the current speed is updated even in such a case.
- If "-1" is set for the commanded speed of the first positioning data on starting, a "No commanded speed error (error code: 503)" occurs and positioning does not begin.

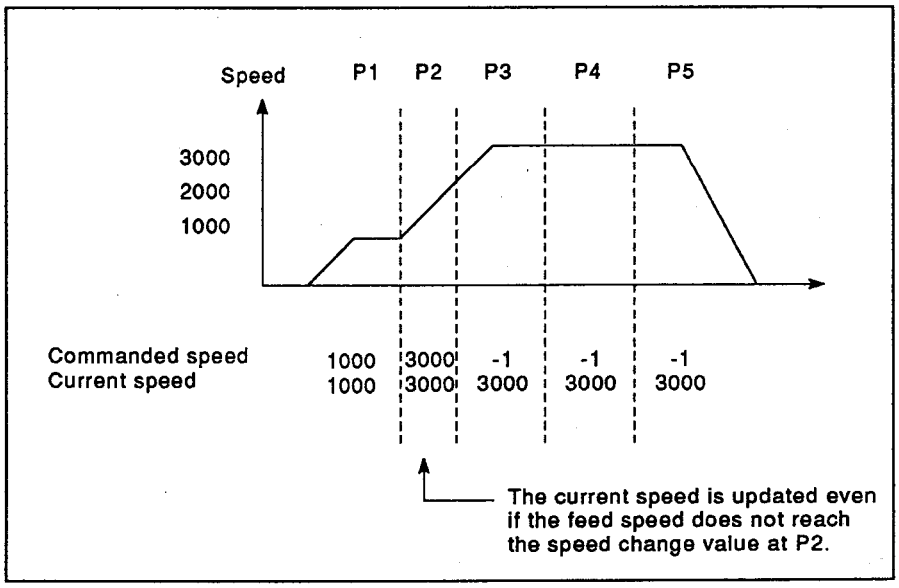


Fig. 3.6 Relationship Between Commanded Speed and Current Speed

Standard speed change mode

- When the commanded speed of the ongoing positioning data number and that of the next data number are different, the currently valid speed is accelerated or decelerated to the designated value of the next data number after the axis has reached the positioning end point.

- For acceleration or deceleration, the parameters of the positioning data number executing acceleration or deceleration are used. A speed change does not take place when the commanded speed is the same.

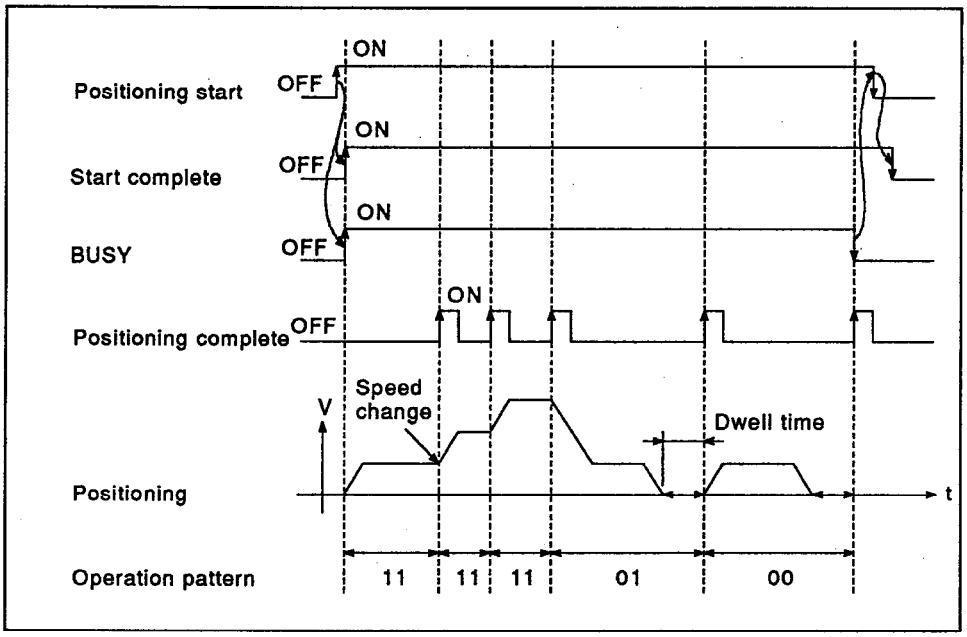
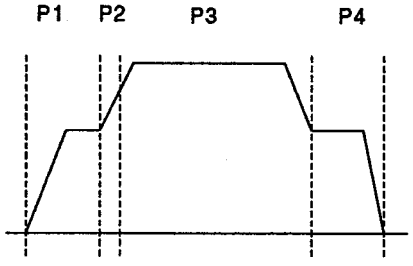


Fig. 3.7 Operation in Standard Speed Change Mode

- Speed change conditions
  When the travel value is too short for the target speed and consequently the actual speed does not reach the target speed in acceleration and deceleration, the actual speed is accelerated or decelerated to as close a speed as possible to the target.
  If the axis overruns the travel value when automatic deceleration is required (for example, when the operation pattern is 00 or 01), the axis will stop at the positioning address immediately, and "insufficient travel value warning (warning code: 513)" will be issued.

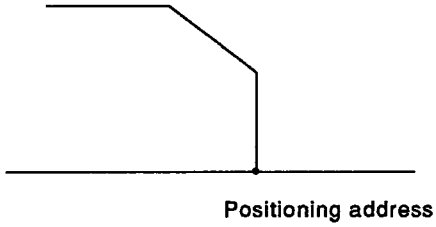
[When the speed cannot be changed at P2]

Speed relationship: P1 = P4, P2 = P3, P1 < P2



[When the travel value is short in automatic deceleration]

Since the travel value required for automatic deceleration cannot be assured, the axis stops immediately at any speed higher than 0.



Positioning address

Advance speed change mode

- When the commanded speed of the ongoing positioning data number and that of the next data number are different, the currently valid speed is changed to the designated value of the next data number at the end of the current positioning.
- For acceleration or deceleration, the parameters of the positioning data number executing the acceleration or deceleration are used. A speed change does not take place when the commanded speed is the same.

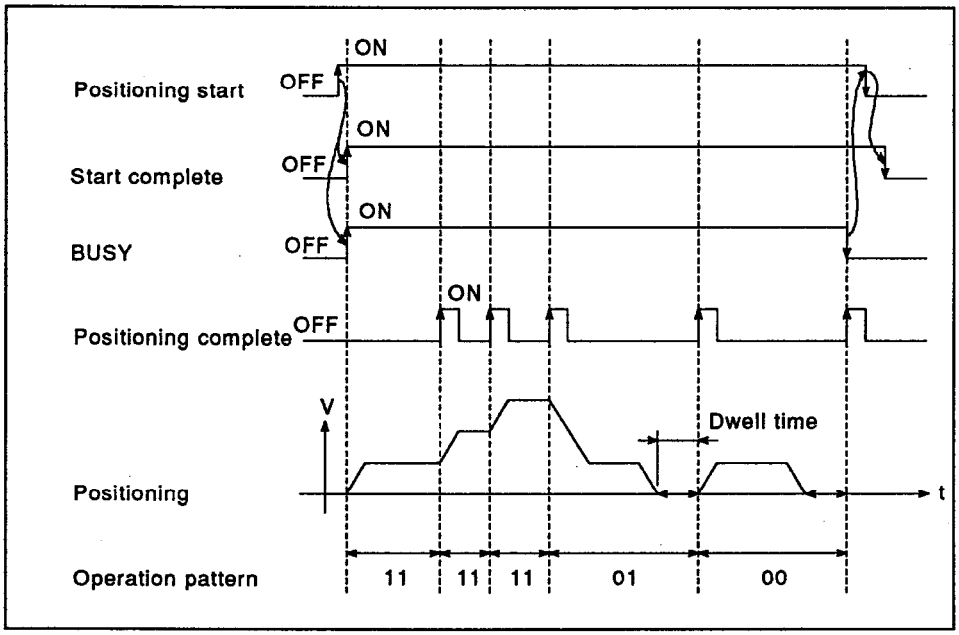
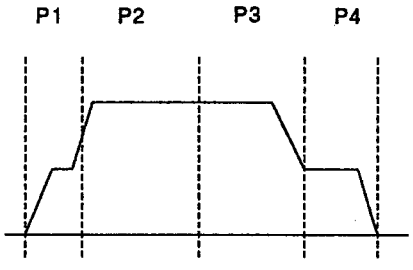


Fig. 3.8 Operation in Advance Speed Change Mode

- Speed change conditions
  When the travel value is too short for the target speed and consequently the actual speed does not reach the target speed in acceleration and deceleration, the actual speed is accelerated or decelerated to as close a speed as possible to the target.
  If the axis overruns the travel value when automatic deceleration is required (for example, when the operation pattern is 00 or 01), the axis will stop at the positioning address immediately, and "insufficient travel value warning (warning code: 513)" will be issued.

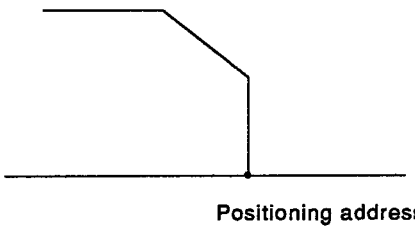
[When the speed cannot be changed to P2 at P1]

Speed relationship: P1 = P4, P2 = P3, P1 < P2



[When the travel value is short in automatic deceleration]

Since the travel value required for automatic deceleration cannot be assured, the axis stops immediately at any speed higher than 0.



3.3.5 Interpolation

(1) Interpolation uses two axes.

(2) Write the control method to: the positioning data for axis 1 for interpolation by axis 1 and axis 2; the positioning data for axis 2 for interpolation by axis 2 and axis 3; or the positioning data for axis 3 for interpolation by axis 3 and axis 1.

(3) The positioning identifier, M code, dwell time, commanded speed and other parameters for axis 1 are used for interpolation by axis 1 and axis 2, those for axis 2 for interpolation by axis 2 and axis 3, or those for axis 3 for interpolation by axis 3 and axis 1.
However, the positioning address and arc data used must be those set for the same positioning data number of each axis.

(4) When interpolation is executed using continuous positioning control or continuous locus control, include everything from the first positioning data No. started to the operation pattern 00 positioning data No. in the interpolation.
If the positioning data set for each point of the positioning start data in a block start is interpolation data, make all these points subject to interpolation.
Failure to do this may cause the AD75 to malfunction.

(5) There are two interpolation speed specification methods (interpolation modes), resultant speed (default) and reference axis speed.
The reference axis speed mode is, however, applicable only to linear interpolation control, and it may not be possible to designate either mode if there is an axis unit G (group) mismatch.
During interpolation, the paired axis (second axis) remains in the interpolation state, and returns to standby on completion of interpolation.
If an error occurs during interpolation, both axes decelerate to a stop and go into an error status.

(a) Axis unit G (groups) are classified as follows.

Unit G (Group)	Unit
Group 1	mm, inch
Group 2	degree
Group 3	PULS (PLS)

(b) Whether or not interpolation is possible is determined as follows.

Interpolation	Speed Designation	Unit G Matched	Unit G Mismatched
Linear interpolation	Resultant speed	Applicable	Inapplicable
	Reference axis speed	Applicable	Applicable
Circular interpolation	Resultant speed	Applicable	Inapplicable
	Reference axis speed	Inapplicable	Inapplicable

1) The units "mm" and "inch" can be used together and they belong to the same group.

2) Circular interpolation cannot be performed when "degrees" is selected as the unit.
Selecting circular interpolation as the control method with degree units causes a "Control method setting error (error code: 524)" and positioning does not begin.
If positioning control is in progress, an immediate stop will occur on detection of the error.

(c) Speed unit when different units are used

Linear or circular interpolation in the resultant speed mode is possible whether unit group is matched or mm and inch units are both used.
Linear interpolation can be executed in the reference axis mode even when the unit G is mismatched.
The following table shows the applicable speed units in such cases.

Speed Designation	Interpolation Axes	Applicable Speed	Speed Unit
Resultant speed (linear interpolation, circular interpolation) (mm and inch are used together.)	Axis 1 and axis 2	Speed of axis 1	Unit of axis 1. The unit is always the same.
	Axis 2 and axis 3	Speed of axis 2	Unit of axis 2. The unit is always the same.
	Axis 3 and axis 1	Speed of axis 3	Unit of axis 3. The unit is always the same.
Reference axis speed (linear interpolation) (Various units are used together.)	Axis 1 and axis 2	Speed of axis 1	Unit of axis 1. The unit is always the same.
	Axis 2 and axis 3	Speed of axis 2	Unit of axis 2. The unit is always the same.
	Axis 3 and axis 1	Speed of axis 3	Unit of axis 3. The unit is always the same.

REMARK

For details on the resultant speed and reference axis speed, see Section3.4.2 (9).

3.3.6 Speed control (VF, VR)

(1) Description of speed control

(a) The designated axis of the positioning start data is controlled at the commanded speed until a stop command is input.

(b) The VF or VR speed control mode can be selected according to the direction of rotation.

- VF..... Start in forward direction
- VR..... Start in reverse direction

(2) Operation timing

Fig. 3.9 shows the speed control operation timing.

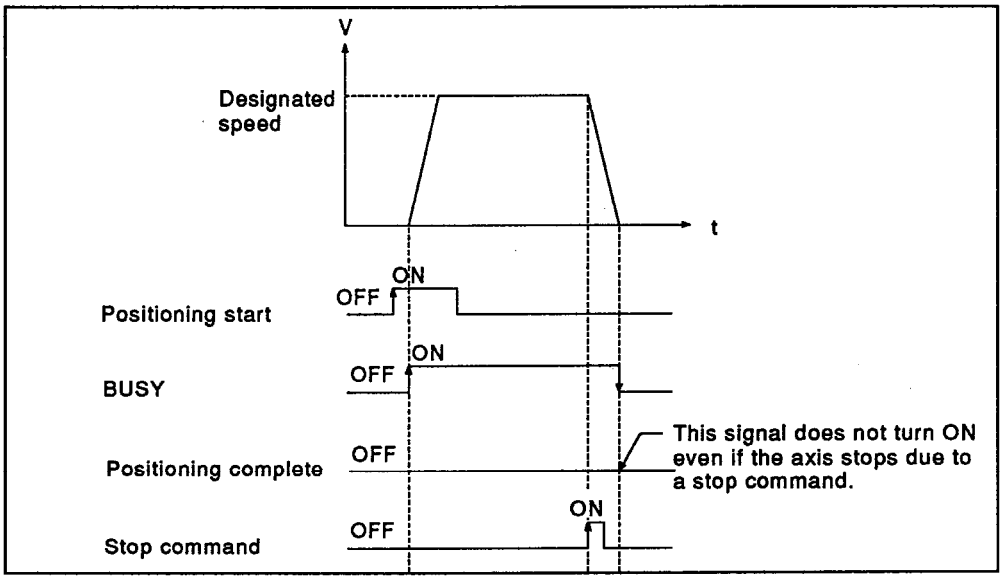


Fig. 3.9 Speed Control Operation Timing

(3) Feed present value updating

As shown below, the processing of the feed present value differs depending on the setting of "feed present value update request designation during speed control" of extended parameters #1. (See Section 3.4.2 (10).)

(a) When 0 (feed present value update disabled) is set:
The feed present value remains unchanged before and after execution of speed control.

(b) When 1 (feed present value update enabled) is set:
The feed present value is updated during speed control.

POINT

When positioning is commenced with the feed present value update request designation setting "1", do not change it until positioning control is completed.
If the setting is changed to "0" in the middle of positioning control, the feed present value cannot be maintained.

(4) Confirmation during speed control

The speed control in progress flag is changed to 1 during speed control. *

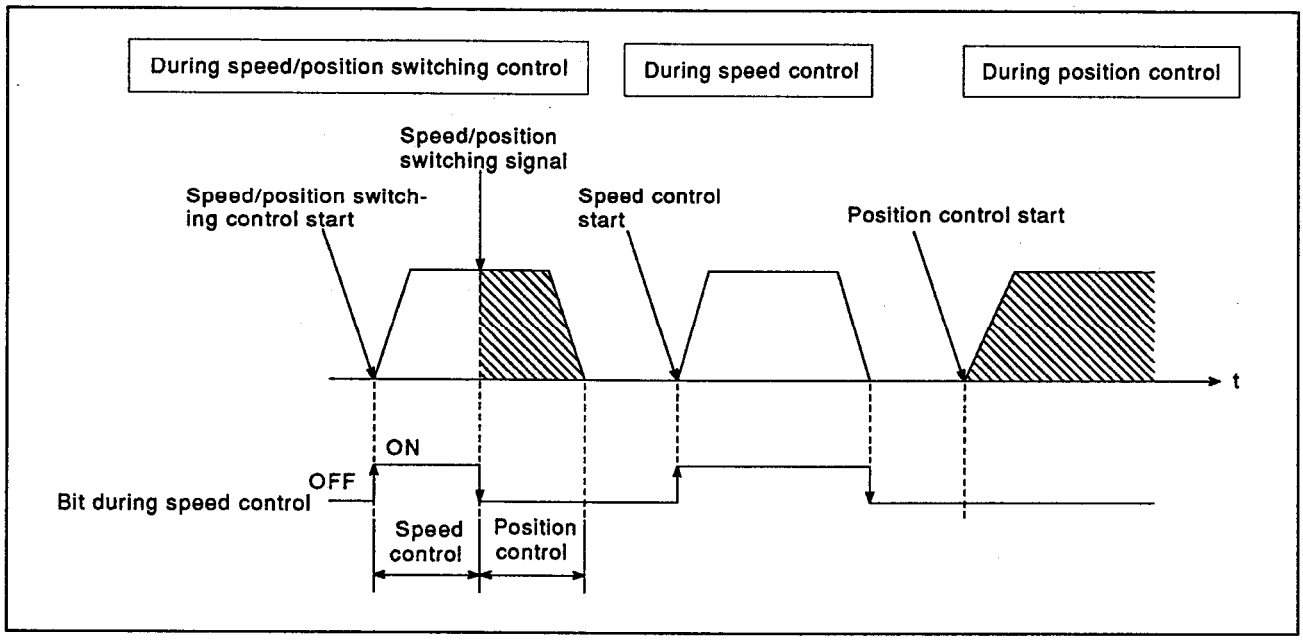


Fig. 3.10 Speed Control In Progress Flag Timing Chart

(5) Constraints

(a) Speed control cannot be used for continuous locus control.

If speed control is designated when the operation pattern of the positioning data is continuous locus control, "continuous locus control not possible error (error code: 516)" will result, and positioning will not begin.

(b) The dwell time setting is ignored.

(c) The M code can be used only in the "WITH mode".
When the AFTER mode is selected, no M codes will be output, and the M code ON signal will not be turned ON.

REMARK

*: The speed control in progress flag is set at bit 0 of the "status" area in the axis monitor area of the buffer memory. For details, See Section 3.6.3 (2).

(6) Designating positioning data *1

The following positioning data can be set with the peripheral device or sequence program:

Data	Necessity of Setting *2
Operation pattern	o
Control method *3	Select "forward speed control" or "reverse speed control".
Acceleration time	o
Deceleration time	o
Positioning address/Travel value	—
Circular interpolation address	—
Commanded speed	o
Dwell time	Δ
M code	Δ

REMARKS

1) *1: For details of positioning data, see Section 3.4.5.

2) *2: Whether or not setting is necessary is indicated by one of the following symbols:

- o : Must be set.
- Δ : May be set as required.
- — : Need not be set.

3) *3: Make the selection of "forward speed control" or "reverse speed control" for the control method based on the direction of rotation of the motor.

3.3.7 Speed/position switching control (VPF, VPR)

(1) Description of speed/position switching control

(a) Speed control is executed for the designated axis of the positioning start data until receipt of the speed/position switching signal, whereupon the control mode switches from speed control to position control and positioning is performed for the designated travel value.

(b) The VPF or VPR speed/position switching control mode can be selected according to the direction of rotation.

- VPF..... Start in forward direction (address incremental direction)
- VPR ..... Start in reverse direction (address decremental direction)

(2) Switching from speed control to position control

(a) A speed/position switching signal switches the control mode from speed control to position control.

(b) The speed/position switching signal is valid only when the speed/position switching enabled flag in the axis control data is ON. (See Section 3.6.4 (2).)
If the speed/position switching enable flag is turned ON after the speed/position switching signal, the control mode cannot switch from speed control to position control, which means that speed control remains in effect.

(3) Operation timing

Fig. 3.11 shows the operation timing of speed/position switching control.

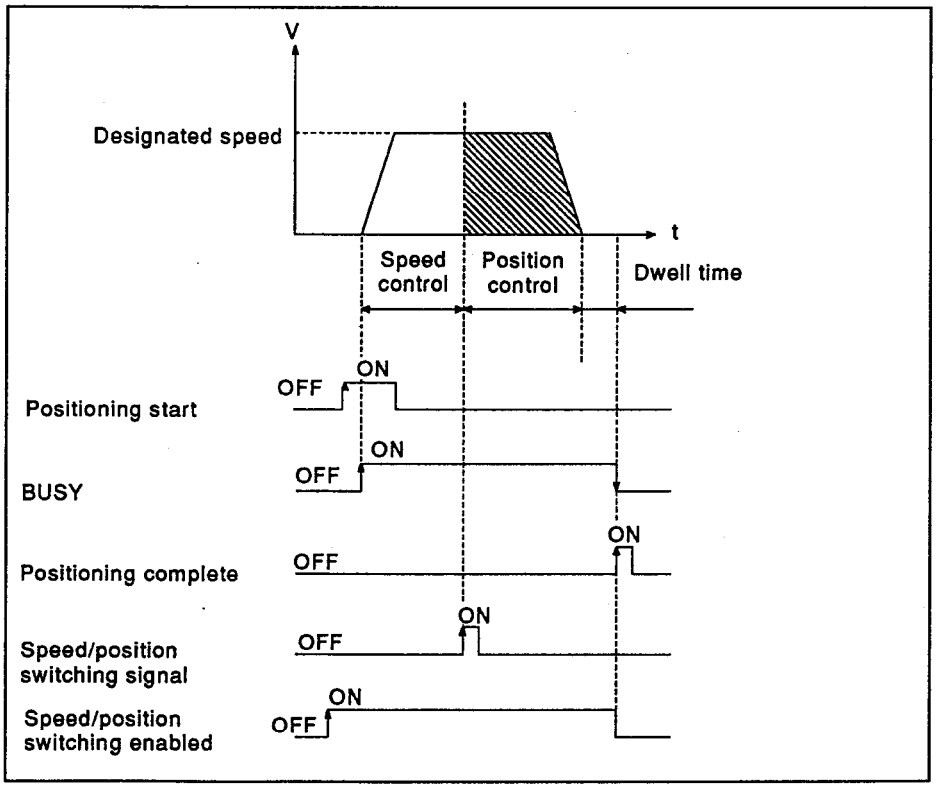


Fig. 3.11 Speed/Position Switching Control Operation Timing

(4) Feed present value updating

As described below, the processing of the feed present value is different depending on the setting of "feed present value update request designation during speed control" of extended parameters #1. (See Section 3.4.2 (10).)

(a) When 0 (feed present value update disabled) is set:

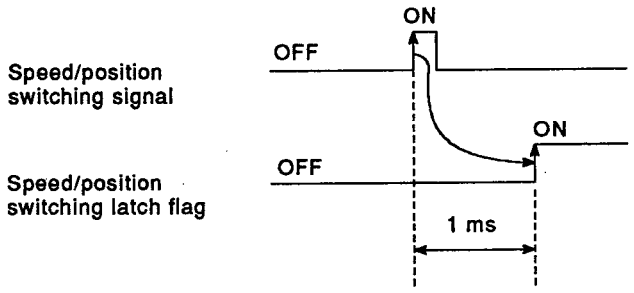
- The feed present value remains is the same during speed control as before speed control started.
- Feed present value updating begins on switching of the control mode to position control.

(b) When 1 (feed present value update enabled) is set:

- The feed present value is updated during speed control.

(5) Switching time from speed control to position control

The time from speed/position control switching signal ON to speed/position switching latch flag ON is 1 ms.



POINT

When positioning is commenced with a feed present value update request designation setting of "1", do not change it until positioning control is completed.
If the setting is changed to "0" in the middle of positioning control, the feed present value cannot be maintained.

(6) Travel value change

(a) Travel values can be changed by position control in the speed control mode of speed/position switching control.
Any requests for travel value changes will be ignored in the position control mode of speed/position switching control.

(b) Travel values changed during speed control are stored to the speed/position switching control travel value change register using the sequence program. (See Section 3.6.4 (2).)
The data stored in the speed/position switching control travel value change register will become the travel value when the speed/position switching signal is turned ON.

(c) The travel value from the point when a switch to position control is made due to input of a speed/position switching signal from an external source is stored in the "travel value after speed/position switching signal ON" area in the axis monitor area. (See Section 3.6.3 (2))

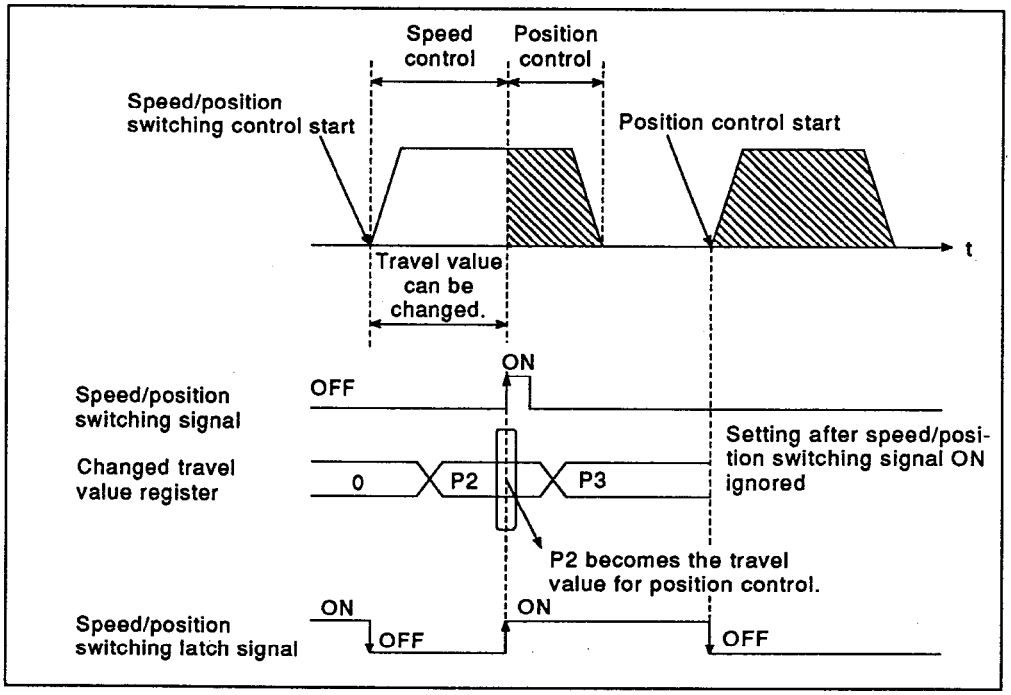


Fig. 3.12 Travel Value Change Timing in Position Control

POINTS

(1) Requests for travel value changes can be identified simply by writing changed travel values to the changed travel value register using the sequence program.

(2) The travel value after the change can become valid at any time up to input of the speed/position switching signal during speed/position switching control.

(3) The "speed/position switching latch flag" in the axis monitor area can be used as a travel value change enable/disable interlock in position control. (See Section 3.6.3 (2))

(7) Constraints

(a) To use a pulse train output motor, turn ON the speed/position switching signal within the stable speed range (stable speed state). A warning will be issued if the signal is turned ON during acceleration because of a large fluctuation in the number of droop pulses.

(b) Speed/position switching control cannot be used for continuous locus control.
If speed/position switching control is designated when the operation pattern of the positioning data is continuous locus control, an axis error will result, and positioning will not begin.

(c) Only position control is performed when both speed/position switching enabled and speed/position switching signals are turned ON at the start of positioning.

(d) If the travel value in position control is shorter than the deceleration distance at the control speed, deceleration begins on input of a speed/position switching signal.

(e) A software stroke limit range check is executed only when the "feed present value update request" is ON during speed control.

(8) Designating positioning data *1

The following positioning data can be set with the peripheral device or sequence program:

Data	Necessity of Setting *2
Operation pattern	o
Control method *3	Select "forward speed/position control" or "reverse speed/position control".
Acceleration time	o
Deceleration time	o
Positioning address/Travel value	—
Circular interpolation address	—
Commanded speed	o
Dwell time	Δ
M code	Δ

REMARKS

1) *1: For details of positioning data, see Section 3.4.5.

2) *2: Whether or not setting is necessary is indicated by one of the following symbols:

- o : Must be set.
- Δ : May be set as required.
- — : Need not be set.

3) *3: Make the selection of "forward speed/position control" or "reverse speed/position control" for the control method based on the direction of rotation of the motor.

3.3.8 Home position return function

(1) Description of home position return

(a) Home position return means moving the axes to the machine home position, for example when the power is switched on.

(b) The AD75 provides the following six types of home position return:

- Near-zero point dog method
- Stopper stop (1) (on elapse of dwell time)
- Stopper stop (2) (by zero point signal issued when the axis contacts the stopper)
- Stopper stop (3) (method without a near-zero point dog)
- Count method (1) (using a zero point signal)
- Count method (2) (using no zero point signal)

Specify the home position return method with the home position return parameter.

(2) Precautions

(a) The home position return parameter must be set for each axis to perform home position return.

(b) The home position return function is not available when the operation pattern is continuous locus control or continuous positioning control.

(c) Acceleration/Deceleration time selection for home position return
For home position return, set an acceleration time and a deceleration in the parameters for home position return of positioning data No. 9001 and high-speed home position return of positioning data No. 9002, respectively.

REMARK

The home position return parameters comprise the "basic parameters for home position return" and the "extended parameters for home position return".

- Basic parameters for home position return: Section 3.4.3
- Extended parameters for home position return: Section 3.4.4

(3) Home position return methods

Near-zero point dog home position return

(a) Description of near-zero point home position return

Near-zero point dog home position return stops axis motion with in response to a zero point signal after the near-zero point dog has been turned OFF.
A pulse generator (PG) capable of generating a zero point signal is required.

(b) Operations in near-zero point dog home position return

When near-zero point dog home position return is started, the following operations are performed:

1) Axis travel occurs in the designated home position return direction at the designated home position return speed.

2) The speed decreases to the creep speed when the near-zero point dog comes ON.

3) The axis stops in response to the zero point signal after the near-zero point dog has been turned OFF.
A "deviation counter clear output" is issued to the drive unit.

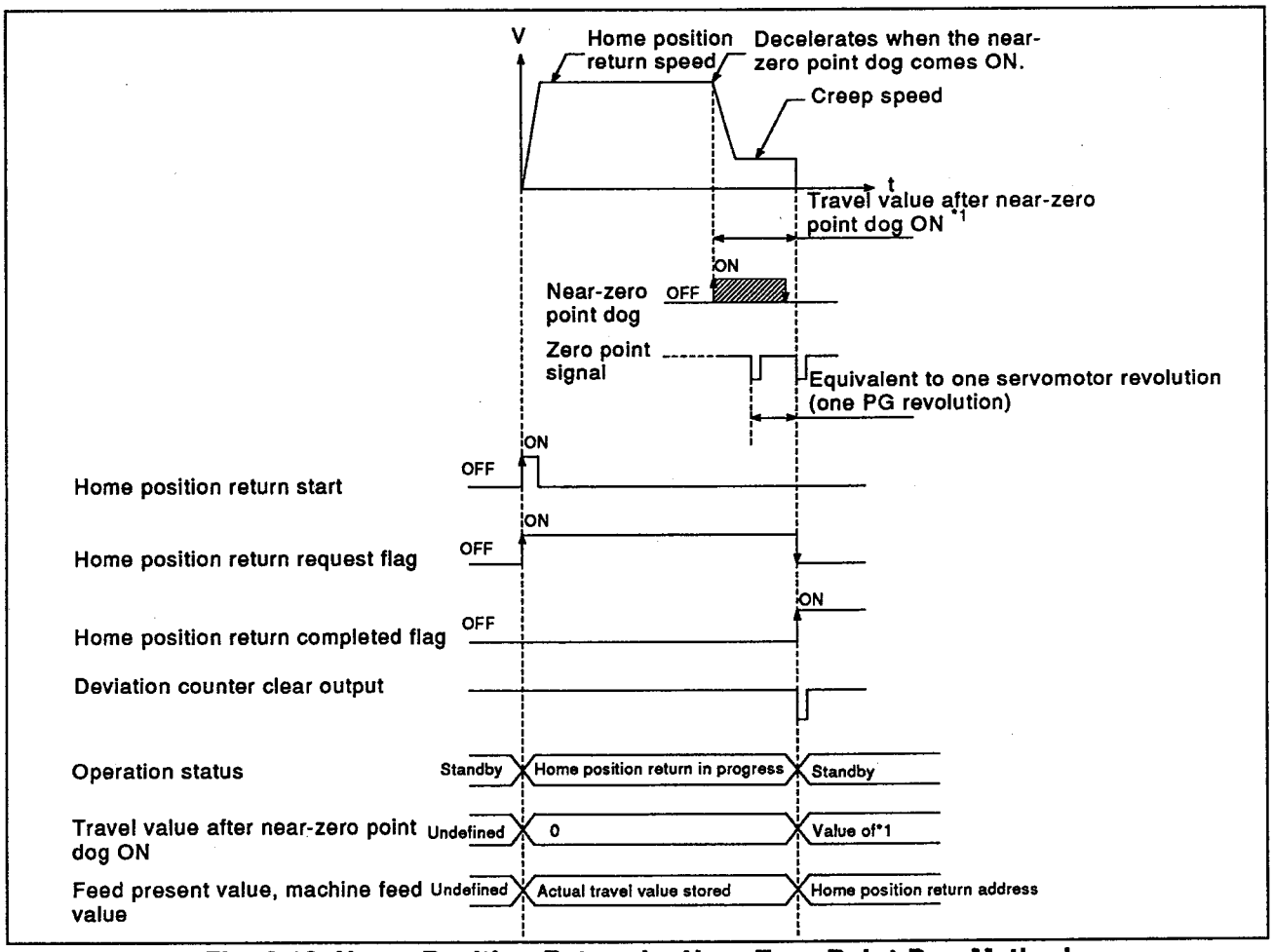
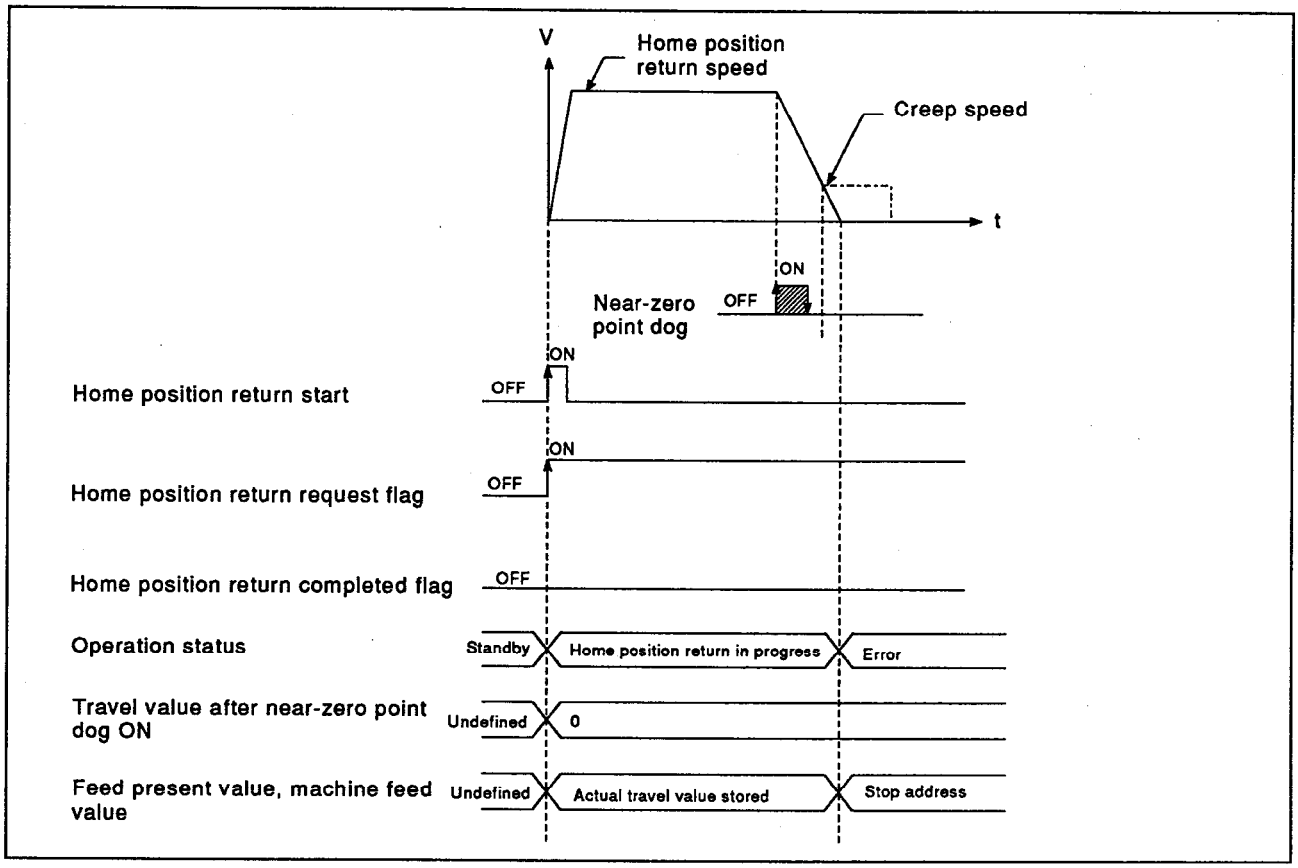


Fig. 3.13 Home Position Return by Near-Zero Point Dog Method

(c) Constraints

1) Keep the near-zero point dog ON until deceleration from the home position return speed to the creep speed begins.
If the dog is turned OFF during deceleration from the home position return speed, axis motion will decelerate to a stop.

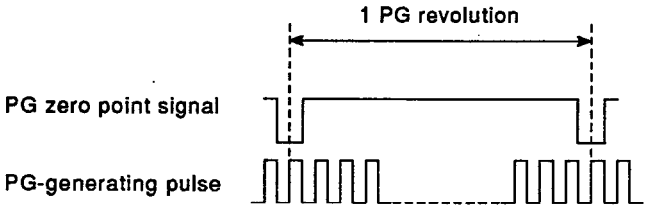


2) An error will occur if an attempt is made to perform another home position return after completion of one home position return operation with the home position return retry function disabled.
In such a case, return the axis by JOG operation to a position before where the near-zero point dog turns ON, then perform home position return.

3) Home position return when the near-zero point dog comes ON begins at the creep speed.

REMARK

The zero point signal issued from the PG is generated as a single pulse per PG revolution.



Count method (1) (using a zero point signal)

(a) Description of count method (1) home position return

1) Count method (1) home position return stops axis motion in response to a zero point signal as soon as the designated distance after the near-zero point dog was turned ON (travel value after near-zero point dog ON) has been traveled.

2) Set the travel value after near-zero point dog ON in the home position return parameters.

3) A pulse generator (PG) capable of generating a zero point signal is required.

(b) Operations in count method (1) home position return
When count method (1) home position return is started, the following operations are performed:

1) Axis travel occurs in the designated home position return direction at the designated home position return speed.

2) The speed decelerates to the creep speed with the near-zero point dog ON.

3) The axis stops with a zero point signal after the near-zero point dog has been turned ON.
A "deviation counter clear output" is issued to the drive unit.

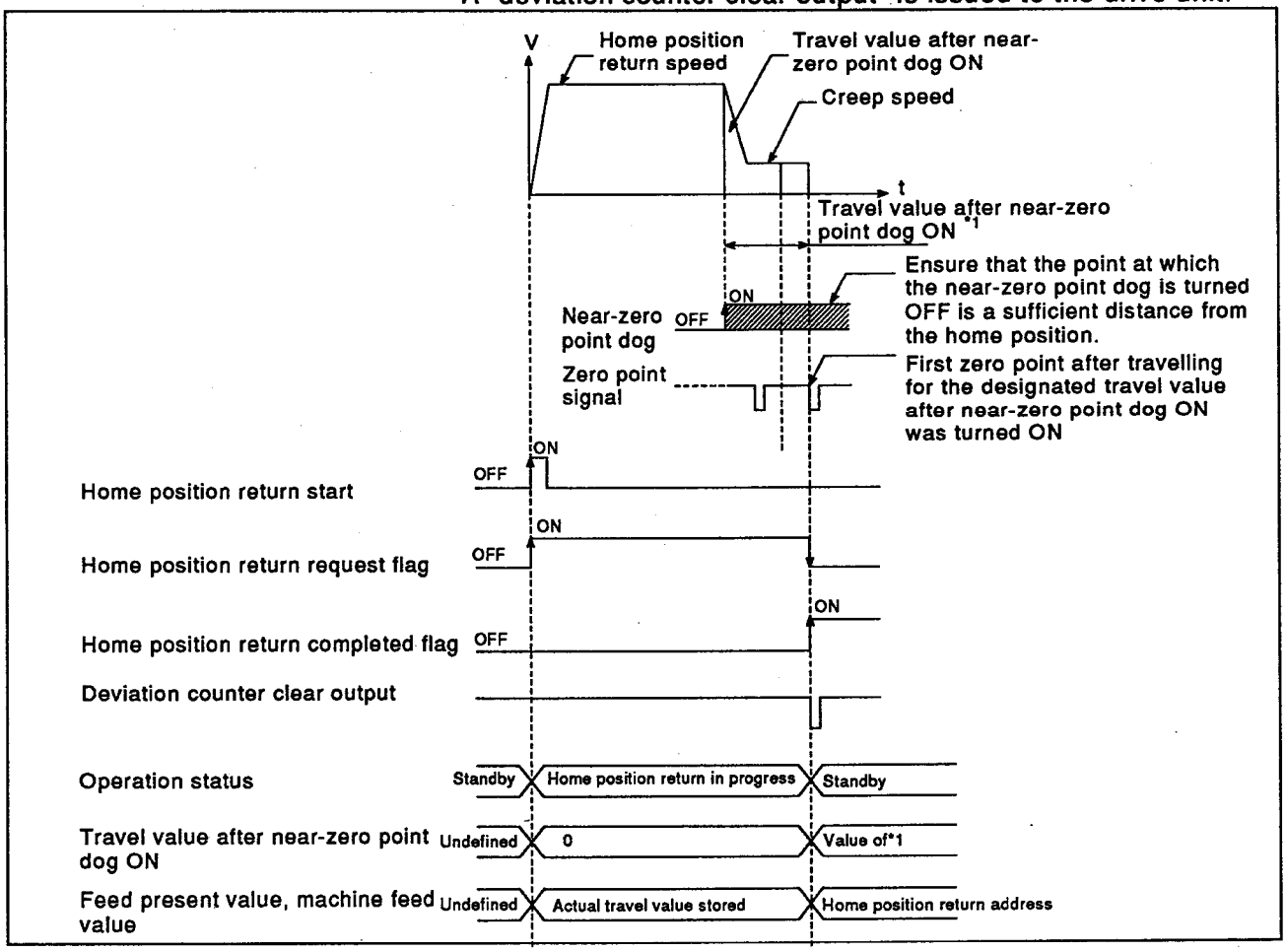
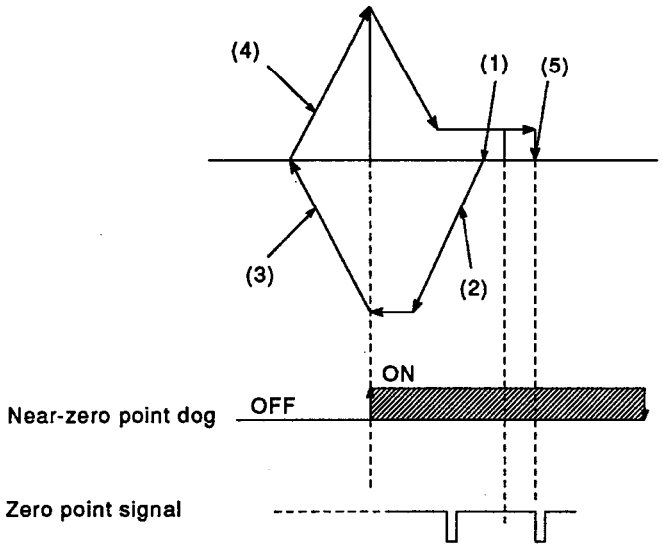


Fig. 3.14 Home Position Return by Count Method (1)

(c) Operations on home position return when the near-zero point dog comes ON and continuous starting of home position return

In count method (1) home position return, home position return can be performed when the near-zero point dog comes ON, and continuous starting of home position return is possible.
When home position return when the near-zero point dog comes ON or continuous starting of home position return is executed, the axis returns to a position where the near-zero point dog is OFF before home position return is started.



[Operations at the start of home position return when the near-zero point dog comes ON]

(1) Home position return begins.

(2) Axis travel occurs in the reverse direction to the home position return direction.

(3) Deceleration begins as soon as the near-zero point dog is detected in the OFF status.

(4) After the axis has stopped, it returns to the home position.

(5) Home position return is completed on detection of the first zero point subsequent to travelling for the travel value after near-zero point dog ON was turned ON.

Fig. 3.15 Count Method (1) Home Position Return at Near-zero Dog ON

(d) Constraint

1) If the set travel value after near-zero point dog ON is shorter than the distance required for deceleration from the home position speed, an error will result, and home position return will not be performed.
Refer to the setting example for the travel value after near-zero point dog ON in the home position parameters, and set a travel value longer than the distance for deceleration from the home position return speed.

Count method (2) (no zero point signal used)

(a) Description of count method (2) home position return

1) Count method (2) home position return uses the designated distance after the near-zero point dog has been turned ON (travel value after near-zero point dog ON) to define the home position.

2) Set the travel value after near-zero point dog ON in the home position return parameters.
Compared with the other home position return methods, this method causes an error of about 1 ms.

(b) Operations in count method (2) home position return
When count method (2) home position return is started, the following operations are performed:

1) Axis travel occurs in the designated home position return direction at the designated home position return speed.

2) The speed decreases to the creep speed when the near-zero point dog comes ON.

3) Axis motion stops after travelling for the designated travel value after the near-zero point dog has been turned ON.

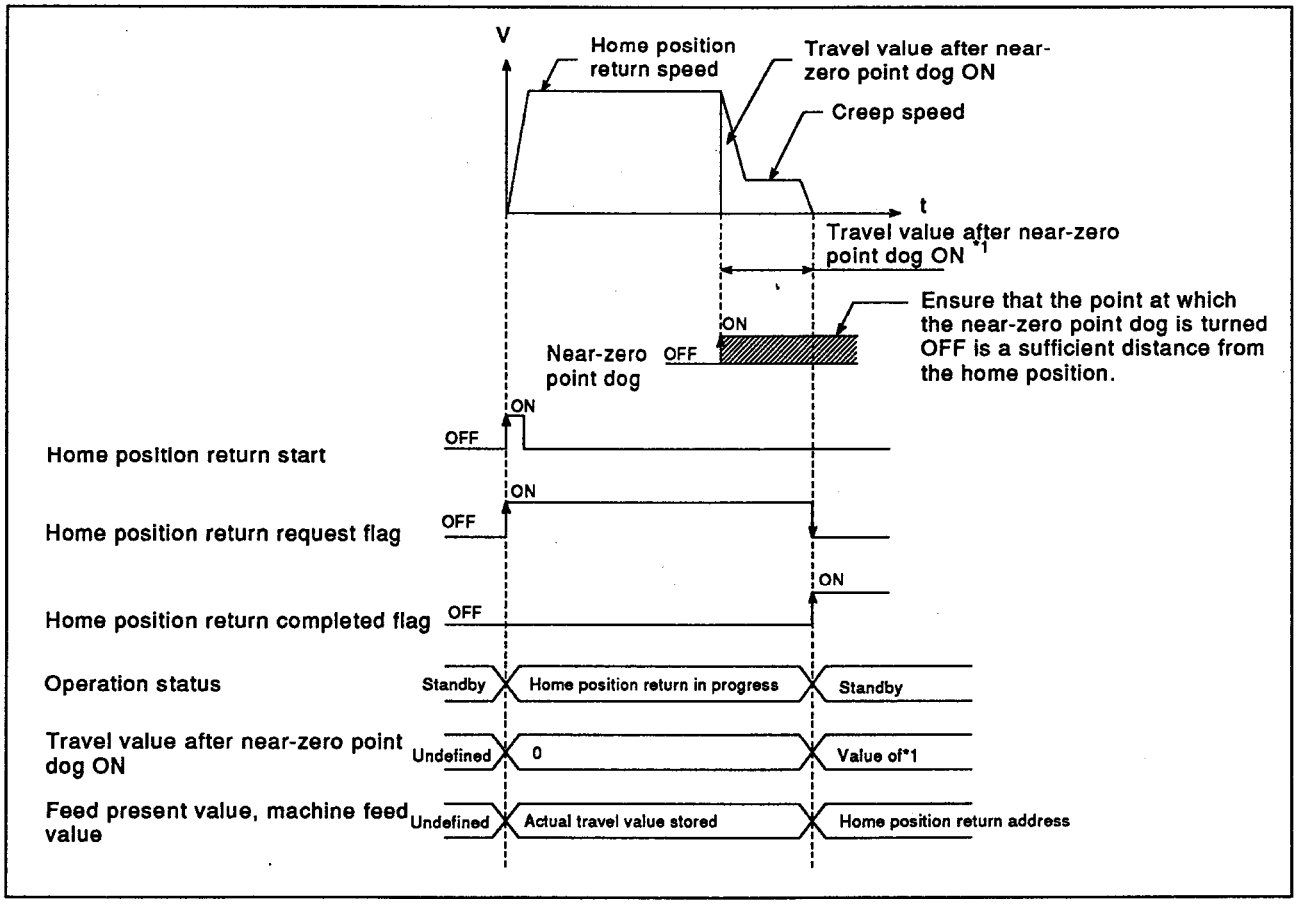
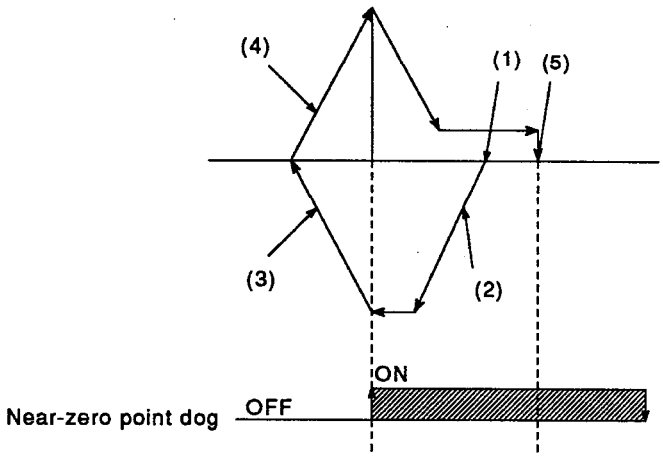


Fig. 3.16 Home Position Return by Count Method (2)

(c) Operations on home position return when the near-zero point dog comes ON and continuous starting of home position return
In count method (2) home position return, home position return can be performed when the near-zero point dog comes ON, and continuous starting of home position return is possible.
When home position return when the near-zero point dog comes ON or continuous starting of home position return is executed, the axis returns to a position where the near-zero point dog is OFF before home position return is started.



[Operations at the start of home position return when the near-zero point dog comes ON]

(1) Home position return begins.

(2) Axis travel occurs in the reverse direction to the home position return direction.

(3) Deceleration begins as soon as the near-zero point dog is detected in the OFF status.

(4) After the axis has stopped, it returns to the home position.

(5) Home position return is completed on completion of travelling for the travel value after near-zero point dog ON was turned ON.

Fig. 3.17 Count Method (2) Home Position Return at Near-zero Dog ON

(d) Constraint

1) If the set travel value after near-zero point dog ON is shorter than the distance required for deceleration from the home position speed, an error will result, and home position return will not be performed.
Refer to the setting example for travel value after near-zero point dog ON in the home position parameters, and set a travel value longer than the distance for deceleration from the home position return speed.

POINT

Compared with count method (1) home position return, count method (2) home position return is inferior in the accuracy of the stop position in home position return. However, this method is helpful when the AD75 cannot receive a zero point signal.

Stopper stop (1) (on elapse of dwell time)

(a) Description of stopper stop (1) home position return

1) Home position return is completed on elapse of the dwell time after the near-zero point dog has been turned ON.
In stopper stop (1), home position return is not completed until the dwell time elapses even if the near-zero point dog is turned OFF in the middle of home position return.

2) After the home position return speed has decreased to the creep speed, it is necessary to limit the servomotor torque, otherwise the servomotor will malfunction when contact is made with the stopper.

(b) Operations in stopper stop (1) home position return

When stopper stop (1) home position return is started, the following operations are performed:

1) Axis travel occurs in the designated home position return direction at the designated home position return speed.

2) The speed decreases to the creep speed when the near-zero point dog comes ON.

3) During travel at the creep speed the stopper is contacted and axis motion stops.

4) On elapse of the dwell time measured from the point when the near-zero point dog comes ON, home position return is completed.

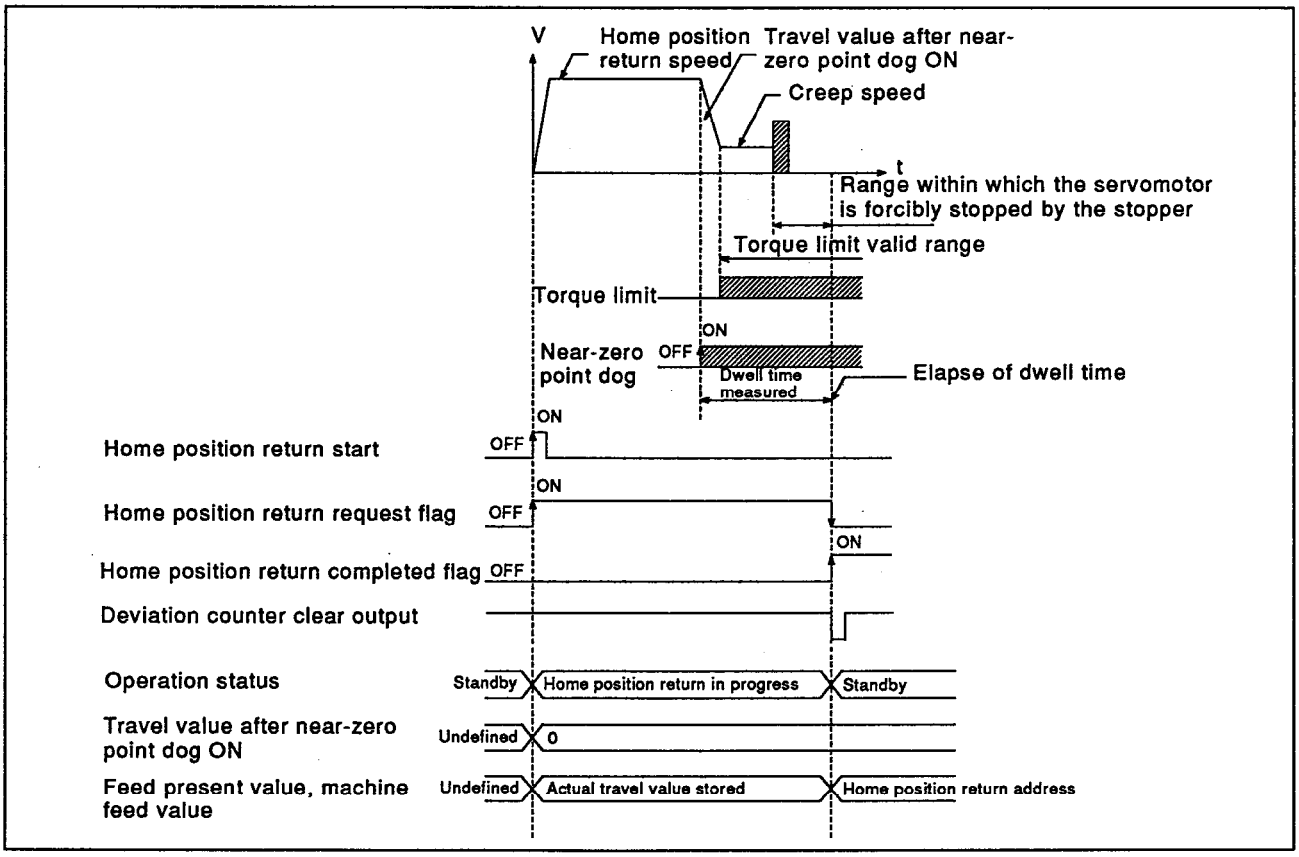
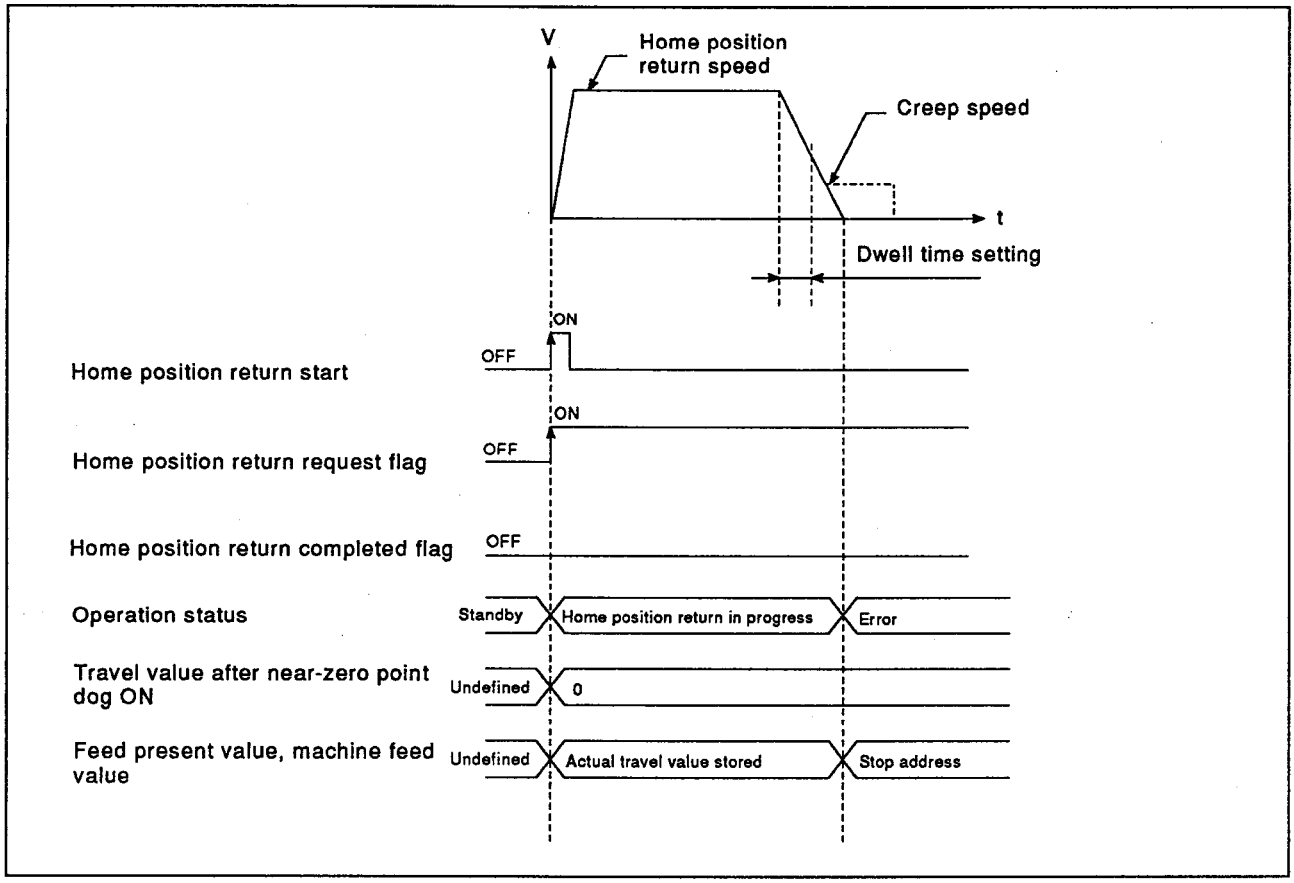


Fig. 3.18 Home Position Return by Stopper Stop (1)

(c) Constraints

1) Set a longer dwell time than the time required for axis motion to reach the stopper after the near-zero point dog has been turned ON.

- If the dwell time elapses during deceleration from the home position return speed, axis motion decelerates to a stop.



2) If the dwell time elapses before axis motion reaches the stopper, motion stops at that point and this position is set as the home position.

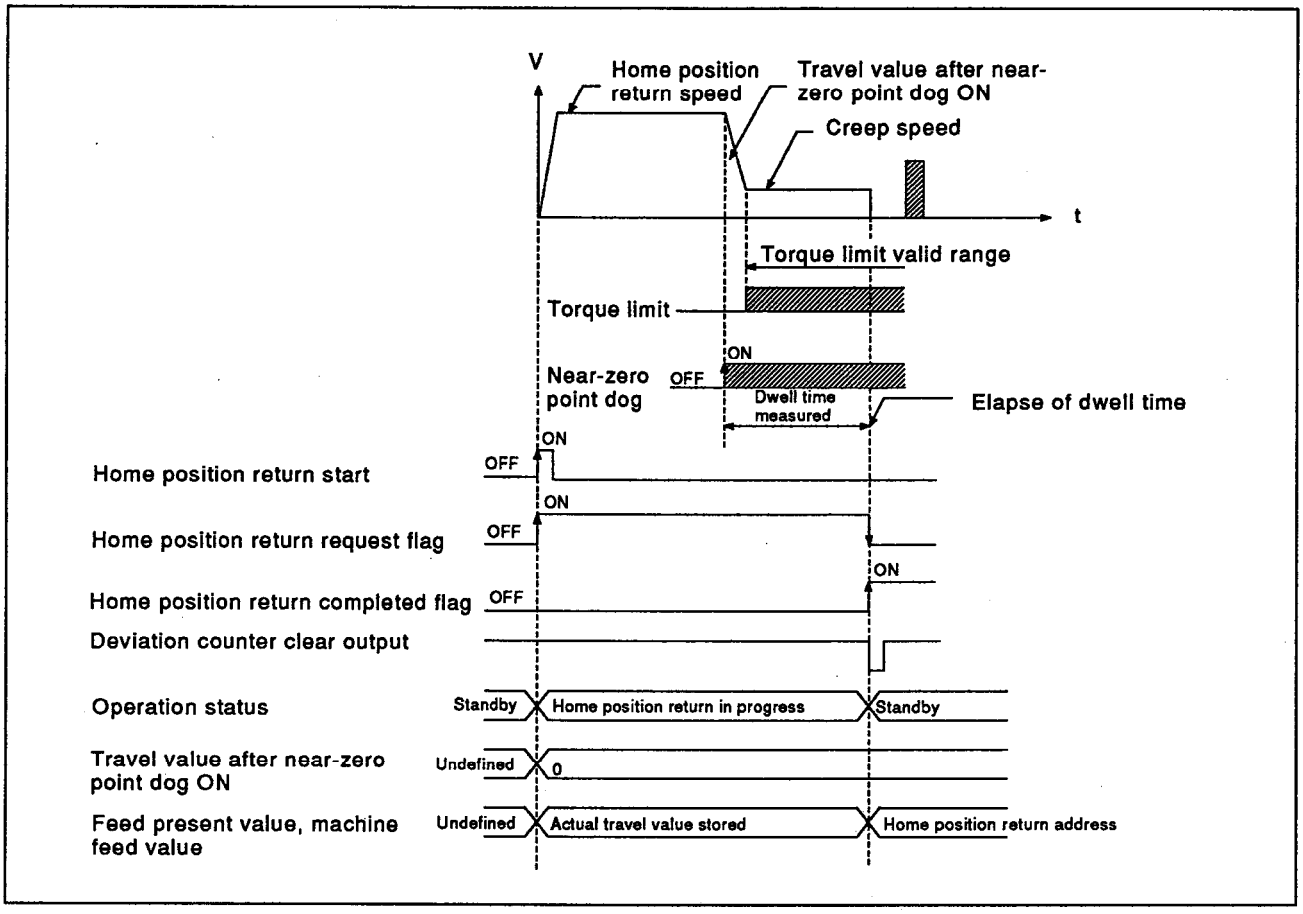


Fig. 3.19 When Dwell Time Elapses Before Axis Reaches Stopper

3) Home position return when the near-zero point dog comes ON begins at the creep speed.

Stopper stop (2) (by zero point signal issued on contacting the stopper)

(a) Description of stopper stop (2) home position return

1) This method completes home position return in response to a zero point signal input from an external switch to the zero point signal terminal on contacting the stopper.
The zero point signal is input whether the near-zero point dog is turned ON or OFF.

2) After the home position return speed has reached the creep speed, it is necessary to limit the servomotor torque, otherwise the servomotor will malfunction when contact is made with the stopper.

(b) Operations in stopper stop (2) home position return

When stopper stop (2) home position return is started, the following operations are performed:

1) Axis travel occurs in the specified home position return direction at the specified home position return speed.

2) The speed decreases to the creep speed when the near-zero point dog comes ON.

3) During travel at the creep speed the stopper is contacted and axis motion stops.

4) On input of a zero point signal, home position return is completed.

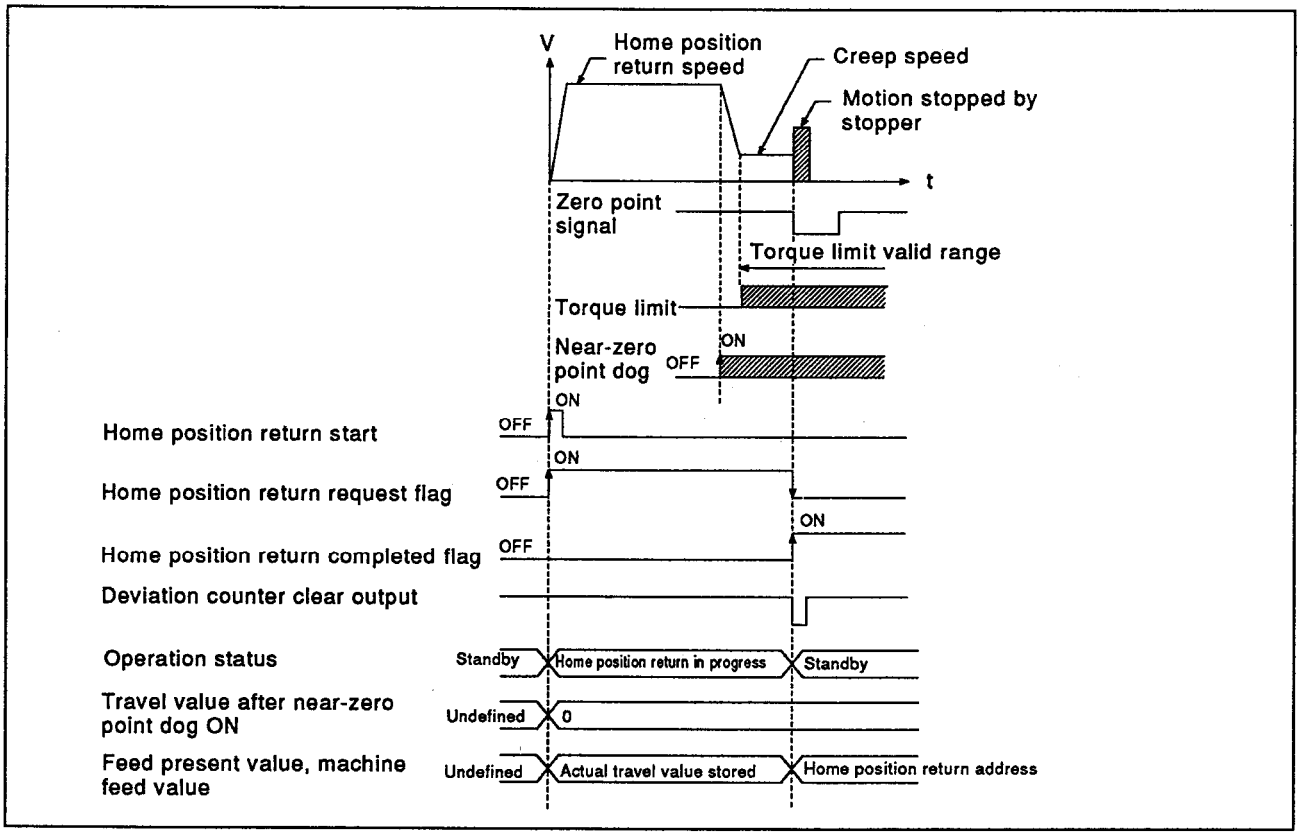


Fig. 3.20 Home Position Return by Stopper Stop (2)

(c) Constraints

1) Input an external zero point signal after contact is made with the stopper.
A zero point signal input before deceleration to the creep speed causes axis motion to decelerate to a stop.

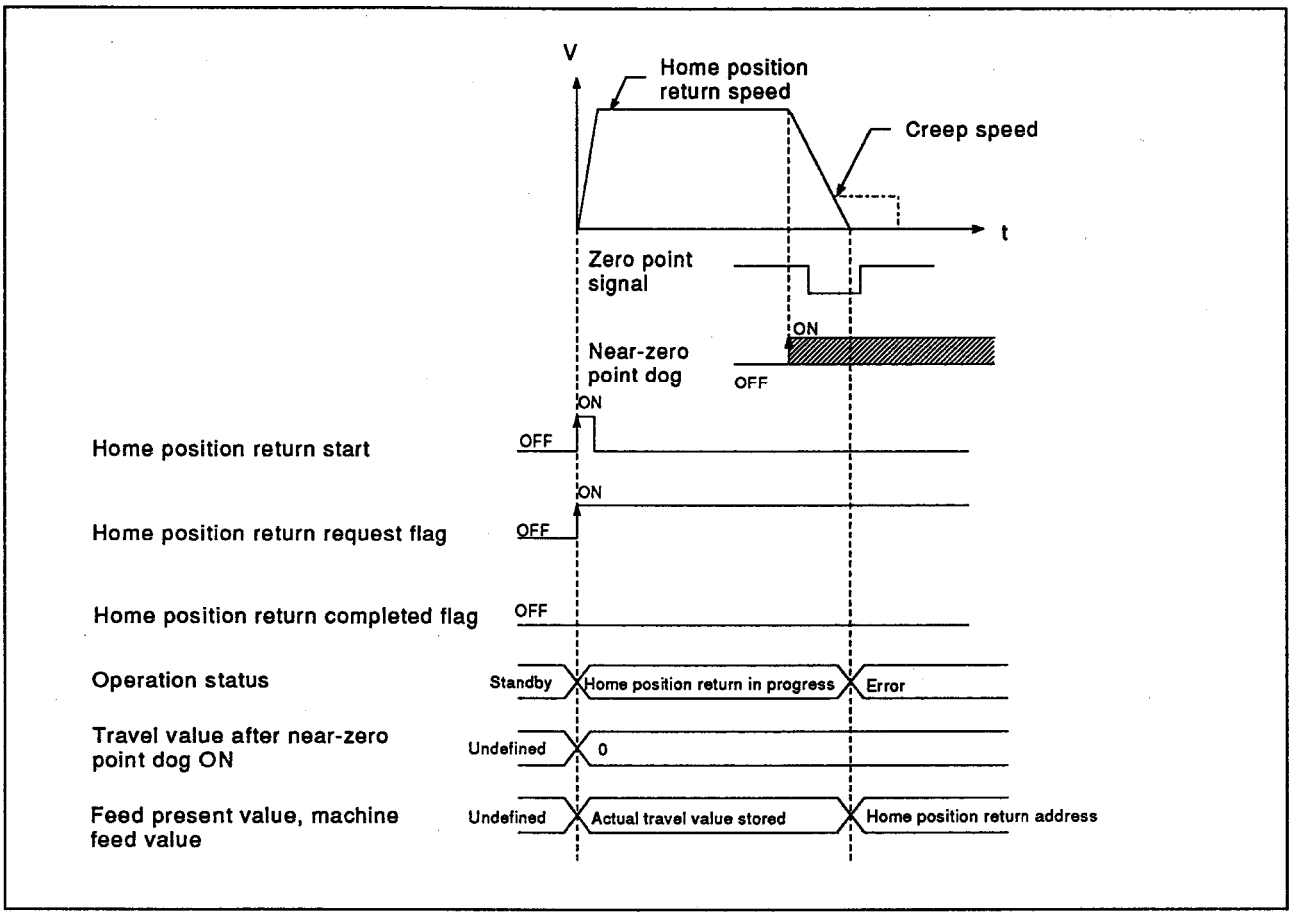


Fig. 3.21 Operation When Zero Point Signal Input Before Creep Speed Reached

2) If a zero point signal is input before axis motion reaches the stopper, motion stops at that point and this position is set as the home position.

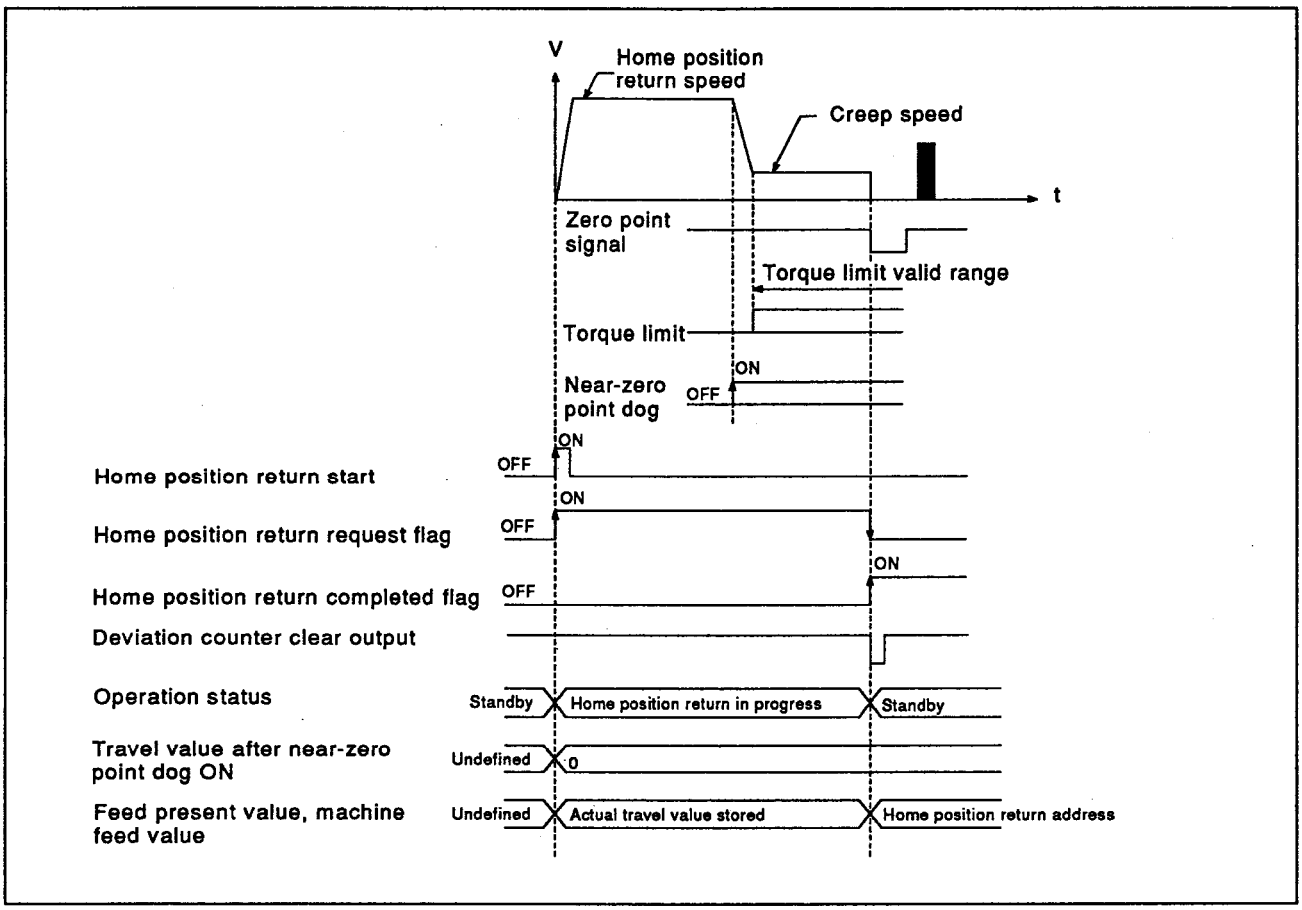


Fig. 3.22 Operation when Dwell Time Elapses before Stopping by the Stopper

3) Home position return at near-zero dog ON begins at the creep speed.

Stopper stop (3) (method without a near-zero point dog)

(a) Description of stopper stop (3) home position return

1) This method starts home position return at the creep speed, and completes it with a zero point signal input from an external switch to the zero point signal terminal when the axis contacts the stopper.

2) It is necessary to limit the servomotor torque.

Otherwise, the servomotor will malfunction when contact is made with the stopper.

(b) Operations in stopper stop (3) home position return

When stopper stop (3) home position return is started, the following operations are performed:

1) Axis travel occurs in the specified home position return direction at the specified home position return speed.

2) During travel at the creep speed the stopper is contacted and axis motion stops.

3) On input of a zero point signal, home position return is completed.

