CONTENTS

3.4.4 Extended parameters for home position return

Table 3.9 Extended Parameters for Home Position Return

Item \ Unit	Setting Ranges				Initial Value
	mm	inch	degree	pulse	
Home position return dwell time	• 0 to 65535(ms)				0
Travel value setting after near-zero point dog ON	0 to 214748364.7 μm	0 to 21474.83647 inch	0 to 21474.83647 degree	0 to 2147483647 pulse	0
Home position return acceleration time selection	• 0 to 3				0
Home position return deceleration time selection	• 0 to 3				0
Home position shift amount	-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 torque limit	• 1 to 300 (%)				300

(1) Home position return dwell time

(a) The home position return dwell time is the time until home position return is completed after the near-zero point dog comes ON during home position return by the stopper stop (1) method.
Set a travel time equal to or greater than the time from the near-zero point dog ON to the stopper stop.

(b) Any value in the setting range can be input at a time other than when executing stopper stop (1).

(2) Setting for travel value after near-zero point dog ON

(a) When count type home position return is set, this sets the travel value from near-zero point dog ON to the home position.

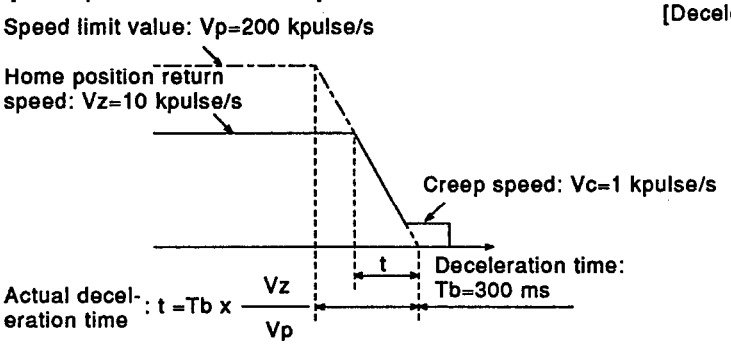
(b) After the near-zero point dog comes ON, the first zero point encountered after traveling the set travel value is the home position.

(c) Set the travel value after the near-zero point dog ON to the distance for decelerating from the home position return speed to the creep speed or greater.

Example

(1) When the speed limit value is set to 200 kpulse/s, the zero return speed to 10 kpulse/s, the creep speed to 1 kpulse/s, and deceleration time to 300 ms, the travel value after near-point dog ON is calculated as follows:

[Home position return motion]



[Deceleration distance] $= \frac{1}{2} \times \frac{Vz}{1000} \times t$ ··· Converted to speed per millisecond

$= \frac{Vz}{2000} \times \frac{Tb \times Vz}{Vp}$

$= \frac{10 \times 10^3}{2000} \times \frac{3000 \times 10 \times 10^3}{2000}$

$= 75$

↓

*Set the travel value after the near-zero point dog ON to 75 or more.

(3) Home position return acceleration time selection

(a) This sets which of the set acceleration times 0 to 3 is used for the acceleration time in home position return.

- Acceleration time 0: Set by the basic parameters [See Section 3.4.1.]
- Acceleration times 1 to 3: Set by the extended parameters [Refer to Section 3.4.2.]

(4) Home position return deceleration time selection

(a) This sets which of the set deceleration times 0 to 3 is used for the deceleration time in home position return.

- Deceleration time 0: Set by the basic parameters [See Section 3.4.1.]
- Deceleration time 1 to 3: Set by the extended parameters [Refer to item 3.4.2.]

(5) Home position shift amount

(a) This sets the shift amount from the detected zero phase signal to the home position.
For details of the home position shift function, see Section 3.3.8(6).

(6) Home position return torque limit

(a) This is the set value limiting servo motor torque after reaching the creep speed in home position return.

(b) After reaching the creep speed in each home position return method, the torque is limited by the set home position return torque limit.

POINTS

(1) D-A converter is necessary to set the torque limit.

(2) Be sure to set the home position return torque limit when carrying out home position return by stopper stop method (1), (2), or (3).

(3) Any value in the setting range can be input when the torque is not limited.

REMARK

For details on the buffer memory address and setting range when setting home position return extended parameters with a sequence program, see Section 3.6.2(6).

3.4.5 Positioning data

Positioning data are used in the AD75 to execute positioning control (i.e. control other than home position return, JOG operation and manual operation).

Positioning data consists of a positioning identifier, M code, dwell time, commanded speed, positioning address, and arc data.
Set the positioning data for each axis.

The value ranges of each of the positioning data are checked when positioning is executed.
If the set value is outside the range, positioning is not executed.

Table 3.10 Positioning Data

Item \ Unit		Setting Ranges: mm	Setting Ranges: inch	Setting Ranges: degree	Setting Ranges: pulse	Initial Value
Operation pattern		00: Positioning end 01: Continuous positioning control 11: Continuous locus control				00
Control method		(see table below)				0
Acceleration time No.		• 0 to 3				0
Deceleration time No.		• 0 to 3				0
Positioning adress/ Travel value	Absolute	-214748364.8 to 214748364.7 (μm)	-21474.83648 to 21474.83647 (inch)	0 to 359.99999 (degree)	-2147483648 to 2147483647 (pulse)	0
	Incremental (other than speed/position switching control)	-214748364.8 to 214748364.7 (μm)	-21474.83648 to 21474.83647 (inch)	-21474.83648 to 21474.83647 (degree)	-2147483648 to 2147483647 (pulse)	0
	Speed/position switching control	0 to 214748364.7 (μm)	0 to 21474.83647 (inch)	0 to 21474.83647 (degree)	0 to 2147483647 (pulse)	0

Notation of peripheral device	Description of setting	Instruction code
ABS linear 1	• Linear control of axis 1 (ABS)	01_H
INC linear 1	• Linear control of axis 2 (INC)	02_H
Fixed-pitch feed 1	• Fixed-pitch feed of axis 1	03_H
ABS linear 2	• Linear interpolation control of axis 2 (ABS)	04_H
INC linear 2	• Linear interpolation control of axis 2 (INC)	05_H
Fixed-pitch feed 2	• Fixed-pitch feed control by linear interpolation of axis 2	06_H
ABS circular interpolation	• Circular interpolation control by auxiliary point designation(ABS)	07_H
INC circular interpolation	• Circular interpolation control by auxiliary point designation(INC)	08_H
ABS circular right	• Circular interpolation control by center point designation(ABS, CW)	09_H
ABS circular left	• Circular interpolation control by center point designation(ABS, CCW)	$0A_H$
INC circular right	• Circular interpolation control by center point designation(INC, CW)	$0B_H$
INC circular left	• Circular interpolation control by center point designation(INC, CCW)	$0C_H$
Forward speed control	• Speed control (forward)	$0D_H$
Reverse speed control	• Speed control (reverse)	$0E_H$
Forward speed/position	• Speed/position switching control (forward)	$0F_H$
Reverse speed/position	• Speed/position switching control (reverse)	10_H
Present value change	• Present value change	11_H

Item	Unit	Setting Ranges				Initial Value
		mm	inch	degree	pulse	
Arc address	Absolute	-214748364.8 to 214748364.7 (μm)	-21474.83648 to 21474.83647 (inch)	0 to 359.99999 (degree)	-2147483648 to 2147483647 (pulse)	0
	Incremental			-21474.83648 to 21474.83647 (degree)		
Commanded speed		0.01 to 600000.00 (mm/min)	0.001 to 600000.000 (inch/min)	0.001 to 600000.000 (degree/min)	1 to 1000000 (pulse/s)	0
		-1 (Current speed: the same speed as the previous positioning data No.)				
Dwell time		0 to 65535(ms)				0
M code		0 to 32767				0

(1) Operation pattern

(a) Set the operation pattern for completion of positioning.

- Positioning end: Positioning is completed in accordance with the designated positioning data.
- Continuous positioning: Positioning stops when positioning is completed in accordance with the designated positioning data, and then positioning is continued in accordance with the next positioning data.
- Continuous locus control: After positioning is completed in accordance with the designated positioning data, positioning is continued in accordance with the next positioning data.

(2) Control method

(a) This sets the control methods when executing positioning control.

(3) Acceleration time No.

(a) This sets which of the acceleration times 0 to 3 (set by the basic and detailed parameters) is used for the acceleration time.

- Acceleration time 0: Refer to the basic parameters (Section 3.4.1.)
- Acceleration times 1 to 3: Refer to the extended parameters (Section 3.4.2.)

(4) Deceleration time No.

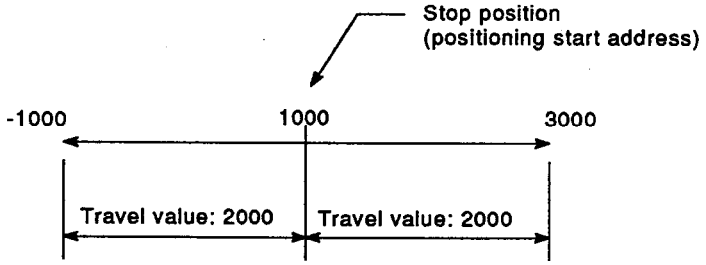
(a) This sets which of the deceleration times 0 to 3 (set by the basic and extended parameters) is used for the deceleration time.

- Deceleration time 0: Refer to the basic parameters (Section 3.4.1.)
- Deceleration times 1 to 3: Refer to the extended parameter (Section 3.4.2.)

(5) Positioning address

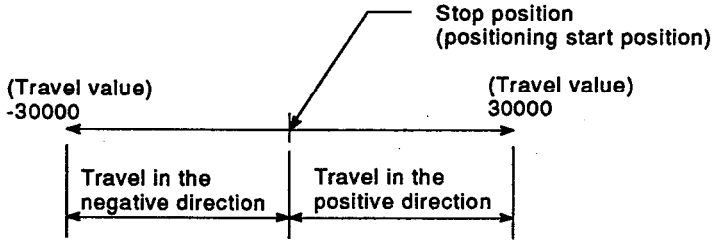
(a) Absolute (ABS) mode

- Set the positioning address (end address) in ABS mode to the absolute address (address from the home position).



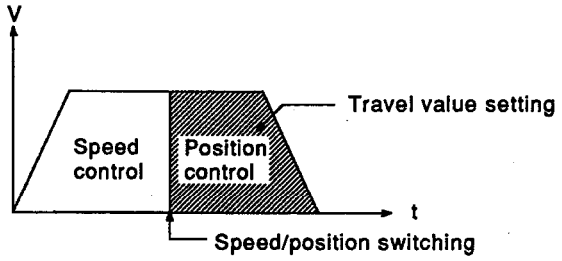
(b) Incremental (INC) mode

- This sets the travel value in the incremental mode.
- The travel direction is designated using signs.
  When the travel value is positive: positive direction (address incremental direction)
- When the travel value is negative: negative direction (address decremental direction)



(c) Speed/position switching control

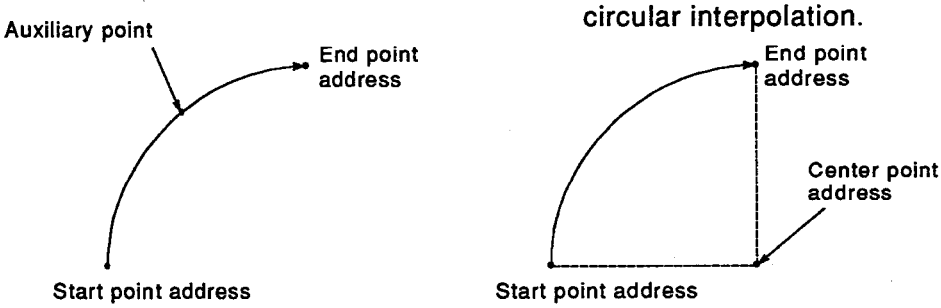
- This sets the travel value after the speed control mode is switched to position control mode.



(6) Arc address

(a) Arc address data is necessary only for circular interpolation control.

- When an auxiliary point is designated: Set the address of the pass point for circular interpolation.
- When a center point is designated: Set the address of center point of the arc for circular interpolation.



(a) Circular interpolation by auxiliary point designation

(b) Circular interpolation by center point designation

(7) Commanded speed

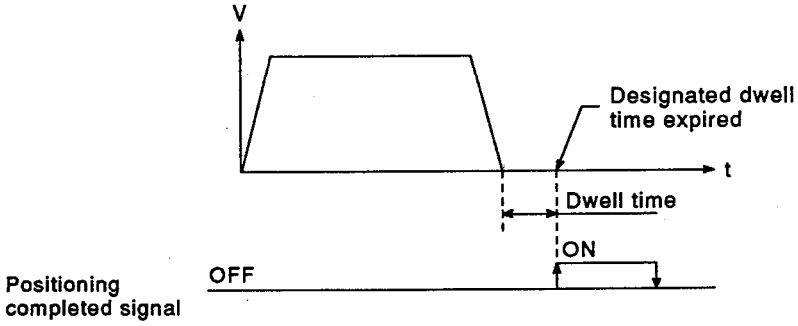
(a) This sets the commanded speed during positioning.

(b) When the set commanded speed exceeds the speed limit value, positioning is carried out within the speed limit value.

(c) If the commanded speed is set to "-1", positioning is controlled using the current speed (the same speed as the previous positioning speed).*
When starting positioning, if the initial positioning data for positioning control is set to "-1", the "no speed setting" error occurs and positioning does not start.

(8) Dwell time

(a) This sets the delay after positioning completion before the next positioning control begins.
When positioning operation is completed, it sets the delay time before the "positioning completed" signal is output.



(b) When the operation pattern is continuous locus control, control is executed with a dwell time of 0 (ms) even if a dwell time is set.

(9) M code

(a) This sets M code output in positioning control.
An M code is output only on axis 1 in interpolation operation.

(b) If no M code is to be output, set "0".

(c) This sets the M code output timing with the "M code ON signal output timing" setting of the extended parameters. (For the M code ON signal output timing, see Section 3.3.2.)

REMARK

*: The current speed is used for constant speed control.
When the current speed is designated during the constant speed control and the positioning data No. speed designated by positioning start is replaced, all positioning data Nos. for which the current speed is designated can be controlled at the designated speed.

3.4.6 Start block information

Pattern, data No. special start, and parameter are set for start block information.
Start block information can be set up to 50 points (1 to 50) for each axis.

Table 3.11 Start Block Information List

Item	Setting Ranges	Initial Value
Pattern	• 0: End • 1: Continued	End
Data No.	• 1 to 600	0
Special start	<table><tr><th>Special start</th><th>Setting parameter</th></tr><tr><td>0: Normal start</td><td>—</td></tr><tr><td>1: Conditional start 2: Wait start 3: Simultaneous start</td><td>Condition data No.</td></tr><tr><td>4: Stop start</td><td>Repeat count</td></tr><tr><td>5: FOR loop</td><td>Condition data No.</td></tr><tr><td>6: FOR condition</td><td>—</td></tr><tr><td>7: NEXT start</td><td>—</td></tr></table>	Normal start
Parameter	• Condition data No.: 1 to 10 • Repeat count: 0 to 255	0

(1) Pattern

(a) This sets whether to end positioning control at the designated point or to start the positioning at the next pointer.

1) End: When positioning control of the designated point is completed, positioning ends.

2) Continued: When positioning control of the designated point is completed, positioning control of the next point starts.

3) The data No. set after the end point is not to be executed.

(2) Data No. (Positioning data No.)

(a) This sets the data No. for positioning control.
If data numbers are set at multiple points, positioning control is performed in order starting from the point designated in the buffer memory for setting the "positioning start point number".*

(3) Special start

(a) This sets the start requirements when starting positioning.

REMARK

* : The positioning start point number setting memory is located at the following addresses:

Axis number	Axis 1	Axis 2	Axis 3
Positioning start point number setting buffer memory	1178	1228	1278

(b) The possible start requirements include condition judgment, simultaneous start, stop, and repeat processing.

1) Normal start

- Execute the positioning data No. for the same point.

2) Conditional start

- A condition judgment is made for the designated condition data No. and operation is started only if the condition is satisfied.
  When the condition is satisfied: The start data No. of the point for which the condition is satisfied is started.
  When the condtion is not satisfied: The condition for the next point is judged.

- When the condition data No. setting is outside range, an error occurs when the positioning data No. is executed, and positioning control is not executed.

3) Wait start

- A condition judgment is made for the designated condition data No. and operation is started only if the condition is satisfied.

- If the condition is satisfied, the start data No. of the point for which the condition is satisfied is started.

- If the condition data No. setting is out of the range, an error occurs when the positioning data No. is executed, and positioning control is not executed.

4) Simultaneous start

- Simultaneous start is carried out with the pulse output level for the designated axis (or axes).

- Simultaneous start is possible for a maximum of three axes. (The axes for which a simultaneous start is to be executed are set for the condition data No. designated by parameter.)

- In simultaneous starting, an error occurs and the positioning data No. is not executed in the following cases:
  The other axis (axes) is BUSY.
  The principal axis is set in the parameter setting.
  The other axis (axes) is not set in the parameter setting.

5) Stop

- Stops the positioning operation.

- When restarting, the positioning data No. of the same point is executed.

6) FOR loop (count)

- Repeats and executes FOR to NEXT loop for the repeat count set in the parameter setting.
  At the beginning of repeat processing, the start data No. of the same point is executed.

- When the repeat count is set to "0", the loop is endless.

- If there is no NEXT after the FOR, no error occurs, but repeat processing is not carried out.

7) FOR condition

- The condition of the condition data No. designated by parameter is judged, and the steps between FOR and NEXT are repeated until this condition is satisfied.

- If there is no NEXT after the FOR, no error occurs, but repeat processing is not carried out.

8) NEXT

- Indicates the repeat end.

- Returns to the top of FOR to NEXT loop.

- In the case of FOR (count), the repeat count is decremented and, on reaching 0, the loop is ended after executing the positioning of the start data No. of the same point.

- If NEXT is executed before FOR, the same processing as for normal start is carried out.

(c) When the designated data No. is executed, the start conditions set for special start and each of the parameter ranges are checked.
If the start conditions and parameters are outside the setting range, positioning control is not carried out.

(4) Parameters

(a) When "conditional start", "wait start", "simultaneous start", "FOR loop", and "FOR condition" are set by the special start [see item (3)], these settings set the start conditions.

Condition data No.:	Designate the condition data No. for which the condition data used with the conditional start, wait start, simultaneous start, or FOR condition, is set.(For details on condition data, see Section 3.4.7.)
Repeat count:	Sets the repeat count for the FOR to NEXT loop instruction.

POINT

Processing for FOR to NEXT loop
Nesting of FOR to NEXT loops is not possible.
If nesting is attempted, a warning is issued.

Point	Special start setting
1	Normal start
2	FOR
3	Normal start
4	FOR
5	Normal start
6	Normal start
7	NEXT
8	Normal start
9	NEXT

The jump destination of the NEXT designated for points 7 and 9 is the FOR at point 4. If the designated NEXT is executed at point 9, an error occurs.

3.4.7 Condition data

The condition data serve to make condition judgments when a conditional start, wait start, or simultaneous start is executed.
Up to ten condition data (Nos. 1 to 10) can be created in buffer memory.

- Axis 1 :Buffer memory addresses 4400 to 4499
- Axis 2 :Buffer memory addresses 4650 to 4749
- Axis 3 :Buffer memory addresses 4900 to 4999

One condition data comprises a condition identifier and three parameters (address, parameter 1, parameter 2).

Configuration of condition data

Condition identifier	.. 16 bits
Vacant	.. 16 bits
Address	.. 32 bits
Parameter 1	.. 32 bits
Parameter 2	.. 32 bits
Vacant	.. 32 bits

The range check for each of the parameters in the condition data is performed when the positioning data No. is executed.
If any of the condition data parameter setting is out of range, an error occurs and positioning is not performed.

(1) Condition identifier

There are the following types of condition identifier: "condition objects" on which the condition judgment is to be performed, and "comparison condition".

(a) Condition object

The condition object sets the object of the condition judgment.
There are the five types of condition judgment shown below.

	Instruction Code
Device X	01_H
Device Y	02_H
Buffer memory (16 bits)	03_H
Buffer memory (32 bits)	04_H
Positioning data No.	05_H

(b) Comparison condition

The comparison condition sets the operation method in accordance with the condition object.
There are the following 14 types of comparison condition.

Comparison Condition		Relationship Between Condition Object and Parameters	Instruction Code	Condition Objects that can be Designated
Normal operators	=	n = (parameter 1)	01_H	Buffer memory (16/32 bit)
	≠	n ≠ (parameter 1)	02_H	
	≤	n ≤ (parameter 1)	03_H	
	≥	n ≥ (parameter 1)	04_H	
Range operators	Range designation 1	(parameter 1) ≤ n ≤ (parameter 2) *	05_H	Buffer memory (16/32 bit)
	Range designation 2	n ≥ (parameter 1), n ≥ (parameter 2)	06_H	
Bit operator	ON	Parameter 1 ON	07_H	Device X
	OFF	Parameter 1 OFF	08_H	Device Y
Simultaneous start	Axis designation	Axis 1 designated	09_H	Positioning data No.
		Axis 2 designated	$0A_H$	
		Axes 1 and 2 designated	$0B_H$	
		Axis 3 designated	$0C_H$	
		Axes 1 and 3 designated	$0D_H$	
		Axes 2 and 3 designated	$0E_H$	

REMARK

*:With range designation 1, an error occurs if (parameter 1) > (parameter 2).

(2) Address

(a) The address serves to designate a buffer memory address which is used when the comparison condition is a "normal operator" or "range operator".
The condition judgment is made on the basis of the value in the buffer memory designated by the address and the parameter 1 and parameter 2 values.

(b) No address is used if the condition object is "device X", "device Y", or "positioning data No.".

(3) Parameter 1

(a) Parameter 1 is the data set when the comparison condition is a "normal operator", "range operator", "bit operator", or "positioning data No.".

(b) The data to be set differs according to the operator used.

Condition Object	Normal Operator/ Range Operator	Bit Operator
Device X	—	Bit No.
Device Y	—	Bit No.
Buffer memory (16 bit)	Numerical value	—
Buffer memory (32 bit)	Numerical value	—

If the comparison condition is "simultaneous start", set the positioning data No. of the other axis involved in the simultaneous start. (See (5) below.)

(4) Parameter 2

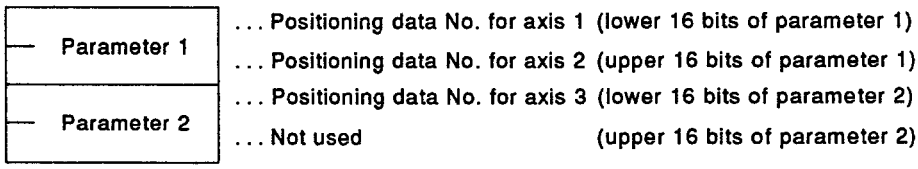
(a) Parameter 2 is the data set when the comparison condition is a range operator.

(b) Only numerical data can be set for parameter 2.
If the comparison condition is "simultaneous start", set the positioning data No. of the other axis involved in the simultaneous start. (See (5) below.)

(5) Setting parameter 1 and parameter 2 for simultaneous start

(a) If the comparison condition is "simultaneous start", set the positioning data numbers of the axes involved in the simultaneous start by using parameter 1 and parameter 2.

(b) Set the positioning data numbers for axes 1 to 3 as shown below. (The area used for axes 1 to 3 is fixed.)



3.5 I/O Signals

3.5.1 I/O signal list

The AD75 uses 16 inputs and 16 outputs for data communication with the PC CPU.
Table 3.12 shows the I/O signals when the AD75 is loaded in slot No.0 of the main base unit.

X devices represent input signals from the AD75 to the PC CPU.
Y devices represent output signals from the PC CPU to the AD75.