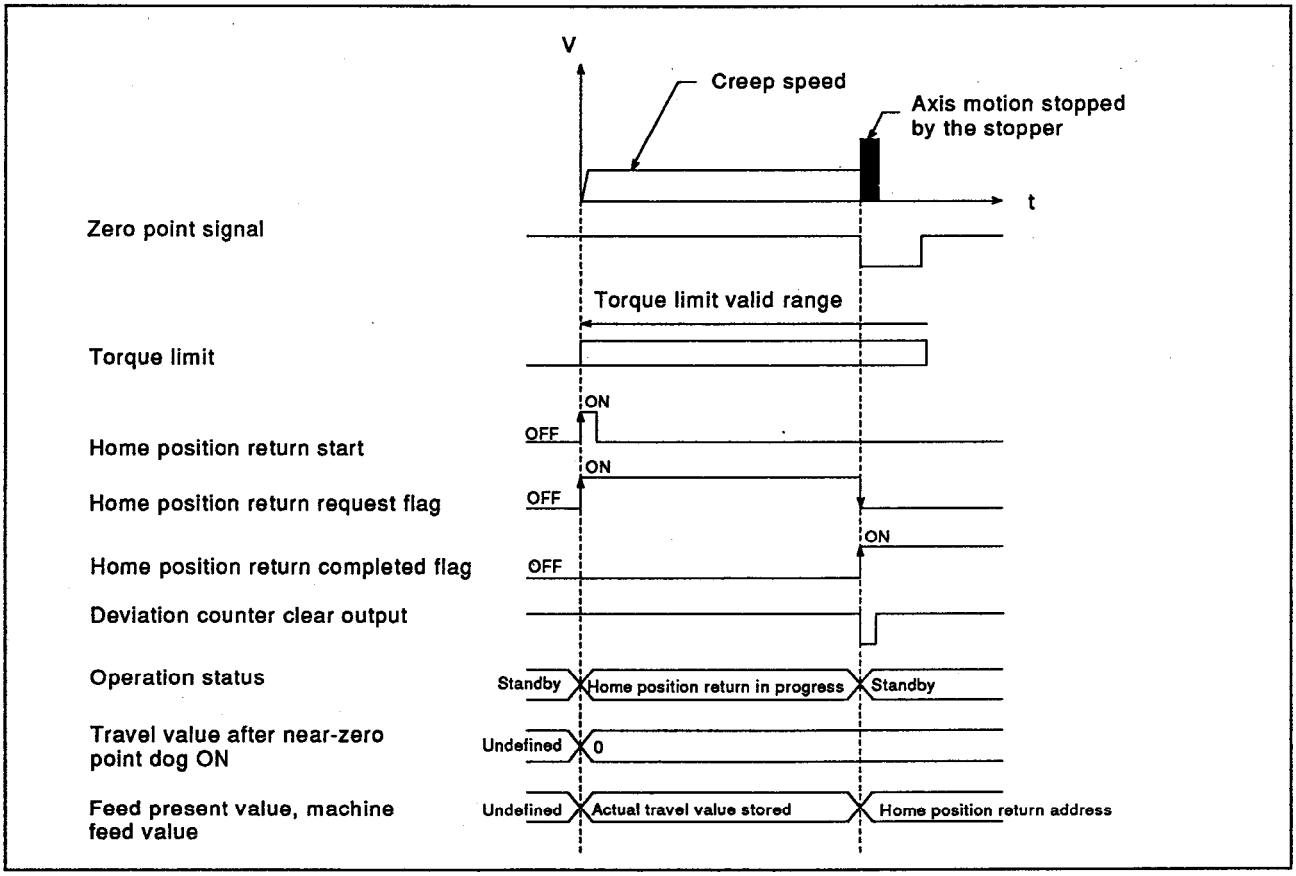


Fig. 3.23 Home Position Return by Stopper Stop (3)

(c) Constraints

1) If a zero point signal is input before axis motion reaches the stopper, motion stops at that point and this position is set as the home position.

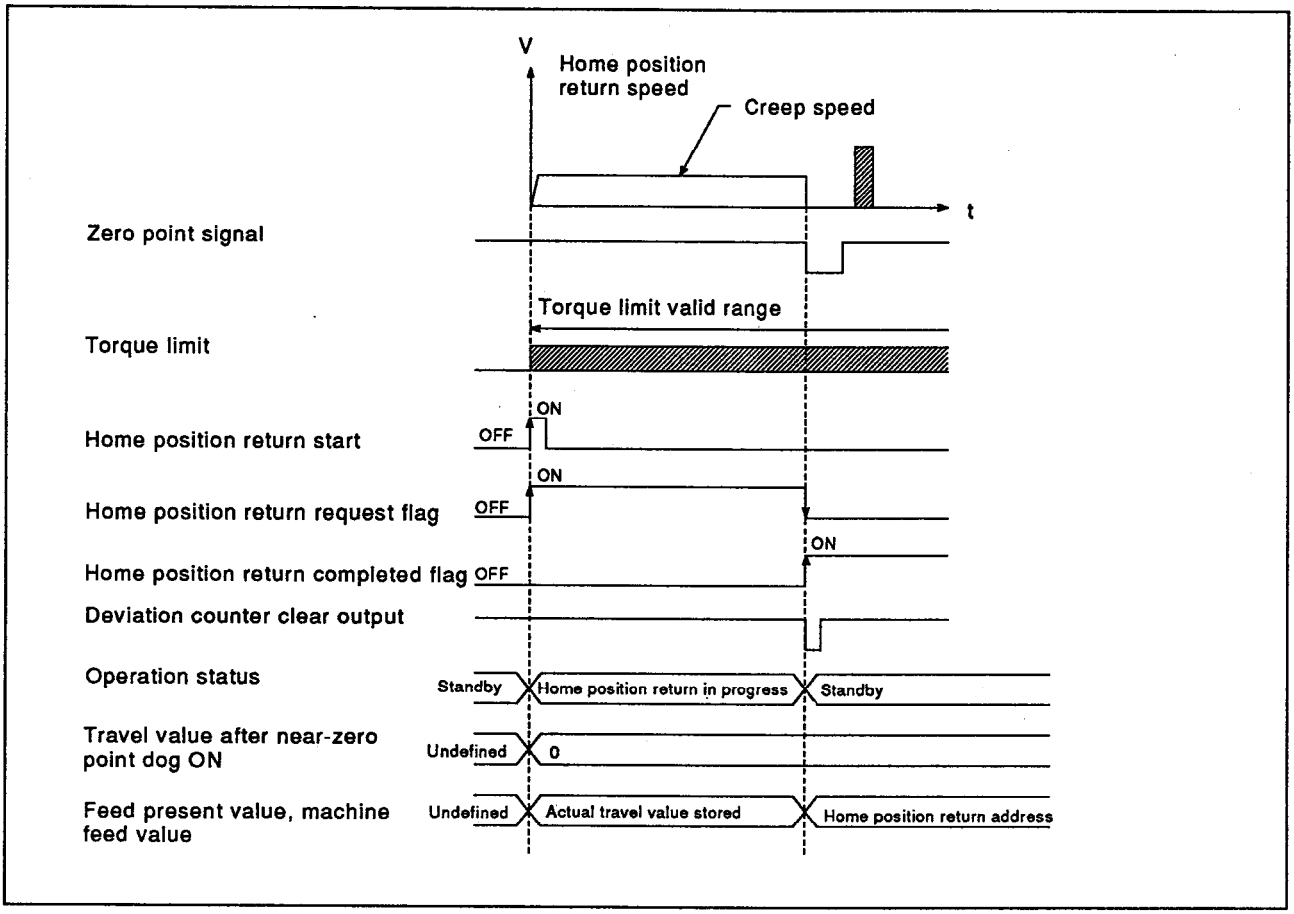


Fig. 3.24 When a Zero Point Signal is Input Before Reaching Stopper

2) If there is an external zero point signal input at the start of home position return, an error will result, and home position return will not be performed.

3) Stopper stop (3) home position return cannot execute the home position return retry function.

4) When the limit switch is turned OFF, axis motion decelerates to a stop.

POINT

Although stopper stop (3) home position return takes time to complete home position return because it is performed at the creep speed from the beginning, it is helpful when a near-zero point dog cannot be installed.

(4) Home position return start methods

There are three home position return start methods, as shown below:

- Machine home position return start
- High-speed home position return start
- High-speed machine home position return start

POINTS

(1) The "home position return request flag" is turned ON at the start of machine home position return.
As soon as machine home position return is completed properly, the "home position return request flag" is turned OFF, and the "home position return completed flag" is turned ON.
Depending on the home position return method, the actual travel value may be stored to the "travel value after near-zero point dog ON" area.

(2) After machine home position return has been completed normally, the set home position address is stored to the feed present value/machine value area.

(3) During machine home position return, the "axis operation status" in the axis monitor area remains "home position return in progress".

Machine home position return start

(a) Description of machine home position return

1) Machine home position return start establishes the machine home position by the home position return methods described in Section 3.3.8 (3).

2) Designate positioning start data No. 9001 to start machine home position return.

High-speed home position return start

(a) Description of high-speed home position return start

1) After the machine home position has been established by a machine home position return, high-speed home position return start can be used to travel to the home position at a high speed at the start of positioning without using a home position detection signal.
The travel value is calculated from the home position return address stored in the AD75's internal buffer memory when machine home position return is completed, and the present machine value at high-speed home position return start, and the axis travels to the home position according to this value.

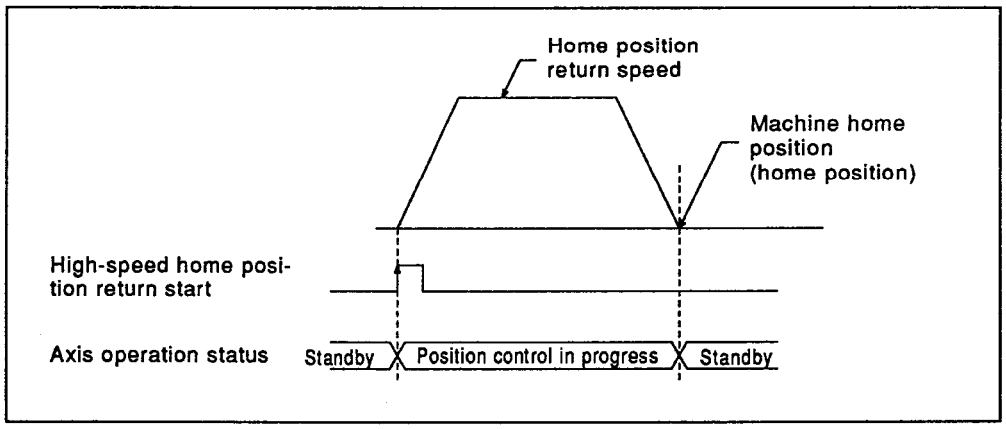
2) Designate positioning start data No. 9002 to start high-speed home position return.

(b) Operations in high-speed home position return

When high-speed home position return is started, the following operations are performed:

1) Axis travel occurs in the machine home position direction at the specified home position return speed. (The travel direction depends on the present machine value when the high-speed home position return start was performed.)

2) Axis motion decelerates to a stop at the home position.



(c) Constraints

1) High-speed home position return cannot be performed until the machine home position has been established by executing a machine home position return.
High-speed home position return cannot be executed while the "home position return request flag" is ON.

2) High-speed home position return is performed at the home position return speed set in the parameters.

3) The set home position address is not stored to the feed present value/machine feed value area when high-speed home position return is completed.

4) During home position return, the axis operation status of the axis is "position control in progress".

5) The following data values do not change in high-speed home position return:

- Home position return request flag
- Home position return completed flag
- Travel value after near-zero point dog ON

6) If the present machine value exceeds the lower or upper limit even once during positioning over an indefinite distance in speed control, an error will occur when high-speed home position return is performed.
High-speed home position return cannot take place until the machine home position has been established by executing a machine home position return.

REMARK

The present machine value is always updated, regardless of the operation pattern. It remains unchanged when the present value is changed.

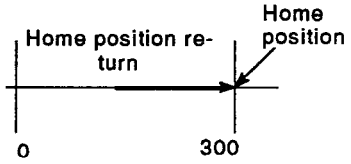
High-speed machine home position return

(a) By executing the positioning program for absolute home position using the "absolute original point" value in the buffer memory axis monitor area, positioning to the absolute original point can be performed.

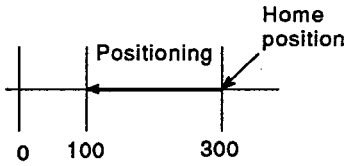
(b) The "absolute original point" matches the home position address parameter when home position return is completed.

(c) The "absolute original point" value changes when the present value changes.

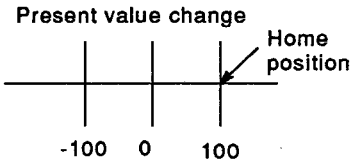
1) When home position return is completed, home position address 300 is stored to the "absolute original point" area.



2) The axis is positioned to address 100.



3) If the present value is changed to -100 at this position, the "absolute original point" is changed to 100.



4) By executing the program for positioning to absolute original point (ABS linear 1) using the "absolute original point" value at this position, positioning to the home position is performed.

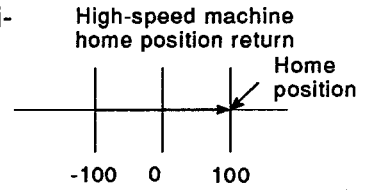


Fig. 3.25 Absolute Original Point Value and Positioning to Home Position

POINT

The absolute original point is not changed after any of the following control operations is performed:

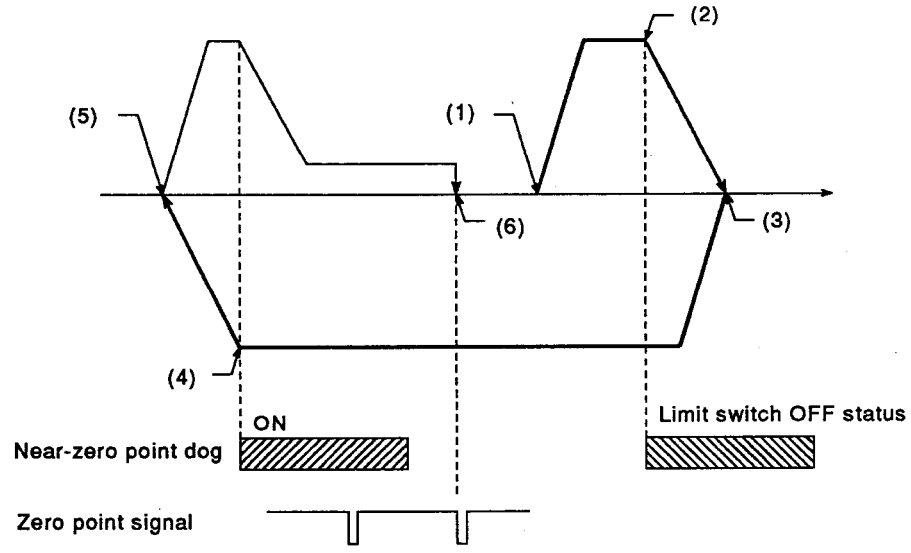
- Present feed value 0 clear at the start of fixed-pitch feed
- Present feed value update request command OFF during speed control

Consequently, positioning to the home position cannot be executed by absolute positioning using the absolute original point after the above operations.

(5) Home position return retry function

(a) This function retries home position return using the upper and lower limit switches.
It can perform home position return without moving the axis back past the near-zero point dog by using JOG operation or other operation modes.

(b) When a home position return start is executed with the home position return retry function enabled, axis travel occurs in the home position return direction. However, if the upper or lower limit switch is turned OFF before the near-zero point dog status is detected, the axis decelerates to a stop, then travels in the reverse direction to the home position return direction.
When the near-zero point dog is detected in the OFF status, the axis decelerates to a stop, and home position return is reattempted.



[Operation of home position return retry function]

(1) Axis motion starts in the home position return direction on receipt of a home position return start signal.

(2) Axis motion decelerates to a stop as soon as the limit switch is turned OFF.

(3) After axis motion has stopped in response to the detection of the limit switch OFF status, it starts in the reverse direction to the home position return direction at the home position return speed.

(4) Axis motion decelerates to a stop when the near-zero point dog goes OFF.

(5) After it has stopped after near-zero point dog OFF, the axis returns to the home position.

Fig. 3.26 Home Position Return Retry Using Upper/Lower Limit Switches

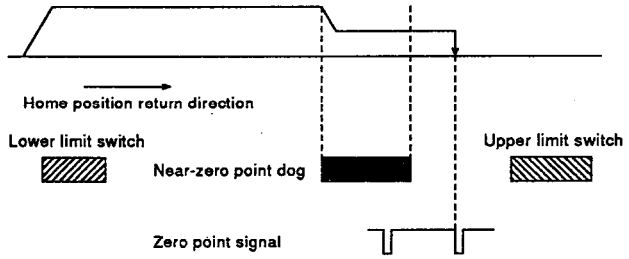
POINT

Set upper and lower limit switches whenever the home position return retry function is disabled.

(c) Even if the upper and lower limit switches are turned OFF, home position return can be performed when the home position return retry function is enabled.

- When the direction of travel into the travel range and the home position return direction are the same, normal home position return takes place.
- When the direction of travel into the travel range is different from the home position return direction, axis motion decelerates to a stop when the near-zero point dog goes OFF, then returns to the home position.

1) Operation when the direction of travel into the travel range and the home position return direction are the same



2) Operation when the direction of travel into the travel range is different from the home position return direction

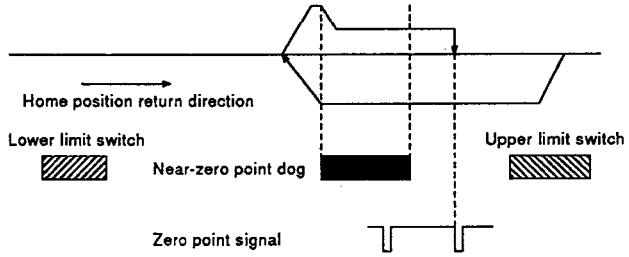


Fig. 3.27 Home Position Return Retry Operation with Upper/Lower Limit Switches OFF

(d) Relationship between home position return method and home position return retry function

Home Position Return Method	Home Position Return Retry Function Disabled	Home Position Return Retry Function Enabled
Near-zero point dog method	x	o
Count method (1)	x	o
Count method (2)	x	o
Stopper stop (1)	x	Δ*
Stopper stop (2)	x	
Stopper stop (3)	x	x

*: In some cases, home position return retry may not be possible due to a mechanical stopper.

(e) Conditions for executing the home position return retry function

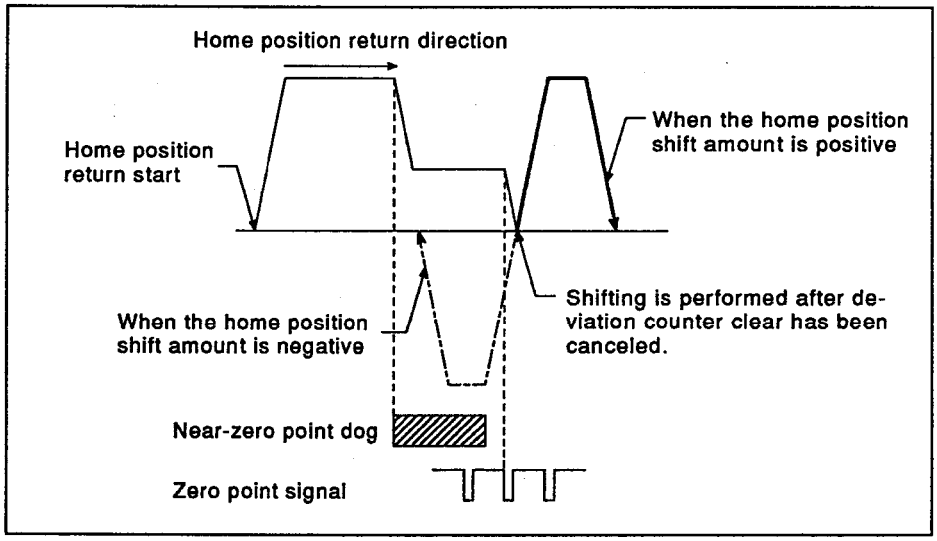
- Limit switches must be installed at the upper and lower stroke ends of the machine.
  The motor will keep running until either limit switch is actuated.
- Do not make it impossible to continue operation (for example by turning OFF the power to the drive unit) by using the upper and lower limit switches.

(6) Home position shift function

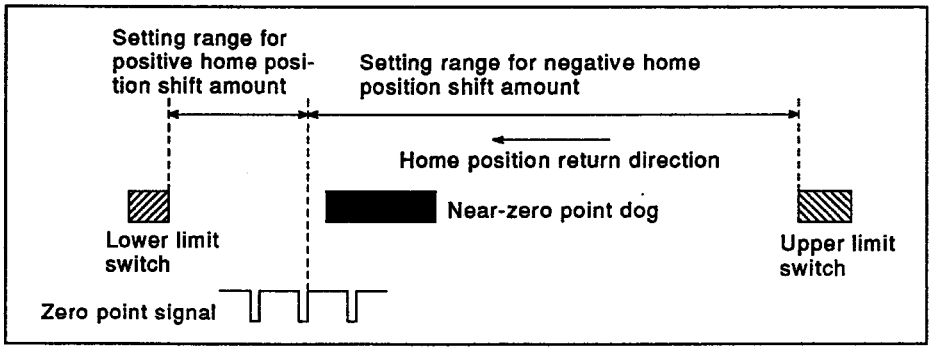
(a) Description of home position shift function

This function discontinues home position return to correct the home position.
It can shift the home position to a position between zero points or to a position away from the zero point.

- When the home position shift amount is positive:
  The home position is shifted in the specified home position return direction.
- When the home position shift amount is negative:
  The home position is shifted in the reverse direction of the specified home position return direction.



(b) Set the home position shift amount within the range from the position at which the zero point signal is detected to the upper and lower limit switches.



(c) Set the following data after shifting with the home position shift function:

- Home position return request flag
- Home position return completed flag
- Axis operation status
- Travel value after near-zero point dog ON
- Feed present value
- Machine feed value

(d) The set home position shift amount is not added to the travel value after near-zero point dog ON.

(e) The home position shift function perform shifting at the home position return speed, irrespective of the home position return method.

(7) Home position return request flag OFF request

(a) Description of home position return request flag OFF request

This function forcibly turns OFF the ON home position return request flag in a system which does not require home position return.

(8) Combinations of home position return and other functions

(a) Home position return start after home position return stop

Home position return interrupted by an external stop signal or axis stop can be restarted by inputting a positioning start signal.
However, when the home position return retry function is disabled an error may occur, depending on the stop position.
Before restarting positioning suspended in the middle of home position return, enable the home position return retry function, or move the axis from the stop position by JOG operation or manual pulse generator operation.

(b) Speed change during home position return

Speed changes are not possible after entering the creep speed.

3.3.9 Manual pulse generator operation

(1) Description of manual pulse generator operation

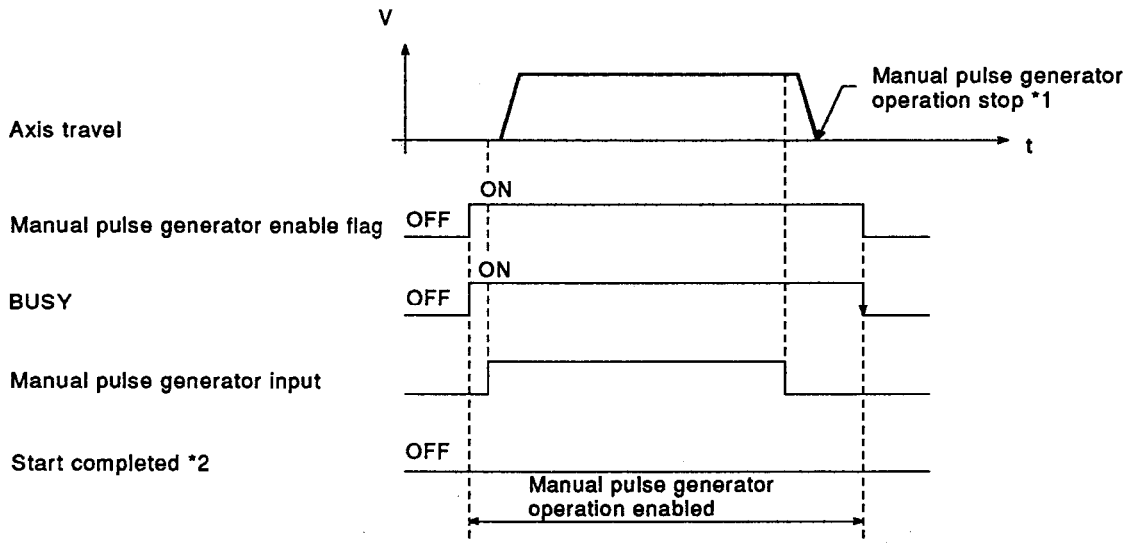
(a) Manual pulse generator operation means positioning control using input pulses from a manual pulse generator. *1
This function is used to perform accurate positioning manually.

(b) Up to three manual pulse generators can be connected to one AD75. One manual pulse generator can control one to three axes simultaneously.

(2) Execution of manual pulse generator operation

(a) Setting the manual pulse generator enable flag to "1 (enabled)" turns ON the BUSY signal, enabling manual pulse generator operation. *2 Positioning control can be performed with input pulses from the manual pulse generator.

(b) Setting the manual pulse generator enable flag to "0 (disabled)" turns OFF the BUSY signal, disabling manual pulse generator operation.



[Notes]

1) *1: One control cycle time (100 ms) after the manual pulse generator has stopped input, the AD75 outputs the last pulse.

2) *2: In manual pulse generator operation, the start completed signal remains OFF.

REMARKS

1) Select and set the manual pulse generator to be used at the following buffer memory addresses:

Axis No.	Axis 1	Axis 2	Axis 3
Buffer memory address	29	179	329

2) Set the manual pulse generator enable flag at the following buffer memory addresses:

Axis No.	Axis 1	Axis 2	Axis 3
Buffer memory address	1167	1217	1267

(3) Description of control

(a) The travel value and output speed in positioning control by manual pulse generator operation are shown below.

- The travel value according to input pulses from the manual pulse generator is calculated from the following expression:

$$\left[\begin{array}{c}\text{Travel}\\ \text{value}\end{array}\right] = \left[\begin{array}{c}\text{Number of}\\ \text{input pulses}\end{array}\right] \times \left[\begin{array}{c}\text{Set manual pulse}\\ \text{generator 1 pulse}\\ \text{input magnification}\end{array}\right] \times \left[\begin{array}{c}\text{Travel value}\\ \text{per pulse}\end{array}\right]$$

- In manual pulse generator operation, positioning is performed at a speed corresponding to the number of input pulses per unit time.

$$\left[\begin{array}{c}\text{Output}\\ \text{speed}\end{array}\right] = \left[\begin{array}{c}\text{Number of input}\\ \text{pulses per con-}\\ \text{trol cycle time}\end{array}\right] \times \left[\begin{array}{c}\text{Set manual pulse}\\ \text{generator 1 pulse}\\ \text{input magnification}\end{array}\right] \times \left[\begin{array}{c}\text{Travel}\\ \text{value}\\ \text{per pulse}\end{array}\right]$$

(4) Precautions

(a) After manual pulse generator operation, set the manual pulse generator enable flag to "0 (disabled)".
If this flag is left at the "1" (enabled) setting, unintended positioning could be started by inadvertent operation at the manual pulse generator.

(b) If the manual pulse generator enable flag is turned on when the BUSY signal is ON in positioning control, home position return or JOG operation, a "in-operation start warning" will be issued.

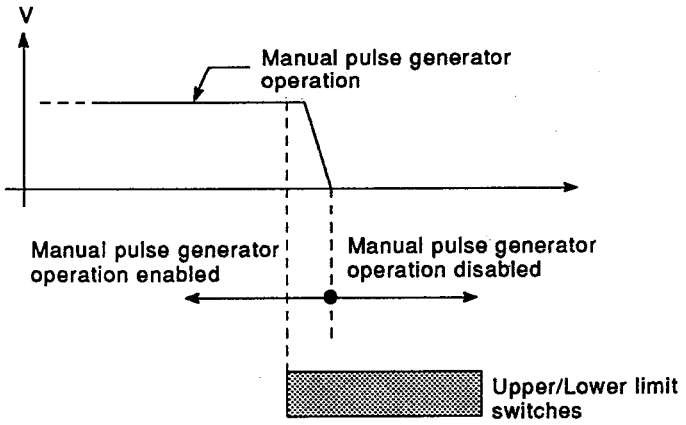
(c) During manual pulse generator operation, the torque limit value is controlled to the value set in the parameters or by a torque value change.

(d) For the manual pulse generator 1 pulse input magnification, set the value for the relevant axis.
If the magnification is outside the setting range, operation is performed using the following values.

- If the manual pulse generator 1 pulse input magnification is set higher than "100", the value used is "100".
- If the manual pulse generator 1 pulse input magnification is set lower than "1", the value used is "1".

(e) If a stop cause occurs during manual pulse generator operation, the axis will stop, and go into the "stopped" or "error" status. The BUSY signal will be turned OFF at the same time.
After eliminating the stop cause, set the manual pulse generator enable flag from "0" to "1". Manual pulse generator operation will be enabled.

(f) Axis motion decelerates to a stop when the upper or lower limit switch is turned OFF.
Input pulses to the upper or lower limit switch in the OFF status are ignored after the axis has stopped.
However, manual pulse generator operation can be continued with input pulses to the limit switch in the ON status.



3.3.10 JOG operation

(1) Description of JOG operation

(a) JOG operation refers to positioning control in response to a JOG start signal.
While the JOG start signal remains ON, JOG operation is performed at the JOG speed set in the control data. Axis motion decelerates to a stop as soon as the JOG start signal is turned OFF.

(b) JOG operation can be executed in the test mode when a peripheral device is used.

(2) Acceleration/Deceleration processing and JOG speed

(a) Acceleration/Deceleration processing is controlled by the acceleration time and deceleration time set in the JOG operation acceleration/deceleration selection of the extended parameters, as well as the JOG speed limit parameter.

(b) If the JOG speed is outside the setting range at the start of JOG operation, an axis error will occur, and JOG operation will not begin.

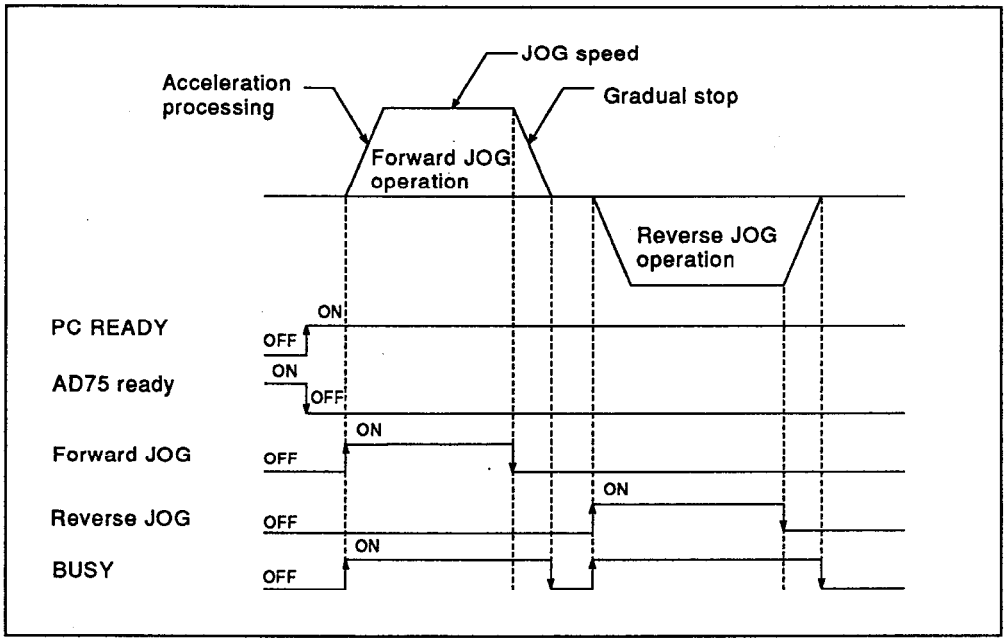
(c) If the JOG speed exceeds the JOG speed limit, an axis warning will be issued, and JOG operation will be performed according to the JOG speed limit.
In such a case, the speed limit flag will be turned ON.

(3) Operations in JOG operation

When JOG operation is started, the following operations are performed:

(a) As soon as the forward/reverse JOG start signal is turned ON, axis motion starts in the specified direction at the specified JOG speed.

(b) Axis motion decelerates to a stop when the JOG start signal goes OFF.



REMARKS

1) A specific JOG start signal is assigned to each axis.

Axis No.	Axis 1	Axis 2	Axis 3
Forward JOG start	Y16	Y18	Y1A
Reverse JOG start	Y17	Y19	Y1B

2) The JOG speed during JOG operation can be checked in the buffer memory.

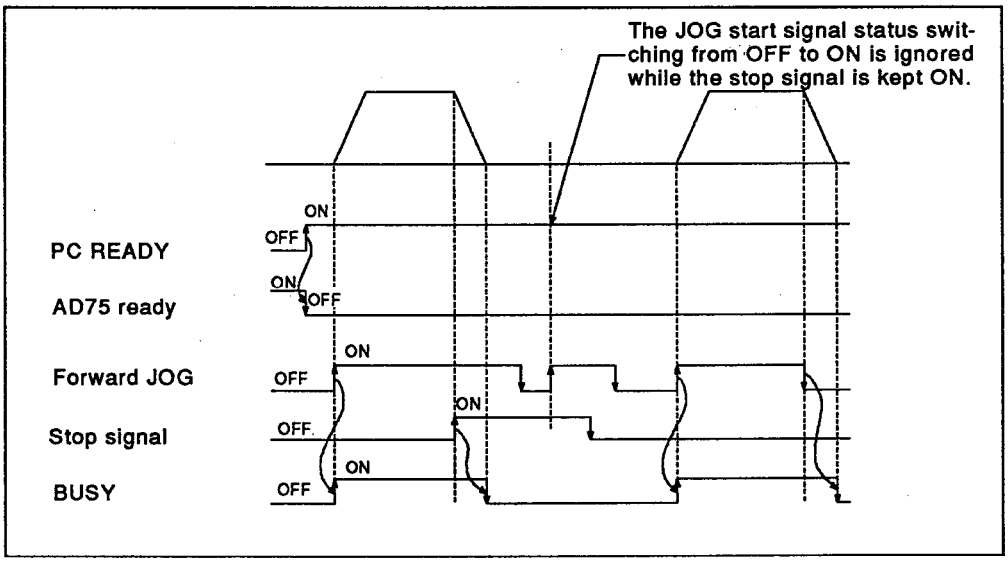
Axis No.	Axis 1	Axis 2	Axis 3
Buffer memory address	1161,1160	1211,1210	1261,1260

(4) Operations when the stop signal is ON (input)

(a) When the stop signal is turned ON during JOG start, axis motion decelerates to a stop.

(b) While the stop signal remains ON, the JOG start signal is ignored.

(c) JOG operation can be restarted by turning OFF the stop signal and turning ON the JOG start signal.



POINTS

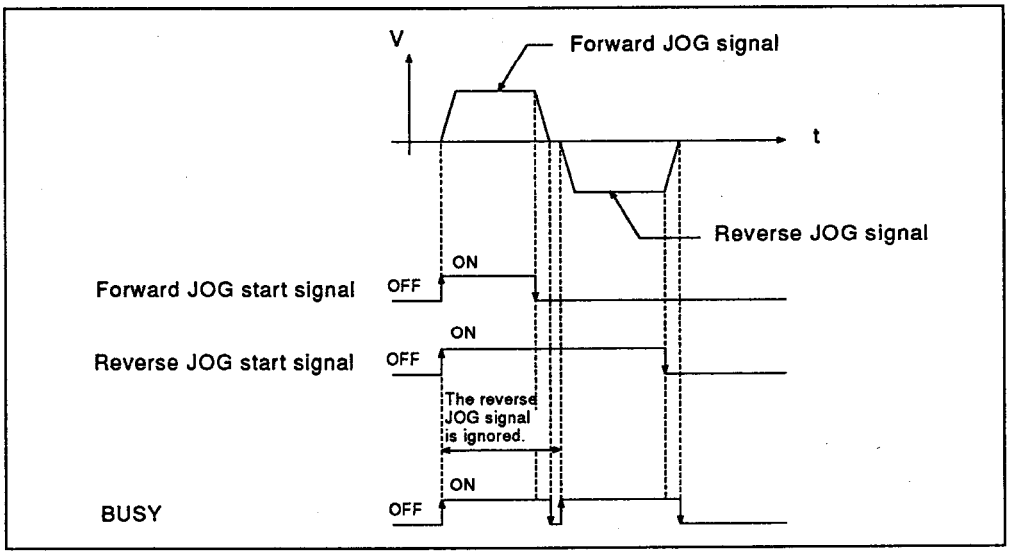
(1) When setting the JOG speed using the sequence program, write the value of the actual JOG speed multiplied by 100 or 1000 to the JOG speed area of the buffer memory.
For example, to set a JOG speed of 10000.00 mm/min., store "1000000" as the speed change value.

(2) The JOG speed is set in the units specified in basic parameters #1.

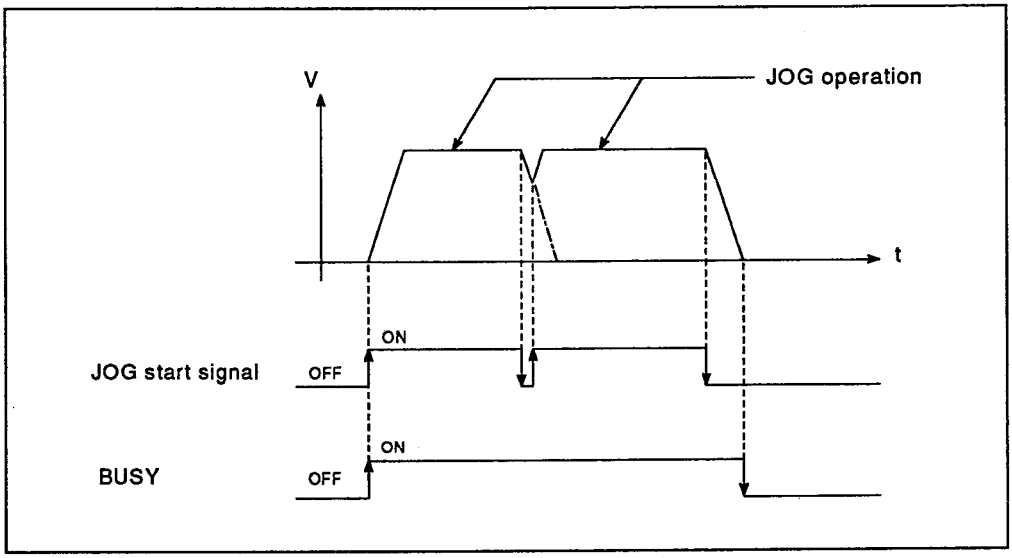
(3) Write the JOG operation speed in units of two words.

(5) Limitations on JOG operation

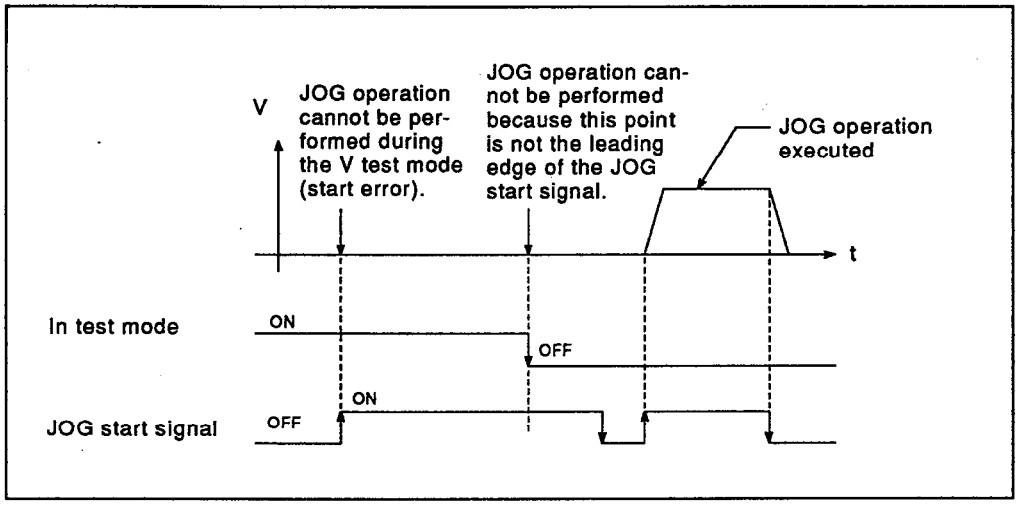
(a) When both forward and reverse JOG signals are turned ON simultaneously for one axis, forward JOG operation will be performed.
If the reverse JOG signal is ON when the forward JOG is turned OFF, JOG operation will stop and then reverse JOG operation will begin. (The reverse JOG signal becomes valid when the BUSY signal is turned OFF.)



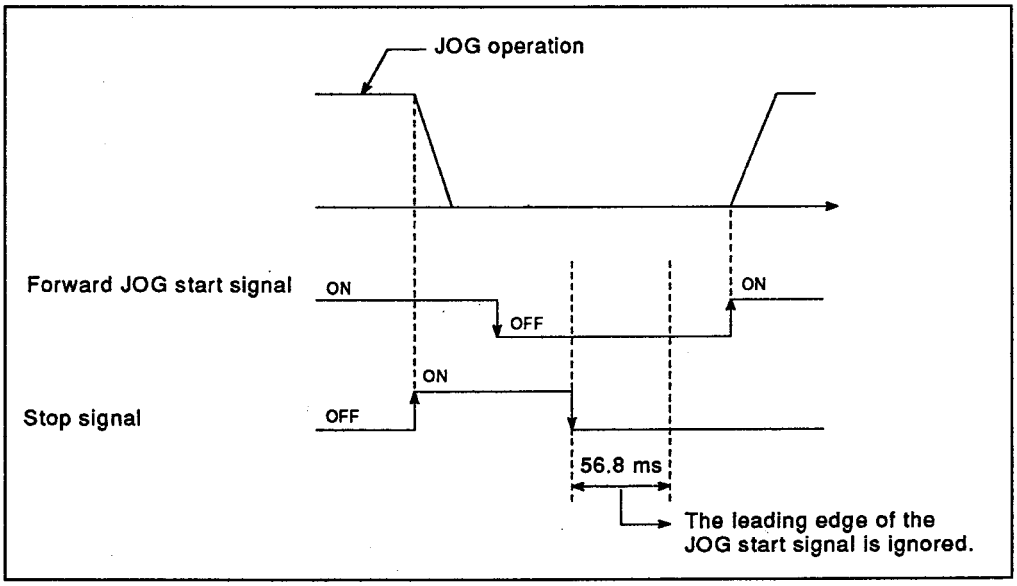
(b) If the JOG start signal is turned back ON during deceleration initiated by turning it OFF, JOG operation will restart from where the signal is turned ON.



(c) In the test mode at a peripheral device, JOG operation cannot be performed with a JOG start signal.
JOG operation will begin at the leading edge (OFF → ON) of the JOG start signal after the test mode of the peripheral device has been cancelled.



(d) The JOG signal status switching from OFF to ON, which takes place within 56.8 ms after the stop signal has been turned OFF, is ignored.



(6) JOG speed change

(a) The jog speed can be changed within the "JOG speed limit" setting range of basic parameters #2 during JOG operation.

(b) To change the JOG speed, turn ON the positioning speed change request of the axis control data, or an external speed change request.
The "speed change processing in progress flag" in the axis monitor area remains ON during speed change processing.

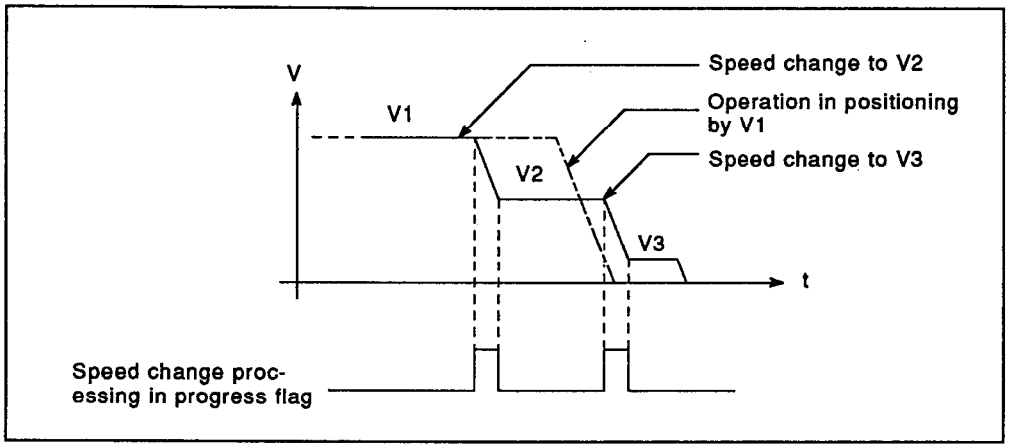


Fig. 3.28 Speed Change Processing Flag Operation Timing

(c) Even if the speed change processing flag is turned ON, the JOG speed can be changed.

(d) Deceleration processing can be continued even if the JOG speed is changed during deceleration with the JOG start signal OFF. However, a warning will be issued.

(e) A speed change value beyond the JOG speed limit results in an axis warning, and JOG operation is executed at the limit JOG speed.
The speed limit flag is kept ON during this JOG operation.

REMARKS

1) The JOG speed can be changed at the following buffer memory address:

Axis No.		Axis 1	Axis 2	Axis 3
Buffer memory address	Changed speed value	1157, 1156	1207, 1206	1257, 1256
	Speed change request	1158	1208	1258

2) The speed change flags are set at the following buffer memory addresses:

Axis No.	Axis 1	Axis 2	Axis 3
Buffer memory address	831	931	1031

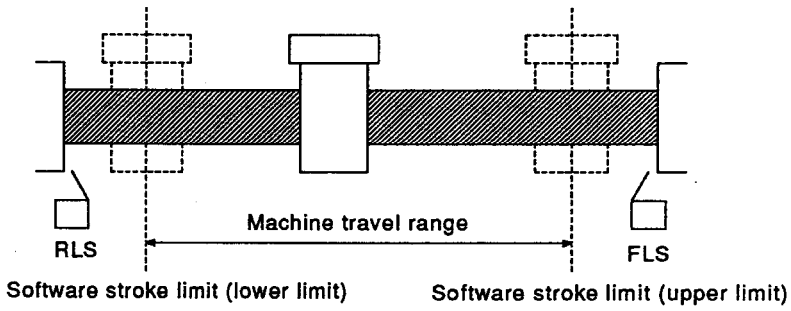
3.3.11 Software stroke limit function

(1) Description of software stroke limit function

(a) The software stroke limit function prevents positioning requested by a command which is outside the upper/lower stroke limit setting range.

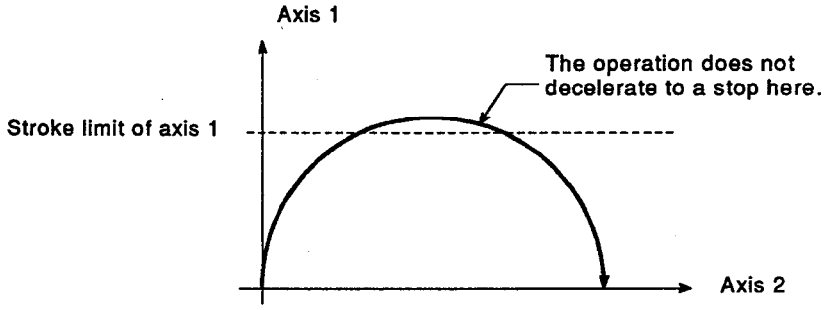
(b) Select a feed present value or machine feed value as the limit in the parameters.

(c) The software stroke limit range is checked at the start of and during operation.



POINT

In circular interpolation control, a software stroke limit check is performed at the start point, end point and arc addresses.
Thus, the path of the axis may overrun the software stroke limit in the middle of control.
However, the operation does not decelerate to a stop in such a case.
Install an external limit switch if there is a possibility of overrun.

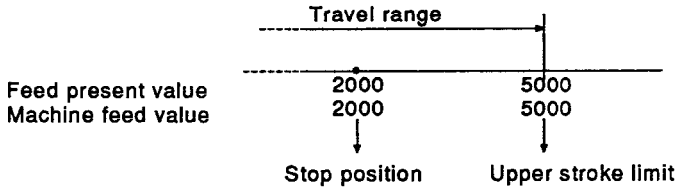


(2) Description of the control

(a) Difference in travel range between the feed present value and the machine feed value
The stroke limit set for the machine feed value is an absolute value with respect to the home return position.*
The stroke limit set for the feed present value is relative to the feed present value.*

[Conditions]

If the current stop position is 2000 and the upper stroke limit is set to 5000;

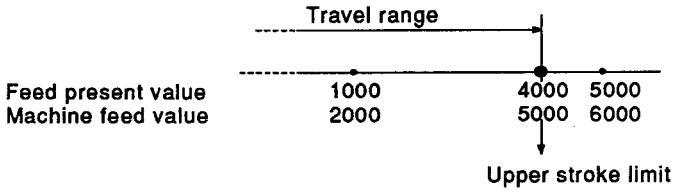


[Present value change]

If the present value is changed from 2000 to 1000, the feed present value is changed to 1000 while the machine feed value remains unchanged.

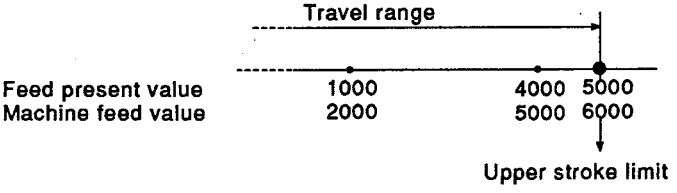
1) If the above upper stroke limit is set for the machine feed value:

Machine feed value 5000 will be the upper stroke limit, which equals the feed present value 4000.



2) If the above upper stroke limit is set to the feed present value:

Feed present value 5000 will be the upper stroke limit, which equals machine feed value 6000.



REMARK

Upon completion of home position return, the feed present value and the machine feed value are set to the home position address of the home position return parameter.

- If positioning control is performed upon completion of the home position return, both the feed present value and the machine feed value will be changed.
- If present value change is performed, only the feed present value will be changed.
- The machine feed value always represents the value with respect to the home position.

(b) Software stroke limit range check performed at the start of operation

1) The following software stroke limit range check is performed on each axis at operation start to determine;
   - Whether or not the operation start point is outside the software stroke limit range.
   - Whether or not the operation would overrun the software stroke limit range.
2) Any axis that has failed to pass either of the above check points, thus causing an axis error, will not be operated.
3) During interpolation control in positioning operation, even if only one axis is out of the software stroke limit range or would overrun the range, an axis error will occur. Consequently, neither axis will be operated.
4) Even if only one axis is out of the software stroke limit range or would overrun the range, thus preventing both axes from being operated at the same time at the start of simultaneous axis positioning, an axis error will occur. Consequently, neither axis will be operated.

Table 3.5 List of Software Stroke Limit Range Checks Performed at Operation Start

		Condition			Remarks
Positioning control	Position control	None			(1) If the feed present value or the machine feed value is outside the software stroke limit range at the start of position control, an error will occur. Consequently, no position control will be performed. (2) If the positioning address is outside the software stroke limit range, no position control will be performed. (3) During circular interpolation control, the software stroke limit range check will also be performed on arc addresses.
	Speed control	When a limit is set to the feed present value	Present value change not performed		(1) Software stroke limit range check not performed.
			Present value change performed		(1) If the feed present value is outside the software stroke limit range at the start of speed control, an error will occur. Consequently, no speed control will be performed.
		When a limit is set to the machine feed value			(1) If the machine feed value is outside the software stroke limit range at the start of speed control, an error will occur. Consequently, no speed control will be performed.
	Speed/ position switching control	When a limit is set for the feed present value	Present value change not performed		(1) Software stroke limit range check not performed.
			Present value change performed		(1) If the feed present value is outside the software stroke limit range at the start of speed/position switching control, an error will occur. Consequently, no speed/position switching control will be performed.
		When a limit is set to the machine feed value			(1) If the machine feed value is outside the software stroke limit range at the start of speed/position switching control, an error will occur. Consequently, no speed control will be performed.
	Home position return	None			(1) Software stroke limit range check not performed.
Manual operation	JOG operation	Software stroke limit of JOG operation/manual pulse generator operation		Invalid	(1) Software stroke limit range check not performed.
				Valid	(1) If the feed present value is outside the software stroke limit range at the start of JOG operation, JOG operation will be started if its direction is toward the software stroke limit range.
	Manual pulse generator operation	Software stroke limit of JOG operation/manual pulse generator operation		Invalid	(1) Software stroke limit range check not performed.
				Valid	(1) If the feed present value is outside the software stroke limit range at the start of manual pulse generator operation, manual pulse generator operation will be started only if its direction is toward the software stroke limit range.

*1: The parameter for "feed present value update request command during speed control" determines whether or not to update the feed present value during speed control.

(c) Software stroke limit range check during operation

1) A software stroke limit range check is performed for position control only.

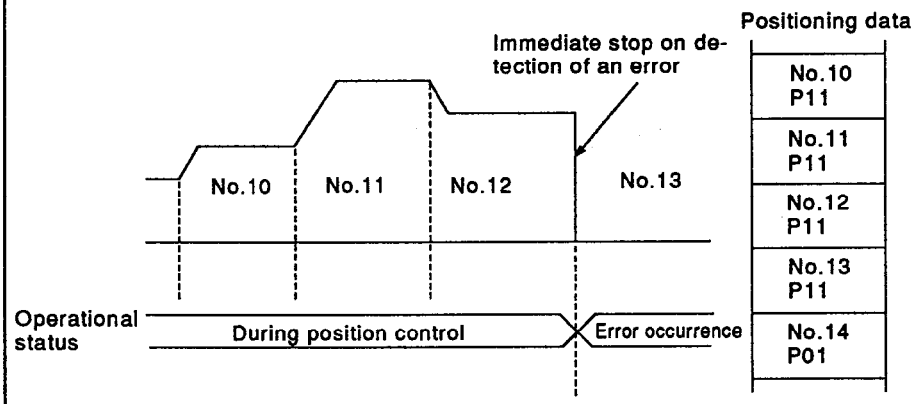
2) If the positioning address of the positioning data is outside the range, an error will occur.

3) During interpolation control, even if one axis is out of the software stroke limit range, an axis error will occur.

4) If the operation pattern is P11 and the next positioning data is position control data, the software stroke limit range check is also run on the next data.
If the next positioning data is found to be outside the software stroke limit range by the check, the current positioning data will be subjected to the same positioning control as P01.
When the next data comes up for processing, an error occurs.

Example

- If the positioning address of positioning data No.13 is outside the software stroke limit range, the axis will decelerate and stop upon execution of positioning data No.12.



(d) Invalidating the software stroke limit range check

To invalidate software stroke limit range check, make the "lower software stroke limit value" equal to the "upper software stroke limit value".
This will allow control regardless of the software stroke limit setting.

(e) Choosing to validate or invalidate the software stroke limit during JOG operation/manual pulse generator operation

The software stroke limit during JOG operation/manual pulse generator operation can be validated or invalidated by setting the parameter for "invalidating the software limit during JOG operation/manual pulse generator operation".

(f) Present value change and software stroke limit range check

Even if an address is put outside the software stroke limit range by a present value change, no error will occur during the change. However, an error will occur at the start of operation due to "attempting to start operation outside the software stroke limit range".

REMARK

To set a stroke limit, or to validate or invalidate a stroke limit with a sequence program, enter data in the following buffer memory areas.

Axis No.	Axis 1	Axis 2	Axis 3
Upper stroke limit	16, 17	166, 167	316, 317
Lower stroke limit	18, 19	168, 169	318, 319
Software limit selection	20	170	320
Invalidating the software limit during JOG operation and manual pulse generator operation	21	171	321

3.3.12 Electronic gear

(1) Electronic gear

(a) Allows the machine travel value per command pulse to be changed as required by setting a travel value per pulse.

(b) Set the travel value per pulse by specifying the "Number of pulses per revolution", "Travel value per revolution", and "Unit magnification" of basic parameters #1.

(c) Setting the travel value per pulse makes it unnecessary to select a servomotor or a detector (encoder) that conforms to the mechanical system, allowing flexible positioning.

(d) The electronic gear function is effective for positioning control, JOG operation, manual pulse generator operation, and home position return.

(2) Electronic gear processing

(a) The electronic gear function accumulates in the AD75 the values less than the travel value per pulse that could not be output as pulses during machine travel. When the cumulative value reaches the travel value per pulse, it is output as a pulse.

(b) Upon completion of fixed-pitch feed, a cumulative value less than the travel value per pulse is cleared to zero.
Accordingly, even when fixed-pitch feed is executed consecutively, the same machine travel value is obtained each time.

(3) Relationship between the commanded speed and the actual speed

The relationship between the commanded speed (the commanded speed set by the positioning data) and the actual speed varies as follows, depending on the electronic gear setting:

(a) When electronic gear setting = 1: commanded speed = actual speed.

(b) When electronic gear setting < 1: commanded speed < actual speed.

(c) When electronic gear setting > 1: commanded speed > actual speed.

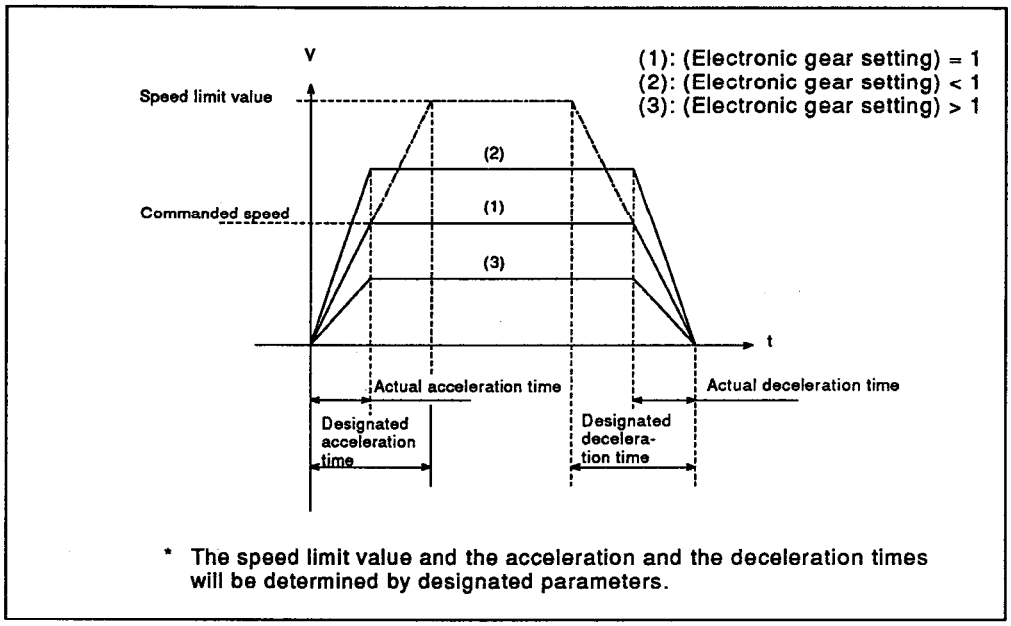


Fig. 3.29 Relationship between commanded speed and actual speed

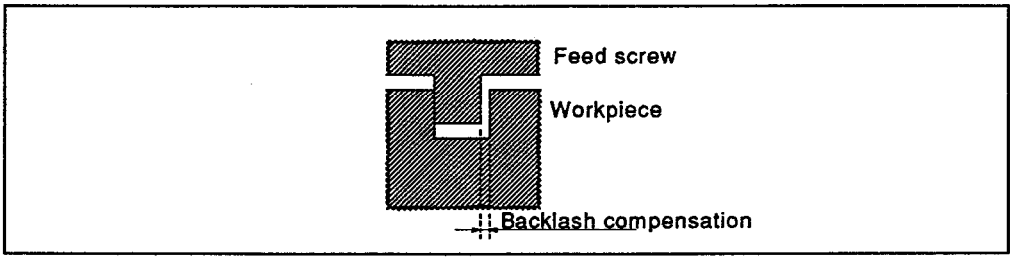
(4) Caution

(a) Note that if the electronic gear setting is low, the actual speed could exceed the speed limit value, causing the servo motor to operate at too high a speed.

3.3.13 Backlash compensation

(1) Backlash compensation

(a) Allows compensation for mechanical backlash to achieve accurate positioning.



(b) When a backlash compensation amount is set, every time the travel direction changes during positioning control, JOG operation, manual pulse generator operation, and home position return, extra feed pulses corresponding to the set backlash compensation amount are generated.

(c) Backlash compensation is performed based on the result of dividing the set backlash compensation amount by the travel value per pulse. The backlash compensation amount can be set in the range from 0 to 65535. Make sure that the backlash compensation amount will be no more than 255 when divided by the travel amount per pulse.
A setting error will occur if 255 is exceeded.
Round off decimals in this calculation.

$$0 \leq \frac{\text{Backlash compensation amount}}{\text{Travel amount per pulse}} \leq 255$$

(Round off decimals)

(2) Caution

(a) The feed pulses for a backlash compensation amount are not added to the feed present value/machine present value.

(b) Be sure to perform home position return before backlash compensation. Otherwise, accurate backlash compensation for the mechanical system is not possible.

(c) The backlash compensation amount can be changed when the PC READY status is OFF.
After the backlash compensation amount is changed, perform home position return.
(When the PC READY status is turned ON, the "home position return request" of the axis monitor will be ON if the backlash compensation amount has been changed.)

(d) When the travel direction changes, feed pulses representing both the travel value and the backlash compensation amount are generated.

REMARK

To change the backlash compensation amount, enter data in the following buffer memory addresses.

Axis No.	Axis 1	Axis 2	Axis 3
Buffer memory address	15	165	315

3.3.14 M code function

(1) M codes

(a) M codes are code numbers (0 to 32767) assigned by the user for each type of positioning control.

(b) M codes can be read by a sequence program to control auxiliary functions (such as clamp, drill rotation, stop, and tool change commands).

(2) Description of M code control

(a) When M = 0, no M code is generated, with the previously issued M code remains valid.
Also, in this case, no M code ON signal is generated.

(b) The M code ON signal for the reference axis is generated during interpolation operation as follows.

Interpolation Axis	Reference Axis	M code ON Signal
During interpolation with axis 1 and axis 2	Axis 1	XD
During interpolation between with 2 and axis 3	Axis 2	XE
During interpolation with axis 3 and axis 1	Axis 3	XF

(3) Output timing of "M code" ON signal

(a) The M code ON signal can be output in two timing modes:
WITH and AFTER

- In the WITH mode, the M code is generated at approximately the same time as the positioning operation starts, thus turning ON the M code ON signal.

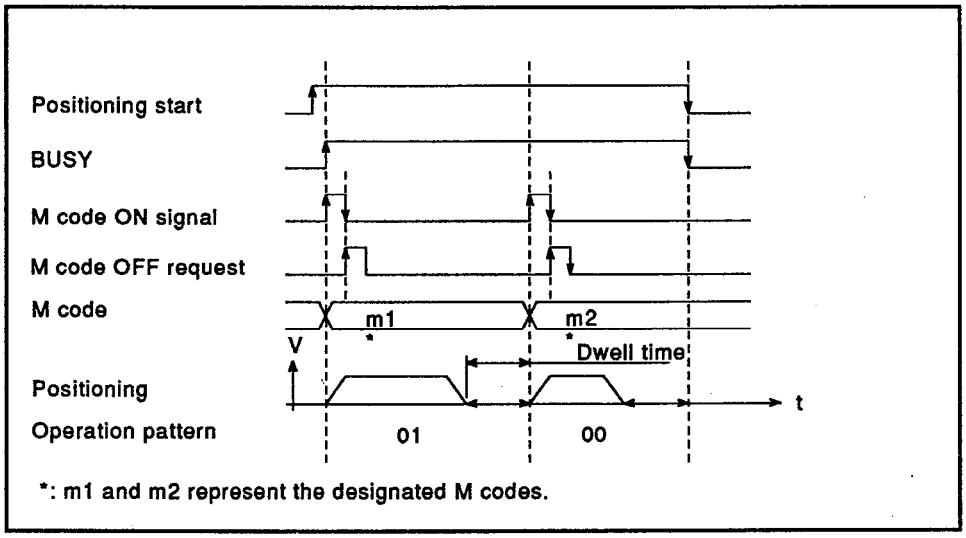


Fig. 3.30 M Code ON/OFF Timig (WITH mode)

REMARK

To set the M code ON signal output timing and request an M code OFF signal, enter data at the following buffer memory address.

Axis No.	Output Timing of M code ON Signal	M code OFF Signal Request
Axis 1	25	1153
Axis 2	175	1203
Axis 3	325	1253

- In the AFTER mode, the M code is output upon completion of the positioning operation, thus turning ON the M code ON signal.

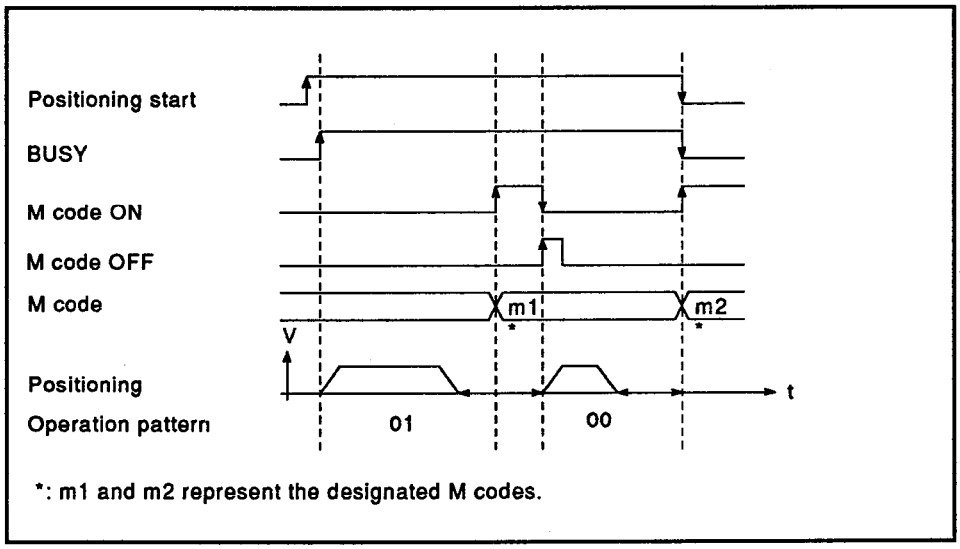


Fig. 3.31 M Code ON/OFF Timing (AFTER mode)

(b) In speed control in the AFTER mode, no M code is output at the completion of the positioning operation during speed control, and the M code ON signal does not come ON.

(c) If the M code ON signal has been turned ON, it must be turned OFF by turning the M code OFF request signal ON with the sequence program.
If the M code ON signal is not turned OFF, one of the following will happen, depending on the operation pattern.

1) If the operation pattern is either positioning complete (00) or continuous positioning control (01):

- The next positioning will not be carried out.
- The system will stand by until the M code ON signal is turned OFF.

2) If the operation pattern is continuous locus control (11):

- The next positioning will be performed, but a warning will be issued.
- If the M code ON signal is ON at the start of positioning control, an error will occur, and the positioning operation will not start.
- If the PC READY signal is turned OFF, the M code ON signal is turned OFF, and "0" will be output as the M code.
- In continuous locus control (11), a warning may be issued if the positioning operation time is too short.
- If there is not enough time to turn OFF the M code ON signal, set 0 for the M code number instead.

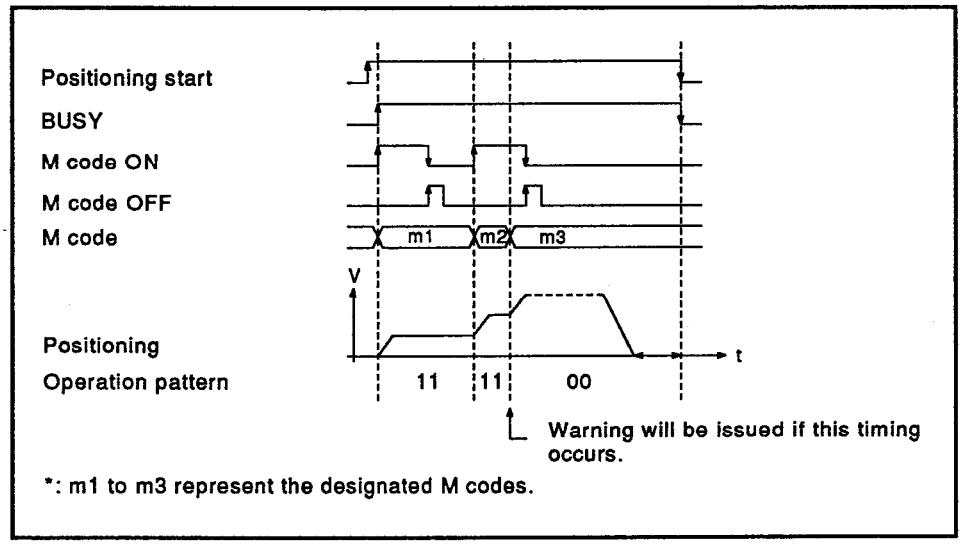


Fig. 3.32 When a Warning Occurs in the WITH Mode

3.3.15 Acceleration/deceleration processing

(1) What is acceleration/deceleration processing?

(a) It is the acceleration processing and deceleration processing at the start of positioning operation, JOG operation, home position return operation, and speed changes.

(2) Relationship between the speed control limit, JOG speed control limit, acceleration time, deceleration time, and rapid stop deceleration time

(a) The speed control limit, JOG speed control limit, acceleration time, deceleration time, and rapid stop deceleration time are defined as follows:

1) The speed control limit is the maximum speed during positioning operation, manual pulse generator operation, and home position return operation.

2) The JOG speed control limit is the maximum speed during JOG operation.
Set the JOG speed control limit to, or lower than, the speed control limit.

3) The acceleration time is the time it takes to reach the designated speed control limit from speed 0.

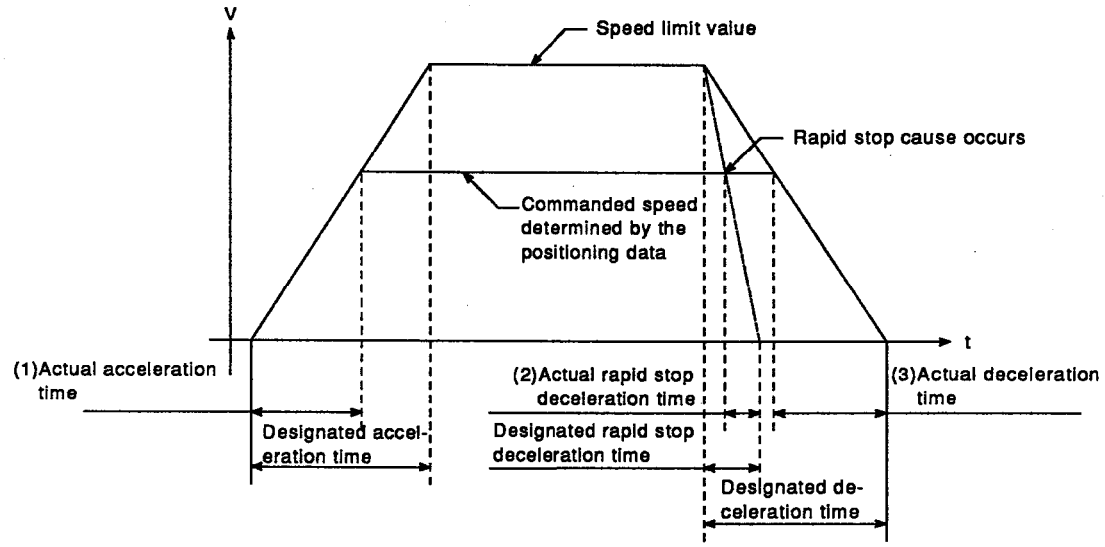
4) The deceleration time and rapid stop deceleration time are times taken to reach speed 0 from the designated speed control limit.

(b) If the commanded speed is designated lower than the parameter speed control limit, the acceleration/deceleration time will be relatively shorter.
Accordingly, set the maximum commanded speed to the same value as, or a similar value to, the parameter speed control limit.

(c) Set the speed control limit, acceleration time, deceleration time, and rapid stop deceleration time by specifying their respective parameters.

(d) During interpolation control with two axes, set the parameters for one of the axes as follows:

- Interpolation control with axis 1 and 2: parameter for axis 1
- Interpolation control with axis 2 and 3: parameter for axis 2
- Interpolation control with axis 3 and 4: parameter for axis 3



(1)Actual acceleration time : Actual acceleration time: The time taken to reach the commanded speed in the positioning data
(2)Actual rapid stop deceleration time : Actual rapid stop deceleration time: The time to reach a complete sudden stop from the commanded speed in the positioning data
(3)Actual deceleration time : Actual deceleration time: The time taken to reach a complete stop from the commanded speed in the positioning data.

Fig. 3.33 Relationships Among Speed Control Limit, Acceleration Time, Deceleration Time, and Rapid Stop Deceleration Time

(e) Setting ranges for acceleration/deceleration time

The setting range for both acceleration and deceleration time is 1 to 65535 ms.

(f) Selection of an acceleration/deceleration time pattern

1) Four patterns each for acceleration time and deceleration time are available for positioning operation.

2) Specify which acceleration and deceleration pattern is to be used for home position return and JOG operation by parameter setting.

POINT

There are four patterns each of acceleration time and deceleration time to choose from.
If more than four patterns are required, rewrite acceleration times 0 to 3 and deceleration times 0 to 3 using the programmable controller before turning ON positioning start signal (Y10 to 12).

(3) Acceleration/deceleration processing

(a) There are two acceleration/deceleration methods: "trapezoidal acceleration/deceleration" and "S-pattern acceleration/deceleration".

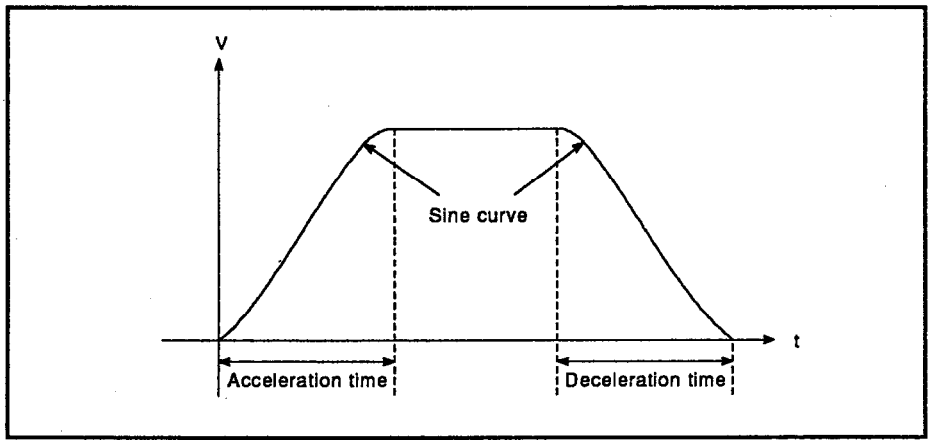


Fig. 3.34 S Pattern Acceleration/Deceleration Processing

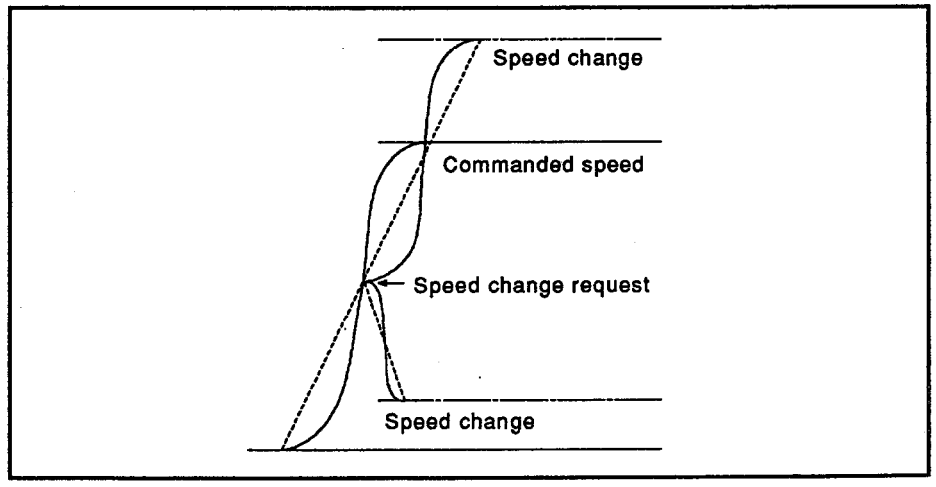
POINTS

(1) S pattern acceleration/deceleration processing cannot be used with stepping motors.

(2) To use S pattern acceleration/deceleration processing, set "S pattern acceleration/deceleration processing" for the acceleration/deceleration processing selection, and set an S curve ratio, in extended parameters #2.

(b) When S curve acceleration/deceleration processing is selected, an S curve ratio must be set. (For details on the S curve ratio, see Section 3.4.2 (18).)
S pattern acceleration/deceleration processing is performed for all acceleration and deceleration at the start and end of positioning, JOG, and home position return operations, and at speed changes.

(c) When a speed change is executed during S pattern acceleration/deceleration, S curve acceleration/deceleration is executed from when the speed change request is received.



3.3.16 Torque limit function

(1) Torque limit function

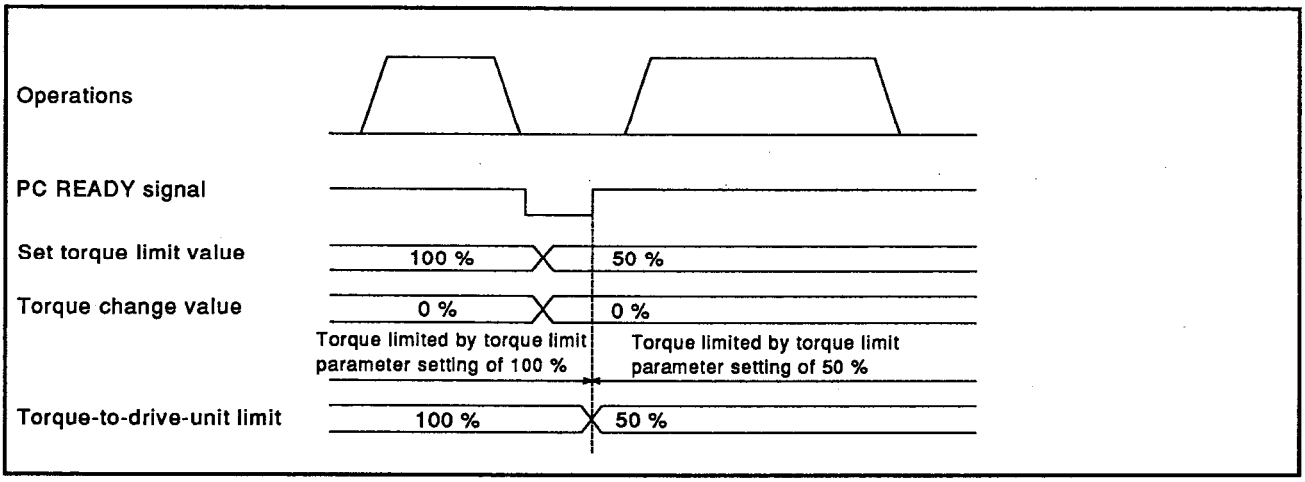
(a) Limits the torque generated by the servomotor within a setting range.

(b) It also maintains the torque within the setting range if the torque required for control exceeds the torque limit value.

(2) Description of the operation under torque limit control

(a) The torque limit value set in the parameters is used as the torque limit setting.
To perform torque limit control based on the set torque limit parameter value, set the torque change value of the axis control data to "0". If the torque change value is set to any value other than "0", torque limit control will be performed based on the torque change value.
See Section 3.3.17 "Torque change function" for further details.

(b) The torque limit parameter value can be changed when the PC READY signal is OFF.
The torque limit parameter value after such a change will be effective after the PC READY signal is turned ON.



(c) The following table describes the operation status and the applicable torque limit value.

Operation Status	Applicable Torque Limit Value(s)
Positioning operation	The torque limit setting in the parameters or the torque change value is used.
Home position return	The torque limit setting in the parameters or the torque change value is used. However, the torque limit value of the home position return parameter is used after the creep speed is reached.
JOG operation	The torque limit setting in the parameters or the torque change value is used.
Manual pulse generator operation	The torque limit setting in the parameters or the torque change value is used.

POINTS

(1) Requirements for using a pulse-train output type

(a) Wiring is required between the D/A conversion module and the drive unit.

(b) A drive unit capable of issuing torque limit commands based on analog voltage is required.