Table 3.12 I/O Signal List

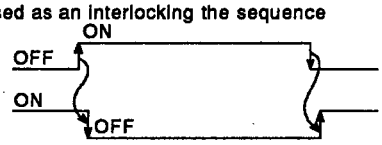
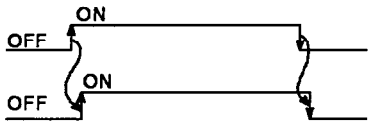
Signal Direction: AD75 to PC CPU			Signal Direction: PC CPU to AD75		
Device Number	Signal		Device Number	Signal	
X0	AD75 ready		Y10	Axis 1	Positioning start
X1	Axis 1	Start completed	Y11	Axis 2	
X2	Axis 2		Y12	Axis 3	
X3	Axis 3		Y13	Axis 1	Axis stop
X4	Axis 1	BUSY	Y14	Axis 2	
X5	Axis 2		Y15	Not used	
X6	Axis 3		Y16	Axis 1	Forward JOG start
X7	Axis 1	Positioning completed	Y17	Axis 1	Reverse JOG start
X8	Axis 2		Y18	Axis 2	Forward JOG start
X9	Axis 3		Y19	Axis 2	Reverse JOG start
XA	Axis 1	Error detection	Y1A	Axis 3	Forward JOG start
XB	Axis 2		Y1B	Axis 3	Reverse JOG start
XC	Axis 3		Y1C	Axis 3	Axis stop
XD	Axis 1	M code ON	Y1D	PC READY	
XE	Axis 2		Y1E	Used by system. Not usable by the user.	
XF	Axis 3		Y1F		

IMPORTANT

Y1E and Y1F, and Y0 to YF are reserved for use by the system, and cannot be used by the user.
If these devices are used, normal operation of the AD75 cannot be guaranteed.
(However, YD to YF must be turned OFF by a user program in one case only: when the AD75 is installed at a remote I/O station.)

(1) Detailed descriptions of input signals

Following table shows the ON/OFF timing and conditions for the input signals.

Device No.	Signal Name			Description
X0	AD75 ready		OFF: Ready ON: Not ready/WDT error	• When the PC READY signal (Y1D) changes from OFF to ON, the setting range of the parameter is checked; if no error is found, this signal is turned OFF. • When the PC READY signal (Y1D) is turned OFF, this signal is turned ON. • If a WDT error occurs, this signal is turned ON. • This signal can be used as an interlocking the sequence program. 
X1 X2 X3	Axis 1 Axis 2 Axis 3	Start completed	OFF: Start not completed ON: Start completed	• When the positioning start signal is turned ON, this signal is turned ON after the start of AD75 positioning processing. (The start completed signal is also turned ON in home position return operation.) • When the start signal is turned OFF, this signal is turned OFF. This signal also goes OFF if a stop signal is received during JOG operation. 
X4 X5 X6	Axis 1 Axis 2 Axis 3	BUSY	OFF: Not BUSY ON: BUSY	• When positioning, home position return or JOG is started, this signal is turned ON. It is turned OFF when the dwell time elapses after positioning stop. (It remains ON during positioning operation.) It is off during a stop in step execution. • In manual pulse generator operation, it is ON while the manual pulse generator enabled flag is ON. • It is turned off when operation is ended by an error and when operation is stopped.
X7 X8 X9	Axis 1 Axis 2 Axis 3	Positioning completed	OFF: Positioning not complete ON: Positioning complete	• This signal is turned ON for the time set in the positioning completion output time parameter after each data No. positioning is complete. (It is not turned ON when the positioning completion output time parameter is 0.) • When positioning operation (including home position return), JOG operation or manual pulse generator operation is started while this signal is ON, it is turned OFF . • It is not turned ON when speed control or positioning are canceled.
XA XB XC	Axis 1 Axis 2 Axis 3	Error detection	OFF: No error ON: Error	• This signal is turned ON on occurrence of the errors in Section 12. After the error is reset, the signal is turned OFF.
XD XE XF	Axis 1 Axis 2 Axis 3	M code ON	OFF: Without M code setting ON: With M code setting	• In the WITH mode, this signal is turned ON at positioning data start. In the AFTER mode, it is turned ON at positioning data completion. • This signal is turned OFF when an M code OFF request is issued. If no M code is designated (M code = 0), this signal remains OFF. • When the positioning operation is continuous locus control, an M code is set even if this signal is not turned OFF, and positioning is continued. However, a warning is issued. • When the PC READY signal is turned OFF, the "M code ON" signal is also turned OFF. • If a start is executed out in the M code ON status, an error occurs.

(2) Detailed descriptions of output signals

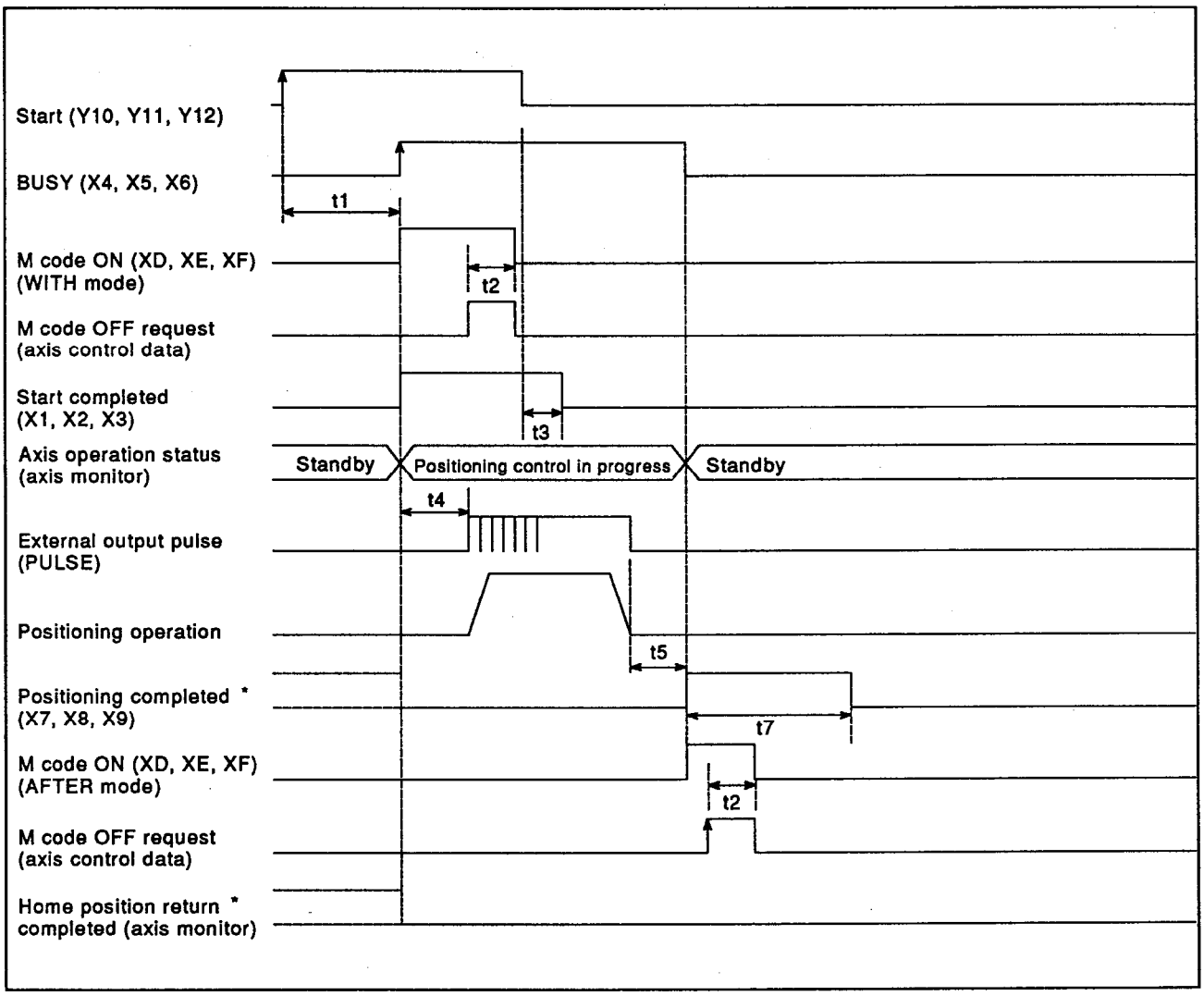
Following table shows the ON/OFF timing and conditions for the output signals.

Device No.	Signal Name			Description
Y10 Y11 Y12	Axis 1 Axis 2 Axis 3	Positioning start	OFF:No positioning start request issued ON: Positioning start request issued	• Start the positioning operation. • The positioning start signal takes effect at its leading edge, whereupon the start is executed. • If the positioning start signal comes ON during the BUSY status, a "start during operation" warning is issued.
Y13 Y14 Y1C	Axis 1 Axis 2 Axis 3	Axis stop	OFF:No axis stop request issued ON: Axis stop request issued	• When this signal is turned ON, home position return operation, positioning operation, JOG operation and manual pulse generator operation are stopped. • When the axis stop signal is turned ON, the "M code ON signal" is turned OFF. • When the axis stop signal is turned ON in positioning operation, the positioning operation goes into the "stopped" status. • Deceleration stop or rapid stop can be selected with the "stop signal rapid stop selection" parameter. • If axis stop signal is turned ON for one axis during interpolation control, a deceleration stop occurs on both axes in the positioning operation.
Y15	Unused	—	—	—
Y16 Y17 Y18 Y19 Y1A Y1B	Axis 1 Axis 1 Axis 2 Axis 2 Axis 3 Axis 3	Forward JOG start Reverse JOG start Forward JOG start Reverse JOG start Forward JOG start Reverse JOG start	OFF: JOG not started ON: JOG started	• While the JOG signal is ON, JOG operation proceeds at the "JOG speed" set in the axis control data. When the JOG start signal is turned OFF, a deceleration stop occurs.
Y1D	PC READY		OFF: PC READY OFF ON: PC READY ON	(a) Signal to notify the AD75 that the PC CPU is normal. • It is turned ON/OFF by the sequence program. • In positioning operation, home position return operation, JOG operation or manual pulse generator operation, PC READY is ON except when the test mode of a peripheral device is in effect. (b) PC READY may be turned OFF when a parameter change is made. (For details, see Section 3.4.) (c) When PC READY is turned from OFF to ON, the following processing must be executed. • Check the parameter setting range. • Turn OFF the AD75 ready signal. (d) When the PC READY is turned from ON to OFF, the following processing must be executed. • Turn ON the AD75 ready signal. • Stop the axis or axes in operation. • Turn off the M code ON signal of each axis and clear the M code storage area.

3.5.2 I/O signal timing

The following shows the I/O signal timing for positioning operation, JOG operation and manual pulse generator operation.

(1) Position control I/O signal input timing



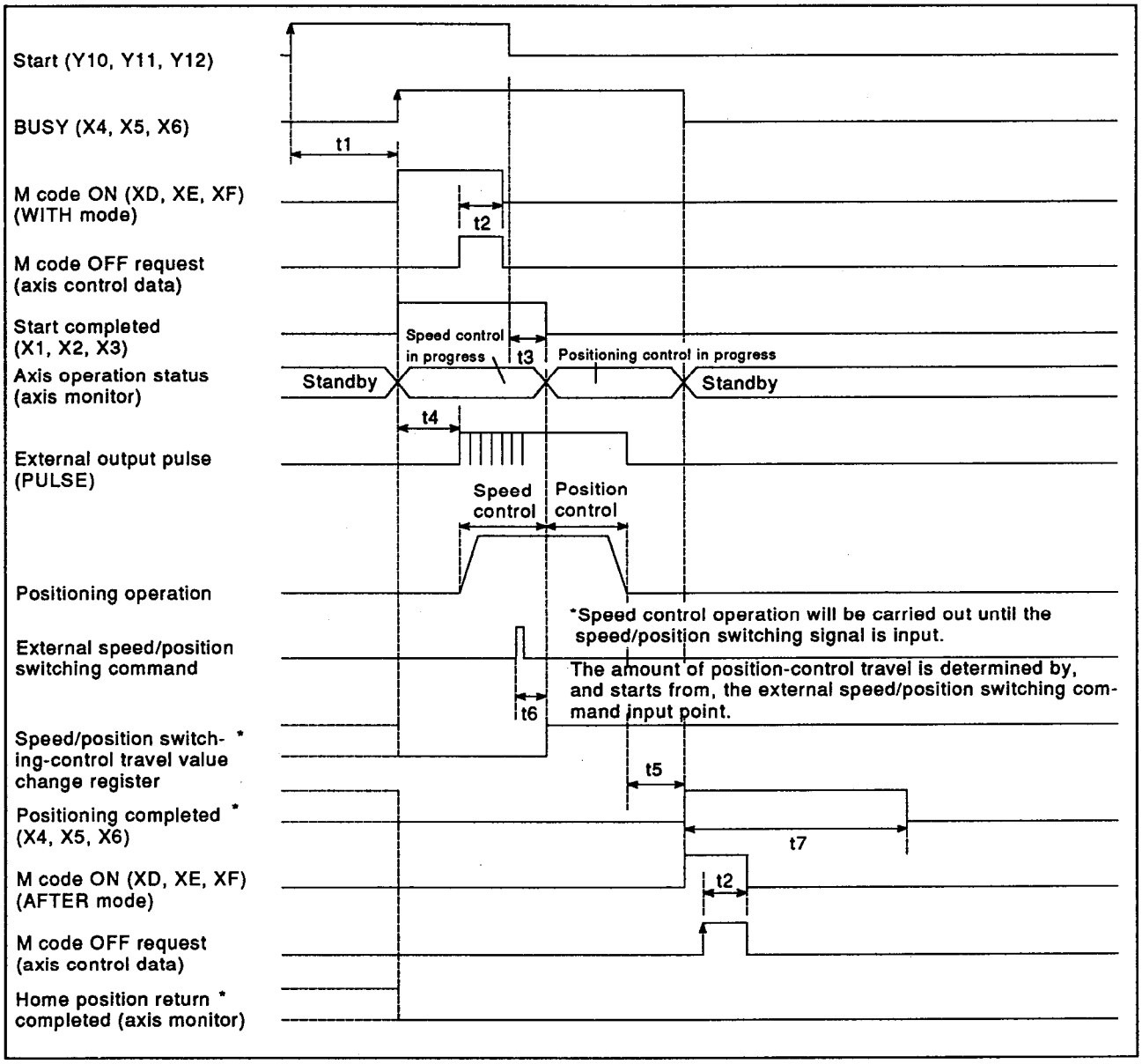
* If one of the signals marked * is ON before the positioning start signal is turned ON, it is turned off when the positioning signal is turned ON.

Normal timing — Unit: ms

t1	t2	t3	t4	t5	t7
5 to 15	0 to 3.5				Determined by parameter

- Some delays may occur in t1 timing due to the following:
  (a) Execution of FROM/TO instruction for start operation
  (b) Operation status of other axis
  (c) Interruption from peripheral device during start processing
  (d) Nature of the positioning data for the start

(2) Speed/position switching control I/O signal input timing



* If one of the signals marked * is ON before the positioning start signal is turned ON, it is turned off when the positioning signal is turned ON.

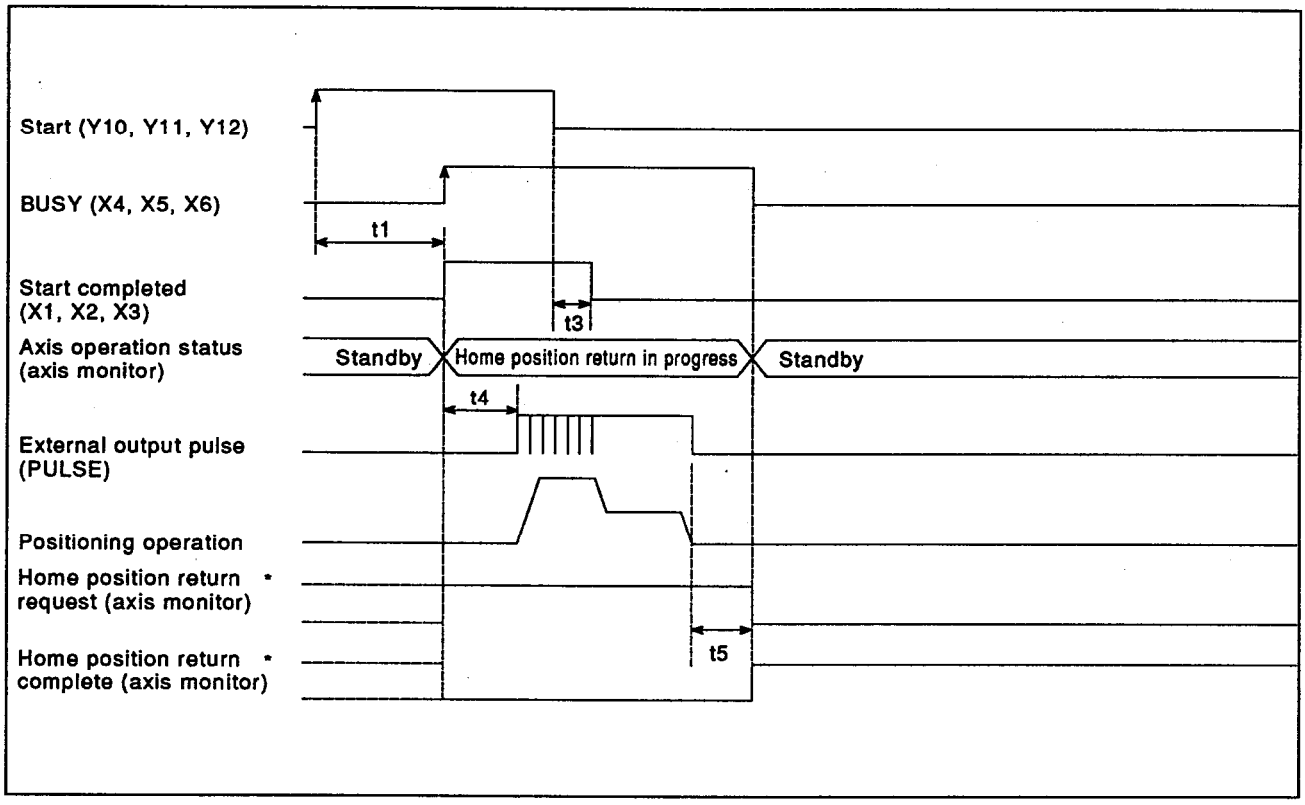
Normal timing

Unit: ms

t1	t2	t3	t4	t5	t6	t7
5 to 15	0 to 3.5				1	Determined by parameter

- Some delays may occur in t1 timing due to the following:
  (a) Execution of FROM/TO instruction for start operation
  (b) Operation status of other axis
  (c) Interruption from peripheral device during start processing
  (d) Nature of the positioning data for the start

(3) I/O signal input timing during home position return



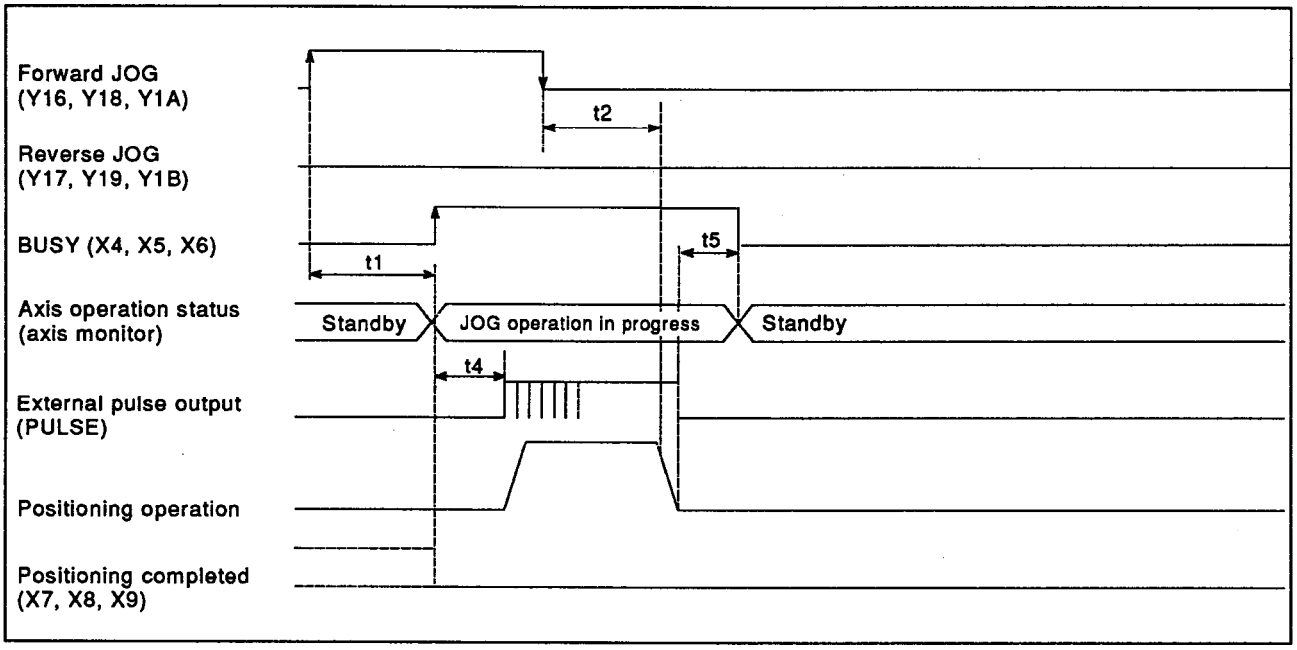
* If one of the signals marked * is ON before the positioning start signal is turned ON, it is turned off when the positioning signal is turned ON.

Normal timing Unit: ms

t1	t2	t3	t4	t5
5 to 15	0 to 3.5			

- Some delays may occur in t1 timing due to the following:
  (a) Execution of FROM/TO instruction for start operation
  (b) Operation status of other axis
  (c) Interruption from peripheral device during start processing
  (d) Nature of the positioning data for the start

(4) I/O signal input timing during JOG operation



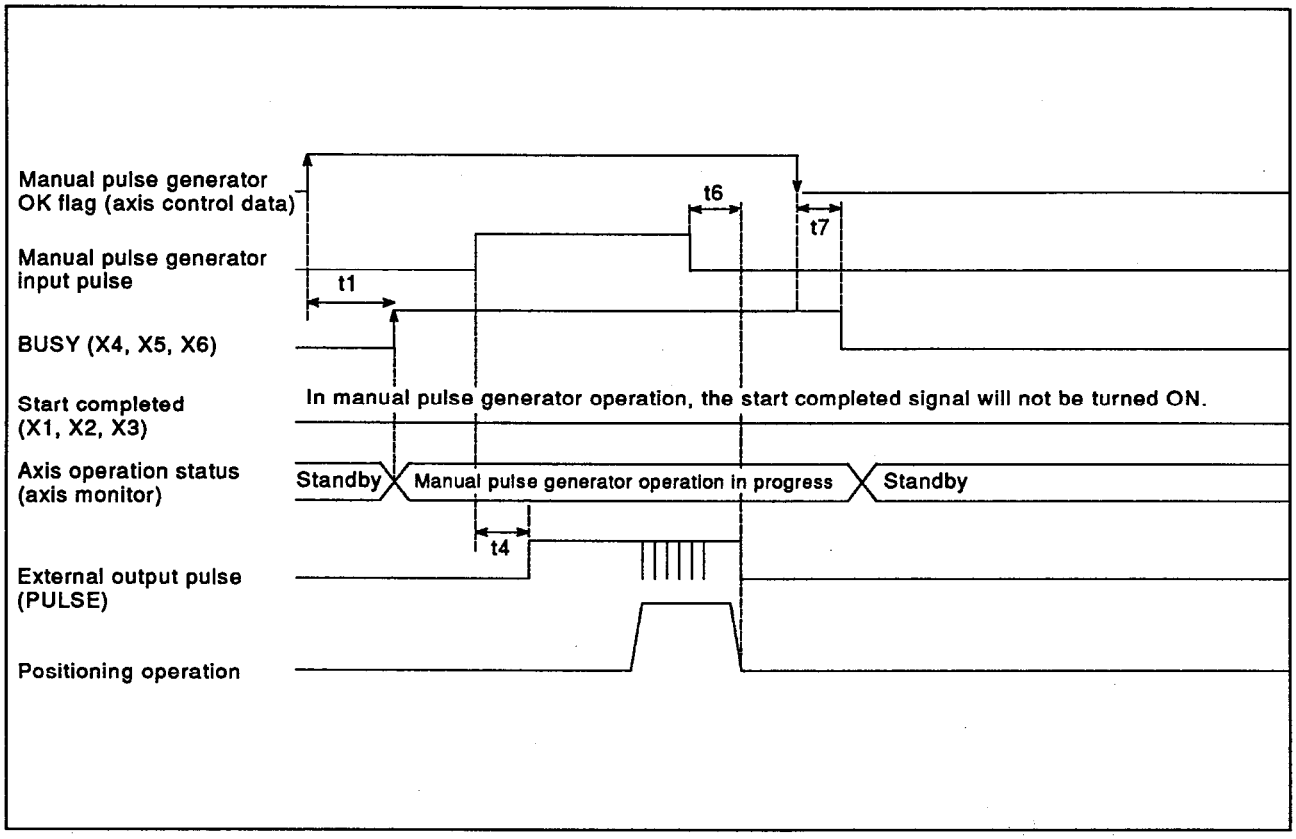
* If one of the signals marked * is ON before the positioning start signal is turned ON, it is turned off when the positioning signal is turned ON.