(c) The set torque limit setting is set in the "torque limit storage area" of the axis monitor. Transmit the "torque limit storage value" to the D/A conversion module using a sequence program.

REMARKS

1) To set the torque limit value using a sequence program, enter data in the following buffer memory addresses.

Axis No.	Axis 1	Axis 2	Axis 3
Torque limit value	24	174	324

2) The following are the buffer memory area addresses of the axis monitor for storing the torque limit value.

Axis No.	Axis 1	Axis 2	Axis 3
For storing the torque limit value	826	926	1026

3.3.17 Torque change function

(1) What is the torque change function?

(a) It is a function for changing the torque limit value during positioning control, JOG operation, and manual pulse generator operation. To change the torque limit value, set the "torque change value" of the axis control data to the required value. The torque generated by the servomotor will be limited to the changed value.

(b) To perform this change, data has to be written to the buffer memory area using a sequence program.

(2) Description of the torque change function

(a) Details of the torque change function

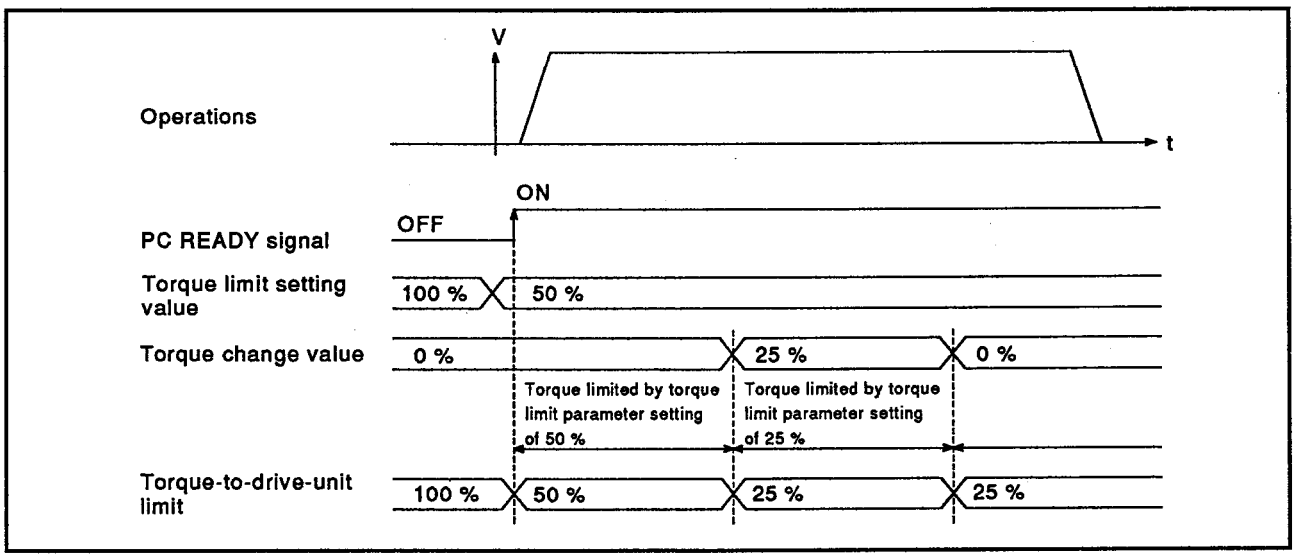
1) The "torque change value" of the axis control data can be changed at any time.
The torque change value takes effect the moment it is written.

2) The setting range is from 0 (zero) to the torque limit setting in the parameters.

- To perform torque limit control based on the torque limit setting in the parameters, set the torque change value of the axis control data to "0".
- If the torque change value is set to any value other than "0", torque limit control will be performed based on the torque change value.

3) At the start of positioning control, JOG operation, and manual pulse generator operation, torque limit control will be performed based on the torque limit setting in the parameters.

(b) If the torque change value is out of the setting range, an axis warning will occur.



REMARK

Set the torque change value in the following buffer memory areas.

Axis No.	Axis 1	Axis 2	Axis 3
Torque change	1176	1226	1276

3.3.18 Present value change

(1) What is present value change?

(a) This function changes the feed present value of an axis that has not been moved to a designated address.
Present value change does not change the machine feed value.

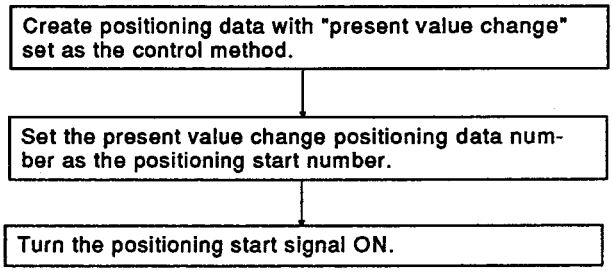
(b) There are two present value change methods: the method using the positioning data, and the method using the present value change buffer memory.

1) For present value change using the positioning data, use the "present value change" setting for the control method in the positioning data.

2) For present value change using the present value change buffer memory, set the address after the change in the buffer memory allocated for present value change use.
Use the positioning start number "9003".

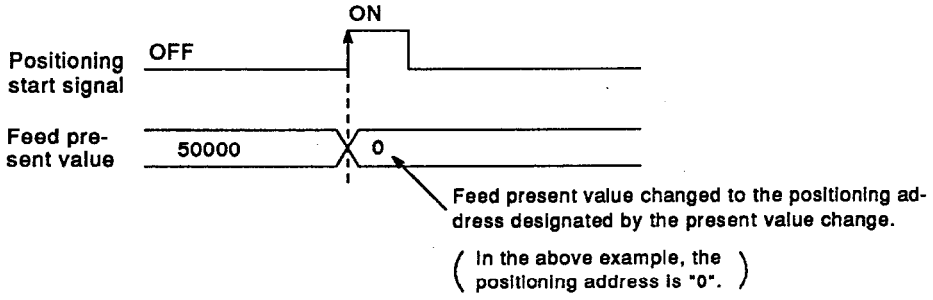
(2) Present value change using positioning data

(a) A present value change using the positioning data is performed according to the procedure below.



(b) Timing of change

When the positioning start signal is turned ON, the feed present value is changed to the newly designated value .



REMARK

The following are the buffer memory addresses for positioning start.

Axis No.	Axis 1	Axis 2	Axis 3
Buffer memory address for positioning start	1150	1200	1250

(c) Error detection

1) An axis error will occur if a value designated in degree units is outside the setting range.

2) An error will not occur even if the set value is outside the stroke limit range.
At the start of positioning control, however, an error will occur due to an operation start from outside the software stroke limit range.

3) An error will occur if the positioning data following the positioning data for continuous locus control is present value change data.
An error will also occur if the operation pattern of the positioning data designating present value change is continuous locus control.

(d) Designating positioning data *1

The following positioning data can be set with the peripheral device or sequence program:

Data	Necessity of Setting *2
Operation pattern	Select "positioning end".
Control method	Select "present value change".
Acceleration time	—
Deceleration time	—
Positioning address/Travel value	o *3
Circular interpolation address	—
Commanded speed	—
Dwell time	—
M code	—

REMARKS

1) *1: For details of positioning data, see Section 3.4.5.

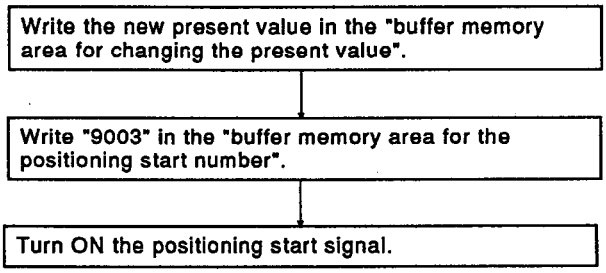
2) *2: Whether or not setting is necessary is indicated by one of the following symbols:

- o : Must be set.
- Δ : May be set as required.
- — : Need not be set.

3) *3: Set the address after the change.

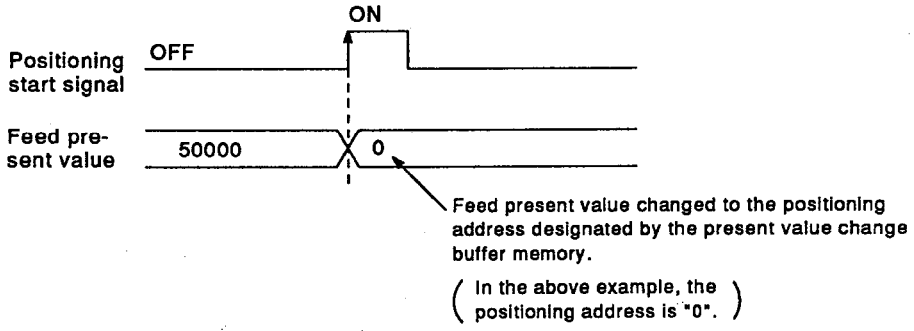
(3) Present value change using the present value change buffer memory

(a) A present value change using the present value change buffer memory is performed according to the procedure below.



(b) Timing of change

When the positioning start signal is turned ON, the feed present value is changed to the newly designated value .



(c) Error detection

1) An axis error will occur if a value designated in degree units is outside the setting range.

2) An error will not occur even if the set value is outside the stroke limit range.
At the start of positioning control, however, an error will occur due to an operation start from outside the software stroke limit range.

REMARK

The following are the buffer memory addresses forpresent value change and positioning start.

Axis No.	Axis 1	Axis 2	Axis 3
Buffer memory address for present value change	1154, 1155	1204, 1205	1254, 1255
Buffer memory address for positioning start	1150	1200	1250

3.3.19 Speed change

(1) What is speed change?

(a) This function changes the present speed to a designated speed during the following positioning.

- Position control
- Speed control
- Speed/position switching control
- JOG operation

(b) A new speed can be written by using a sequence program or the test mode of a peripheral device.

(c) A speed change can be executed at any required position either by turning ON a speed change request in the axis control data, or by turning ON an external speed change request* (external signal).

POINTS

(1) To change the present speed with a sequence program, first multiply the new value by 100 or 1000 and then enter the product of the multiplication as the speed change value.

Example

If the current speed is to be changed to 10000.00 mm/min, enter 1000000 for the changed speed value.

(2) When making consecutive speed changes, set at least 100 ms intervals between successive speed changes.

REMARK

* : To use an external speed change request, "1: external speed change request" must be set for "external positioning start selection" in extended parameters #2. Also, "external start valid" of the buffer memory axis control data must be set to "valid" (1).

Axis No.	Axis 1	Axis 2	Axis 3
Buffer memory for external start valid setting	1171	1221	1271

(2) Description of the operation

(a) A warning will occur in the following cases.

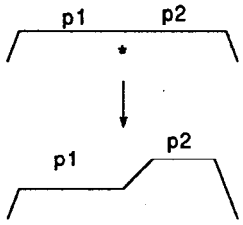
- During deceleration due to a stop command
- During automatic deceleration under positioning control

(b) To change to a new value, set the positioning operation speed change value of the axis control data to the new value.
If the positioning operation speed change value exceeds the speed limit value, a warning will occur and the change value will be set at the limit value.

(c) When the remaining distance is insufficient to complete the change during position control, or during position control in speed/position switching control, the feed speed is controlled to approach the speed change value as closely as possible.

<When the remaining distance is insufficient>

If a speed is designated for P1 while the current speed is designated for P2:



If speed change occurs at "*" where the remaining distance is insufficient to complete the speed change, it is completed in P2, and the current speed is set to the changed speed.

* If a commanded speed is designated for P2, operation is performed at the commanded speed, and the current speed is set to the commanded speed.

However, since the current speed is changed, if the current speed is used as the next positioning speed during continuous positioning, the new change speed value is achieved during the next positioning. On the other hand, if a speed is designated in the next positioning data, the operation is performed at the designated speed.

(d) During interpolation control, speed change is performed based on the speed change value and the speed change request stored in the buffer memory area for the reference axis.

Interpolation Axis	Reference Axis	Buffer Memory	
		Speed Change Value	Speed Change Request
During interpolation with axis 1 and axis 2	Axis 1	1156,1157	1158
During interpolation with axis 2 and axis 3	Axis 2	1206,1207	1208
During interpolation with axis 3 and axis 1	Axis 3	1256,1257	1258

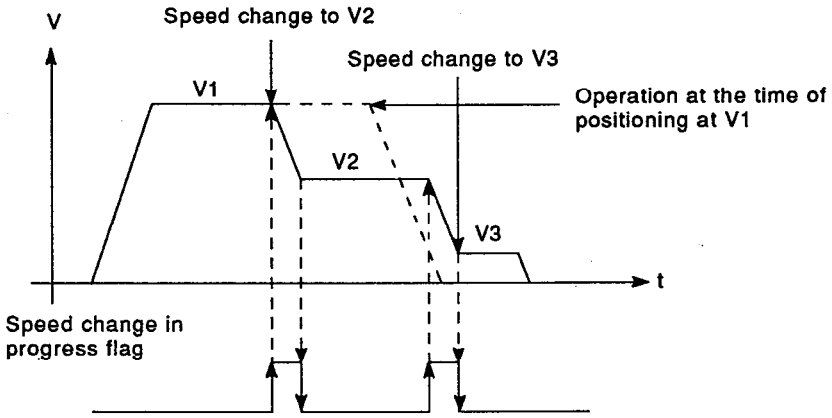
(e) If the control units of the reference axis and other axis differ from each other, the unit of the reference axis will be the unit for the speed change. (See (d) above.)

(f) During speed control, "1" is stored in the applicable buffer memory for the speed change in progress flag (flag ON). Upon completion of the speed change, "0" replaces "1" (flag OFF). (See the table below.)

Axes No.	Speed Change Flag
Axis 1	831
Axis 2	931
Axis 3	1031

(g) Even when the operation pattern is set to continuous locus control (11), an immediate speed change can be executed upon receiving a speed change request.
However, if the distance required to change to the designated speed cannot be secured, no speed change is executed.

<Opeation timing during positioning operation speed change processing>



(3) Speed change request with speed change value of "0"

(a) If a speed change request is made with a speed change value of "0" during positioning control, the axis will decelerate to a stop and the speed change 0 flag of the buffer memory axis monitor will be turned ON.

(b) During interpolation control, "1" is stored in the buffer memory area for the speed change 0 flag for the applicable reference axis.

Interpolation Axes	Reference Axis	Speed Change 0 Flag
During interpolation with axis 1 and axis 2	Axis 1	817
During interpolation with axis 2 and axis 3	Axis 2	917
During interpolation with axis 3 and axis 1	Axis 3	1017

(c) If the speed change value is set to any value other than "0", the speed change "0" flag will be turned OFF, continuing the operation.

(d) When the speed becomes "0" after making a speed change to "0", the BUSY signal will remain ON.
In this case, the axis is stopped but maintains its operation status.

(e) Upon receiving a stop signal, the BUSY signal will be turned OFF, with the operation status of the axis changed to "stopped".

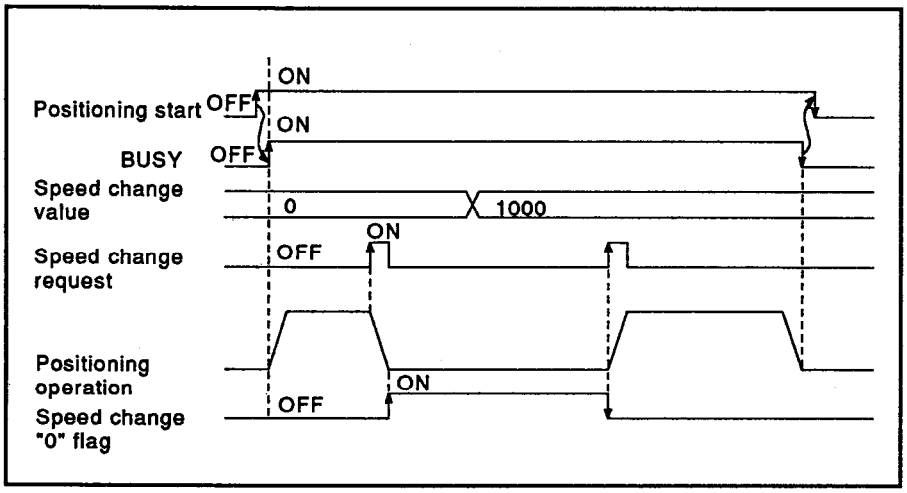


Fig. 3.35 Speed Change "0" Timing

3.3.20 Skip function

(1) What is the skip function?

Upon receipt of a skip signal, this function decelerates axis motion to a stop without processing the remaining travel value, and executes the next positioning.

(2) Skip signal

(a) The skip signal is turned ON when the skip command of the axis control data or the external start signal comes ON.

(b) When the skip signal is turned ON, the axis automatically decelerates and performs the next positioning.
If the skip signal is turned ON in a final positioning operation, operation is terminated.

(c) When the positioning being executed is skipped, the positioning completed signal for positioning in data No. units or automatic acceleration and deceleration units is not turnd ON.

(d) When skip is executed during a dwell time, the dwell time is terminated and the next positioning is started.

(e) The following describes the operation after the skip signal is turned ON during interpolation.

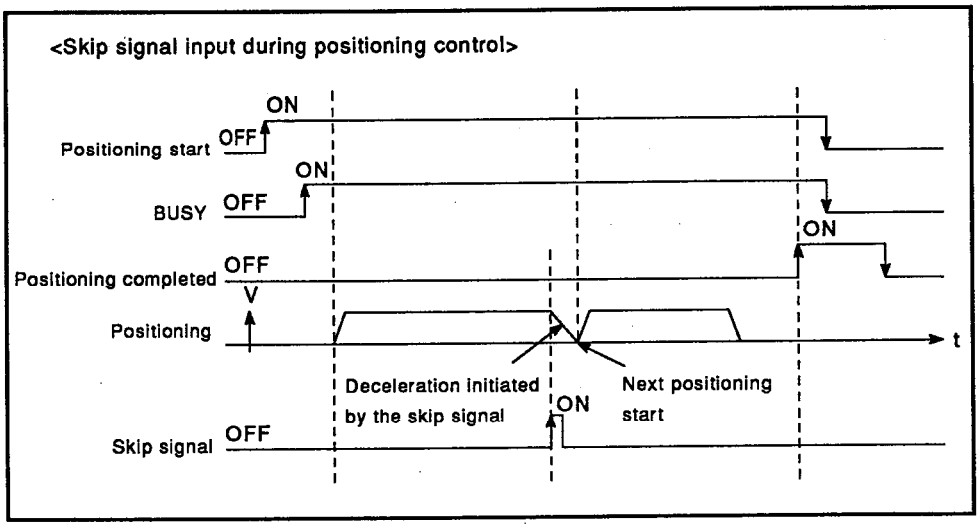
1) During interpolation with axis 1 and axis 2
(reference axis: axis 1)
When the skip signal of axis 1 is turned ON, both axes decelerate to a stop and axis 1 performs the next positioning.

2) During interpolation with axis 2 and axis 3
(reference axis: axis 2)
When the skip signal of axis 2 is turned ON, both axes decelerate to a stop and axis 2 performs the next positioning.

3) During interpolation with axis 3 and axis 1
(reference axis: axis 3)
When the skip signal of axis 3 is turned ON, both axes decelerate to a stop and axis 3 performs the next positioning.

(f) If the M code output is in the AFTER mode, no M code is output and the M code ON signal does not come ON.

(g) A skip signal received during home position return is ignored.



REMARKS

1) *: Since the external start signal is used for the following purposes, the skip function must be set in advance if it used to be used for the skip function.

- External positioning start
- External speed change request
- Skip request input signal

External start enable setting is also necessary to use the external start signal.

2) Enter data in the following buffer memory addresses to turn ON the skip command, select the external start input function, and perform the external start enable setting.

Axis No.	Skip Command	External Start Input Selection	External Start Enable Setting
Axis 1	1175	62	1171
Axis 2	1225	212	1221
Axis 3	1275	362	1271

3.3.21 Step function

(1) What is the step function?

The step function enables the user to confirm each positioning step.

(2) Executing the step function

(a) After turning the step enabled flag ON in advance, turn the positioning start signal ON.

(b) When one positioning step is completed normally, the axis operation status will become step standby.

(c) If operation is stopped by the stop signal during step operation, the axis operation status will become step-stopped.

(d) If an error occurs which causes deceleration to a stop during step operation, a step error condition will occur.

(e) The next positioning step is performed if the step start data is set to 01H when the axis operation status is step standby.

(f) The stopped processing of positioning data restarts if the step start data is set to 01H or 02H when the axis operation status is step-stopped.
Positioning will not be performed even if the step start data is set to 02H when the axis operation status is other than step-stopped.

(g) If the axis operation status is inappropriate when setting the step start data, a warning will occur, as shown in the following table.
(A warning is output only when the step enable flag is turned ON.)

Axis Operation Status	Start Data	
	Set to 01	Set to 02
Standby	—	—
Stopped	—	—
Interpolation	X	X
JOG operation	X	X
Manual pulse generator operation	X	X
Analyzing	X	X
Special start standby	X	X
Home position return	X	X
Positioning control	X	X
Speed control	X	X
Speed/position switching: speed control	X	X
Speed/position switching: position control	X	X
Step standby	O	—
Step-stopped	O	O
Step error	—	—
Error	—	—

X: Warning for starting during operation
O: Normal operation
—: Warning for invalid step start data

(h) When the axis operation status is step standby, step-stopped, or step error with the step effective signal ON, the first-point positioning step will be performed upon turning ON the positioning start signal again.

(3) Step function modes

(a) Two step function are available: "the deceleration unit step mode"; and "the data No. unit step mode".

1) Deceleration unit step mode

Normal operation is performed until positioning data that calls for automatic deceleration is encountered. Upon such an encounter, axis motion is automatically decelerated and positioning stopped after the positioning data is executed.

2) Data No. unit step mode

After executing the positioning data, automatic deceleration to a stop is performed regardless of whether automatic deceleration is necessary or not.
Automatic deceleration is executed forcibly even if the operation pattern is continuous locus control (11).
(The operation is the same as continuous positioning control (01).)
Therefore, when performing continuous operation in which the positioning data has the operation patterns 00 and 01 only, positioning in the deceleration unit step mode operates in the same manner as in the data No. unit step mode.

(b) During interpolation with axis 1 and axis 2, positioning is performed in the step mode of axis 1; during interpolation with axis 1 and axis 2, the step mode of axis 2; and during interpolation with axis 3 and 1, the step mode of axis 3.

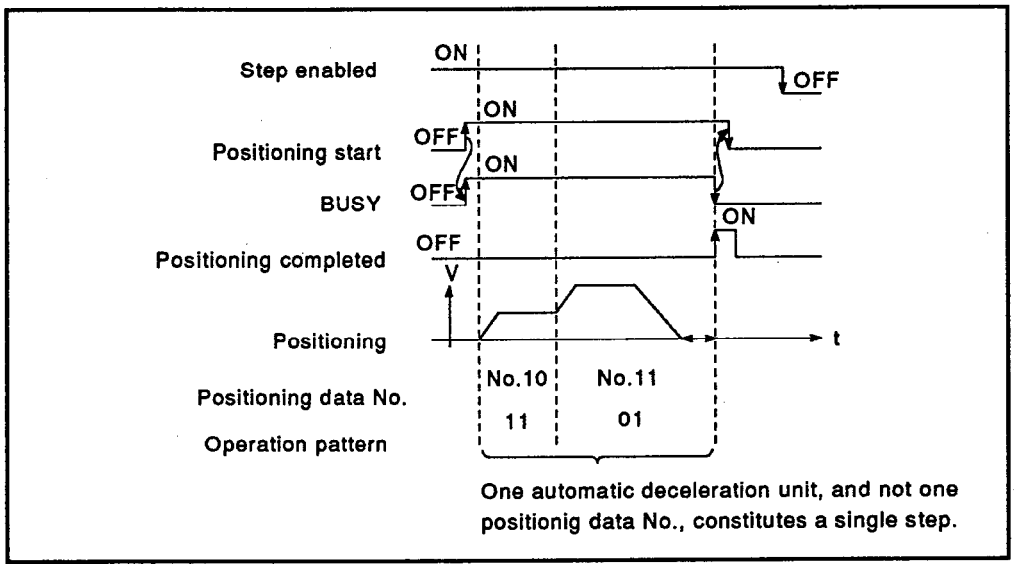


Fig. 3.36 Operation for Deceleration-Unit Step Execution

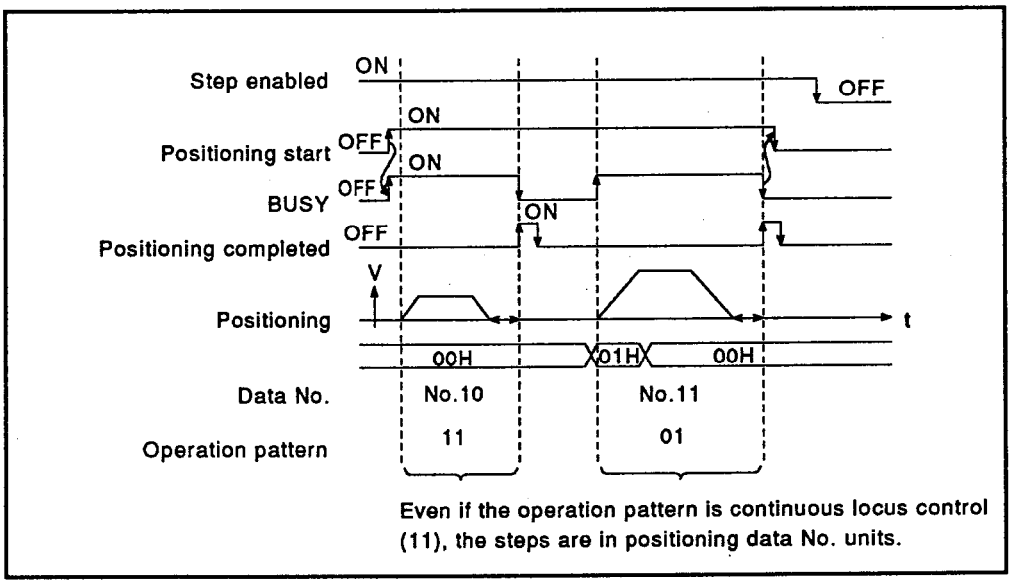


Fig. 3.37 Operation for Positioning Data No.-Unit Step Execution

(4) Step function in continuous locus control (11)
If positioning is performed in the data No. unit step mode when the operation pattern is continuous locus control (11), the AD75 performs operation according to pattern 11 to check the positioning operation for abnormality.
However, since the axis is actually operated in the data No. unit step mode, the operation is carried out in accordance with operation pattern 01.
The axis operation status becomes "step error" at this time.
If "01" is set in the step start data, step operation will resume at the data following the positioning data which has caused the error.

3.3.22 Command in-position

(1) What is command in-position?

(a) For each occurrence of automatic deceleration during positioning control, this function turns ON the command in-position flag when the remaining positioning distance is within the "command in-position range".
The command in-position flag is set when the command in-position range check determines the remaining positioning distance is within the "command in-position range".

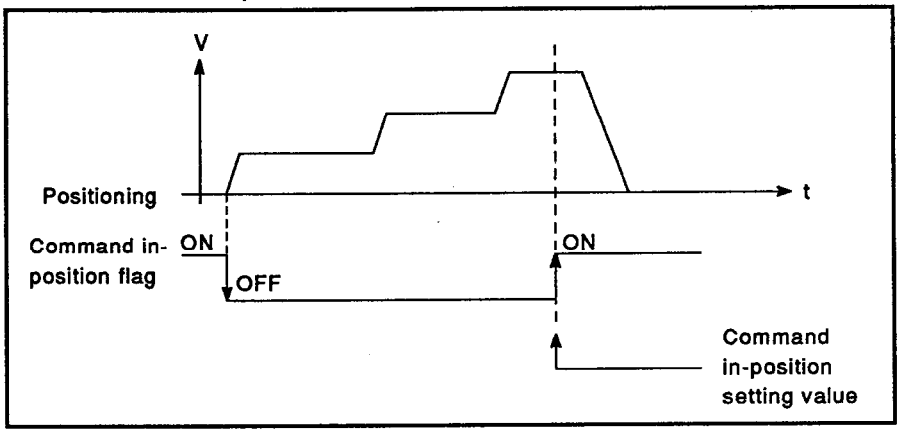


Fig. 3.38 ON/OFF Timing of the Command In-Position Flag

(2) Description of the operation

(a) The command in-position range check is run all the time during positioning control and deceleration to a stop by the step function, except in the following conditions:

- During deceleration to a stop due to a stop command/rapid stop command
- During speed control or during speed control in speed/position switching control

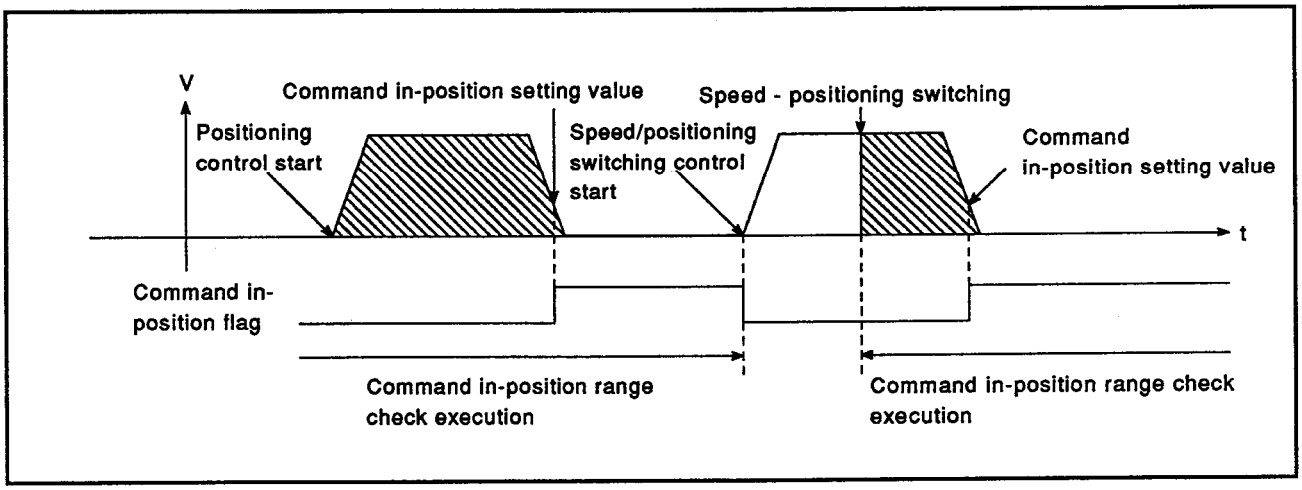


Fig. 3.39 Command In-Position Range Check

(b) The command in-position flag is turned OFF in the following situations:

- At the start of positioning
- During home position return
- During speed control
- During JOG control
- During manual pulse generator operation

(c) During interpolation control, the command in-position function is executed based on the data stored in the buffer memory areas for the command in-position range and the command in-position flag for the reference axis.

Interpolation Axes	Reference Axis	Buffer Memory	
		Command In-position Range	Command In-position Flag
During interpolation with axis 1 and axis 2	Axis 1	22,23	817
During interpolation with axis 2 and axis 3	Axis 2	172,173	917
During interpolation with axis 3 and axis 1	Axis 3	322,323	1017

3.3.23 Teaching function

(1) What is the teaching function?

(a) This function changes a positioning address reached by manual operation (JOG operation or manual pulse generator operation) to the positioning address of a designated positioning data No.

(b) In the case of circular interpolation with a designated auxiliary point, The teaching function can change the circular interpolation auxiliary point address and the positioning address.
In the case of circular interpolation with a designated center point the teaching function can change the positioning address.

(2) Positioning address

The written positioning address or auxiliary point address for circular interpolation is an absolute address with respect to the home position.

(3) Axes subject to teaching

Teaching can be performed for each axis individually or for designated interpolation axes.

- Individual axis teaching: designate one target axis at a time.
- Interpolation axes teaching:designate a pair of target axes at a time.

(4) Constraints

(a) The teaching function is performed for stopped axes with a sequence program.
Even if an error or warning occurs during manual operation, this function is effective unless the axis is in the BUSY status.

POINTS

(1) Positioning identifiers, M codes, dwell time, and commanded speed can also be changed during teaching operation.

(2) The teaching function uses the control data addresses of the buffer memory.
Set the following data in the control data addresses.

Setting Data	Buffer Memory Address(es)
Target axis	1103
Positioning data No.	1104
Write pattern	1105
Write request	1106
Write positioning data	1108 to 1137
Flash ROM write request	1138

For details of the control data addresses, see Section 3.6.4.

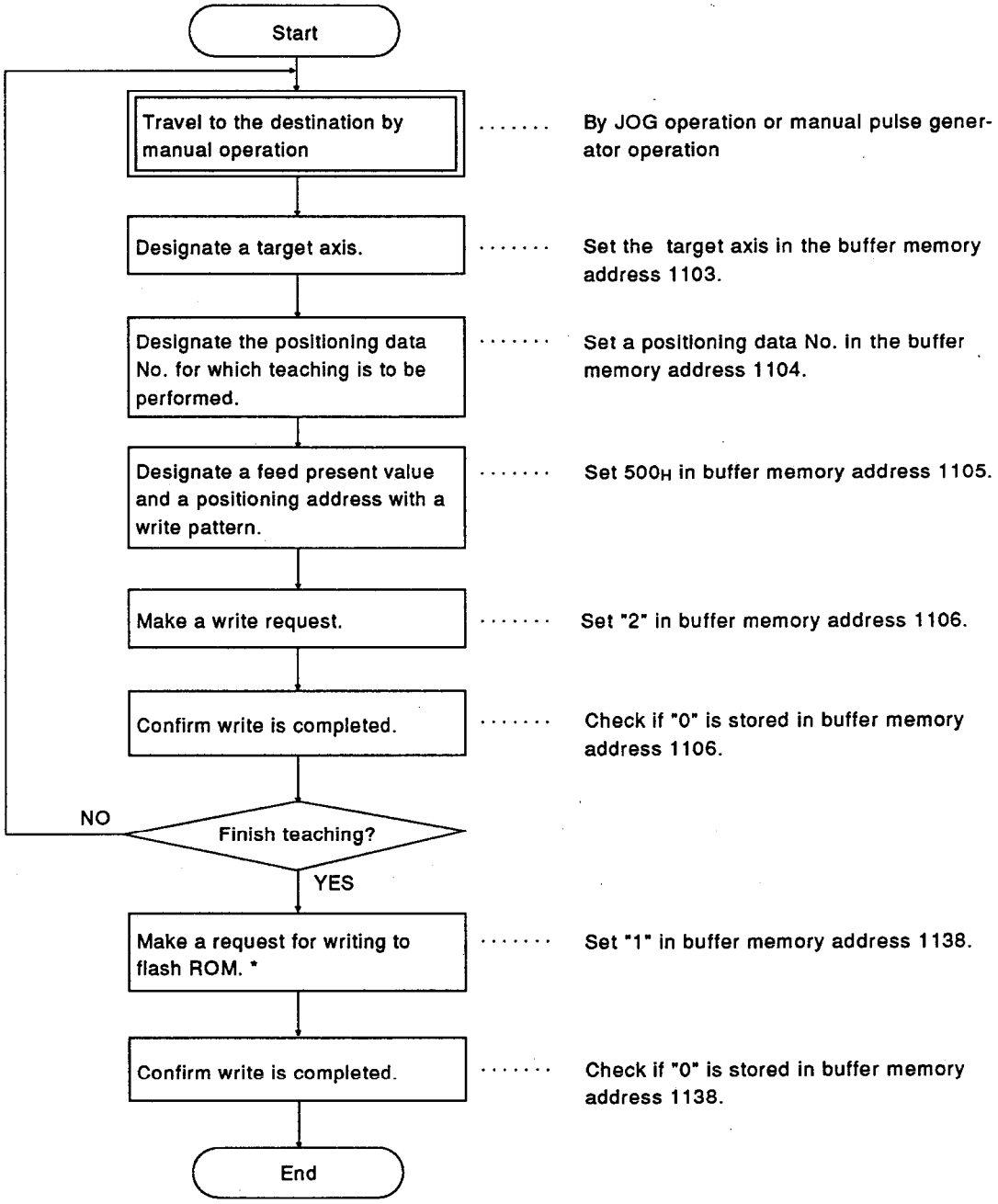
REMARK

*: "Positioning identifier" is a generic term that covers the positioning pattern, acceleration time No., deceleration time No., and control method.

(5) Teaching procedure

The following flowcharts describes the teaching procedure with a sequence program.

(a) When controlling each axis independently, and when performing interpolation (except for circular interpolation with a designated auxiliary point), the teaching function can be used to change the positioning address in the individual axis control or interpolation control (except circular interpolation with a designated auxiliary point).



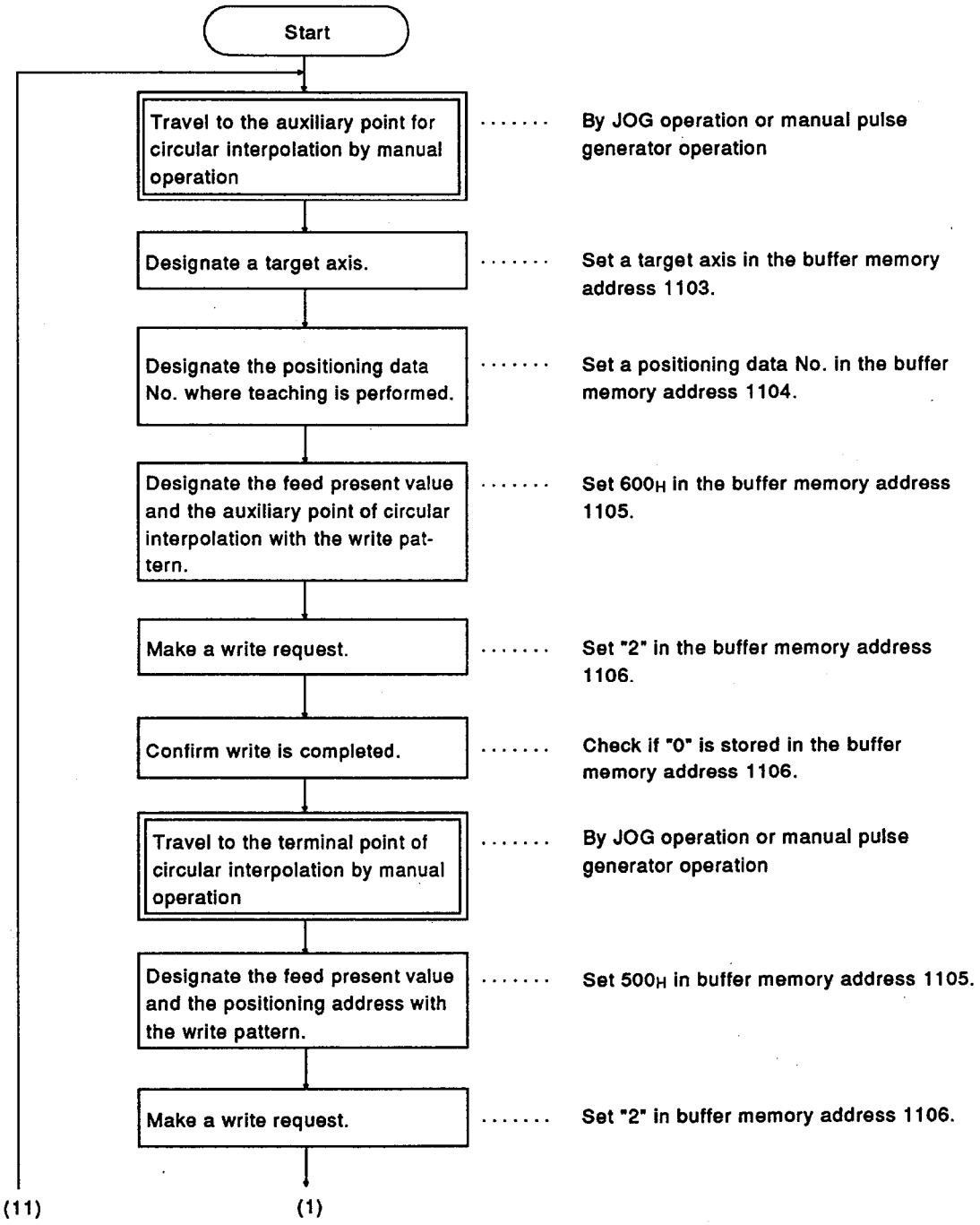
POINT

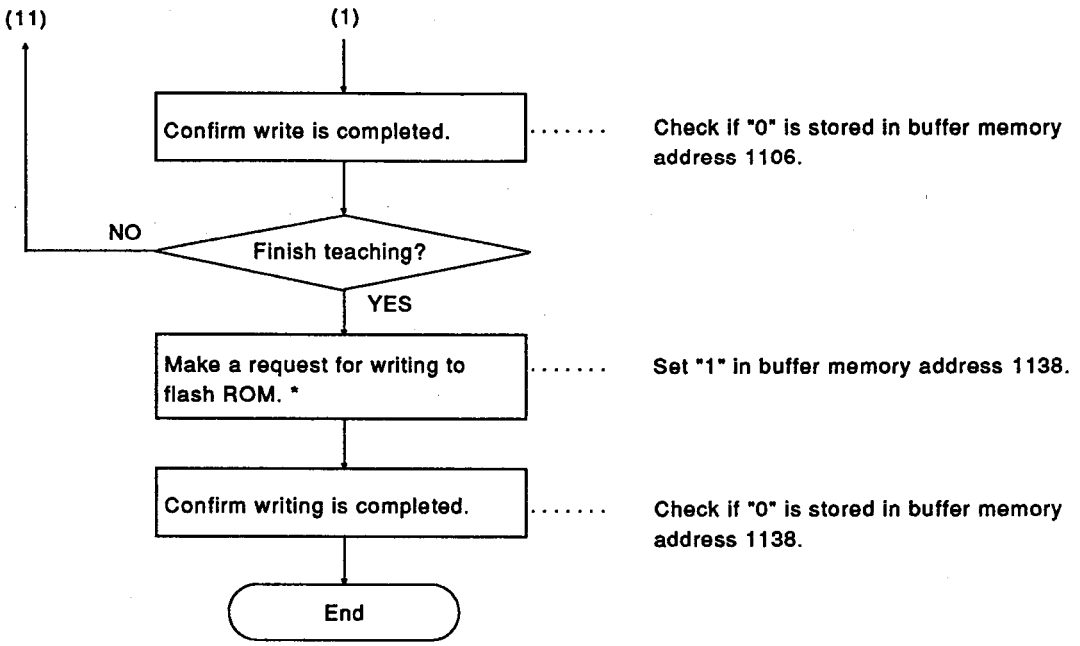
*: Writing to the flash ROM is possible up to 100,000 times.
Once the flash ROM has been writen to 100,000 times, writing to the flash ROM will no langer be possible.

(b) Procedure for controlling circular interpolation with a designated auxiliary point

In the case of circular interpolation with a designated auxiliary point, the teaching function enables the auxiliary point and the final address to be changed.

(In the case of circular interpolation with a designated center point, the teaching function enables the final address to be changed. See (a) for details about the teaching procedure.)





POINT

*: Writing to the flash ROM is possible up to 100,000 times.
Once the flash ROM has been writen to 100,000 times, writing to the flash ROM will no longer be possible.

3.3.24 Override function

(1) Override function

(a) Changes the positioning speed (current speed) to 1 to 300 % of the commanded speed.

(b) This is accomplished by writing the required override value (1 to 300 %) in the buffer memory area for the positioning speed override setting.

(2) Description of the operation

(a) The override function continues to be effective for the current speed even after a speed change is executed.

(b) The current speed remains unchanged when the override value is set to 100 %.

(c) The override function is ineffective for the speed during deceleration due to a stop command, or for automatic deceleration during position control.
The override function will take effect again after deceleration to a stop.

(d) Any value set for this function is invalid if it exceeds the speed control limit; the positioning will be performed at the speed control limit.
In this case, a warning (warning No. 501) occurs, turning the speed control flag ON.

(e) If it is not possible to secure a sufficient distance for this function to change the current speed to the designated override speed, the current speed is changed to the highest possible speed within the given distance.
However, no speed change occurs if the operation pattern is "11" (continuous locus control).

(f) During interpolation control, the override function uses the buffer memory area for the positioning speed override setting for the reference axis as shown below.

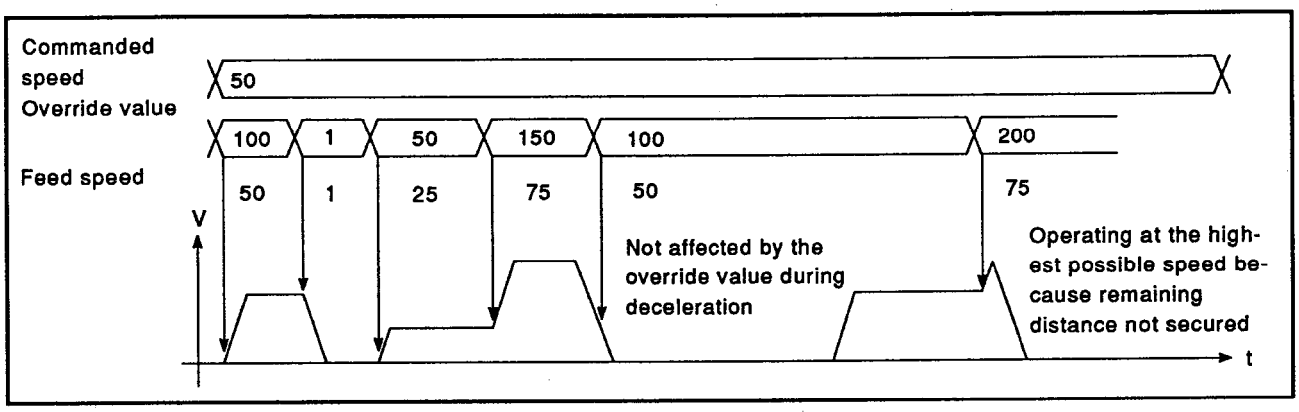
Interpolation Axis	Reference Axis	Buffer Memory for Positioning Speed Override Setting
During interpolation with axis 1 and axis 2	Axis 1	1159
During interpolation with axis 2 and axis 3	Axis 2	1209
During interpolation with axis 3 and axis 1	Axis 3	1259

(g) The value in the feed speed storing buffer memory in the axis monitor area changes according to the override value.

(h) If a feed speed of 1 or less results from setting an override value of 100 % or less, feed is performed at the speed of "1" in the current speed units.

(i) If the set override value is outside the setting range, operation is performed using the value indicated below.

- For 0 % : Operation at 100 %
- For 301 % : Operation at 300 %

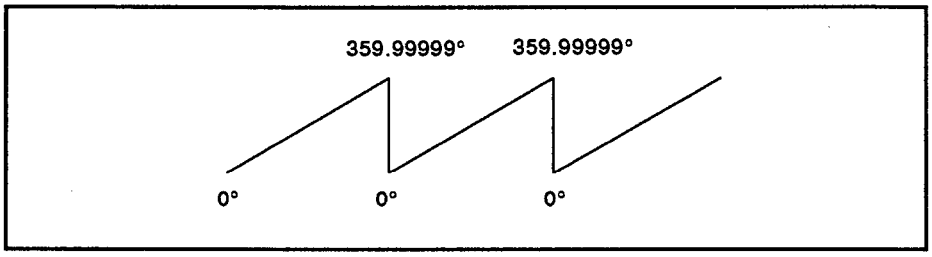


3.3.25 Control unit "degrees"

The control unit "degrees" differs from other control units as described below.

(1) Addresses of the feed present value and machine feed value

Ring addresses of 0° to 359.99999° are assigned to feed present values and machine feed values.

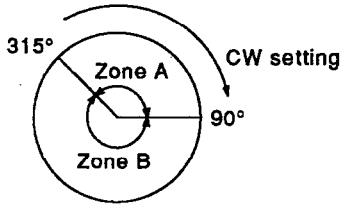


(2) Validating/invalidating software stroke limits

The software stroke limit value range is from 0° to 359.9999°.

(a) How to validate software stroke limits

To validate software stroke limits, set the lower limit value first and then the upper limit value clockwise.



1) To define travel range A, perform the following setting:

- Set the lower limit value to 315.00000°
- Set the upper limit value to 90.00000°

2) To define travel range B, perform the following setting:

- Set the lower limit value to 90.00000°
- Set the upper limit value to 315.00000°

(b) How to invalidate software stroke limits

To invalidate software stroke limits, define the lower software stroke limit value and the upper software stroke limit value as follows:

(Lower software stroke limit value) = (Upper software stroke limitvalue)

This stops software stroke limit settings from affecting the operation.

(3) Positioning control

This section describes the positioning control when the control unit is degrees.

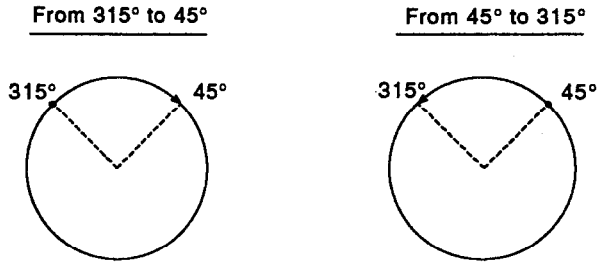
(a) In the absolute data method:

1) When the stroke limit is invalid

Positioning is performed taking the shortcut from the present value. (Shortcut positioning control)

Example

(1) Move clockwise to go from the present value of 315° to 45°.
(2) Move counterclockwise to go from the present value of 45° to 315°.

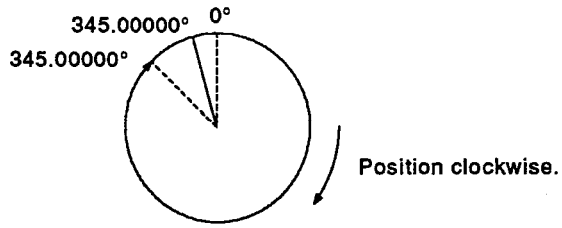


2) When the stroke limit is valid

The positioning direction (clockwise or counterclockwise) is determined by the software stroke limit settings.
Accordingly, shorter path selection may be impossible, depending on the settings.

Example

Move clockwise to go from the present value of 0° to 315° when the software stroke upper limit is 0° and the upper limit is 345°.



POINT

The positioning address range is from 0° to 359.99999°.
To perform positioning that completes a full revolution or more, use the incremental method.

(b) In the incremental method:

Positioning of a designated travel value is performed in a designated direction.

The plus or minus sign placed before each travel value determines the travel direction.

- Minus sign . . Clockwise
- Plus sign . . . Counterclockwise

POINT

The incremental method allows positioning of over 360°.
In order to do this, it is necessary to invalidate the software stroke limits by setting the lower and upper software stroke limit values to the same value (lower software stroke limit value = upper software stroke limit value).

3.4 Parameters

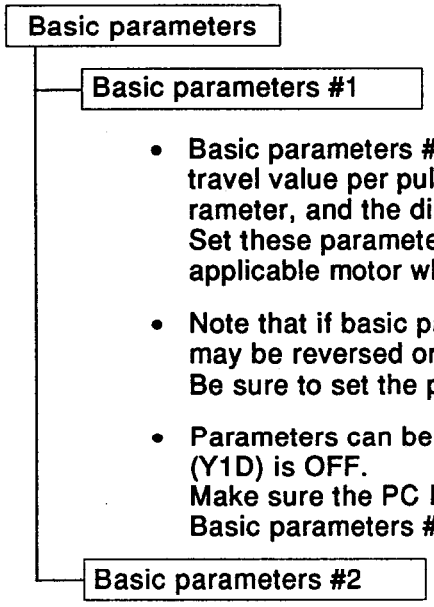
This section describes the parameters of the AD75.

The parameters of the AD75 are set for each axis.

Each parameter is set to its initial value (default) on shipment from the factory.
When memory "all clear" is executed, all parameters are set to defaults.

3.4.1 Basic parameters

The basic parameters are divided into basic parameters #1 and #2.



- Basic parameters #1 includes the control unit parameter, the travel value per pulse parameter, the pulse output mode parameter, and the direction of rotation parameter.
  Set these parameters to suit the mechanical system or applicable motor when booting the system.
- Note that if basic parameters #1 is set inappropriately, rotation may be reversed or no operation may be performed.
  Be sure to set the parameters to suit the system.
- Parameters can be changed only when the PC READY flag (Y1D) is OFF.
  Make sure the PC READY flag (Y1D) is OFF before changing Basic parameters #1.

- Basic parameters #2 are the speed control parameter and the acceleration/deceleration curve parameters.
  Set these parameters when starting up the system.
- The system will operate even if basic parameters #2 are set to the initial values.
- These parameters can be changed regardless of the ON/OFF status of the PC READY flag.

The basic parameters can be set in the following two ways:

- With a peripheral device in the edit mode
- With a sequence program

Table 3.6 List of Basic Parameters

Basic Parameter Group No.	Item / Unit		Setting Ranges				Initial Value
			mm	inch	degree	pulse	
1	Unit setting		0: mm	1: inch	2: degree	3: pulse	3
	Travel value per pulse (A)	Number of pulses per revolution (Ap)	1 to 65535 (pulse)				20000
		Travel value per revolution (Al)	0.1 to 6553.5 (μm)	0.00001 to 0.65535 (inch)	0.00001 to 0.65535 (degree)	1 to 65535 (pulse)	20000
		Unit magnification (Am)	• 1 • 10 • 100 • 1000				1
	Pulse output mode		• 0: PLS/SIGN mode • 1: CW/CCW mode • 2: A-phase/B-phase mode				0
	Direction of rotation		• 0: Present value increases when forward pulse is output • 1: Present value increases when reverse pulse is output				0
2	Speed control		0.01 to 6000000.00 (mm/min)	0.001 to 600000.00 (inch/min)	0.001 to 600000.000 (degree/min)	1 to 1000000 (pulse/s)	200000
	Acceleration time		1 to 65535 (ms)				1000
	Deceleration time		1 to 65535 (ms)				1000

REMARK

For details on the buffer memory address and setting range when setting basic parameters #1 and #2 with a sequence program. See Sections 3.6.2(1) and (2).

(1) Unit setting

(a) Sets the command unit for positioning control.

(b) Changing the command unit does not affect the parameters and the positioning data.
After changing the command unit, check if the parameters and the positioning data are within the setting ranges.
The AD75 will go into an error status upon detecting any data outside the setting range.

(2) Travel value per pulse

The travel value per pulse is the mechanical system value used for positioning control by the AD75. It sets the number of pulses for one revolution of the mechanical system motor, the travel value for one revolution of the motor, and the magnification of the travel value per pulse.

(a) Calculation of the travel value per pulse

1) Mechanical system specification

The following data are required for calculation of the travel value per pulse:

i) Feed screw pitch ..... P_B(mm/rev)

ii) Number of gear teeth of motor shaft ..... Z_1

iii) Number of gear teeth of feed screw shaft..... Z_2

Reduction ratio $\frac{Z_1}{Z_2} = \frac{1}{n}$ (Gear ratio)

iv) Number of pulses per revolution ..... P_f (pulse/rev)

2) For the above mechanical system specification, the number of pulses per revolution, the travel value per revolution, and the unit magnification are as follows:

i) Number of pulses per revolution = P_f

ii) Travel value per revolution = $P_B \times (1/n) \times 10^3$

iii) Unit magnification = M

3) The travel value per pulse is calculated using the following

$$A = \frac{\text{Travel value per revolution}}{\text{Number of pulses per revolution}} \times \text{Unit magnification}$$

$$= \frac{P_B \times (1/n) \times 10^3}{P_f} \times M(\mu m/pulse)$$

Calculation example

[Condition]

- PB = 5(mm/rev)
- $\frac{1}{n} = \frac{1}{1}$
- Pf = 12000(pulse/rev)
- M = 1

[Equation]

$$A = \frac{5 \times (1/1) \times 10^3}{12000}$$

$$= 0.4167(\mu m/pulse)$$

(b) Error compensation

A mechanical error may occur between the command travel value and the actual travel value when positioning is performed based on a travel value per pulse.
With the AD75, this error can be compensated for by changing the number of pulses per revolution, the travel value per revolution, and the unit magnification.
The following explains how to perform this error compensation.

1) Set command travel value L (mm) and perform positioning.

2) Measure actual travel value L' (mm) after positioning.

3) The number of pulses per revolution and the travel value per revolution for compensation are given by the following expressions based on the above command travel value and actual travel value as follows.

i) Travel value per pulse (mm/pulse) A for command travel value L (mm)

$$A = \frac{\text{Travel value per revolution } (A_L)}{\text{Number of pulses per revolution } (A_P)} \times \text{Unit magnification } (A_M)$$

ii) Required number of pulses P (pulse)

$$P = \frac{L}{A} \text{ (pulse)}$$

iii) Apparent travel value per pulse A' for actual travel value L' (mm)

$$A' = \frac{L'}{P} \text{ (mm/pulse)}$$

$$\therefore P = \frac{L'}{A'}$$

$$\therefore A' = A \frac{L'}{L}$$

$$= \frac{\text{Travel value per revolution } (A_L) \times \text{Unit magnification } (A_M)}{\text{Number of pulses per revolution } (A_P)} \times \frac{\text{Actual travel value } (L')}{\text{Command travel value } (L)}$$

$$= \frac{\text{Travel value per revolution } (A_L) \text{ for compensation } (A_L' = A_L \times L')}{\text{Number of pulses per revolution for compensation } (A_P' = A_P \times L)} \times \text{Unit magnification } (A_M)$$

Reduce the fraction A_L'/A_P' to obtain the desired compensation values.

Example

[Condition]
Travel value per revolution ..... 5000 (μm/rev)
Number of pulses per revolution ... 12000 (pulse/rev)
Unit magnification..... 1

[Result of positioning]
Command travel value..... 100 mm
Actual travel value ..... 101 mm

[Compensation value]

$$\frac{A_L'}{A_P'} = \frac{5 \times 10^3}{12000} \times \frac{101 \times 10^3}{100 \times 10^3} = \frac{5050}{12000} = \frac{101}{240}$$

Travel value per revolution: 101 (μm/rev)
Number of pulses per revolution: 240 (pulse/rev)

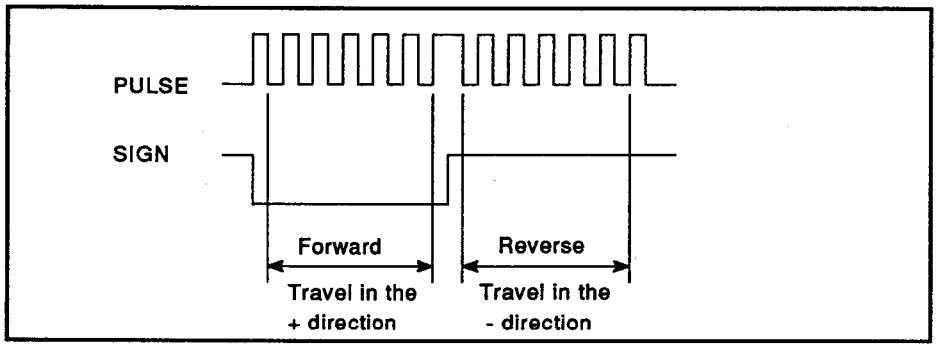
(3) Pulse output mode

This sets the pulse output mode compatible with the servo amplifier to be used.

(a) PLS/SIGN mode

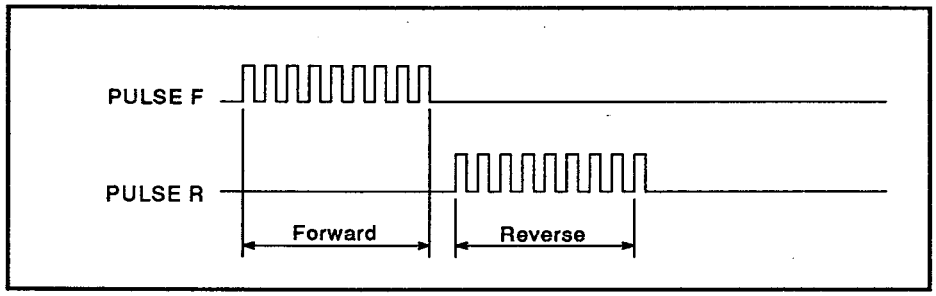
Controls forward/reverse rotation by turning on/off the direction sign (SIGN).

- When the direction sign is LOW: Forward rotation
- When the direction sign is HIGH: Reverse rotation



(b) CW/CCW mode

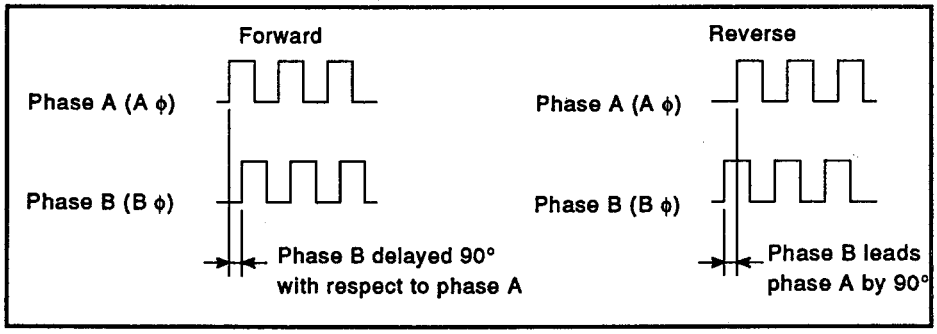
Outputs forward field pulses (PULSE F) in forward rotation.
Outputs reverse field pulses (PULSE R) in reverse rotation.



(c) A/B phase mode

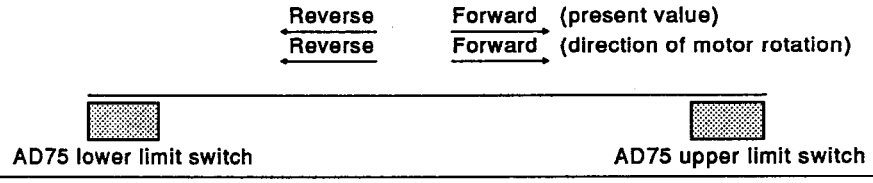
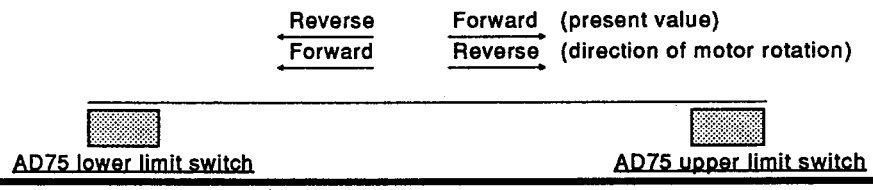
Controls forward/reverse rotation according to the phase difference between phase A (A ϕ) and phase B (B ϕ).

- When phase B is behind phase A by 90° : Forward rotation
- When phase B leads phase A by 90° : Reverse rotation



(4) Direction of rotation setting

This sets the direction of rotation (forward/reverse) when the present value is increasing.
With the AD75, a limit switch ON/OFF check is performed with the upper limit in the direction of increase of the present value and the lower limit in the direction of decrease.
Because of this the relationship between the actual direction of rotation of the motor and arrangement of the upper and lower limit switches is as shown below.

Direction of Rotation Setting	Motor Rotation and Arrangement of External Hardware Stroke Limit Switches
Forward	
Reverse	

(5) Speed limit value

(a) This sets the maximum speed for positioning operation (including home position return) and manual pulse generator operation.

(b) If the commanded speed and home position return speed in positioning operation are set greater than the speed limit value, they are restrained within the designated speed limit value.

(c) In manual pulse generator operation, if the speed expressed as the number of input pulses for the designated time exceeds the speed limit value, it is restrained within the speed limit value.
The input pulses exceeding the speed limit value are discarded, and the travel value is therefore reduced by the corresponding amount.

(d) If the target speed is greater than the speed limit value due to speed change or override in positioning operation, it is restrained within the speed limit value.
"Speed control flag" of the axis monitor is turned on while the speed is restrained within the speed limit value.

(e) When the speed is being restrained, the warning "over the speed limit value" is given.

(f) For linear interpolation and circular interpolation operation, the speed is restrained within the speed limit value of the reference axis.

1) For interpolation with axis 1 and axis 2, the speed is restrained within the speed limit value of axis 1.

2) For interpolation with axis 2 and axis 3, the speed is restrained within the speed limit value of axis 2.

3) For interpolation with axis 3 and axis 1, the speed is restrained within the speed limit value of axis 3.

(6) Acceleration time 0

(a) This sets the time taken to reach the speed limit value from speed 0 in positioning operation.

(7) Deceleration time 0

(a) This sets the time taken to reach speed 0 from the speed limit value in positioning operation.

REMARK

For the relationship between the speed limit value, acceleration time, and deceleration time. See Section 3.3.15.

3.4.2 Extended parameters

The extended parameters consist of extended parameters #1 and extended parameters #2.

Extended parameters

Extended parameters #1

- Extended parameters #1 are data such as the backlash compensation amount and software stroke limit.
  Set these parameters at system start-up using the AD75.
- These parameters can be reset only when the PC READY flag (Y1D) is OFF.
  Check that the PC READY flag is OFF before resetting extended parameters #1.

Extended parameters #2

- Extended parameters #2 are data allowing full use of the functions of the AD75.
  Set these parameters as required.
- Extended parameters# 2 can be used at their initial values.
- These parameters can be reset regardless of whether the PC READY flag is ON or OFF.

The following methods are used for setting the detailed parameters.

- Setting in the edit mode of a peripheral device
- Setting with a sequence program

Table 3.7 Extended Parameter List

Extended Parameter No.	Item / Unit	Setting Ranges				Initial Value
		mm	inch	degree	pulse	
1	Backlash compensation amount	0 to 6553.5 μm	0 to 0.65535 inch	0 to 0.65535 degree	0 to 65535 pulse	0
	Software upper stroke limit	-214748364.8 to 214748364.7 μm	-21474.83648 to 21474.83647 inch	0 to 359.99999 degree	-2147483648 to 2147483647 pulse	2147483647
	Software lower stroke limit	-214748364.8 to 214748364.7 μm	-21474.83648 to 21474.83647 inch	0 to 359.99999 degree	-2147483648 to 2147483647 pulse	-2147483648
	Software stroke limit selection	• 0: Multiply the feed present value by the software stroke limit. • 1: Multiply the machine feed value by the software stroke limit.				0
	Software stroke limit valid/invalid setting in manual pulse generator operation	• 0: The software stroke limit is invalid in JOG operation and manual pulse generator operation. • 1: The software stroke limit is valid in JOG operation and manual pulse generator operation.				0
	Command in-position	0.1 to 3276700.0 μm	0.00001 to 327.67000 inch	0.00001 to 327.67000 degree	1 to 32767 pulse	100
	Torque limit value setting	• 1 to 500 %				300
	M code ON signal output timing	• 0: WITH mode • 1: AFTER mode				0
	Speed change type	• 0: Standard speed switching mode • 1: Advance speed switching mode				0
	Interpolation speed designation	• 0: Resultant speed • 1: Reference axis speed				0
	Feed present value update request during speed control	• 0: Feed present value is not updated during speed control. • 1: Feed present value is updated during speed control.				0
	Manual pulse generator selection	• 0: Manual pulse generator operation not allowed. • 1: Manual pulse generator 1 used. • 2: Manual pulse generator 2 used. • 3: Manual pulse generator 3 used.				Axis 1: 1 Axis 2: 2 Axis 3: 3

Table 3.7 Extended Parameter List (continued)

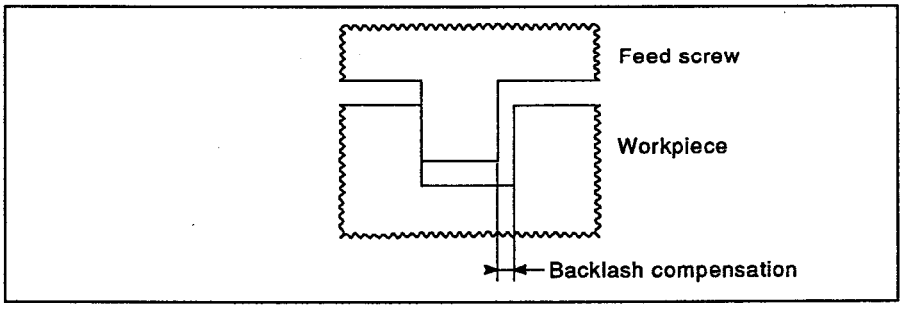
Extended Parameter No.	Item / Unit	Setting Ranges				Initial Value
		mm	inch	degree	pulse	
2	Acceleration time 1 to 3	1 to 65535 ms				1000
	Deceleration time 1 to 3	1 to 65535 ms				1000
	JOG speed limit value	0.01 to6000000.00 mm/min	0.001 to 600000.000 inch/min	0.001 to 600000.000 degree/min	1 to 1000000 pulse/s	20000
	JOG operation acceleration time selection	0 to 3				0
	JOG operation deceleration time selection	0 to 3				0
	Acceleration/deceleration processing selection	• 0: Trapezoidal acceleration/deceleration processing • 1: S pattern acceleration/deceleration processing				0
	S curve ratio	1 to 100 %				100
	Rapid stop deceleration time	1 to 65535 ms				1000
	Stop group 1 to 3 Rapid stop selection	• 0: Normal deceleration stop • 1: Rapid stop				0
	Positioning completed signal output time	0 to 65535 ms				300
	Allowable error range for circular interpolation	0 to 10000.0 μm	0 to 1.00000 inch	0 to 1.00000 degree	0 to 100000 pulse	100
	External positioning start selection	• 0: External positioning start • 1: External speed change request • 2: Skip request				0

REMARK

For details on the buffer memory address and setting range when setting extended parameters #1 and #2 with a sequence program, see Sections 3.6.2(3) and (4).

(1) Backlash compensation amount

(a) This sets the backlash amount (play) of the machine.



(b) Set the backlash compensation amount within the following range:

$$0 \leq \frac{\text{Backlash compensation amount}}{\text{Travel value per pulse}} \leq 255$$ (Decimal point fractions are rounded off.)

(c) When the backlash compensation amount is set, compensation by the backlash compensation amount is executed for each change of positioning direction at the start of positioning.

(2) Software stroke limit *1

(a) The software stroke limits are the upper/lower limit values for machine travel.

1) Upper software stroke limit: upper limit value of machine travel

2) Lower software stroke limit: lower limit value of machine travel

(b) If a command exceeding the setting range of the software stroke limits is given, the positioning corresponding to the command is not carried out.

(3) Software stroke limit selection

(a) This sets whether the software stroke limit is multiplied by the feed present value or the machine present value.

(4) Software stroke limit valid/invalid setting

(a) This sets whether the software stroke limits are valid or invalid in JOG or manual pulse generator operation.

(5) Command in-position range

(a) This sets the ON position [(positioning address) - (present value)] for the command in-position signal.

(6) Torque limit

(a) This sets the torque limit value.

(7) "M code ON" signal output timing

(a) This sets "M code ON" signal output to WITH mode or AFTER mode.

- WITH mode: Sets the M code and turns on the "M code ON" signal when positioning operation starts.
- AFTER mode: Sets the M code and turns on the "M code ON" signal when positioning operation ends.

REMARK

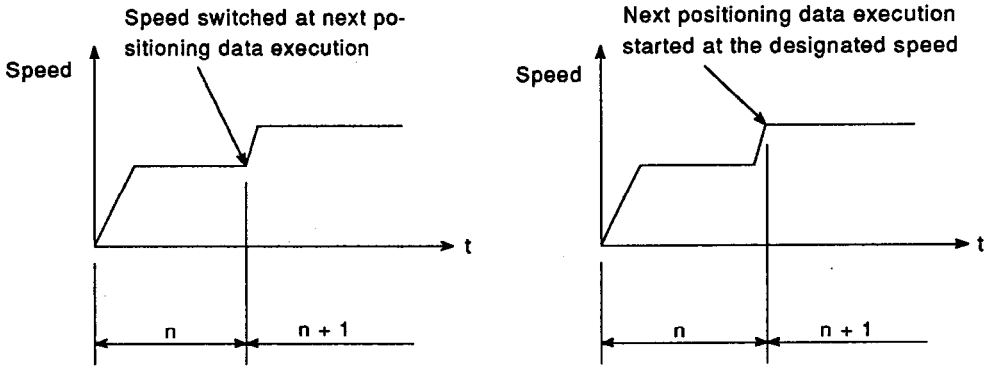
*1: For details on software stroke limits, see Section 3.3.11.

(8) Speed switching type

(a) This sets the speed switching mode to standard switching or advance switching.

- Advance switching: The speed is switched at the end of current positioning data.
- Standard switching: The speed is switched when next positioning data is executed.

(b) When positioning data No. n is executed, the speed is switched as follows:

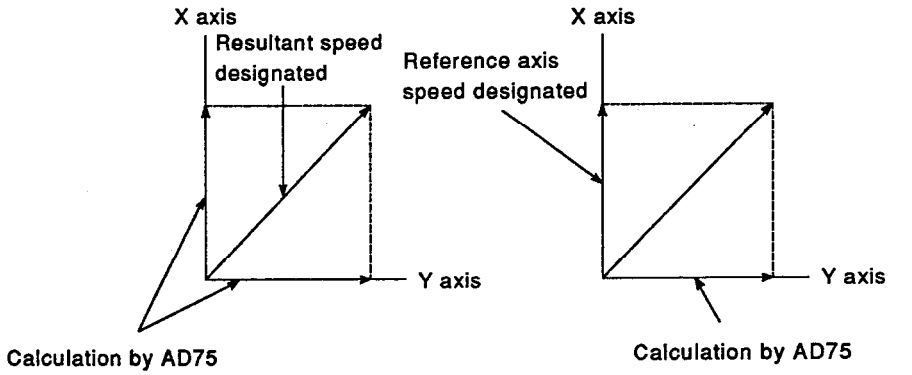


(a) Standard switching (b) Advanced switching

(9) Interpolation speed designation

(a) When the linear/circular interpolation is carried out, either the resultant speed or the reference axis speed is set.

- Resultant speed: Designates the travel speed for control. The speed of each axis is calculated by the AD75.
- Reference axis speed: Designates the axis speed set for the reference axis. The speed of the other axis used for interpolation is calculated by the AD75.



(a) Resultant speed designation (b) Reference axis designation (when X axis is the reference)

(b) In circular interpolation, or if different unit groups are designated for the interpolation axes, an error may occur and positioning according to the designated positioning data may not be carried out.

Interpolation Control	Speed Designation	Execution of Positioning	
		Matching of Unit Groups	Mismatching of Unit Groups
Linear interpolation	Resultant speed designation	Executed	Not executed
	Reference axis speed designation	Executed	Executed
Circular interpolation	Resultant speed designation	Executed	Not executed
	Reference axis speed designation	Not executed	Not executed

POINT

When the speed calculated by the AD75 exceeds the speed limit value during interpolation control, control is carried out without acknowledging the speed limit value.
When designating the interpolation speed, pay attention to the following:

- For the resultant speed, designate the value so that the speed of each axis does not exceed the speed limit value.
- For the reference axis speed, set the long axis as the reference axis. If the reference axis is set to the short axis, the speed on the long axis may exceed the speed limit value.

REMARK

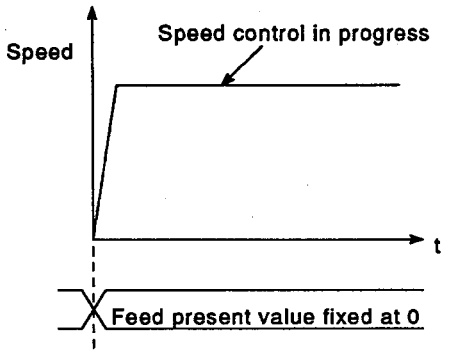
Unit groups are as follows:

- Group 1: mm, inches
- Group 2: degrees
- Group 3: pulses

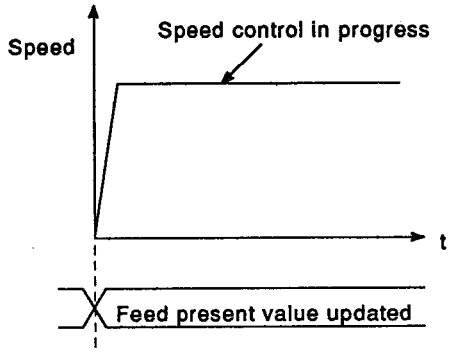
(10) Feed present value during speed control

(a) This parameter sets whether the feed present value is updated or not during speed control, and during speed control in speed/position switching control.

- When the feed present value is not updated:
  During speed control, the feed present value remains at 0.
  During speed/position switching control, the feed present value is updated on switching to position control.
- When the feed present value is updated:
  During speed control, the feed present value is updated from 0.



(a) Feed present value not updated



(b) Feed present value updated

(11) Manual pulse generator selection

(a) This sets which of the manual pulse generators connected to axes 1 to 3 is used for the control.

- For the manual pulse generator of axis 1:
  Manual pulse generator 1
- For the manual pulse generator of axis 2:
  Manual pulse generator 2
- For the manual pulse generator of axis 3:
  Manual pulse generator 3

(12) Acceleration times 1 to 3

(a) These set the time from speed 0 to the speed limit value for positioning operations.
Acceleration times 1 to 3 operate in the same way as acceleration time 0 of the basic parameters #2.
(For details of acceleration time 0, see Section 3.4.1.)

(13) Deceleration times 1 to 3

(a) These set the time from the speed limit value to speed 0 for positioning operations.
Deceleration times 1 to 3 operate in the same way as deceleration time 0 of the basic parameters #2.
(For details of deceleration time 0, see Section 3.4.1.)

(14) JOG speed limit value

(a) This sets the maximum speed in JOG operation.

(b) Set the JOG speed limit value to the speed limit value or lower.
If the JOG speed limit value exceeds the speed limit value, a setting range error occurs.

(c) When the JOG speed value is greater than the JOG speed limit, the actual speed is restrained within the JOG speed limit value.

- The "speed limit flag" of the axis monitor is turned ON while the speed is restrained within the JOG speed limit value.
- When the speed is being restrained, the warning "over JOG speed limit" is issued

(15) JOG operation acceleration time selection

(a) This sets which of the acceleration times 0 to 3 is used for the acceleration time in JOG operation.

- Acceleration time 0: Set in the basic parameters [See Section 3.4.1.]
- Acceleration time 1 to 3: Set in the extended parameters [See item (12).]

(16) JOG operation deceleration time selection

(a) This sets which of the deceleration times 0 to 3 is used for the deceleration time in JOG operation.

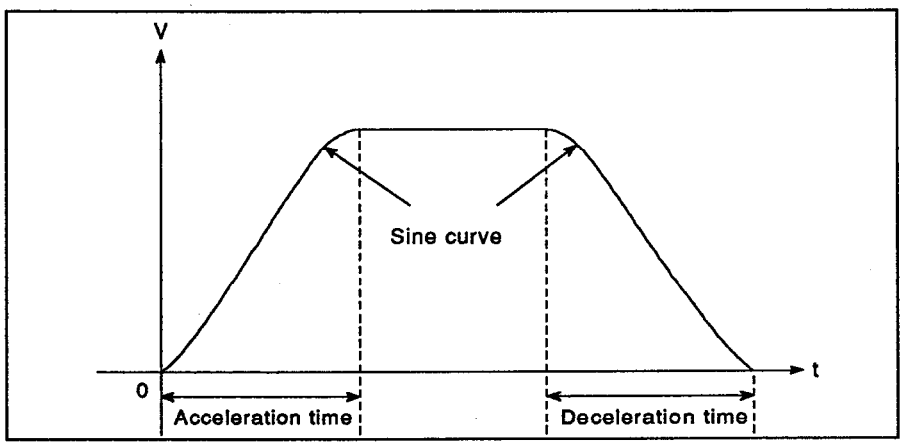
- Deceleration time 0: Set in the basic parameters [See Section 3.4.1.]
- Deceleration time 1 to 3: Set in the detailed parameters [See item (13).]

(17) Acceleration/deceleration processing selection

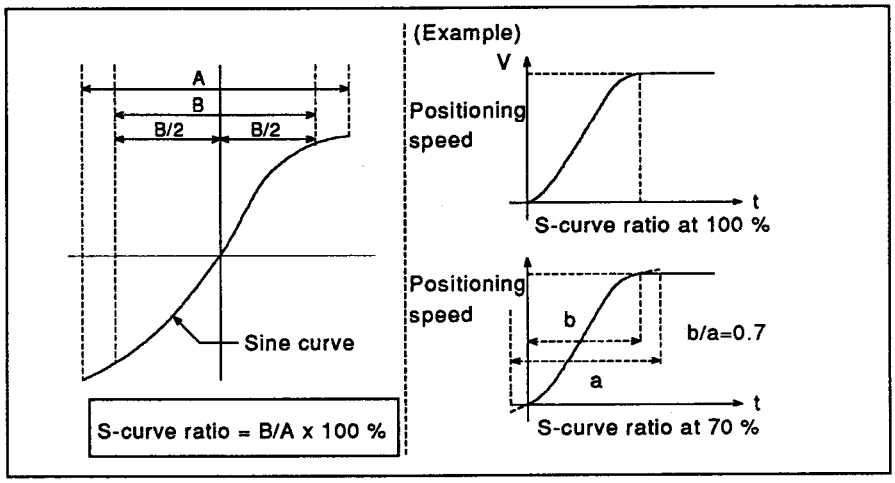
(a) This sets the acceleration/deceleration processing to trapezoidal processing or S pattern processing.

(18) S curve ratio

(a) This sets the S curve ratio when the S pattern acceleration/deceleration processing is carried out.
When an S curve ratio is set, the acceleration/deceleration processing is carried out smoothly.
The smaller the value of the S curve ratio, the closer the processing curve becomes to a straight line.
The S pattern acceleration/deceleration graph takes the form of a sine curve, as follows:



The S curve ratio sets which part of the sine curve is used to describe the acceleration/deceleration curve, as shown below.



(19) Rapid stop deceleration time

(a) This sets the time taken to reach speed 0 from the speed limit value when a rapid stop is executed.

(20) Rapid stop selection (Stop group 1 to 3)

(a) This selects whether a normal deceleration stop or rapid stop is executed when a stop cause occurs.
The setting is valid for positioning operation, home position return, and JOG operation.

(b) Once rapid stop has been selected, rapid stop deceleration is carried out when the stop signal of stop groups 1 to 3, corresponding to the following stop causes, is input.

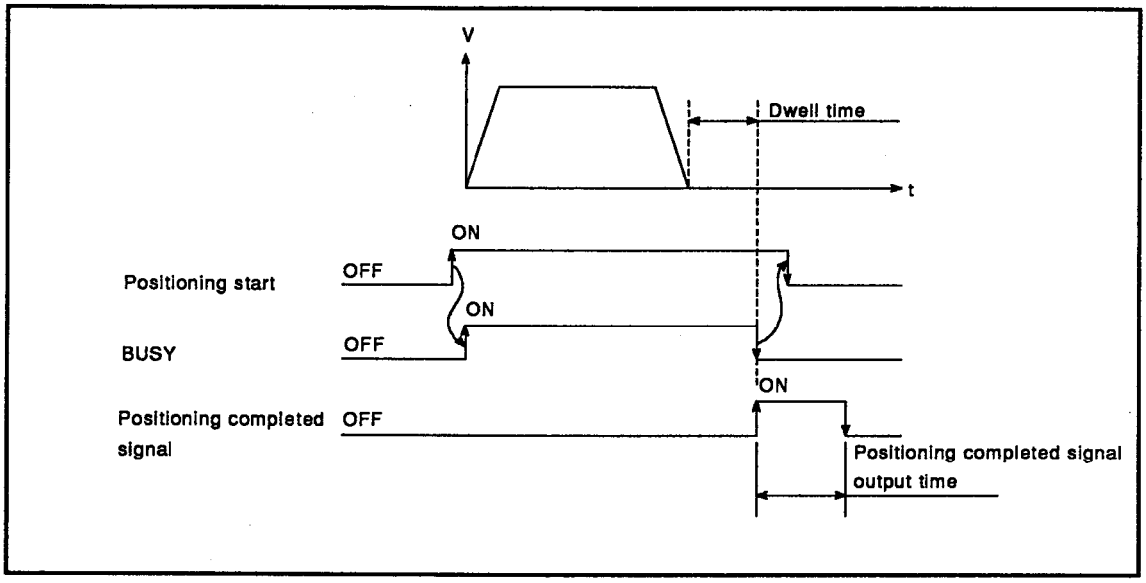
- Stop group 1: Stop due to hardware stroke limit
- Stop group 2: Stop due to software stroke limit
  Stopped by a peripheral device
  Stop due to PC READY OFF
- Stop group 3: Stop due to the external stop signal
  Stop due to stop signal from the programmable controller.
  Stop due to error occurrence
  (other than stop group 1 or 2)

(c) If the "rapid stop selection" setting is changed during rapid stop or deceleration, rapid /deceleration stop continues using the setting when the stop signal was input.

(d) In case of linear/circular interpolation, stop or rapid stop is carried out according to the rapid stop setting of the axis where the stop cause has occurred.

(21) Positioning completed signal output time

(a) This sets the time of output of the "positioning completed signal" from the AD75.



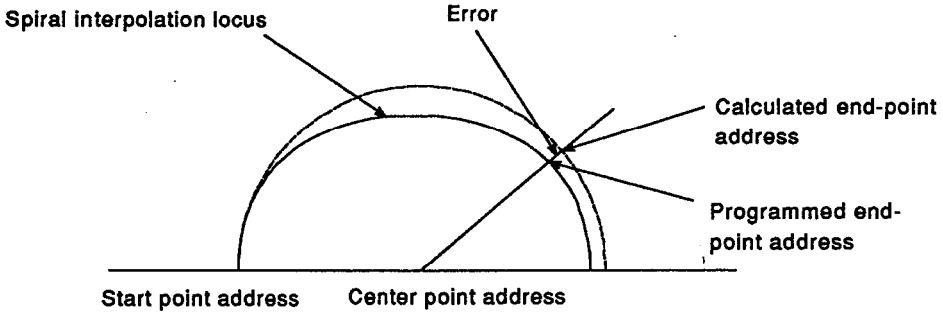
(22) Allowable error range for circular interpolation

(a) When the circular interpolation control is executed by center point designation, the circular locus calculated from the start address and center point address may deviate from the end address.

(b) The allowable error range for circular interpolation is set as the tolerance between the calculated circular locus and the end address. When the calculated circular arc error and the end address error are within the set allowable error range, circular interpolation is carried out at the end address while compensating for the error by spiral interpolation.

(c) The allowable error range for circular interpolation tolerance is set in the extended parameters #2 for the following axes:

- In case of circular interpolation with axes 1 and 2: Axis 1
- In case of circular interpolation with axes 2 and 3: Axis 2
- In case of circular interpolation with axes 3 and 1: Axis 3



(23) External start function selection

(a) This sets what function applies to the external start signal.

1) External positioning start setting

- The positioning operation is started by the external start signal input.

2) External speed change request setting

- The current positioning operation speed is changed by external start signal input.
- When the external speed is to be changed, set the speed change value as the "positioning operation speed change value" of the axis control data.

3) Skip request setting

- The current positioning operation is skipped by the external start signal input.

3.4.3 Basic parameters for home position return

Table 3.8 Basic Parameters for Home Position Return

Item \ Unit	Setting Ranges				Initial Value
	mm	inch	degree	pulse	
Home position return method	• 0:Near-zero point dog metho • 1:Stopper stop (1) (caused by time-out of the dwell timer) • 2:Stopper stop (2) (caused by the zero point signal when in contact with the stopper) • 3:Stopper stop (3) (method without near-zero point dog) • 4:Count method (1) (zero point signal is used) • 5:Count method (2) (zero point signal is not used)				0
Home position return direction	• 0:Forward direction (address increases) • 1:Reverse direction (address decreases)				0
Zero position address	-214748364.8 to 214748364.7 μm	-21474.83648 to 21474.83647 inch	0 to 359.99999 degree	2147483648 to 2147483647 pulse	0
Home position return speed	0.01 to 6000000.00 mm/min	0.001 to 600000.000 inch/min	0.001 to 600000.000 degree/min	1 to 1000000 pulse/s	1
Creep speed	0.01 to 6000000.00 mm/min	0.001 to 600000.000 inch/min	0.001 to 600000.000 degree/min	1 to 1000000 pulse/s	1
Home position return retry	• 0:home position return is not retried in accordance with the upper/lower limit switch. • 1:home position return is retried in accordance with the upper/lower limit switch.				0

(1) Home position return method

(a) Designates the home position return method when home position return is carried out.
(For details of the home position return method, see Section 3.3.8.)

(2) Home position return direction

(a) Designates the direction for home position return.
Allows travel in the designated direction on home position return start.

IMPORTANT

(1) Home position return is controlled according to the home position return direction and speed. When the near-zero point dog is turned ON, deceleration is started.
Caution: incorrect setting of the home position return direction may cause the drive system to overrun.

(2) If the home position return direction is not the same every time, use the home position return retry function.
For details of the home position return retry function, see Section 3.3.8.

REMARK

For details on the buffer memory address and setting range when setting home position return basic parameters with a sequence program, see Section 3.6.2 (5).

(3) Home position return address

(a) This address sets the present value of the home position upon completion of home position return.

(b) Upon normal completion of home position return, the home position return address set as the feed present value and machine feed value is stored.

(c) It is recommended the home position return address be set to either the upper or lower software stroke limit value.

(d) Even if the set value of the home position return address falls outside the software stroke limits, no setting error warning is given.
Check the value set for the software stroke limit in detailed parameters 1 and set the home position return address to a value within the software stroke limit.

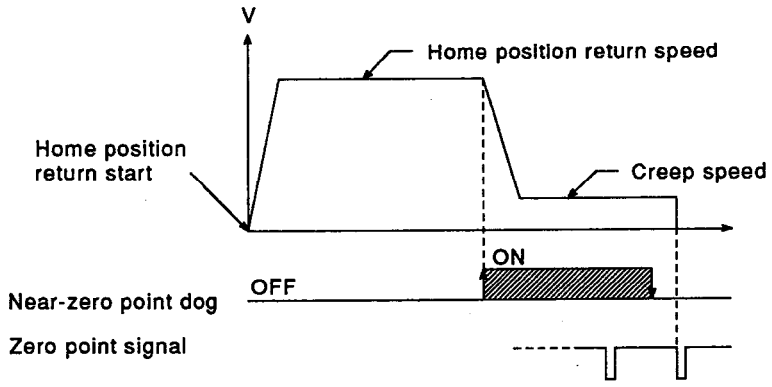
(4) Home position return speed

(a) This sets the home position return speed.

(b) Set a value within the speed limit value designated by basic parameter 2.

(5) Creep speed

(a) This sets the creep speed (low speed up until stopping after decelerating from the home position return speed) after near-zero point dog ON.



(b) Set a value within the home position return speed.

(c) The creep speed is related to the detection error in the case of home position return by a zero phase signal and to the size of the impact with the stopper in the case of home position return by stopper.
Therefore, take the error range and the size of impact into consideration when setting the creep speed.

(6) Home position return retry

(a) This sets whether or not a home position return is retried in accordance with the upper/lower limit switch

(b) Using the home position return retry function, the home position return operation can start wherever the machine position is designated.
For details of the home position return retry function, see Section 3.3.8.

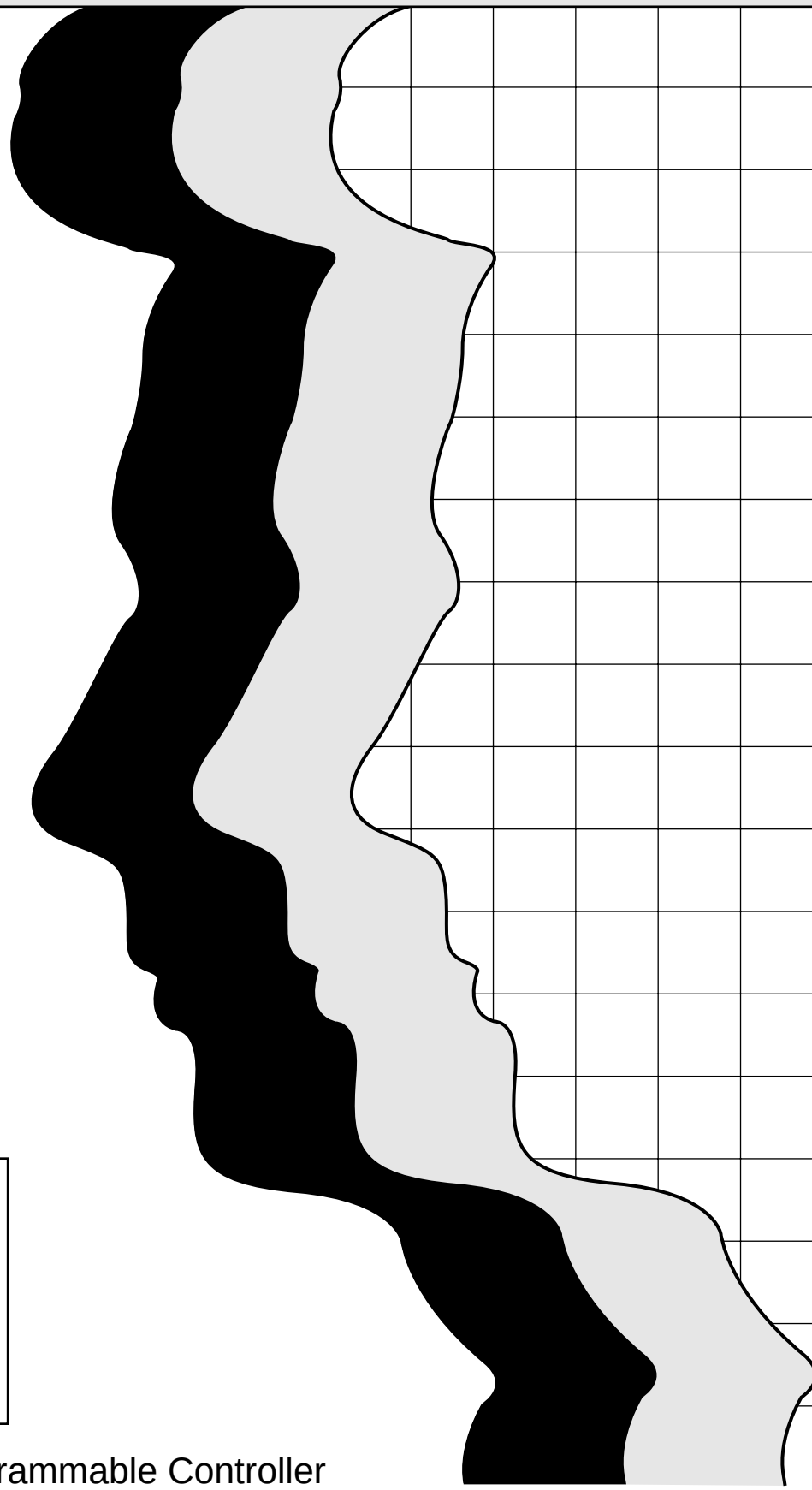
REMARK

In order to use the home position return retry function, input from the upper/lower limit switches to the AD75 is required.

MITSUBISHI

Positioning Module
type A1SD75P1/P2/P3, AD75P1/P2/P3

User's Manual



A
MELSEC

Mitsubishi Programmable Controller

Positioning Module
type A1SD75P1/P2/P3, AD75P1/P2/P3

User's Manual

MODEL	A1SD75/AD75-U-E
MODEL CODE	13J812
IB(NA)66589-B(9606)MEE	

MITSUBISHI ELECTRIC CORPORATION
HEAD OFFICE : MITSUBISHI DENKI BLDG MARUNOUCHI TOKYO 100-0005 TELEX : J24532 CABLE MELCO TOKYO
NAGOYA WORKS : 1-14 , YADA-MINAMI 5 , HIGASHI-KU, NAGOYA , JAPAN

When exported from Japan, this manual does not require application to the Ministry of International Trade and Industry for service transaction permission.

Specifications subject to change without notice.

IMPORTANT

(1) Design the configuration of a system to provide an external protective or safety inter locking circuit for the PCs.

(2) The components on the printed circuit boards will be damaged by static electricity, so avoid handling them directly. If it is necessary to handle them take the following precautions.

(a) Ground your body and the work bench.

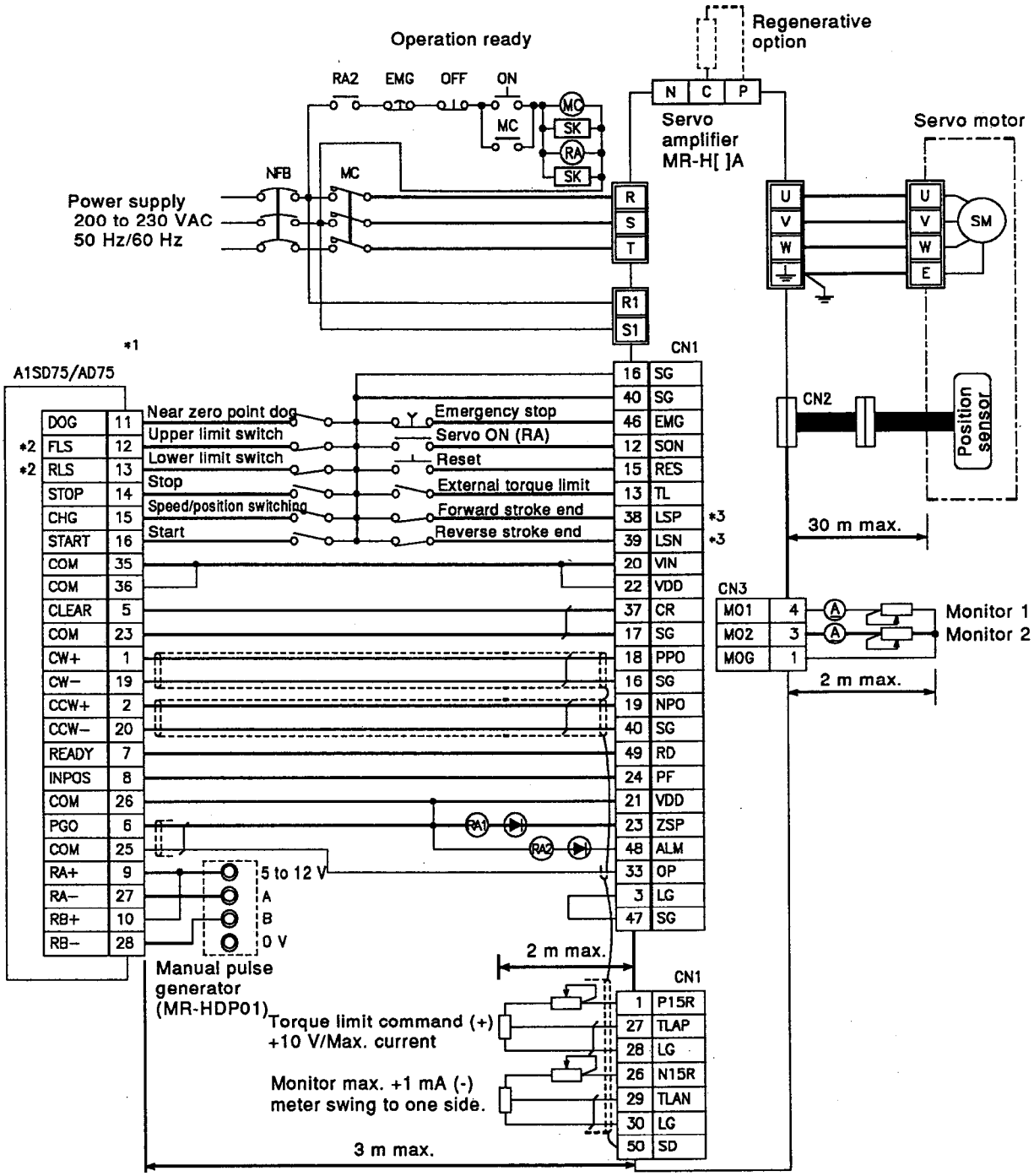
(b) Do not touch the conductive areas of the printed circuit board and its electrical parts with non-grounded tools, etc.

Under no circumstances will Mitsubishi Electric be liable or responsible for any consequential damage that may arise as a result of the installation or use of this equipment.

All examples and diagrams shown in this manual are intended only as an aid to understanding the text, not to guarantee operation. Mitsubishi Electric will accept no responsibility for actual use of the product based on these illustrative examples.

Owing to the very great variety in possible applications of this equipment, you must satisfy yourself as to its suitability for your specific application.

(2) When open collector is used



REMARKS

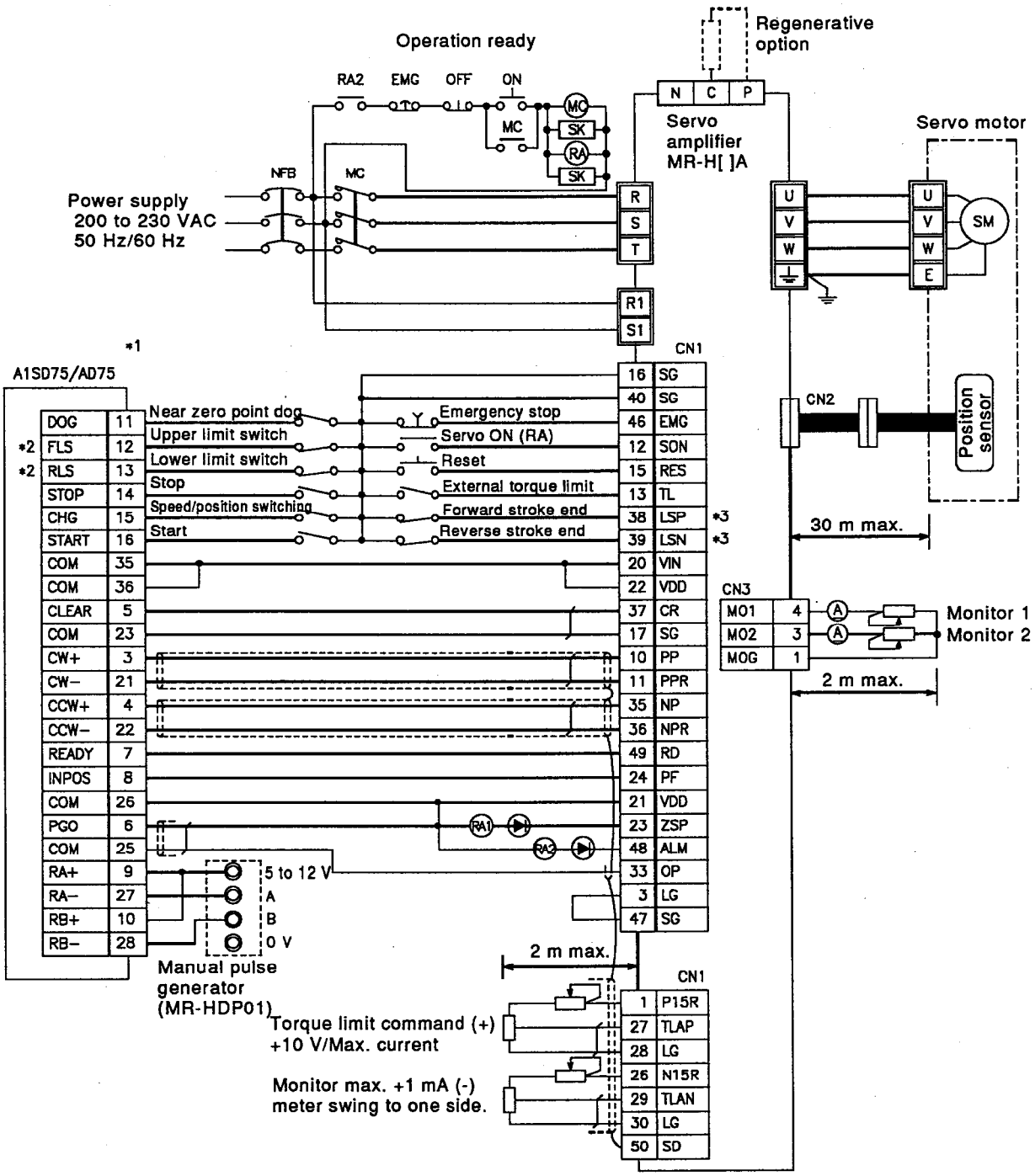
1) *1: The applications of the A1SD75/AD75 connector pin numbers are the same for axes 1 through 3.

2) *2: The A1SD75/AD75 upper limit switch (FLS) and lower limit switch (RLS) are used with the retry function during home position return. Set the limits inside those for the servo limit switches.

3) *3: These are the servo limit switches (for stopping).

6.2 Example of Connection Between A1SD75/AD75 and MR-H

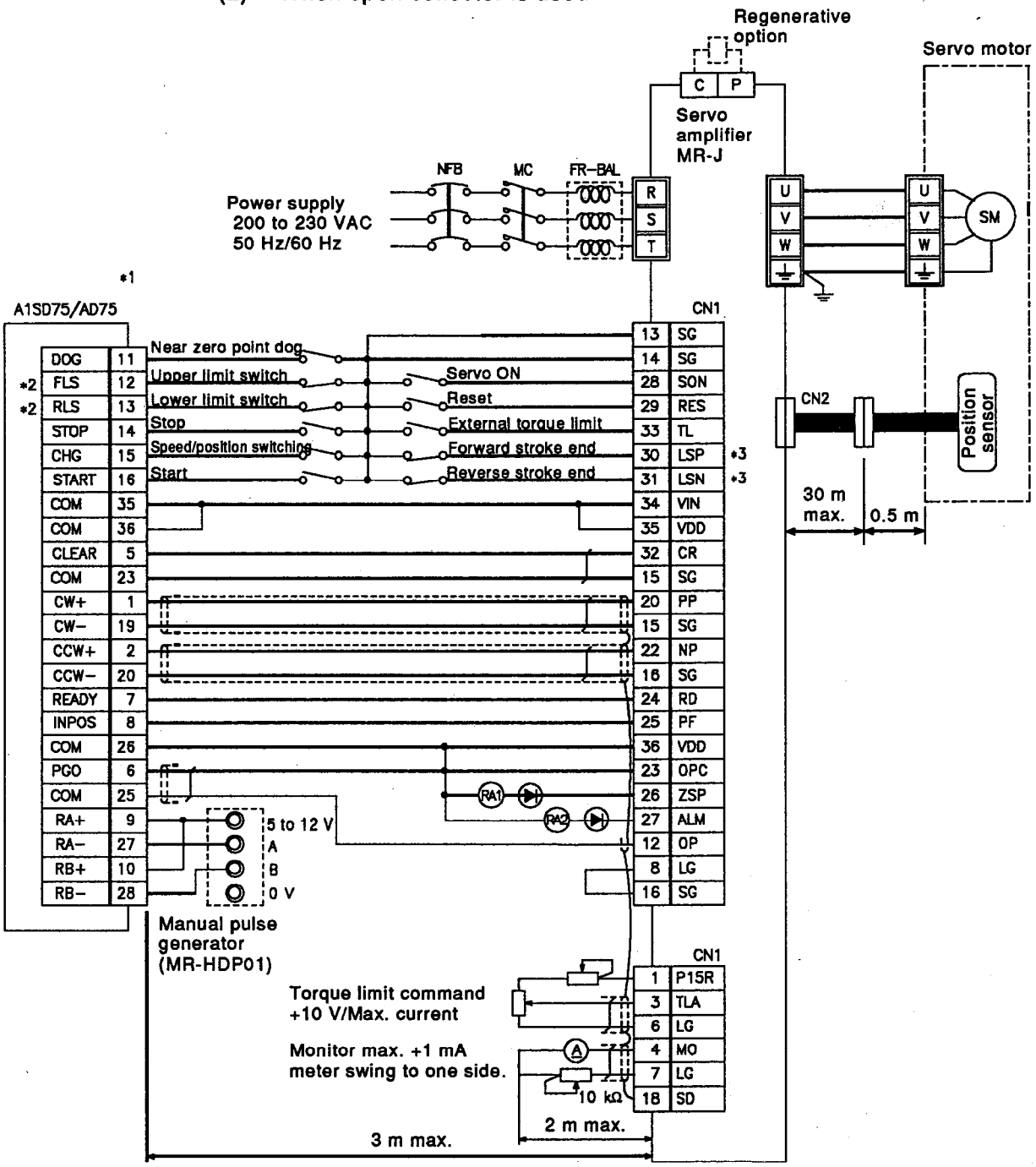
(1) When differential driver is used



REMARKS

1) *1: The applications of the A1SD75/AD75 connector pin numbers are the same for axes 1 through 3.
2) *2: The A1SD75/AD75 upper limit switch (FLS) and lower limit switch (RLS) are used with the retry function during home position return. Set the limits inside those for the servo limit switches.
3) *3: These are the servo limit switches (for stopping).

(2) When open collector is used



REMARKS

1) *1: The applications of the A1SD75/AD75 connector pin numbers are the same for axes 1 through 3.

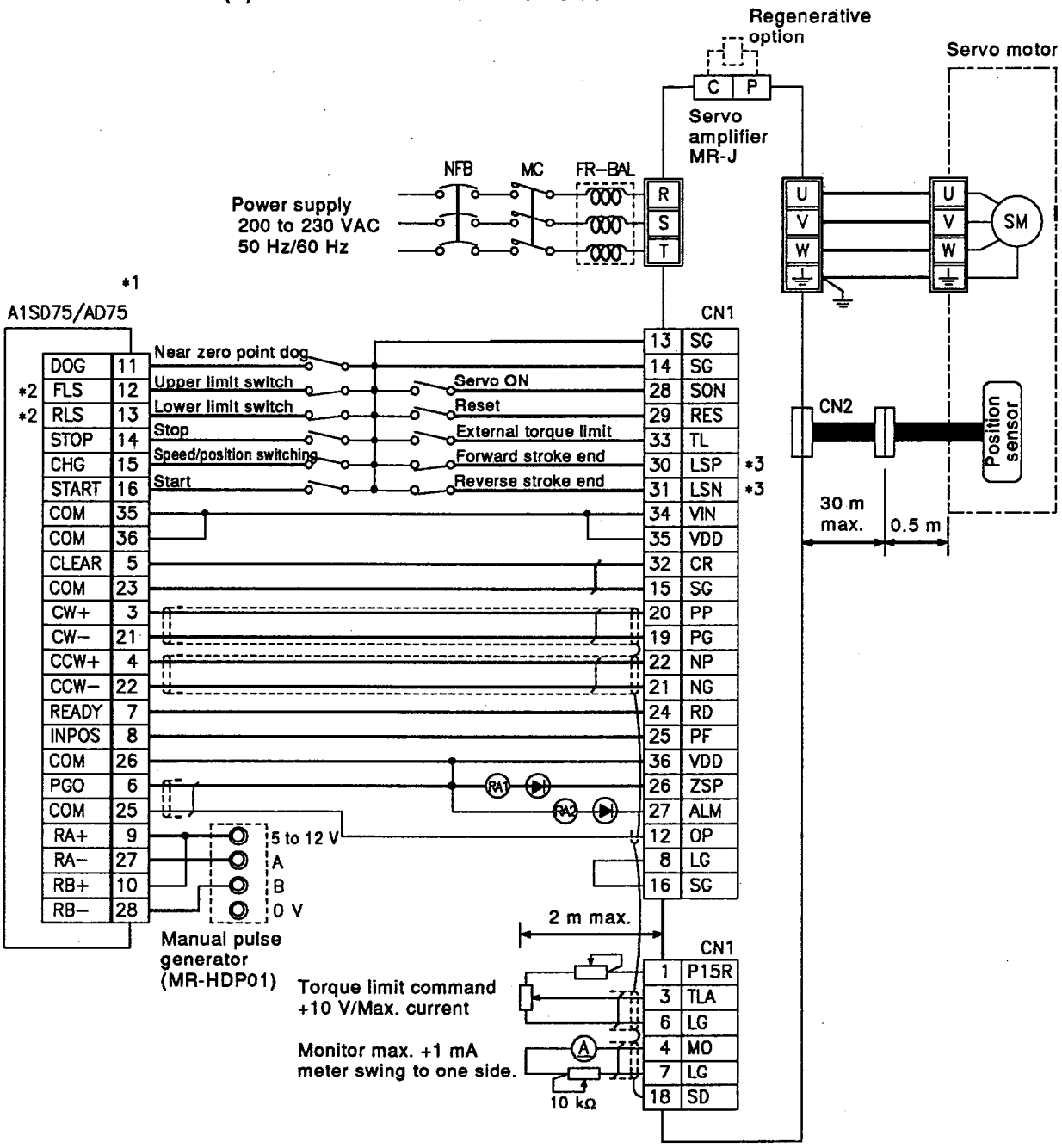
2) *2: The A1SD75/AD75 upper limit switch (FLS) and lower limit switch (RLS) are used with the retry function during home position return. Set the limits inside those for the servo limit switches.

3) *3: These are the servo limit switches (for stopping).

APPENDIX 6 EXAMPLE CONNECTION TO SERVO AMPLIFIER

6.1 Example of Connection Between A1SD75/AD75 and MR-J

(1) When differential driver is used



REMARKS

1) *1: The applications of the A1SD75/AD75 connector pin numbers are the same for axes 1 through 3.

2) *2: The A1SD75/AD75 upper limit switch (FLS) and lower limit switch (RLS) are used with the retry function during home position return. Set the limits inside those for the servo limit switches.

3) *3: These are the servo limit switches (for stopping).

(3) When connecting an AD75 and drive unit using the open collector system, wire as shown in Figure 5.2.

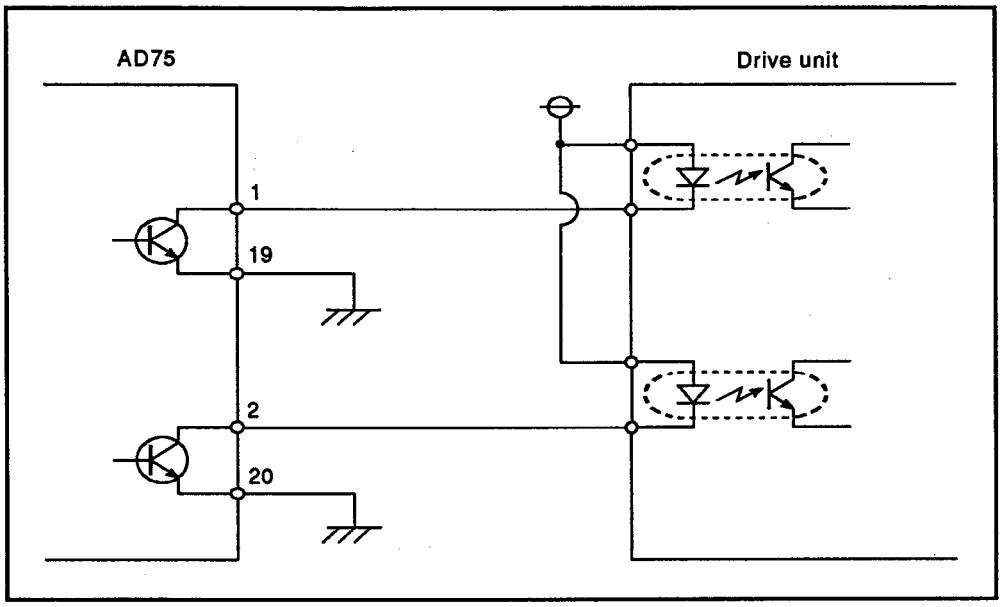


Fig. 5.2 Example Connection Using AD75 Open Collector

5.4 AD75 Command Pulse Logic

(1) It may not be possible to receive command pulses from some models of servo amplifier and stepping motor driver whose command pulse logic does not match that of the AD75.

(2) If the AD75 and servo amplifier/stepping motor driver have different logics, use differential driver output and cross the wiring as shown in Figure 5.3.
In this case the open collector system cannot be used.

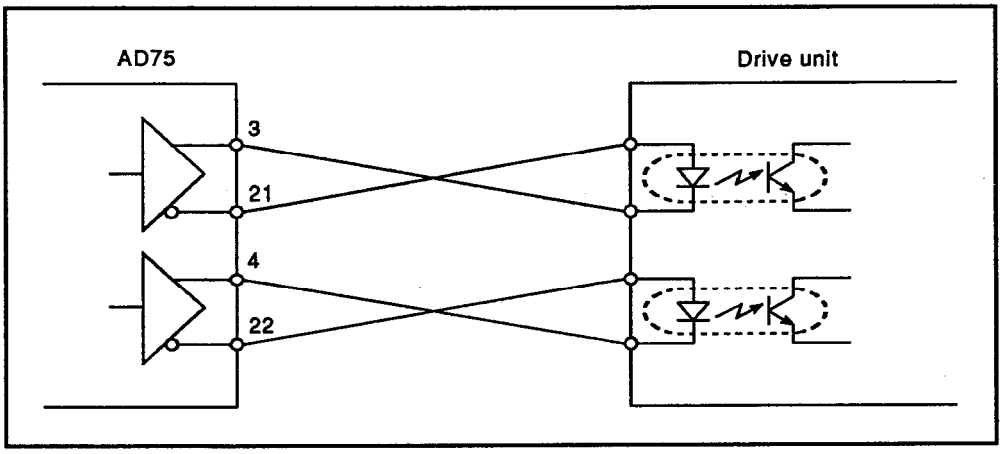


Fig. 5.3 Example of Wiring When the Command Pulse Logic Does Not Match

(3) When the AD75 is connected to an MR-J/MRH servo amplifier (made by Mitsubishi), the logic can be changed by changing the servo amplifier parameter settings, which means that the normal wiring shown in Figures 5.1 and 5.2 can be used.

5.2 Recommended Connection

(1) The AD75 has two systems of pulse train output: open collector system and differential driver system.

(2) In general, since the differential driver system is more resistant to noise than the open collector system, it is recommended to connect the AD75 to the drive unit using the differential driver system. However, since the load current of the AD75 differential driver is 20 mA, the differential driver must be used within the range of the specification in 5.1.

5.3 Method for Connection to Drive Unit

(1) Generally, the command pulse input section of the drive unit (servo amplifier, stepping motor driver) is open collector input with isolation by photocoupler.
Connection to a drive unit with open collector input is explained here.

(2) You are recommended to use the differential driver system for connection between the AD75 and drive unit in order to increase the noise margin. (See Figure 5.1.)

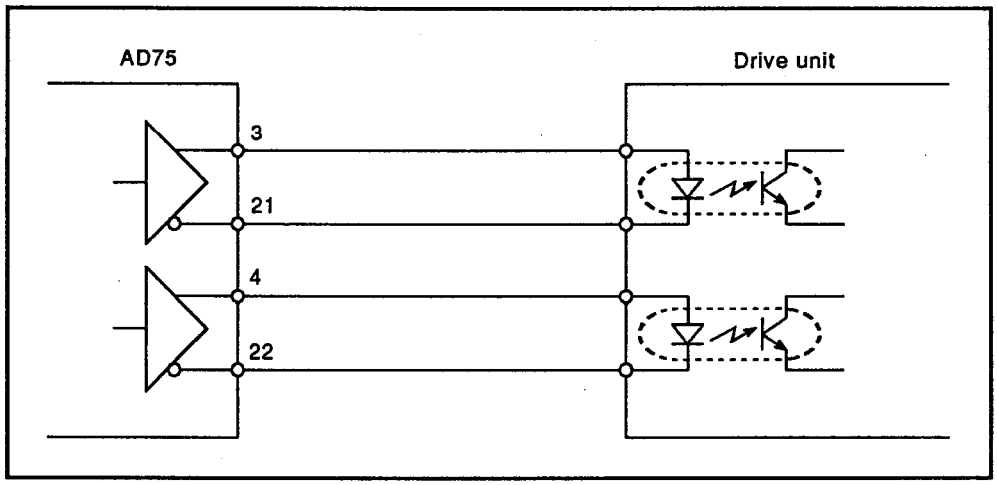


Fig. 5.1 Example Connection Using AD75 Differential Driver

APPENDIX 5 CONNECTION TO DRIVE UNITS

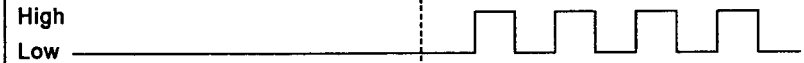
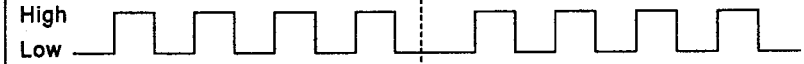
5.1 AD75 Pulse Output Specification

(1) With the AD75, positioning control is performed by outputting a pulse train to the drive unit.

(2) The AD75 has three types of pulse output: "SING pulse output", "CW/CCW pulse output", and "A phase/B phase pulse output": the type of pulse output used must be set in the basic parameters #1 of the AD75.

(3) The pulse output of the AD75 is shown in Table 5.1.

Table 5.1 AD75 Pulse Output

		Forward	Reverse
SING pulse output	PULSE		
	SING		
CW/CCW pulse output	PULSE F		
	PULSE R		
A phase/B phase pulse output	A phase		
	B phase		

REMARK

With the AD75 open collector system (transistor output), "High" and "Low" represent the following statuses.

- High: AD75 pulse output transistor OFF
- Low: AD75 pulse output transistor ON

APPENDIX 4 POINTS TO NOTE WHEN REPLACING A1SD71/AD71 WITH A1SD75P[ ]/AD75P[ ]

The points to note when replacing A1SD71/AD71 with A1SD75P[ ]/AD75P[ ] are explained here.
(For a functional comparison between A1SD75P[ ]/AD75P[ ] and A1S71/AD71, see Section 1.3.)

(1) The pulse output logic and connector pin layout are different for the A1SD75P[ ]/AD75P[ ].
For details on the pulse output logic, see APPENDIX 5.

Item	A1SD75P[ ]/AD75P[ ]	A1SD71/AD71
Connector used	Connector: 10136-3000VE Cover: 10336-56F0-008	Connector: FCN-361J040-AU Cover: FCN-360C040-B
Number of connectors	One per axis (Accessories for number of units corresponding to the number of axes)	One per unit
Connector pin layout	Pin numbers have the same application for each axis.	X-axis and Y-axis designated for pin numbers.
Zero point signal specification	Corresponds to 5 VDC/24 VDC [When using MR-H/MR-J, 24 VDC power is used. (See connection example.)]	Corresponds to 5 VDC/24 VDC
Manual pulse generator model name	MR-HDP01	OSM-01-2(C)

(2) In order to connect an A1SD75P[ ] and a peripheral device, a conversion cable (A1D75-C01H) is required.

APPENDIX 3 CONVERSION TABLE OF POSITIONING DATA NO. AND BUFFER MEMORY ADDRESS

Data No.	Positioning Identifier	M-Code	Dwell Time	Commanded Speed		Positioning Address		Arc Data		Data No.	Positioning Identifier	M-Code	Dwell Time	Commanded Speed		Positioning Address		Arc Data	
				Lower	Upper	Lower	Upper	Lower	Upper					Lower	Upper	Lower	Upper	Lower	Upper
1	1300	1301	1302	1304	1305	1306	1307	1308	1309	51	1800	1801	1802	1804	1805	1806	1807	1808	1809
2	1310	1311	1312	1314	1315	1316	1317	1318	1319	52	1810	1811	1812	1814	1815	1816	1817	1818	1819
3	1320	1321	1322	1324	1325	1326	1327	1328	1329	53	1820	1821	1822	1824	1825	1826	1827	1828	1829
4	1330	1331	1332	1334	1335	1336	1337	1338	1339	54	1830	1831	1832	1834	1835	1836	1837	1838	1839
5	1340	1341	1342	1344	1345	1346	1347	1348	1349	55	1840	1841	1842	1844	1845	1846	1847	1848	1849
6	1350	1351	1352	1354	1355	1356	1357	1358	1359	56	1850	1851	1852	1854	1855	1856	1857	1858	1859
7	1360	1361	1362	1364	1365	1366	1367	1368	1369	57	1860	1861	1862	1864	1865	1866	1867	1868	1869
8	1370	1371	1372	1374	1375	1376	1377	1378	1379	58	1870	1871	1872	1874	1875	1876	1877	1878	1879
9	1380	1381	1382	1384	1385	1386	1387	1388	1389	59	1880	1881	1882	1884	1885	1886	1887	1888	1889
10	1390	1391	1392	1394	1395	1396	1397	1398	1399	60	1890	1891	1892	1894	1895	1896	1897	1898	1899
11	1400	1401	1402	1404	1405	1406	1407	1408	1409	61	1900	1901	1902	1904	1905	1906	1907	1908	1909
12	1410	1411	1412	1414	1415	1416	1417	1418	1419	62	1910	1911	1912	1914	1915	1916	1917	1918	1919
13	1420	1421	1422	1424	1425	1426	1427	1428	1429	63	1920	1921	1922	1924	1925	1926	1927	1928	1929
14	1430	1431	1432	1434	1535	1436	1437	1438	1439	64	1930	1931	1932	1934	1935	1936	1937	1938	1939
15	1440	1441	1442	1444	1445	1446	1447	1448	1449	65	1940	1941	1942	1944	1945	1946	1947	1948	1949
16	1450	1451	1452	1454	1455	1456	1457	1458	1459	66	1950	1951	1952	1954	1955	1956	1957	1958	1959
17	1460	1461	1462	1464	1465	1466	1467	1468	1469	67	1960	1961	1962	1964	1965	1966	1967	1968	1969
18	1470	1471	1472	1474	1475	1476	1477	1478	1479	68	1970	1971	1972	1974	1975	1976	1977	1978	1979
19	1480	1481	1482	1484	1485	1486	1487	1488	1489	69	1980	1981	1982	1984	1985	1986	1987	1988	1989
20	1490	1491	1492	1494	1495	1496	1497	1498	1499	70	1990	1991	1992	1994	1995	1996	1997	1998	1999
21	1500	1501	1502	1504	1505	1506	1507	1508	1509	71	2000	2001	2002	2004	2005	2006	2007	2008	2009
22	1510	1511	1512	1514	1515	1516	1517	1518	1519	72	2010	2011	2012	2014	2015	2016	2017	2018	2019
23	1520	1521	1522	1524	1525	1526	1527	1528	1529	73	2020	2021	2022	2024	2025	2026	2027	2028	2029
24	1530	1531	1532	1534	1535	1536	1537	1538	1539	74	2030	2031	2032	2034	2035	2036	2037	2038	2039
25	1540	1541	1542	1544	1545	1546	1547	1548	1549	75	2040	2041	2042	2044	2045	2046	2047	2048	2049
26	1550	1551	1552	1554	1555	1556	1557	1558	1559	76	2050	2051	2052	2054	2055	2056	2057	2058	2059
27	1560	1561	1562	1564	1565	1566	1567	1568	1569	77	2060	2061	2062	2064	2065	2066	2067	2068	2069
28	1570	1571	1572	1574	1575	1576	1577	1578	1579	78	2070	2071	2072	2074	2075	2076	2077	2078	2079
29	1580	1581	1582	1584	1585	1586	1587	1588	1589	79	2080	2081	2082	2084	2085	2086	2087	2088	2089
30	1590	1591	1592	1594	1595	1596	1597	1598	1599	80	2090	2091	2092	2094	2095	2096	2097	2098	2099
31	1600	1601	1602	1604	1605	1606	1607	1608	1609	81	2100	2101	2102	2104	2105	2106	2107	2108	2109
32	1610	1611	1612	1614	1615	1616	1617	1618	1619	82	2110	2111	2112	2114	2115	2116	2117	2118	2119
33	1620	1621	1622	1624	1625	1626	1627	1628	1629	83	2120	2121	2122	2124	2125	2126	2127	2128	2129
34	1630	1631	1632	1634	1635	1636	1637	1638	1639	84	2130	2131	2132	2134	2135	2136	2137	2138	2139
35	1640	1641	1642	1644	1645	1646	1647	1648	1649	85	2140	2141	2142	2144	2145	2146	2147	2148	2149
36	1650	1651	1652	1654	1655	1656	1657	1658	1659	86	2150	2151	2152	2154	2155	2156	2157	2158	2159
37	1660	1661	1662	1664	1665	1666	1667	1668	1669	87	2160	2161	2162	2164	2165	2166	2167	2168	2169
38	1670	1671	1672	1674	1675	1676	1677	1678	1679	88	2170	2171	2172	2174	2175	2176	2177	2178	2179
39	1680	1681	1682	1684	1685	1686	1687	1688	1689	89	2180	2181	2182	2184	2185	2186	2187	2188	2189
40	1690	1691	1692	1694	1695	1696	1697	1698	1699	90	2190	2191	2192	2194	2195	2196	2197	2198	2199
41	1700	1701	1702	1704	1705	1706	1707	1708	1709	91	2200	2201	2202	2204	2205	2206	2207	2208	2209
42	1710	1711	1712	1714	1715	1716	1717	1718	1719	92	2210	2211	2212	2214	2215	2216	2217	2218	2219
43	1720	1721	1722	1724	1725	1726	1727	1728	1729	93	2220	2221	2222	2224	2225	2226	2227	2228	2229
44	1730	1731	1732	1734	1735	1736	1737	1738	1739	94	2230	2231	2232	2234	2235	2236	2237	2238	2239
45	1740	1741	1742	1744	1745	1746	1747	1748	1749	95	2240	2241	2242	2244	2245	2246	2247	2248	2249
46	1750	1751	1752	1754	1755	1756	1757	1758	1759	96	2250	2251	2252	2254	2255	2256	2257	2258	2259
47	1760	1761	1762	1764	1765	1766	1767	1768	1769	97	2260	2261	2262	2264	2265	2266	2267	2268	2269
48	1770	1771	1772	1774	1775	1776	1777	1778	1779	98	2270	2271	2272	2274	2275	2276	2277	2278	2279
49	1780	1781	1782	1784	1785	1786	1787	1788	1789	99	2280	2281	2282	2284	2285	2286	2287	2288	2289
50	1790	1791	1792	1794	1795	1796	1797	1798	1799	100	2290	2291	2292	2294	2295	2296	2297	2298	2299

2.3 Positioning Data [Data No. to]

Axis							
Data No.	Pattern	Control Method	Direction	Speed	Address	Dwell Time	M-Code
1							
2							
3							
4							
5							
6							
7							
8							
9							
0							
1							
2							
3							
4							
5							
6							
7							
8							
9							
0							
1							
2							
3							
4							
5							
6							
7							
8							
9							
0							
1							
2							
3							
4							
5							
6							
7							
8							
9							
0							
1							
2							
3							
4							
5							
6							
7							
8							
9							
0							
1							
2							
3							
4							
5							
6							
7							
8							
9							
0							

	Initial Value	Axis 1	Axis 2	Axis 3	Remark
	0				
	0				
	0				
	1				
	1				
	0				
	0				
	0				
	0				
	0				
	0				
	300				

(2) Home position return data

Item		Setting Range			
		mm	inch	degree	pulse
Home position return basic parameters	Home position return method	0: Near-zero point dog method 1: Stopper stop (1) (according to dwell timer time-out) 2: Stopper stop (2) (by zero point signal when the stopper is struck) 3: Stopper stop (3) (method without near-zero point dog) 4: Count method (1) (zero point signal used) 5: Count method (1) (zero point signal not used)			
	Home position return direction	0: Positive direction (direction in which address increases) 1: Negative direction (direction in which address decreases)			
	Home position address	-2147483648 to 2147483647 x 10^{-1} μm	-2147483648 to 2147483647 x 10^{-5} inch	0 to 35999999 x 10^{-5} degree	-2147483648 to 2147483647 pulse
	Home position return speed	1 to 600000000 x 10^{-2} mm/min	1 to 600000000 x 10^{-3} inch/min	1 to 600000000 x 10^{-3} degree/min	1 to 1000000 pulse/s
	Creep speed				
	Home position return retry	0: Home position return retry is not carried out by upper/lower limit switch. 1: Home position return retry is carried out by upper/lower limit switch.			
Home position return extended parameters	Home position return dwell time	0 to 65535 ms			
	Travel value after near-zero point dog	0 to 2147483647 x 10^{-1} μm	0 to 2147483647 x 10^{-5} inch	0 to 2147483647 x 10^{-5} degree	0 to 2147483647 pulse
	Home position return acceleration time selection	0 to 3			
	Home position return deceleration time selection				
	Home position shift amount	-2147483648 to 2147483647 x 10^{-1} μm	-2147483648 to 2147483647 x 10^{-5} inch	0 to 35999999 x 10^{-5} degree	-2147483648 to 2147483647 pulse
	Home position return torque limit value	0 to 300 %			

	Initial Value	Axis 1	Axis 2	Axis 3	Remark
	3				
	20000				
	20000				
	1				
	1				
	0				
	20000				
	1000				
	1000				
	0				
	2147483647				
	-214783648				
	0				
	0				
	100				
	300				
	0				
	0				
	0				
	0				
	Axis 1: 1 Axis 2: 2 Axis 3: 3				
	1000				
	1000				
	1000				
	1000				
	1000				
	1000				
	20000				
	0				
	0				
	0				
	100				
	1000				
	0				
	0				
	0				
	300				
	100				
	0				

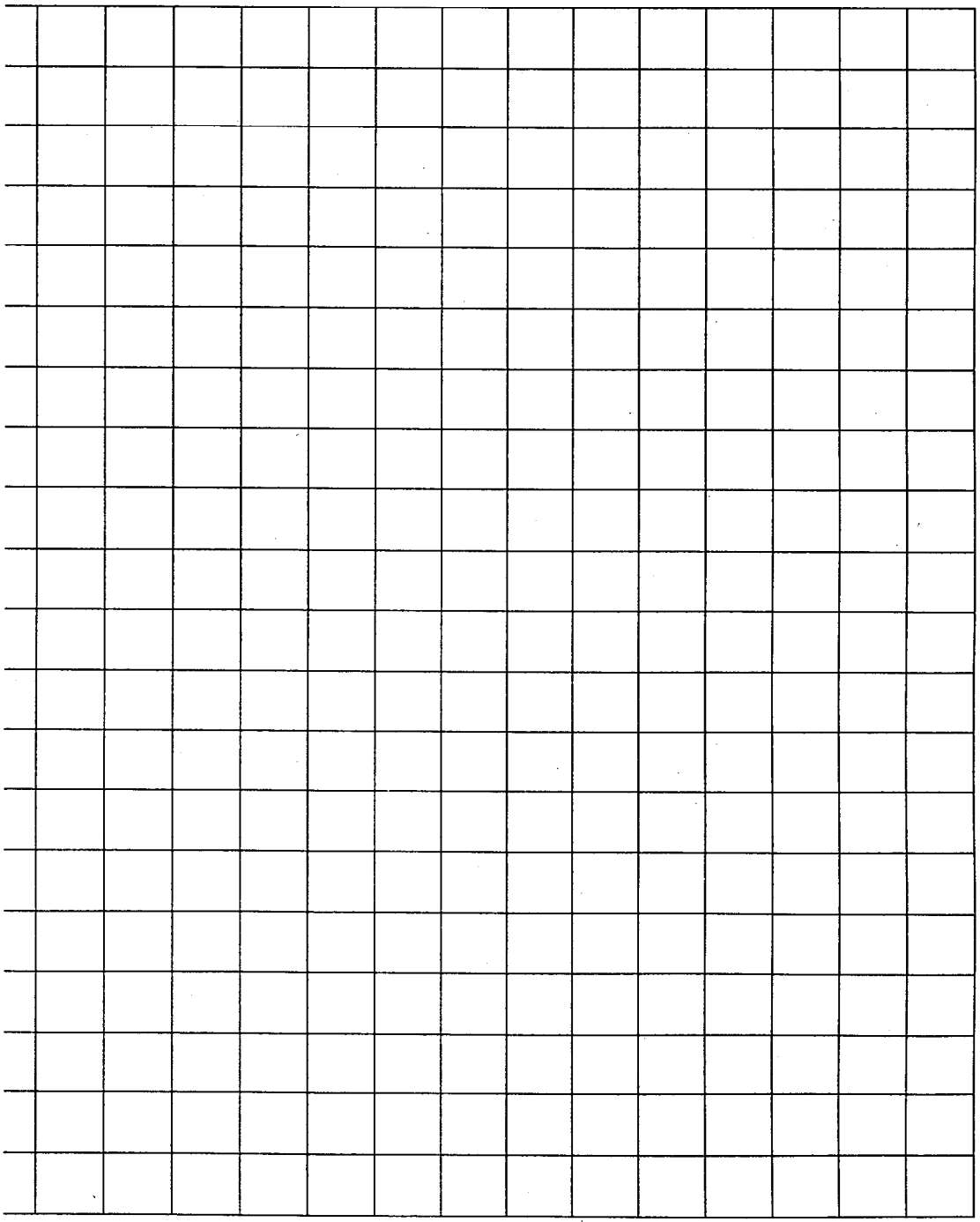
2.2 Parameter and Home Position Return Data

(1) Parameters

Item		Setting Range			
		mm	inch	degree	pulse
Basic parameter #1	Unit setting	0	1	2	3
	Number of pulses per revolution	1 to 65535 pulse			
	Travel value per revolution	1 to 65535 x 10^{-1} μm	1 to 65535 x 10^{-1} inch	1 to 65535 x 10^{-1} degree	1 to 65535 pulse
	Travel value magnification per pulse	1: x 1 10 : x 10 100: x 100 1000: x 1000			
	1 pulse output mode	0: PLS/SIG mode 1: CW/CCW mode 2: Phase A/phase B mode			
	Direction of rotation setting	0: Increase of present value by forward pulse output 1: Increase of present value by reverse pulse output			
Basic parameter #2	Speed limit value	1 to 600000000 x 10^{-2} mm/min	1 to 600000000 x 10^{-3} inch/min	1 to 600000000 x 10^{-3} degree/min	1 to 1000000 pulse/s
	Acceleration time	1 to 65535 ms			
	Deceleration time				
Extended parameter #1	Backlash compensation amount	0 to 65535 x 10^{-1} μm	0 to 65535 x 10^{-5} inch	0 to 65535 x 10^{-5} degree	0 to 65535 pulse
	Software stroke upper limit	-2147483648 to 2147483647 x 10^{-1} μm	-2147483648 to 2147483647 x 10^{-5} inch	0 to 35999999 x 10^{-5} degree	-2147483648 to 2147483647 pulse
	Software stroke lower limit				
	Software stroke limit selection	0: Software stroke limit is applied to the feed present value. 1: Software stroke limit is applied to the feed machine value.			
	Valid software stroke limit in JOG operation and manual pulse generator operation	0: Software stroke limit is invalid in JOG operation and manual pulse generator operation. 1: Software stroke limit is valid in JOG operation and manual pulse generator operation.			
	Command in-position range	1 to 32767000 x 10^{-1} μm	1 to 32767000 x 10^{-5} inch	1 to 32767000 x 10^{-5} degree	1 to 32767 pulse
	Torque limit value	1 to 500 %			
	M code ON signal output timing	0: WITH mode 1: AFTER mode			
	Speed switching mode speed change type	0: Standard speed switching mode 1: Advance speed switching mode			
	Interpolation speed designation method (interpolation mode)	0: Resultant speed 1: Reference axis speed			
	Feed present value update request command in speed control	0: Feed present value is not updated during speed control. 1: Feed present value is updated during speed control.			
	Manual pulse generator selection	0: Manual pulse generator operation is not acknowledged. 1: Manual pulse generator 1 is used. 2: Manual pulse generator 2 is used. 3: Manual pulse generator 3 is used.			
Extended parameter #2	Acceleration time 1	1 to 65535 ms			
	Acceleration time 2				
	Acceleration time 3				
	Deceleration time 1				
	Deceleration time 2				
	Deceleration time 3				
	JOG speed limit value	1 to 600000000 x 10^{-2} mm/min	1 to 600000000 x 10^{-3} inch/min	1 to 600000000 x 10^{-1} degree/min	1 to 1000000 pulse/s
	JOG operation acceleration time selection	0 to 3			
	JOG operation deceleration time selection				
	Acceleration/deceleration processing selection	0: Trapezoidal acceleration/deceleration processing 1: S pattern acceleration/deceleration processing			
	S curve ratio	1 to 100 %			
	Rapid stop deceleration time	1 to 65535 ms			
	Stop group 1 rapid stop selection	0: Normal deceleration stop 1: Rapid stop			
	Stop group 2 rapid stop selection				
	Stop group 3 rapid stop selection				
	Positioning completed signal output time	0 to 65535 ms			
	Allowable error range for circular interpolation	0 to 100000 x 10^{-1} μm	0 to 100000 x 10^{-5} inch	0 to 100000 x 10^{-5} degree	0 to 100000 pulse
	External start function selection	0: External start 1: External speed change 2: Skip request			

APPENDIX 2 FORMAT CHART

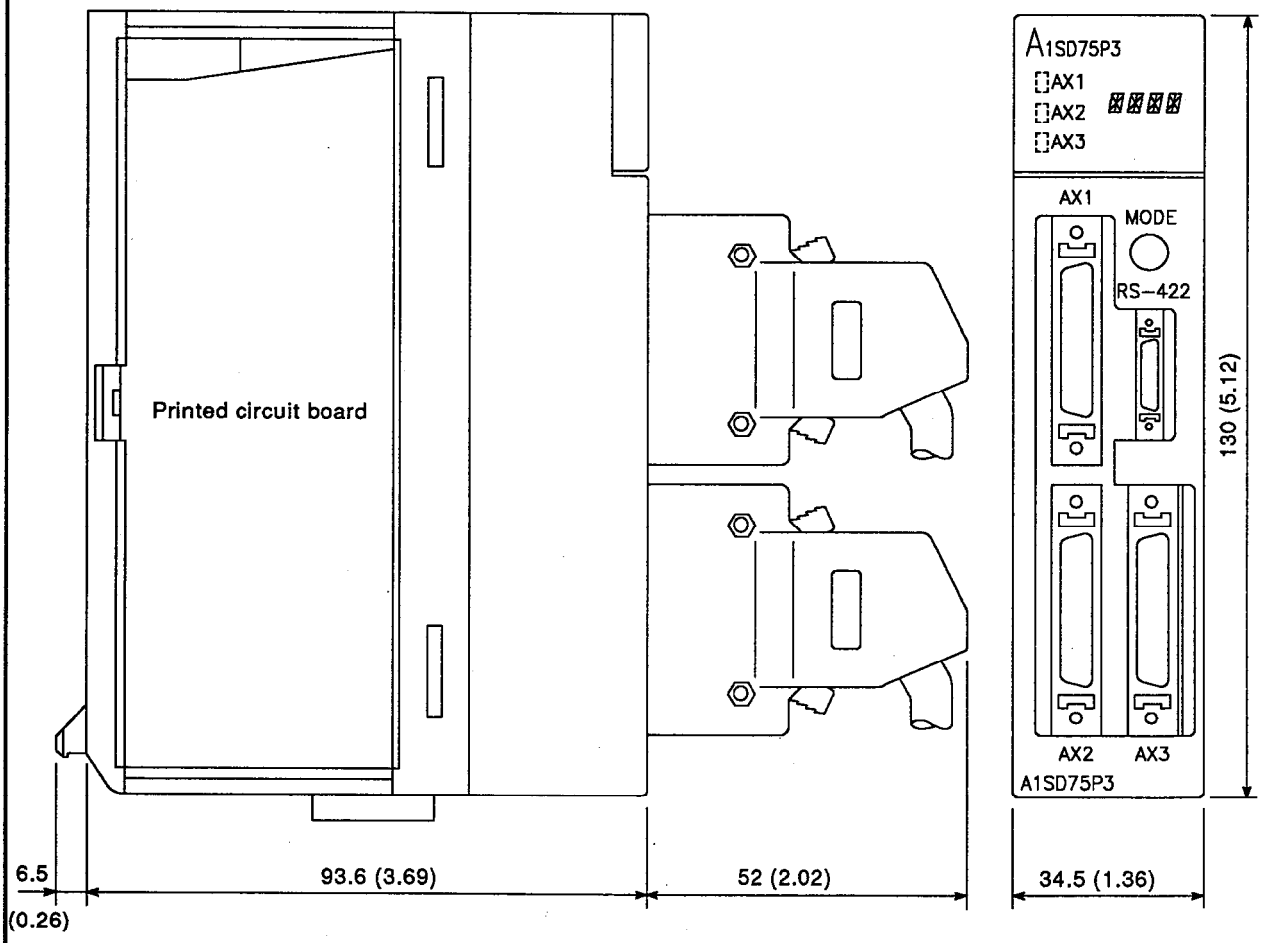
2.1 Positioning Module Operation Chart



Axis address
mm, inch, degree, pulse

Axis address
mm
inch
degree
pulse

(2) AISD75P1/P2/P3

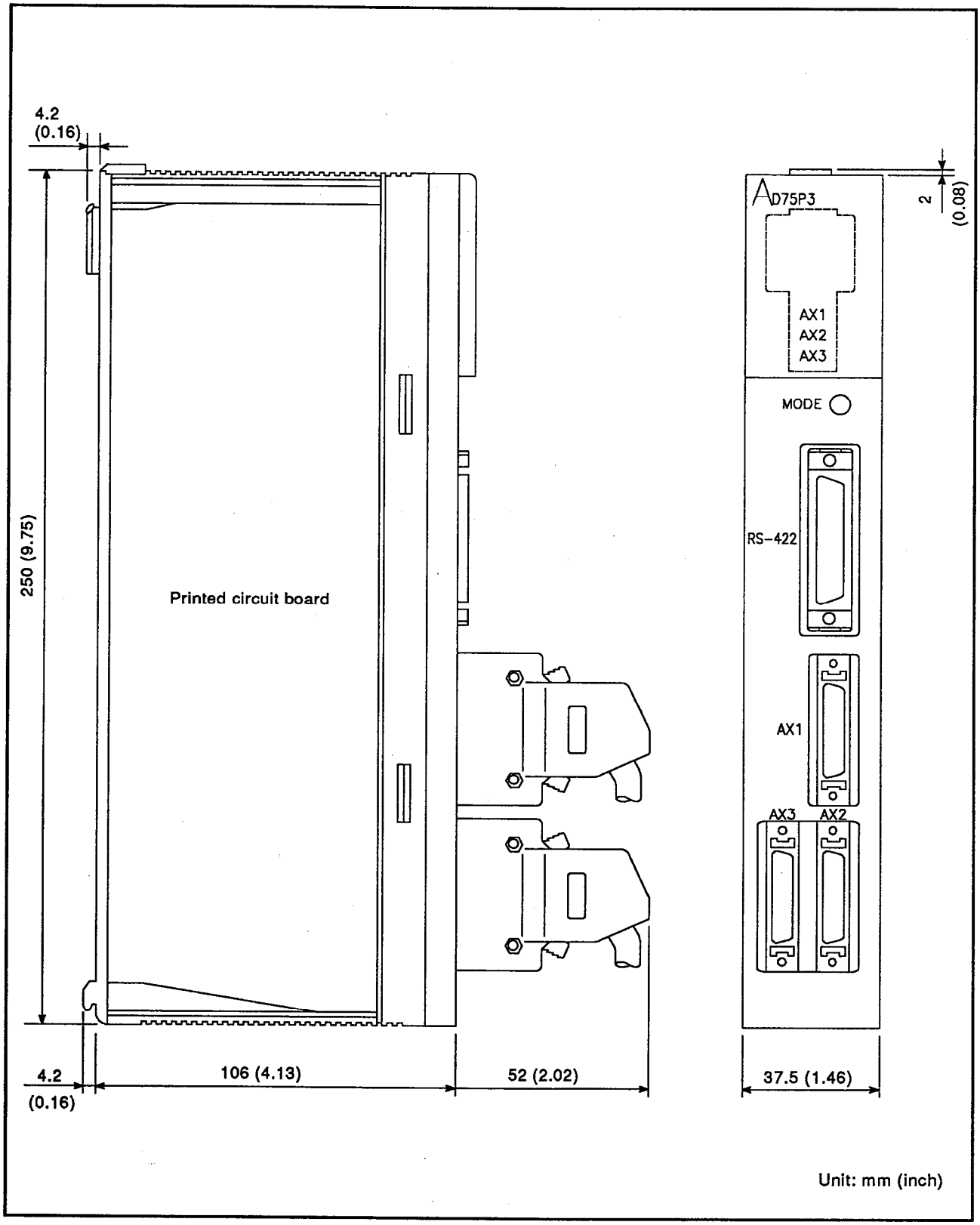


Unit: mm (inch)

APPENDICES

APPENDIX 1 EXTERNAL DIMENSIONS

(1) AD75P1/P2/P3



13.3 Error Start History

If an error occurs at operation start, the contents of the start history area (address:541) in the buffer memory are copied to the error start history area (address: 543 to 622).

The contents of the error start history area are deleted when the AD75 power is turned OFF. ("0" is stored in the error start history when the AD75 power is turned ON.)

A maximum of 16 records can be stored in the error start history area when the AD75 power is turned ON.

The error start history can be monitored at a peripheral device.

For details on operation of the peripheral device, refer to the following manual:

- SW0IVD-AD75P Type Positioning Module Software Package Operating Manual (IB-66596)

<Example of Display at Peripheral Device>

No.	Ax.	Start	Mode	Time	Res.
1	1	Ext.	100	21:34:56.7	OK
2	2	PC	M/P	21:43:12.3	OK
3	2	PC	JOG	21:43:34.4	201
4	1	Ext.	Re100	21:43:54.8	OK
5	3	Prog	101	10:18:03.7	201

Error Code	Error Name	Detection Timing	Operation Status when Error Occurs	Corrective Action
502	Low remaining decentralized speed	In remaining decentralized mode for positioning control	Warning for applicable axis	No processing
503	M code ON signal ON	When positioning data executed	Execution of positioning data continues.	Correct the ON/OFF timing of the M code OFF signal.
505	No operation end setting	When the 50th point is updated	Operation ends.	Set the operation end at the 50th point.
506	FOR to NEXT nesting	At FOR command analysis	Operation continues.	Create a configuration with only one level of FOR to NEXT nesting.
508	Speed-position switch during acceleration	When speed-position switching signal turned ON		Do not turn ON the speed-position switching signal during acceleration.
509	Insufficient remaining distance	At speed change	Speed change is carried out. (Except for operation pattern 11)	Carry out the speed change with a feed speed close to the speed change value.
512	External start function incorrect	When external signal turned ON	Nothing happens when the external start signal comes ON.	Set the parameter within the setting range.
513	Insufficient travel value	In positioning operation	After reaching the positioning address, the machine stops.	Correct the positioning data and parameter.
	Travel value change register in speed/positioning control out of range	When speed-position switching signal turned ON	Positioning control is carried without using the change register.	Set the travel value within the setting range.
514	Commanded speed out of range	On analysis	The commanded speed is clamped at the speed limit value.	Set a commanded speed within the setting range.
900	<System control data> Clock data setting incorrect	At clock data setting		Reset with the correct clock data.

13.2 Warning List

The following shows the description and corrective action for warning.

Error Code	Error Name	Detection Timing	Operation Status when Error Occurs	Corrective Action
000	Normal status	——	——	——
100	<General> Start during operation	When start request is turned ON	Operation continues.	Correct the start request ON timing.
101	Present value change when BUSY	When present value change request issued (test mode)	The present value change request is not acknowledged.	Do not change the present value while the axis is in operation.
102	Deviation counter clear request	When deviation counter clear request issued	Deviation counter clear request is ignored	Do not clear the deviation counter while the axis is in motion.
104	Restart disabled	When restart command request issued	Operation continues.	Correct the start request ON timing.
105	Applicable axis incorrect	At writing/reading	Reference axis warning	Set a correct value and issue the writing/reading request again.
106	Positioning data No. incorrect		Applicable axis warning	
107	Writing pattern incorrect			
108	Flash writing incorrect	At writing/reading	Warning for axis 1	No processing
109	Write during BUSY	When writing request issued	Warning for applicable axis	Issue the writing/reading request while the axis is not BUSY.
111	PC READY is ON	When F-ROM writing executed	Warning for axis 1	None (response is made to the request when Y1D is turned OFF.)
112	Override value incorrect	On analysis	• If the set value is 0, 100 is used for control. • If the set value is 301 or more, 300 is used for control.	Set a value within the setting range.
113	Torque change value out of range	During operation	Torque change is not carried out.	
300	<JOG> Speed change during deceleration	At JOG operation speed change	Speed change is not carried out.	Do not change the JOG operation speed during deceleration by turning off the JOG start signal.
301	JOG speed limit value	At JOG operation speed change	• JOG operation is carried out at the JOG speed limit value if the limit value is exceeded. • The speed limit in progress flag is ON while the speed is limited by the JOG speed limit value.	Set a value within the setting range.
401	<Manual pulse generator> Out of manual pulse generator input magnification range	At manual pulse generator input magnification change	If the set input magnification is 101 or more, the value actually used is set as 100 by clamping. When the set value is "0", the value actually used is set as "1" by clamping.	Set the manual pulse generator 1 pulse input magnification within the setting range.
402	Manual pulse generator selection setting 0	At operation start	Operation does not start	• Turn off the manual pulse generator operation enable flag. • Set the manual pulse generator selection value to 1, 2, or 3. • Turn the PC READY signal from OFF to ON.
500	<Positioning operation> Deceleration/stop speed change	At speed change	Speed change is not carried out.	Do not execute a speed change during deceleration due to a stop command, while operation is stopped, or during automatic deceleration in positioning.

Error Code	Error Name	Detection Timing	Operation Status when Error Occurs	Corrective Action
962	Rapid stop deceleration time incorrect	At data analysis	At the start: Operation does not start During operation: Deceleration stop	Set the value within the setting range.
963	Stop group 1 selection error			
964	Stop group 2 selection error			
965	Stop group 3 selection error			
966	Out of allowable range for circular interpolation			
967	External start selection error			
980	<Error history> (Home position return basic parameters) Home position return method error			
981	Home position return direction error			
982	Home position address setting error			
983	Home position return speed error			
984	Creep speed error			
985	Home position return retry error			
991	<Error history> (Home position return detail parameter) Home position return torque control limit	When PC READY is switched from OFF to ON	The AD75 READY (X0) is not turned OFF.	Set the value within the setting range.
992	Near-zero point dog travel value error			
993	Home position acceleration selection error			
994	Home position deceleration selection error			
999	Flash ROM sum check error	On writing to flash ROM	The AD75 READY (X0) is not turned OFF.	Write to flash ROM again. If the same error occurs again, replace the module.

Error Code	Error Name	Detection Timing	Operation Status when Error Occurs	Corrective Action
921	<Error history> (Extended parameter #1) S/W stroke upper limit	When PC READY is switched from OFF to ON	The AD75 READY (X0) is not turned OFF.	Set the value within the setting range.
922	S/W stroke lower limit			
923	S/W stroke limit selection			
924	S/W stroke limit valid			
925	Torque limit setting value incorrect			
926	Command in-position range			
927	M code ON timing error			
928	Speed switching mode error			
929	Interpolation speed designation method			
930	Present value update request error			
931	Manual pulse generator selection error			
933	(Spare)	——	——	——
934	(Spare)			
935	(Spare)	——	——	——
936	(Spare)			
937	(Spare)			
938	Backlash compensation amount error 2	When PC READY is switched from OFF to ON	The AD75 READY (X0) is not turned OFF.	Set the value within the setting range.
950	<Error history> (Extended parameter #2) Acceleration time 1 setting error	At data analysis	At the start: Operation does not start During operation: Deceleration stop	Set a value within the setting range.
951	Acceleration time 2 setting error			
952	Acceleration time 3 setting error			
953	Deceleration time 1 setting error			
954	Deceleration time 2 setting error			
955	Deceleration time 3 setting error			
956	JOG speed control limit error			
957	JOG acceleration selection setting error			
958	JOG deceleration selection setting error			
959	Acceleration/decelera tion selection setting error			
960	S curve ratio setting error			

Error Code	Error Name	Detection Timing	Operation Status when Error Occurs	Corrective Action
518	Out of operation pattern range	On analysis of positioning data	At start: No operation During operation: Deceleration stop	Correct the operation pattern.
519	Other interpolation axis BUSY		At start: No operation During operation: Deceleration stop	Correct the control method.
520	Unit group mismatch	On analysis of positioning data	At start: No operation During operation: Deceleration stop	• Correct the positioning data or change the parameters.
521	Interpolation description command incorrect			Correct the control method.
522	Commanded speed setting error			Correct the commanded speed.
524	Control method setting error			Correct the control method or parameter.
525	Auxiliary point setting error		At start: No operation During operation: Deceleration stop	Correct the arc address.
526	End point setting error			Correct the positioning address.
527	Center point setting error			Correct the arc address.
530	Address out of range		At start: No operation During operation: Deceleration stop	Correct the positioning address.
532	Simultaneous start not possible	At simultaneous start	Operation is finished.	Correct the special start data and positioning data.
533	Condition data error	On analysis of special start data		Reset the special start data.
534	Special start command error			
536	M code ON signal ON start	At positioning start	At start: No operation	Start operation after M code ON signal is turned OFF.
537	PC READY OFF start			Start operation after PC READY ON.
538	READY OFF start			Start operation after checking the AD75 READY is ON.
543	Out of start No. range			Reset the positioning start No.
544	Out of radius range	On analysis of positioning data	At start: No operation During operation: Immediate stop	Correct the positioning data.
900	<Error history> (Basic parameter #1) Out of unit setting range	At power ON or when PC READY is switched from OFF to ON	The AD75 READY flag (X0) is not turned OFF.	Set the value within the setting range.
901	Number of pulses per revolution setting error			
902	Travel value per revolution setting error			
903	Unit magnification setting error			
904	Pulse output mode error			
905	Direction of rotation setting error			
910	<Error history> (Basic parameter #2) Out of speed limit range	At power ON or when PC READY is switched from OFF to ON At the start of operation	At power ON or when PC READY is switched from OFF to ON, the AD75 READY flag (X0) is not turned OFF. At start: No operation.	Set the value within the setting range.
911	Out of acceleration time range			
912	Out of deceleration time range			

Error Code	Error Name	Detection Timing	Operation Status when Error Occurs	Corrective Action
206	Count type travel value error	At count type home position return start	Home position return fault	• Calculate the travel distance from the speed limit, home position return speed, deceleration speed. Set the travel value after the near-zero point dog equal to or greater than the deceleration distance. • Decrease the home position return speed. • Adjust the near-zero point dog position ti extend the travel value after the near-zero point dog.
207	Home position return request ON	At high speed home position return start		Execute the home position return.
208	Out of creep speed range	At home position return start		Set the creep speed to a speed within the home position return speed.
209	Home position return restart not possible	At restart request after home position return stop	No restart	Restart home position return.
300	<JOG> Out of JOG speed range	At JOG operation start	JOG operation is not carried out when the set value is "0" or out of the setting range.	Set a value within the setting range (except "0").
500	<Positioning operation> Start data No. incorrect	On analysis of special start data	Operation is ended.	Correct the special start data.
501	Error before simultaneous start			
502	Start data No. incorrect	On analysis of positioning data	The positioning data is not executed.	Correct the positioning data.
503	No commanded speed	On analysis of initial positioning data at the start	At start: No operation	
504	Out of linear travel value range	On analysis of positioning data		Review the positioning address.
506	Excessive arc error	At calculation of locus for circular interpolation control by center point designation	The circular interpolation control by center point designation is not executed.	• Correct the center point address and end point address. • Correct the value for the allowable error range for circular interpolation.
507	Start outside stroke limit +	At operation start	At start: No operation	Set the feed present value within the software stroke limit setting range by JOG operation or manual pulse generator operation.
508	Start outside stroke limit -			
509	Travel outside stroke limit +			• In case of positioning operation, set the positioning address within the software stroke limit setting range. • For JOG operation and manual pulse generator operation start, carry out operation within the software stroke limit range.
510	Travel outside stroke limit -			
511	Travel outside stroke limit +	During operation	Immediate stop at positioning data No. immediately preceding the positioning data No. at which the stroke limit was exceeded.	Correct the positioning data.
512	Travel outside stroke limit -			
514	Out of range for present value change	On analysis of present value change	Present value is not changed.	Set the present value after the change within the setting range.
515	Present value change not possible			Do not designate present value change in the next positioning data of continuous locus control.
516	Continuous locus control not possible	On analysis of positioning data	At start: No operation	• Do not designate fixed pitch feed in the next positioning data of continuous locus control. • Do not carry out fixed pitch feed, speed control or speed/position control with the continuous locus control operation pattern.