Normal timing Unit: ms

t1	t2	t4	t5
1 to 60	0 to 3.5	6.5 to 10	0 to 3.5

- Some delays may occur in t1 timing due to the following:
  (a) Execution of FROM/TO instruction for start operation
  (b) Operation status of other axis
  (c) Interruption from peripheral device during start processing
  (d) Nature of the positioning data for the start

(5) Output signals input timing during manual pulse generator operation



* If one of the signals marked * is ON before the positioning start signal is turned ON, it is turned off when the positioning signal is turned ON.

Normal timing Unit: ms

t1	t4	t6	t7
1 to 60	0 to 3.5	60	1 to 60

- Some delays may occur in t1 timing due to the following:
  (a) Execution of FROM/TO instruction for start operation
  (b) Operation status of other axis
  (c) Interruption from peripheral device during start processing
  (d) Nature of the positioning data for the start

3.6 Buffer Memory List

The AD75 has a buffer memory for data communication with the PC CPU. The following data are stored in the buffer memory. The AD75 carries out positioning control using these data.

- Parameter area for setting the AD75 parameters.
- Monitor area for checking the control status of the AD75.
- Control data area for setting the control status of the AD75.
- Buffer memory positioning data area for setting positioning data by sequence program.
- Positioning start information area for setting positioning start information by sequence program.
- PC CPU memory area for block start condition data.

(1) Buffer memory area

(a) Parameter area

- Basic parameters ..... Area for setting basic parameters for positioning control such as command unit, travel value per pulse, pulse output mode and direction of rotation
- Detailed parameters..... Area for setting detailed information for positioning control such as backlash compensation, stroke limits, M code output timing, acceleration/deceleration time and selection of rapid stop.
- Home position return basic parameters .... Area for setting the basic parameters for home position return such as the home position return method, direction, address and speed
- Home position return extended parameters .... Area for setting the required information for home position return such as home position return dwell time and home position return acceleration/deceleration time.

(b) Monitor area

- System monitor..... Area which stores information on the control status common to the system.
- Axis monitor ..... Area which stores information on the control status for each axis.

(c) Control data area

- System control data..... Area for reading/writing the clock data and positioning data.
- Axis control data..... Area for setting the control status for each axis.

(d) Buffer memory positioning data area

Data area for setting positioning data using the sequence program.

(e) Positioning start information area

- Positioning start data..... Area for setting the positioning data No.
- Positioning special start data ..... Area for setting special operations in normal positioning operation, such as condition judgment, simultaneous start, stop or repeat.
- Condition data..... Area for setting condition judgment for the special operation instruction set in the positioning special start data.
- Indirect designation ..... Area for setting the positioning data No. indirectly.

(f) PC CPU memory area

Area for controlling positioning start from the sequence program by setting the condition judgment value for the condition judgment and wait judgment from the sequence program.

POINT

Sections 3.6.2 to 3.6.7 explain each area of the buffer memory. Buffer memory address that are not described (missing address numbers) are not available to the user.
If the user writes to the missing addresses, an error may occur.

(2) Data reading/writing in the buffer memory

Reading and writing method in the buffer memory are shown as follows:

(a) Reading

- Using the sequence program ..... The buffer memory address is designated by the buffer memory access instruction. Data can be read directly in 1 word (16-bit) or 2 word units.
- Using a peripheral device ..... Data applicable to each mode of a peripheral device can be read.

(b) Writing

- Using the sequence program ..... The buffer memory address is designated by the buffer memory access instruction. Data can be written directly in 1 word (16-bit) or 2 word units.
- Using a peripheral device ..... Data is stored in the peripheral device and the data is written into the AD75 buffer memory by block transfer from the peripheral device.

<Buffer memory contents and writing conditions>

Contents		Writing Condition
Parameter area		Write enabled at all times Some changes may not take effect immediately; this depends on the parameter type.
Monitor area		Read only
Control data area		Write enabled at all times
Buffer memory positioning data area		Write enabled Write before positioning start (Y10 to Y12) for the applicable axis is turned ON.
Positioning start information	Positioning start data	
	Positioning special start data	
	Condition data	
	Indirect designation	
PC CPU memory area		Write enabled at all times
Transmission interface area between the PC CPU and AD75		Write enabled at all times

POINT

The buffer memory does not back up data by battery.
When the power is turned on, the AD75 carries out the following processing with respect to the buffer memory.

- Parameter area ..... Transmits the parameter value
- Monitor area, control data area ..... Initialized.
- Buffer memory positioning data area .. Transmits the data in the flash
- PC CPU memory area ..... Initialized.

3.6.1 Buffer memory configuration

The buffer memory configuration is shown below:

Address				
0 to 13	Basic parameters	For axis 1		Parameter area
14	Not used (unavailable)			
15 to 62	Extended parameters			
63 to 69	Not used (unavailable)			
70 to 87	Home position return parameters			
88 to 149	Not used (unavailable)			
150 to 163	Basic parameters	For axis 2		
164	Not used (unavailable)			
165 to 212	Extended parameters			
213 to 219	Not used (unavailable)			
220 to 237	Home position return parameters			
238 to 299	Not used (unavailable)			
300 to 313	Basic parameters	For axis 3		
314	Not used (unavailable)			
315 to 362	Extended parameters			
363 to 369	Not used (unavailable)			
370 to 387	Home position return parameters			
388 to 449	Not used (unavailable)			
450 to 799	System monitor		System monitor area	Monitor area
800 to 899	Axis monitor for axis 1		Axis control data area	
900 to 999	Axis monitor for axis 2			
1000 to 1099	Axis monitor for axis 3			
1100 to 1149	System control data		Axis monitor area	Control data area
1150 to 1199	Axis control data for axis 1		System control data area	
1200 to 1249	Axis control data for axis 2			
1250 to 1299	Axis control data for axis 3			
1300 to 2299	Buffer memory positioning data for axis 1			Buffer memory positioning data area
2300 to 3229	Buffer memory positioning data for axis 2			
3300 to 4299	Buffer memory positioning data for axis 3			
4300 to 4499	Start block for axis 1			
4500 to 4549	Indirect designation for axis 1			
4550 to 4749	Start block for axis 2			
4750 to 4799	Indirect designation for axis 2			
4800 to 4999	Start block for axis 3			
5000 to 5049	Indirect designation for axis 3			
5050 to 5099	PC CPU memory area			PC CPU memory area
5100 to 7167	Spare			

3.6.2 Parameter area

The parameter area of the buffer memory is described here.

This section describes the buffer memory address and setting range for axis 1, axis 2 and axis 3.
For details on setting, refer to Sections 3.4.1 and 3.4.2.

(1) Basic parameters #1

Buffer Memory Address			Item		Setting Range				Initial Value
Axis 1	Axis 2	Axis 3							
0	150	300	Unit setting		0: mm 1: inch 2: degree 3: pulse				3
1	151	301	Travel value per pulse	Number of pulses per revolution	1 to 65535 pulse				20000
2	152	302		Travel value per revolution	1 to 65535 x 10^{-1} μm	1 to 65535 x 10^{-5} inch	1 to 65535 x 10-5 degree	1 to 65535 pulse	20000
3	153	303		Unit magnification	1: x1 times, 10: x10 times, 100: x100 times, 1000: x1000 times				1
4	154	304	Pulse output mode		0: PLS/SIGN mode 1: CW/CCW mode 2: A phase/B phase mode				1
5	155	305	Rotation direction setting		bit0 0: Increase of present value on forward rotation pulse output 1: Increase of present value on reverse rotation pulse output				0

(2) Basic parameters #2

Buffer Memory Address			Item	Setting Range				Initial Value
Axis 1	Axis 2	Axis 3						
6 7	156 157	306 307	Speed limit value	1 to 600000000 x 10^{-2} mm/min	1 to 600000000 x 10^{-3} inch/min	1 to 600000000 x 10-5 degree/min	1 to 1000000 pulse/s	200000
8 9	158 159	308 309	Acceleration time 0	1 to 65535 ms				1000
10 11	160 161	310 311	Deceleration time 0	1 to 65535 ms				1000

POINTS

(1) Basic parameters #2 determine the slope of acceleration and deceleration.
Sets the optimum values according to the system. (Operation using the initial values is also possible.)

(2) Basic parameters #1 can only be set while the sequence ready signal (Y1D) is OFF.

(3) Basic parameters #2 can be set provided the BUSY status is not effective.

(3) Extended parameters #1

Buffer Memory Address			Item	Setting Range				Initial Value
Axis 1	Axis 2	Axis 3						
15	165	315	Backlash compensation	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	0
16 17	166 167	316 317	Software stroke limit 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	+2147483647
18 19	168 169	318 319	Software stroke limit Lower 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	-2147483648
20	170	320	Software stroke limit Selection	bit0 0: The software stroke limit is applied to the feed present value. 1: The software stroke limit is applied to the machine feed value.				0
21	171	321	Valid software stroke limit of JOG operation and manual pulse generator operation	bit0 0: The software stroke limit is valid in JOG operation and manual pulse generator operation. 1: The software stroke limit is invalid in JOG operation and manual pulse generator operation.				0
22 23	172 173	322 323	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	100
24	174	324	Torque limit setting value	1 to 500 %				300
25	175	325	M code ON signal output timing	bit0 0: WITH mode 1: AFTER mode				
26	176	326	Speed change mode speed change type	bit0 0: WITH mode 1: AFTER mode				0
27	177	327	Interpolation method designation method (interpolation mode)	bit0 0: Resultant speed 1: Long axis speed				0
28	178	328	Feed present value update request command during speed control	bit0 0: Feed present value is not updated during speed control. 1: Feed present value is updated during speed control.				0
29	179	329	Manual pulse generator selection	0: Manual pulse generator operation is not acknowledged. 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

POINT

The settings for extended parameters #1 are valid when the PC READY signal is turned from OFF to ON. After the detailed parameters 1 settings have been rewritten while the PC READY signal is ON, turn the PC READY signal OFF and then back ON.

(4) Extended parameters #2

Buffer Memory Address			Item	Setting Range				Initial Value
Axis 1	Axis 2	Axis 3						
36 37	186 187	336 337	Acceleration time 1	1 to 65535 ms				1000
38 39	188 189	338 339	Acceleration time 2					
40 41	190 191	340 341	Acceleration time 3					
42 43	192 193	342 343	Deceleration time 1	1 to 65535 ms				1000
44 45	194 195	344 345	Deceleration time 2					
46 47	196 197	346 347	Deceleration time 3					
48 49	198 199	348 349	JOG speed limit value	1 to 600000000 x 10^{-2} μm/min	1 to 600000000 x 10^{-3} inch/min	1 to 600000000 x 10-3 degree/min	1 to 1000000 pulse/s	20000
50	200	350	JOG operation acceleration time selection	0 to 3				0
51	201	351	JOG operation deceleration time selection	0 to 3				0
52	202	352	Acceleration/deceleration processing selection	bito 0: Trapezoidal acceleration/deceleration process 1: S pattern acceleration/deceleration processing				0
53	203	353	S curve ratio	1 to 100 %				100
54 55	204 205	354 355	Rapid stop deceleration time	1 to 65535 ms				1000
56	206	356	Stop group 1 rapid stop selection	bit0 0: Normal deceleration stop 1: Rapid stop				0
57	207	357	Stop group 2 rapid stop selection	bit0 0: Normal deceleration stop 1: Rapid stop				0
58	208	358	Stop group 3 rapid stop selection	bit0 0: Normal deceleration stop 1: Rapid stop				0
59	209	359	Positioning completed signal output time	0 to 65535 ms				300
60 61	210 211	360 361	Circular interpolation tolerance	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	100
62	212	362	External start function selection	0: External positioning start 1: External speed change request 2: Skip request				0

(5) Home position return basic parameters

Buffer Memory Address			Item	Setting Range				Initial Value
Axis 1	Axis 2	Axis 3						
70	220	370	Home position return type	Near-zero point dog 1: Stopper stop 1 (by time-out of the dwell timer) 2: Stopper stop 2 (by zero point signal when stopper is contacted) 3: Stopper stop 3 (without near-zero point type) 4: Count type 1 (zero point signal used) 5: Count type 2 (zero point signal not used)				0
71	221	371	Home position return direction	bit0 0: Positive direction (address incremental direction) 1: Negative direction (address decrease direction)				0
72 73	222 223	372 373	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	0
74 75	224 225	374 375	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	1
76 77	226 227	376 377	Creep 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	1
78	228	378	Home position return retry	bit0 0: Home position return retry is not performed using upper/lower limit switch. 1: Home position return retry is performed using upper/lower limit switch.				0

(6) Home position return extended parameters

Buffer Memory Address			Item	Setting Range				Initial Value
Axis 1	Axis 2	Axis 3						
79	229	379	Home position return dwell time	0 to 65535 ms				0
80 81	230 231	380 381	Travel value after near-zero point dog setting	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	0
82	232	382	Home position return acceleration time selection	0 to 3				0
83	233	383	Home position return deceleration time selection	0 to 3				0
84 85	234 235	384 385	Home position return shift amount	-2147483648 to +2147483647 x 10^{-1} μm	-2147483648 to +2147483647 x 10^{-5} inch	-2147483648 to +2147483647 x 10^{-5} degree	-2147483648 to +2147483647 pulse	0
86	236	386	Home position return torque limit value	1 to 300 (%)				300

POINT

The home position return basic parameter and home position return extended parameter settings become valid when the PC READY signal is turned from OFF to ON. If you change a home position return basic parameter or home position return extended parameter setting while the PC READY signal is ON, turn the PC READY signal OFF and then back ON afterwards.

3.6.3 Monitor area

The monitor area of the buffer memory is described here.

Writing data to the monitor area does not cause an error; the data is stored in the monitor area as it is.
When the PC CPU reads the data, the AD75 sets new information automatically, which means that writing data to the monitor area does not cause a problem.

When the power is turned on, the initial values are stored in the monitor area.

(1) System monitor area

The system monitor area can be monitored using the monitor function of peripheral devices.

Buffer Memory Address (Common to Axis 1, Axis 2 and Axis 3)	Item	Remark/Setting Range	Initial Value
450	Test mode flag	• Flag for determining whether the test mode of the peripheral device is currently effective or not. • The device is turned ON when the peripheral device is in the test mode and turned OFF when it is not in the test mode. bit0 0: Not in test mode 1: In test mode	0
451	Unit type name	When the power is turned ON or the PC READY signal is ON, the AD75 unit type name is stored. 0: AD75P1 1: AD75P2 2: AD75P3	Module model name is stored.
452 453 454 455	OS type	• When the power is turned ON or the PC READY signal is ON, the AD75 type is stored. • It is stored in 8 letters of ASCII code.	OS type is stored.
456 457	OS version	• When the power is turned ON or the PC READY signal is ON, the AD75 version is stored. • It is stored in 4 letters of ASCII code.	OS version
460	Clock data (hour:minute)	Software type clock data that counts time by cyclic interruption in the AD75 system. • Used for recording the times at which errors (warnings) occur in the error (warning) history. • When the power is turned on, the clock data must be set in the PC CPU. [The clock of the PC CPU does not always conform to that of the AD75. If time conformity is required, rese the PC CPU periodically.] b15 b0 Minute (00 to 59 is stored in BCD.) Hour (00 to 23 is stored in BCD.)	0
461	Clock data (second, 100 ms)	Ditto b15 b0 100 ms (00 to 09 is stored in BCD.) Second (00 to 59 is stored in BCD.)	0

Buffer Memory Address (Common to Axis 1, Axis 2 and Axis 3)															
Start History															
0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
462	467	472	477	482	487	492	497	502	507	512	517	522	527	532	537
463	468	473	478	483	488	493	498	503	508	513	518	523	528	533	538
464	469	474	479	484	489	494	499	504	509	514	519	524	529	534	539
465	470	475	480	485	490	495	500	505	510	515	520	525	530	535	540
466	471	476	481	486	491	496	501	506	511	516	521	526	531	536	541
542															

	Item	Remark/Setting Range	Initial Value
	Start history Start axis	•The axis No. of the started axis is stored here. 1 to 3	0
	Start history Operation type	• The axis positioning data No. for JOG operation, manual pulse generator operation or positioning operation is stored here. • PC CPU, external start or peripheral device is stored as the start source. • Restart flag is turned ON when restarting from stopped state. b15 b0 Positioning operation :1 to 600 Block positioning operation :7000 (H1B58) JOG operation :8060 (H1F7C) Manual pulse generator operation :8061 (H1F7D) Home position return :8051 (H1F73) High-speed home position return :8052 (H1F74) Present value change :8053 (H1F75) Start source 00: PC CPU 01: External signal 10: Peripheral device Restart flag	0
	Start history Start hour: minute	• The hour and minute when the start was executed are recorded as follows. b15 b0 Minute (00 to 59 is stored in BCD.) Hour (00 to 23 is stored in BCD.)	0
	Start history Start second: 100 ms	• The second and 100 ms unit when the start was executed are recorded as follows. b15 b0 100 ms (00 to 09 is stored in BCD.) Second (00 to 59 is stored in BCD.)	0
	Start history Error judgment	• Error judgment result is stored at the start time. • If an error occurs at the start time and the start operation is not carried out, the error flag is turned ON and the error No. is stored. • If the start is executed during operation (while BUSY signal is ON), the BUSY warning flag is turned ON. b15 b0 Error No. Error flag BUSY start warning flag	0
	Start history Pointer	• The next pointer of the latest axis error is designated by a value from 0 to 15. • It is 0 when the power is turned on.	0

Buffer Memory Address (Common to Axis 1, Axis 2 and Axis 3)															
Start History in the Event of an Error															
0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
543	548	553	558	563	568	573	578	583	588	593	598	603	608	613	618
544	549	554	559	564	569	574	579	584	589	594	599	604	609	614	619
545	550	555	560	565	570	575	580	585	590	595	600	605	610	615	620
546	551	556	561	566	571	576	581	586	591	596	601	606	611	616	621
547	552	557	562	567	572	577	582	587	592	597	602	607	612	617	622
623															

	Item	Remark/Setting Range	Initial Value
	Start history in the event of an error Start axis	• The axis No. of the axis where an error occurred on starting is stored here. 1 to 3	0
	Start history in the event of an error Operation type	• The axis positioning data No. for JOG operation, manual pulse generator operation and positioning operation are stored. • PC CPU, external start or peripheral device is stored as the start source. • Restart flag is turned ON when restarting from stopping. b15 [ ] b0 Positioning operation : 1 to 600 Block positioning operation : 7000 (H1B58) JOG operation : 8060 (H1F7C) Manual pulse generator operation : 8061 (H1F7D) Home position return : 8051 (H1F73) High-speed home position return : 8052 (H1F74) Present value change : 8053 (H1F75) → Start source 00: PC CPU 01: External signal 10: Peripheral device → Restart flag	0
	Start history in the event of an error Start hour: minute	• The hour and minute when the error was detected are recorded as follows. b15 b0 → Minute (00 to 59 is stored in BCD.) → Hour (00 to 23 is stored in BCD.)	0
	Start history in the event of an error Start second: 100 ms	• The second and 100 ms unit when the error was detected are recorded as follows. b15 b0 → 100 ms (00 to 09 is stored in BCD.) → Second (00 to 59 is stored in BCD.)	0
	Start history in the event of an error Error judgment	• The error judgment result is stored at the start time. • If an error occurs at the start time and the start operation is not carried out, the error flag is turned ON and the error No. is stored. • If the start is executed during operation (while BUSY signal is ON), the BUSY warning flag is turned ON. b15 [ ] b0 Error No. → Error flag → BUSY start warning flag	0
	Start history Pointer	• The next pointer after the latest axis error is indicated by a value from 0 to 15. • It is 0 when the power is turned on.	0

Buffer Memory Address (Common to Axis 1, Axis 2 and Axis 3)															
Error History/Warning History															
0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
624	628	632	636	640	644	648	652	656	660	664	668	672	676	680	684
625	629	633	637	641	645	649	653	657	661	665	669	673	677	681	685
626	630	634	638	642	646	650	654	658	662	666	670	674	678	682	686
627	631	635	639	643	647	651	655	659	663	667	671	675	679	683	687
688															
689	693	697	701	705	709	713	717	721	725	729	733	737	741	745	749
690	694	698	702	706	710	714	718	722	726	730	734	738	742	746	750
691	695	699	703	707	711	715	719	723	727	731	735	739	743	747	751
692	696	700	704	708	712	716	720	724	728	732	736	740	744	748	752
753															

	Item	Remark/Setting Range	Initial Value
	Error history Error occurrence axis	• The error occurrence axis is stored. 1 to 3	0
	Error history Axis error No.	• The axis error No. is stored.	0
	Error history Axis error hour: minute of occurrence	• The hour and minute when the axis error was detected are recorded as follows. b15 b0 → Minute (00 to 59 is stored in BCD.) → Hour (00 to 23 is stored in BCD.)	0
	Error history Axis error second, 100 ms division, of occurrence	• The second and 100 ms unit when the axis error was detected are recorded as follows. b15 b0 → 100 ms (00 to 09 is stored in BCD.) → Second (00 to 59 is stored in BCD.)	0
	Error history Pointer	• The next pointer after the latest axis error is designated by a value from 0 to 15. • It is 0 when the power is turned on.	0
	Warning history Warning occurrence axis	• The warning occurrence axis is stored. 1 to 3	0
	Warning history Axis warning No.	• The axis warning No. is stored.	0
	Warning history Axis warning occurrence hour:minute	• The hour and minute when the axis warning was detected are recorded as follows. b15 b0 → Minute (00 to 59 is stored in BCD.) → Hour (00 to 23 is stored in BCD.)	0
	Warning history Axis error occurrence second, 100 ms division	• The second and 100 ms unit when the axis warning was detected are recorded as follows. b15 b0 → 100 ms (00 to 09 is stored in BCD.) → Second (00 to 59 is stored in BCD.)	0
	Warning history Pointer	• The next pointer after the latest axis warning is designated by a value from 0 to 15. • It is 0 when the power is turned on.	