13.1 Error List

The following tables give the descriptions of errors and the corrective actions to take against them.

Error Code	Error Name	Detection Timing	Operation Status when Error Occurs	Corrective Action
000	Normal status	———	———	———
001 003 004 005	<Critical error> Fault Below zero Overflow Underflow	H/W fault	The system stops	• Check for noise. • Check for hardware faults.
100	<General> Peripheral device stop during operation	"Stop" key input from the peripheral device during operation.	Deceleration stop or rapid stop	Reset the error by axis error reset.
101	PC READY OFF during operation	When PC READY goes OFF during operation	Deceleration stop or rapid stop	Reset the error by axis error reset.
102	Drive module ready OFF	When drive module ready signal goes OFF during operation	Immediate stop	Reset the error by axis error reset.
103	Test mode error during operation	During test mode	Deceleration stop	After determining the cause, turn the power of the AD75 and peripheral devices OFF and back ON.
104	H/W stroke limit +	At the start of operation	Operation is not started.	fter resetting the error, start the JOG operation and manual pulse generator operation in the reverse direction of the limit switch.
		During operation	Deceleration stop	
105	H/W stroke limit -	At the start of operation	Operation is not started.	fter resetting the error, start JOG operation or manual pulse generator operation in the reverse direction to the direction when the limit switch was struck.
		During operation	Deceleration stop	
106	Stop signal ON at start	At the start of operation	Operation is not started.	Reset the error by axis error reset.
107	Ready OFF to ON during BUSY	When PC READY signal (Y1D) comes ON	The AD75 READY signal (X0) is turned ON. Next operation is not started.	Turn the PC READY signal (Y1D) from OFF to ON.
201	Start at home position	At the start of home position return	Home position return fault	• Enable the home position return retry function. • Use JOG operation or manual pulse generator operation to move from the present position to carry out home position return.
		At the start of home position return by stopper stop (3) (method without near-zero point dog) or external signal home position return without near-zero point dog		• Move the present position by JOG operation or manual pulse generator operation to carry out home position return.
203	Dog detection timing error	Deceleration from home position return speed in progress	Deceleration stop	• Correct the home position return speed.
204	Zero-point detection timing error			• Correct the home position return speed. • Zero-point signal from external source is input while travelling at the creep speed.
205	Dwell time error			• Correct the home position return speed. • Extend the dwell time.

(b) If an axis warning occurs, the warning code corresponding to the warning content is stored at the following buffer memory address for the axis warning No. storage.

Axis No.	Buffer Memory Address
1	808
2	908
3	1008

Every a warning is issued, the latest warning code is stored in the buffer memory address for axis warning No. storage.

(c) If an axis warning is issued for positioning operation, "1" is set at bit 10 (b10) of the following buffer memory address for status storage.

Axis No.	Buffer Memory Address
1	817
2	917
3	1017

(d) Warning codes are classified into the following main groups.

Warning Code	Error Classification
100 to 199	General warning
200 to 299	Warning during home position return
300 to 399	Warning during JOG operation
400 to 499	Warning during manual pulse generator operation
500 to 599	Warning during positioning operation
900 to 999	System control data range check warning

(3) Axis error reset

Set "1" at the relevant buffer memory address for axis error reset - 1151 (for axis 1), 1201 (for axis 2) and 1251 (for axis 3) - then carry out the following processing to reset the error status.
- Turn OFF the axis error detection signal.
- Clear the axis error No.
- Turn OFF the axis warning detection signal.
- Clear the axis warning No.
- Switch the operation status from "error" to "standby".
- Switch the operation status from "step error" to "standby".

(4) Invalidation of settings

If any of the following operations are attempted, the settings are considered invalid and no errors/warning occurs.
- Speed change during home position return
- Speed change while no operation is in progress
- Axis stop when axis is stopped
- Axis rapid stop when axis stopped
- Axis stop while no axis operation is in progress
- Axis rapid stop while no axis operation is in progress
- Writing to the buffer memory monitor area

(b) If an error occurs, the error detection input signal is turned ON, and the error code corresponding to the error content is stored at the following buffer memory address for axis error number storage.

Axis No.	Error Detection Signal Input	Buffer Memory Address
1	XA	807
2	XB	907
3	XC	1007

Every time an error occurs, the latest error code is stored in the buffer memory address for axis error storage.

(c) Error codes are classified into the following main groups:

Error Code	Error Classification
001 to 009	Critical error
010 to 099	Error at system start
100 to 199	General error
200 to 299	Error during home position return
300 to 399	Error during JOG operation
400 to 499	Error during manual pulse generator operation
500 to 599	Error during positioning operation
900 to 999	Parameter setting range check error

(2) Warning detection

(a) The warnings detected are classified into system warnings and axis warnings.

1) The system warnings are as follows:
- System control data setting error
  The axis warning is issued for axis 1.
- Positioning data setting error
  The axis warning is issued for all axes.
  If an interpolation designation or axis setting error occurs, the warning is issued for the following axes.
  * In interpolation control for axis 1 and axis 2: axis 1
  * In interpolation control for axis 2 and axis 3: axis 2
  * In interpolation control for axis 3 and axis 1: axis 3

2) The axis warnings are issued in response to incorrect setting for positioning operation, JOG operation, manual pulse generator operation, or home position return operation, or system error. To reset an axis warning, turn on the axis error reset signal.
Warnings cannot be reset without eliminating their cause.
When an axis warning occurs, the axis operation status is not changed.

13. TROUBLESHOOTING

This chapter describes the various errors and warnings that may occur when using the AD75, and the corrective action to take if they occur.

(1) Error detection

(a) The errors detected by the AD75 consist of parameter setting range errors and errors that occur at operation start or while operation is in progress.

1) Parameter setting range errors

A parameter check is performed at power ON and at the leading edge (OFF → ON) of the PC READY signal: if the parameter settings are found to be incorrect in the checking, an error occurs.
If an error occurs, the AD75 READY signal is not turned OFF.
To reset an error, change the erroneous parameter setting to a correct value, then turn on the PC READY signal.

2) Errors at operation start/during operation

These are the errors that may occur at the start of, or during, positioning control, JOG operation, and manual pulse generator operation.
If an axis error occurs during interpolation operation, the error number is stored for both the reference axis and the other interpolation axis.
However, when the positioning data for each point of the positioning start data table is analyzed, the axis error number is stored only for the reference axis in the following cases:
- When the other interpolation axis is BUSY or,
- When an error occurs for the data not related to interpolation of the positioning data or parameters.

If an error occurs at the simultaneous start of positioning operations, the stored axis error contents differ depending on whether the error exists before or after the simultaneous start:
- Before simultaneous start (when the axis number is incorrect or the other axis is BUSY), an "error before simultaneous start" occurs.
- After simultaneous start (positioning error, software stroke limit error, etc.), the error code for the axis on which the error occurred is stored.
  Since simultaneous start cannot be carried out, a "simultaneous start not possible error" error code is stored for all error-free axes.

For the axis on which the error occurred, the axis operation status is "error".
If an error occurs during operation, the travelling axis is decelerated to a stop, and the axis operation status is "error".
Even if an error occurs at one axis during interpolation operation, both axes decelerate to a stop.

12.7.2 Program for reading positioning data through the positioning data interface

This section shows an example of a sequence program for reading the positioning data from the AD75.

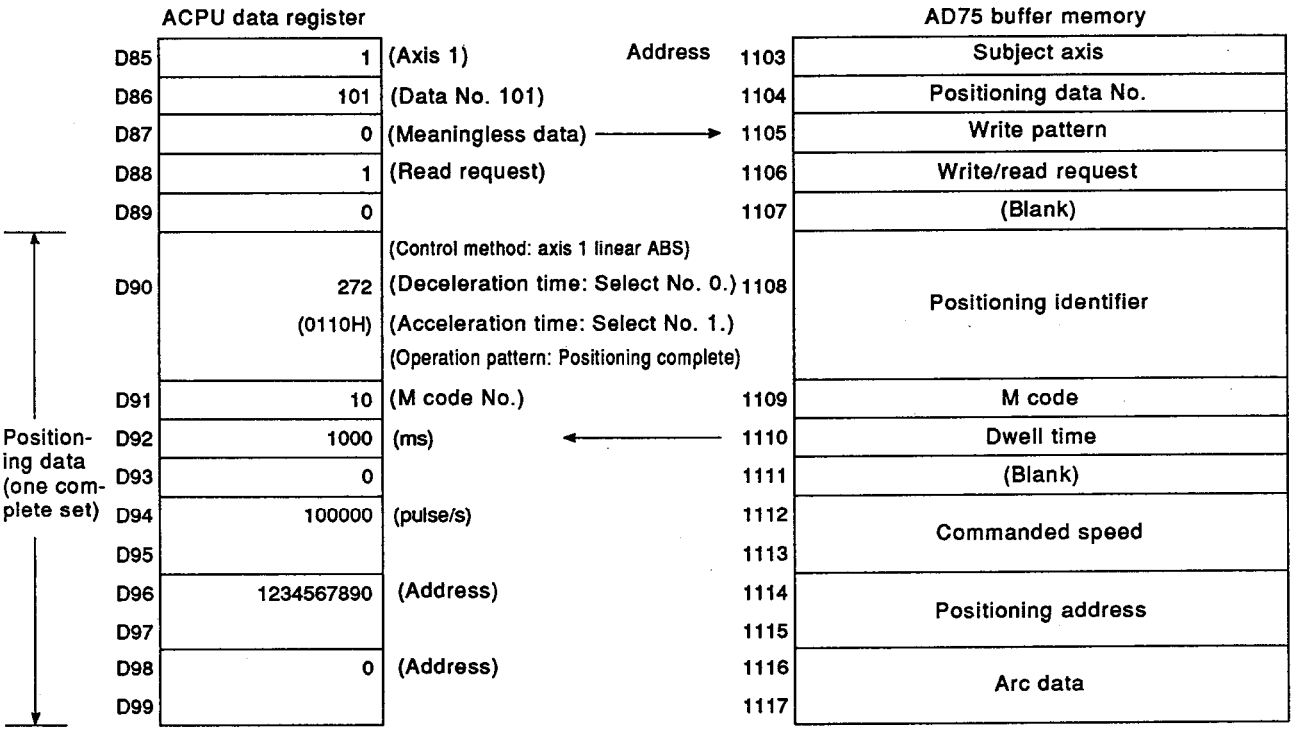
(1) Setting conditions

- There are no particular conditions to be set.

(2) Program example

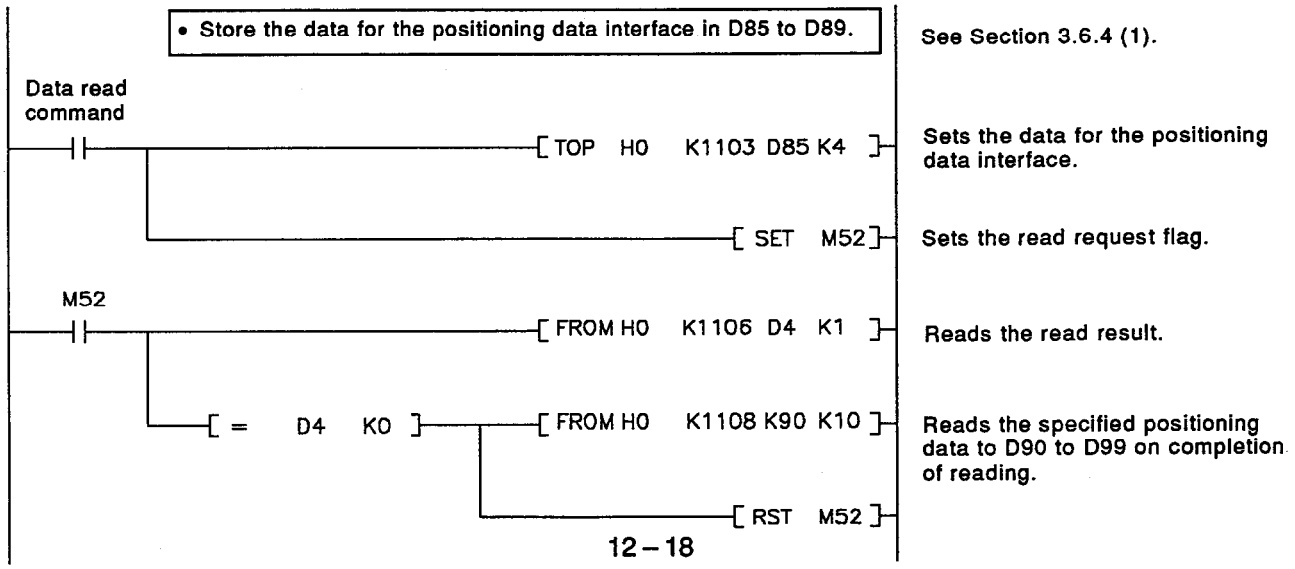
- The program shown here reads the positioning data of data No. 101 for axis 1 into D90 to D99.

(a) Data transfer

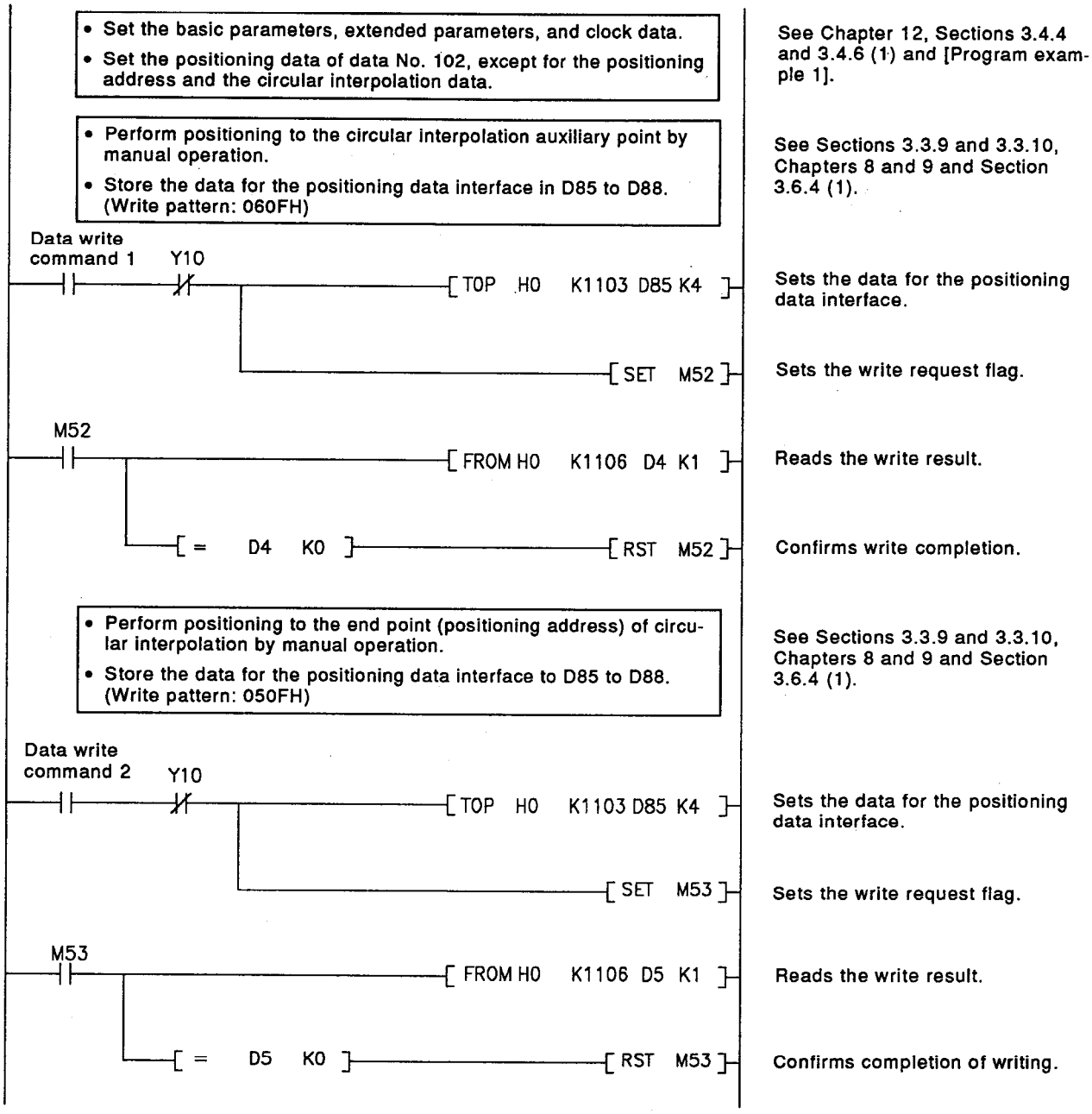


For positioning data details and set values, refer to Section 3.4.4.
For the positioning data-interface system control data areas shown above, refer to Section 3.6.4 (1).

(b) Program



(b) Program



POINTS

(1) Use addresses No. 1103 - No. 1137 in the system control data area as the buffer memory area for the positioning data interface.

(2) Before setting the positioning data, check the teaching function and teaching procedure described in Section 3.3.23.

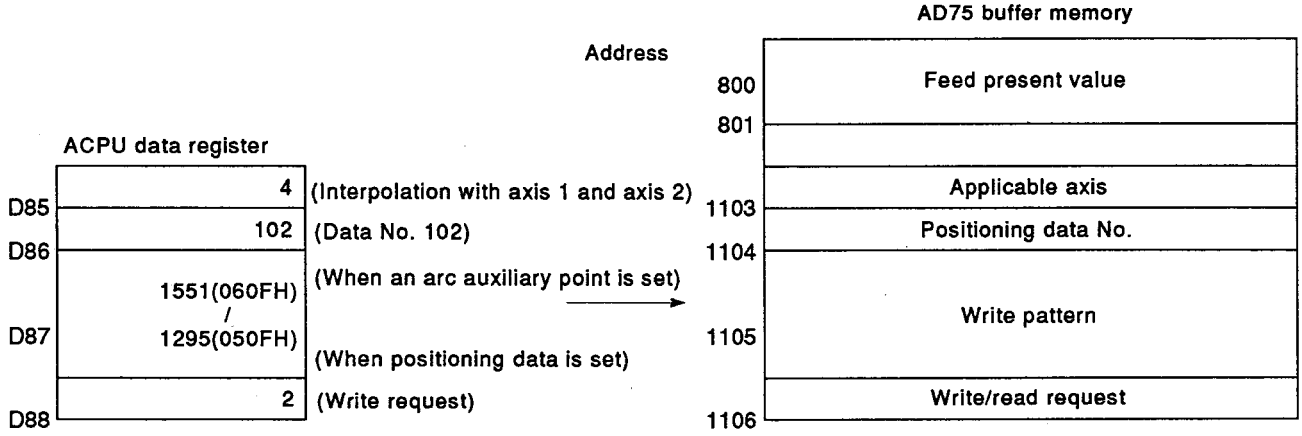
(3) The positioning address to be written is the absolute address (ABS) value.

(4) It is advisable to register the written positioning data to the AD75's flash ROM after confirming that positioning using the data has been performed and completed correctly.

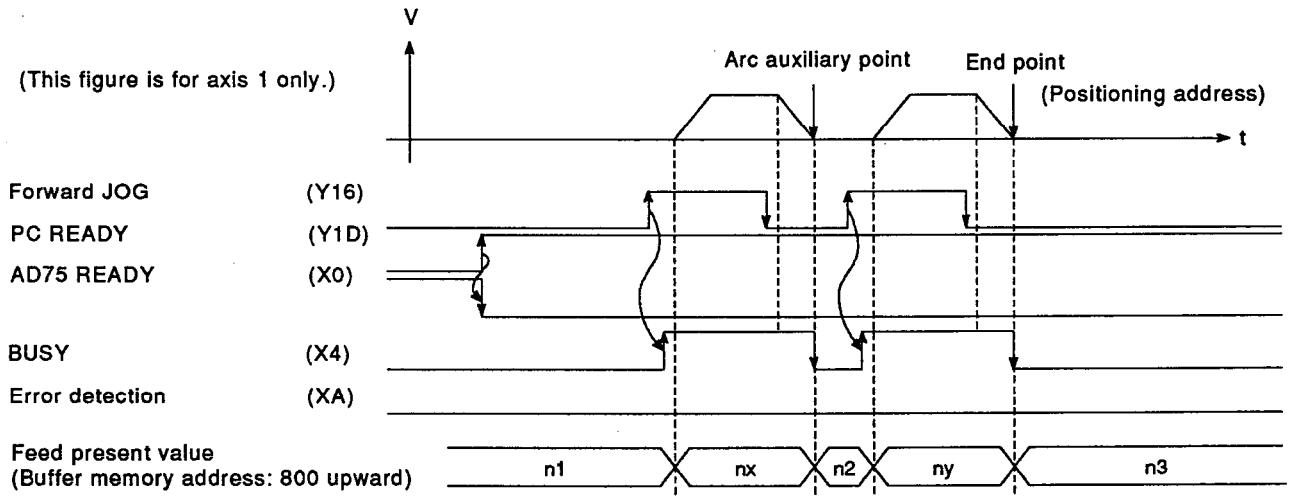
(3) Program example 2

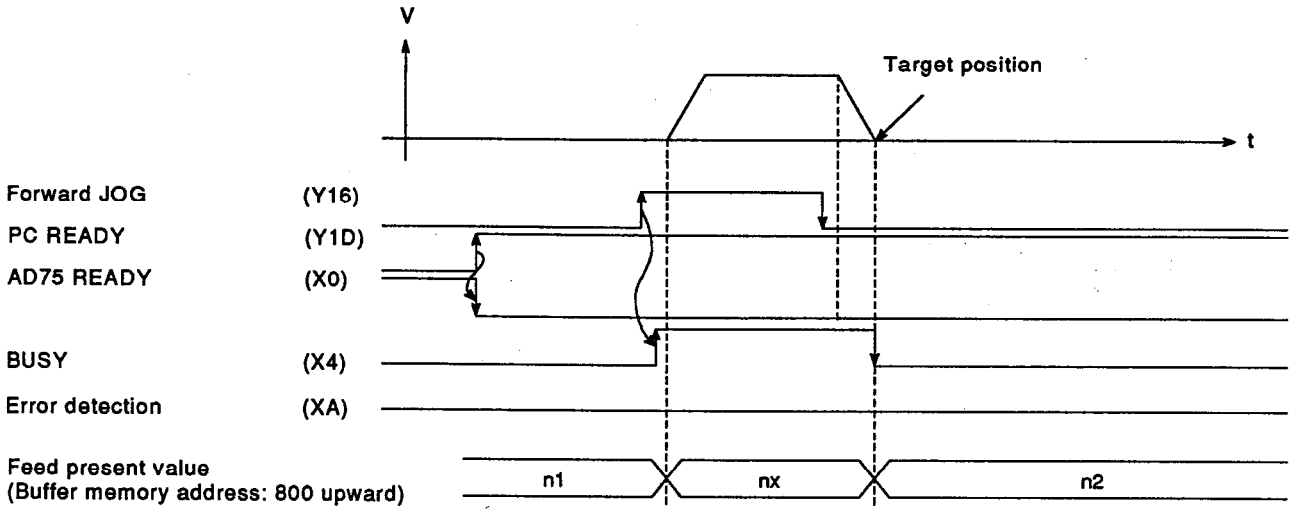
- The program shown here writes only the positioning address and the circular interpolation data (auxiliary point for circular interpolation) as the positioning data for circular interpolation control using the feed present value to data No. 102 for axes 1 and 2 (for circular interpolation control by designation of an auxiliary point).

(a) Data transfer

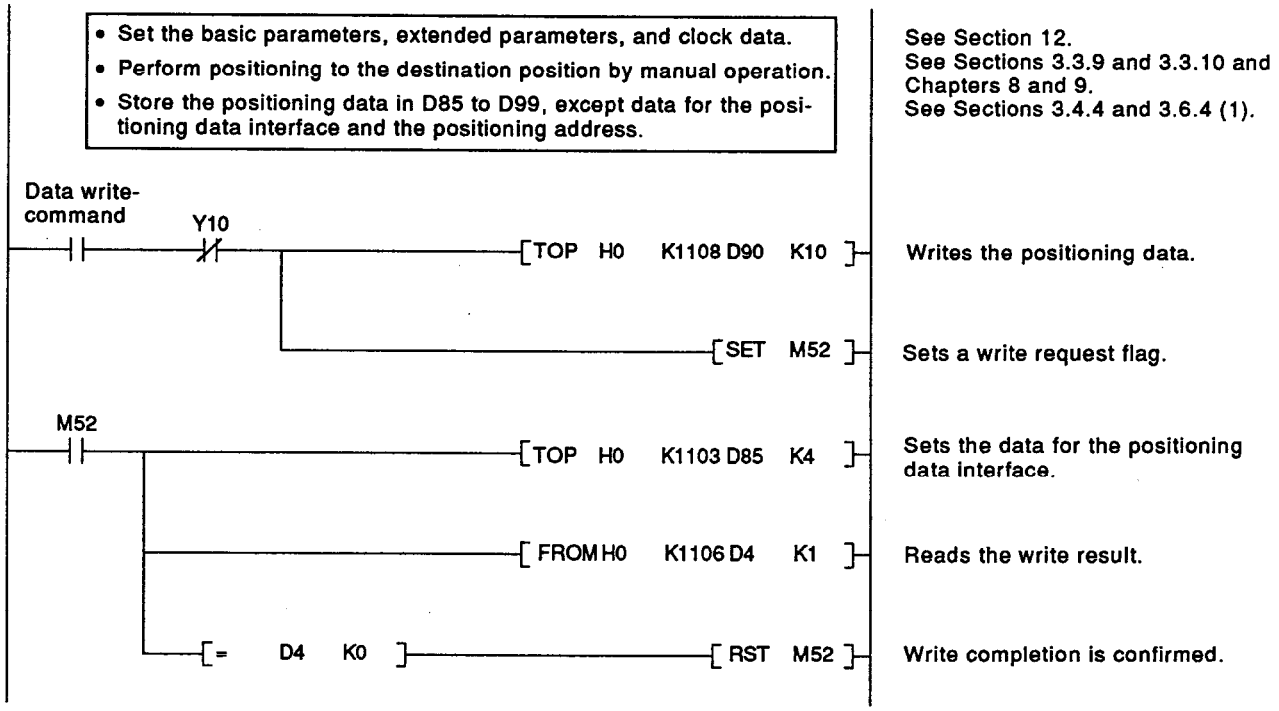


For details on the positioning data interface system control data areas, see Section 3.6.4 (1).





(b) Program



POINTS

(1) Use addresses No. 1103 to No. 1137 in the system control data area as the buffer memory area for the positioning data interface.

(2) Before setting the positioning data, check the teaching function and teaching procedure described in Section 3.3.23.

(3) The positioning address to be written is the absolute address (ABS) value.

(4) It is advisable to register the written positioning data in the AD75's flash ROM after confirming that positioning using the data has been performed and completed correctly.

12.7 Program for Setting and Reading Positioning Data Through the Positioning Data Interface

This section shows examples of sequence programs for setting (writing) positioning data, such as positioning addresses obtained by the teaching function in manual operation (JOG operation, manual pulse generator operation) to the AD75 and for reading positioning data from the AD75.

12.7.1 Program for setting positioning data through the positioning data interface

This section shows an example of a sequence program for setting (writing) positioning data obtained by the teaching function.

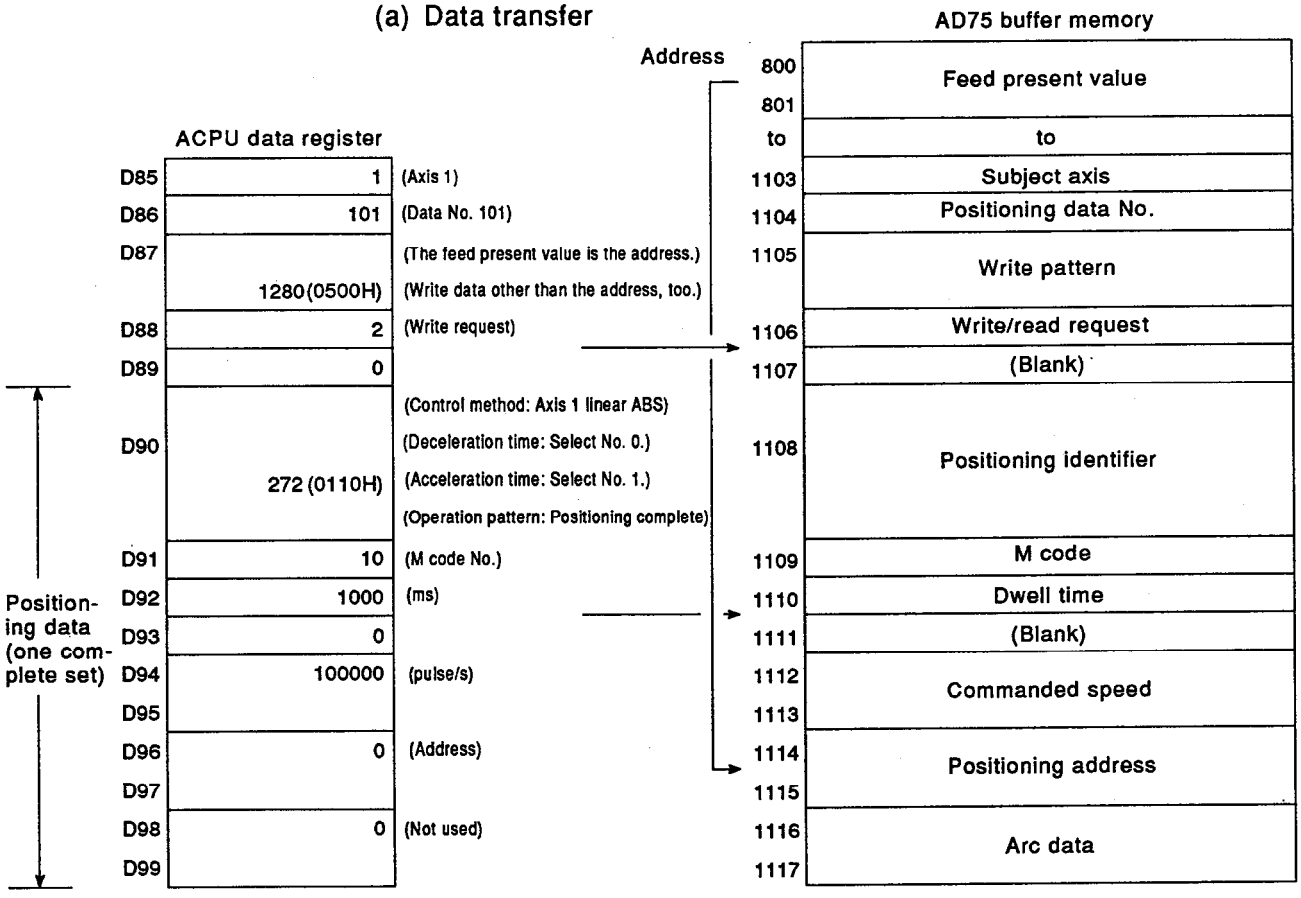
(1) Setting condition

- To set the feed present value as the positioning address or auxiliary point for circular interpolation, write positioning data when the BUSY signal is turned OFF.

(2) Program example 1

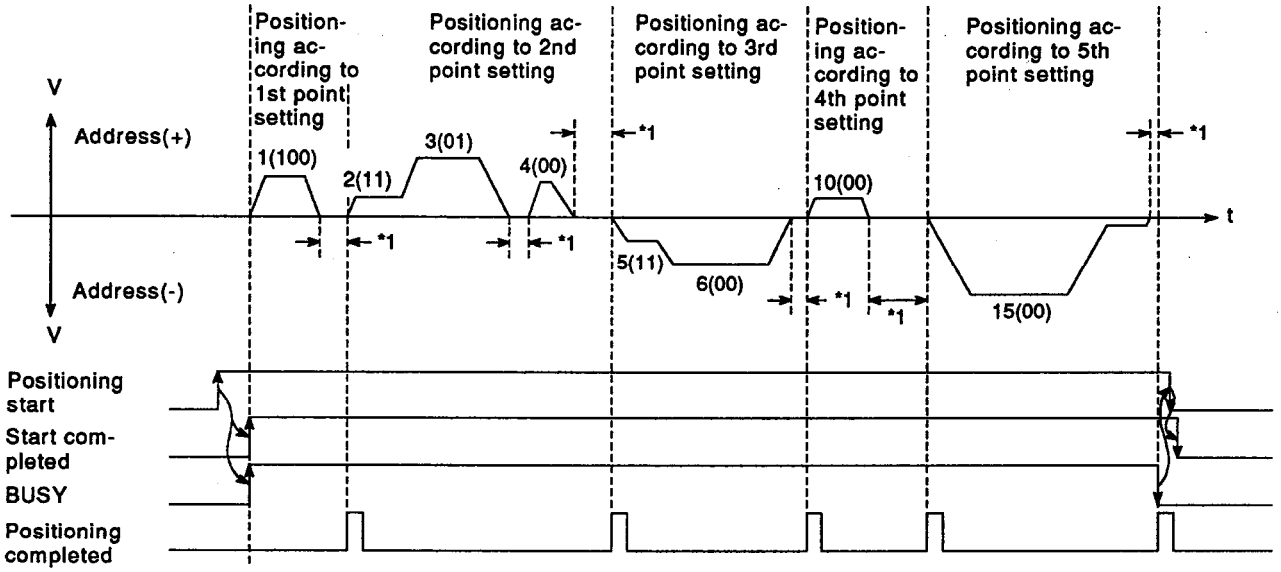
- The program shown here writes the feed present value as the positioning address, and the other positioning data stored in D90 to D95, to data No. 101 for axis 1 (for individual control of each axis or for interpolation (except for circular interpolation by designating an auxiliary point)).

(a) Data transfer



For details on positioning data and set values, see Section 3.4.4.
For details on the positioning data interface system control data areas shown above, see Section 3.6.4 (1).

The figure below illustrates positioning by normal start when block positioning is performed according to the data numbers shown in the program example.
In the figure, the numbers not in parentheses represent the positioning data numbers and those in parentheses represent the operation pattern.



*1: Dwell time by the respective positioning data

POINTS

(1) A block positioning data No. range check takes place in the following cases. If the AD75 detects an out-of-range error in the range check, positioning is not performed according to the positioning data.
The AD75 turns ON the error detection signal (XA/XB/XC) for the faulty axis, and stores the error code in the buffer memory (addresses: 807/907/1007).

(2) The available numbers for positioning start data are 1 to 600 (positioning data numbers).

(3) Block positioning can be executed without including special positioning start and condition data in the positioning start information. Set special positioning start data or condition data as required when specifying the positioning start conditions for each block or conditions for repeating blocks alternately.

(4) For debugging during positioning, it is advisable to confirm the positioning of each block or data number using the step function described in Section 3.3.21.

(5) The positioning start information handled by the AD75 is not stored in the flash ROM.
Set positioning start information when the relevant axis is not in operation whenever positioning is to be performed, then start block positioning.

12.6 Program for Setting Positioning Start Information

This section shows an example of a sequence program for setting positioning start information for block positioning from the ACPU to the AD75.

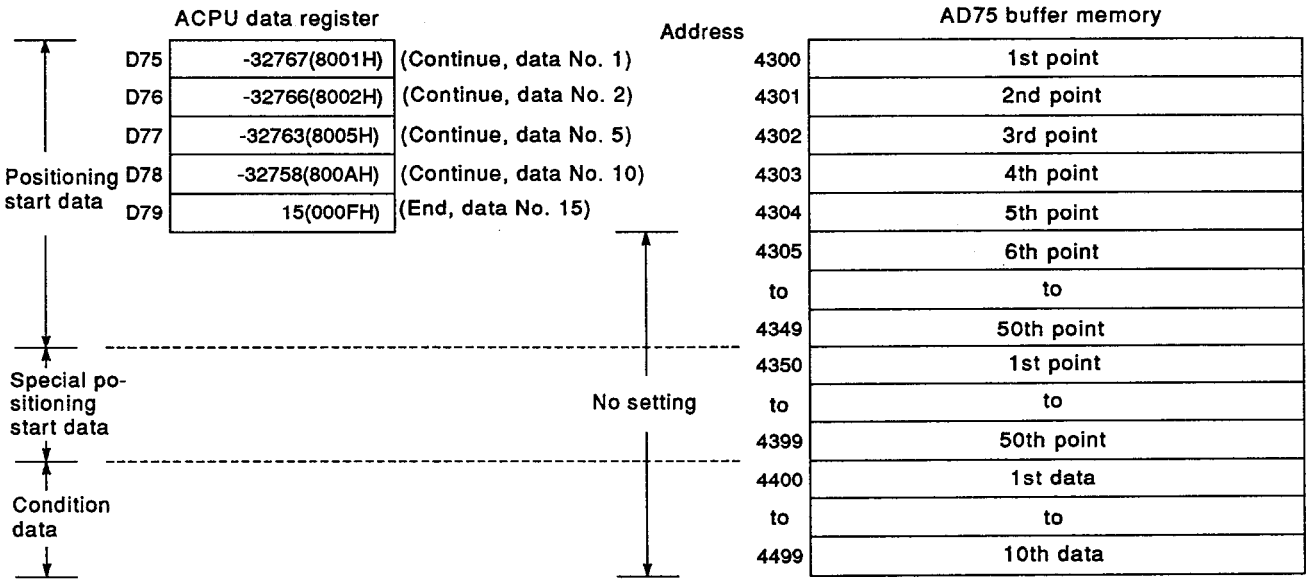
(1) Setting condition

- Write positioning start information when the relevant axis is not in operation.

(2) Program example

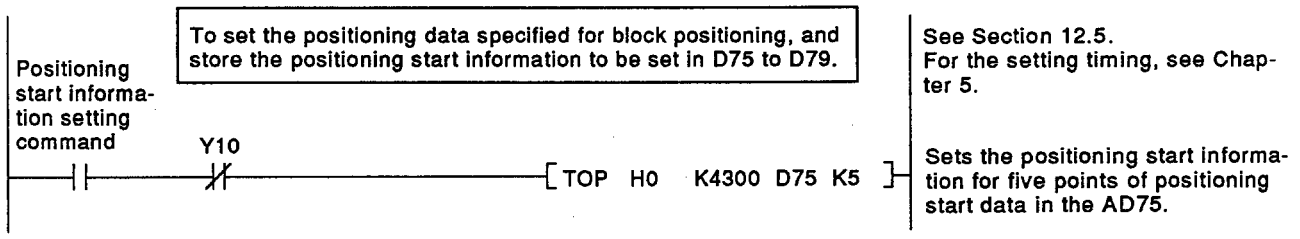
- The program shown here sets the positioning start data (5 points) for axis 1, stored in D75 to D79, in the AD75.
- In this example, no special positioning start or condition data corresponding to the positioning start data are set.

(a) Data transfer



(For details on positioning start data and set values, see Section 3.4.6.)

(b) Program



POINTS

(1) A positioning data range check is performed when positioning is executed on the basis of that positioning data. If the AD75 detects an error in the range check, positioning cannot be performed according to the positioning data.
The AD75 turns ON the error detection signal (XA/XB/XC) for the faulty axis, and stores the error code in the buffer memory (addresses: 807/907/1007).

(2) The positioning data the AD75 handles is stored in the flash ROM. At start-up of the AD75, the positioning data in the flash ROM is stored in the internal memory and buffer memory of the AD75, and is used for positioning.

- Positioning data of data No. 1 to No. 100:
  Stored in the internal memory and buffer memory.
- Positioning data of data No. 101 to No. 600:
  Stored in the internal memory.

(3) From the ACPU, only the positioning data of data No. 1 to No. 100 can be set in the buffer memory, and the data becomes valid as soon as it is written to the buffer memory (only data requiring change can be written and become valid). From the AD75, the positioning data of data No. 1 to No. 600 can be set.

(4) After the positioning data has been set, it is advisable to confirm that positioning can be performed correctly according to the set data before registering it in the flash ROM.

(5) Set the positioning data when the relevant axis is not in operation, then start positioning.

12.5 Program for Setting Positioning Data

This section shows an example of a sequence program for setting AD75 positioning data from the ACPU.

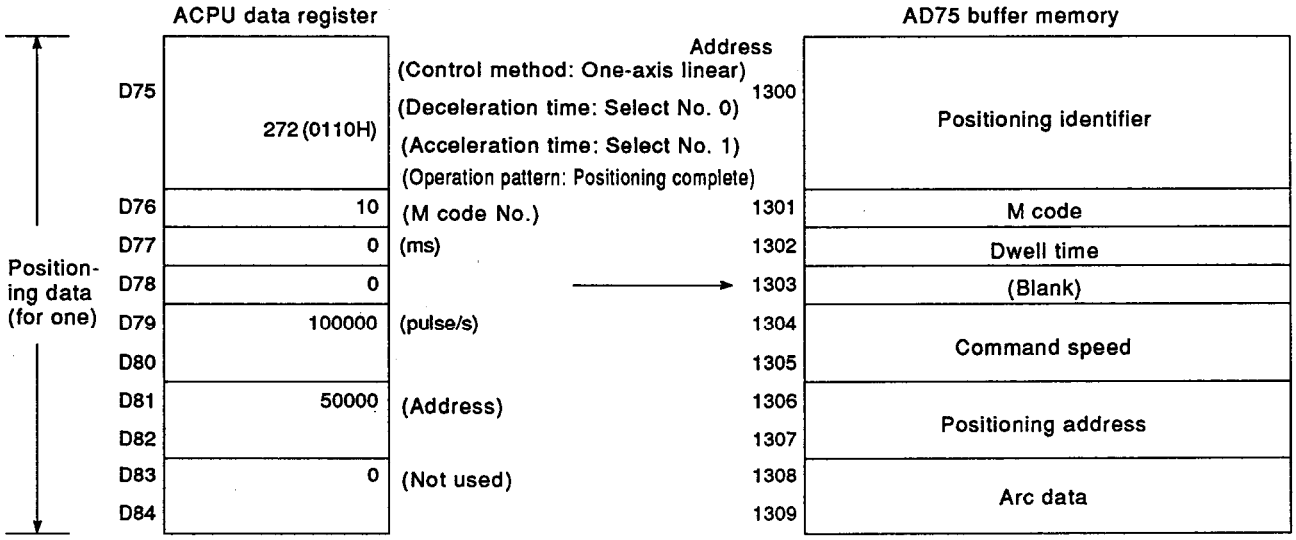
(1) Setting condition

- Write parameters when the relevant axis is not in operation.

(2) Program example

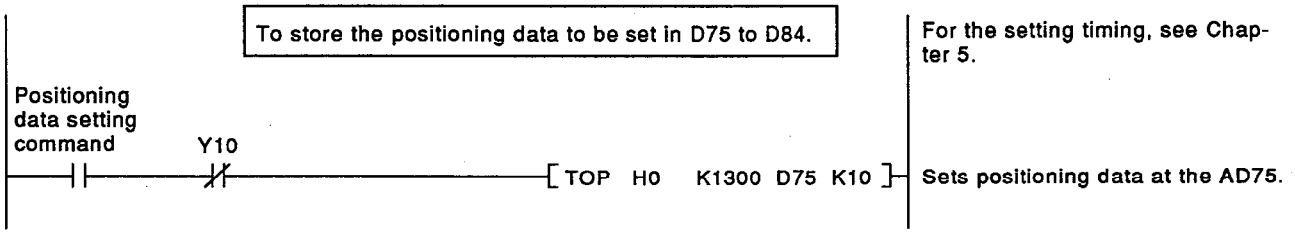
- The program shown here sets the positioning data for axis 1, stored in D0 to D9, in the AD75 using positioning data No. 1.

(a) Data transfer



(For details on positioning data and set values, see Section 3.4.4.)

(b) Program



POINTS

(1) A parameter setting range check takes place in the following cases. If the AD75 detects an error in the parameter setting range check, it turns ON the error detection signal (XA/XB/XC) for the faulty axis, and stores the error code in the buffer memory (addresses: 807/907/1007). (The AD75 READY signal (X0) does not turn OFF.)

- At start-up of the AD75.
- When the PC READY signal (Y1D) status is switched from OFF to ON.
- When the parameters are set in the AD75.

(2) To perform home position return, set the following parameters in accordance with the system configuration:

- Set all the basic parameters for home position return.
- Set only the necessary home position return extended parameters.

(3) The parameter values held in the flash ROM are stored in the buffer memory at start-up of the AD75.
After changing a parameter, it is advisable to confirm that the AD75 operates properly with the changed parameter before registering it in the flash ROM and using it as the set value at start-up of the AD75.

(4) The home position return parameters can be changed when the PC READY signal (Y1D) is turned OFF.
When changing the home position return parameters after positioning, first turn OFF the PC READY signal after completion of positioning.
After the parameters have been changed, turn ON the PC READY signal, and resume positioning.

12.4 Program for Setting Home Position Return Parameters

This section shows an example sequence program for setting home position return parameters in the AD75 from the ACPU.

(1) Setting condition

- Write parameters when the PC READY signal (Y1D) is turned OFF.

(2) Program example

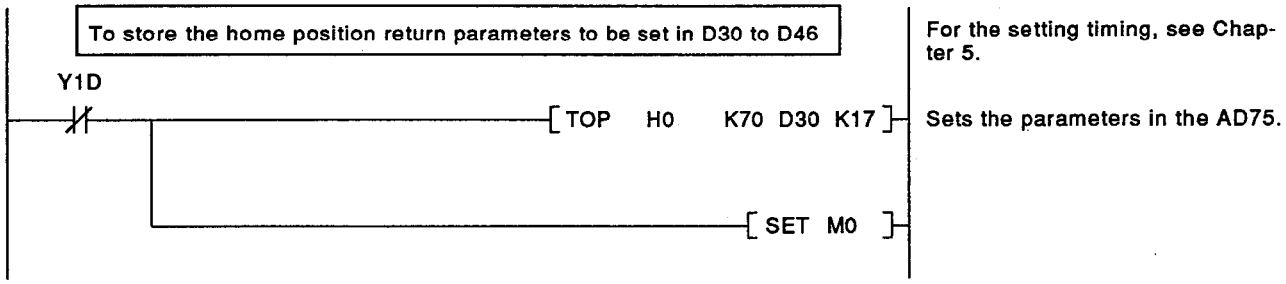
- The program shown here sets the home position return settings for axis 1, stored in D30 to D46, in the AD75.

(a) Data transfer

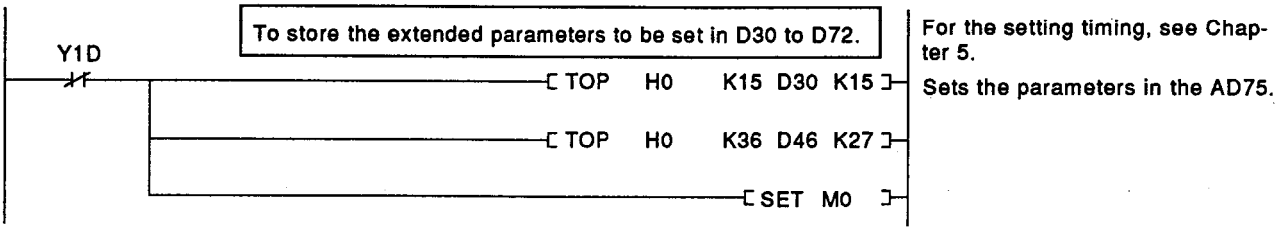
	ACPU data register			Address	AD75 buffer memory
Home position return basic parameters	D30	0	(Near-zero point dog method)	70	Home position return method
	D31	1	(Negative direction)	71	Home position return direction
	D32	0	(pulse)	72	Home position address
	D33			73	
	D34	50000	(pulse/s)	74	Home position return speed
	D35			75	
	D36	100	(pulse/s)	76	Creep speed
	D37			77	
	D38	1	(Execute)	78	Home position return retry
	D39	1000	(ms)	79	Home position return dwell time
Home position return extended parameters	D40	0	(pulse)	80	Travel after near-zero point value designation
	D41			81	
	D42	0	(Select acceleration time 0)	82	Home position return acceleration time selection
	D43	0	(Select deceleration time 0)	83	Home position return deceleration time selection
	D44	0	(pulse)	84	Home position shift
	D45			85	
	D46	300	(%)	86	Home position return torque limit value

(For details on parameters and set values, see Section 3.4.3.)

(b) Program



(b) Program



POINTS

(1) A parameter setting range check takes place in the following cases. If the AD75 detects an error in the parameter setting range check, it turns ON the error detection signal (XA/XB/XC) for the faulty axis, and stores the error code in the buffer memory (addresses: 807/907/1007). (The AD75 READY signal (X0) does not turn OFF.)

- At start-up of the AD75.
- When the PC READY signal (Y1D) status is switched from OFF to ON.
- When the parameters are set in the AD75.

(2) Extended parameters #1 are data which seldom require changes once set at system start-up.
Extended parameters #2 are data to be set to make the best use of the AD75's functions.
Change the parameters according to the system as appropriate.

(3) The parameter values held in the flash ROM are stored in the buffer memory at start-up of the AD75.
After changing a parameter, it is advisable to confirm that the AD75 operates properly with the changed parameter before registering it in the flash ROM and using it as the set value at start-up of the AD75.

(4) Extended parameters #1 can be changed when the PC READY signal (Y1D) is turned OFF.
When changing extended parameters #1 after positioning, first turn OFF the PC READY signal after completion of positioning.
After the parameters have been changed, turn ON the PC READY signal, and resume positioning.

(5) Extended parameters #2 can be changed whether the PC READY signal (Y1D) is turned ON or OFF, and become valid as soon as they are changed.
Positioning by changing the acceleration time, etc. on a case-by-case basis must, therefore, be started after changing the parameters.

(6) External start function selection (buffer memory addresses: 62/112/362) requires control of the external start enable setting area (addresses: 1171/1221/1271) and the following setting to the buffer memory:

- When external positioning start is selected: Positioning start signal number (addresses: 1150/1200/1250)
- When external speed change request is selected: Speed change value (addresses: 1156 to/1206 to/1256 to)
- When skip request is selected: No setting required.

12.3 Program for Setting Extended Parameters

This section shows examples of sequence programs for setting extended parameters in the AD75 from the ACPU.

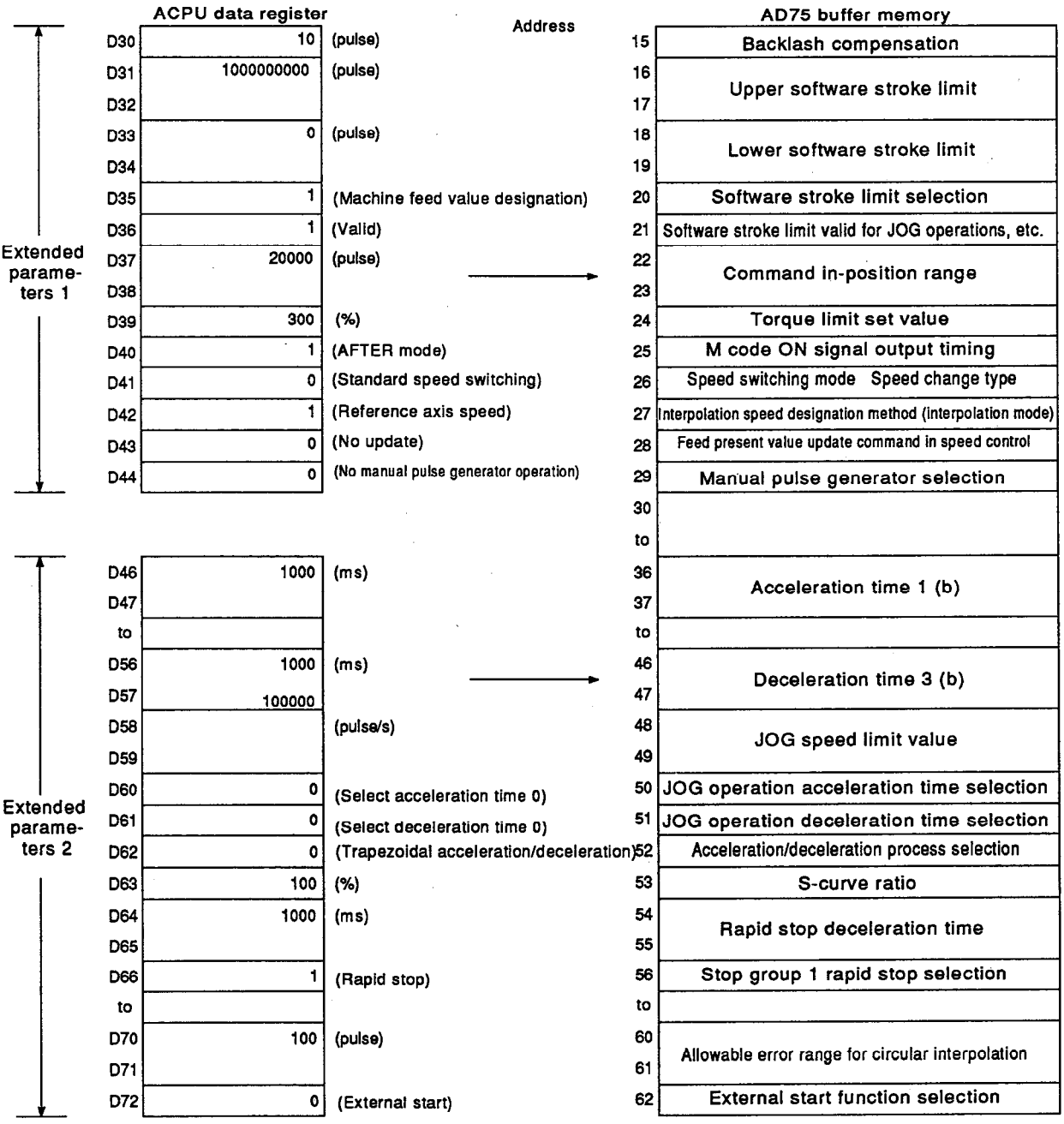
(1) Setting conditions

- Write extended parameters #1 when the PC READY signal (Y1D) is turned OFF.
- Write extended parameters #2 when positioning is not executed.

(2) Program example

- The program shown here sets the extended parameter settings for axis 1, stored in D30 to D72, in the AD75.

(a) Data transfer



(For details on parameters and set values, see Section 3.4.2.)

POINTS

(1) The basic parameters are data to be set in accordance with the mechanical system or applicable motor.
An improper parameter value can reverse the forward/reverse directions of rotation of the motor, or make it completely inoperable. Set the correct parameters for the system.

(2) A parameter setting range check takes place in the following cases. If the AD75 detects an error in the parameter setting range check, it turns ON the error detection signal (XA/XB/XC) for the faulty axis, and stores the error code in the buffer memory (addresses: 807/907/1007). (The AD75 READY signal (X0) does not turn OFF.)

- At start-up of the AD75.
- When the PC READY signal (Y1D) status is switched from OFF to ON.
- When the parameters are set in the AD75.

(3) Basic parameters #1 are the basic data for positioning, including home position return, whereas basic parameters #2 are the data to set the acceleration/deceleration gradients in positioning.

(4) The parameter values held in the flash ROM are stored in the buffer memory at start-up of the AD75.
After changing a parameter, it is advisable to confirm that the AD75 operates properly with the changed parameter before registering it in the flash ROM and using it as the set value at start-up of the AD75.

(5) Basic parameters #1 can be changed when the PC READY signal (Y1D) is turned OFF.
When changing the basic parameters #1 after positioning, first turn OFF the PC READY signal after completion of positioning.
After the parameters have been changed, turn ON the PC READY signal, and resume positioning.

(6) Basic parameters #2 can be changed whether the PC READY signal (Y1D) is turned ON or OFF, and become valid as soon as they are changed.
Positioning by changing the acceleration time, etc. on a case-by-case basis must, therefore, be started after changing the parameters.

12.2 Program for Setting Basic Parameters

This section shows an example of a sequence program for setting basic parameters in the AD75 from the ACPU.

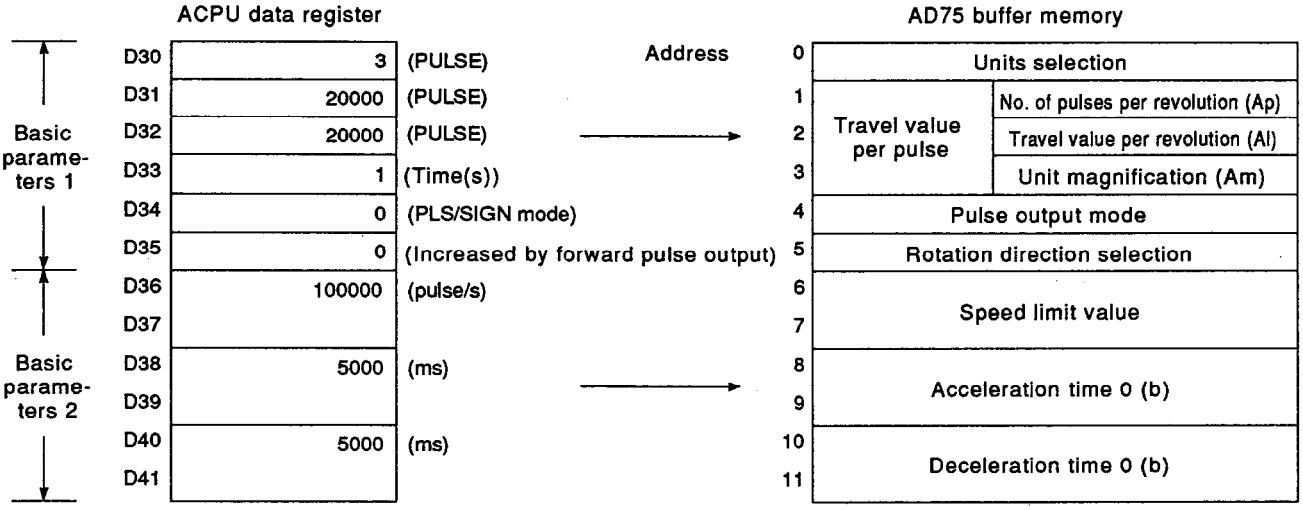
(1) Setting conditions

- Write basic parameters #1 when the PC READY signal (Y1D) is turned OFF.
- Write basic parameters #2 when positioning is not executed.

(2) Program example

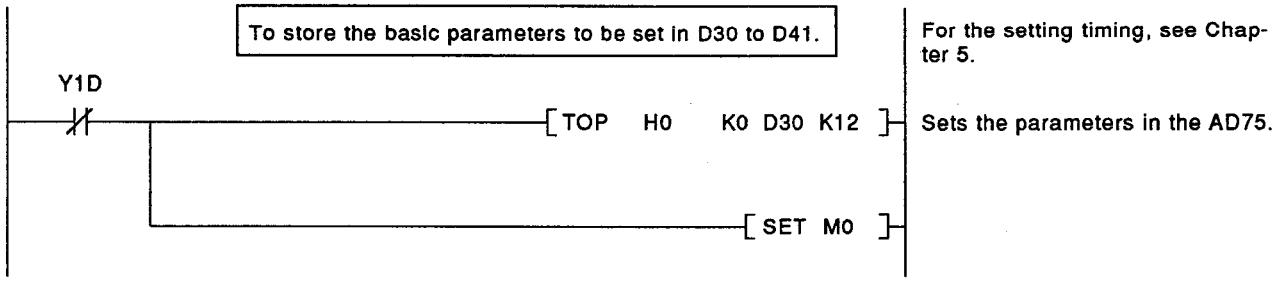
- The program shown here sets the basic parameter settings for axis 1, stored in D30 to D41, in the AD75.

(a) Data transfer



(For details on parameters and set values, see Section 3.4.1.)

(b) Program



12.1 Program for Setting Clock Data (System Control Data)

This section shows an example of a sequence program for setting AD75 clock data (one of the system control data) from the ACPU.

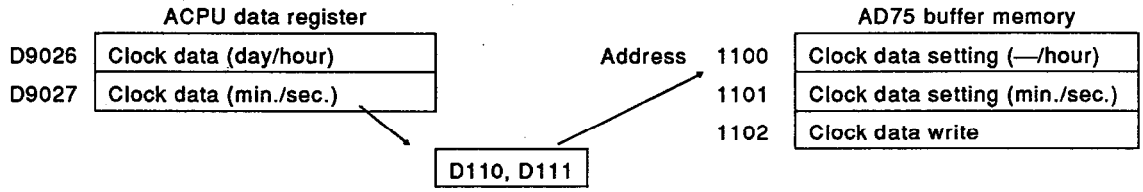
(1) Setting conditions

- There are no particular conditions to be set.

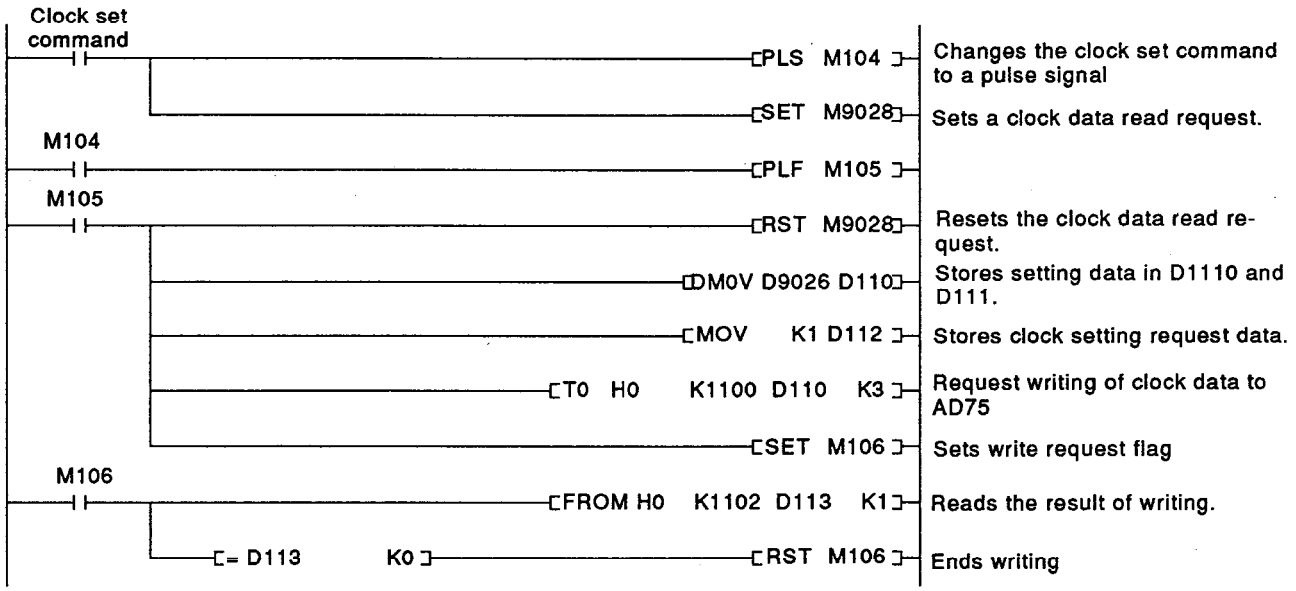
(2) Program example

- The program shown here reads clock data from the ACPU to the AD75.

(a) Data transfer



(b) (Program)



POINTS

(1) Set clock data in the AD75 each time the ACPU is turned ON. Otherwise, the clock data count will start from the AD75 start-up time of 00 day/00 hour/00 minute/00 second.

(2) The set clock data will be used as history data.

(3) The first eight bits of the data set at address 1100 (in the control data area) in the AD75's buffer memory will be ignored.

(4) The AD75 controls the clock data to an accuracy of 0.1 second to facilitate measurement of tact time and other data in start history recording by the user.

(5) Since the clock data in the AD75 is less accurate than that in the ACPU, match it with the ACPU clock data at least once a day.

Device Name	Device			Use	ON Status or the Stored Value Indicates:
	Axis 1	Axis 2	Axis 3		
Data register	D0			Status	Flag statuses
	D1			Status (for specific flag)	Specific flag status
	D2			Absolute original point	Home position address, etc.
	D3				
	D4			General-purpose	———
	D5			General-purpose	
	D6			Speed command value	Speed
	D7				
	D8			Speed change command value	Target speed
	D9				
	D10	———		Manual pulse generator operation enabled	"Enable" value
	D11			Manual pulse generator operation disabled	"Disabled" value
	D12			Manual pulse generator 1 pulse input magnification	Magnification value
	D13				
	D30			Parameter settings	Applicable set value
	to				
	D72				
	D73			General-purpose	———
	D74			General-purpose	
	D75			Positioning data set value or positioning start data setting	Applicable set value
	D84				
	D85			Positioning data interface	Teaching set value or read value
	D99				
	D100			Flash ROM registration result	Result value
	D101	D102	D103	Axis error code	Error code
	D104	D105	D106	Axis warning code	Warning code
	D107	D108	D109	Axis error reset result	Result value
	D110			Clock data setting (hour)	Clock data
	D111			Clock data setting (min./sec.)	
	D112			Clock data set request	Set request data
	D113			Clock data write result	Result value

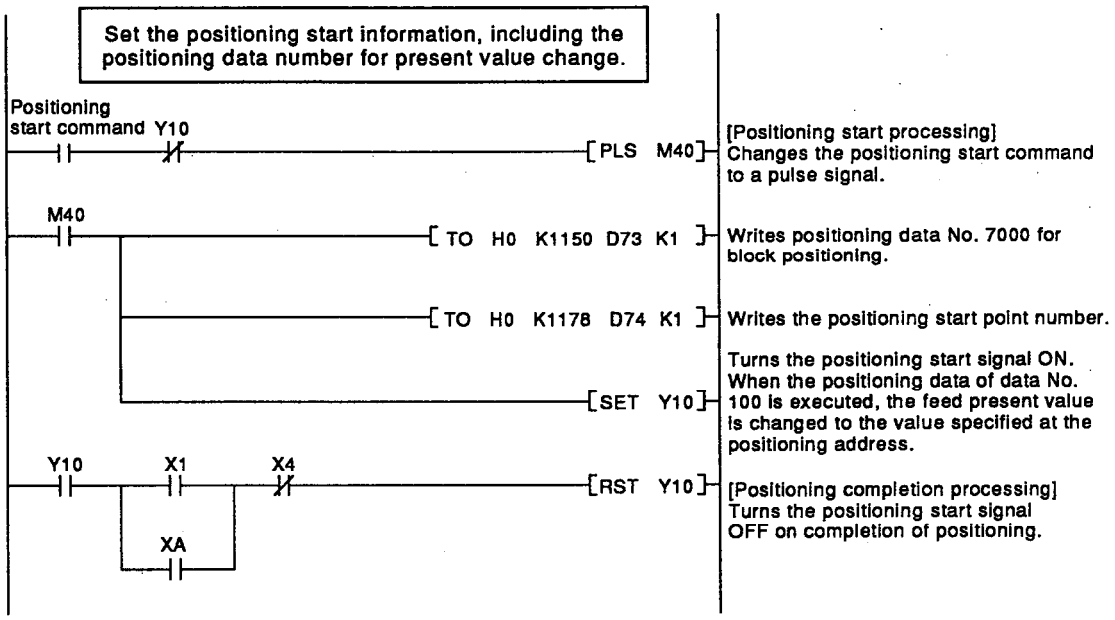
12. DATA SETTING USING A SEQUENCE PROGRAM

This chapter describes sequence programs to set clock data (system control data), parameters, positioning data and positioning start information in the AD75's buffer memory from the ACPU.

The following table shows the applications of the I/O signals (X, Y), internal relays (M) and data registers (D) used in the program examples, including the devices used in the programs cited in sections 5 to 11.

Device Name	Device			Use	ON Status or the Stored Value Indicates:
	Axis 1	Axis 2	Axis 3		
Input	X0			AD75 READY	Not ready/WDT error
	X1	X2	X3	Start completed	Start completed
	X4	X5	X6	Busy	Busy (operation in progress)
	X7	X8	X9	Positioning completed	Positioning completed
	XA	XB	XC	Error detection	Error detection
	XD	XE	XF	M code ON	M code being output
Output	Y10	Y11	Y12	Positioning start	Requesting start
	Y13	Y14	Y1C	Axis stop	Requesting stop
	Y16	Y18	Y1A	Forward JOG start	Forward start in progress
	Y17	Y19	Y1B	Reverse JOG start	Reverse operation starting
	Y1D			PC READY	Ready
Internal relay	M0			Parameter setting completed flag	Setting completed
	M1			Flash ROM registration processing in progress flag	Processing
	M2	M3	M4	Axis error reset request in progress flag	Request issued
	M10			Machine home position return start flag	Home position return enabled
	M11			High-speed home position return start flag	Home position return enabled
	M12			High-speed machine home position return flag	Home position return enabled
	M13			Home position return request flag OFF request	Flag OFF request
	M14				Flag OFF request
	M40			Positioning command flag	Command exists
	M41			Restart command flag	Command exists
	M42			Restart request flag	Request issued
	M50			JOG operation enable flag	Operation enabled
	M51			Speed change request flag	Requesting change
	M52			Positioning data write/read request flag	Request issued
	M53				
	M100			"AD75 normal" flag	Normal
	M101			Initial error reset complete flag	Error reset complete
	M102			All BUSY signals OFF flag	All OFF
	M103			AD75 operation enable flag	Operation enabled
	M104			Clock setting command flag	Command exists
	M105			Clock setting command flag	Command exists
	M106			Clock data write request flag	Request issued
	M9028			Clock data read request	Request issued

(c) Program



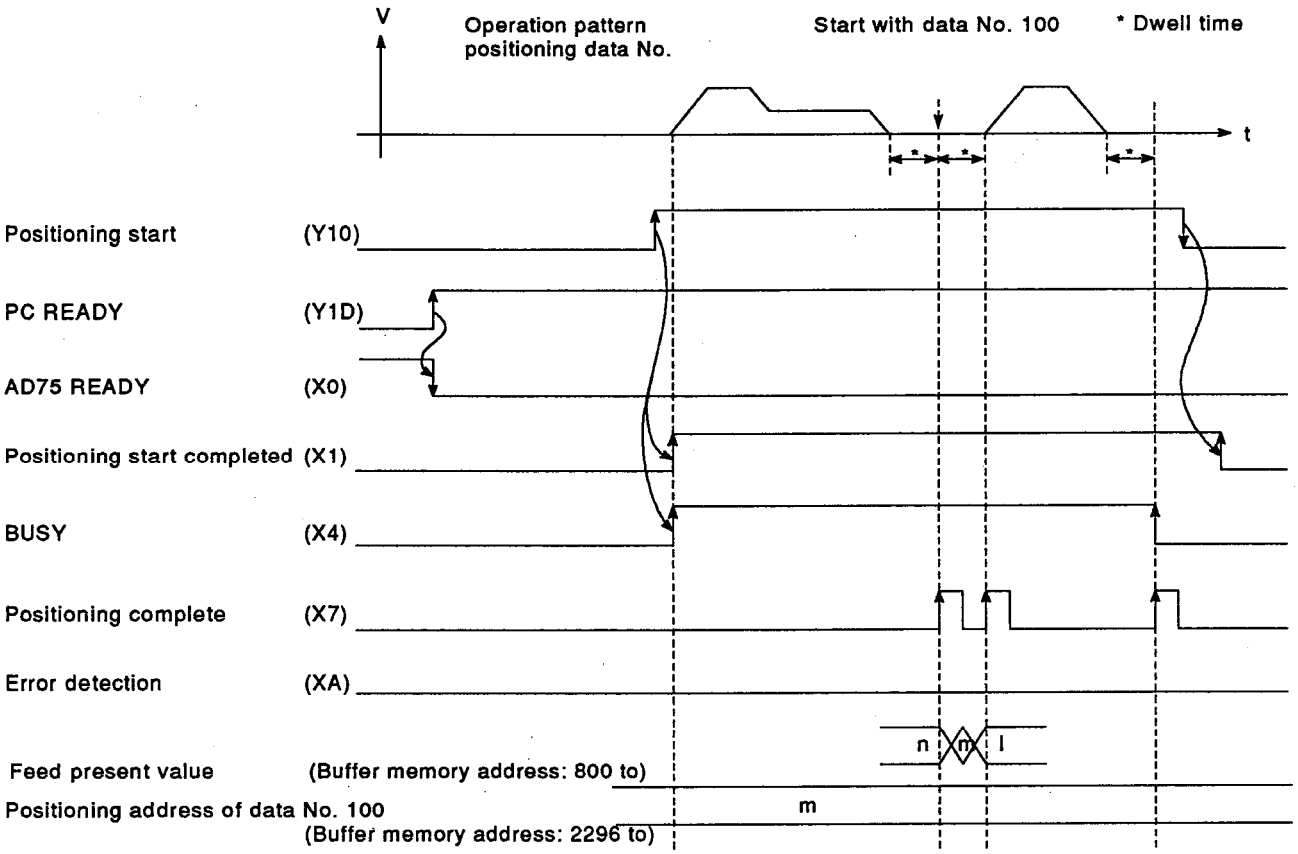
POINTS

(1) Before performing a present value change, check the present value change operation and applicable restrictions by referring to Section 3.3.18.

(2) Positioning data in which a present value change instruction is designated can beexecuted just after the positioning data of operation pattern "01" or "00" to perform a present value change.

(3) A present value change value outside the stroke limit range does not cause an error.
However, an "operation start outside software stroke limit range" error will occur at the begining of the following positioning.

(b) I/O signals

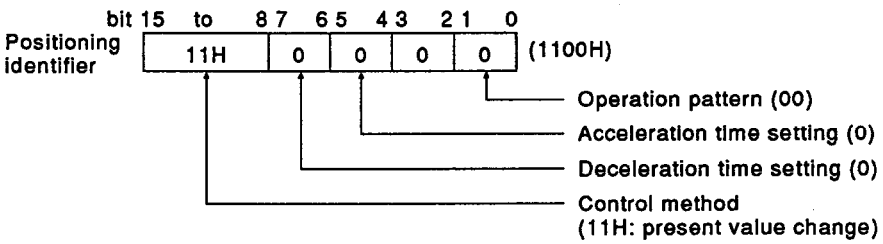

V
Operation pattern
positioning data No.
Start with data No. 100
* Dwell time
t
Positioning start (Y10)
PC READY (Y1D)
AD75 READY (X0)
Positioning start completed (X1)
BUSY (X4)
Positioning complete (X7)
Error detection (XA)
n
m
l
Feed present value (Buffer memory address: 800 to)
Positioning address of data No. 100
(Buffer memory address: 2296 to)
m

11.2 Present Value Change Program Using Present Value Change as the Control Method

This section describes a program example for changing the feed present value by executing the positioning data number specified for the present value change command.

(1) Conditions

- Set positioning data for which 1100_H (present value change) is set as the control method of the positioning identifier.

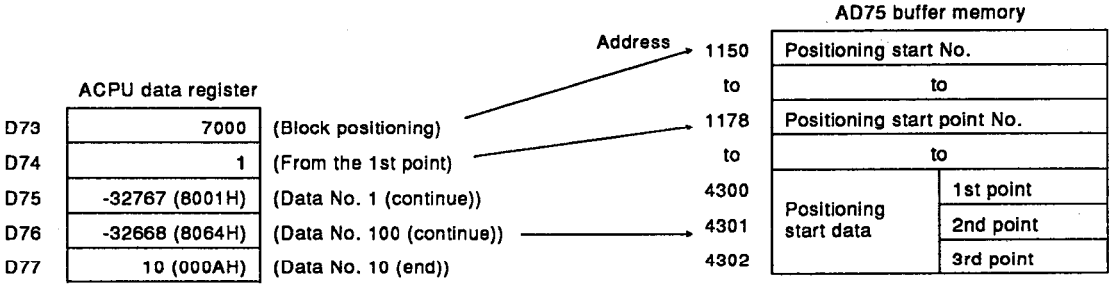


- Set a new present value for the positioning address.

(2) Program example

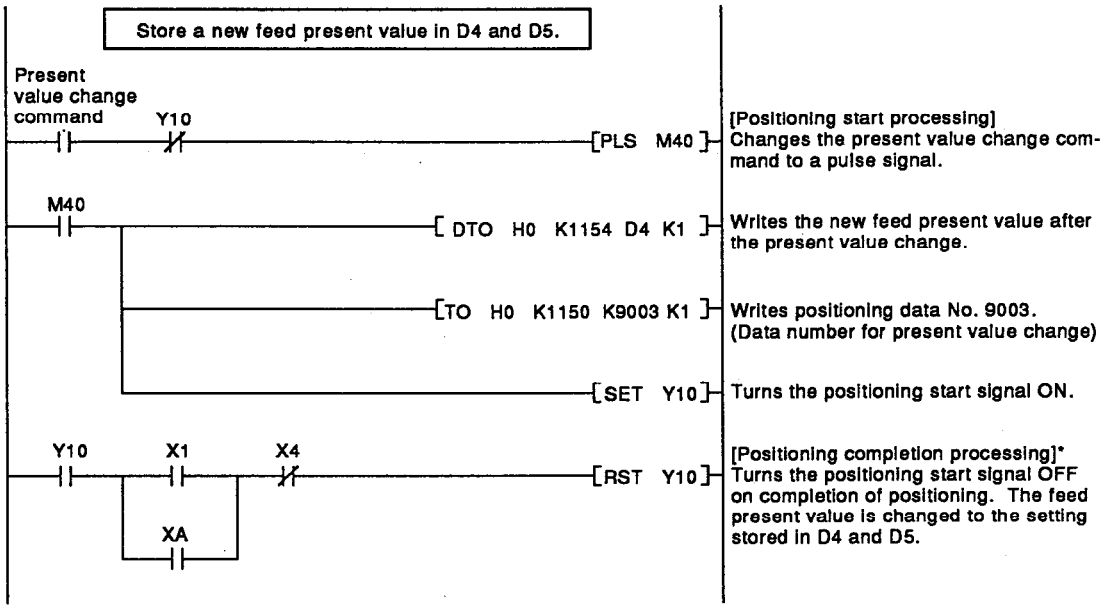
- The program shown here changes the present value of axis 1 using positioning data No. 100.

(a) Data transfer



For details on start numbers, see Section 3.4.5.
For details on the present value change value, see Section 3.6.4.

(c) Program example



POINTS

(1) Before performing a present value change, check the present value change operation and applicable restrictions by referring to Section 3.3.18.

(2) The present value change program and the positioning start program are the same, except that the data number for positioning is 9003.
Thus, the present value cannot be changed while the "stop command" and the "M code ON flag" remain ON.

(3) *: The positioning completion processing is the same as that executed by the positioning start program.
The positioning start signal can be turned OFF in the start completion processing of a positioning start program even if the program is not for a present value change.

(4) A new present value outside the stroke limit range does not cause an error.
However, an "operation start outside software stroke limit range" error will occur at the beginning of the following positioning.

11.1 Present Value Change Program Using Positioning Data No. 9003

This section describes an example of a program for changing the feed present value by starting positioning data No. 9003.

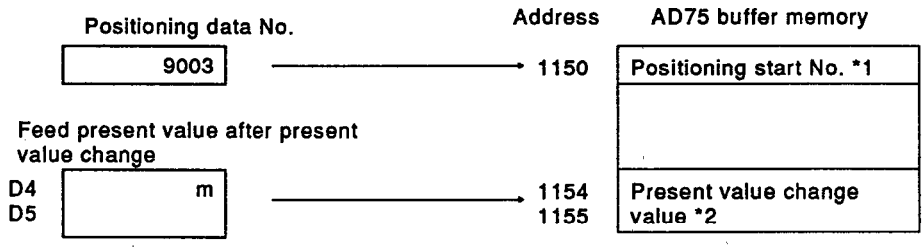
(1) Condition

- Set a new present value in the present value change value area prior to present value change.

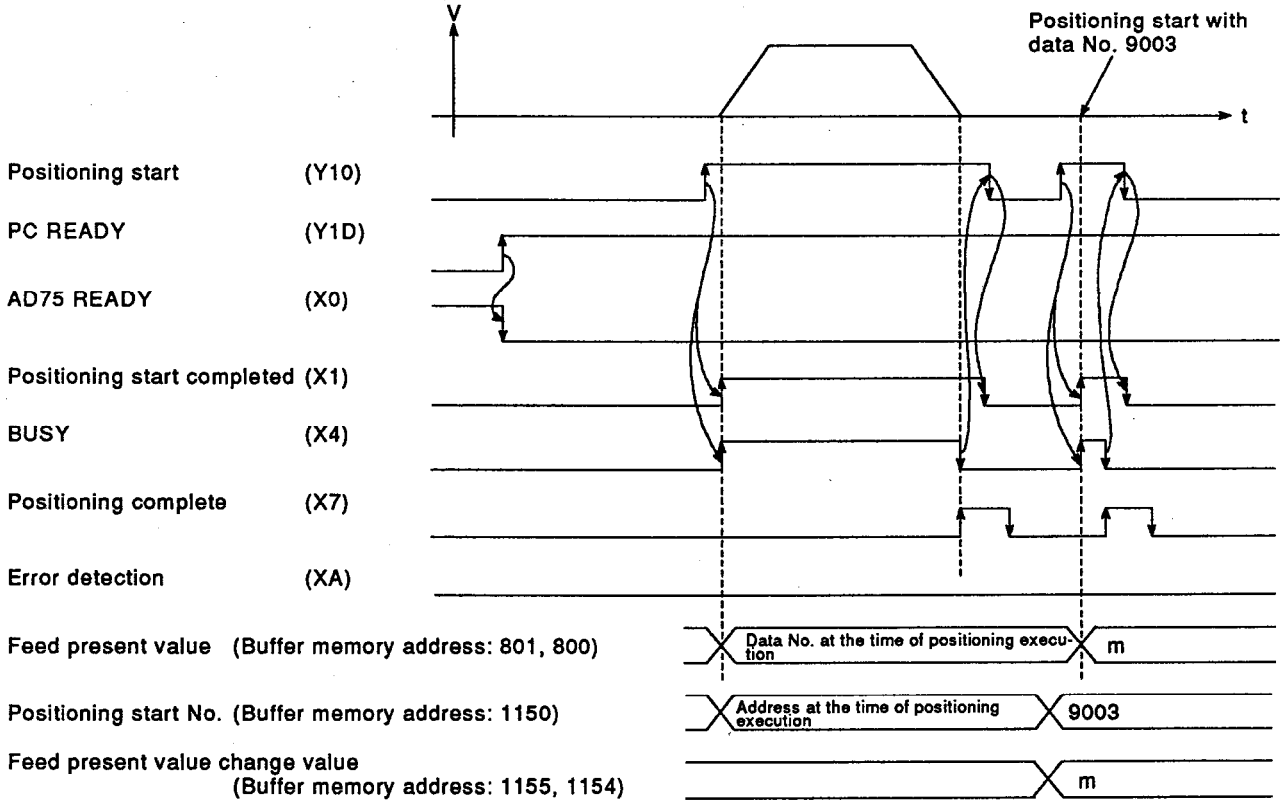
(2) Program example

- The program shown here changes the present value of axis 1.

(a) Data transfer



(b) I/O signals



REMARKS

1) *1: For details on positioning start numbers, see Section 3.4.5.
2) *2: For details on the present value change value area in the buffer memory, see Section 3.6.4.

11. PRESENT VALUE CHANGE

Present value change means changing the feed present value of an axis at rest. (For details of present value change, see Section 3.3.18.)

Present value change can be executed in the following two ways:

- Using positioning data No. 9003 ..... See Section 11.1.
- Using the present value change as the control method ..... See Section 11.2.

This chapter describes programming for changing the feed present value of an axis from the ACPU using the above approaches.

POINTS

(1) Present value change using positioning data No. 9003
Write data No. 9003 to the positioning start number area in the buffer memory and turn ON the positioning start signal. *1

(2) Present value change using "present value change" as the control method

(a) Write the positioning data number for which present value change is designated to the positioning start number area in the buffer memory and turn ON the positioning start signal.

(b) A positioning data number for which present value change is designated as the control method can be set after the positioning data number set in the positioning start data block in the start information area. *2
This data is used to perform present value change during continuous positioning of two or more data blocks according to the start information.

REMARKS

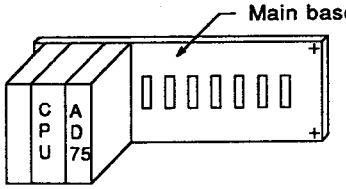
1) *1: The positioning start number area is located at the following buffer memory addresses. (See Section 3.6.4.)

Axis No.	Axis 1	Axis 2	Axis 3
Positioning start number area	1150	1200	1250

2) *2: The positioning start area is located at the following buffer memory addresses. (See Section 3.6.6.)

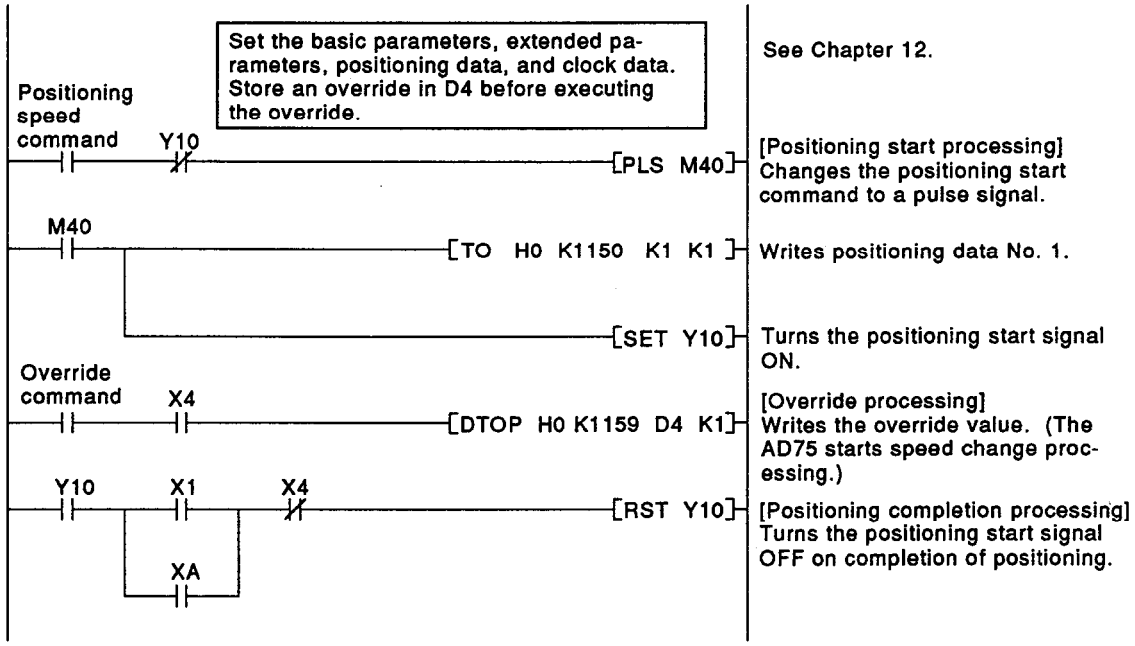
Axis No.	Axis 1	Axis 2	Axis 3
Positioning start data area	4300 to 4349	4550 to 4599	4800 to 4849

3) Unless otherwise stated, this section shows sequence programs to be used under the following conditions:
- CPU*: A3UCPU
- AD75 I/O signals: X/Y00$_H$ to X/Y1F$_H$
(when the AD75 is loaded at slot 0 of the main base unit)



MEMO

(c) Program



POINTS

(1) Before executing a speed change, check the override operation and applicable restrictions by referring to Section 3.3.24.

(2) For interpolation operation, use the set positioning operation speed override value for the reference axis.

(3) When the override value is 100 %, the current speed remains unchanged.

(4) If the override value for the deceleration speed is changed during deceleration in response to a stop command, or during automatic deceleration during position control, the new value will not become effective until motion has stopped after deceleration.

(5) If the override speed exceeds the speed control limit, the limit is used as the positioning speed.

(6) If the remaining distance is not long enough to increase the speed to the override value during position control, positioning is performed at the highest possible speed.

10.2 Override Programs

The positioning speed (current speed) can be overridden within the range of 1 to 300 % in 1 % increments to change the speed.
When a speed change is performed during positioning, the changed positioning speed is also overridden.

This section shows program examples for changing the present positioning speed using the override function.

(1) Conditions

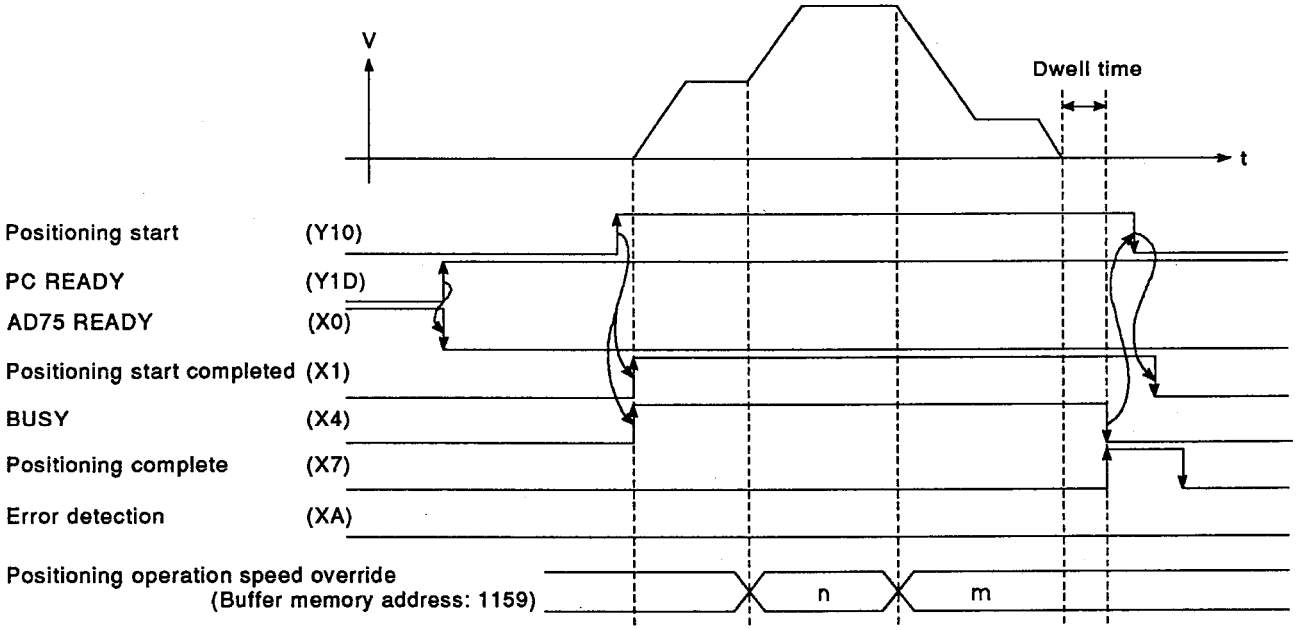
- Set a positioning speed override value during positioning.

(2) Program example

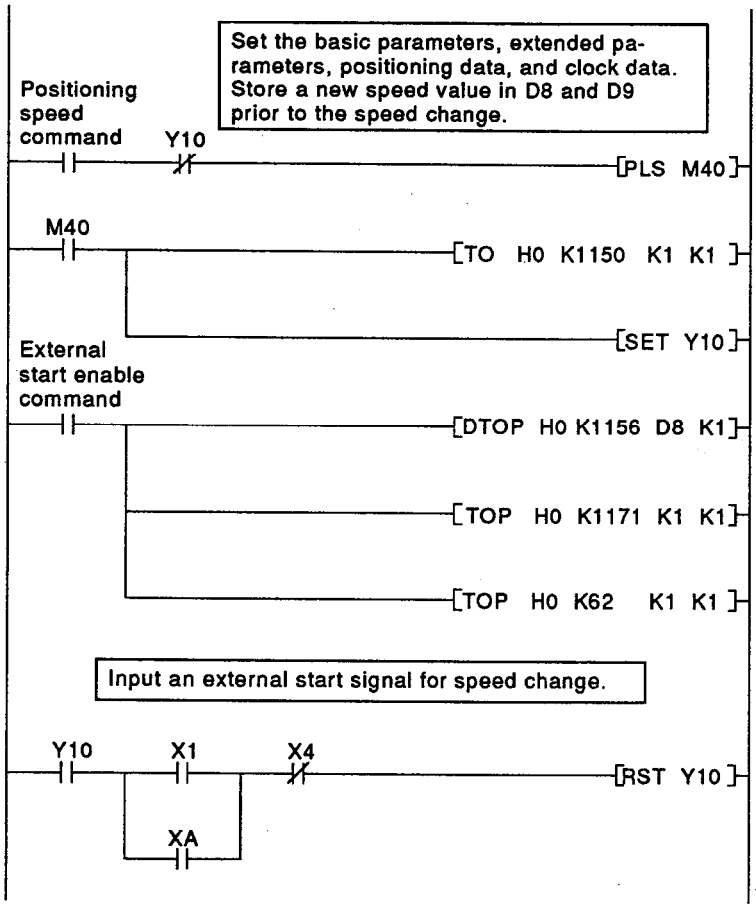
- The program shown here changes the positioning speed of axis 1.

(a) Data transfer

(b) I/O signals



(c) Program



POINTS

(1) When "external speed change request" is selected using external start function selection, set the speed change value (address: 1156/1206/1256) before inputting the external start signal.
When "skip request" is selected, no settings have to be made.
Whichever function is selected, the timing for external start function selection and external start "valid" setting is the same as when "external positioning start" is selected.

(2) External start is a function whereby the command is input directly into the AD75. Use of an external start signal can eliminate timing variations of up to one ACPU scan time.
This is useful when an earlier start by command input or reduction of variation is desired.

(3) The external start valid setting prevents actuation of the selected function by incorrect input.
In order to stop the selected function being actuated by input of the external start signal, it is recommended that "invalid" be set.

(4) Before using any of the functions, check the operation and applicable restrictions by referring to the following sections on the functions that can be selected by external start function selection.
- External positioning start : See Sections 3.3.1 to 3.3.7 and Section 7.3.1.
- External speed change request : See Section 3.3.19, Section 10.
- Skip request : See Section 3.3.20.

(5) For interpolation operation, use the speed change value and external start signal for the reference axis.

10.1.2 Program to change the speed from an external device

This section shows an example of a program in which the speed is changed from an external source during positioning operation by selecting "external speed change request" in external positioning start selection.

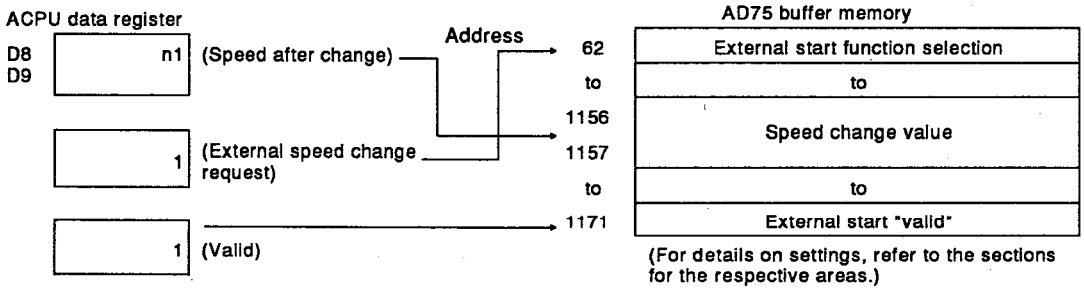
(1) Conditions

- Select external speed change request using the external positioning function selection.
- Carry out the following setting before inputting the external start signal.
  1) Set external start "valid".
  2) Set the speed change value.

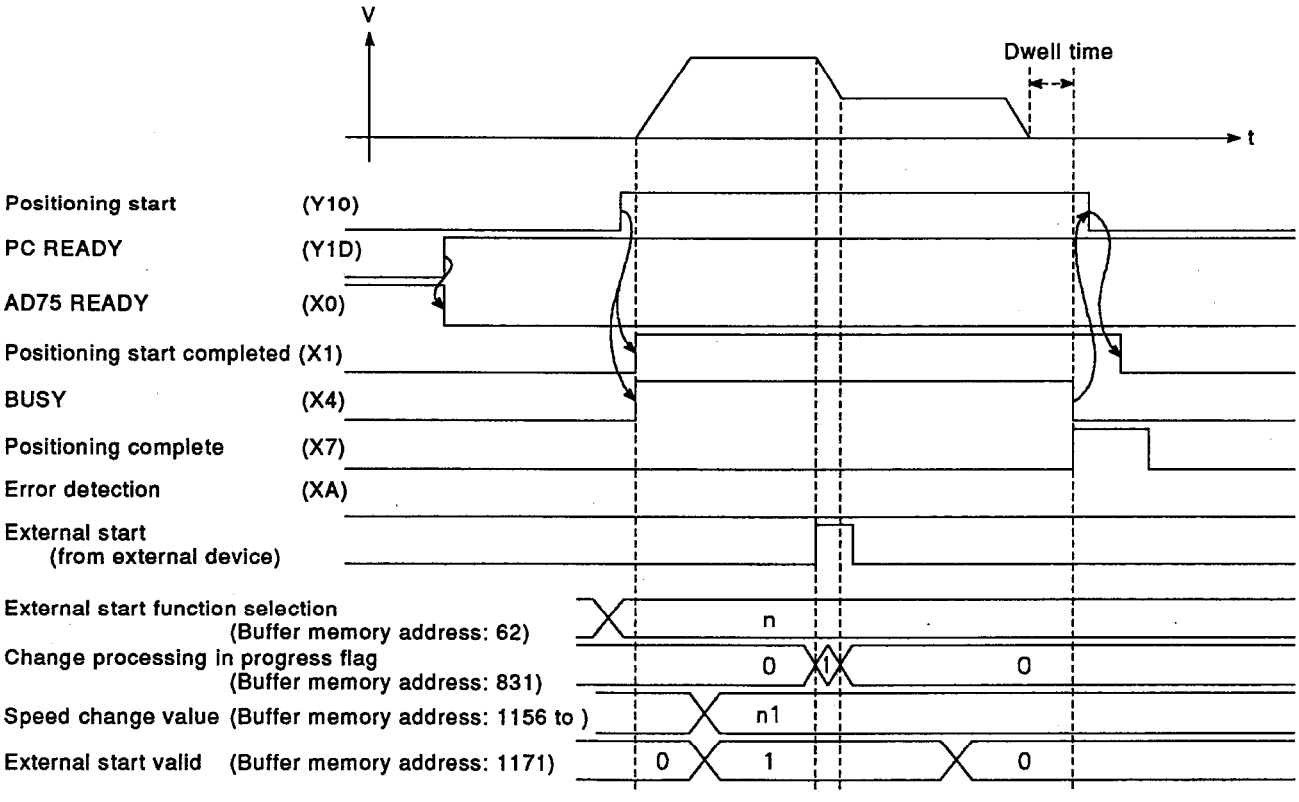
(2) Program example

- The program shown here issues a speed change request from an external device to axis 1.

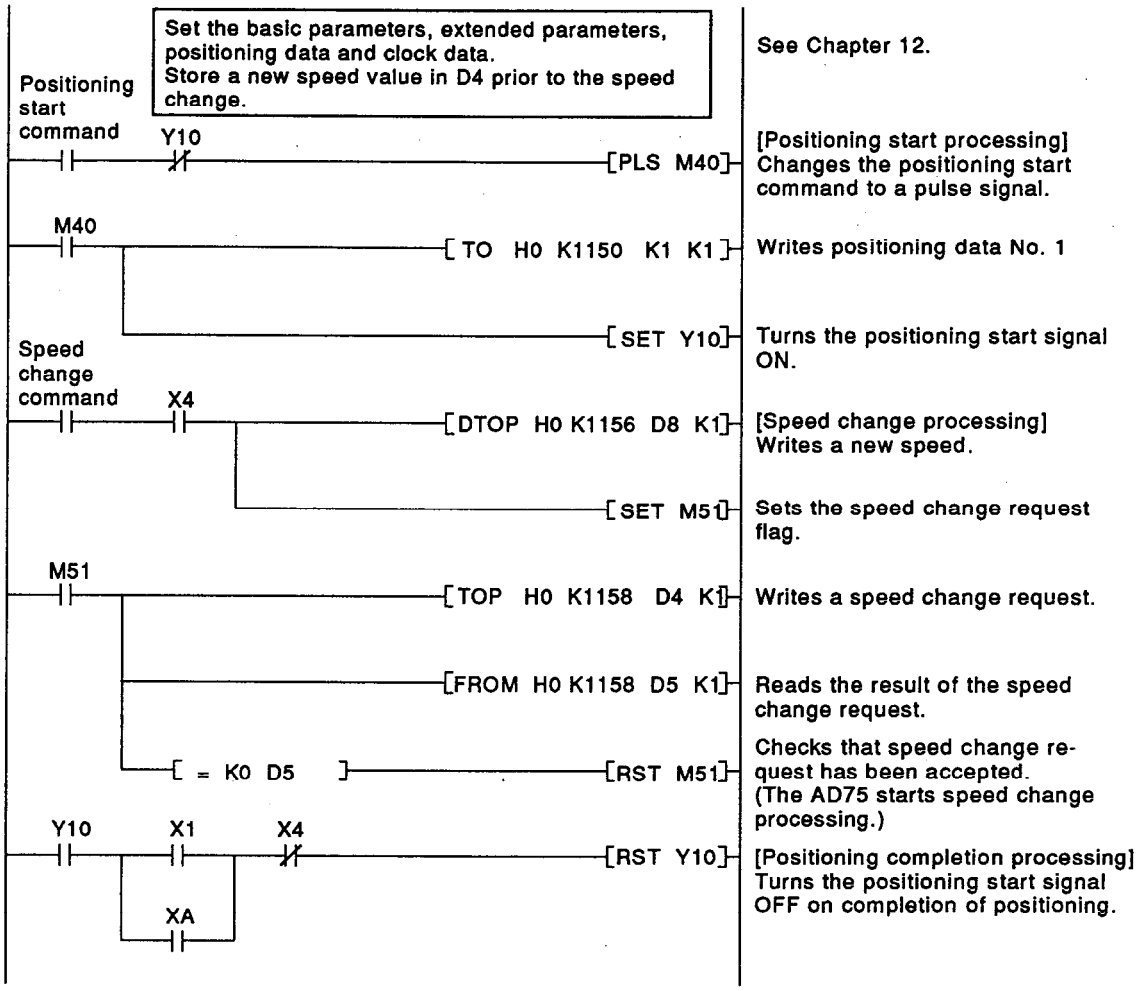
(a) Data transfer



(b) I/O signals



(c) Program



POINTS

(1) Before performing a speed change, check the speed change operation and applicable restrictions by referring to Section 3.3.19.

(2) For interpolation operation, use the speed change value and speed change request for the reference axis.

10.1 Speed Change Programs

This section shows program examples for changing the present positioning speed using the speed change function.

10.1.1 Program to change the speed from the ACPU

Shown below is a program example for changing the speed from the ACPU in response to a positioning speed change request in the axis control data.

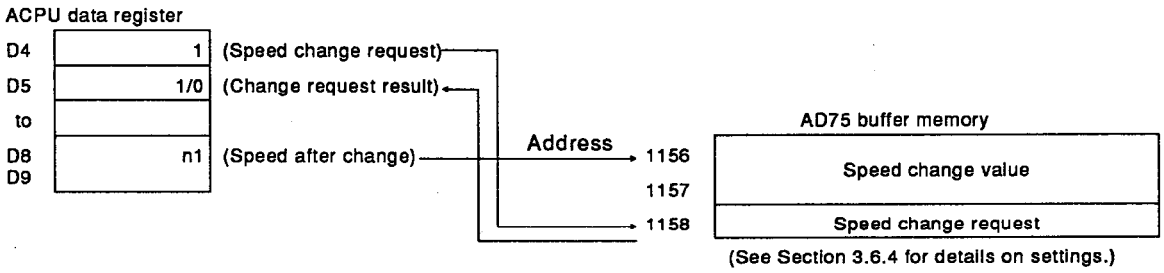
(1) Conditions

- Set a speed change value before issuing a speed change request.

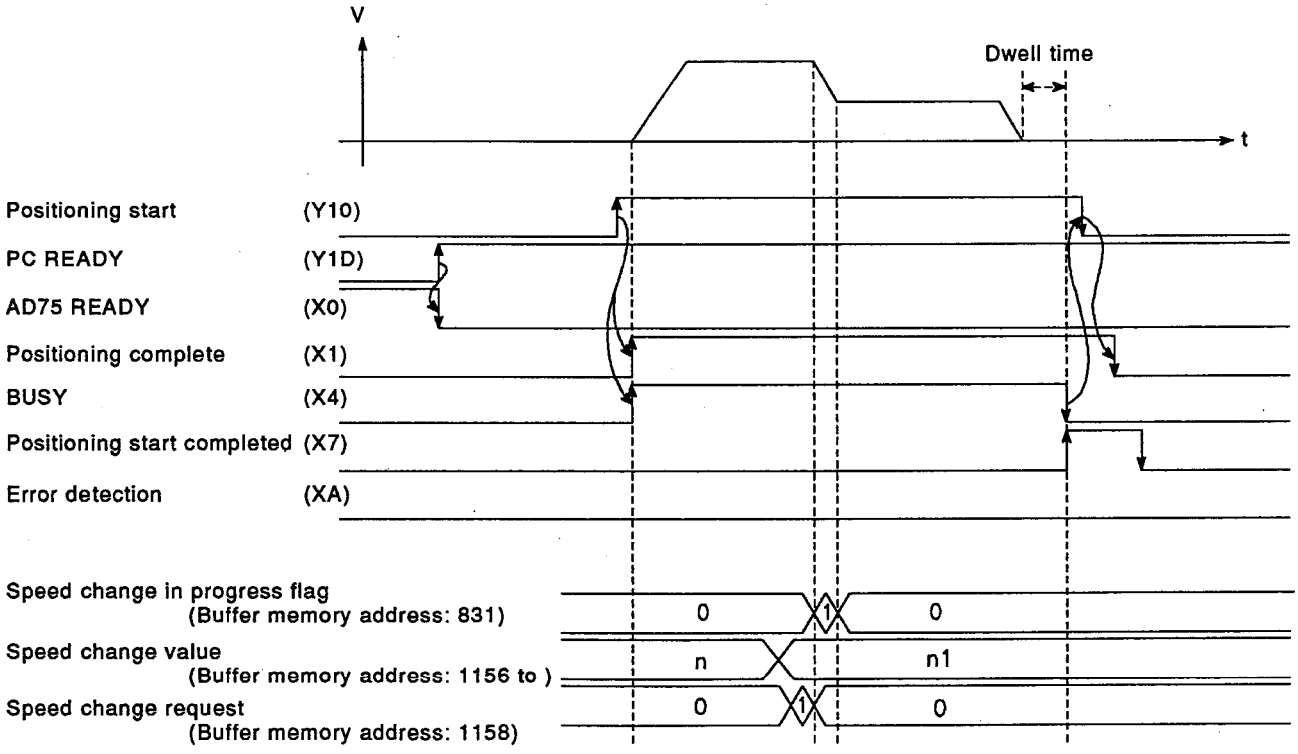
(2) Program example

- The program shown here issues a speed change request for axis 1.

(a) Data transfer



(b) I/O signals



10. SPEED CHANGE AND OVERRIDE

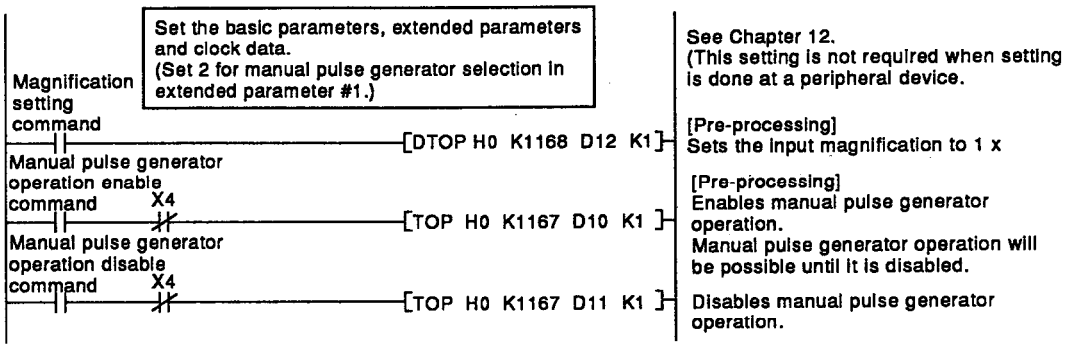
Speed changes and overrides can be executed at any time from the ACPU, an external device or the AD75P, by changing the positioning speed within the speed control limit range.

This chapter describes the use of the speed change and override functions in programming to change the positioning speed from the ACPU or an external device.
For speed changes from the AD75P in the test mode, see the AD75P Operating Manual.

REMARK

Unless otherwise specified, this section shows the sequence program when the ACPU at the station where the AD75 is installed is an A3UCPU and the I/O signals of the AD75 as seen from the A3UCPU are 00H to 1FH.

(c) Program



POINTS

(1) Positioning control is carried out based on the parameter settings and the number of pulses input from the manual pulse generator, as follows.

$$\text{[Travel value]} = \left(\begin{array}{l}\text{Number of}\\ \text{input}\\ \text{pulses}\end{array}\right) \times \left(\begin{array}{l}\text{Manual pulse gener-}\\ \text{ator 1 pulse input}\\ \text{magnification setting}\end{array}\right) \times \left(\begin{array}{l}\text{Travel}\\ \text{value}\\ \text{per pulse}\end{array}\right)$$

$$\text{[Output speed]} = \left(\begin{array}{l}\text{Number of input}\\ \text{pulses per con-}\\ \text{trol cycle time}\end{array}\right) \times \left(\begin{array}{l}\text{Manual pulse gener-}\\ \text{ator 1 input magnifi-}\\ \text{cation setting}\end{array}\right) \times \left(\begin{array}{l}\text{Travel}\\ \text{value}\\ \text{per pulse}\end{array}\right)$$

(2) The last pulse is output with a delay of 1 control cycle time (about 100 ms).

(3) The torque limit during manual pulse generator operation is controlled in accordance with the parameter setting value or torque change value.

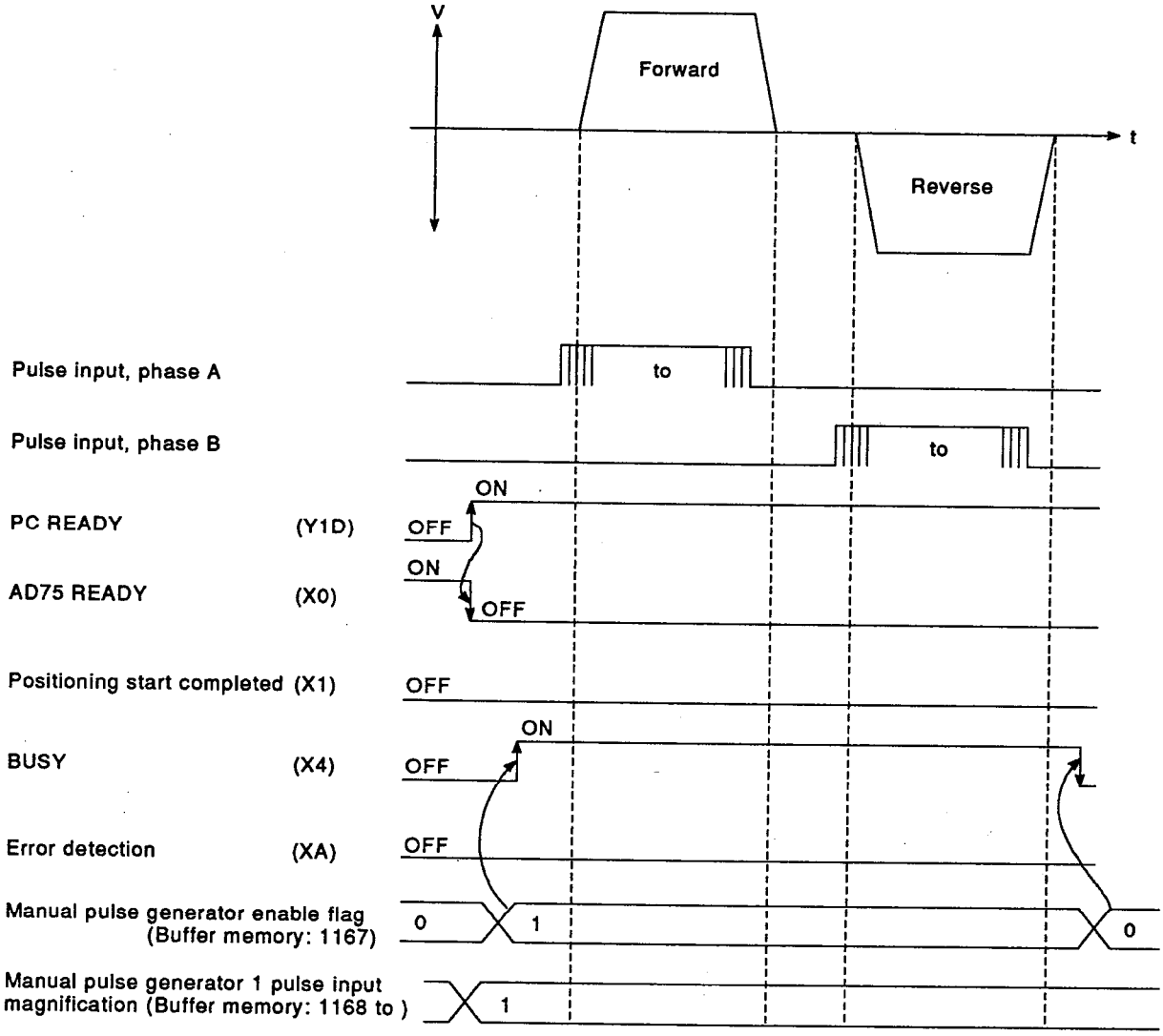
(4) After the upper/lower limit switch signal has been turned OFF during manual pulse generator operation, causing deceleration to a stop, input pulses for travel in the direction that caused the limit switch signal to go OFF are not acknowledged.
Input pulses in the direction that cause the limit switch signal to come ON are acknowledged.

(5) When the manual pulse generator operation is completed, the manual pulse generator enable flag must be set to 0.
If it is left set at "1" (enabled), inadvertent operation at the manual pulse generator will cause incorrect positioning operation.

(6) When manual pulse generator operation is used to determine a positioning data address, the "feed present value" stored in the buffer memory (axis 1: 800, 801) is used when travelling to the target position is completed.

(7) Before carrying out manual pulse generator operation, check the details of manual pulse generator operation and applicable restrictions by referring to Section 3.3.9.

(b) I/O signals



REMARK

When a stop signal is input during a manual pulse generator operation, the BUSY signal is turned OFF.
Before reattempting manual pulse generator operation, set the manual pulse generator enable flag from 0 to 1.

9.3 Programming

This section describes a sequence program for the pre/post-processing by the ACPU to carry out a manual pulse generator operation.

9.3.1 Manual pulse generator operation program

An example of pre/post-processing program for a manual pulse generator operation is shown here.

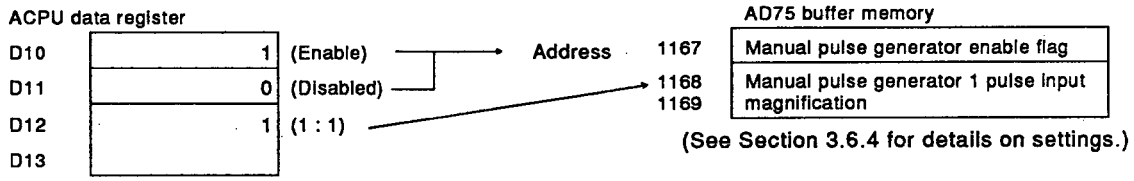
(1) Conditions

- Set the basic parameters and extended parameters.
- Set the clock data as required.
- Carry out the pre-processing when the BUSY signal is OFF.

(2) Program example

- The program shown below executes the pre/post-processing for a manual pulse generator operation at axis 1.

(a) Data transfer



(See Section 3.6.4 for details on settings.)

9.2 Buffer Memory for Manual Pulse Generator Monitor

The following statuses are stored in a buffer memory when manual pulse generator operation is executed and can be monitored as required by reading the buffer memory.

(1) System monitor area

The items monitored in the system monitor area for monitoring the buffer memory in the AD75 are the same as for positioning.

(2) Axis monitor area
Check these by referring to Section 7.2.1.

Monitor Item	Buffer Memory			Description of Monitor Item	References
	Axis 1	Axis 2	Axis 3		
Feed present value	800 801	900 901	1000 1001	The present position is stored. The home position address is stored on completion of home position return.	Section 3.6.3 (2)
Machine feed value	802 803	902 903	1002 1003	The present position in reference to a home position determined by the characteristics of the machine (in the machine coordinate system) is stored. The home position address is stored on completion of home position return.	
Feed speed	804 805	904 905	1004 1005	Stores the present speed. ("0" for stop)	
Axis error code	807	907	1007	The latest axis error code is stored. When an axis error is reset, "0" is stored. (For the axis 1, reset is requested using the buffer memory address "1151".)	
Axis warning code	808	908	1008	The latest axis warning code is stored. When an axis error is reset, "0" is stored. (For axis 1, reset is requested using the buffer memory address "1151".)	
Axis operation status	809	909	1009	The axis operation status (error, stand-by, or positioning control in progress) is stored.	
Axis feed speed	812 813	912 913	1012 1013	The present speed is stored. ("0" for stop)	
External I/O signal	816	916	1016	The ON/OFF status of the I/O signal to/from external devices is stored.	
Status	817	917	1017	The ON/OFF status of various flags used by the AD75 is stored.	
Absolute original point	822 823	922 923	1022 1023	The address home position return is stored. The position is not established when the power is turned on.	
Torque control value	826	926	1026	The torque limit value/torque change value are stored.	

9.1 Parameter Setting for Manual Pulse Generator Operation

Manual pulse generator operation is carried out from the pulse input of the manual pulse generator.

This section describes the setting of basic parameters and extended parameters required for manual pulse generator operation.

POINTS

(1) Setting of basic parameters and extended parameters in the AD75 is required for manual pulse generator operation.
Check the details on parameters in this section and carry out setting at the AD75 before starting manual pulse generator operation.

(2) For parameter setting in the AD75P, refer to the operating manual of the AD75P.

(1) Basic parameters

The basic parameters that must be set at the AD75 are the same as those for positioning.
Check these settings by referring to Section 7.1.2 (1).

(2) Extended parameters

The extended parameters that must be set at the AD75 are tabled below.

Items to be Set	Buffer Memory			Description of Setting Items	References			
	Axis 1	Axis 2	Axis 3		Details of Settings	Setting Values		Sequence Program Setting Method
						Sequence Program	AD75P	
Backlash compensation amount	15	165	315	Set the machine backlash compensation amount for changes in positioning direction.	Section 3.4.2	Section 3.6.2 (3) (4)	Section 3.4.2	Section 12.3
Software upper stroke limit	16 17	166 167	316 317	Set the upper limit of the machine travel range.				
Software lower stroke limit	18 19	168 169	318 319	Set the lower limit of the machine travel range.				
Software stroke limit selection	20	170	320	Set the software stroke limit for either the feed present value or machine present value.				
Software stroke limit validity in JOG operation, manual pulse generator operation	21	171	321	Set whether or not the software stroke limit is valid in manual pulse generator operation.				
Torque limit setting value	24	174	324	Set the torque limit value.				
Manual pulse generator selection	29	179	329	Set the manual pulse generator to be used. (Setting value n (1 to 3) corresponds to axis No. 1 to 3.)				

9. MANUAL PULSE GENERATOR OPERATION

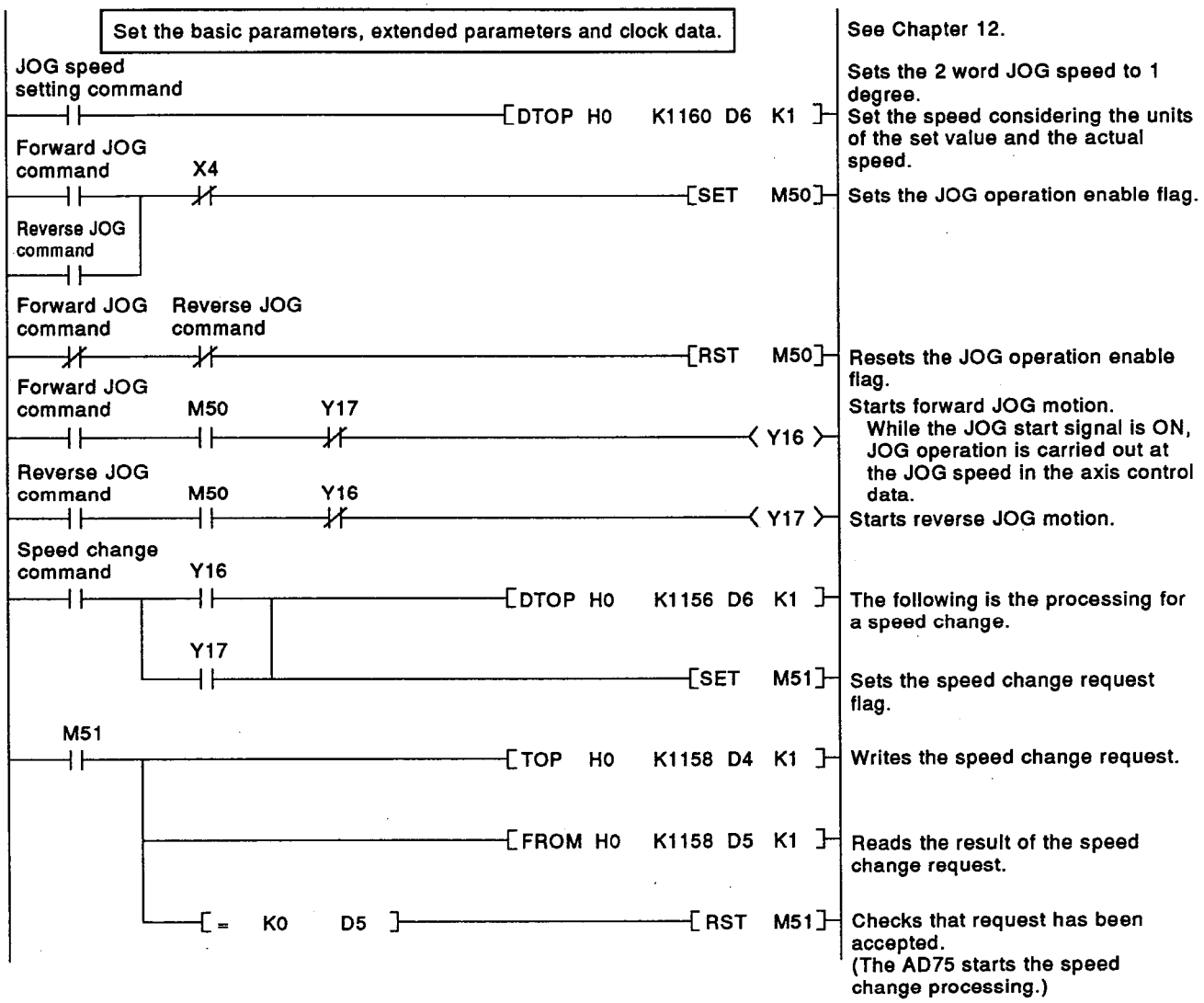
Manual pulse generator operation is a positioning operation in which pulses are input from a manual pulse generator to the AD75 to move the applicable axis by a distance commensurate with the number of input pulses.

Manual pulse generator operation is used for precise manual positioning.

Set the basic parameters and extended parameters in accordance with the positioning system configuration, carry out manual pulse generator selection, and enable manual pulse generator operation, before starting manual pulse generator operation.

This chapter describes the pre-processing and post-processing at the ACPU when manual pulse generator operation is executed on the basis of the basic parameters and extended parameters set at the AD75.

(c) Program



POINTS

(1) When JOG operation is used to determine a positioning data address, "the feed present value" (buffer memory address 800 and 801 for the axis 1) stored in the buffer memory is used on completing motion to the desired position.

(2) When the forward JOG signal and reverse JOG signal of the same axis are turned ON simultaneously, forward JOG operation is carried out.
When the forward JOG signal is turned off, causing deceleration to a stop, reverse JOG operation is carried out if the reverse JOG signal is ON.

(3) JOG operation is not carried out during operation from a peripheral device in the test mode.

(4) A JOG signal status change from OFF to ON is not acknowledged within 56.8 ms after the stop signal is turned OFF.

(5) Before carrying out JOG operation, check the details of JOG operation and applicable restrictions by referring to Section 3.3.10.

8.3 Programming

This section describes the sequence program used at the ACPU to request the AD75 to perform JOG operation.

REMARK

Unless otherwise specified, this section shows the sequence program when the ACPU at the station where the AD75 is installed is an A3UCPU and the I/O signals of the AD75 as seen from the A3UCPU are 00H to 1FH.

8.3.1 JOG operation program

A program example in which the ACPU requests the AD75 to start JOG operation is shown here.

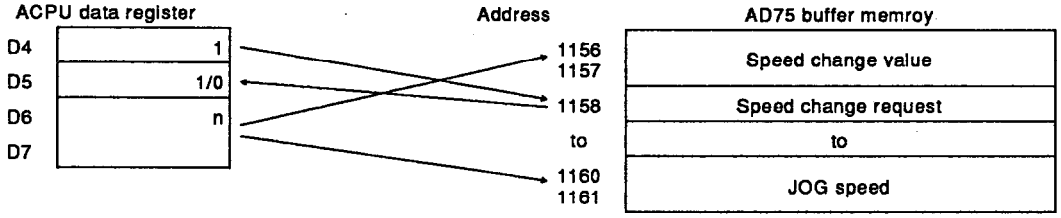
(1) Conditions

- Set the basic parameters, extended parameters and positioning data.
- Set the clock data as required.
- Start operation when the BUSY signal is OFF.

(2) Program example

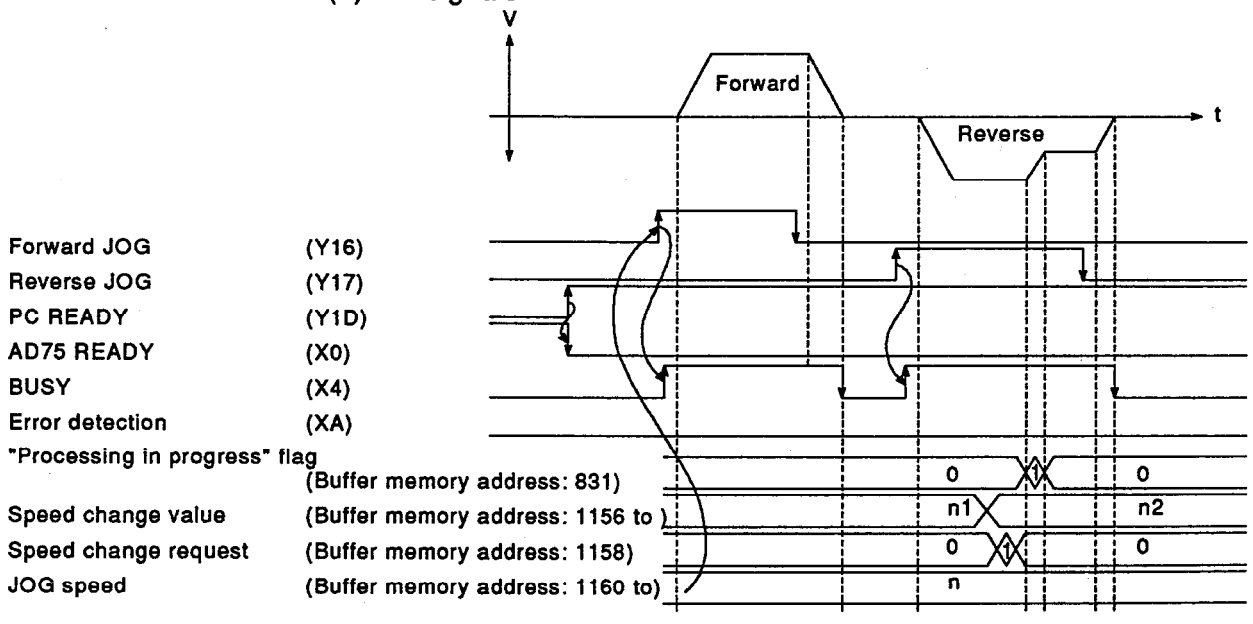
- A JOG operation request for the axis 1 is shown.

(a) Data transfer



(See Section 3.6.4 for details on JOG speed.)

(b) I/O signals



* If a stop signal is input during JOG operation, restart will not be possible without turning the JOG start signal ON again.

8.2 Buffer Memory for JOG Operation Monitor

The following statuses are stored in a buffer memory when JOG operation is executed and can be monitored as required by reading the buffer memory.

(1) System monitor area

The monitor item of the system monitor area for monitoring the buffer memory of the AD75 is the same as for positioning.
Check this according to Section 7.2.1.

(2) Axis monitor area

Items to be Set	Buffer Memory Address			Description of Monitor Items	References
	Axis 1	Axis 2	Axis 3		
Feed present value	800 801	900 901	1000 1001	The present position is stored. The home position address is stored on completion of home position return.	Section 3.6.3 (2)
Machine feed value	802 803	902 903	1002 1003	The present position in reference to a home position determined by the characteristics of the machine (in the machine coordinate system) is stored. The home position address is stored on completion of home position return.	
Feed speed	804 805	904 905	1004 1005	Stores the present speed. ("0" for stop)	
Axis error code	807	907	1007	The latest axis error code is stored. When an axis error is reset, "0" is stored. (For the axis 1, reset is requested using the buffer memory address "1151".)	
Axis warning code	808	908	1008	The latest axis warning code is stored. When an axis error is reset, "0" is stored. (For axis 1, reset is requested using the buffer memory address "1151".)	
Axis operation status	809	909	1009	The axis operation status (error, stand-by, or positioning control in progress) is stored.	
Axis feed speed	812 813	912 913	1012 1013	The present speed is stored. ("0" for stop)	
External I/O signal	816	916	1016	The ON/OFF status of the I/O signal to/from external devices is stored.	
Status	817	917	1017	The ON/OFF status of various flags used by the AD75 is stored.	
Target speed	820 821	920 921	1020 1021	The actual target speed taking into account the JOG speed control limit is stored. (0 is stored when the machine is not operating.)	
Absolute original point	822 823	922 923	1022 1023	The address home position return is stored. The position is not established when the power is turned on.	
Torque control value	826	926	1026	The torque limit value/torque change value are stored.	
Speed control limit in progress flag	830	930	1030	Whether the speed limit is controlled or not in the event of a speed change or positioning operation override is stored.	
Speed change processing in progress flag	831	931	1031	Whether speed change processing is in progress or not is stored.	

Items to be Set	Buffer Memory Address			Description of Setting Items	References			
	Axis 1	Axis 2	Axis 3		Details of Settings	Setting Values		Sequence Program Setting Method
						Sequence Program	AD75P	
JOG operation acceleration time selection	50	200	350	Sets which of acceleration times 0, 1 ,2 and 3 set in the basic parameters and extended parameters during JOG operation.	Section 3.4.2	Section 3.6.2 (3) (4)	Section 3.4.2	Section 12.3
JOG operation deceleration time selection	51	201	351	Sets which of deceleration times 0, 1, 2 and 3 set in the basic parameters and extended parameters is used during JOG operation.				
Acceleration/deceleration processing selection	52	202	352	Set the processing for acceleration/deceleration. (Trapezoidal or S pattern)				
S curve ratio	53	203	353	Set the S curve ratio in S pattern acceleration/deceleration processing				
Rapid stop deceleration time	54 55	204 205	354 355	Set the time taken to reach speed 0 from the speed control limit when a rapid stop is executed.				
Stop group 1 to 3 Rapid stop selection	56 57	206 207	356 357	Select the normal deceleration stop or rapid stop for each group.*1				
External start function selection	58 62	208 212	358 362	External speed change request is set with the input of external start signal. *2				

*1 Stop causes for each group

- Stop group 1: H/W stroke limit
- Stop group 2: Software stroke limit, peripheral device stop, PC READY OFF
- Stop group 3: Stop with stop signal, occurrence of error (other than stop groups 1 and 2)

*2 When the JOG speed change command is input from an external source using an external start signal, carry out the following setting.

- Set an external speed change request using the external start function selection of extended parameter #2.
- Set the external start valid setting (buffer memory address: 1171, 1221, and 1271) before starting.

8.1 Parameter Settings Required for JOG Operation

JOG operation is carried out by turning the forward/reverse output signal for each axis ON and OFF from the ACPU.
This section describes the basic parameter and extended parameter settings required for JOG operation.

POINTS

(1) To carry out a JOG operation, the basic parameters and extended parameters for the AD75 must be set.

(2) For details on the method for setting the parameters with the AD75P, refer to the operating manual of the AD75P.

(1) Basic parameters

The basic parameter settings (set at addresses 0 to 11 for the axis 1) to be made in the buffer memory of the AD75 are the same as those for positioning.
Check the settings by referring to Section 7.1 (1). (When checking, switch positioning operation to JOG operation.)

(2) Extended parameters

The table below shows the extended parameter settings to be made in the buffer memory of the AD75.

Items to be Set	Buffer Memory Address			Description of Setting Items	References			
	Axis 1	Axis 2	Axis 3		Details of Settings	Setting Values: Sequence Program	Setting Values: AD75P	Sequence Program Setting Method
Backlash compensation amount	15	165	315	Set the machine backlash compensation amount for changes in positioning direction.	Section 3.4.2	Section 3.6.2 (3) (4)	Section 3.4.2	Section 12.3
Software upper stroke limit	16 17	166 167	316 317	Set the upper limit of the machine travel range.				
Software lower stroke limit	18 19	168 169	318 319	Set the lower limit of the machine travel range.				
Software stroke limit selection	20	170	320	Set the software stroke limit for either the feed present value or machine present value.				
Software stroke limit validity in JOG operation, manual pulse generator operation	21	171	321	Set whether or not the software stroke limit is valid in JOG operation.				
Torque limit setting value	24	174	324	Set the torque limit value.				
Acceleration time 1 to 3	36 to	186 to	336 to	Set the time taken to reach the speed control limit from speed 0.				
Deceleration time 1 to 3	42 to	192 to	342 to	Set the time from the speed control limit to speed 0.				
JOG speed limit value	48 49	198 199	348 349	Set the maximum speed for JOG operation to a value lower than the speed limit value in the basic parameters.				

8. JOG OPERATION

JOG operation is a positioning operation used to determine the positioning address of the positioning data for an axis, or to move an axis in the reverse direction for home position return. JOG operation can be carried out from the ACPU or the AD75P.

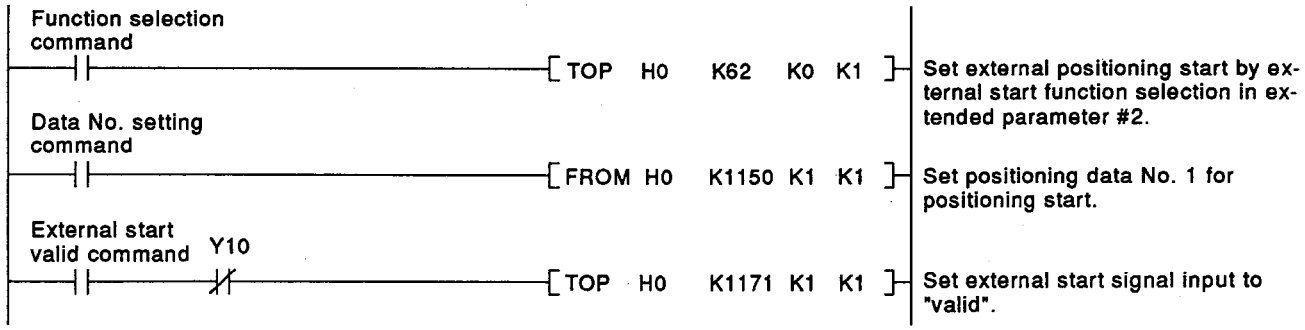
The basic parameters and extended parameters are set for each axis according to the positioning system configuration, then JOG operation is carried out by turning the output signal for the JOG operation ON and OFF.

This chapter describes a JOG operation from the ACPU executed in accordance with the basic parameters and extended parameters set in the AD75. For details on JOG operation from the AD75P, refer to the operating manual of the AD75P.

POINT

When using JOG operation to determine a positioning address, you are recommended to use a slow JOG speed.
(Set the JOG speed in the axis control data area in the buffer memory. For axis 1, set the JOG speed in buffer memory address 1160.)

(c) Program



POINTS

(1) When "External speed change request" is selected using external start function selection, set the speed change value (address: 1156 to/1206 to/1256 to) before inputting the external start signal.
When "Skip request" is selected, no settings have to be made.
Whichever function is selected, the timing for external start function selection and external start "Valid" setting is the same as when "External positioning start" is selected.

(2) External start is a function whereby the command is input directly into the AD75.
Use of an external start signal eliminates the effects of variation in ACPU scan time.
This is useful when an earlier start by command input or reduction of variation is desired.

(3) The external start valid setting prevents actuation of the selected function by incorrect input.
In order to stop the selected function being actuated by input of the external start signal, it is recommended that "Invalid" be set.

(4) Before using any of the functions, check the operation and applicable restrictions by referring to the following sections on the functions that can be selected by external start function selection.

- External positioning start : See Sections 3.3.1 to 3.3.7 and Section 7.3.1.
- External speed change request : See Section 3.3.19, Section 10.
- Skip request : See Section 3.3.20.

7.3.5 Program for handling an external start signal

The following functions can be executed in accordance with the external start function selection (buffer memory address: 62/112/362) by inputting an external start signal.

- When external positioning start is selected
  Positioning start can be carried out in accordance with the pre-set positioning start No.
- When external speed change is selected
  Speed during positioning can be changed to a pre-set speed.
- When skip request is selected
  Positioning operation using the present data No. can be stopped (by deceleration stop) and operation continued from the next positioning operation.

This section shows an example of an external positioning start program in which external positioning is started from an external source by external positioning start selection.

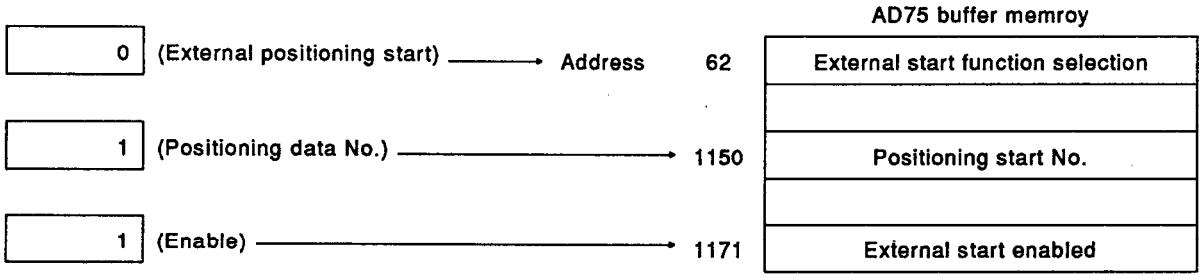
(1) Conditions

- Select external positioning start using the external positioning function selection.
- Carry out the following setting before inputting the external start signal.
  1) Set external start "valid".
  2) Set the positioning start No.

(2) Program example

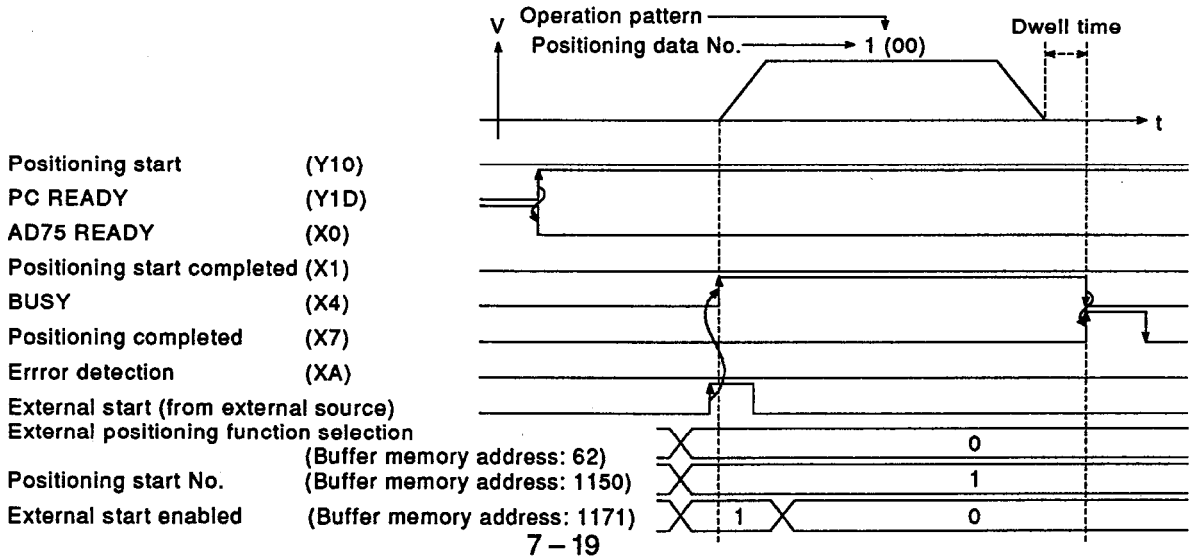
- The program shown here executes an external positioning start for the axis 1, which is in the stand-by status.

(a) Data transfer

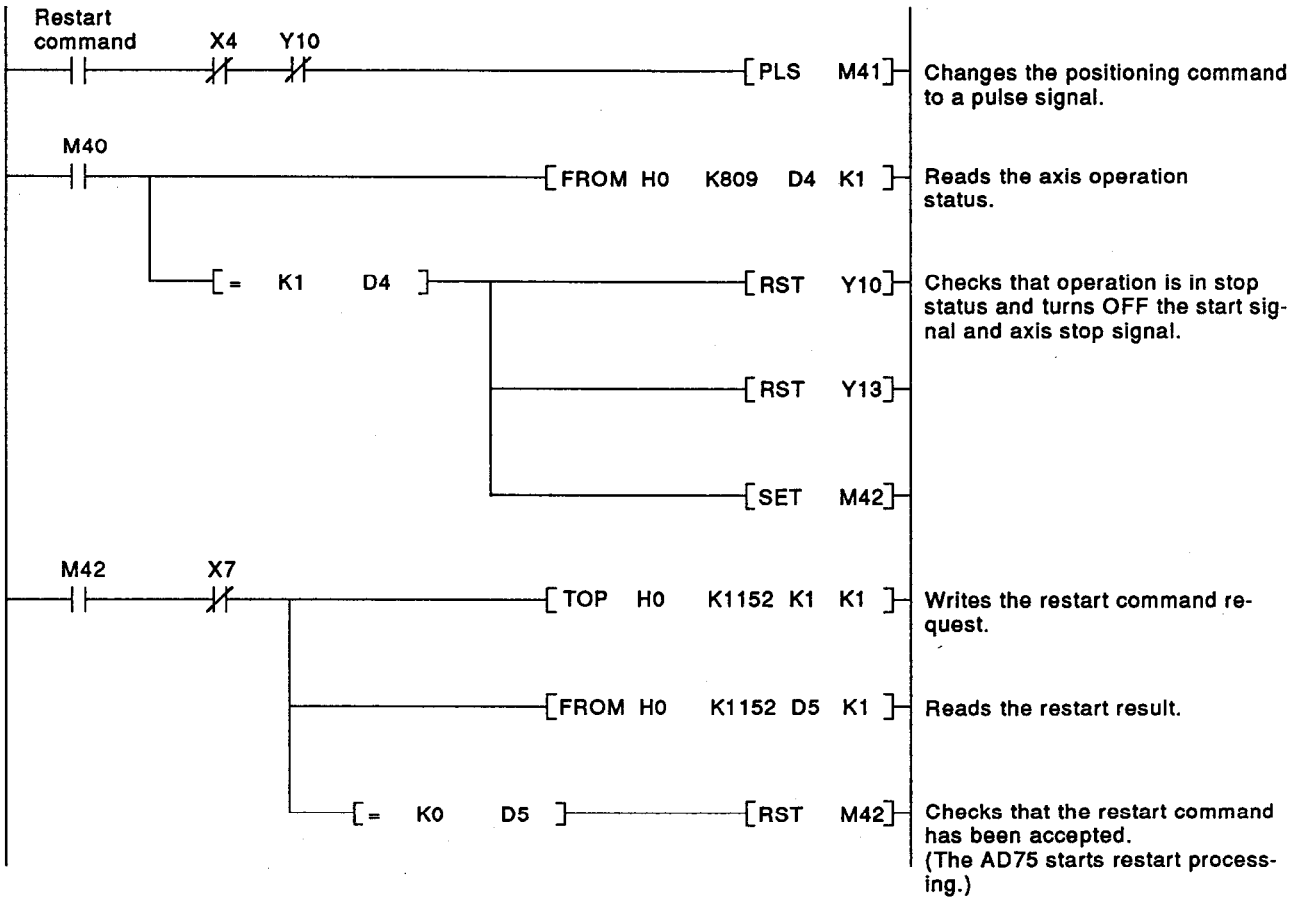


(For details on the set values refer to the sections for respective areas.)

(b) I/O signals



(c) Program



POINTS

(1) If a restart command request is issued when axis operation is in the stopped status and the positioning data is for position control, positioning control is carried out from the stop position to the end of the stopped positioning data, regardless of whether the AD75 is an absolute data type or incremental type.
When a restart is executed while axis operation is in the stopped status during block positioning based on the positioning start information, positioning control is carried out from the stop position to the final positioning data of the point, then control continues to the positioning in the next point.

(2) When an interpolation operation is in the stopped status, write the restart request to the restart area of the reference axis to execute restart.

(3) If axis operation is not in the stopped status when a restart is attempted, a multiple start warning occurs, and the current processing is continued.
If this happens, change the value written in the restart command area from 1 to 0.

(4) Before restarting the operation, check the restart procedure by referring to Section 1.2.4.

7.3.4 Program for restarting after a stop

An example of a restart program when the ACPU requests the AD75 to start positioning operation after a stop signal has been input from the ACPU or an external source during positioning operation and the AD75 is in the stopped status, is shown here.
Even an axis which has been set to the stopped status in block positioning based on positioning start information (by execution of the "stop" special start instruction) can be started with this program.

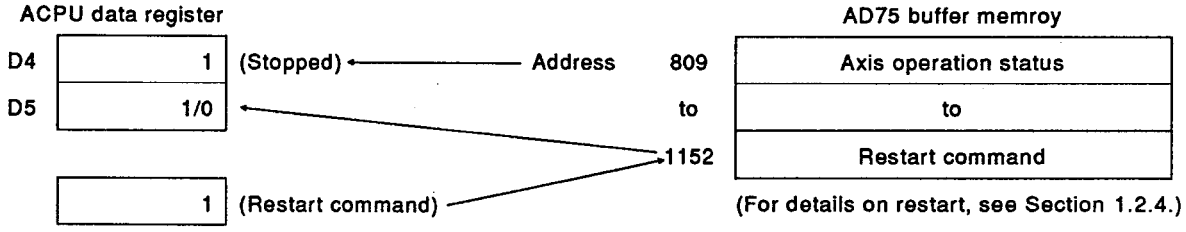
(1) Conditions

- Start operation for the following conditions.
  1) The positioning data is for position control and the axis operation status is "stopped".
  2) The BUSY signal, positioning start signal and positioning completed signal are OFF.

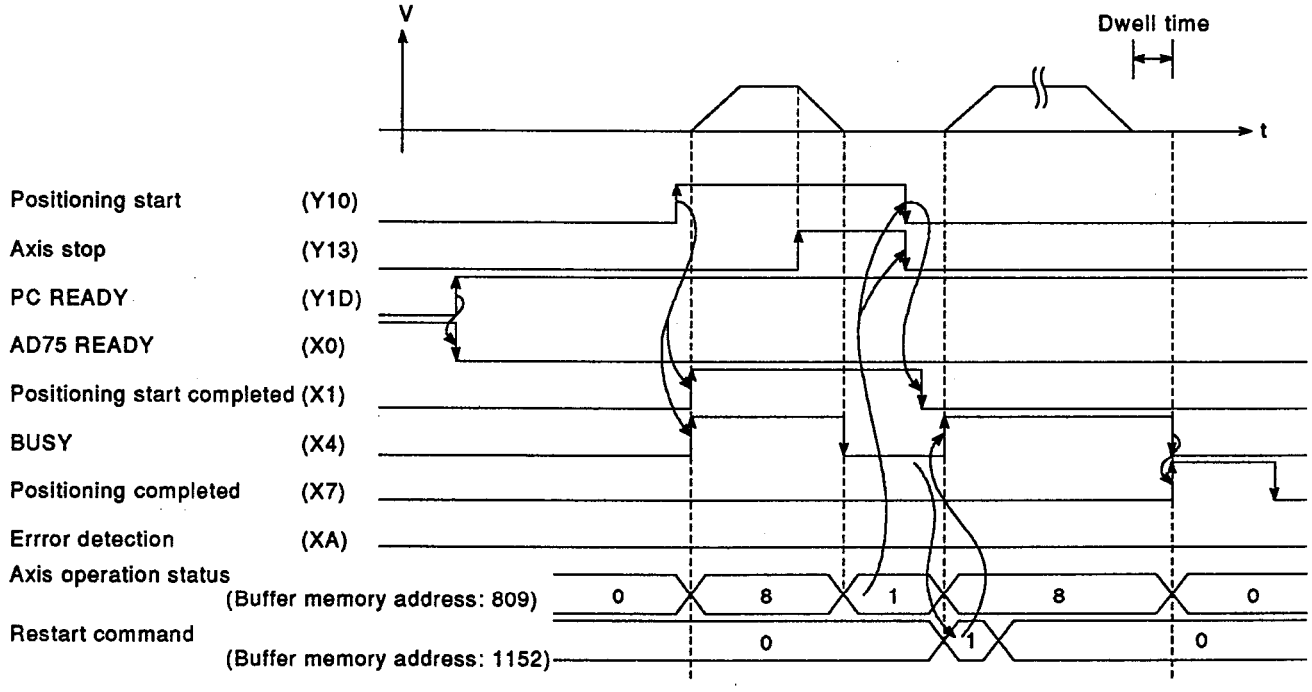
(2) Program example

- The program shown here restarts positioning for the axis 1, which is in the stopped status.

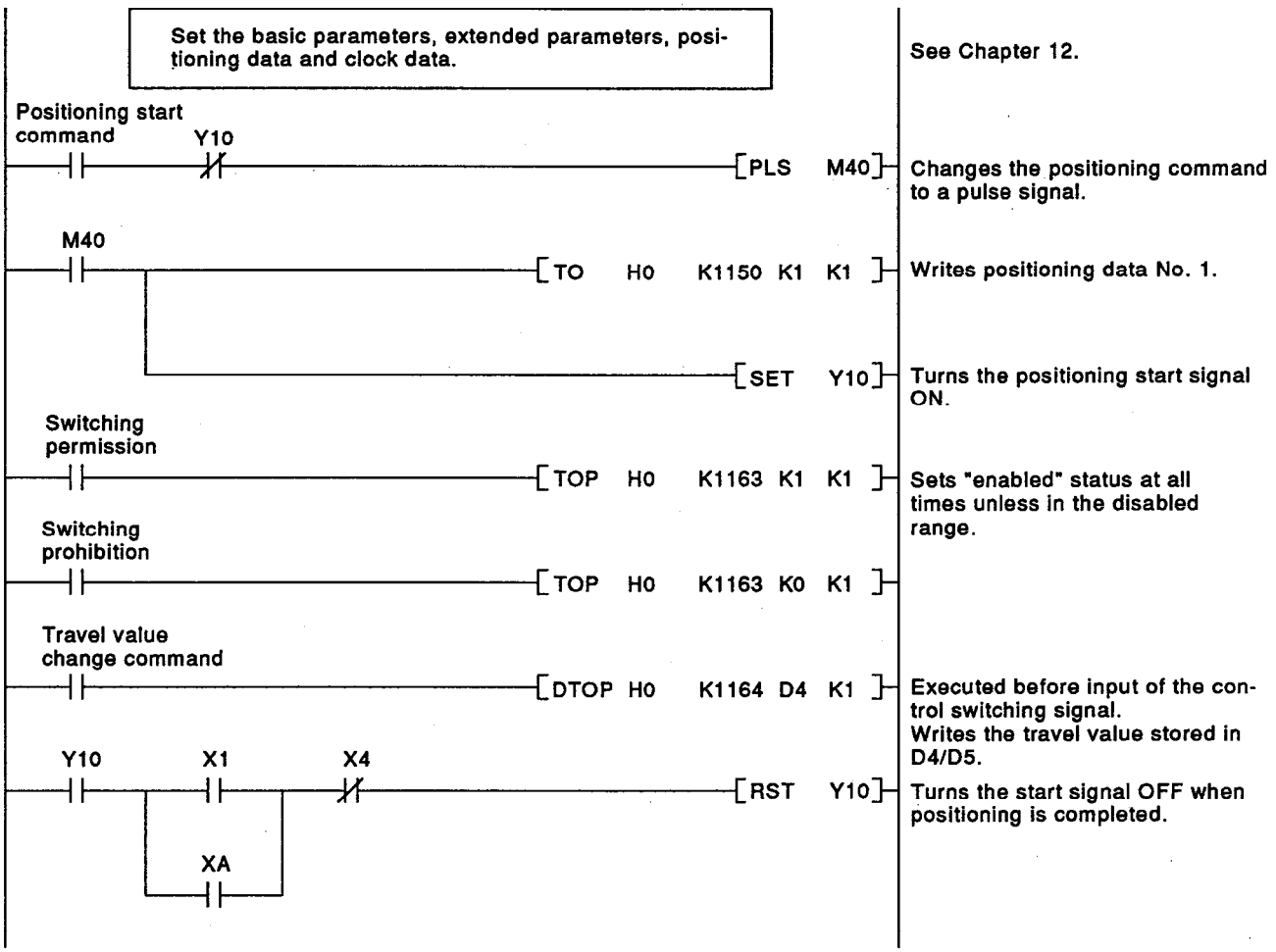
(a) Data transfer



(b) I/O signals



(c) Program



POINTS

(1) Before carrying out positioning, check the positioning operation and restrictions on setting positioning data by referring to Sections 3.3.1 to 3.3.7.

(2) When positioning is completed normally, it is recommended that the positioning data be registered in the flash ROM of the AD75.

7.3.3 Speed/position switching control operation program

An example of a positioning program where positioning operation is carried out by speed/position switching control is shown here.

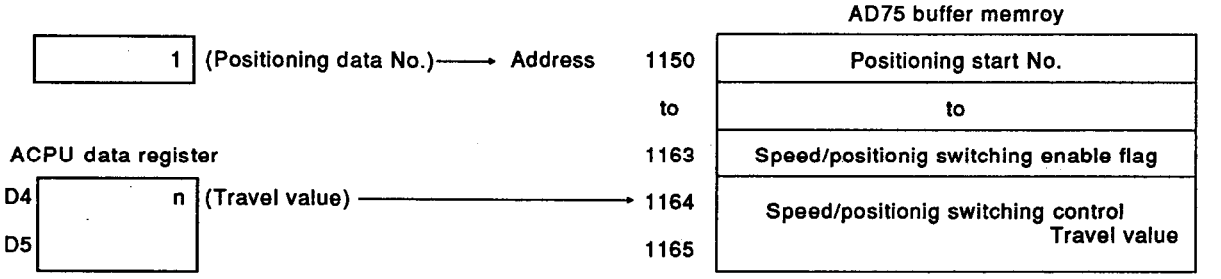
(1) Conditions

- Set the basic parameters, extended parameters and positioning data.
- Set clock data as required.
- Start the operation when the positioning start signal is OFF.
- If the travel value is to be changed during positioning, change it during speed control.
- Enable switching before the control switching signal is input from the external source.