(2) Axis monitor area

Buffer Memory Address			Item	Remark/Setting Range	Initial Value
Axis 1	Axis 2	Axis 3			
800 801	900 901	1000 1001	Feed present value	• The present execution position is stored. • When the positioning type is absolute, the feed present value becomes a coordinate value. • When home position return is completed, the home position return address is set. • The feed present value is changed by the present value change function. • The software stroke limit can be applied at the feed present value by parameter setting.	0
802 803	902 903	1002 1003	Machine feed value	• The present position in the machine coordinate system, which takes a particular position determined by the machine as its home position, is stored. • The home position return address is set when home position return is completed. • The machine value is not changed by the present value change function. • The software stroke limit can be applied at the machine value by parameter setting.	0
804 805	904 905	1004 1005	Feed speed	• In all operations, the actual speed at the time is stored. • During interpolation, the actual resultant speed or reference axis speed at that time 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. • When an axis stops, zero is stored.	0
806	906	1006	Valid M code	• M code is stored. • When the PC READY signal is turned OFF, zero is entered.	0
807	907	1007	Axis error No.	• If an axis error occurs, the applicable error code is stored. If another axis error occurs after an error code has been stored, the current error code is overwritten by the new error code. • The axis error No. is cleared by axis error reset ON.	0
808	908	1008	Axis warning No.	• If an axis warning occurs, the applicable warning code is stored. If another axis warning occurs after a warning code has been stored, the current warning code is overwritten by the new warning code. • The axis warning No. becomes zero at axis error reset ON.	0
809	909	1009	Axis operation status	• The axis operation status is stored. 0: Standby 1: Stopped 2: Interpolation in progress 3: JOG operation in progress 4: Manual pulse generator operation in progress 5: Analysis in progress 6: Special start wait in progress 7: Home position return in progress 8: Position control in progress 9: Speed control in progress 10: Speed control in progress in speed/position switching control 11: Position control in progress in speed/position switching control -1: Error -2: Step standby -3: Step-stopped -4: Step error	0
810	910	1010	Current speed	• In operation based on positioning data, the commanded speed designated in the positioning data becomes the current speed. If the commanded speed is omitted, the previous current speed is maintained. • During interpolation, the actual resultant speed or reference axis speed at that time 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. • When the positioning data operation is completed, the value becomes zero. • In the stopped status caused by a stop command, the current speed before the stop is held. • In JOG or manual pulse generator operation, zero is stored.	0
812 813	912 913	1012 1013	Axis feed speed	• The actual speed of each axis is stored. • When the axis stops, zero is stored.	0

Buffer Memory Address			Item	Remark/Setting Range	Initial Value
Axis 1	Axis 2	Axis 3			
814 815	914 915	1014 1015	Speed/position switching control Travel value after switching the control	• During speed control by the speed/position switch control, the speed/position switch signal is turned ON. The travel value from the point at which switching to position control occurs to positioning completion is stored here.	0
816	916	1016	External I/O signal	• Indicates ON/OFF status of external I/O signal. b15 b0 Description Indicates ON/OFF status of drive unit ready. Indicates ON/OFF status of zero point signal. Indicates ON/OFF status of in-position signal. Indicates ON/OFF status of near-zero point signal. Indicates ON/OFF status of stop signal. Indicates ON/OFF status of upper limit. Indicates ON/OFF status of lower limit. Indicates ON/OFF status of external start. Indicates ON/OFF status of speed-position switching signal. Indicates ON/OFF status of deviation counter clear.	0

Buffer Memory Address			Item	Remark/Setting Range		Initial Value
Axis 1	Axis 2	Axis 3				
817	917	1017	Status	Indicates ON (1)/OFF (0) status of each flag. b15 b0 Item Speed control in progress flag Speed/position switching flag Command in-position flag Home position return request flag Home position return completed flag Axis warning detected Speed change 0 flag Absolute original point overflow flag Absolute original point underflow flag		0
				Item	Description	
				Speed control in progress flag	• This is used to determine whether speed control or position control is in progress: it is turned ON during speed control. In speed/position switching control, it is turned ON on switching from speed to position control by the external speed- position switching signal. • It is turned OFF during position control, JOG operation and manual pulse generator operation, and when the power is turned on.	0
				Speed/ position switching latch flag	• This is flag is turned ON on switching to position control during speed/position switching control. It is used for travel value change interlock in position control. • It is turned OFF when the next positioning data, JOG operation or manual pulse generator operation is executed.	0
				Com-mand in-position flag	• This flag is turned ON when the remaining distance is less than the designated "command in-position range". • It is turned OFF when the axis travels in each operation. • The command in-position check is always carried out during position control. The command in-position check is not carried out during speed control, or during the speed control part of speed/position switching control.	0
				Home position return request flag	• This flag is turned ON when any of the following occurs, and turned OFF on completion of home position return. • When the power to the AD75 module is turned on. • When the drive unit ready signal is turned OFF. • When the PC READY flag is turned ON. • When home position return is started.	1
				Home position return com-pleted flag	• This flag is turned ON when home position return is completed normally. • It is turned OFF in the event of home position return start, positioning operation start, JOG operation start or manual pulse generator operation start, and when the drive unit ready signal is turned OFF.	0
				Axis warning detected	• This signal is turned ON when an axis warning occurs. • It is turned OFF when the axis error reset is ON.	0
				Speed change 0 flag	• This flag is turned ON when the speed change value is 0 and a speed change is requested. • It is turned OFF when the speed change value is not 0 and a speed change is requested.	0
				Absolute original point overflow flag/ underflow flag	• It is turned ON when shifting of the absolute original point caused by a present value change leads to an underflow or overflow.	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. bit0 0: Speed control in progress 1: Speed control not in progress	0
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. bit0 0: Speed change processing completed 1: Speed change processing in progress	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, 843 / 943 / 1043: Commanded speed 844 / 944 / 1044, 845 / 945 / 1045: Axis 1 Positioning address 846 / 946 / 1046, 847 / 947 / 1047: Axis 1 Arc data	0

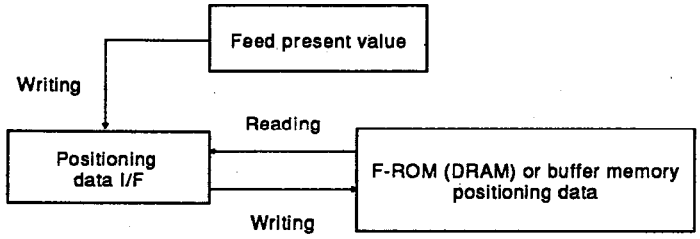
3.6.4 Control data area

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: b15 b0 →Hour (00 to 23 is stored in BCD.) →Day data is not acknowledged if set.	0
1101	Clock data setting (minute, second)	• The minute and second are set as follows: b15 b0 →Second (00 to 59 is stored in BCD.) →Minute (00 to 59 is stored in BCD.)	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. Address field Positioning data field b15 b8 b0 Positioning identifier M code Dwell time Commanded speed 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 (Common for Axis 1, Axis 2 and Axis 3)	Item	Remark/Setting Range	Initial Value
1106	Write/read request	• 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)	0
1108 to 1137	Read/write positioning data interface	Axis 1: 1108 Positioning identifier; 1109 M code; 1110 Dwell time; 1111 Spare; 1112–1113 Commanded speed; 1114–1115 Positioning address; 1116–1117 Arc data Axis 2: 1118 Positioning identifier; 1119 M code; 1120 Dwell time; 1121 Spare; 1122–1123 Commanded speed; 1124–1125 Positioning address; 1126–1127 Arc data Axis 3: 1128 Positioning identifier; 1129 M code; 1130 Dwell time; 1131 Spare; 1132–1133 Commanded speed; 1134–1135 Positioning address; 1136–1137 Arc data	0
1138	F-ROM writing request	• 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)	0

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.

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				

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

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.

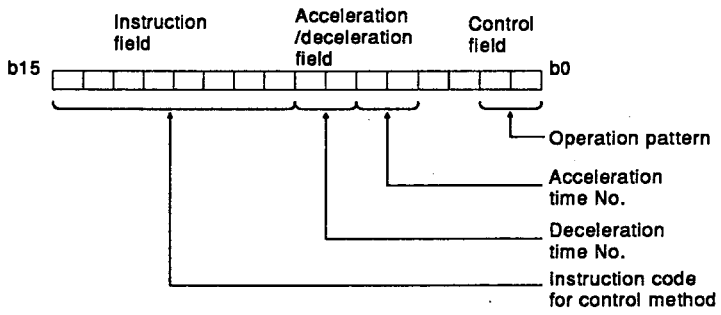
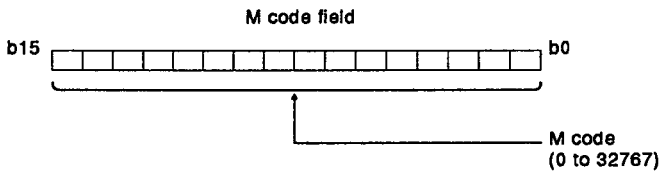
[Buffer memory positioning data areas configuration]

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

	Offset
Positioning identifier	+0
M code	+1
Dwell time	+2
Spare	+3
Commanded speed	+4
	+5
Positioning address	+6
	+7
Arc address	+8
	+9

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							
1300	2300	3300	Positioning identifier						0
1301	2301	3301	M code						0
1302	2302	3302	Dwell time		0 to 65535 ms				0
1303	2303	3303	Not used		—				
1304 1305	2304 2305	3304 3305	Commanded speed		-1: Setting of the commanded speed is omitted.				
					1 to 600000000 x 10^{-2} μm/min	1 to 600000000 x 10^{-3} inch/min	1 to 600000.000 /min	1 to 1000000 pulse/s	0
1306 1307	2306 2307	3306 3307	Positioning address	ABS	-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	0
				INC	Other than speed/position switching control				
					-2147483648 to +2147483647 x 10^{-1} μm	-2147483648 to +2147483647 x 10^{-5} inch	-2147483648 to +2147483647 x 10^{-5} degree	-2147483648 to +2147483647 pulse	0
					Speed/position switching control				
					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	0
1308 1309	2308 2309	3308 3309	Arc address	ABS	-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	0
				INC			-2147483648 to +2147483647 x 10^{-5} degree		

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

	Offset
Condition identifier	+0
Unused	+1
Address	+2
Unused	+3
Parameter 1	+4
	+5
Parameter 2	+6
	+7
Unused	+8
	+9

(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

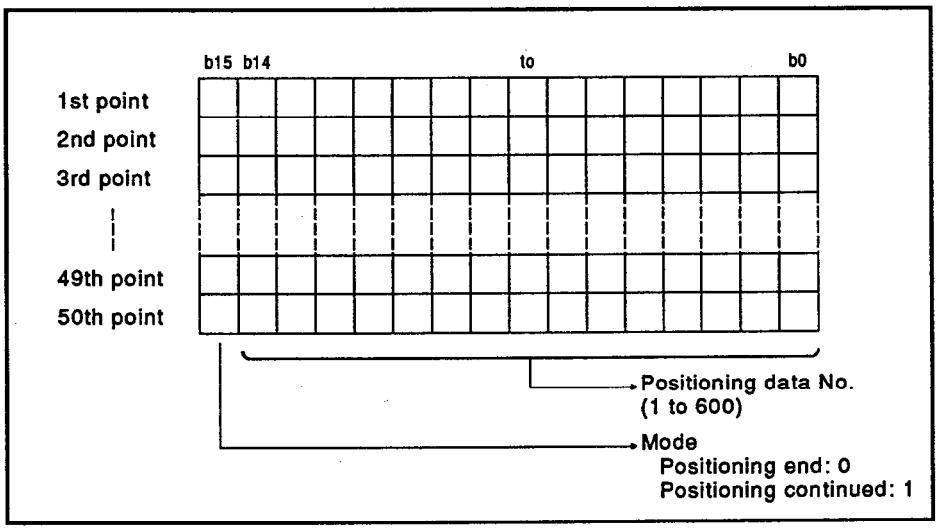
If operation is started without making a setting in the buffer memory for setting the positioning start point number, operation is started from the first point.

(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.

(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).

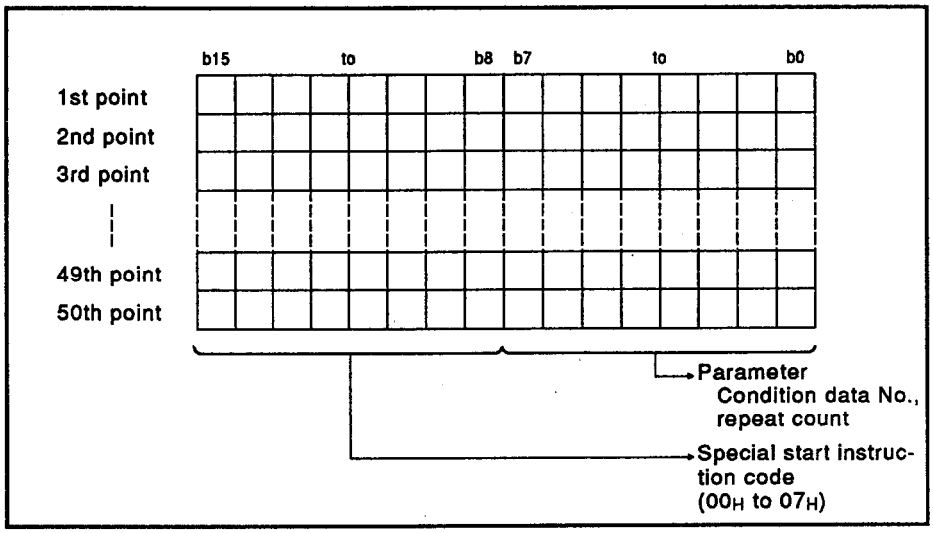
2) For the parameter, set a condition data number or repeat count.

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.

(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.

(b) Configuration of condition data

Axis 1 condition data

Address		
4400	Condition identifier	1st data
4401	Unused	
4402	Address	
4403		
4404	Parameter 1	
4405		
4406	Parameter 2	
4407		
4408	Unused	
4409		
4410	Condition identifier	2nd data
4411	Unused	
4412	Address	
4413		
4414	Parameter 1	
4415		
4416	Parameter 2	
4417		
4418	Unused	
4419		
4420	to	
4489		
4490	Condition identifier	10th data
4491	Unused	
4492	Address	
4493		
4494	Parameter 1	
4495		
4496	Parameter 2	
4497		
4498	Unused	
4499		

Axis 2 condition data

Address		
4650	Condition identifier	1st data
4651	Unused	
4652	Address	
4653		
4654	Parameter 1	
4655		
4656	Parameter 2	
4657		
4658	Unused	
4659		
4660	Condition identifier	2nd data
4661	Unused	
4662	Address	
4663		
4664	Parameter 1	
4665		
4666	Parameter 2	
4667		
4668	Unused	
4669		
4670	to	
4739		
4740	Condition identifier	10th data
4741	Unused	
4742	Address	
4743		
4744	Parameter 1	
4745		
4746	Parameter 2	
4747		
4748	Unused	
4749		

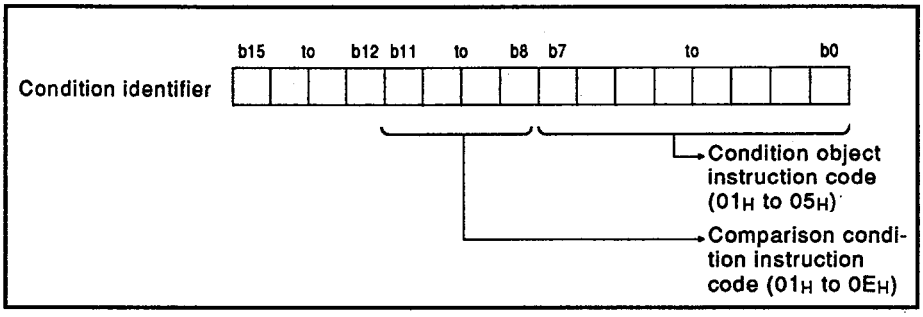
Axis 3 condition data

Address		
4900	Condition identifier	1st data
4901	Unused	
4902	Address	
4903		
4904	Parameter 1	
4905		
4906	Parameter 2	
4907		
4908	Unused	
4909		
4910	Condition identifier	2nd data
4911	Unused	
4912	Address	
4914	Parameter 1	
4915		
4916	Parameter 2	
4917		
4918	Unused	
4919		
4920	to	
4989		
4990	Condition identifier	10th data
4991	Unused	
4992	Address	
4993		
4994	Parameter 1	
4995		
4996	Parameter 2	
4997		
4998	Unused	
4999		

(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]

Address	
5050	
5051	
5052	
5097	
5098	
5099	

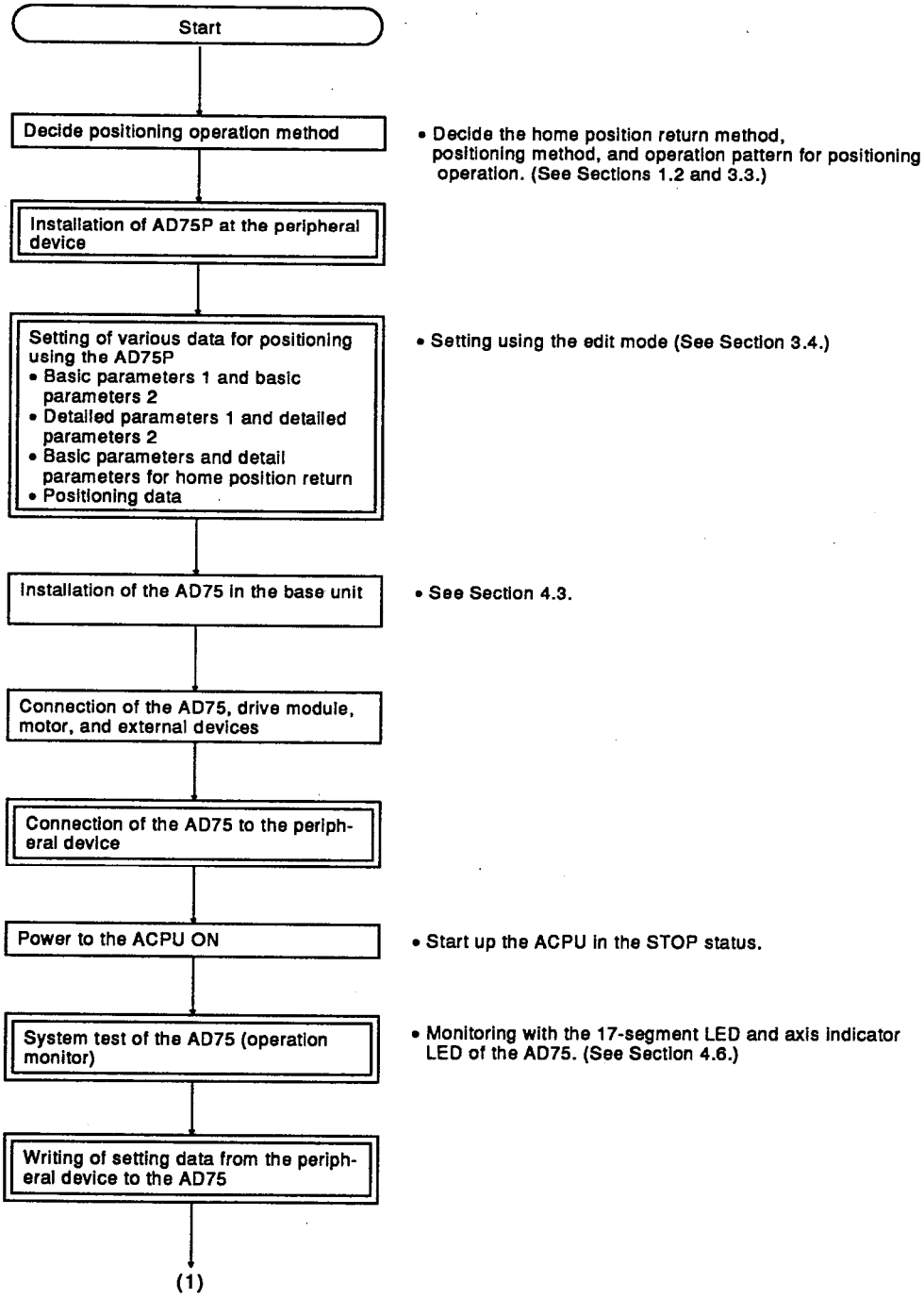
MEMO

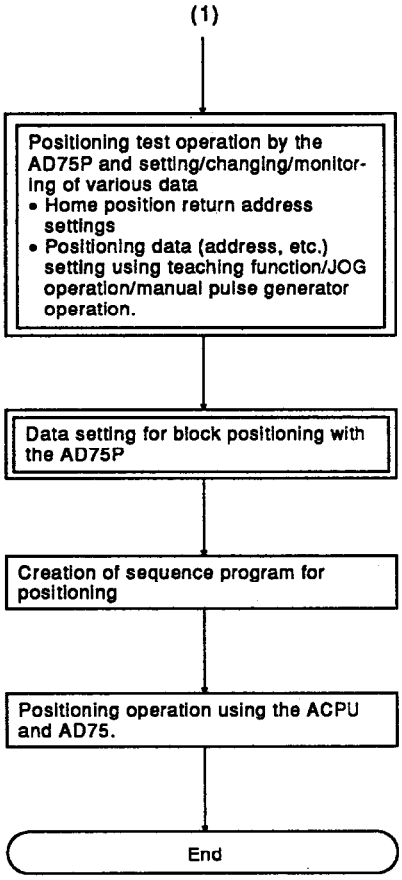
4. OPERATING PROCEDURE AND SETTING

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:





• 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.

4.2 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.

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.

4.3.3 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[ ].

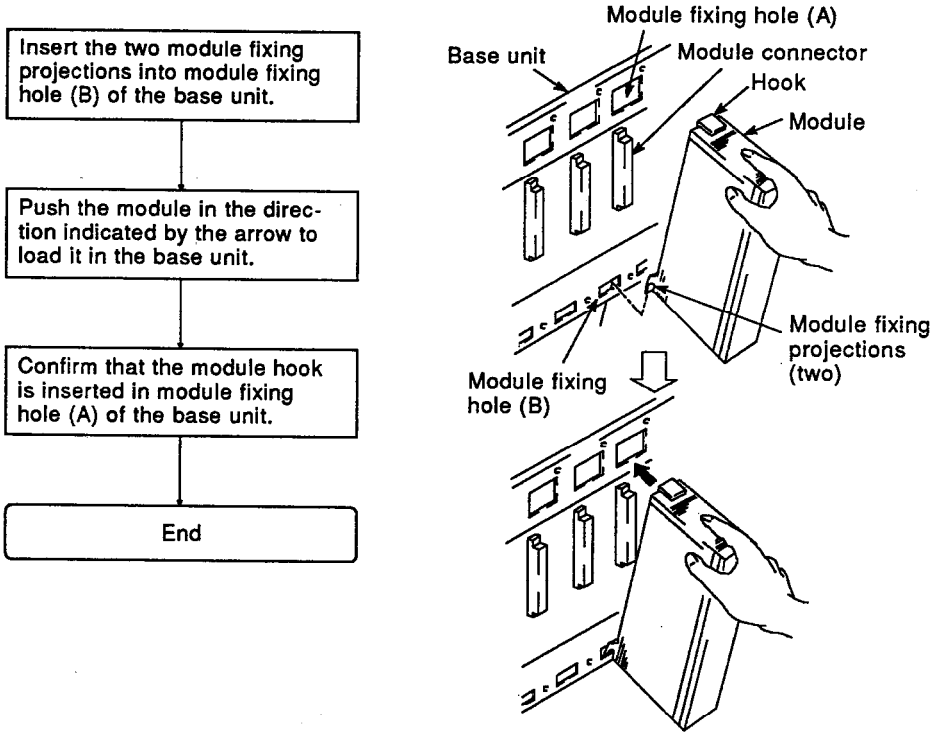
(a) Mounting the module

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.

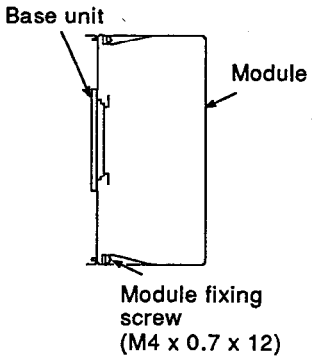
(2) Turn the power supply OFF before mounting the module.
Installation with the power on could result in failure or malfunction of the module.



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.

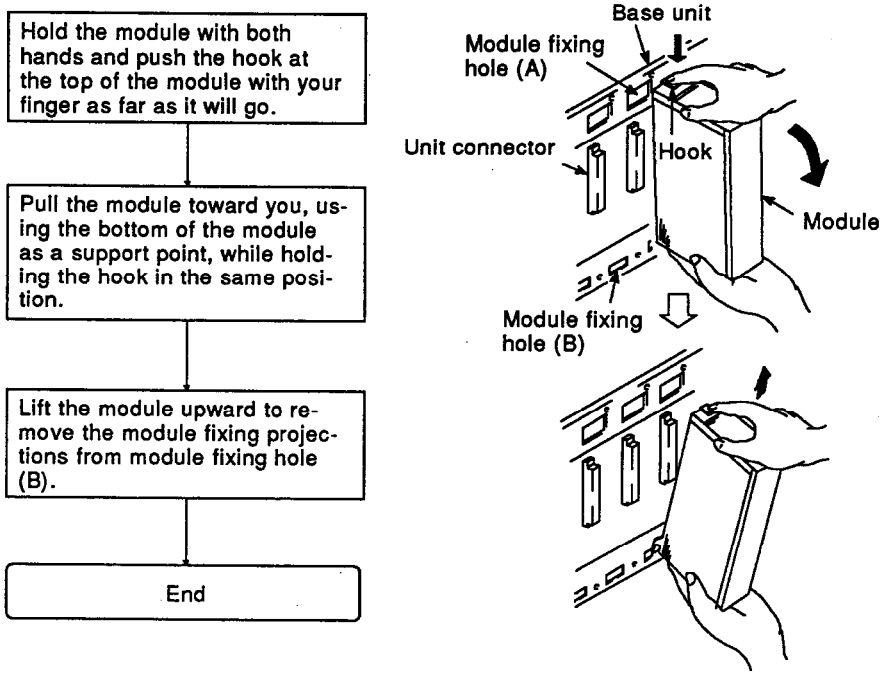


(b) Removing the module

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 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.

(2) Mounting/removing the AISD75P[ ].

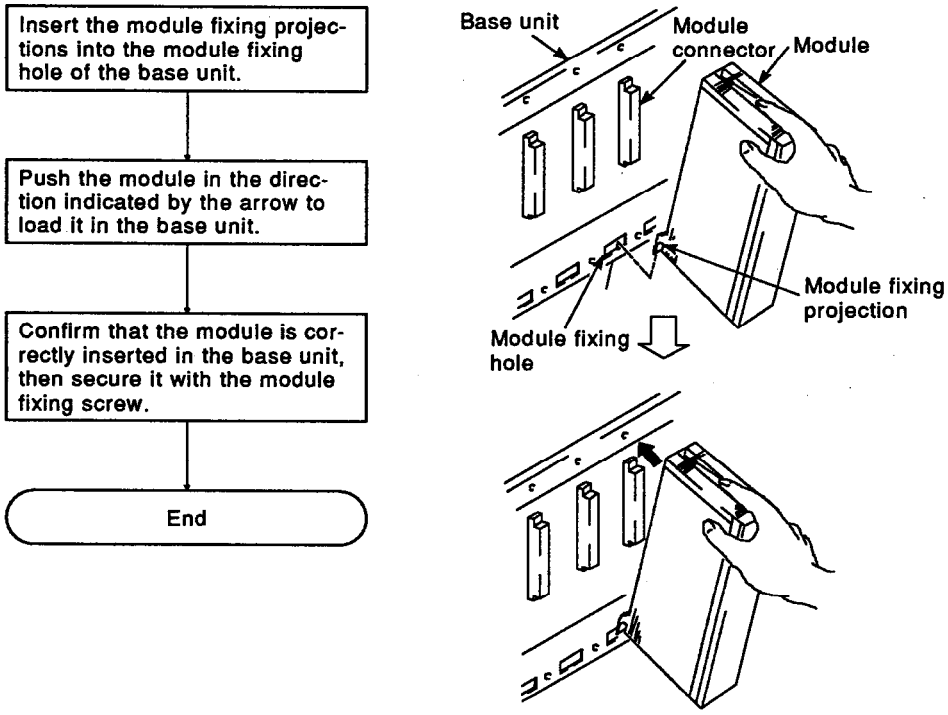
(a) Mounting the module

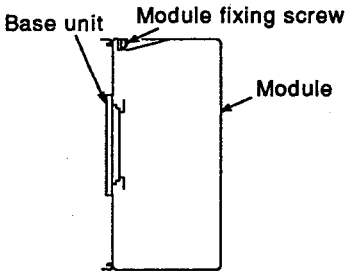
The procedure for mounting the module is as follows:

⚠ 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

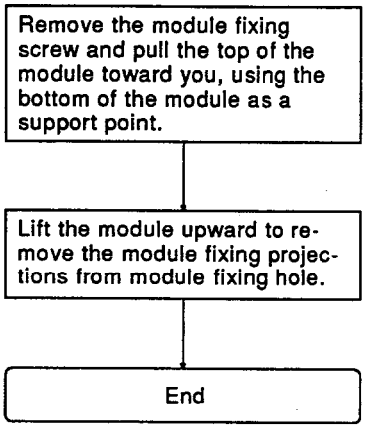
Attempting to mount the module without inserting the fixing projections into module fixing hole (B) may damage the module connector and module.

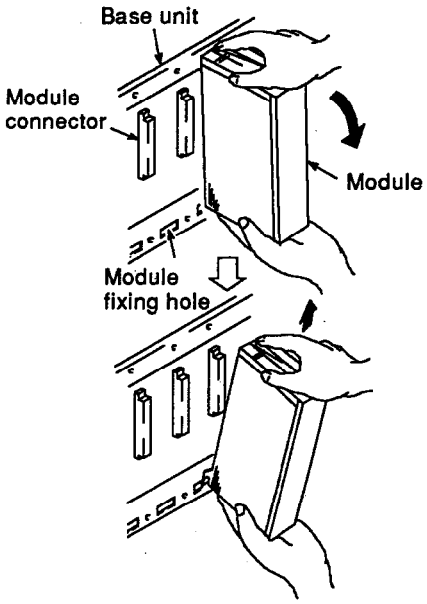
(b) Removing the module

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.



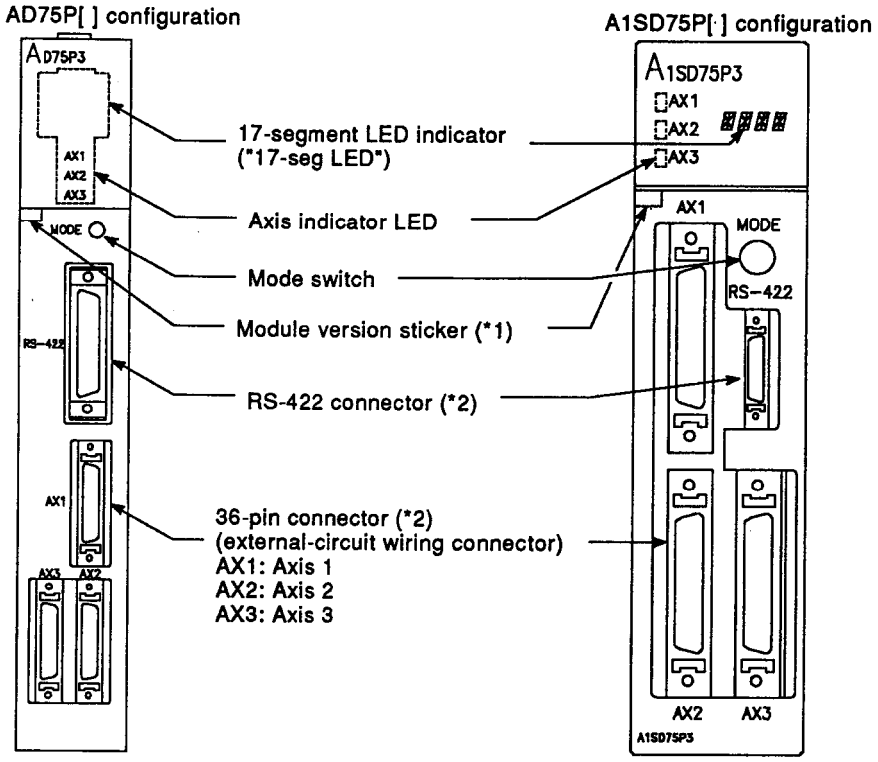


POINT

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.

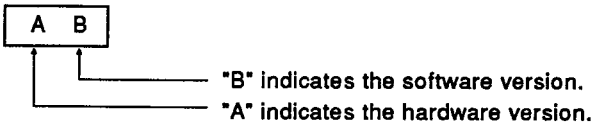
4.4 Part Names

The names of each part of the AD75 are indicated below:

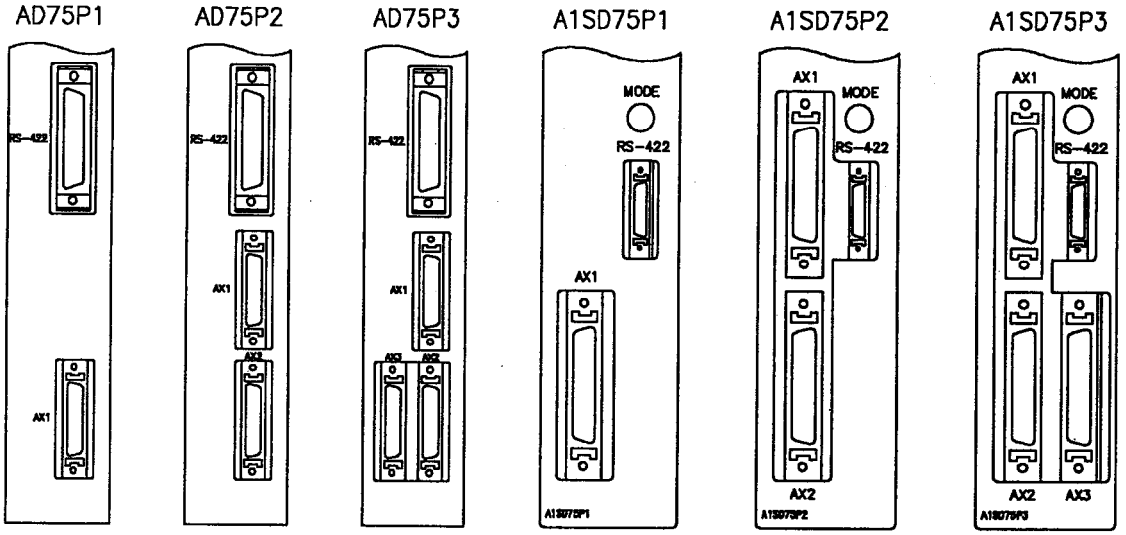


REMARKS

1) *1: Stickers for hardware version and software version of the module.
(Example)



2) *2: The interfaces of each AD75 are indicated below:



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.

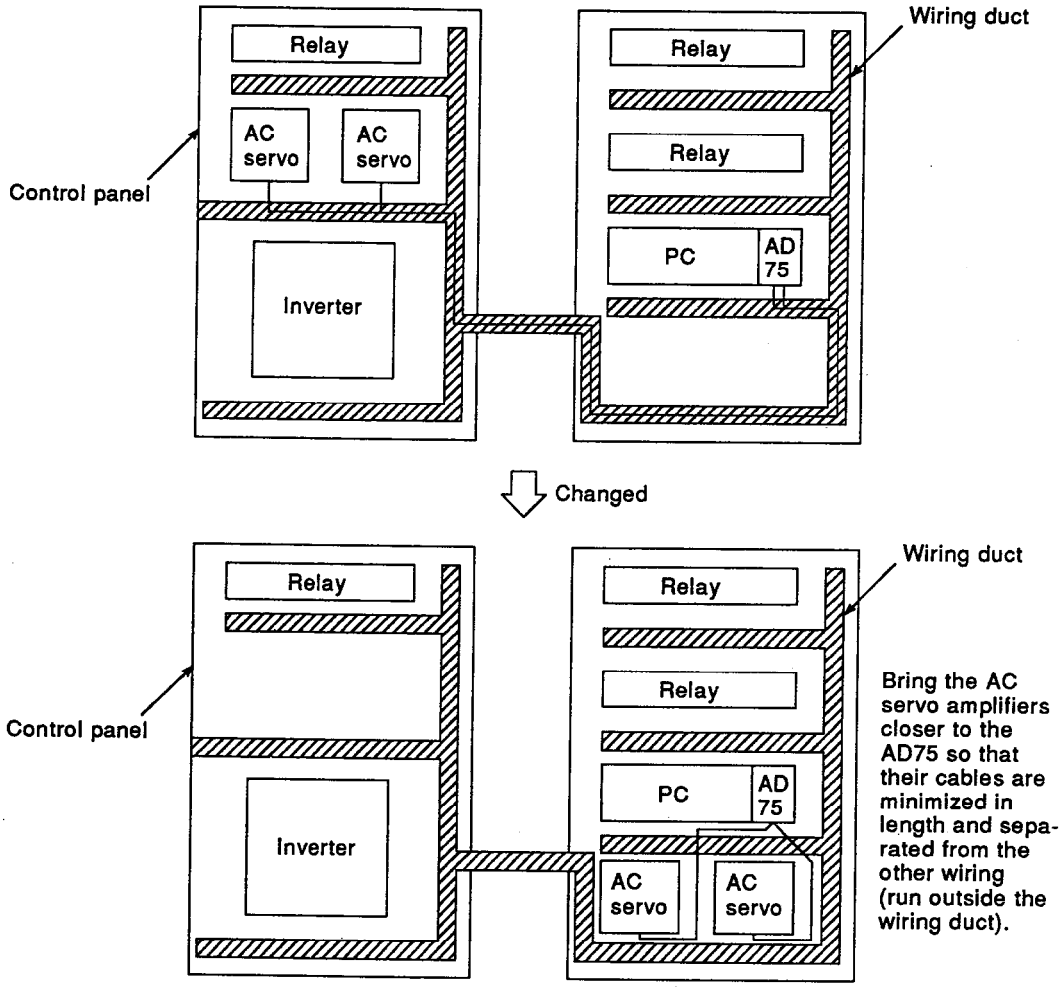
(b) If I/O signal wires have to be laid close to these lines, either use a partitioned duct or separate conduits.

(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.

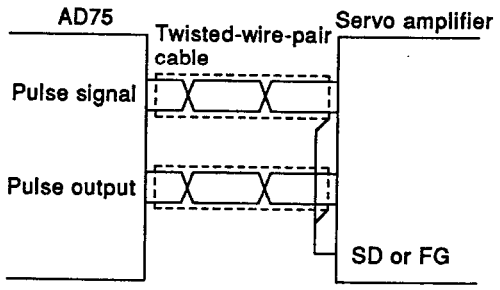
(e) If the connecting cable is too long, or is too close to a main circuit line, malfunctions could occur due to noise.

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.



4.5.2 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.

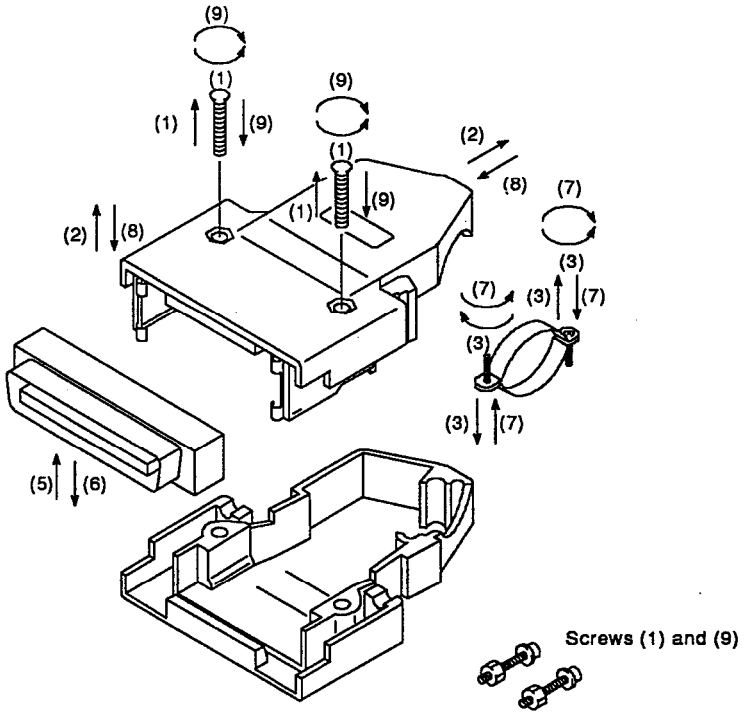
(5) Take out the part to which the connections are made and connect each wire of the signal cable. (For the connecting procedure, see Section 4.5.3.)

(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.



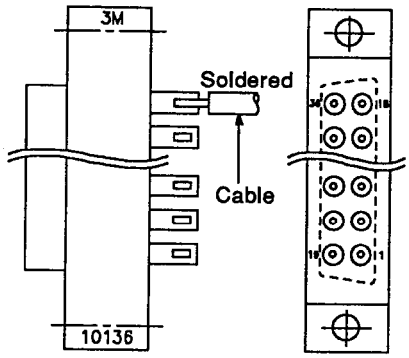
4.5.3 Connecting signal wires

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

4.6 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.

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.

"V000"
Version

(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.

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.

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.

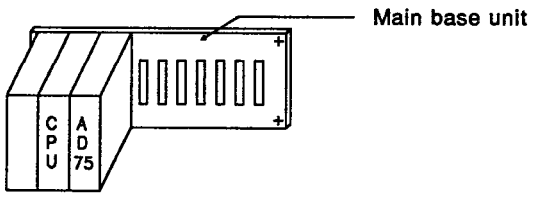
Table 5.1. Devices Used in Program Examples

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

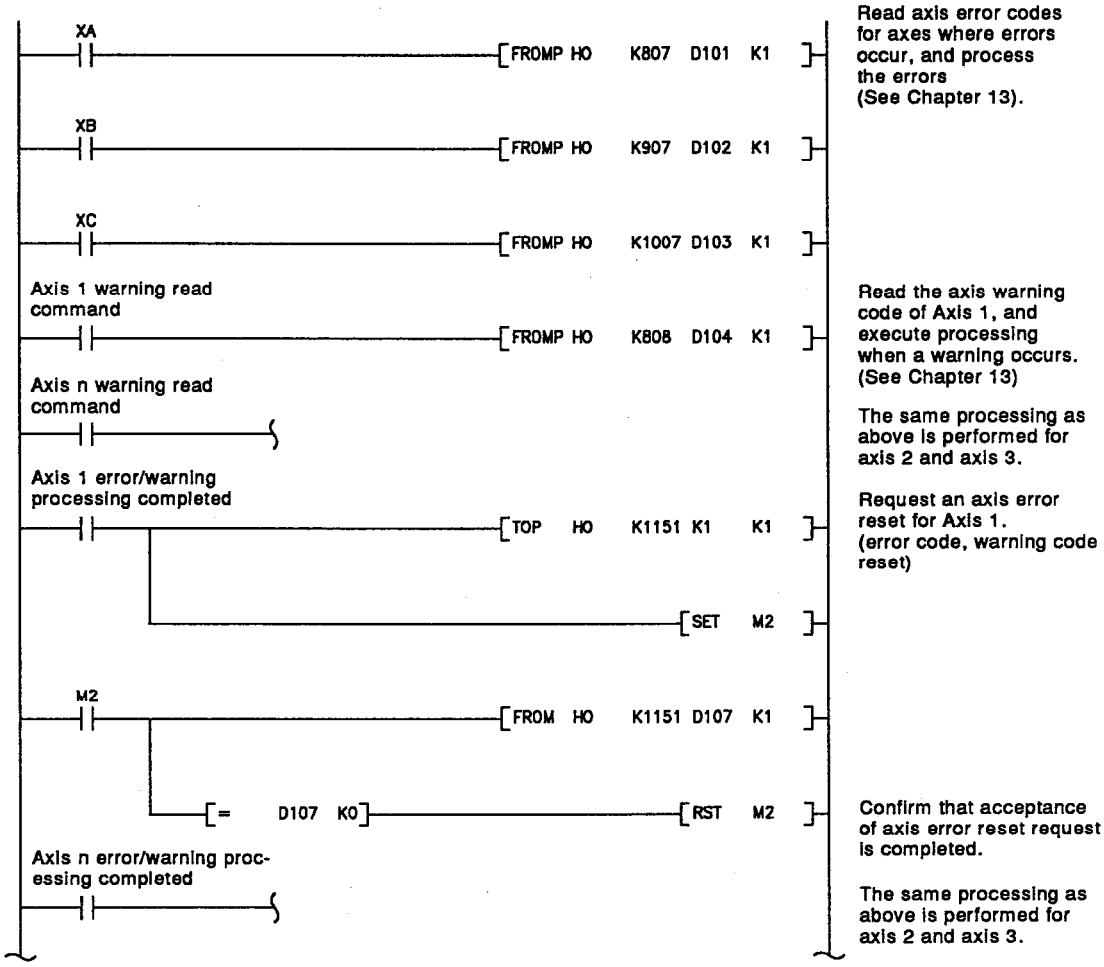
REMARK

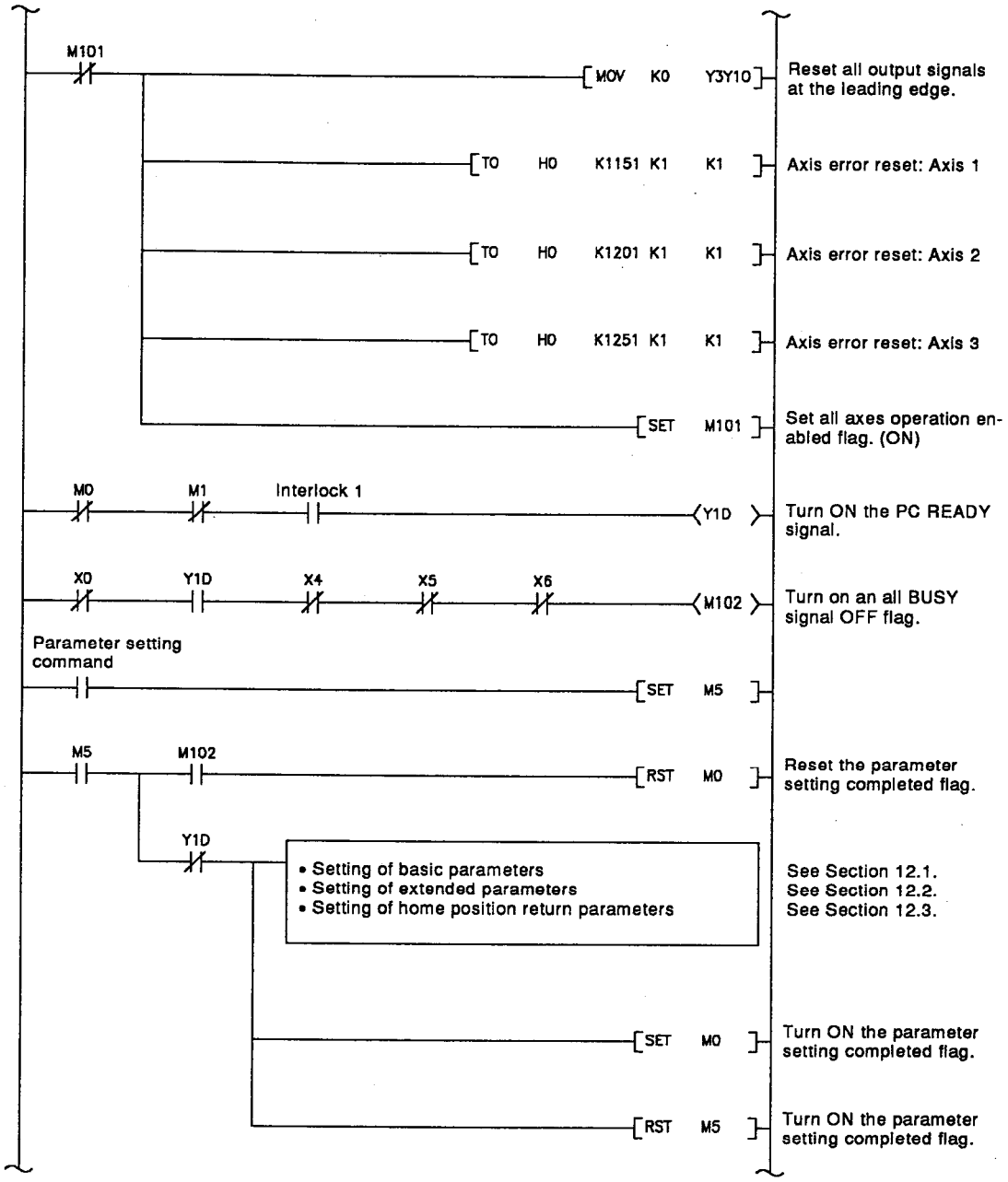
Unless otherwise specified, the sequence programs in this section comply with the following conditions.