(2) Program example

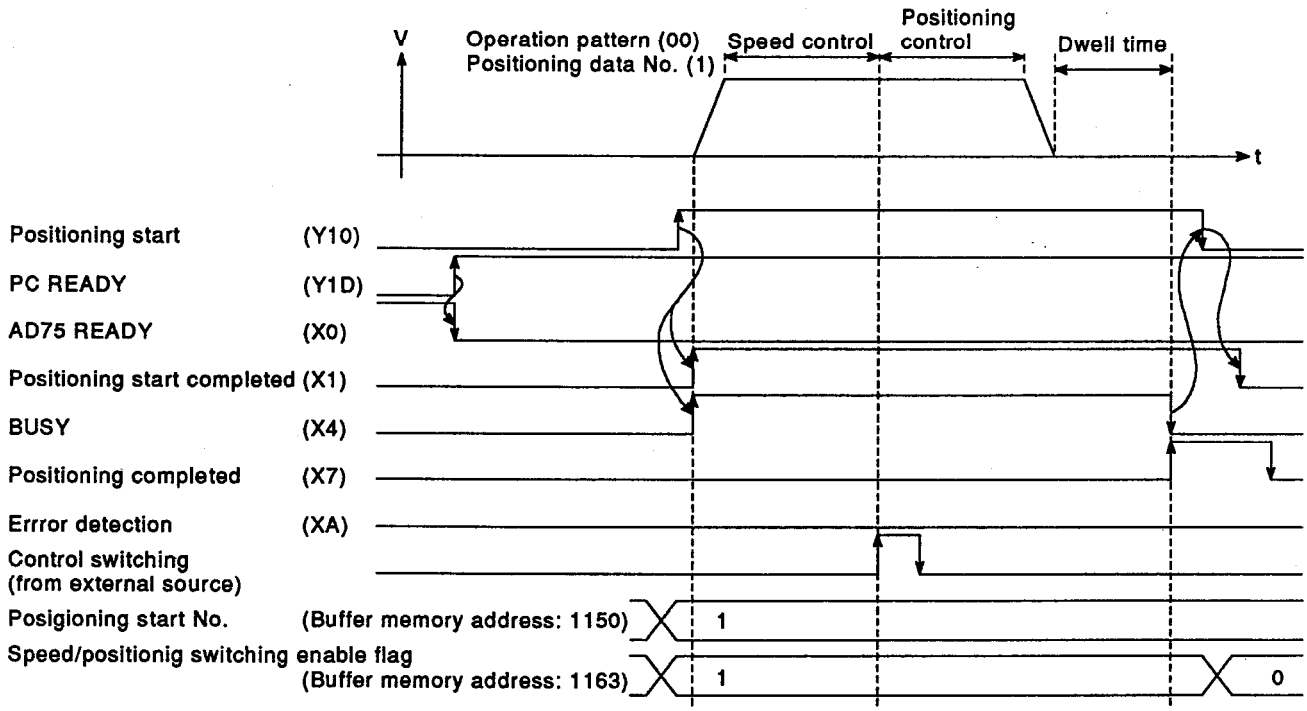
- The program shown here sets positioning data No. 1 and starts positioning for the first axis 1.

(a) Data transfer

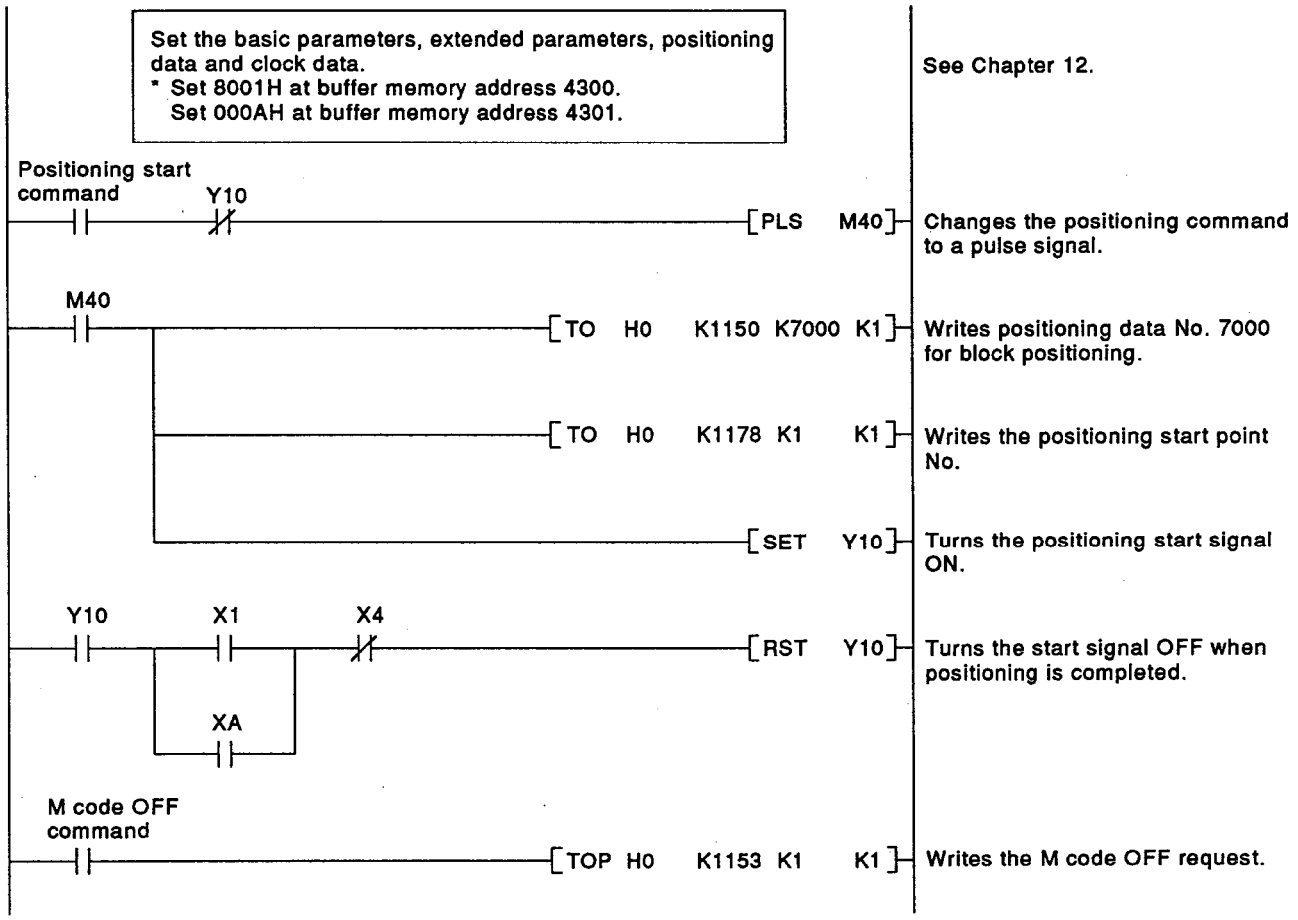


(For details on start numbers, see Section 3.4.5)

(b) I/O signals



(c) Program



POINTS

(1) Before carrying out positioning, check the positioning operation and restrictions on setting positioning data and positioning start information (for block positioning) by referring to Sections 3.3.1 to 3.3.7.

(2) When carrying out positioning using the positioning start information, set data in the following areas in the buffer memory in advance.
1) Positioning start point No.
2) Positioning start information area
* Set the positioning special start data and condition data as required.

Block positioning can be performed with positioning start data only. At the positioning start, set positioning data No. 7000 for block positioning start in the positioning start No. area in the buffer memory, then turn ON the start signal.
When the start signal is turned ON, the positioning operation is carried out in sequence, starting from the positioning data whose No. is designated at the position designated by the positioning start point number.

(3) For interpolation operation, turn on the positioning start signal of the reference axis to start operation.

(4) When positioning is completed normally, it is recommended that the positioning data be registered in the flash ROM of the AD75.

7.3.2 Positioning start program using positioning start information

An example of a positioning start program in which the ACPU requests the AD75 to start positioning operation is shown here.

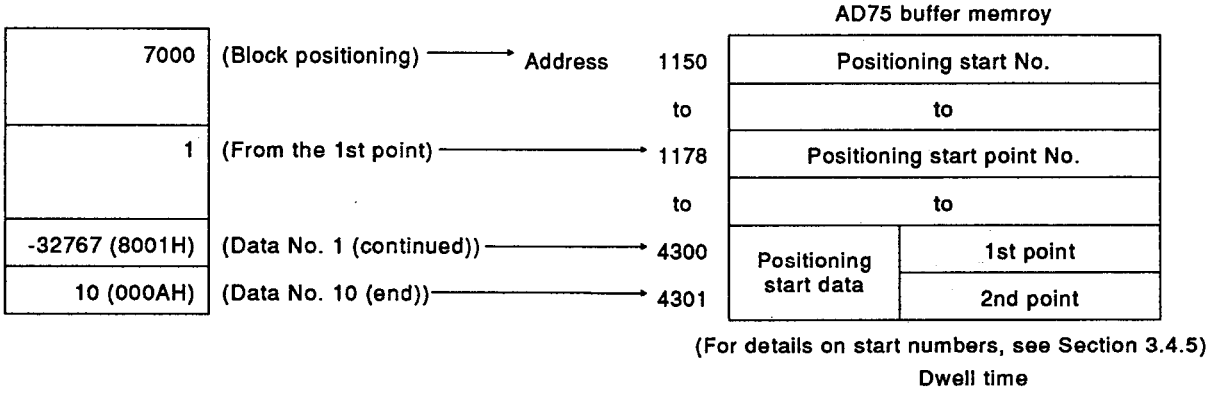
(1) Conditions

- Set the basic parameters, extended parameters and positioning data.
- Set the clock data as required.
- Start the operation when the positioning start signal is OFF.

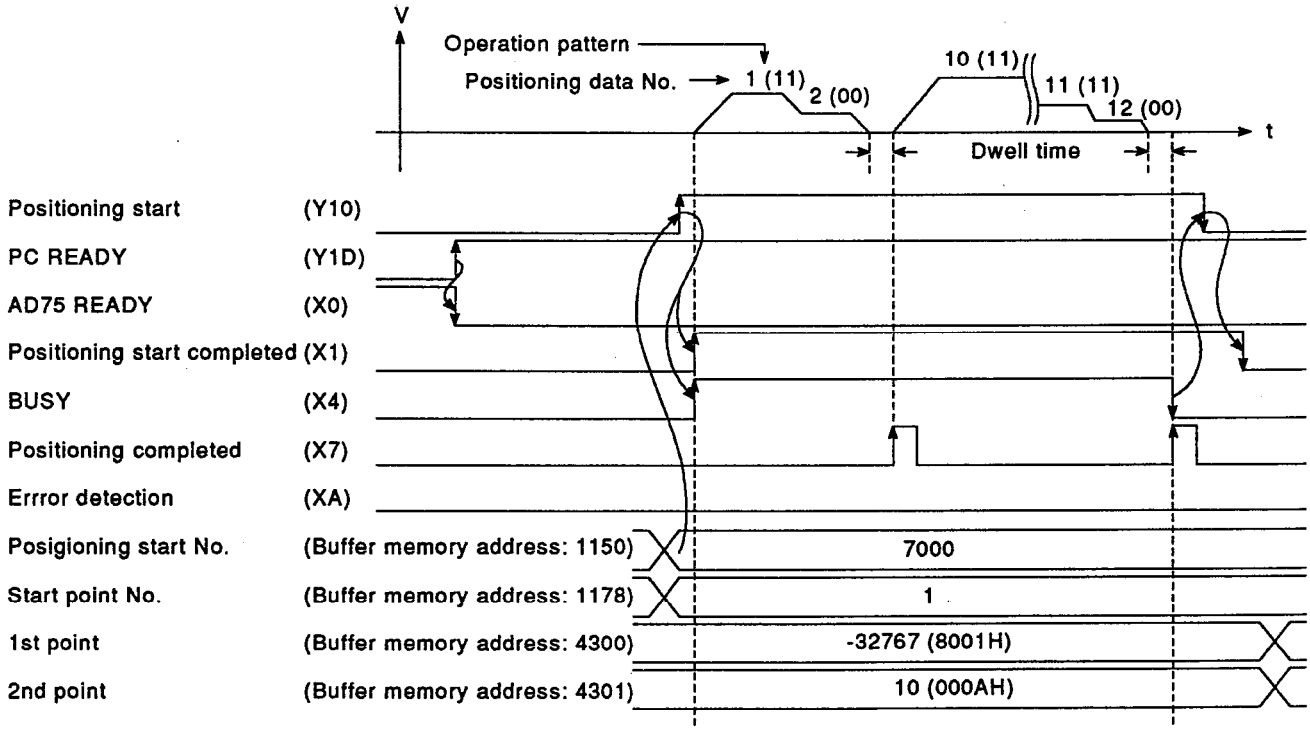
(2) Program example

- The program shown here sets the positioning data Nos. for two points in the positioning start data of the positioning start information for the first axis 1, and starts positioning.

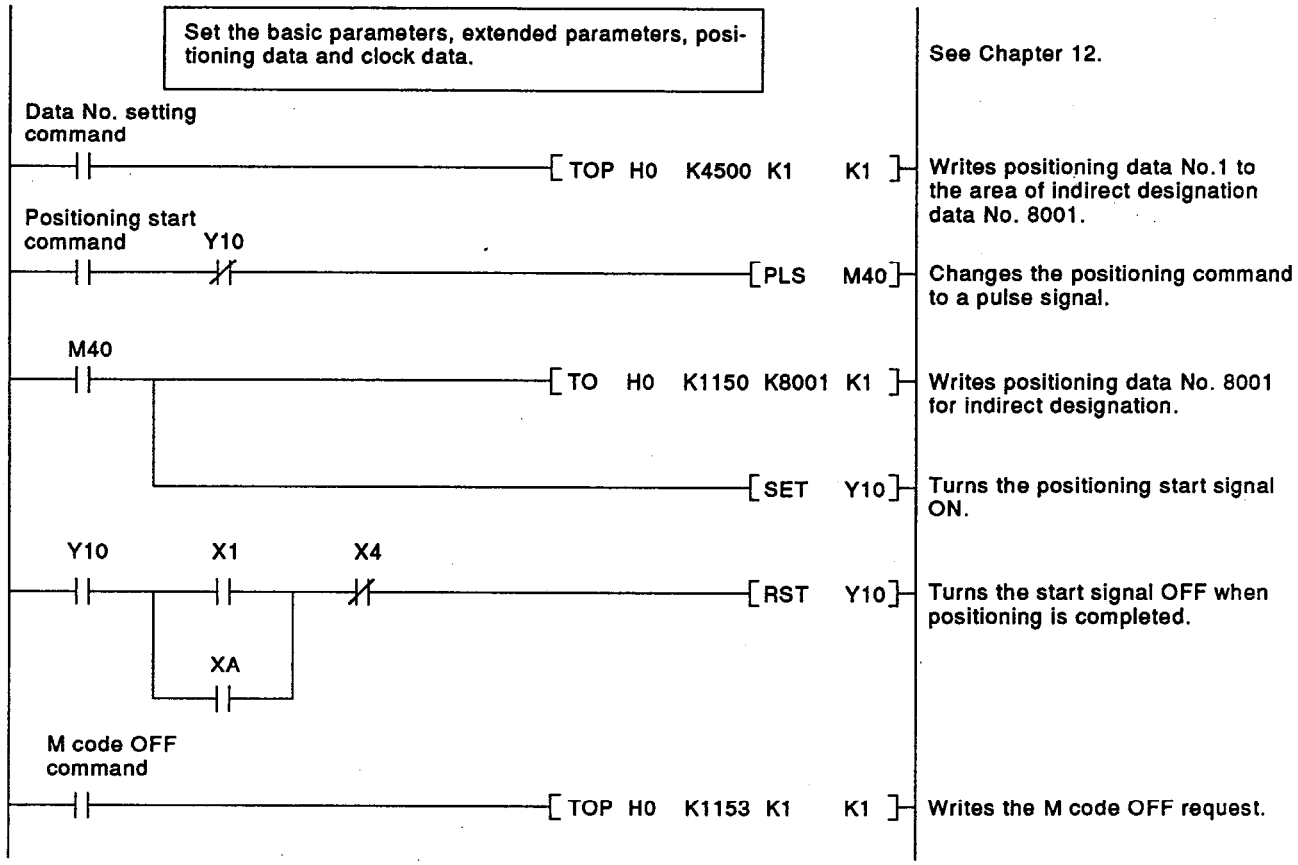
(a) Data transfer



(b) I/O signals



2) When the positioning data No. is indirectly designated



POINTS

(1) Before carrying out positioning, check the positioning operation and restrictions on setting positioning data by referring to Sections 3.3.1 to 3.3.7.

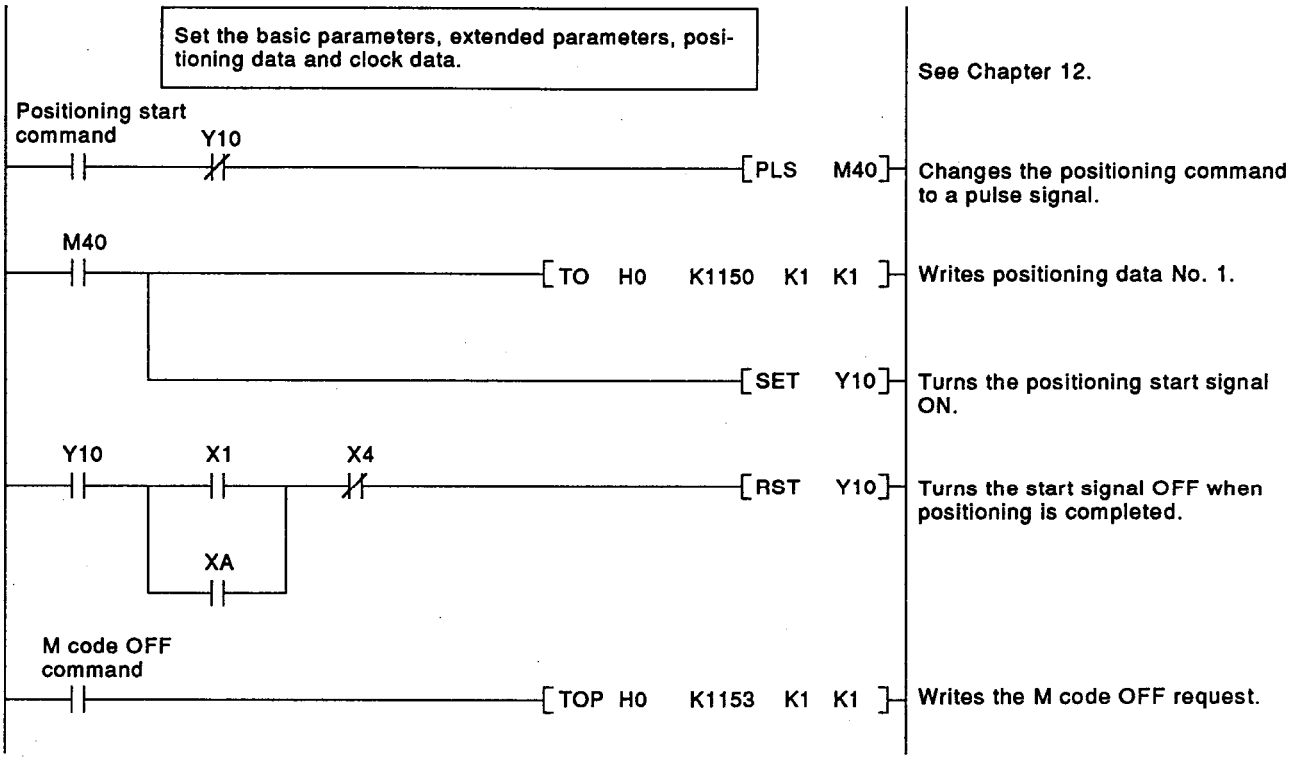
(2) When designating the positioning data No. indirectly, set the data No. of the positioning data used for positioning in the indirect designation area in the buffer memory in advance.
(It is written to the area of the data Nos. used for indirect designation (8001 to 8050)).
At positioning start, set the positioning data No. 8001 to 8050 for the above indirect designation at the start No. area in the buffer memory, and turn ON the start signal.
After the start signal is turned ON, positioning operation is carried out from the positioning data of the No. designated in the indirect designation area to the positioning data for operation pattern "00".

(3) For interpolation operation, turn on the positioning start signal of the reference axis to start operation.

(4) When positioning is completed normally, it is recommended that the positioning data be registered in the flash ROM of the AD75.

(c) Program

1) When the positioning data No. is designated directly



POINTS

(1) Before carrying out positioning, check the positioning operation and restrictions on setting positioning data by referring to Sections 3.3.1 to 3.3.7.

(2) When designating the positioning data No. directly, set the data No. of the positioning data used for positioning at the start No. area in the buffer memory, and turn ON the start signal.
After the start signal is turned ON, positioning operation is carried out from the positioning data of the designated No. to the positioning data of operation pattern "00".

(3) For interpolation operation, turn on the positioning start signal of the reference axis to start the operation.

(4) When positioning is completed normally, it is recommended that the positioning data be registered in the flash ROM of the AD75.

7.3 Programming

This section describes a sequence programs in which the ACPU requests the AD75 to start positioning operation.

REMARK

Unless otherwise specified, this section shows the sequence program when the ACPU at the station where the AD75 is installed is an A3UCPU and the I/O signal of the AD75 as seen from the A3UCPU are 00H to 1FH.

7.3.1 Positioning start program

An example of a positioning start program in which the ACPU requests the AD75 to start positioning operation is shown here.

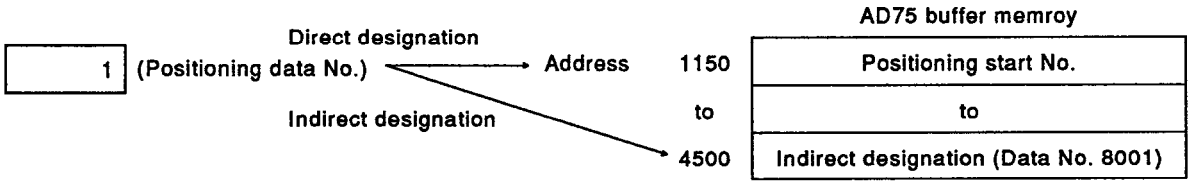
(1) Conditions

- Set the basic parameters, extended parameters and positioning data.
- Set the clock data as required.
- Start the operation when the positioning start signal is OFF.

(2) Program example

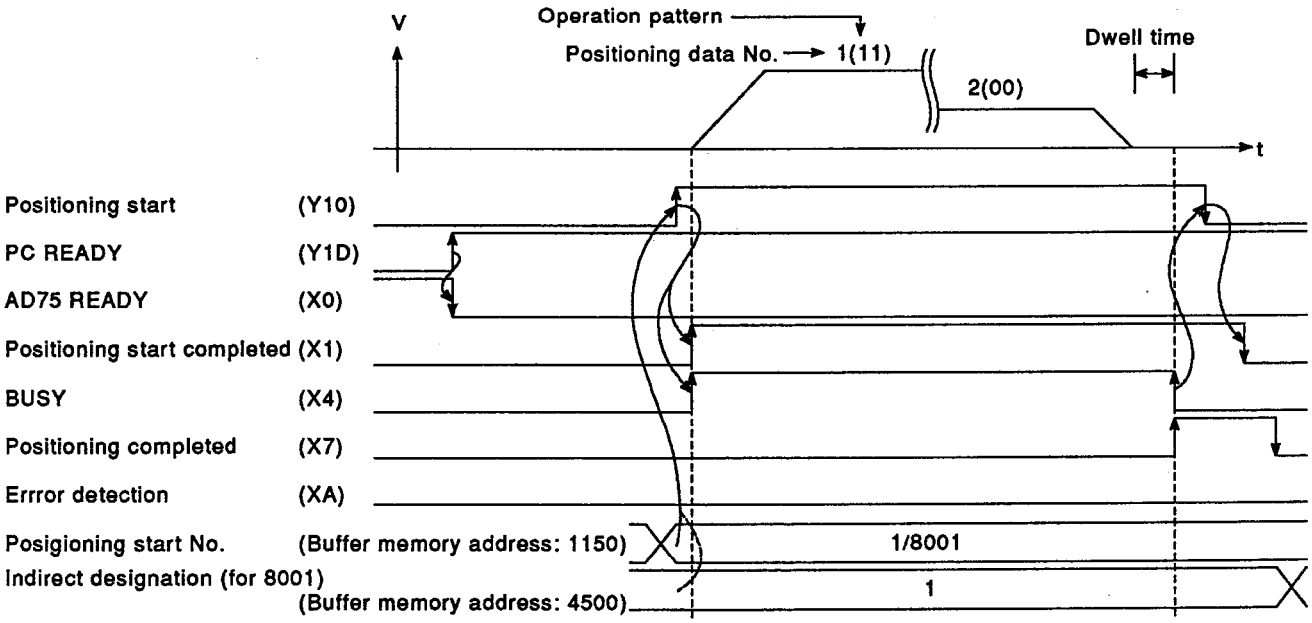
- The program shown here sets positioning data No. 1 and starts positioning on the axis 1.

(a) Data transfer



(For details on start numbers, see Section 3.4.5)

(b) I/O signals



Monitor Item	Buffer Memory Address			Description of Monitor Item	References
	Axis 1	Axis 2	Axis 3		
Speed control limit in progress flag	830	930	1030	Whether the speed limit is controlled or not in the event of a speed change or positioning operation override is stored.	Section 3.6.3 (2)
Speed change processing in progress flag	831	931	1031	Whether a speed change process is in progress or not is stored.	
Currently executed start data pointer	832	932	1032	Stores the pointer of the positioning start data currently being executed, which is included in the positioning start information. 1 is stored for positioning start (not restart) and 0 is stored for positioning completion.	
Last executed positioning data No.	833	933	1033	The positioning data No. executed last is stored. (Retained until the next positioning data is executed.)	
Repeat counter	834	934	1034	When the number of repetitions is set by the currently executed positioning special start data in the positioning start information, the remaining number of repetitions is stored. If the loop is infinite, 0 is stored from the beginning of the loop.	
Currently executed positioning data No.	835	935	1035	The positioning data No. which is currently being executed is stored. For indirect designation, the data No. actually being executed is stored.	
Currently executed block No.	836	936	1036	When data No. 7000 is set for the positioning start No. and positioning is carried out in accordance with the positioning start information, the set data No. 7000 is stored. (0 is stored in other cases.)	
Currently executed positioning data	838 839 840 841 842 843 844 845 846 847	938 939 940 941 942 943 944 945 946 947	1038 1039 1040 1041 1042 1043 1044 1045 1046 1047	The settings of the currently executed positioning data are stored. Positioning identifier M code Dwell time Not used Commanded speed Positioning address Arc data	Section 3.6.3 (2) Section 3.6.5

7.2.2 Axis monitor area

Monitor Item	Buffer Memory Address			Description of Monitor Item	References
	Axis 1	Axis 2	Axis 3		
Feed present value	800 801	900 901	1000 1001	The present position is stored. The home position address is stored on completion of home position return.	Section 3.6.3 (2).
Machine feed value	802 803	902 903	1002 1003	The present position in reference to a home position determined by the characteristics of the machine (in the machine coordinate system) is stored. The home position address is stored on completion of home position return.	
Feed speed	804 805	904 905	1004 1005	Stores the present speed. ("0" for stop) For interpolation, the present resultant speed or reference axis speed is stored for the reference axis, and "0" is stored for the other interpolation axis.	
Effective M code	806	906	1006	Effective M code is stored. "0" is stored when the PC READY signal is OFF.	
Axis error code	807	907	1007	The latest axis error code is stored. When an axis error is reset, "0" is stored. (For the first axis, reset is requested using the buffer memory address "1151".)	
Axis warning code	808	908	1008	The latest axis warning code is stored. When an axis error is reset, "0" is stored. (For axis 1, reset is requested using the buffer memory address "1151".)	
Axis operation status	809	909	1009	The axis operation status (error, stand-by, or positioning control in progress) is stored.	
Present speed	810 811	910 911	1010 1011	The speed set by the positioning data is stored. For interpolation, the present resultant speed or reference axis speed is stored for the reference axis, and "0" is stored for the other interpolation axis.	
Axis feed speed	812 813	912 913	1012 1013	The present speed is stored. ("0" for stop)	
Speed/position switching control	814 815	914 915	1014 1015	The travel value between switching to position control and positioning completion is stored.	
External I/O signal	816	916	1016	The ON/OFF status of the I/O signals to/from external devices is stored.	
Status	817	917	1017	The ON/OFF status of various flags used by the AD75 is stored.	
Target value	818 819	918 919	1018 1019	The target value for positioning operation is stored as follows: • For positioning control, the target value based on the designated positioning address/travel value. The target value is "0" on completion of positioning. • "0" during speed control and home position return. • For speed/position switching control, "0" at the start, and the travel value after the switch to position control.	
Target speed	820 821	920 921	1020 1021	The present speed is overwritten. The actual target speed, taking into account the current speed, override and speed limit value, is stored. ("0" is stored at every travel completion.) For interpolation, the present resultant speed or reference axis speed is stored for the reference axis, and "0" is stored for the other interpolation axis.	
Torque control value	826	926	1026	The torque limit value/torque change value are stored.	
Special start data instruction code setting value	827	927	1027	Stores the instruction code of the special start instruction in the positioning special start data which is indicated by the pointer of the positioning start data currently being executed, which is included in the positioning start information. (Retained until the start data pointer is updated.)	
Special start data instruction parameter setting value	828	928	1028	Stores the parameter of the special start instruction in the positioning special start data which is indicated by the pointer of the positioning start data currently being executed, which is included in the positioning start information. (Retained until the start data pointer is updated.)	
Positioning data No. setting value	829	929	1029	Stores the positioning start data No. which is indicated by the pointer of the positioning start data currently being executed, which is included in the positioning start information. (Retained until the start data pointer is updated.)	

7.2 Buffer Memory for Positioning Monitor

The following statuses are stored in a buffer memory when positioning is executed and can be monitored as required by reading the buffer memory.

7.2.1 System monitor area

Monitor Item		Buffer Memory Address			Description of Monitor Item	References
		Axis 1	Axis 2	Axis 3		
Start history 0 to 15	Start axis	462, 467, ... 537			The No. (1 to 3) of the start axis is stored.	Section 3.6.3 (1).
	Operation type	463, 468, ... 538			The positioning operation type, start source, and restart/no restart status are stored.	
	Start hour:min	464, 469, ... 539			The hour and minute of the start time are stored in BCD code.	
	Start second:100 ms	465, 470, ... 540			The second and 100 msec division of the start time are stored in BCD code.	
	Error judgment	466, 471, ... 541			The error judgment results (error, warning) and error code at the start are stored.	
Start history pointer		542			The area No. (0 to 15) following the area which stores the latest start history information (see above) is stored.	
Error start history 0 to 15	Start axis	543, 548, ...618			The No. (1 to 3) of the started axis for which the error occurred is stored.	
	Operation type	544, 549, ... 619			The type of positioning operation in which the error occurred, the start source, and the restart/no restart status are stored.	
	Start hour:min	545, 550, ... 620			The hour and minute of the time of the start with error are stored in BCD code.	
	Start second:100 ms	546, 551, ... 621			The second and 100 msec division of the time of the start with error are stored in BCD code.	
	Error judgment	547, 552, ... 622			The error judgment result (error, warning) and error code in the event of a start with error are stored.	
Error start history pointer		623			The area No. (0 to 15) following the area which stores the latest error start history information (see above) is stored.	
Error history 0 to 15	Axis where error occurred	624, 628, ... 684			The No. (1 to 3) of the axis for which the error occurred is stored.	
	Axis error code	625, 629, ... 685			The axis error code is stored. (See Chapter 13.)	
	Axis error occurrence hour:min	626, 630, ... 686			The hour and minute of the axis error occurrence is stored in BCD code.	
	Axis error occurrence sec:100 ms	627, 631, ... 687			The second and 100 msec division of the axis error occurrence is stored in BCD code.	
Error history pointer		688			The area No. (0 to 15) following the area which stores the latest error history information is stored.	
Warning history 0 to 15	Axis where warning occurred	689, 693, ... 749			The No. (1 to 3) of the axis for which the warning occurred is stored.	
	Axis warning code	690, 694, ... 750			The axis warning code is stored. (See Chapter 13.)	
	Axis warning occurrence hour:min	691, 695, ... 751			The hour and minute of the axis warning occurrence is stored in BCD code.	
	Axis warning occurrence sec:100 ms	692, 696, ... 752			The second and millisecond of the axis warning occurrence is stored in BCD code.	
Warning history pointer		753			The area No. (0 to 15) following the area which stores the latest warning history information (see above) is stored.	

REMARK

*1: When the condition data No. is designated by the positioning special start data in the positioning start information, the condition data settings to be made in the AD75 buffer memory are as indicated below.
The condition data is the data for the condition judgment and wait judgment carried out by the AD75 when the positioning for each block is started. The following information is set for one set of condition data.

Items to be Set	Buffer Memory Address			Description of Setting Items	References			
	Axis 1	Axis 2	Axis 3		Details of Settings	Setting Values: Sequence Program	Setting Values: AD75P	Sequence Program Setting Method
Condition identifier	4400 4410 to 4490	4650 4660 to 4740	4900 4910 to 4990	Set the condition object and condition operator for condition judgment by the AD75.	Section 3.4.6.	Section 3.4.6.		———
Address	4402 4403 4412 4413 to 4493	4652 4653 4662 4663 to 4743	4902 4903 4912 4913 to 4993	When the condition object is the buffer memory, set the AD75 buffer memory addresses at which the designated values of parameters #1 and #2 and the condition judgment values are stored.				
Parameter 1 Parameter 2	4404 to 4414 to 4494 to	4654 to 4664 to 4744 to	4904 to 4914 to 4994 to	Set the values for condition judgment, bit No. or positioning data No. corresponding to the condition object. (*2)				

REMARK

*2: When the condition object is a positioning data No. (simultaneous start), the positioning data No. for the simultaneous start is set in parameter #1 and parameter #2 (both two-word areas) as shown below.
The address shows the condition data No. 1 for axis 1.

Address	Buffer memory	
4404	Parameter #1 (lower bits)	..... Positioning data No. (for axis 1 start)
4405	Parameter #1 (upper bits)	..... Positioning data No. (for axis 2 start)
4406	Parameter #2 (lower bits)	..... Positioning data No. (for axis 3 start)
4407	Parameter #2 (upper bits)	..... Not used

(Setting example)

This example is for setting the positioning special start data required to set the following conditions.
(The address is for condition data No. 1 for the first axis.)
1) I/O signal X4 (BUSY signal for axis 1) to/from the ACPU is set to OFF
2) The value in the PC CPU memory area (address: 5050) in the buffer memory is set to "1000" to "1999".
3) Simultaneous start with the positioning data No. for axis 1 and data No. 100 for axis 3.

Address	Buffer memory		Setting value of 1)	Setting value of 2)	Setting value of 3)
4400	Condition identifier	.....	0801H	0503H	0D05H
4401	(Blank)		0H	0H	0H
4402	Address	.....	0H	136AH (5050)	0H
4403			0H	0H	0H
4404	Parameter 1	.....	4H	03E8H (1000)	1H
4405			0H	0H	0H
4406	Parameter 2	.....	0H	07CFH (1999)	64H
4407			0H	0H	0H
4408	(Not used)		0H	0H	0H
4409	(Not used)		0H	0H	0H

(4) Positioning start number

The table below shows the positioning start number settings to be made in the AD75 buffer memory.

Items to be Set	Buffer Memory Address			Description of Setting Items	References			
	Axis 1	Axis 2	Axis 3		Details of Settings	Setting Values: Sequence Program	Setting Values: AD75P	Sequence Program Setting Method
Positioning start No.	1150	1200	1250	Set the positioning data No. for starting the positioning operation. (*) 1 to 600: For positioning for one block ending with operation pattern "00" 7000: For positioning in accordance with the positioning start information 8001 to 8050: For positioning with indirect designation area (set the address between 4500 and 4549 for axis 1.)	Sections 3.4.5 and 7.3.	Section 7.3.		Section 7.3.
Positioning start point No.	1178	1228	1278	When the positioning start No. is set as 7000, set the point in the positioning start data of the positioning start information from which the positioning operation is to start.				

REMARK

*: When executing a home position return start, high speed home position return start, or present value change, set the appropriate data No. for the function at this setting item:

- Data No. 9001: Home position return start ..... See Section 6.3.1.
- Data No. 9002: High speed home position return start ..... See Section 6.3.2.
- Data No. 9003: Present value change ..... See Chapter 11.

(5) Positioning start information

When positioning is executed with multiple blocks, where one block is an operation ending with operation pattern "00", the following positioning start information settings should be made in the AD75 buffer memory.

Items to be Set	Buffer Memory Address			Description of Setting Items	References			
	Axis 1	Axis 2	Axis 3		Details of Settings	Setting Values: Sequence Program	Setting Values: AD75P	Sequence Program Setting Method
Positioning start data (1 to 50 points)	4300 4301 to 4349	4550 4551 to 4599	4800 4801 to 4849	Set the data for one block as one point and set a maximum of 50 points in the order of positioning. Designate at bit No.15 whether positioning is continued from the designated data No. to the next point.	Section 3.4.6.	Section 3.4.6.		Section 12.6.
Positioning special start data (1 to 50 points)	4350 4351 to 4399	4600 4611 to 4649	4850 4851 to 4899	If a special operation (condition judgment, simultaneous start, stop, or repeat processing) is to be added to the normal positioning operation, set the appropriate data at this item.				———
Condition data (maximum 10 items)	4400 to 4499	4650 to 4749	4900 to 4999	When the condition data No. is designated by the parameter setting of the positioning special start data, set the condition data (*1) for the condition data No.				

(3) Positioning data

The table below shows the positioning data settings to be made in the AD75 buffer memory.
Positioning data Nos. 1 to 100 can be set in the buffer memory.

Items to be Set	Buffer Memory Address			Description of Setting Items	References			
	Axis 1	Axis 2	Axis 3		Details of Settings	Setting values		Sequence Program Setting Method
						Sequence Program	AD75P	
Positioning identifier	1300 1310 to 2290	2300 2310 to 3290	3300 3310 to 4290	Set the following data of the applicable positioning data in the fields for instruction, acceleration/deceleration, and control. • Operation pattern (00, 01, 11) • Setting No. for acceleration time (0 to 3) • Setting No. for deceleration time (0 to 3) • Control method (01H to 11H)	Section 3.4.4.	Section 3.6.5.	Section 3.4.4.	Section 12.5.
M code	1301 1311 to 2291	2301 2311 to 3291	3301 3311 to 4291	Set the M code of the applicable positioning data.				
Dwell time	1302 1312 to 2292	2302 2312 to 3292	3302 3312 to 4292	Set the dwell time of the applicable positioning data.				
Commanded speed	1304 1305 1314 1315 to 2294 2295	2304 2305 2314 2315 to 3294 3295	3304 2205 3314 3315 to 4294 4295	Set the speed for positioning using the applicable positioning data.				
Positioning address	1306 1307 1316 1317 to 2296 2297	2306 2307 2316 2317 to 2396 3297	3306 3307 3316 3317 to 4296 4297	Set the type of positioning address for the applicable positioning data. • If absolute (ABS): Absolute address • If incremental (INC): Travel value				
Arc address	1308 1309 1318 1319 to 2298 2299	2308 2309 2318 2319 to 3298 3299	3308 3309 3318 3319 to 4298 4299	When executing circular interpolation control, set the following items as absolute addresses in an absolute (ABS) system, or as the travel value in an incremental (INC) system: • Auxiliary point designation Set the address of the pass point on the arc. • Center point designation Set the address of the arc center point.				

REMARK

Set positioning data No. 101 to 600 for the AD75 by using the AD75P whenever possible.
When setting data in the AD75 from the ACPU, refer to the program example in Section 12.7.

(2) Extended parameters

The table below shows the extended parameters to be set in the AD75 buffer memory.

Items to be Set	Buffer Memory Address			Description of Setting Items	References			
	Axis 1	Axis 2	Axis 3		Details of Settings	Setting Values: Sequence Program	Setting Values: AD75P	Sequence Program Setting Method
Backlash compensation amount	15	165	315	Set the machine backlash compensation amount for changes in positioning direction.	Section 3.4.2.	Section 3.6.2 (3) and (4)	Section 3.4.2.	Section 12.3.
Software upper stroke limit	16 17	166 167	316 317	Set the upper limit of the machine travel range.				
Software lower stroke limit	18 19	168 169	318 319	Set the lower limit of the machine travel range.				
Software stroke limit selection	20	170	320	Set the software stroke limit for either the feed present value or machine present value.				
Command in-position range	22 23	172 173	322 323	Set the position [(positioning address) - (present value)] at which the command in-position signal is turned ON.				
Torque limit setting value	24	174	324	Set the torque limit value.				
M code ON signal output timing	25	175	325	Set the timing in accordance with which the M code ON signal is turned ON.				
Speed change type in speed switching mode	26	176	326	Set the speed switching type in the speed switching mode. (Standard or advance).				
Interpolation speed designation method	27	177	327	Set the designation method of the speed for interpolation. (Resultant speed or reference axis).				
Feed present value update request command in speed control	28	178	328	Set whether the feed present value is updated or not updated during speed control or the speed control part of speed/position switching control.				
Acceleration time 1 to 3	36 to	186 to	336 to	Set the time taken to reach the speed control limit from speed 0.				
Deceleration time 1 to 3	42 to	192 to	342 to	Set the time from the speed control limit to speed 0.				
Acceleration/deceleration process selection	52	202	352	Set the processing for acceleration/deceleration. (Trapezoidal or S pattern)				
S curve ratio	53	203	353	Set the S curve ratio in S pattern acceleration/deceleration processing				
Rapid stop deceleration time	54 55	204 205	354 355	Set the time taken to reach speed 0 from the speed control limit when a rapid stop is executed.				
Stop group 1 to 3 rapid stop selection	56 57 58	206 207 208	356 357 358	Select the normal deceleration stop or rapid stop when a stop is executed. *				
Positioning completion signal output time	59	209	359	Set the output time of "positioning completed signal" output from the AD75.				
Allowable error range for circular interpolation.	60 61	210 211	360 361	Set the allowable range for error between the circular locus and end point coordinates in circular interpolation.				
External start function selection	62	212	362	Set positioning start by input of an external start signal.				

REMARK

*: Stop causes for each group

- Stop group 1: H/W stroke limit
- Stop group 2: S/W stroke limit, peripheral stop, and PC READY OFF
- Stop group 3: Stop by stop signal in the event of error (other than stop groups 1 and 2)

7.1 Parameter, Positioning Data, and Start Information Settings Required for Positioning

Positioning is carried out using one of the three control methods described in Sections 3.3.1 through 3.3.5.

This section describes the settings of the basic parameters, extended parameters, positioning data and positioning start information required for positioning.

POINTS

(1) The basic parameters, extended parameters, and positioning data must be set to carry out positioning.
Carry out the positioning operation after checking the details of the parameters and positioning data described in this section and setting the AD75.

(2) For details on the method for setting parameters, positioning data, and positioning start information when using the AD75P, refer to the operating manual of the AD75P.

(1) Basic parameter

The table below shows the basic parameters to be set in the AD75 buffer memory.

Items to be Set	Buffer Memory Address			Description of Setting Items	References			
	Axis 1	Axis 2	Axis 3		Details of Settings	Setting Values		Sequence Program Setting Method
						Sequence Program	AD75P	
Unit setting	0	150	300	Set the command unit for positioning control.	Section 3.4.1.	Section 3.6.2 (1) and (2)	Section 3.4.1.	Section 12.2.
Number of pulses per revolution (Ap)	1	151	301	Set the number of pulses per revolution of the motor, which is determined by the mechanical system.				
Travel value per revolution (Al)	2	152	302	Set the travel value per revolution of the motor, which is determined by the mechanical system.				
Unit magnification (Am)	3	153	303	Set the magnification of the travel value per pulse.				
Pulse output mode	4	154	304	Set in accordance with the drive unit. (PLS/SIGN, CW/CCW, phase A/B)				
Rotational direction setting	5	155	305	Set the direction of rotation when the present value is increased.				
Speed control limit	6 7	156 157	306 307	Set the maximum speed of positioning operation (including home position return) and manual pulse generator operation.				
Acceleration time 0	8 9	158 159	308 309	Set the time taken to reach the speed control limit from speed 0.				
Deceleration time 0	10 11	160 161	310 311	Set the time taken to reach speed 0 from the speed control limit.				

7. POSITIONING START

Positioning start is the start processing which positions the machine at the designated position in accordance with various parameters, positioning data and positioning start information pre-set in the AD75 by the user. The start can be executed from the ACPU or an external device.
Set the basic parameters, extended parameters, positioning data, and positioning start information for each axis according to the positioning system configuration. Then, designate the user-set positioning data No. for the positioning start, and execute the start.

This chapter describes the method for executing a positioning start using the basic parameters and extended parameters set in the AD75, positioning data, and positioning start information.

POINTS

(1) Positioning start is not possible when the AD75 is in the following statuses.

- Sequence ready signal (Y1D): OFF.
  (If a positioning start is executed from a peripheral device while the peripheral device is in the test mode, positioning start is possible regardless of whether the sequence ready signal is ON or OFF.)
- AD75 ready flag (X0): ON
- M code: ON

(2) If the relevant axis is BUSY when the positioning start is executed, the following happens:

- Currently operating axes continue operation.
- A "start during operation" warning (warning code: 100) is issued for the relevant axis.

REMARK

The difference between the positioning start methods when starting from the ACPU and starting from an external device is the method of input of the start signal to the AD75. The necessary parameters, positioning data and positioning start information are the same.

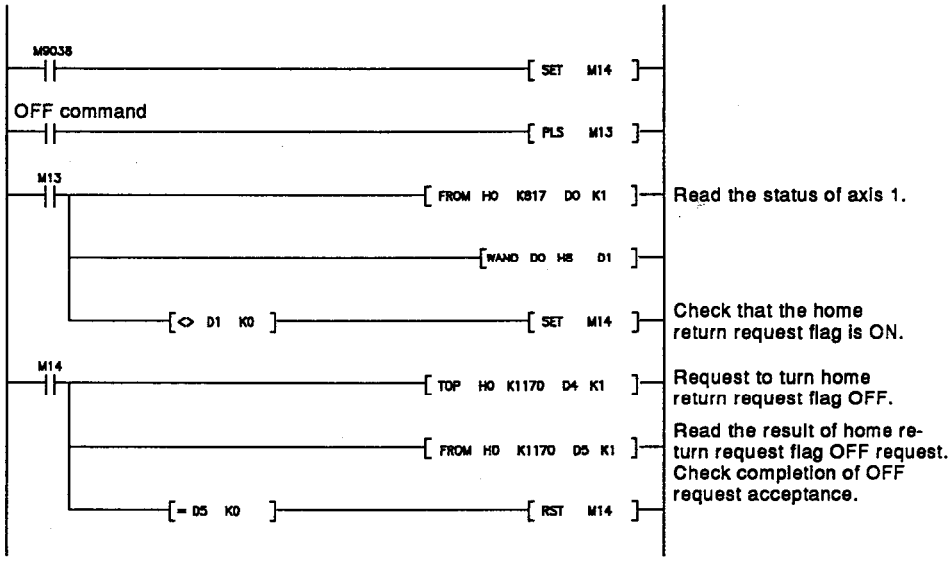
1) Starting from the ACPU:

- Turn ON the positioning start signal (Y10, Y11, and Y12).

2) Starting from an external device:

- Input the start signal via the external interface of the AD75.
- Set "External positioning start" for external start function selection (buffer memory address: 62, 212, and 362) in extended parameter #2.
- Set the external start valid setting (buffer memory address: 1171, 1221, and 1271) before starting.

(c) Program



POINT

In a system which does not require home position return, execute the processing described in this section only to forcibly turn a home position return request flag from ON to OFF.
In a system which requires home position return, execute home position return when the home position return request flag is ON.

6.3.4 Home position return request flag OFF requesting program

An example of a program for forcing the home position return request flag (bit 3) of the status area (address:817, 917, 1017) of the AD75 buffer memory from ON to OFF from the ACPU is shown below.

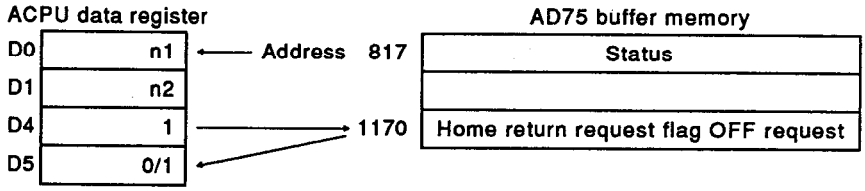
(1) Conditions

- Execute the program each time the home position return request flag (bit 3) is turned ON.

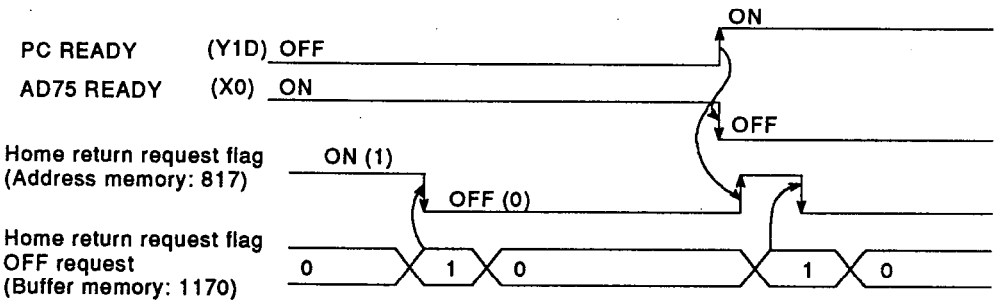
(2) Program example

- The program in this example forces the home position return request flag for axis 1 OFF.

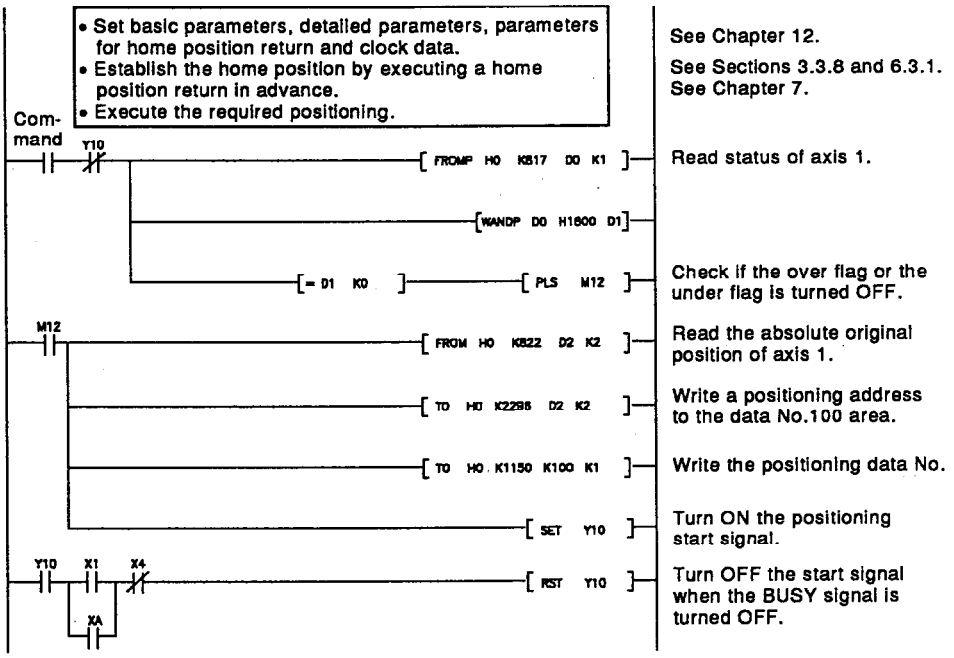
(a) Data transfer



(b) I/O signals



(c) Program



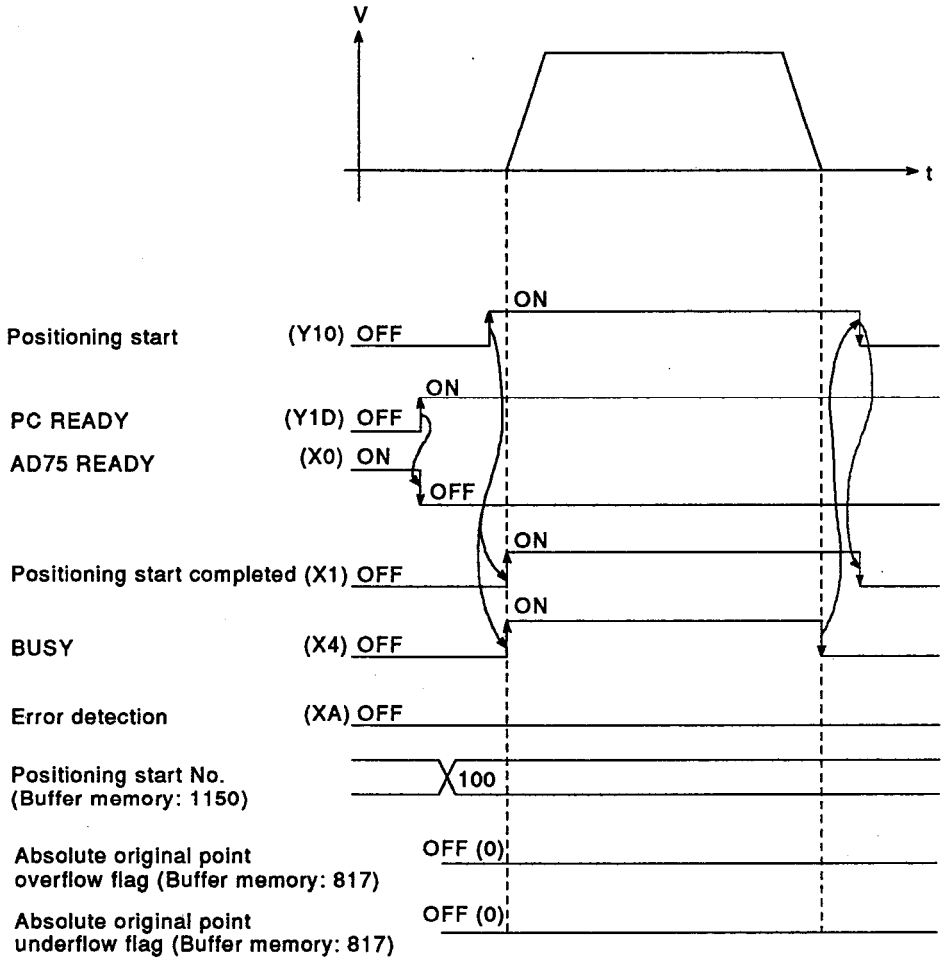
POINTS

(1) High-speed machine home position return is a type of absolute positioning control that makes the value of the "absolute home position" of the buffer memory axis monitor the positioning address of the positioning data. Execution of a positioning program (ABS-1), by designating the positioning data No. which makes the value of the "absolute home position" the positioning address enables positioning to the absolute home position.

(2) On completion of positioning, the "absolute home position" becomes the home position address value in the parameters.

(3) Before executing high-speed home position return, check the high-speed home position return operation and restrictions that apply to it by referring to Section 3.3.8.

(b) I/O signals


V
t
Positioning start
(Y10) OFF
ON
PC READY
(Y1D) OFF
ON
AD75 READY
(X0) ON
OFF
Positioning start completed (X1) OFF
ON
BUSY
(X4) OFF
ON
Error detection
(XA) OFF
Positioning start No.
(Buffer memory: 1150)
100
Absolute original point
overflow flag (Buffer memory: 817)
OFF (0)
Absolute original point
underflow flag (Buffer memory: 817)
OFF (0)

6.3.3 High-speed machine home position return program

An example of a program for executing a high-speed machine home position return from the ACPU is presented below.

(1) Conditions

- Set basic parameters, detailed parameters and parameters for home position return in advance.
- If necessary, set the clock data in advance.
- At the positioning data No. designated by the high-speed machine home position return request, register data other than positioning addresses in the AD75 flash ROM.

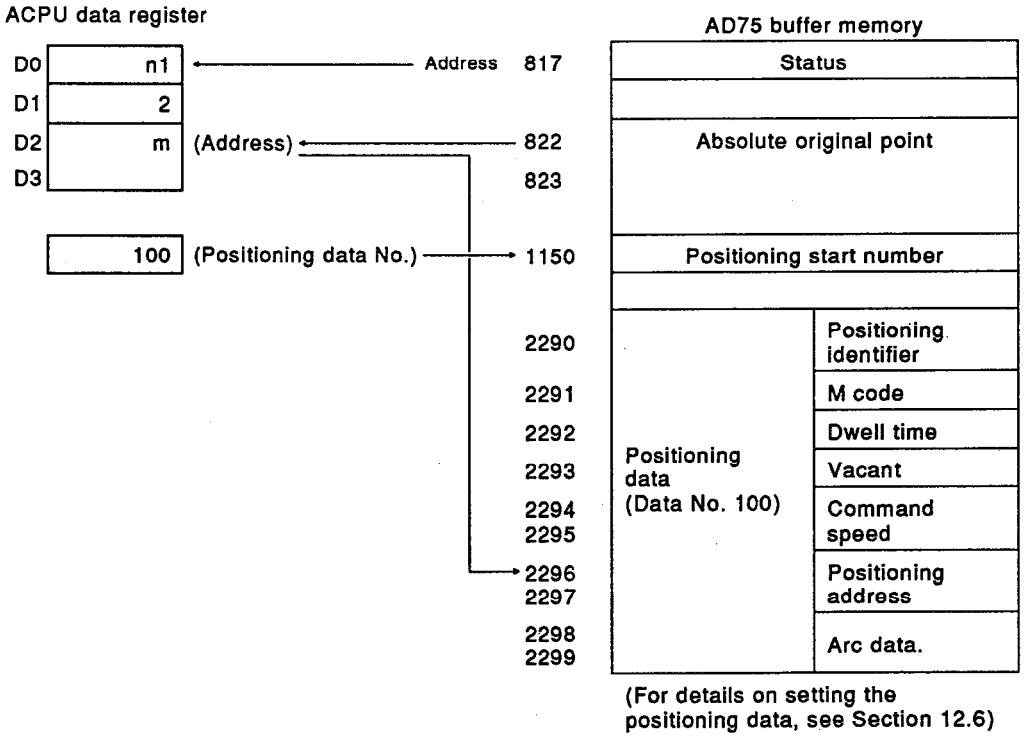
  Data No. 1 to 100 : Registered at the ACPU or the AD75P.
  Data No. 101 to 600 : Registered at the AD75P.

- Only start the program when the absolute home position overflow flag and underflow flag are OFF.

(2) Program example

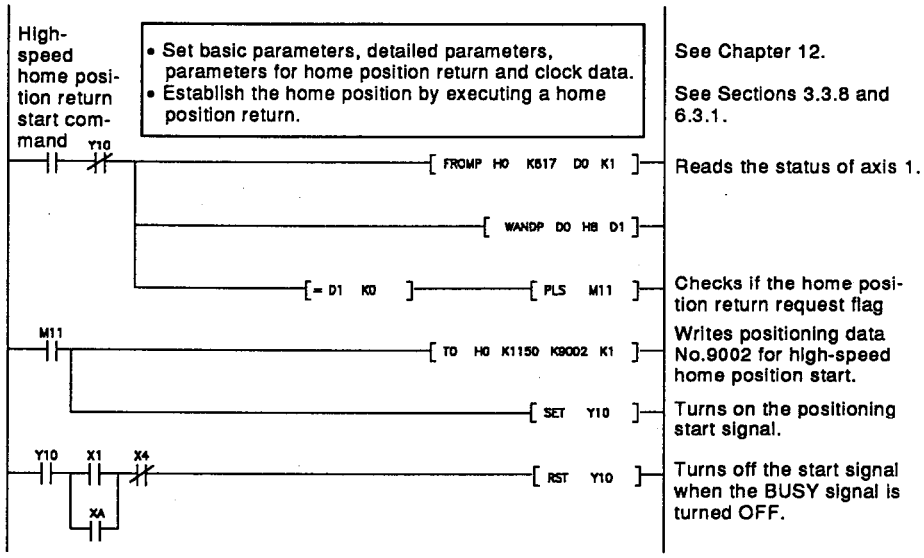
- The program in this example requests a high-speed machine home position return for axis 1 using data No.100.
  The value in the absolute home position storage area of the buffer memory is used for the positioning address of positioning data No. 100.

(a) Data transfer



(For details on setting the positioning data, see Section 12.6)

(c) Program



POINTS

(1) The only difference between a high-speed home position return sequence program and a positioning start sequence program is the data No. at the start; otherwise they are the same.

- High-speed home position return start data No. : 9002
- Positioning start data Nos. : 1 to 600, 8001 to 8050 (for indirect designation)

(2) High-speed home position return start is the positioning for traveling to the home position at high speed without using a home position detection signal, and it is executed by using the machine present value.
It is possible to start a high-speed home position return after the home position has been established by executing a machine home position return.

(3) Before executing high-speed home position return, check the high-speed home position return operation and restrictions that apply to it, and the high-speed home position start method, by referring to Section 3.3.8.

6.3.2 High-speed home position return start program

An example of a start program for executing a high-speed home position return from the ACPU is presented below.

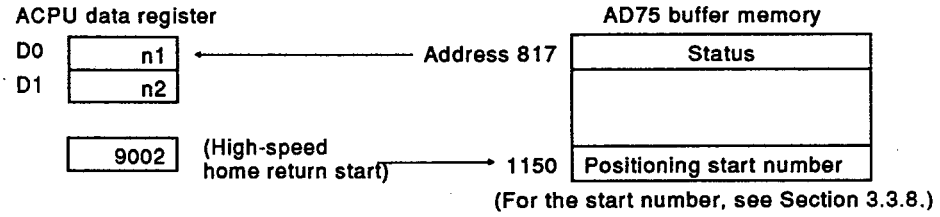
(1) Conditions

- Establish the home position by executing a home position return. In a situation just after a machine present value underflow or overflow has occurred during speed control, execute another machine home position return before executing high-speed home position return.
- Be sure to start the program when the home position return request flag and positioning start signal are turned OFF.

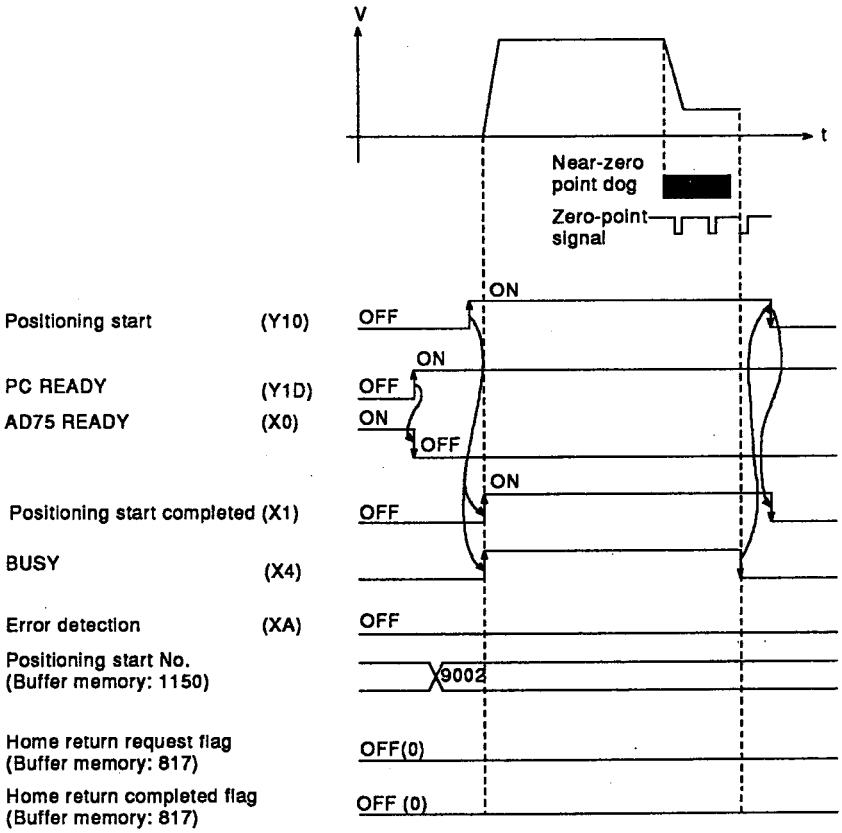
(2) Program example

- The program in this example requests a high-speed home position return start for the first axis.

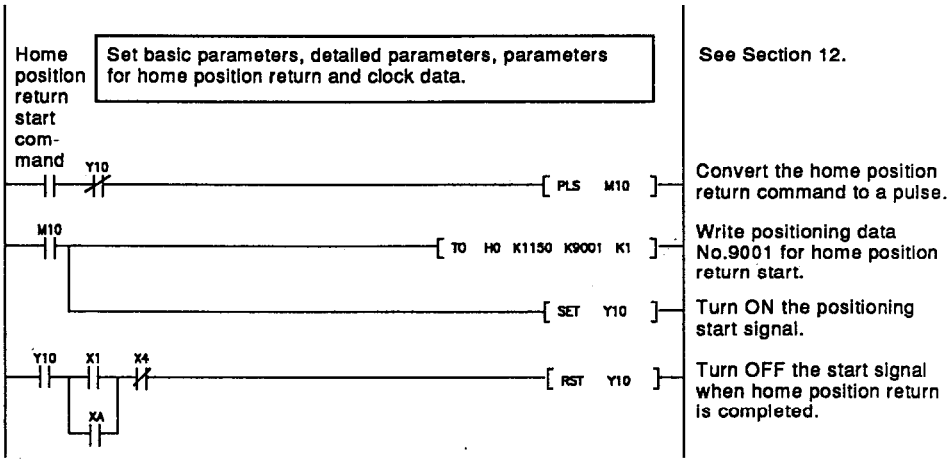
(a) Data transfer



(b) I/O signals



(c) Program



POINTS

(1) The only difference between a home position return sequence program and a positioning start sequence program is the data No. at the start; otherwise they are the same.

Home position return start data No. : 9001

Positioning start data Nos. : 1 to 600, 8001 to 8050 (for indirect designation)

(2) Before executing home position return, check the home position return operation, and restrictions that apply, for the method set in the home position return parameters, and the home position start method, by referring to Section 3.3.8.

(3) After confirming that home position return is executed and completed normally, you are recommended to register the home position return parameters including the home position address in the AD75 flash ROM.

6.3 Programming

Sequence programming for executing a home position return from the ACPU is described here.

6.3.1 Home Position Return Start Programs

An example of a program for starting a home position return in response to a machine home position return request from the ACPU is presented below.

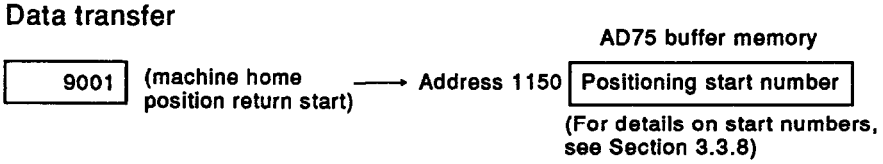
(1) Conditions

- Set the basic parameters, detailed parameters and parameters for home position return in advance.
- If necessary, set clock data in advance.
- Start the program when the home position return completed flag and the positioning start signal are OFF.

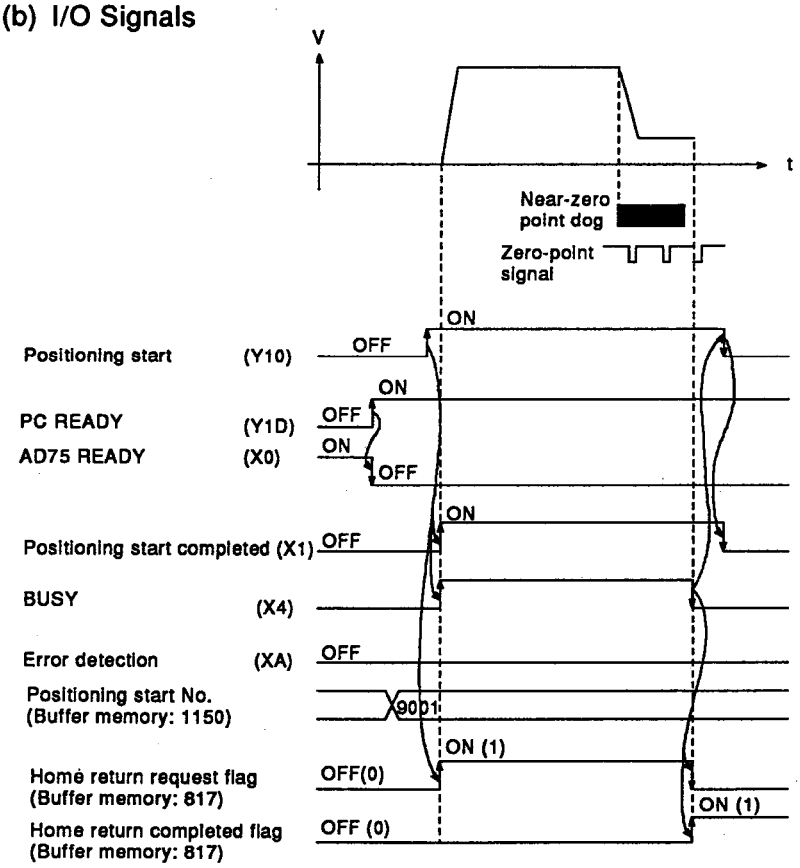
(2) Program example

- The program in this example requests a home position return start for axis 1.

(a) Data transfer



(b) I/O Signals



6.2 Buffer Memory for Monitoring Home Position Return

The monitored items whose status is stored in the buffer memory on execution of a home position return are shown here. Whenever necessary, check these statuses by reading them from the buffer memory.

Table 6.2 Buffer Memory for Monitor List

Monitored Items	Buffer Memory Address			Description of Monitored Items	References
	Axis 1	Axis 2	Axis 3		
External I/O signal	816	916	1016	Stores ON/OFF status of external I/O signals.	Section 3.6.3 (2).
Status	817	917	1017	Stores ON/OFF status of the flags that the AD75 handles.	
Absolute original point	822 823	922 923	1022 1023	Stores the parameter home position address value when home position return is completed.	
Travel value after the near-zero point dog is turned ON	824 825	924 925	1024 1025	Stores 0 when the home position return is started. Stores the travel value between the turning ON of the near-zero point dog and completion of home position return.	

6.1 Parameter Settings Required For Home Position Return

Home position return is performed by using one of the six methods described in Section 3.3.8. This section describes the parameters that must be set in order to execute home position return.

POINTS

(1) Home position return parameters, basic parameters, and detailed parameters must be set for the AD75 so that home position return can be executed. Check that the home position return parameters, basic parameters and detailed parameters indicated in this section have been set at the AD75 before attempting to execute home position return.

(2) For details on setting parameters at the AD75P, refer to the AD75P Operating Manual.

Table 6.1 Home Position Return Parameters (Basic and Extended)

Items to be Set	Buffer Memory			Description of Setting Items	References			
					Details of Settings	Setting Values		Sequence Program Setting Method
	Axis 1	Axis 2	Axis 3			Sequence Program	AD75P	
Home position return method	70	220	370	Sets the home position return method.	Section 3.3.8. Section 3.4.3.	Section 3.6.2 (5).	Section 3.4.3.	Section 12.4.
Home position return direction	71	221	371	Sets the home position return direction.				
Home position return address	72 73	222 223	372 373	Sets the present value of the home position when home position return is finished.				
Home position return speed	74 75	224 225	374 375	Sets the speed for home position return.				
Creep speed	76 77	226 227	376 377	Sets the creep speed after the near-zero point dog is turned ON.				
Home position return retry	78	228	378	Sets whether home position return retry is to be executed or not using the upper/lower limit switches.				
Home position return dwell time	79	229	379	Set the time between turning ON of the near-zero point dog and completion of home position return.				
Travel value after near-zero point dog setting	80 81	230 231	380 381	Sets the travel value after the near-zero point dog is turned ON.				
Selection of home position return acceleration time	82	232	382	Set which acceleration time (of 0 to 3) set in the basic parameters and detailed parameters, is to be used for home position return.				
Selection of home position return deceleration time	83	233	383	Set which acceleration time (of 0 to 3) set in the basic parameters and detailed parameters, is to be used for home position return.				
Home position shift amount	84 85	234 235	384 385	Set the shift amount from detection of the zero-point signal to the home position.				
Home position return torque limit value	86	236	386	Set a value to limit the torque of the servomotor after it reaches creep speed.				

6. HOME POSITION RETURN PROGRAMS

Home position return is the positioning control performed when the machine home position needs to be confirmed, for example when the power is turned ON. It can be executed from the ACPU or the AD75P.

Set home position return parameters including the home position return method for each axis, home position return directions and home position return addresses, and execute home position return using whichever of the following two start methods is suitable for the positioning system configuration:

- Machine home position return start ..... Start positioning data No.9001 in the positioning operation to execute a home position return using the set control method.
- High-speed home position return start... Start positioning data No.9002 in the positioning operation to start axis motion that continues until the machine feed value coincides with the home position address, without using a home position detection signal.

This section describes the method for executing home position return from the ACPU using a sequence program. For details on home position return executed from the AD75P, refer to the Operating Manual for the AD75P.

POINT

The high-speed home position return start is the same as a positioning operation to the home position. High-speed home position return is only possible after the home position has been established by a machine home position return.

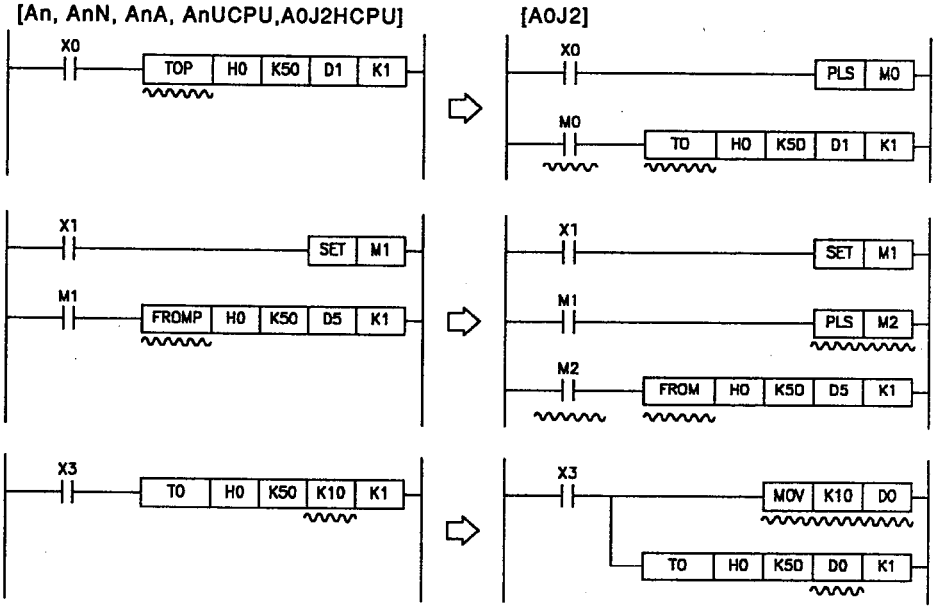
MEMO

5.2 Notes on Writing Programs

Some general notes on writing data from the ACPU to the AD75 buffer memory are presented below.

(1) With regard to the data setting described in this section, Mitsubishi recommends that the various parameters, positioning data and positioning start information should, as far as possible, be set at the AD75P.
If these data are set in a sequence program, the program will be large and many devices will be used, making programming complicated and increasing scan time.

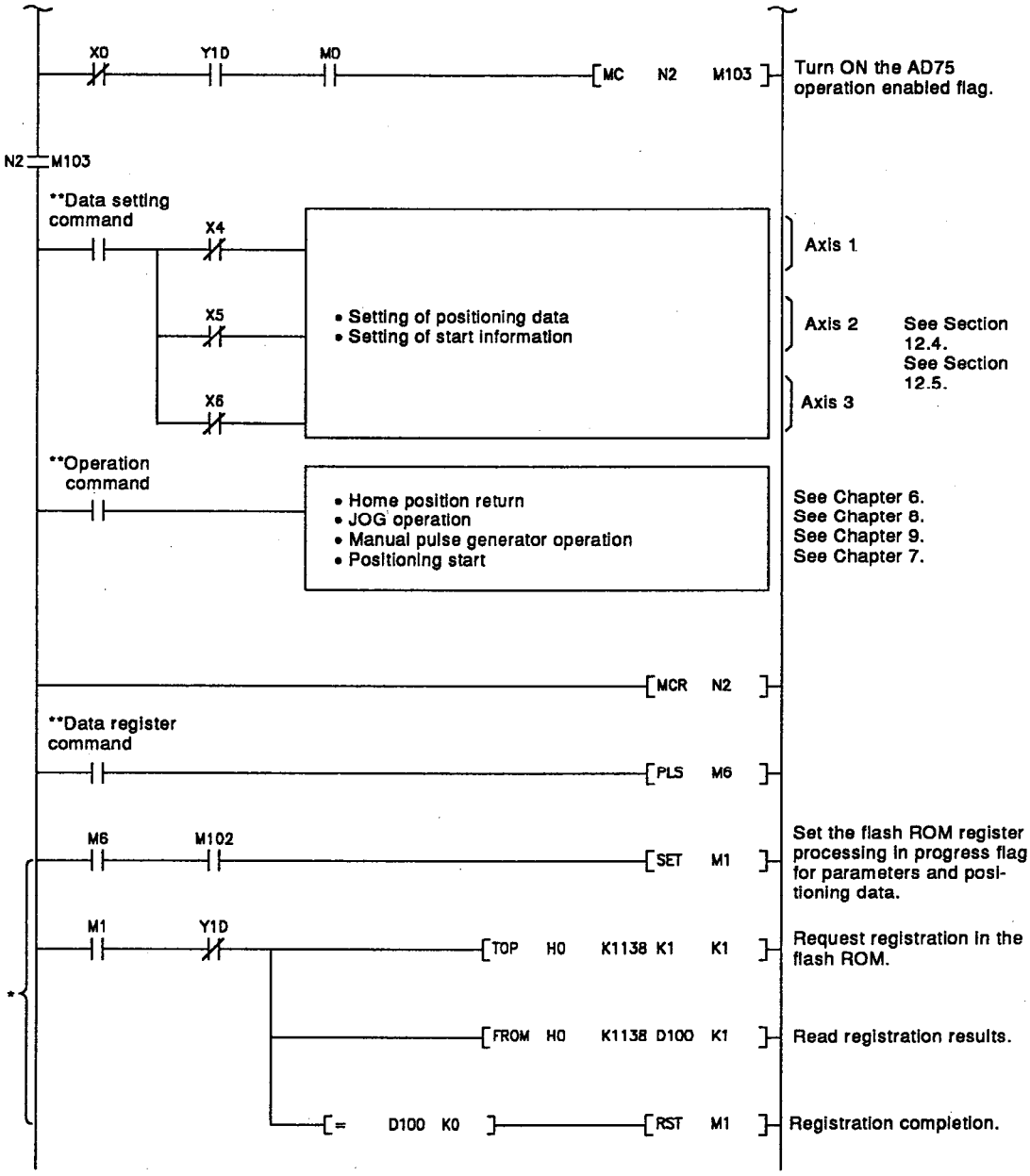
(2) Programming with A0J2CPU
There are some commands which cannot be used, for example TOP/FROMP, if the AD75 is used with A0J2CPU.
If using A0J2CPU, make the following changes:



(3) Restriction on the number of FROM/TO command executions

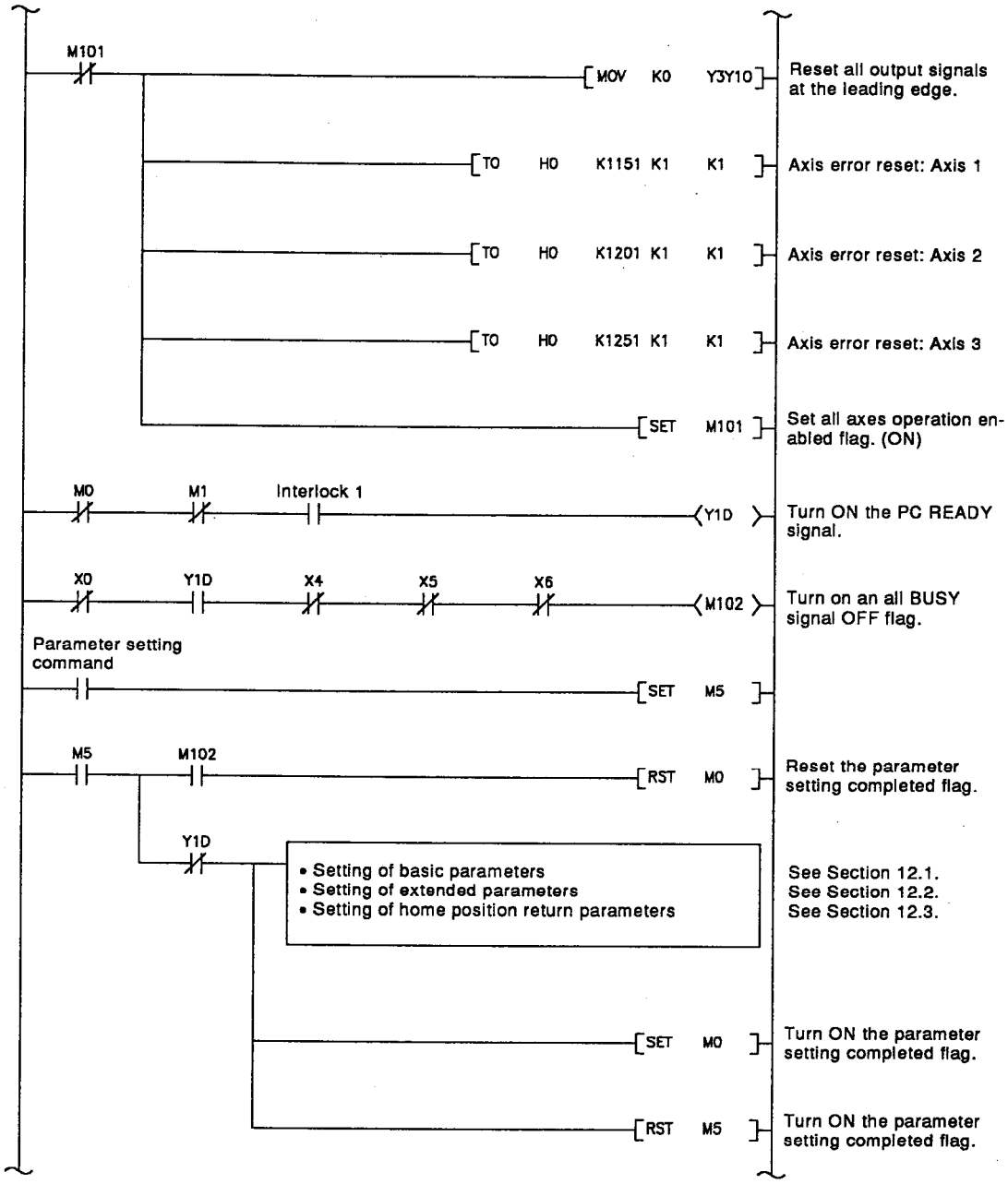
(a) The number of FROM/TO command executions possible for axes subject to positioning control by the AD75 is limited to one execution (32-bit data) per scan per axis.
Communications between the ACPU and the AD75 should be performed by using one FROM/TO command per scan per axis.