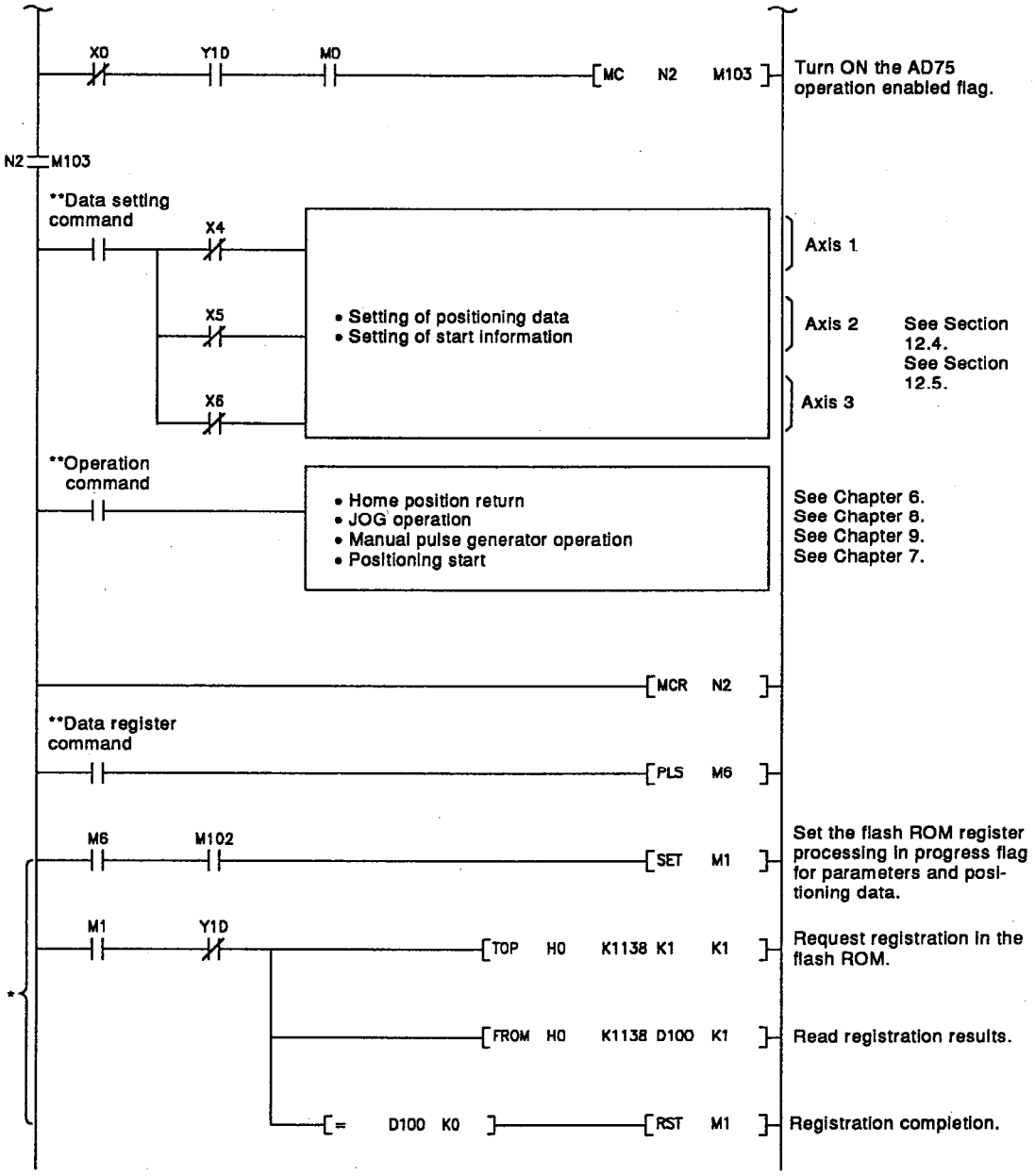
- CPU module : A3UCPU
- I/O signals of the AD75: X/Y00H to X/Y1FH (when the AD75 is set in slot 0 of the main base unit.)



[Program examples]




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.



REMARK

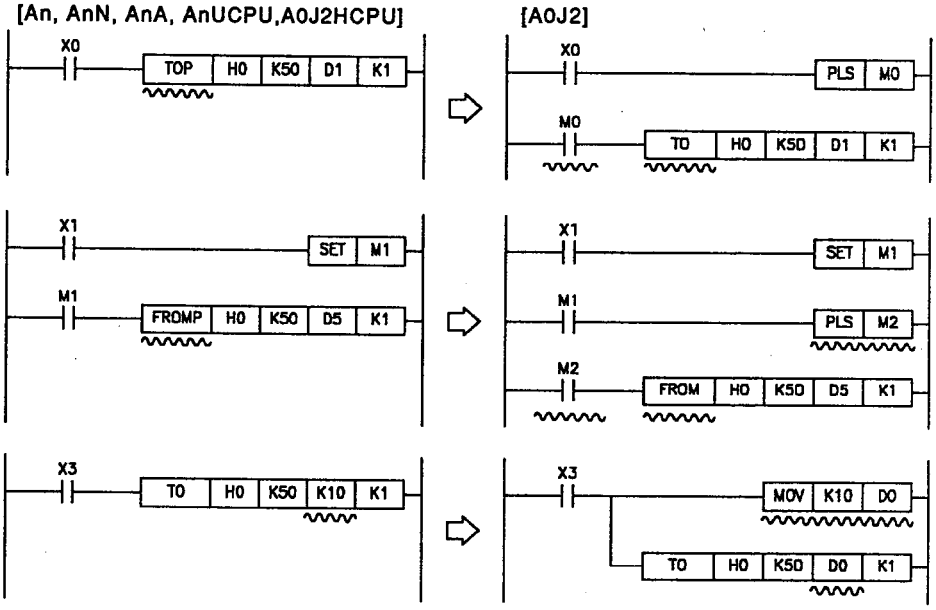
* : This is a program for storing data set at the programmable controller-such as the basic parameters, extended parameters, home position return parameters, positioning data, etc. -to the flash ROM.
This program is not necessary if the above data is written to the AD75 by a sequence program when the programmable controller power comes ON.

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.

MEMO

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.

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.				

6.2 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.	

6.3 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.

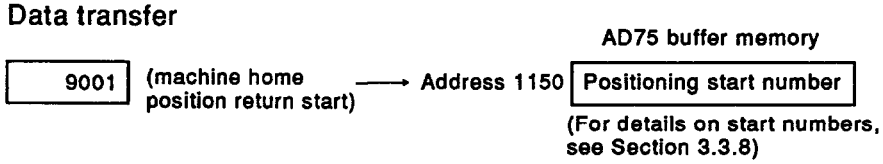
(1) Conditions

- 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.

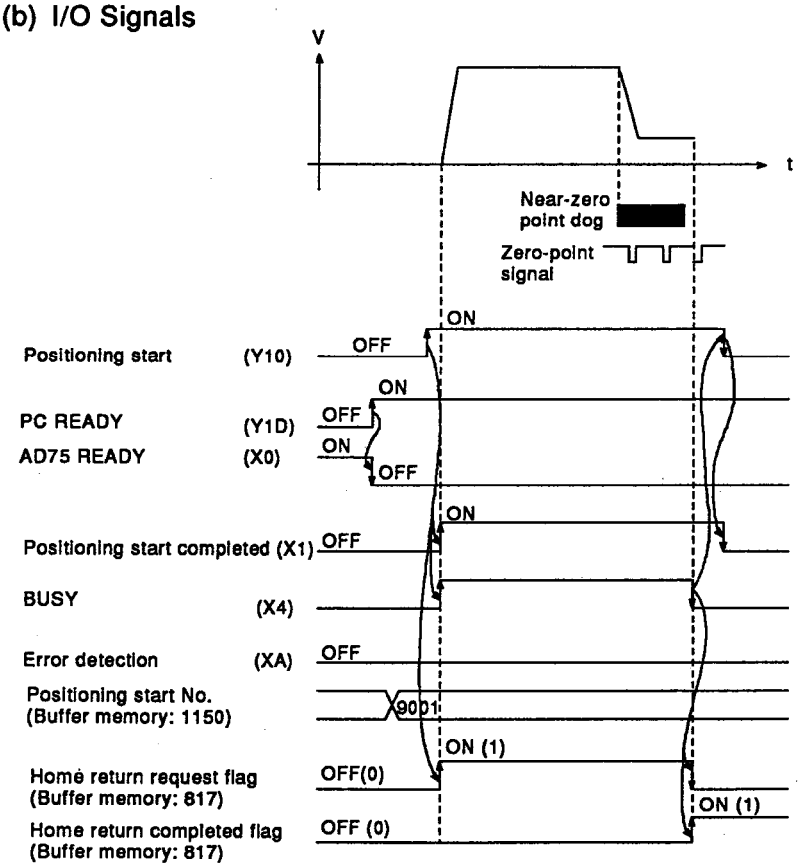
(2) Program example

- The program in this example requests a home position return start for axis 1.

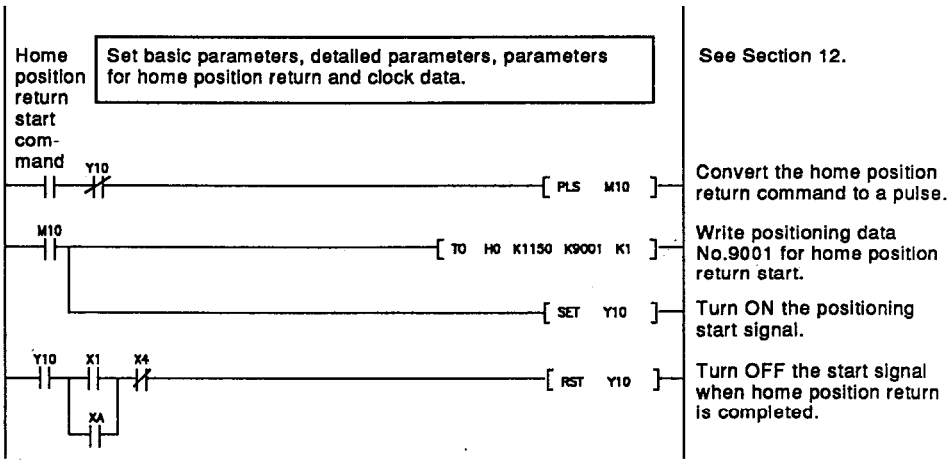
(a) Data transfer



(b) I/O Signals



(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.

6.3.2 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.

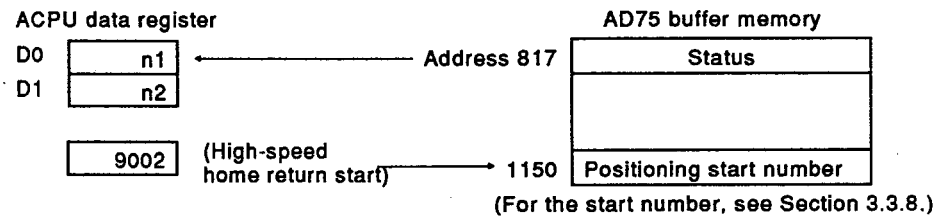
(1) Conditions

- 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.

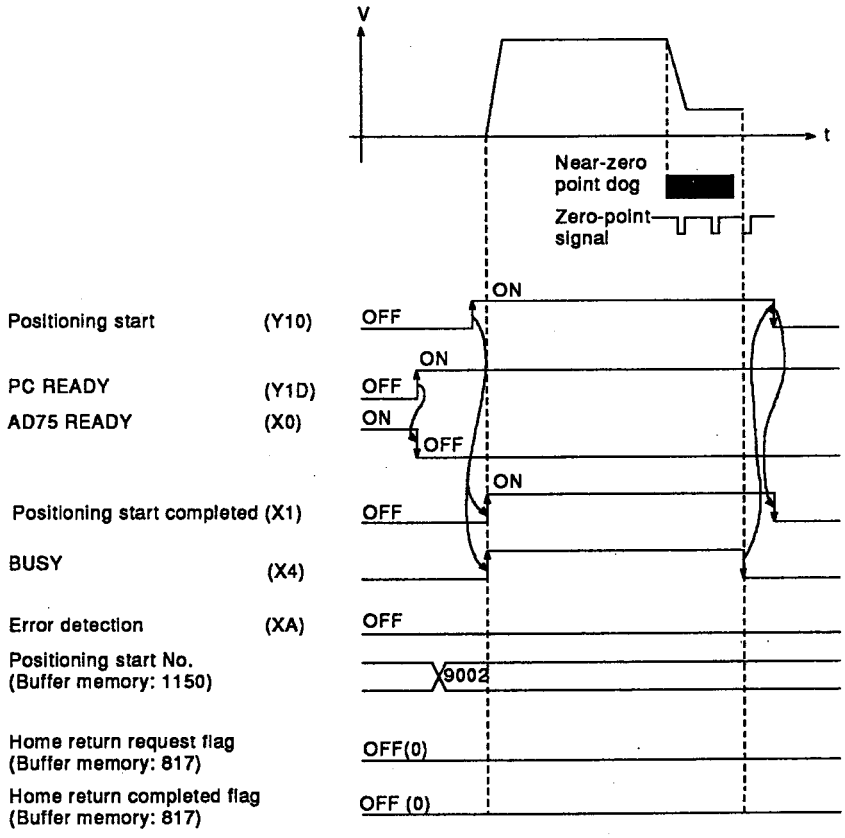
(2) Program example

- The program in this example requests a high-speed home position return start for the first axis.

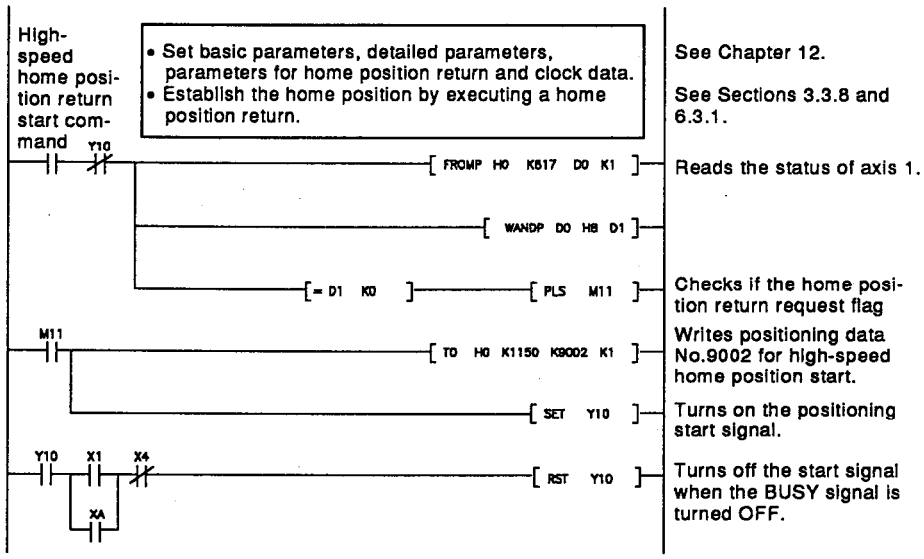
(a) Data transfer



(b) I/O signals



(c) Program



POINTS

(1) The only difference between a 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.

6.3.3 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.

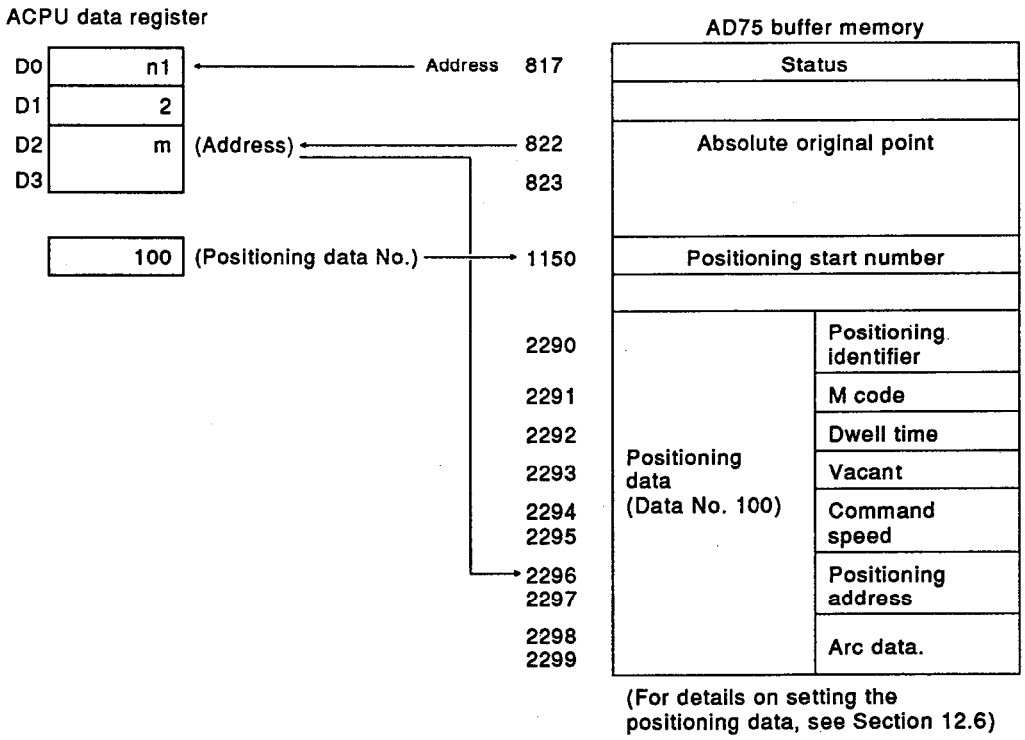
  Data No. 1 to 100 : Registered at the ACPU or the AD75P.
  Data No. 101 to 600 : Registered at the AD75P.

- Only start the program when the absolute home position overflow flag and underflow flag are OFF.

(2) Program example

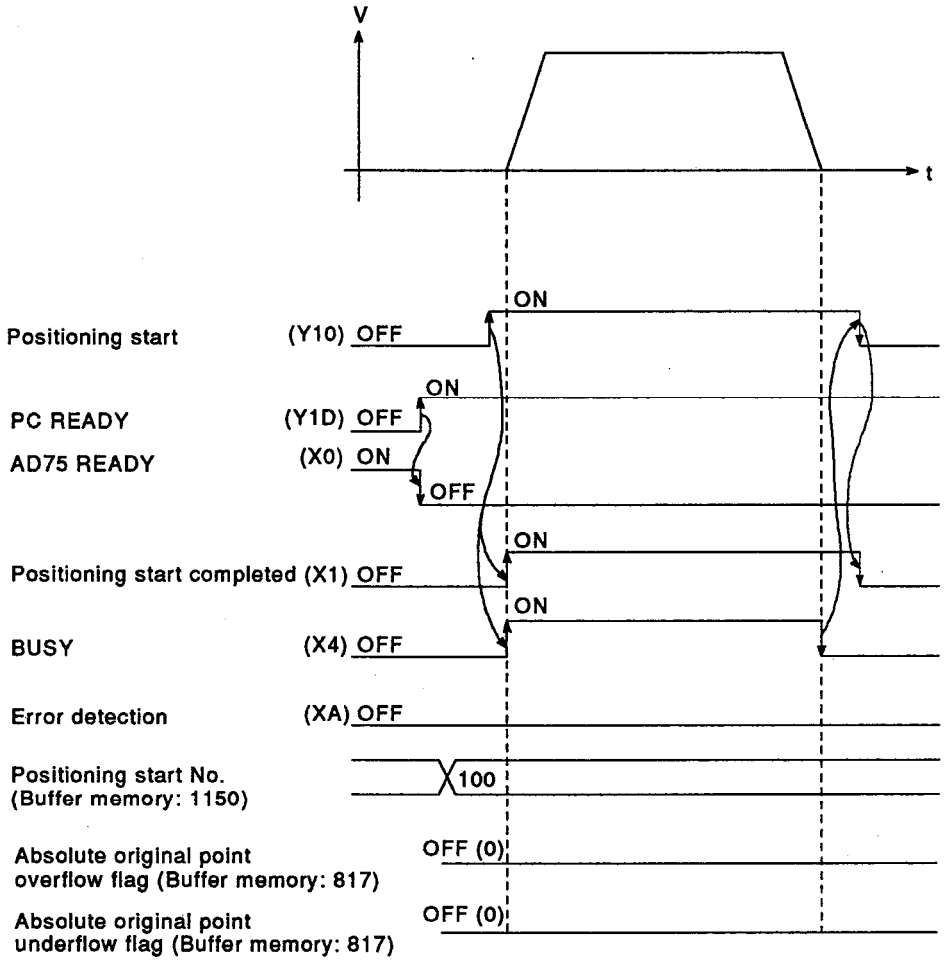
- The program in this example requests a high-speed machine home position return for axis 1 using data No.100.
  The value in the absolute home position storage area of the buffer memory is used for the positioning address of positioning data No. 100.

(a) Data transfer

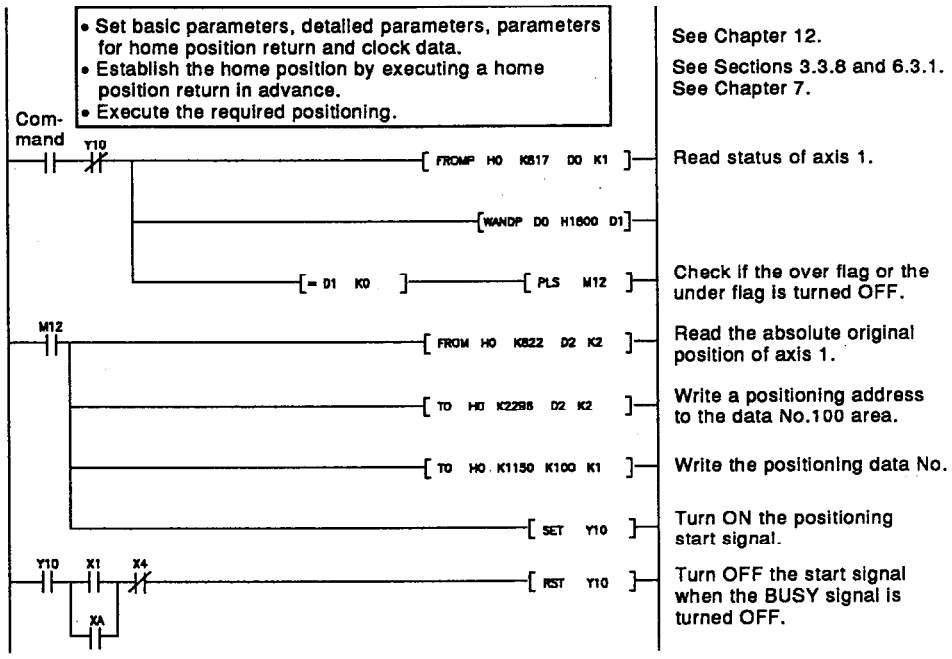


(For details on setting the positioning data, see Section 12.6)

(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)

(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.

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.

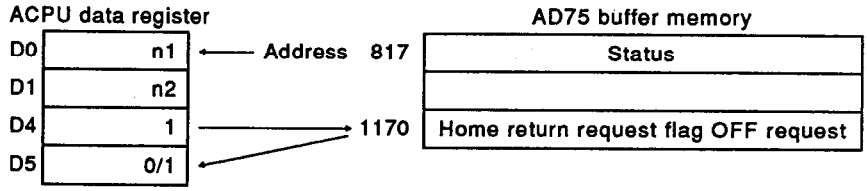
(1) Conditions

- Execute the program each time the home position return request flag (bit 3) is turned ON.

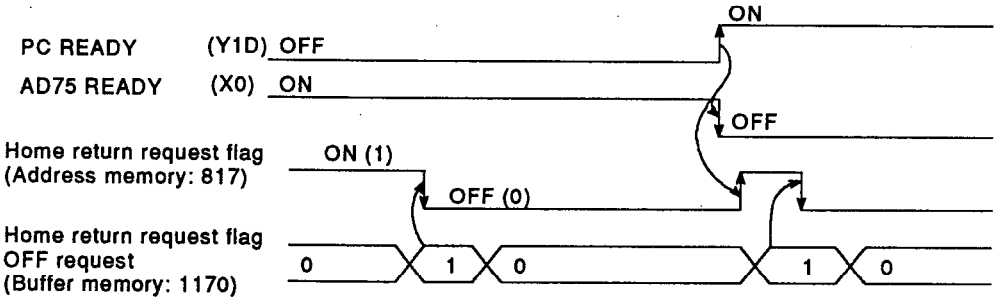
(2) Program example

- The program in this example forces the home position return request flag for axis 1 OFF.

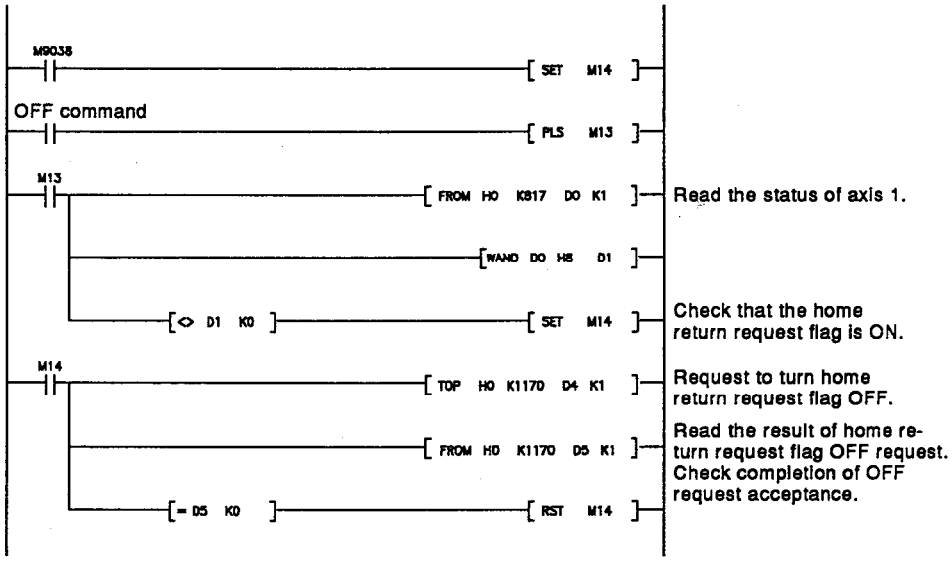
(a) Data transfer



(b) I/O signals



(c) Program



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.

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.

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 Values: AD75P	Sequence Program Setting Method
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.				

(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 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) 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)

(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 values: AD75P	Sequence Program Setting Method
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.

(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.				

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

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 Axis 1	Axis 2	Axis 3	Description of Monitor Item	References
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.	

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.)	

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

7.3 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.

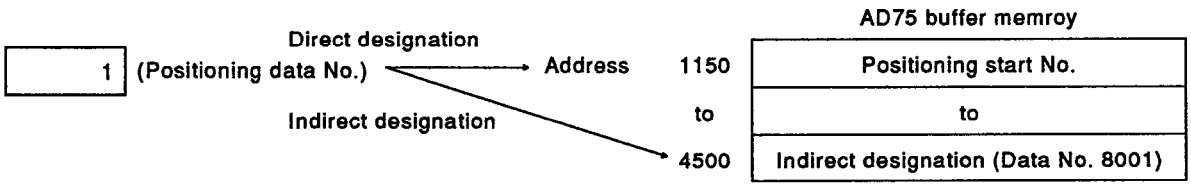
(1) Conditions

- 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

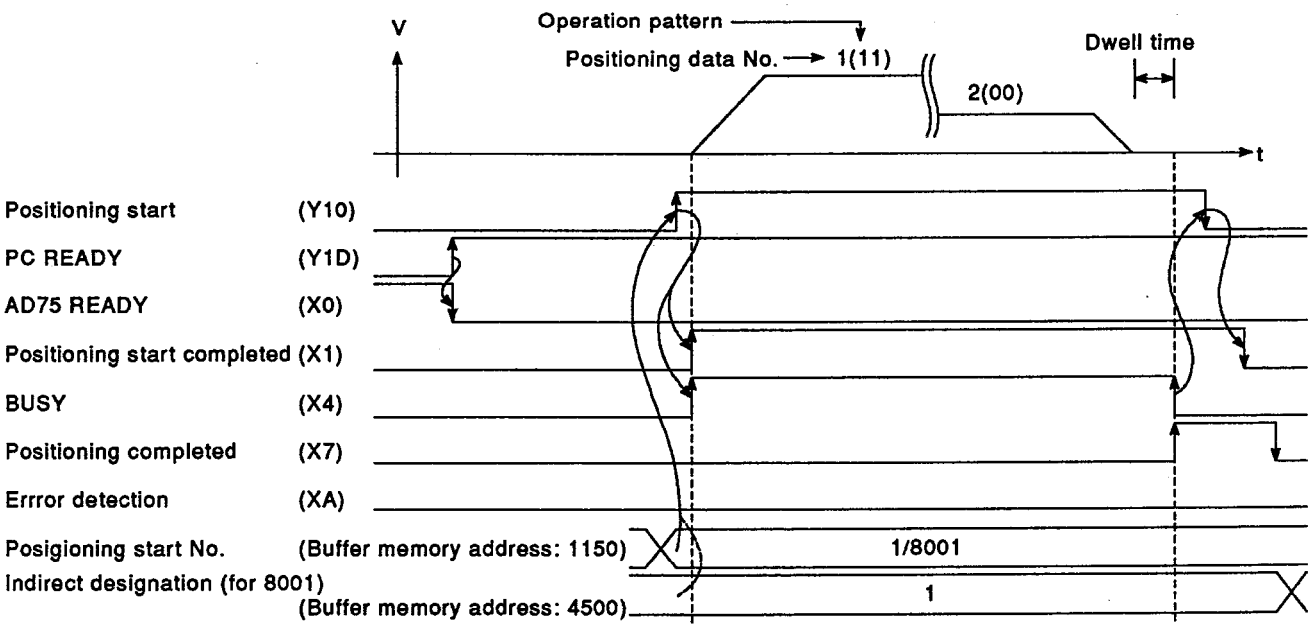
- The program shown here sets positioning data No. 1 and starts positioning on the axis 1.

(a) Data transfer



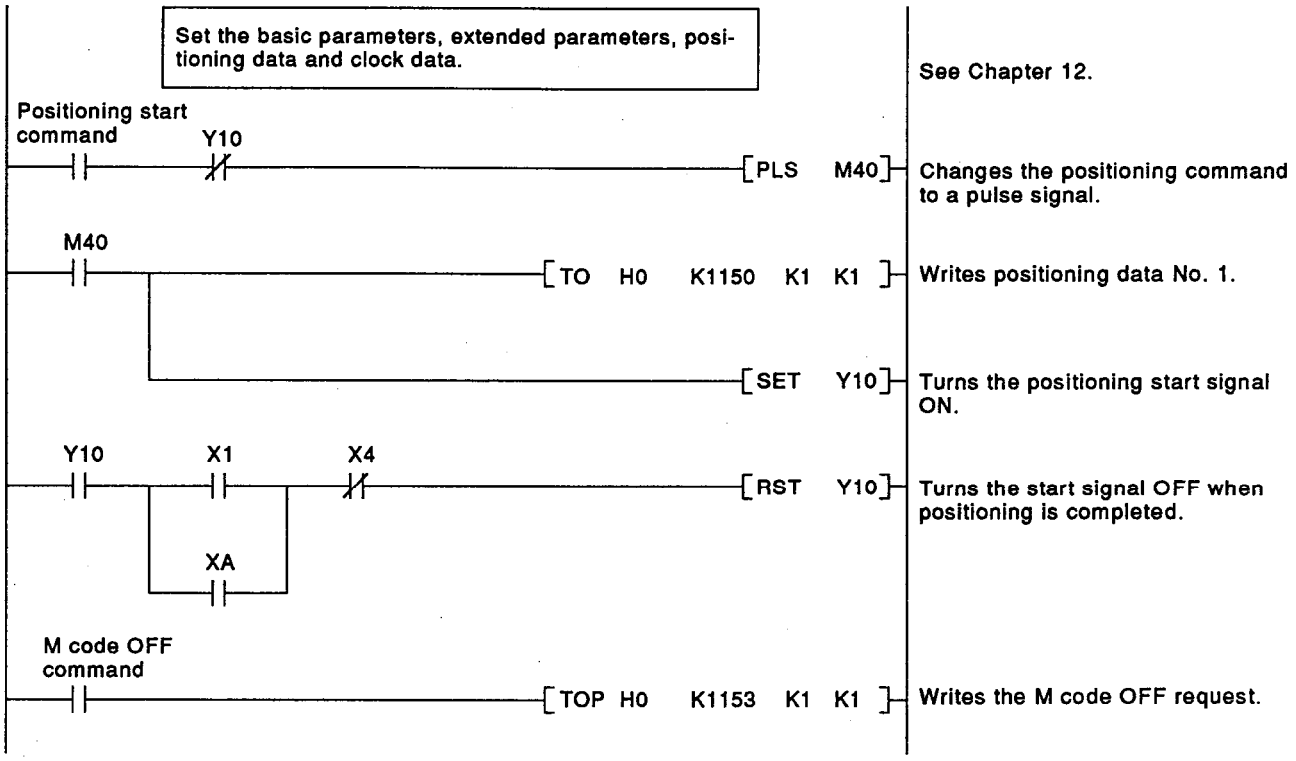
(For details on start numbers, see Section 3.4.5)

(b) I/O signals



(c) Program

1) When the positioning data No. is designated directly



POINTS

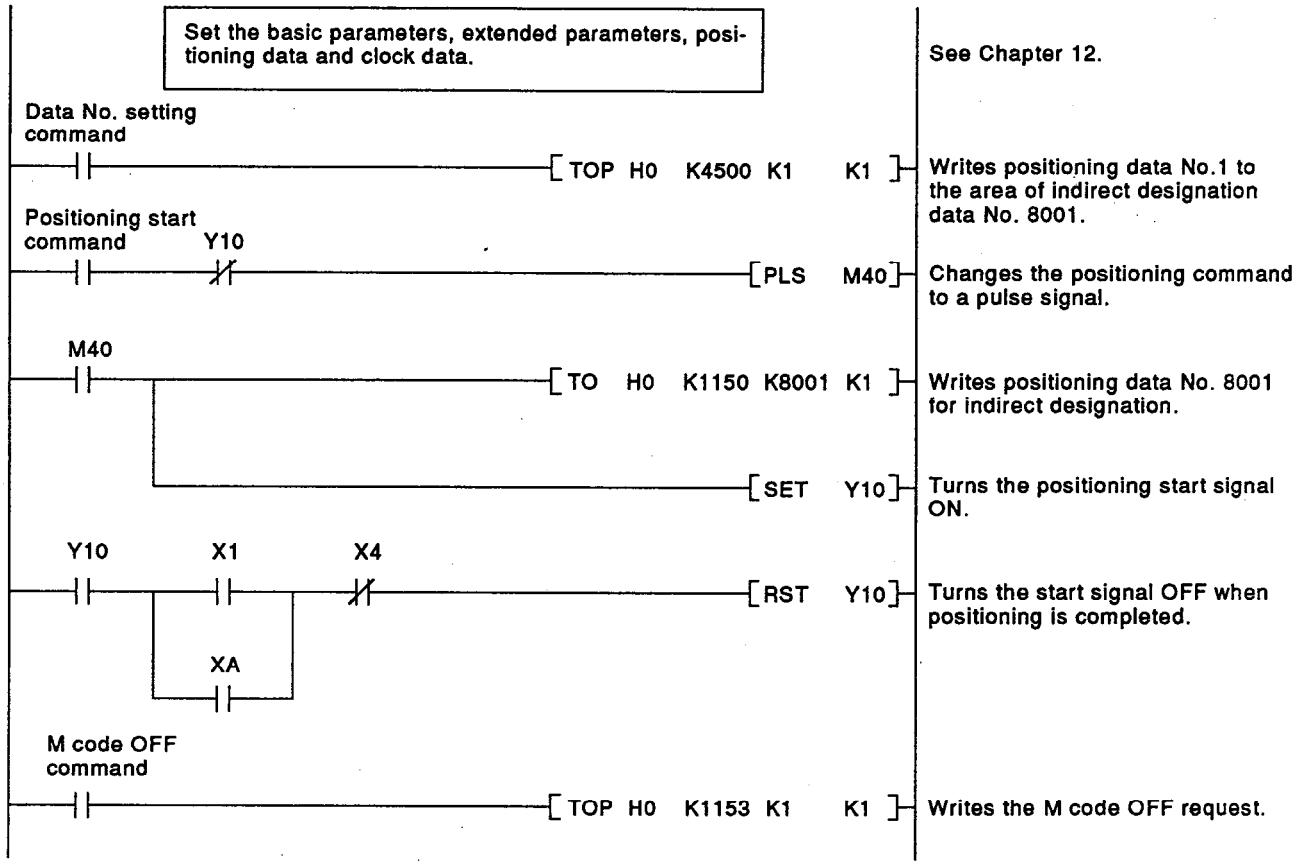
(1) Before carrying out positioning, check the positioning operation and restrictions on setting positioning data by referring to Sections 3.3.1 to 3.3.7.

(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.

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.

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.

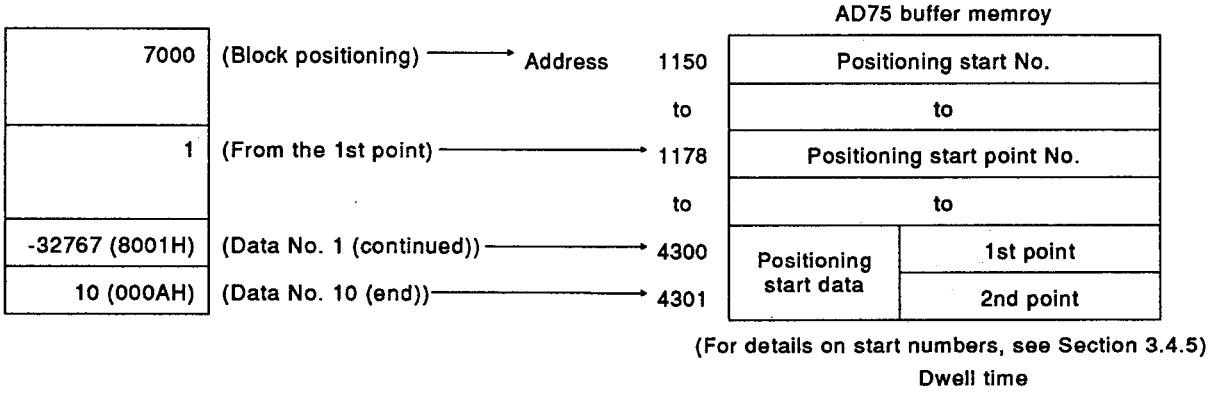
(1) Conditions

- 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.

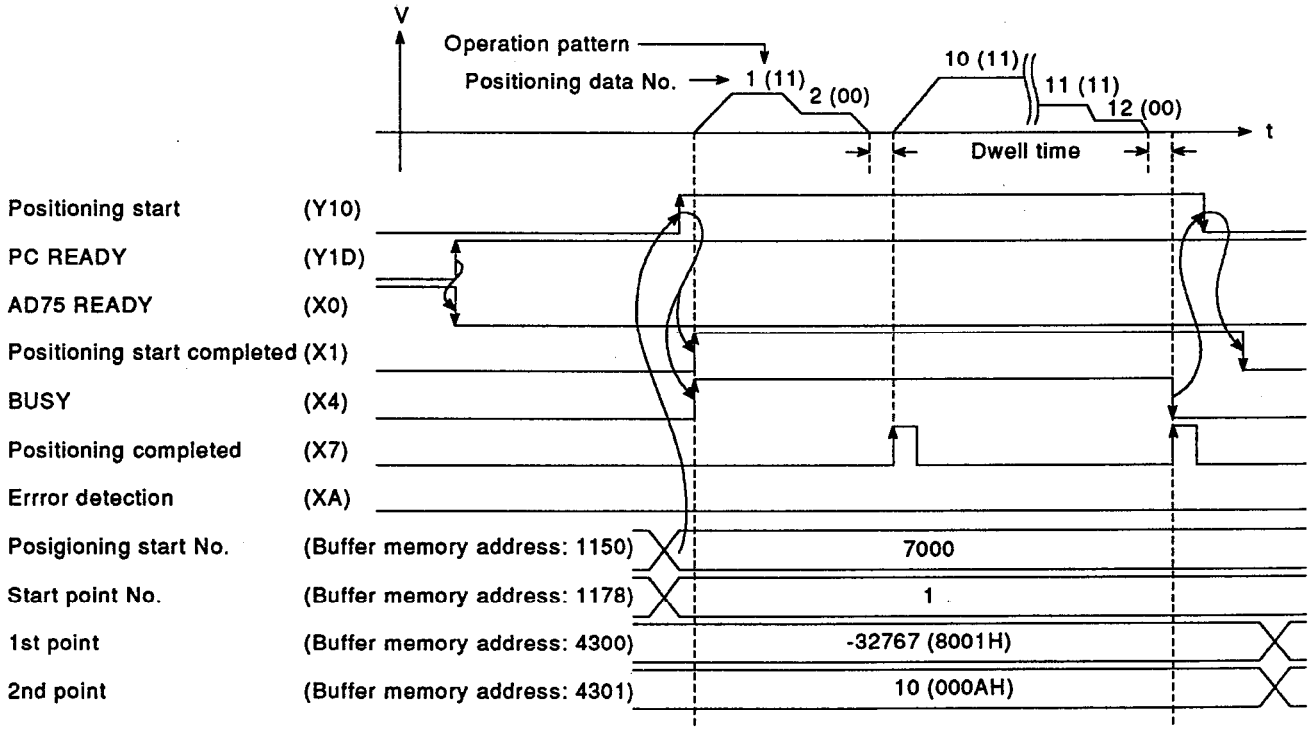
(2) Program example

- 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.

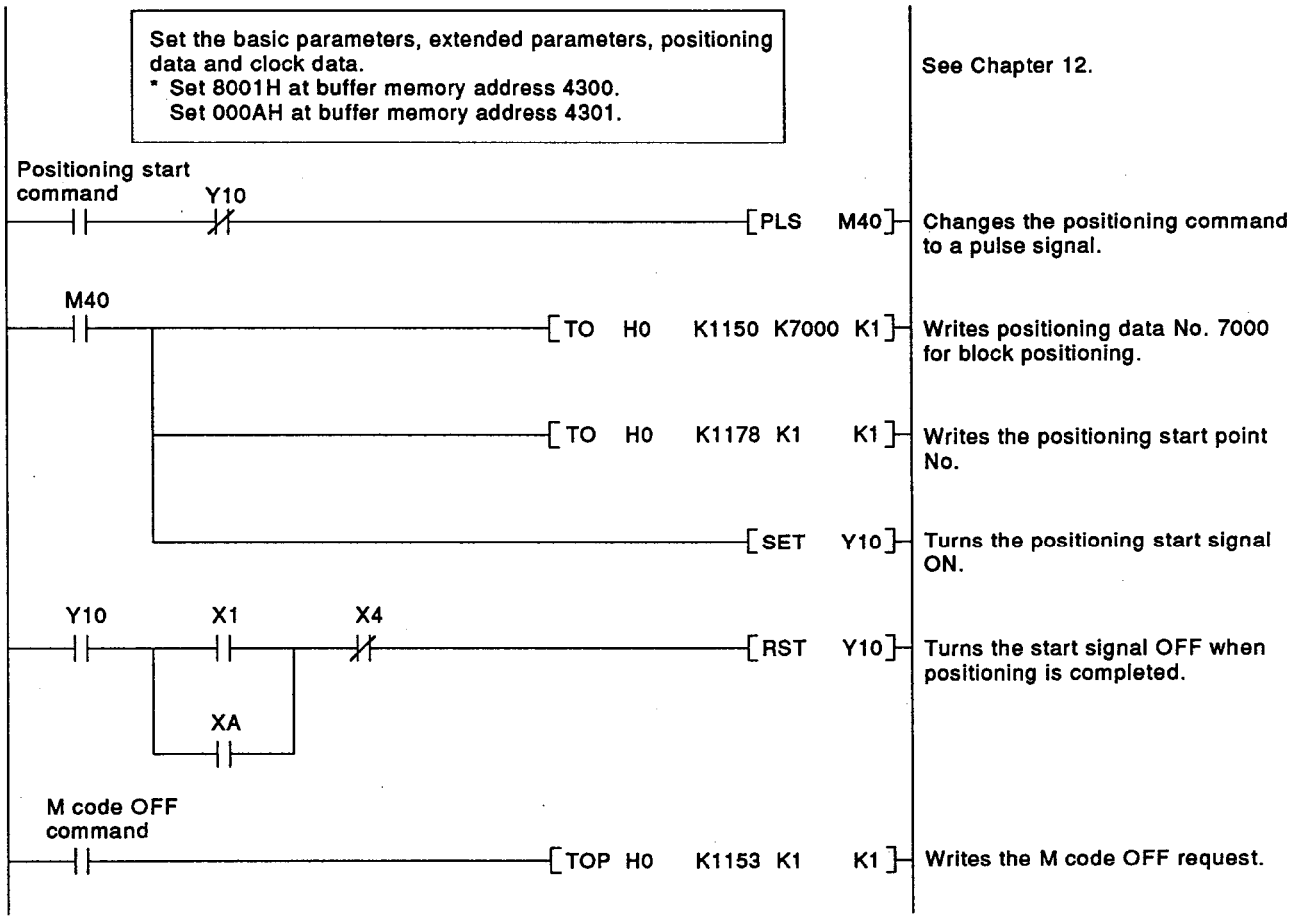
(a) Data transfer



(b) I/O signals



(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.

7.3.3 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.

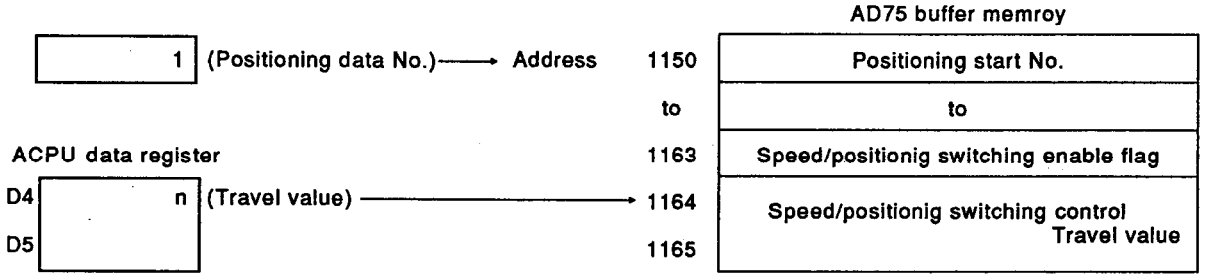
(1) Conditions

- 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

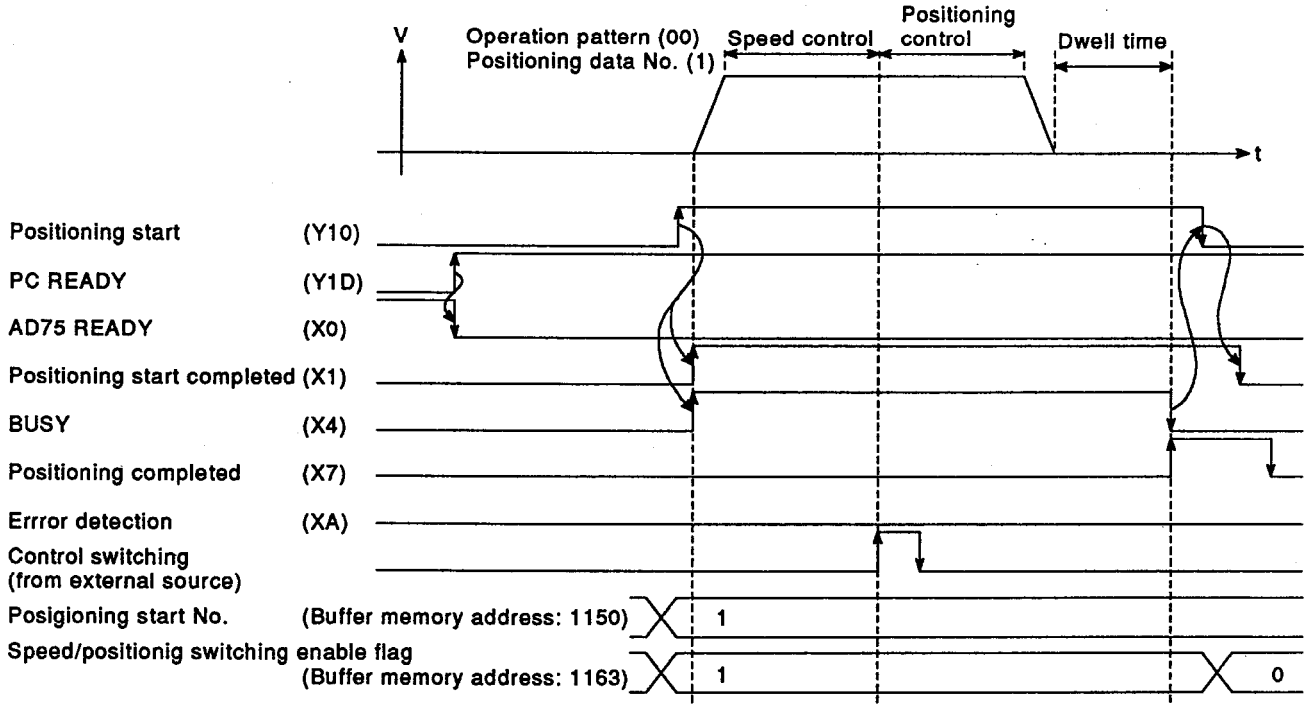
- The program shown here sets positioning data No. 1 and starts positioning for the first axis 1.