(b) Restriction relating to speed change execution intervals
An interval of at least 100 ms is recommended between speed changes executed at the AD75.

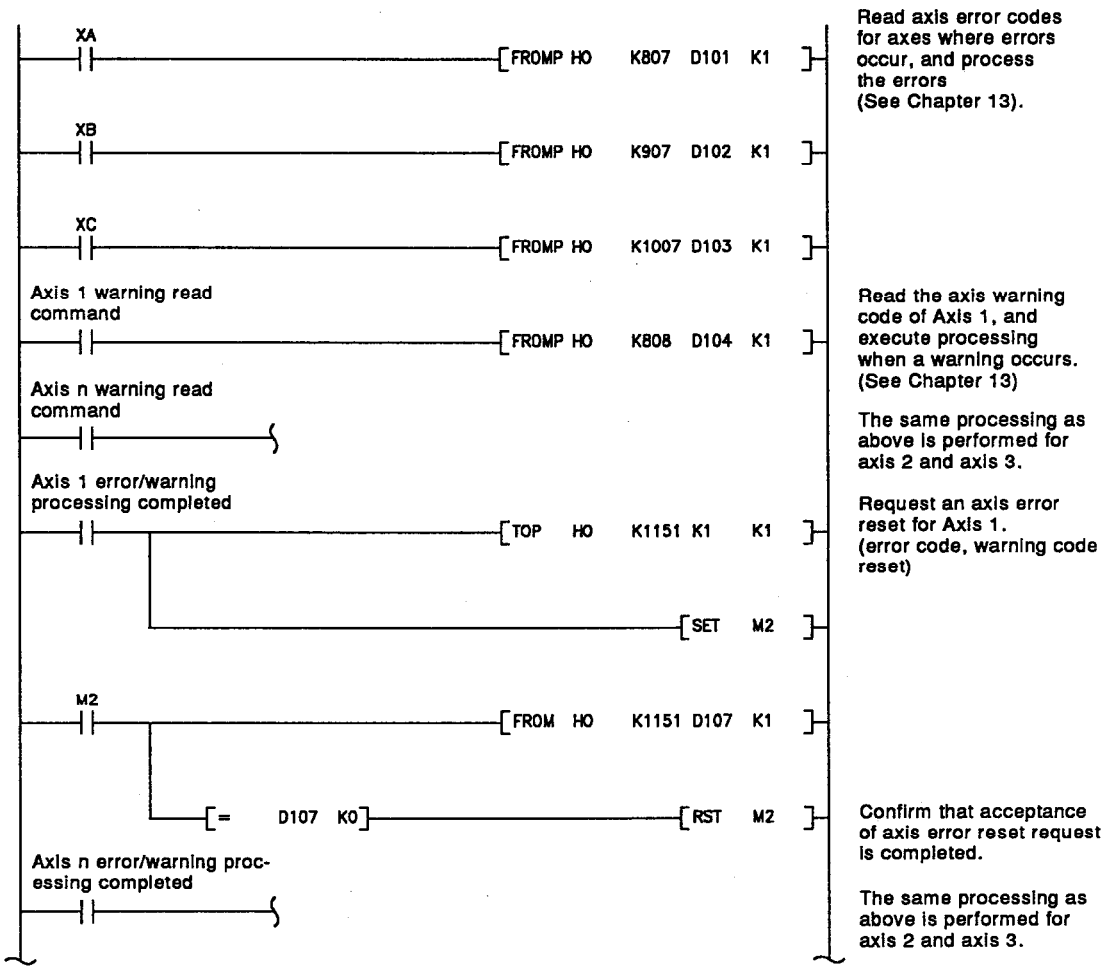


REMARK

* : This is a program for storing data set at the programmable controller-such as the basic parameters, extended parameters, home position return parameters, positioning data, etc. -to the flash ROM.
This program is not necessary if the above data is written to the AD75 by a sequence program when the programmable controller power comes ON.


M101
MOV K0 Y3Y10
Reset all output signals at the leading edge.
TO H0 K1151 K1 K1
Axis error reset: Axis 1
TO H0 K1201 K1 K1
Axis error reset: Axis 2
TO H0 K1251 K1 K1
Axis error reset: Axis 3
SET M101
Set all axes operation enabled flag. (ON)
M0
M1
Interlock 1
Y1D
Turn ON the PC READY signal.
X0
Y1D
X4
X5
X6
M102
Turn on an all BUSY signal OFF flag.
Parameter setting command
SET M5
M5
M102
RST M0
Reset the parameter setting completed flag.
Y1D
• Setting of basic parameters
• Setting of extended parameters
• Setting of home position return parameters
See Section 12.1.
See Section 12.2.
See Section 12.3.
SET M0
Turn ON the parameter setting completed flag.
RST M5
Turn ON the parameter setting completed flag.

[Program examples]



5. CONFIGURATION OF POSITIONING PROGRAMS

This chapter describes the program configuration when creating an AD75 positioning program, and the programs required to execute positioning from the ACPU.

5.1 Program Configuration

The program configuration that can be used when writing the AD75 positioning program is covered here. Compose the program using the required program parts by referring to the relevant reference sections.
Table 5.1 shows the applications of the I/O signals (X,Y), internal relays (M) and data registers (D) which appear in the program examples.

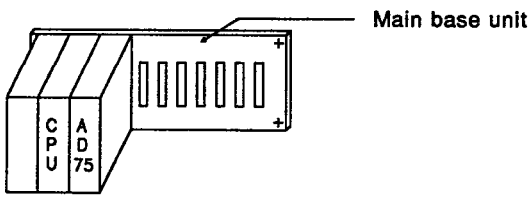
Table 5.1. Devices Used in Program Examples

Device Name	Device			Application	Bit Device: Status when ON Data Register: Stored Data
	Axis 1	Axis 2	Axis 3		
Inputs	X0			AD75 READY	Not ready/WDT error
	X4	X5	X6	BUSY	BUSY (operation in progress)
	XA	XB	XC	Error detection	Error detected
Outputs	Y10	Y11	Y12	Positioning start	Start being requested
	Y13	Y14	Y1C	Axis stop	Stop being requested
	Y16	Y18	Y1A	Forward JOG start	Forward start in progress
	Y17	Y19	Y1B	Reverse JOG start	Reverse start in progress
	Y1D			PC READY	PC CPU normal
Internal relays	M0			Parameter setting completed flag	Setting complete
	M1			Flash ROM register processing in progress flag	Processing in progress
	M2	M3	M4	Axis error reset request in progress flag	Request being made
	M101			Initial error reset completed flag	Error reset completed
	M102			All BUSY signal OFF flag	All BUSY signals OFF
	M103			AD75 operation enabled flag	Operation possible
Data registers	D100			Flash ROM registration result	Registered result
	D101	D102	D103	Axis error code	Error code
	D104	D105	D106	Axis warning code	Warning code
	D107	D108	D109	Axis error reset result.	Axis error reset result

REMARK

Unless otherwise specified, the sequence programs in this section comply with the following conditions.

- CPU module : A3UCPU
- I/O signals of the AD75: X/Y00$_H$ to X/Y1F$_H$ (when the AD75 is set in slot 0 of the main base unit.)



Step 6: Input/output information n monitor

(1) Repeatedly pressing the mode switch displays the following I/O signal names in the 17-segment LED in the order indicated below.

(2) The signal status of each axis indicated on the 17-segment LED is displayed by the axis indicator LED for each axis.

- When the signal is ON ... The axis indicator LED is turned on.
- When the signal is OFF .. The axis indicator LED is turned off.

17-segment LED	I/O Signal Name	Remark
"SVON"	Drive unit READY signal (servo ON signal)	Every time the mode switch is pressed, the next signal in the series is indicated.
"Z-ON"	Zero point signal	
"ULMT"	Upper limit signal	
"LLMT"	Lower limit signal	
"V-P"	Speed/position switching signal	
"DOG"	Near-zero point signal	

Step 7: Switching to operation monitor 1/end of operation monitoring

(1) When the mode switch is pressed, the status returns to operation monitor 1 of step 2.
The operation monitoring from step 2 to step 6 can be repeated by successively pressing the mode switch.

(2) To end operation monitoring, set any required monitor status from step 2 to step 6.

POINTS

(1) The operation monitor function described in this section can be used at any time to check the AD75 status, control status of each axis, and I/O signal status.

(2) Use the operation monitor function when the AD75 is not operating normally, and whenever else it becomes necessary.

(3) In addition to the 17-segment LED displays indicated above, the "FALT" will be displayed if a watchdog timer error occurs at the AD75.
If a watchdog timer error occurs at the AD75, the ACPU must be reset.
If a watchdog timer error still occurs on the AD75 after the ACPU has been reset, the AD75 module must be replaced.
In this case, please contact your nearest Mitsubishi representative.

Step 3: Operation monitor 2

(1) The axis indicator LEDs for each axis are turned ON at approximately 0.5-second intervals in the following order.
In addition, the status of the axis for which the axis indicator LED is ON is indicated on the 17-segment LED.

Axis Conditions	17-segment LED	Remarks
Stand-by	IDLE	• Status when power is turned on/off.
Stopped	STOP	• Temporary stop status of positioning operation.
JOG operation in progress	JOG	———
Manual pulse generator operation in progress	MANP	
Home position return in progress	OPR	
Position control in progress	POSI	
Speed control in progress	VELO	
Speed control part of speed/position switching control in progress	V-P	
Position control part of speed/position switching control in progress	V-P	
Wait status	BUSY	• Wait status of execution by condition designation
Error	E***	• The error code is displayed at the part indicated here by ***. For details on error codes, see Chapter 13.

(2) When the mode switch is pressed, the condition is switched to internal information monitor 1, which is described in step 4.

Step 4: Internal information 1 monitor

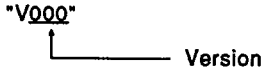
(1) The OS type of the AD75 ("S000") is displayed in the 17-segment LED. Use this as a reference.

(2) The axis indicator LEDs for each axis are turned off.

(3) When the mode switch is pressed, the condition monitor is switched to internal information 2, which is described in step 5.

Step 5: Internal information 2 monitor

(1) The OS version of the AD75 is displayed in the 17-segment LED. Use this as a reference.



(2) The axis indicator LED for each axis is turned off.

(3) When the mode switch is pressed, the condition is switched to the input/output information monitor n, which is described in step 6.

4.6 System Test (Operation Monitor)

This section explains how to check whether the AD75 is operating normally or not at the AD75 itself.
This test can be executed even when no sequence program is stored in the ACPU, or no data is stored in the AD75, or when the AD75 is operating.

Connect the AD75, drive unit, motor and external device before starting the test.

"Mode switch", "17-segment LED" and "axis indicator LED" in the test description are references to the switches/LEDs of the AD75.

Step 1: Power ON

(1) Set the ACPU to STOP.
(If the AD75 is installed at a remote station, set the master station to STOP.)

(2) Turn on the power of the ACPU (or the station at which the AD75 is installed and the master station if the AD75 is installed at a remote station), the drive unit connected to the AD75, and the motor.

(3) The OS type of the AD75 ["S000" is the same as the display in step 4] is displayed in the 17-segment LED for one second.

(4) After one second, the display is switched to operation monitor 1 described in Step 2.

Step 2: Operation monitor 1

(1) One of the following items is displayed in the 17-segment LED and axis indicator LED according to the AD75 conditions.

AD75 Status	17-segment LED	Axis Indicator LED for Each Axis
Operation in progress	RUN	Displays the BUSY signal status of the relevant axis.
Test mode effective	TEST	Light ON: BUSY signal is turned ON.
Stand-by	IDL	Light OFF: BUSY signal is turned OFF.
Error	ERR	LED of axis subject to error comes ON.

(2) When mode switch is pressed, the display is switched to operation monitor 2 described in step 3.

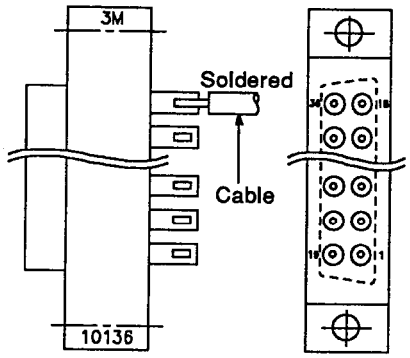
4.5.3 Connecting signal wires

The connector pin wiring is shown below. Connect in accordance with the I/O arrangement and numbers (see Section 3.2.2).

(1) Use AWG#24 to #30 wires (approx. 0.2 to 0.05 SQ).

(2) Solder the wires to the pins. Remove the wire insulation carefully. Be careful not to cause a short circuit due to a wire strand or solder whisker.

(3) Secure the electric wire in the cable clamp, making sure that no tension is applied to the wire connections.
If the presser of the cable clamp does not contact the cable properly, wrap the cable with insulating tape so that it can be clamped better.



Pin arrangement viewed from the above. The connector pin numbers in the figure to the left are as follows:

- Right ... 1 to 18 from the bottom
- Left ..... 19 to 36 from the bottom

4.5.2 External wiring connector disassembly/assembly procedure

For the external wiring connectors have the interface components for external connection of the module packaged with them.
When connecting signal lines, disassemble the connector as shown below.
The disassembly and assembly procedures are as follows:

(1) Loosen the two screws, and remove them.
(Be sure that screws and nuts do not get lost.)

(2) Open the connector cover from the connector side, and remove it by pulling backward.

(3) Take out the cable clamp and loosen the screw.

(4) Pass the signal cable through the cable clamp.

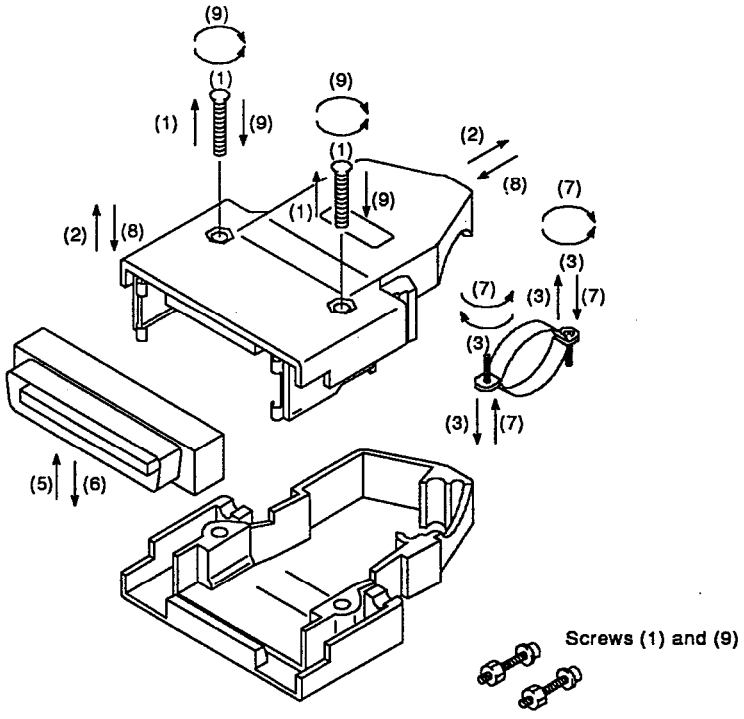
(5) Take out the part to which the connections are made and connect each wire of the signal cable. (For the connecting procedure, see Section 4.5.3.)

(6) Put the part to which connections are made back inside one half of the connector cover.

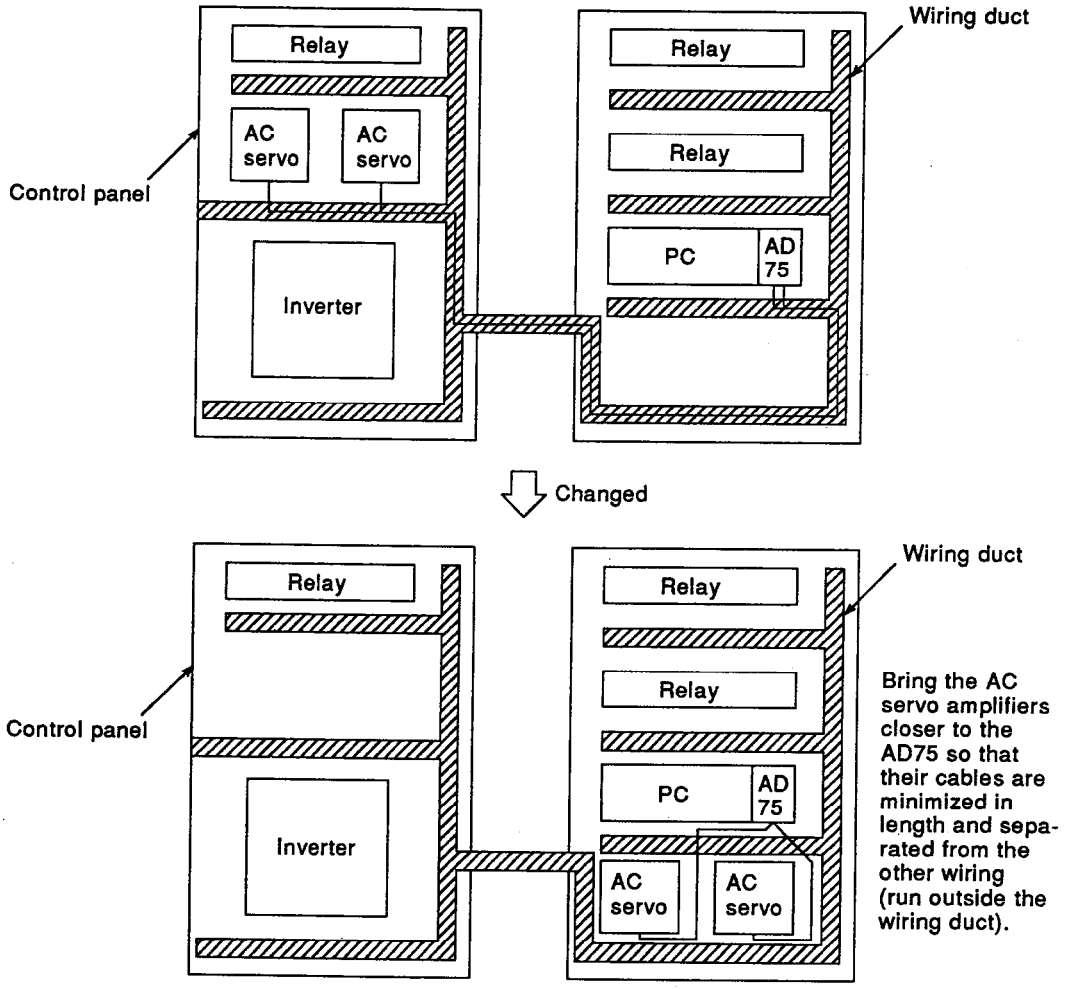
(7) Fasten the screws of the cable clamp and replace it at the position in the connector cover (the same half as in (6) above) from which it was removed.
If the presser of the cable clamp does not contact the cable properly, wrap the cable with insulating tape so that it can be clamped better.

(8) Replace the half of the cover that was removed by pulling it back-end first onto the other half.

(9) Replace and tighten the screws.

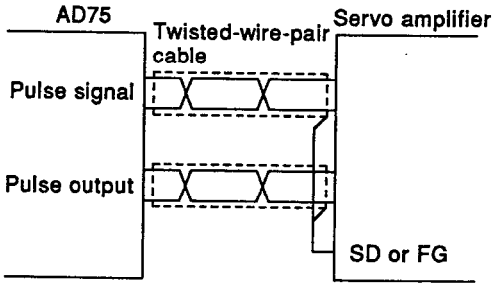


Examples (bad example at the top, good example at the bottom)



REMARK

In environments where noise is likely to cause a problem in the wiring between the AD75 and servo amplifier, use shielded twisted-wire-pair cable that is separate from other shielded cables for the wiring from the AD75 pulse train output terminals.



4.5 Wiring

This section describes the precautions when connecting wiring between the AD75 and external devices (including a drive unit), and how to use the external wiring connector.

4.5.1 Wiring precautions

The precautions when connecting wiring between the AD75 and external devices (including a drive unit) are described below.

(1) Length of connecting cable between the AD75 and drive unit

(a) The length of the connection cable between the AD75 and drive unit is 1 to 3 meters if using an open collector.
However, the distance depends on the drive unit specifications. Confirm the correct specifications of the drive unit.

(b) The length is a maximum of 30 meters if using a differential driver.
If the AD75 and drive unit area long distance apart, use a differential driver.

(2) I/O signal wiring

(a) Do not bundle I/O signal wires with, or lay them close to, power lines or main circuit lines.

(b) If I/O signal wires have to be laid close to these lines, either use a partitioned duct or separate conduits.

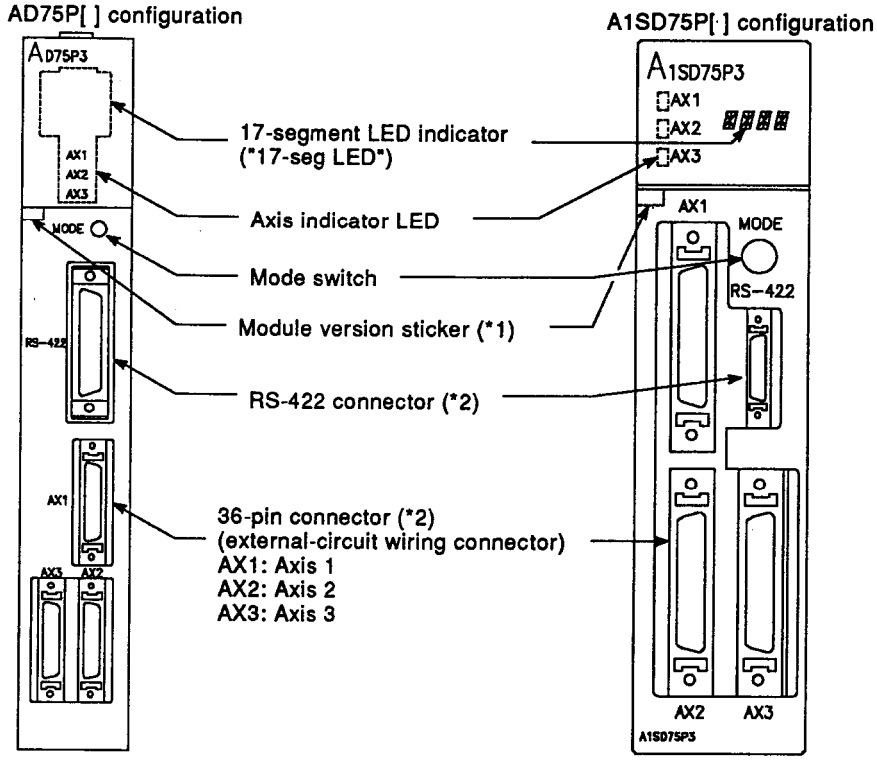
(c) If there is no alternative but to bundle the cables together, use a shielded cable and ground its shielding at the PC CPU side.

(d) If conduits are used for wiring, ground the conduits.

(e) If the connecting cable is too long, or is too close to a main circuit line, malfunctions could occur due to noise.

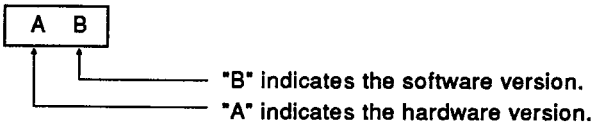
4.4 Part Names

The names of each part of the AD75 are indicated below:

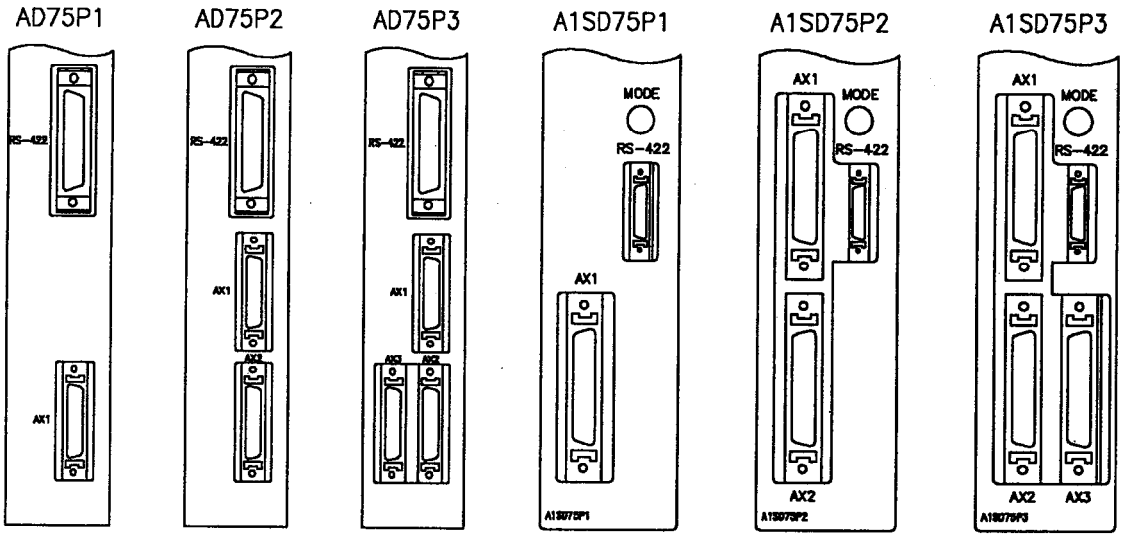


REMARKS

1) *1: Stickers for hardware version and software version of the module.
(Example)



2) *2: The interfaces of each AD75 are indicated below:

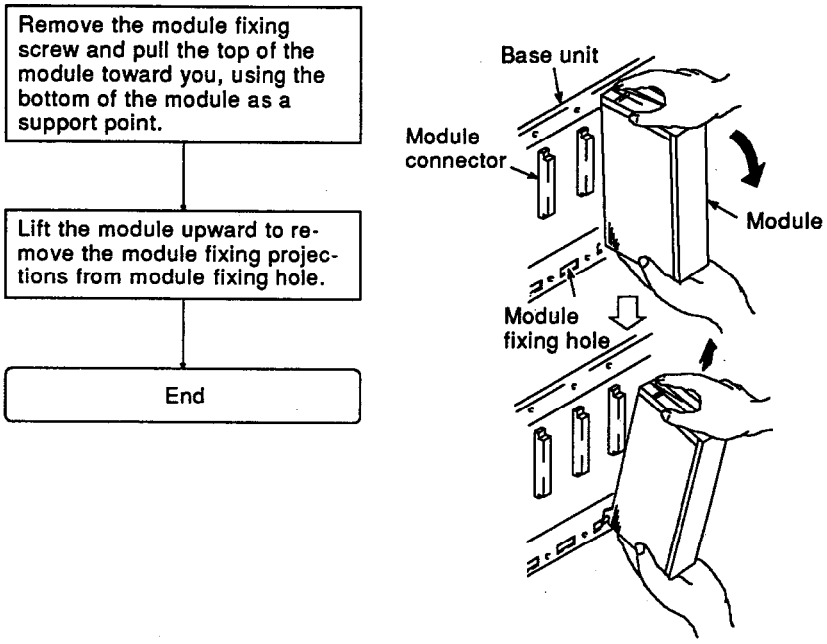


(b) Removing the module

The procedure for removing the module is as follows:

⚠ CAUTION

Turn off power before removing the module.
Removal with the power on may result in failure or malfunction of the module.



POINT

Remove the module fixing screw from the module, then remove the module fixing projections from the module fixing hole.
Forced removal of the module may damage the module fixing projections.

(2) Mounting/removing the AISD75P[ ].

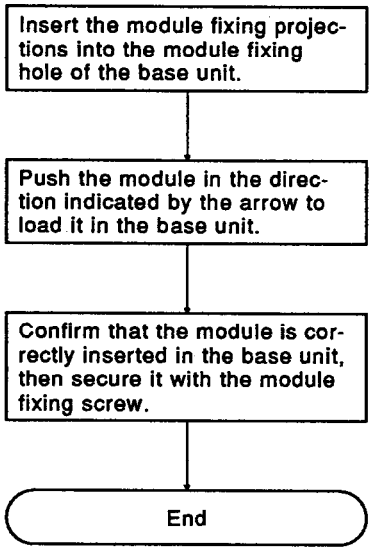
(a) Mounting the module

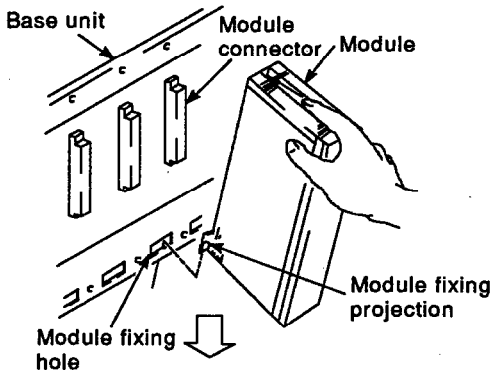
The procedure for mounting the module is as follows:

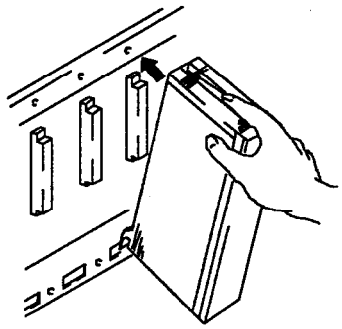
⚠ CAUTION

(1) To mount the module in a base unit, first insert the module fixing projections into the module fixing hole.
Incorrect insertion of the module may result in malfunction, failure, or the module falling out.

(2) Turn the power supply OFF before mounting the module.
Installation with the power on could result in failure or malfunction of the module.

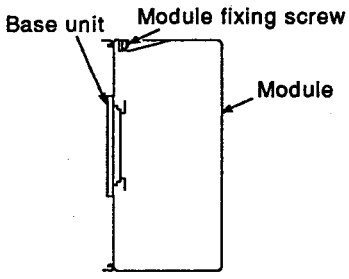






POINT

Attempting to mount the module without inserting the fixing projections into module fixing hole (B) may damage the module connector and module.



(b) Removing the module

The procedure for removing the module is as follows:

⚠ CAUTION

Turn off power before removing the module.
Removal with the power on may result in failure or malfunction of the module.

Hold the module with both hands and push the hook at the top of the module with your finger as far as it will go.

↓

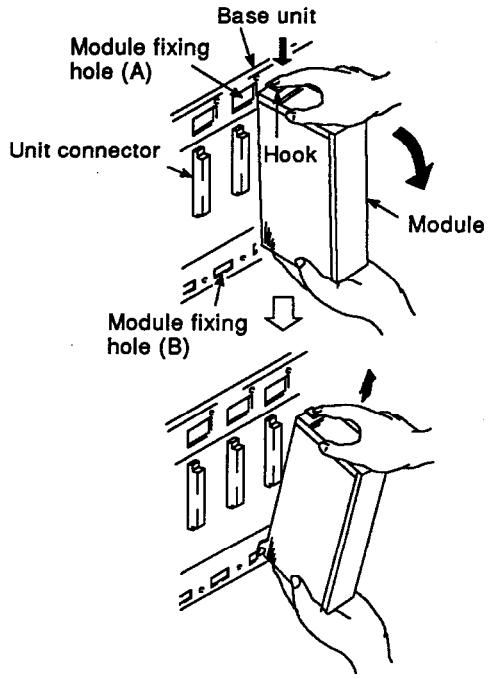
Pull the module toward you, using the bottom of the module as a support point, while holding the hook in the same position.

↓

Lift the module upward to remove the module fixing projections from module fixing hole (B).

↓

End



POINT

Remove the hook from module fixing hole (A), then remove the module fixing projections from module fixing hole (B).
Forced removal of the module may damage the hook or module fixing projections.

4.3.3 Mounting/removing the module

This section explains how to mount the AD75 in the base unit, and how to remove it.

(1) Mounting/removing the AD75P[ ].

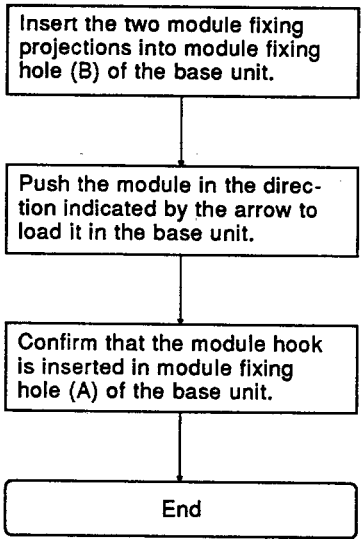
(a) Mounting the module

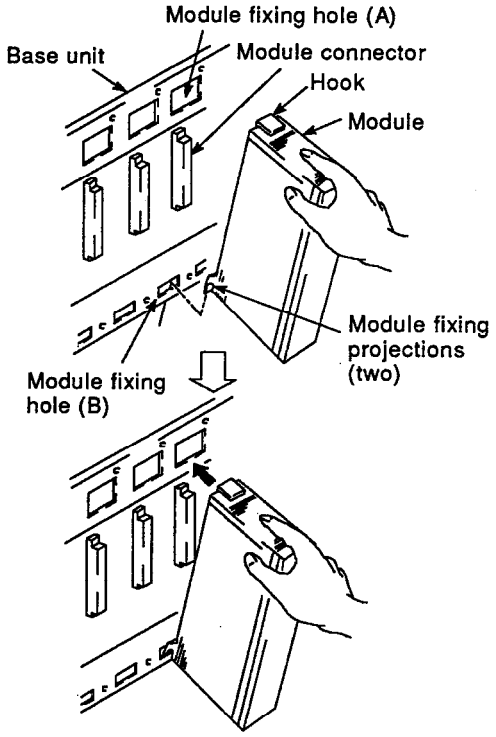
The procedure for mounting the module is as follows:

⚠ CAUTION

(1) To mount the module in a base unit, first insert the module fixing projections into the module fixing hole.
Incorrect insertion of the module may result in malfunction, failure, or the module falling out.

(2) Turn the power supply OFF before mounting the module.
Installation with the power on could result in failure or malfunction of the module.

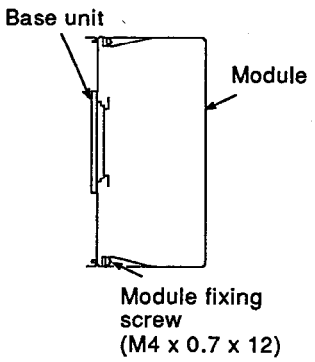




POINTS

(1) Forcibly installing the module without inserting the module fixing projections into module fixing hole (B) may bend the module connector pins or damage the module.

(2) If the module is used in a location subject to a lot of vibration, secure the module to the base with screws. The user must prepare the screws (M4 x 0.7 x 12). (Tightening torque range: 78 to 118 N·cm (8 to 12 kg·cm):[6.9 to 10.4b·inch]) The mounting method is shown on the right.



4.3 Loading and Installation

This section explains the methods for loading and installation and the precautions to take to increase system reliability and to use the functions most efficiently.

⚠ DANGER
Use the programmable controller in an environment that complies with the general specifications stated in this manual. Using it in an environment that does not comply with the specifications could result in electric shock, fire, malfunction, personal injury or deterioration.

4.3.1 Installation environment

Do not install the A series programmable controller at locations subject to any of the following environmental conditions:

(1) Ambient temperatures outside the range 0 to 55 °C.

(2) Ambient humidities outside the range 10 to 90 %RH.

(3) Condensation due to sudden temperature changes.

(4) Corrosive or inflammable gases.

(5) Excessive airborne dust, conductive particles such as iron powder, oil mist, salt, or organic solvents.

(6) Direct sunlight.

(7) Strong electric or magnetic fields.

(8) Direct vibrations or impacts.

4.3.2 Loading precautions

Pay attention to the following points when loading the AD75 to the base unit (main base unit or extension base unit):

(1) Do not load the AD75 to an extension base without a power supply module (A5[ ]B/A1S5[ ]B(S1)). When connecting it, consider the power supply capacity, voltage drop in the extension cable, etc.

(2) If the board temperature exceeds 55 °C, consider forced ventilation of the PC CPU board.

4.2 Handling Precautions

The precautions for handling the AD75 are described below.

(1) The case of the AD75 is made of plastic: do not drop it or subject it to strong impact.

(2) Do not remove the printed circuit board from the case. This could cause failure.

⚠ CAUTION
(3) Turn the PC CPU power supply OFF before mounting the AD75 in a base unit or removing it from a base unit. Mounting or removal with the power on may result in failure or malfunction of the module. (4) Make sure that no wire offcuts or other debris enters the top of the AD75 during wiring, since this could cause fire, failure or malfunction. If anything does enter the module, remove it.

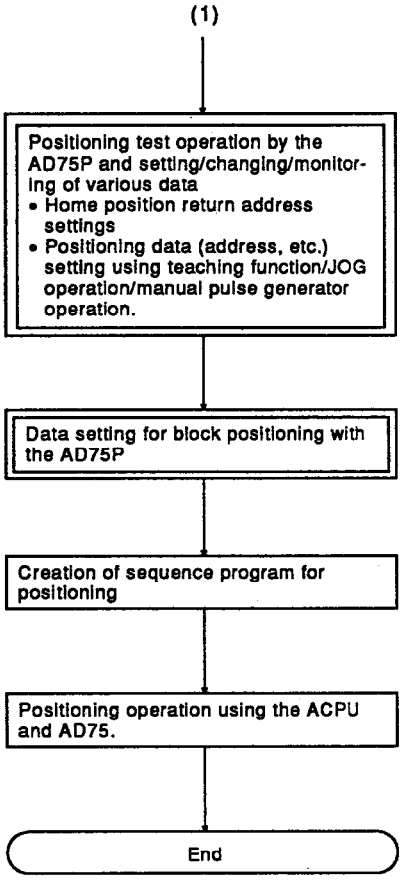
(5) Tighten the module fixing screws within the range described in Section 4.3.3.
For installation/removal of the AD75 to/from the base unit, see Section 4.3.3.

(6) Turn the PC CPU and drive unit power supply OFF before connecting or disconnecting the drive unit connector.
After confirming the correct orientation for insertion, insert the connector directly from the front. Then secure it with the two fixing screws.
Incorrect insertion may result in incorrect input or output due to defective contact.

⚠ DANGER
(7) When the drive unit is not connected, be sure to attach the cover to the connector area of the AD75 interface. Otherwise, malfunction may occur.

(8) After confirming the correct orientation for insertion, insert the connector directly from the front. Then secure it with the two fixing screws.
If no peripheral device is connected, attach the cover to the RS-422 connector area.

⚠ CAUTION
(9) Never disassemble or modify the module. This could cause failure, malfunction, injury or fire. Otherwise, malfunction may occur.



• Operation in the test mode/monitor mode
Setting/changing of data which was not set to the correct value in the edit mode.

• Setting of positioning start data

• See Chapter 5.

REMARK

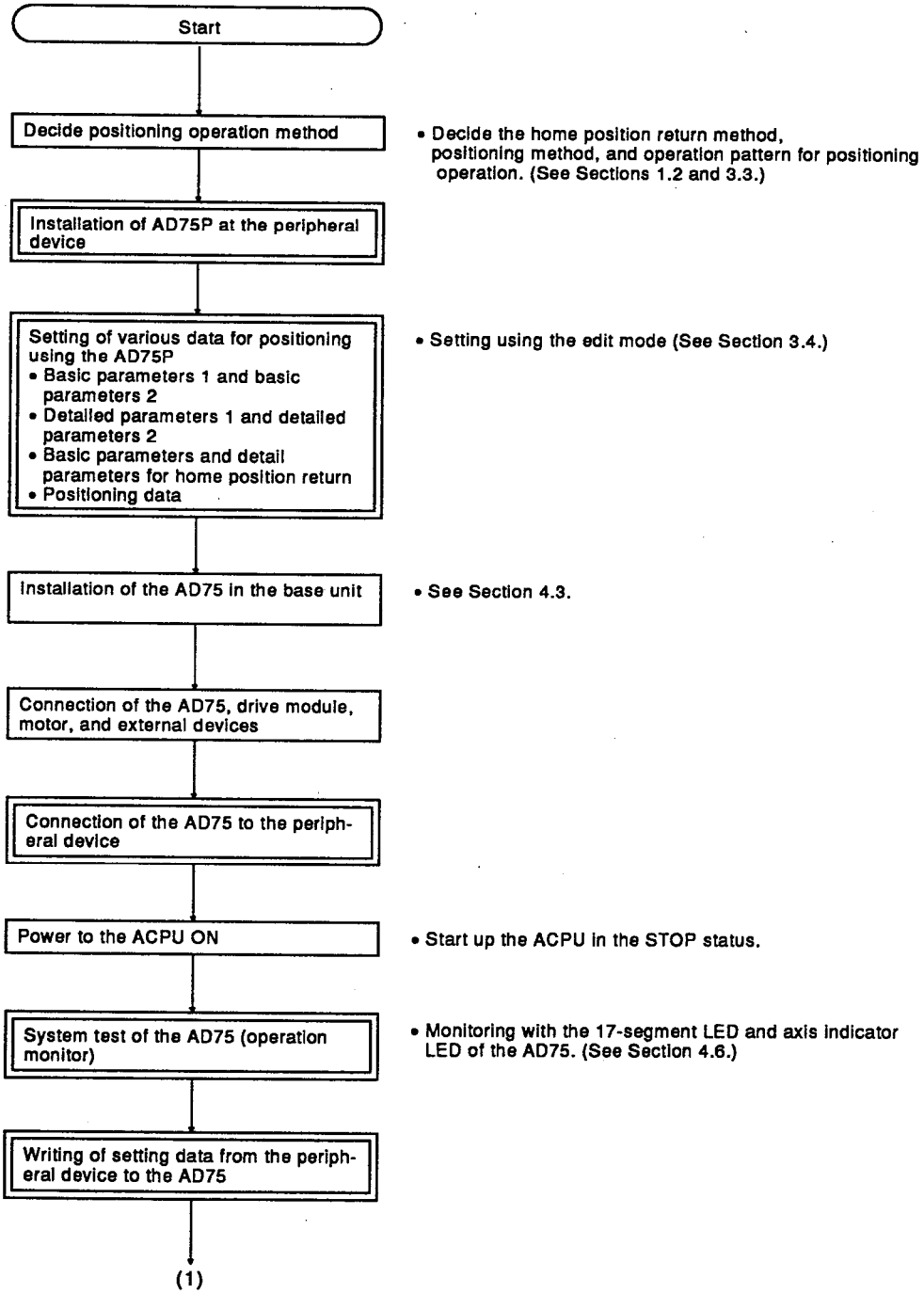
For ☐ refer to the operating manual for the AD75P.

4. OPERATING PROCEDURE AND SETTING

This chapter describes the start-up and positioning procedure, part names, wiring, and connection with an external device.

4.1 Outline of Procedure

The outline of the procedure for positioning operation using the AD75 is as follows:

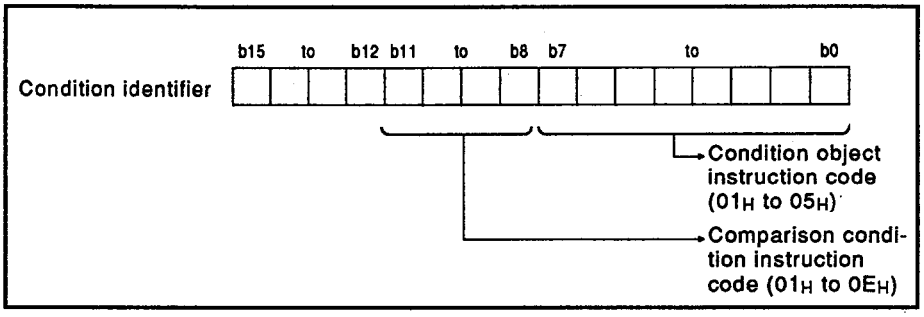


MEMO

(c) Set the data shown below for the items in the condition data area.

1) For the condition identifier, set the "condition object instruction code" and the "comparison condition instruction code".

[For details on the condition object instruction code and comparison condition instruction code, see Section 3.4.7 (1).]



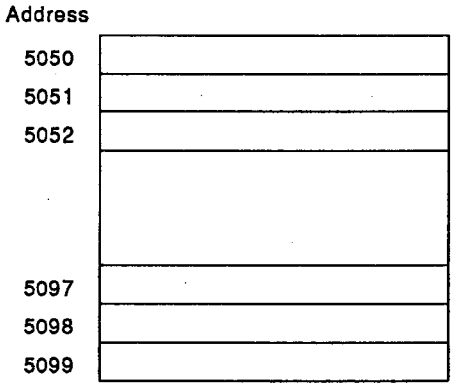
2) For details on the address, parameter 1, and parameter 2, see Section 3.4.7 (2) to (5).

3.6.7 PC CPU memory area

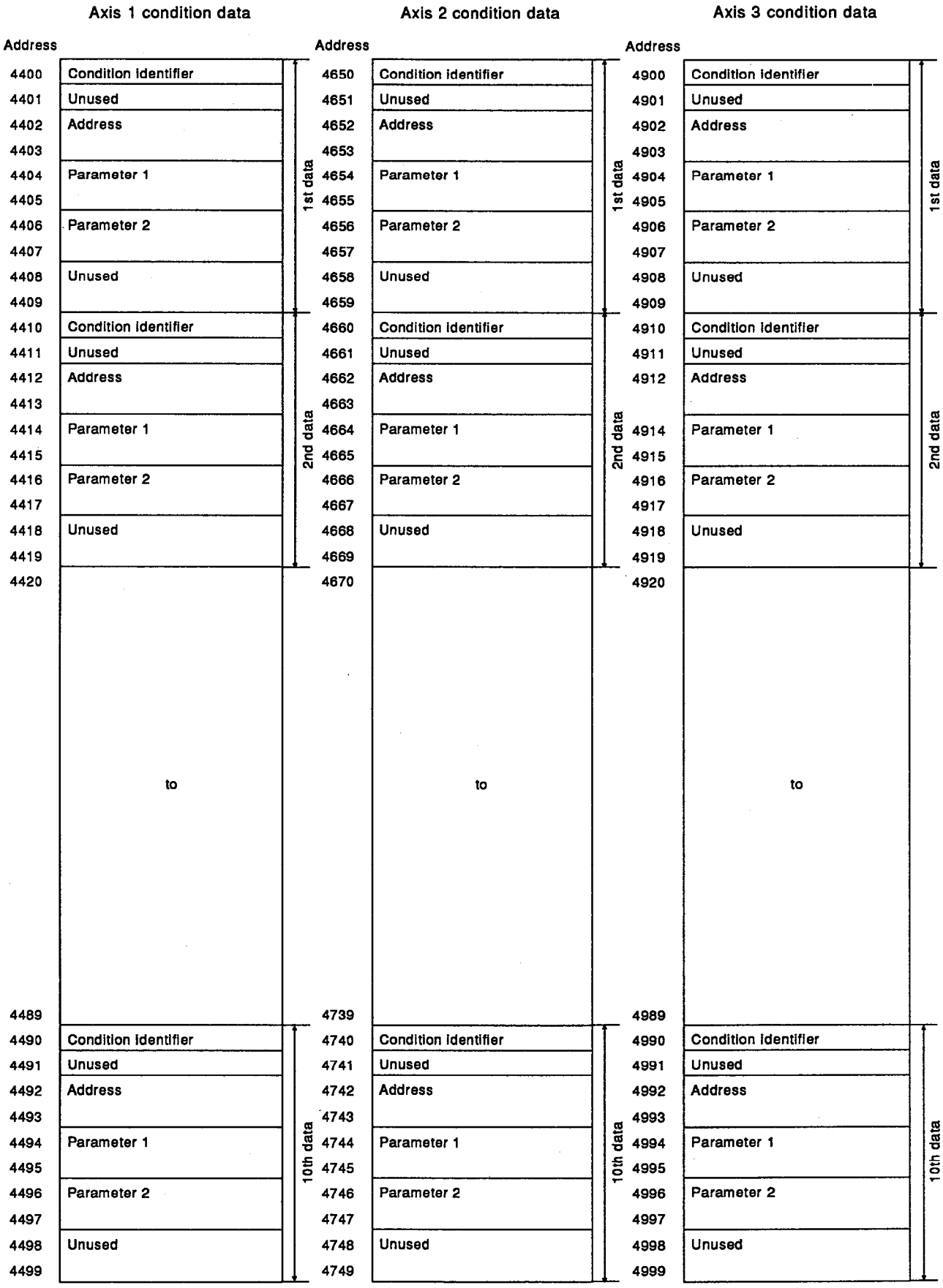
The PC CPU memory area is an area which can be read from and written to without restriction by the sequence program.
This area is also used for the conditions relating to positioning start information condition data. Positioning starts can be controlled by the sequence program by setting values for condition judgments and wait judgments in this area.

When the AD75 is turned OFF, the values written in the PC CPU memory area are deleted. When the power is turned on, the values are cleared to zero.

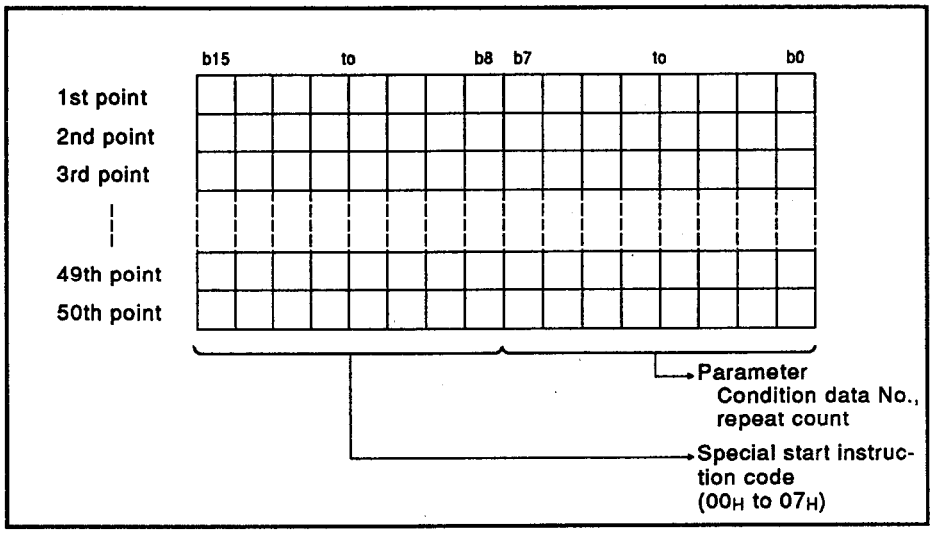
[PC CPU memory area of buffer memory]



(b) Configuration of condition data



(c) The positioning data area has the configuration shown below.



(3) Condition data area

(a) In the condition data area, set the condition designated by the parameter in the positioning special start data.
There can be from 1 to 10 condition data areas.

(2) Positioning special start data area

(a) The positioning special start data area is the area in which AD75 special starts are set.
The positioning special start data area has a 1 to 1 correspondence with the positioning start data area.

Positioning start data area		Positioning special start data area
1st point	----------	1st point
2nd point	----------	2nd point
3rd point	----------	3rd point
49th point	----------	49th point
50th point	----------	50th point

(b) Set the "special start instruction code" and "parameter" in the positioning special start data area.
(For details on the special start instruction code and parameter, see Section 3.4.6.)

1) For the special start instruction code, set the instruction code for a special start start condition (00_H to 07_H).

2) For the parameter, set a condition data number or repeat count.

Special Start	Instruction Code	Setting Parameter
Normal start	00_H	—
Conditional start Wait start Simultaneous start	01_H 02_H 03_H	Condition data No. 1 to 10*
Stop start	04_H	—
FOR loop	05_H	Repeat count (0 to 255)
FOR condition	06_H	Condition data No. 1 to 10*
NEXT	07_H	—

REMARK

* : For the condition data No., set which of the condition data in (3) is to be used.

(1) Positioning start data area

(a) The positioning start data area is the area used when performing block positioning.
It is an area for 1 to 50 points.

(b) Which of the points of the positioning start data area is to be started is designated using the buffer memory for positioning start point No. setting.

	Buffer Memory Address
Axis 1	1178
Axis 2	1228
Axis 3	1278

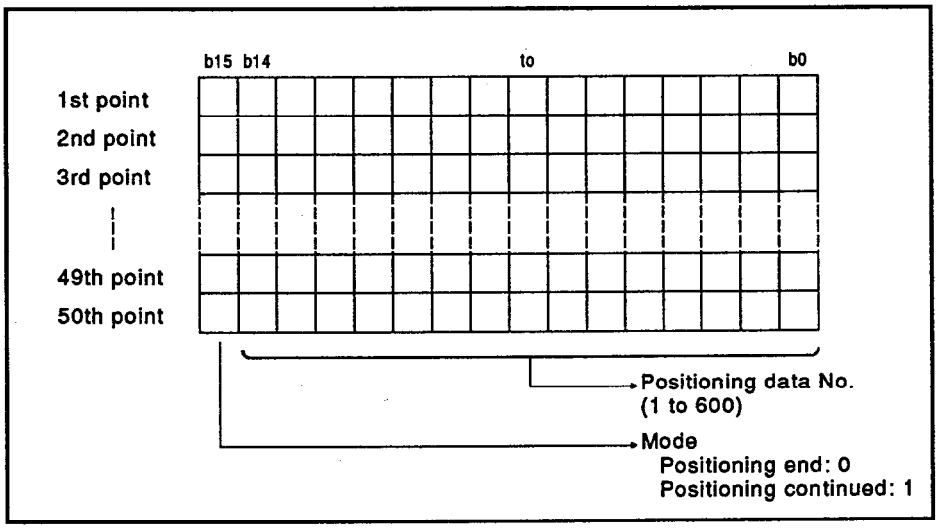
If operation is started without making a setting in the buffer memory for setting the positioning start point number, operation is started from the first point.

(c) Set the "mode" and "positioning data No." in the positioning start data.*
(For details on the mode and positioning data No., see Section 3.4.6.)

1) Set "positioning end: 0" or "positioning continued: 1" for the mode.

2) Set a positioning data No. within the range 1 to 600.

(d) The positioning data area has the configuration shown below.



REMARK

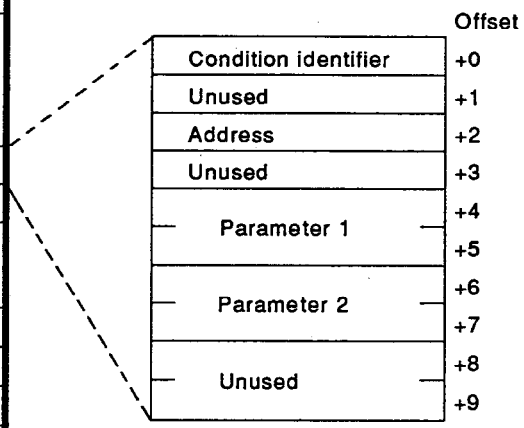
* : Set the data No. for which positioning control is executed as the positioning data No.

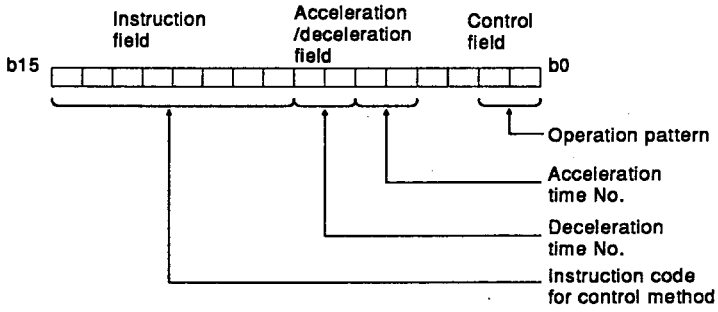
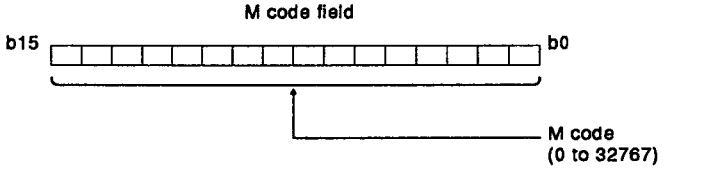
3.6.6 Positioning start information area

This section describes the positioning start information area in the buffer memory.

The buffer memory for axis 1, 2 and 3 is described.
For details of setting, see Section 3.4.6 to 3.4.7.

Positioning Start Information		Address for Axis 1	Address for Axis 2	Address for Axis 3
Positioning start data	1st point	4300	4550	4800
	2nd point	4301	4551	4801
	3rd point	4302	4552	4802
	to	to	to	to
	50th point	4349	4599	4849
Positioning special start data	1st point	4350	4600	4850
	2nd point	4351	4601	4851
	3rd point	4352	4602	4852
	to	to	to	to
	50th point	4399	4649	4899
Condition data	1st data	4400	4650	4900
	to	to	to	to
	10th data	4490	4740	4990
Indirect designation	8001	4500	4750	5000
	8002	4501	4751	5001
	to	to	to	to
	8050	4549	4799	5049



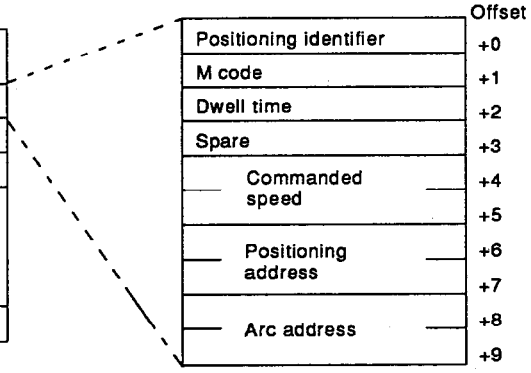
<table>
<tr><th colspan="3">Buffer Memory Address</th><th colspan="2" rowspan="2">Item</th><th colspan="4" rowspan="2">Remark/Setting Range</th><th rowspan="2">Initial Value</th></tr>
<tr><th>Axis 1</th><th>Axis 2</th><th>Axis 3</th></tr>
<tr><td>1300</td><td>2300</td><td>3300</td><td colspan="2">Positioning identifier</td><td colspan="4"> 
</td><td>0</td></tr>
<tr><td>1301</td><td>2301</td><td>3301</td><td colspan="2">M code</td><td colspan="4"> 
</td><td>0</td></tr>
<tr><td>1302</td><td>2302</td><td>3302</td><td colspan="2">Dwell time</td><td colspan="4">0 to 65535 ms</td><td>0</td></tr>
<tr><td>1303</td><td>2303</td><td>3303</td><td colspan="2">Not used</td><td colspan="4">—</td><td></td></tr>
<tr><td rowspan="2">1304
1305</td><td rowspan="2">2304
2305</td><td rowspan="2">3304
3305</td><td colspan="2" rowspan="2">Commanded speed</td><td colspan="4">-1: Setting of the commanded speed is omitted.</td><td></td></tr>
<tr><td>1 to 600000000
x 10^{-2} μm/min</td><td>1 to 600000000
x 10^{-3} inch/min</td><td>1 to 600000.000
/min</td><td>1 to 1000000
pulse/s</td><td>0</td></tr>
<tr><td rowspan="5">1306
1307</td><td rowspan="5">2306
2307</td><td rowspan="5">3306
3307</td><td rowspan="5">Positioning address</td><td>ABS</td><td>-2147483648 to
+2147483647
x 10^{-1} μm</td><td>-2147483648 to
+2147483647
x 10^{-5} inch</td><td>0 to
35999999
x 10^{-5} degree</td><td>-2147483648 to
+2147483647
pulse</td><td>0</td></tr>
<tr><td rowspan="4">INC</td><td colspan="4">Other than speed/position switching control</td><td rowspan="2">0</td></tr>
<tr><td>-2147483648 to
+2147483647
x 10^{-1} μm</td><td>-2147483648 to
+2147483647
x 10^{-5} inch</td><td>-2147483648 to
+2147483647
x 10^{-5} degree</td><td>-2147483648 to
+2147483647
pulse</td></tr>
<tr><td colspan="4">Speed/position switching control</td><td rowspan="2">0</td></tr>
<tr><td>0 to 2147483647
x 10^{-1} μm</td><td>0 to 2147483647
x 10^{-5} inch</td><td>0 to 2147483647
x 10^{-5} degree</td><td>0 to 2147483647
pulse</td></tr>
<tr><td rowspan="2">1308
1309</td><td rowspan="2">2308
2309</td><td rowspan="2">3308
3309</td><td rowspan="2">Arc address</td><td>ABS</td><td rowspan="2">-2147483648 to
+2147483647
x 10^{-1} μm</td><td rowspan="2">-2147483648 to
+2147483647
x 10^{-5} inch</td><td>0 to 35999999
x 10^{-5} degree</td><td rowspan="2">-2147483648 to
+2147483647
pulse</td><td rowspan="2">0</td></tr>
<tr><td>INC</td><td>-2147483648 to
+2147483647
x 10^{-5} degree</td></tr>
</table>

3.6.5 Positioning data area

This section describes the positioning data area in the buffer memory.
The buffer memory address and setting range for axis 1, 2 and 3 are described.
For details of setting, see Section 3.4.5.

[Buffer memory positioning data areas configuration]

Positioning data No.	Axis 1 address	Axis 2 address	Axis 3 address
1	1300	2300	3300
2	1310	2310	3310
3	1320	2320	3320
to	to	to	to
100	2290	3290	4290

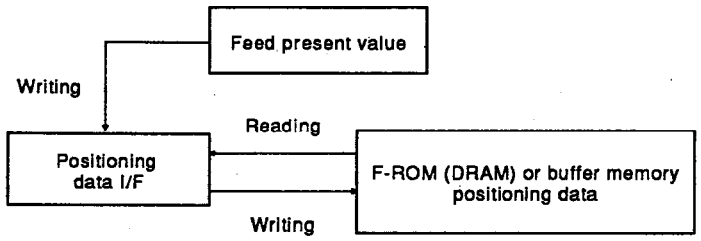


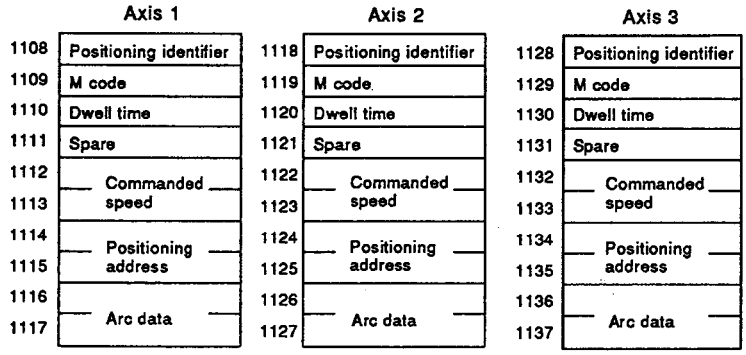
REMARK

For details on the buffer memory addresses for positioning data numbers 1 to 100, see APPENDIX 3.

Buffer Memory Address			Item	Remark/Setting Range	Initial Value
Axis 1	Axis 2	Axis 3			
1170	1220	1270	Home position return request Flag OFF request	• Status of the home position return request flag is turned from ON to OFF. bit0 0: Home position return request flag OFF request accepted (set by OS) 1: Home position return request flag OFF request (set by sequence program)	0
1171	1221	1271	External start valid	• External start is valid. bit0 0: Makes external start invalid. 1: Makes external start valid.	0
1172	1222	1272	Step valid flag	• This flag is used to check each operation in positioning operation. bit0 0: Step operation is not carried out. 1: Step operation is carried out.	0
1173	1223	1273	Step mode	• Sets the positioning unit to be used for step operation. bit0 0: Steps in deceleration units 1: Steps in data No. units	0
1174	1224	1274	Step start information	• This is used for continuation or restart of step operation. bit0 00H: Step start request accepted 01H: Step continuation 02H: Restart	0
1175	1225	1275	Skip command	• When the skip command is turned ON during positioning operation, an automatic deceleration stop occurs and the next positioning is carried out. bit0 0: Skip request accepted (set by OS) 1: Skip request (set by sequence program)	0
1176	1226	1276	Torque change value	• Sets the torque change value. Setting range: 0 to torque control limit value set by parameter	0
1178	1228	1278	Position start point No.	• Set the start point No. for executing positioning (block start). 1 to 50 : Start from the designated point No. Other than above : Start from the first point	0

Buffer Memory Address			Item	Remark/Setting Range				Initial Value
Axis 1	Axis 2	Axis 3						
1150	1200	1250	Positioning start No.	• Start No. for executing positioning is set.				0
1151	1201	1251	Axis error reset	• Axis error detection, axis error No., axis warning detection and axis warning No. are cleared. • Change the axis operation status from "error" to "standby" (start from the beginning if start is included).				0
				bit0 0: Axis error reset request accepted (set by OS) 1: Axis error reset request (set by sequence program)				
1152	1202	1252	Restart command	• When "1" is set while the axis operation status is "stopped", positioning based on the positioning data at the stop is executed from the stop position to the end point.				0
				bit0 0: Restart command accepted (set by OS) 1: Restart command request (set by sequence program)				
1153	1203	1253	M code OFF request	• M code ON signal is turned OFF by the M code OFF request.				0
				bit0 0: M code OFF request accepted (set by OS) 1: M code OFF request (set by sequence program)				
1154 1155	1204 1205	1254 1255	Present value change value	• When the feed present value is changed using positioning data No. 9003, the feed present value after the change is stored. • Even if the set value is outside the software stroke limit, no error occurs.				0
				-2147483648 to +2147483648 x 10^{-1} μm	-2147483648 to +2147483648 x 10^{-5} inch	0 to 35999999 x 10^{-5} degree	-2147483648 to +2147483648 pulse	
1156 1157	1206 1207	1256 1257	Speed change value	• In positioning operation, the speed after the change is stored when a speed change is carried out in JOG operation.				0
				0 to 600000000 x 10^{-2} μm/min	0 to 600000000 x 10^{-3} inch/min	0 to 600000000 x 10^{-3} degree/min	0 to 1000000 pulse/s	0
1158	1208	1258	Speed change request	• In positioning operation, this signal is turned ON(1) after the speed change value is set when a speed change is carried out in JOG operation.				0
				bit0 0: Speed change request accepted (set by OS) 1: Speed change request (set by sequence program)				
1159	1209	1259	Positioning operation speed override	• Used to set an override in the range 1 to 300 % (in 1 % units) with respect to the speed in positioning operation (current speed). • When the override value is 100 %, the positioning operation speed does not change.				100
				1 to 300 %				
1160 1161	1210 1211	1260 1261	JOG speed	• JOG speed during JOG operation is stored. • When the speed during JOG operation is changed, the speed after the change is stored.				0
				0 to 600000000 x 10^{-2} μm/min	0 to 600000000 x 10^{-3} inch/min	0 to 600000000 x 10^{-3} degree/min	0 to 1000000 pulse/s	0
1163	1213	1263	Speed-position switching enable flag	Makes the control switch signal (speed to position switching signal) valid.				0
				bit0 0: Even if the speed-position switching signal is turned ON, speed control is not switched to position control. 1: When the speed/position switch signal is turned ON, speed control is switched to position control.				
1164 1165	1214 1215	1264 1265	Speed/position switching control travel value change register	• This register is used for changing the travel value of position control in speed/position switching control. • The change travel value is set during speed control in speed/position switching control. • When the speed-position switching signal is turned ON, the speed/position switching control travel value register is the travel value of position control. • The travel value set in the positioning data is set at the next speed/position switching control start.				0
				1 to 2147483647 x 10^{-1} μm	1 to 2147483647 x 10^{-5} inch	1 to 2147483647 x 10^{-5} degree	1 to 2147483647 pulse	
1167	1217	1267	Manual pulse generator enable flag	• Used to enable/disable manual pulse generator operation.				0
				bit0 0: Manual pulse generator operation is enabled. 1: Manual pulse generator operation is disabled.				
1168 1169	1218 1219	1268 1269	Manual pulse generator 1 pulse input magnification	• Sets the magnification per pulse for the number of pulses input from the manual pulse generator in manual pulse generator operation.				1
				1 to 100				

<table>
<tr><th>Buffer Memory Address (Common for Axis 1, Axis 2 and Axis 3)</th><th>Item</th><th>Remark/Setting Range</th><th>Initial Value</th></tr>
<tr><td>1106</td><td>Write/read request</td><td>• Positioning data is read or written.
• Simultaneous reading/writing is carried out for interpolation axes.
• Data flow in reading/writing is as follows:
 

* When the "feed present value" is set in the writing pattern address field, when writing is executed the "feed present value" is set in the positioning data interface and then set in the positioning data of the F-ROM or buffer memory.
0: Writing/reading completed (set by OS)
1: Read request (set by sequence program)
2: Write request (set by sequence program)</td><td>0</td></tr>
<tr><td>1108 to 1137</td><td>Read/write positioning data interface</td><td> 
</td><td>0</td></tr>
<tr><td>1138</td><td>F-ROM writing request</td><td>• Write the parameters and positioning data of the OS area to the F-ROM.
bit0 0: F-ROM writing completed (set by OS)
1: F-ROM write request (set by sequence program)</td><td>0</td></tr>
</table>

POINTS

(1) Clock data is set for the start history, error start history, error history and warning history in the system monitor. The times set in the start history and error history can be used as a reference for determining the approximate cycle time and tracing the failure cause when an error occurs.

(2) If the clock data is not set, the clock count starts from day: 0 hour:0 minute: 00 second: 00 when the power to the AD75 is turned ON. When the power to the AD75 is turned ON, synchronize the data with the clock data of the PC CPU.

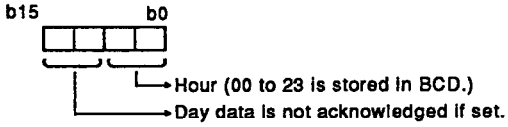
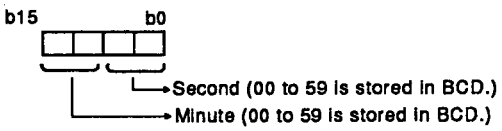
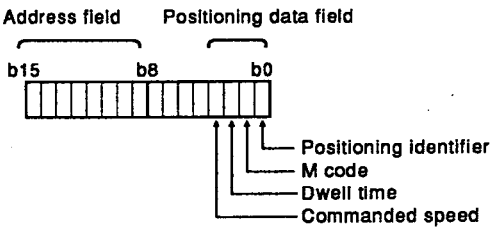
(3) When the positioning data interface is used, the teaching function can be realized in combination with manual operation.

3.6.4 Control data area

This section describes the control data area in the buffer memory.

The initial values are stored in the control data area when the power is turned on.

(1) System control data area

Buffer Memory Address (Common for Axis 1, Axis 2 and Axis 3)	Item	Remark/Setting Range	Initial Value
1100	Clock data setting (hour)	• After turning on the AD75, set the clock data in the AD75 from the PC CPU. • The hour is set as follows: 	0
1101	Clock data setting (minute, second)	• The minute and second are set as follows: 	0
1102	Clock data write	• Turned ON when the clock data is set and written in the AD75. bit00: Clock data write accepted (set by OS) 1: Clock data write request (set by sequence program)	0
1103	Applicable axis	• Axis for which write/read is executed is set. 1: Axis 1 2: Axis 2 3: Axis 3 4: Interpolation, axes 1/2 5: Interpolation, axes 2/3 6: Interpolation, axes 3/1	0
1104	Positioning data No.	• Data No. for writing and reading is set. 1 to 600	0
1105	Writing pattern (Reading is executed unconditionally.)	• Data type for reading is set.  1) The address data used when setting the positioning address/arc auxiliary point is set in the address field. The values designated in the address field (8 bits) and their descriptions are as follows: 0: Sets the values of the positioning address and arc auxiliary point in the positioning data. 1: Sets the value of the positioning address in the positioning data. 2: Sets the value of the arc auxiliary point in the positioning data. 5: Sets the feed present value as the positioning address. 6: Sets the feed present value as the arc auxiliary point. 7: The positioning address and arc auxiliary point are not set. 2) Apart from the positioning address/arc auxiliary point settings, the setting for which of the data written into the read/write positioning data interface area (1108 to 1137) is to be set is designated in the positioning data field. 0: Data corresponding to the bit is set (written). 1: Data corresponding to the bit is not set (not written).	0

Buffer Memory Address			Item	Remark/Setting Range	Initial Value
Axis 1	Axis 2	Axis 3			
832	932	1032	Execution start data pointer	• This pointer shows the start data point currently being executed. • The pointer value becomes 1 in the event of positioning start (not restart). • The pointer value becomes 0 when positioning is completed.	0
833	933	1033	Last execution positioning data No.	• The positioning data No. which was executed last is stored. • This value is maintained until the next positioning data is executed.	0
834	934	1034	Repeat counter	• The remaining number of repeats is stored. • The count is decremented (-1) at the end of a repeat loop. • The loop ends when the count is 0. • 0 is stored from the top of the loop when it is an infinite loop.	0
835	935	1035	Execution positioning data No.	• The positioning data No. currently being executed is stored. • For an indirectly designated positioning data No., the data No. converted to 1-600 is stored.	0
836	936	1036	Block No. being executed	• The block positioning No. is stored.	
838 to 847	938 to 947	1038 to 1047	Positioning data being executed	• The positioning data currently being executed is stored. (See Section 3.4.5) Axis 1 / Axis 2 / Axis 3 838 / 938 / 1038 — Positioning identifier 839 / 939 / 1039 — M code 840 / 940 / 1040 — Dwell time 841 / 941 / 1041 — Spare 842 / 942 / 1042 — Commanded speed 843 / 943 / 1043 844 / 944 / 1044 — Axis 1 Positioning address 845 / 945 / 1045 846 / 946 / 1046 — Axis 1 Arc data 847 / 947 / 1047	0

Buffer Memory Address			Item	Remark/Setting Range	Initial Value
Axis 1	Axis 2	Axis 3			
818 819	918 919	1018 1019	Target value	• The target value is stored in positioning operation as follows: • In position control, the target value is stored based on the designated positioning address/travel value. This target value is stored when positioning control is started. When positioning by position control is completed, zero is stored. • Zero is stored when speed control and home position return are executed. • Zero is stored when speed/position switching control is started. When positioning control is switched, the travel value is stored as the target value. • Zero is stored when JOG operation, manual pulse generator operation, and home position return operation starts are executed.	0
820 821	920 921	1020 1021	Target speed	• In positioning data operation, the actual target speed considering the override and speed control limit is stored as the current speed. When travel is completed, the speed is zero. • During interpolation, the target speed for the resultant speed or reference axis speed is set for axis 1 in axis 1/2 interpolation, axis 2 in axis 2/3 interpolation, and axis 3 in axis 3/1 interpolation. For other interpolation axes, zero is entered. • For JOG operation, the actual target speed, taking into account the JOG speed and the JOG speed limit value, is stored. If JOG operation is discontinued, zero is stored. • In manual pulse generator operation, zero is stored.	0
822 823	922 923	1022 1023	Absolute original point	• The "absolute original point" used when positioning to the home position is stored. • When the power is switched on, the stored value is not defined. • On completing a home position return, the home position address value in the basic parameters for home position return is set as the "absolute original point". • When the present value is changed, the "absolute original point" is changed.	0
824 825	924 925	1024 1025	Travel value after near-zero point dog ON	• Zero is stored when home position return is started. • When home position return is completed, the travel value (without sign) from near-zero point dog ON to home position return completed is stored. It remains zero when home position return with no near-zero point dog and stopper stop type home position return are executed.	0
826	926	1026	Torque limit stored value	• The torque limit set value or torque change value is stored. • The torque limit set value is stored in the event of positioning start, JOG start, and manual pulse generator operation start. • If a value other than zero is set in the torque change value storage buffer memory (1176, 1226, 1276) during operation, the torque value after the change is stored.	0
827	927	1027	Special start data instruction code set value	• The special start data instruction code designated by the start data pointer during execution is stored. • The value is maintained until the start data pointer is updated.	0
828	928	1028	Special start data instruction parameter set value	• The special start data instruction parameter designated by the start data pointer during execution is stored. • This value is maintained until the start data pointer is updated.	0
829	929	1029	Start positioning data No. set value	• The positioning data No. designated by the start data pointer during execution is stored. • If the designation is indirect, the indirect designation No. is stored. • The value is maintained until the start data pointer is updated.	0
830	930	1030	Speed control in progress flag	• If the speed value to be changed to exceeds the speed control limit as a result of speed change or positioning operation override, this flag is ON when operating at the speed limit value. • It is turned OFF when the above status is canceled or an axis stop occurs.	0
				bit0 0: Speed control in progress 1: Speed control not in progress	
831	931	1031	Speed change processing in progress flag	• This flag is turned ON during speed change processing . • It is turned OFF in the event of deceleration start caused by the stop signal during speed change processing, and after completion of speed change processing.	0
				bit0 0: Speed change processing completed 1: Speed change processing in progress	