(a) Data transfer

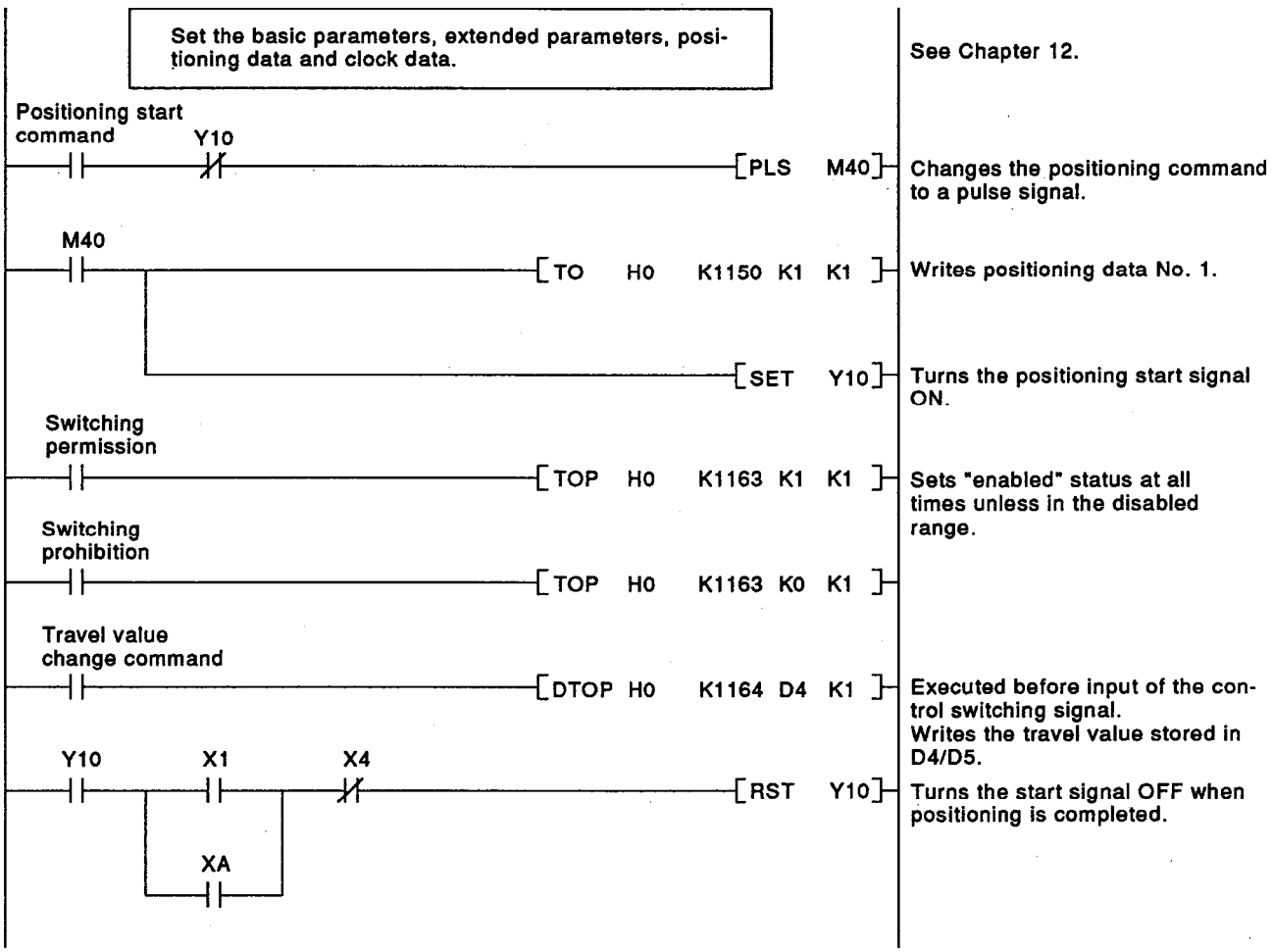


(For details on start numbers, see Section 3.4.5)

(b) I/O signals



(c) Program



POINTS

(1) Before carrying out positioning, check the positioning operation and restrictions on setting positioning data 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.

7.3.4 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.

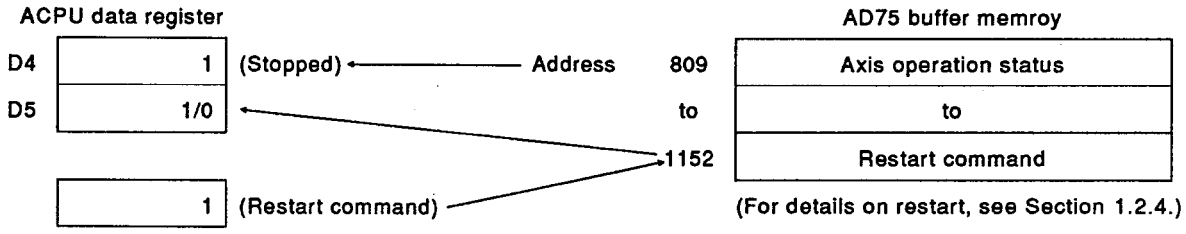
(1) Conditions

- 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.

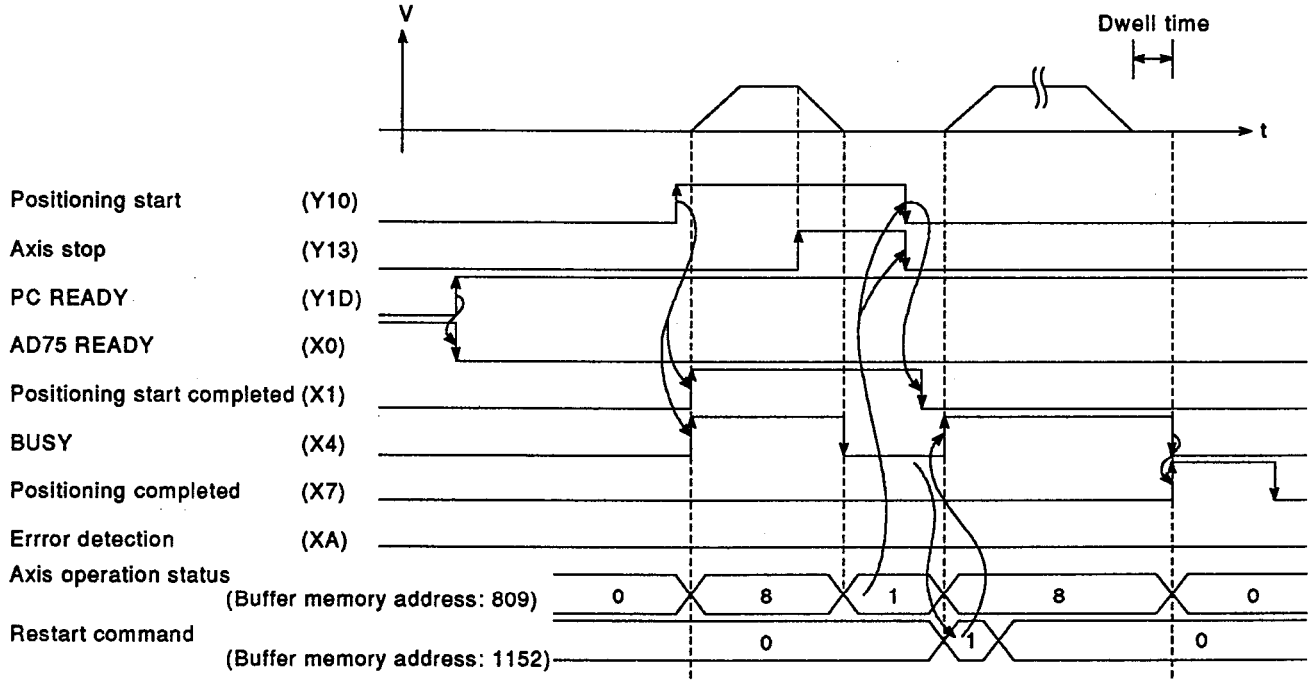
(2) Program example

- The program shown here restarts positioning for the axis 1, which is in the stopped status.

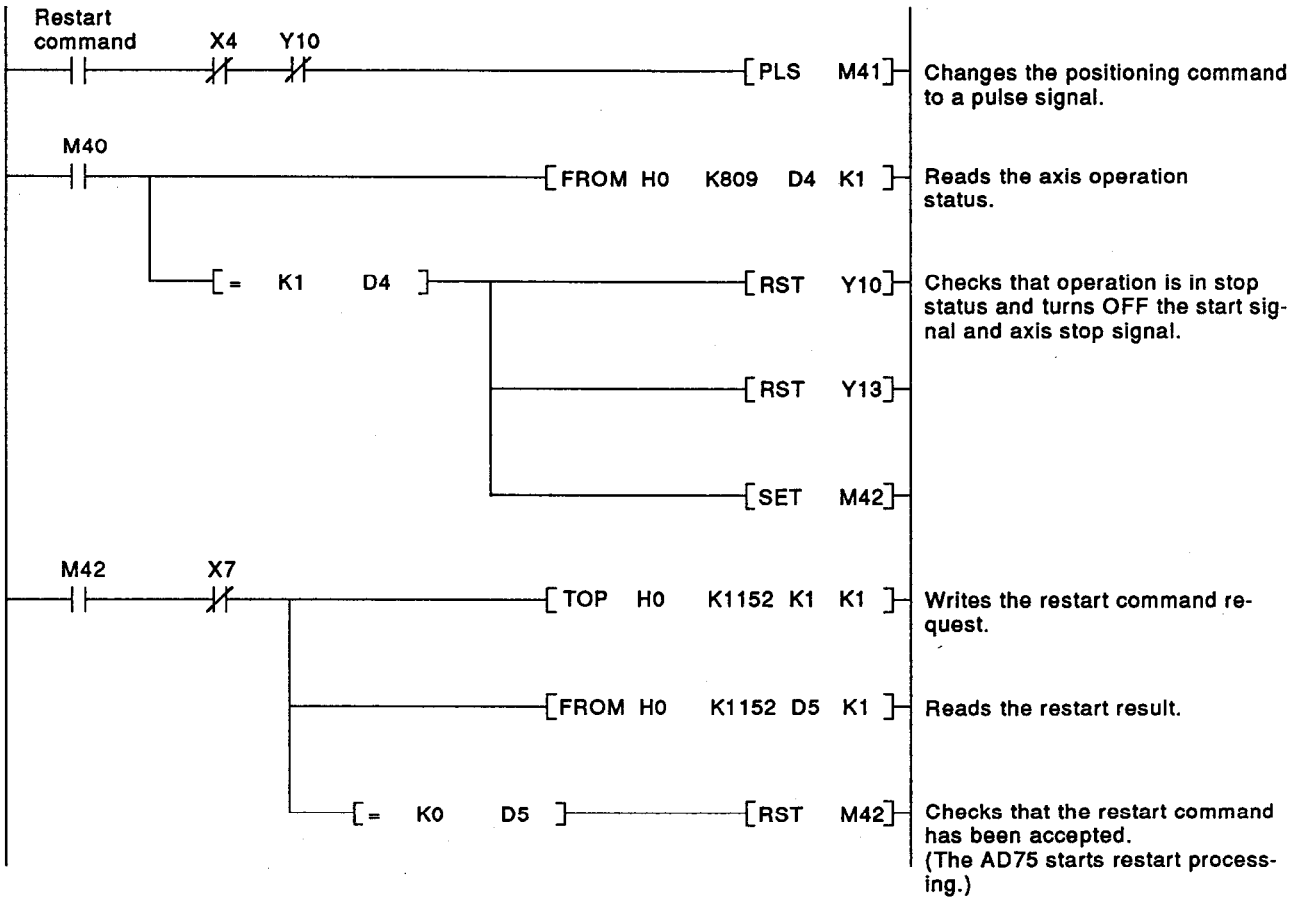
(a) Data transfer



(b) I/O signals



(c) Program



POINTS

(1) 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.

7.3.5 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.

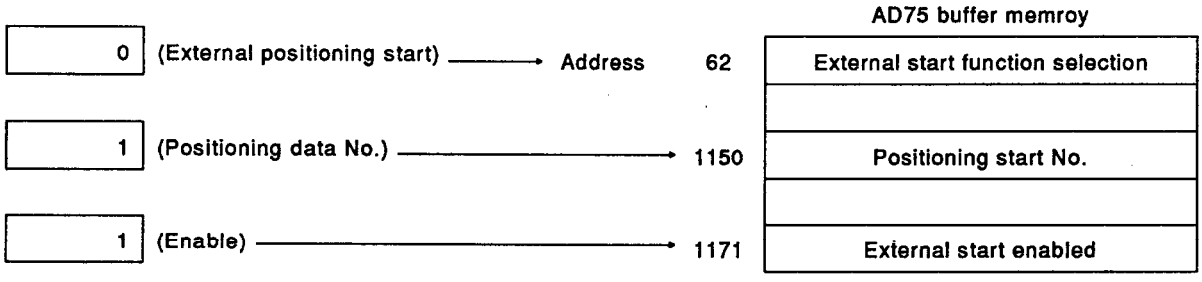
(1) Conditions

- 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

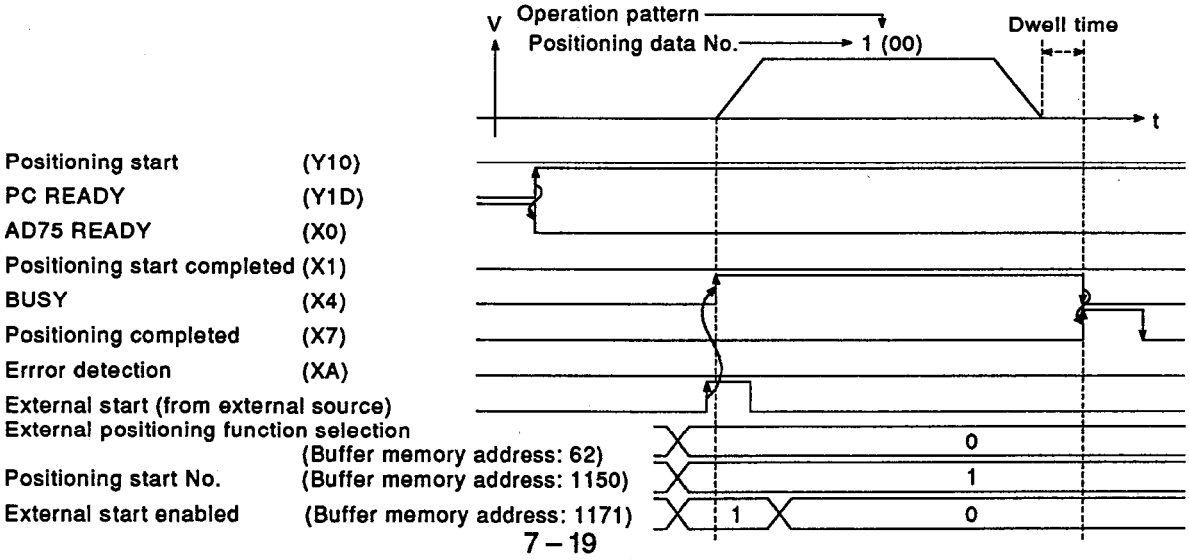
- The program shown here executes an external positioning start for the axis 1, which is in the stand-by status.

(a) Data transfer

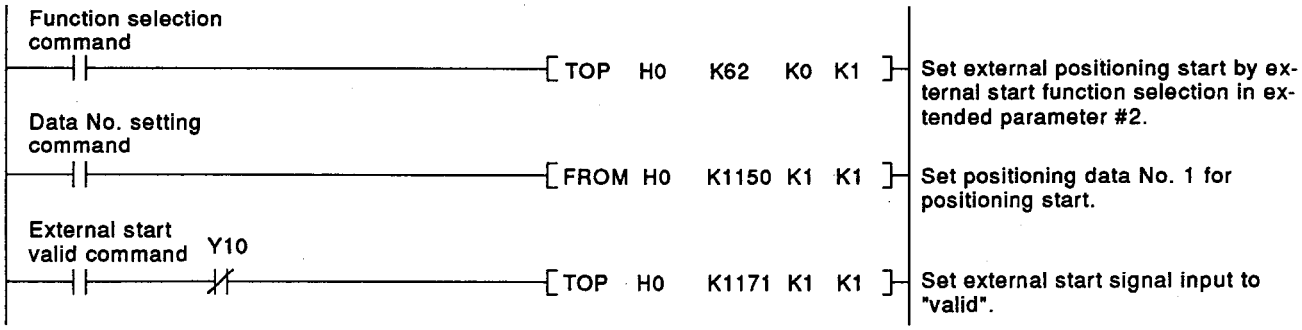


(For details on the set values refer to the sections for respective areas.)

(b) I/O signals



(c) Program



POINTS

(1) 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.

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.)

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.				

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.

8.2 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.	

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.

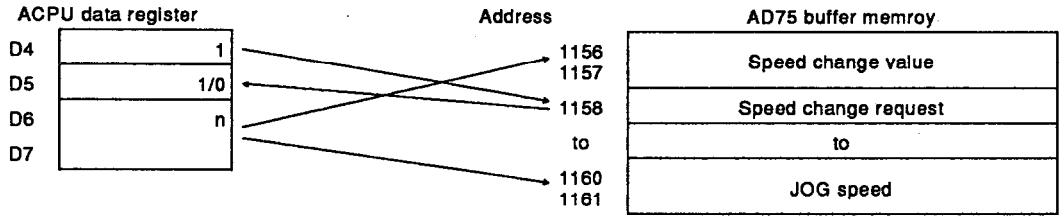
(1) Conditions

- 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

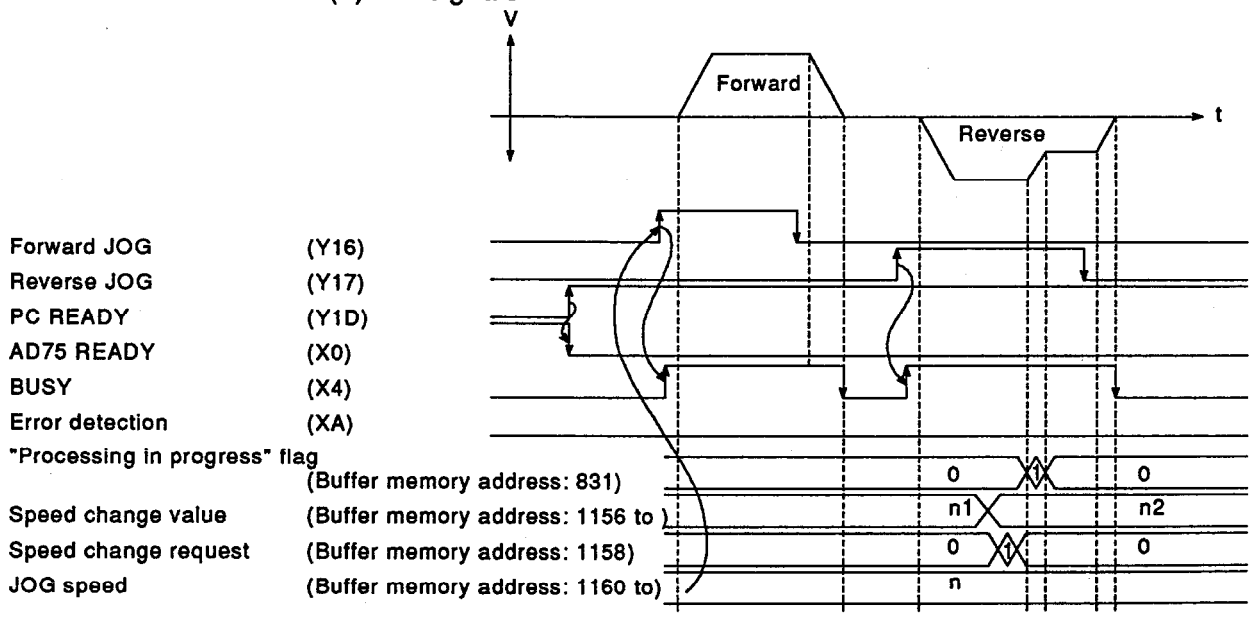
- A JOG operation request for the axis 1 is shown.

(a) Data transfer



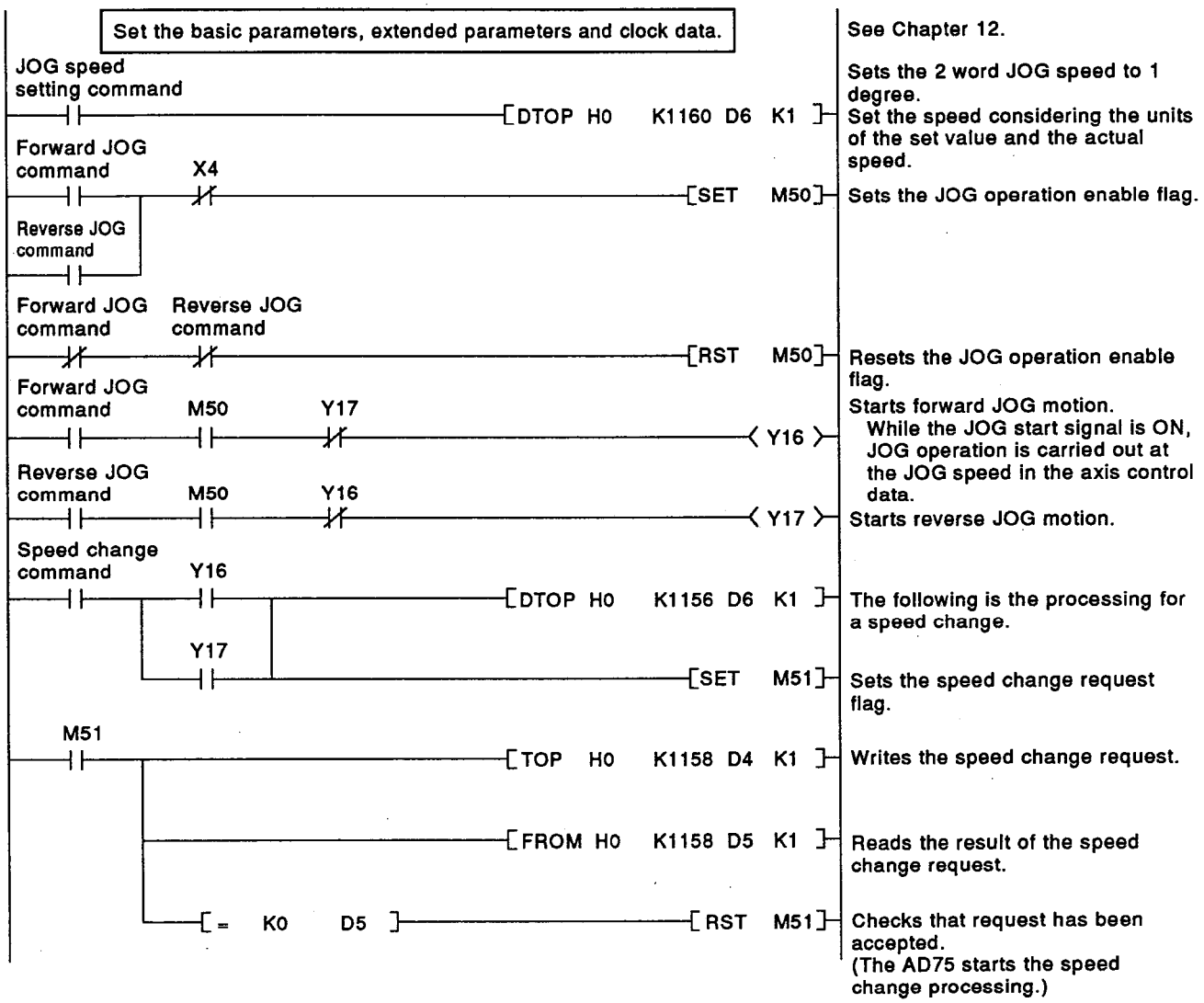
(See Section 3.6.4 for details on JOG speed.)

(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.

(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.

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.

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 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 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.)				

9.2 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.	

9.3 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.

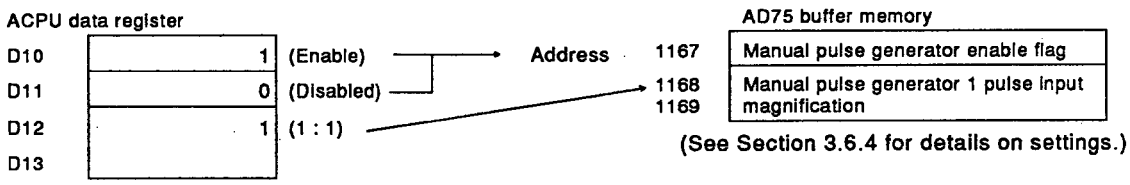
(1) Conditions

- Set the basic parameters and extended parameters.
- Set the clock data as required.
- Carry out the pre-processing when the BUSY signal is OFF.

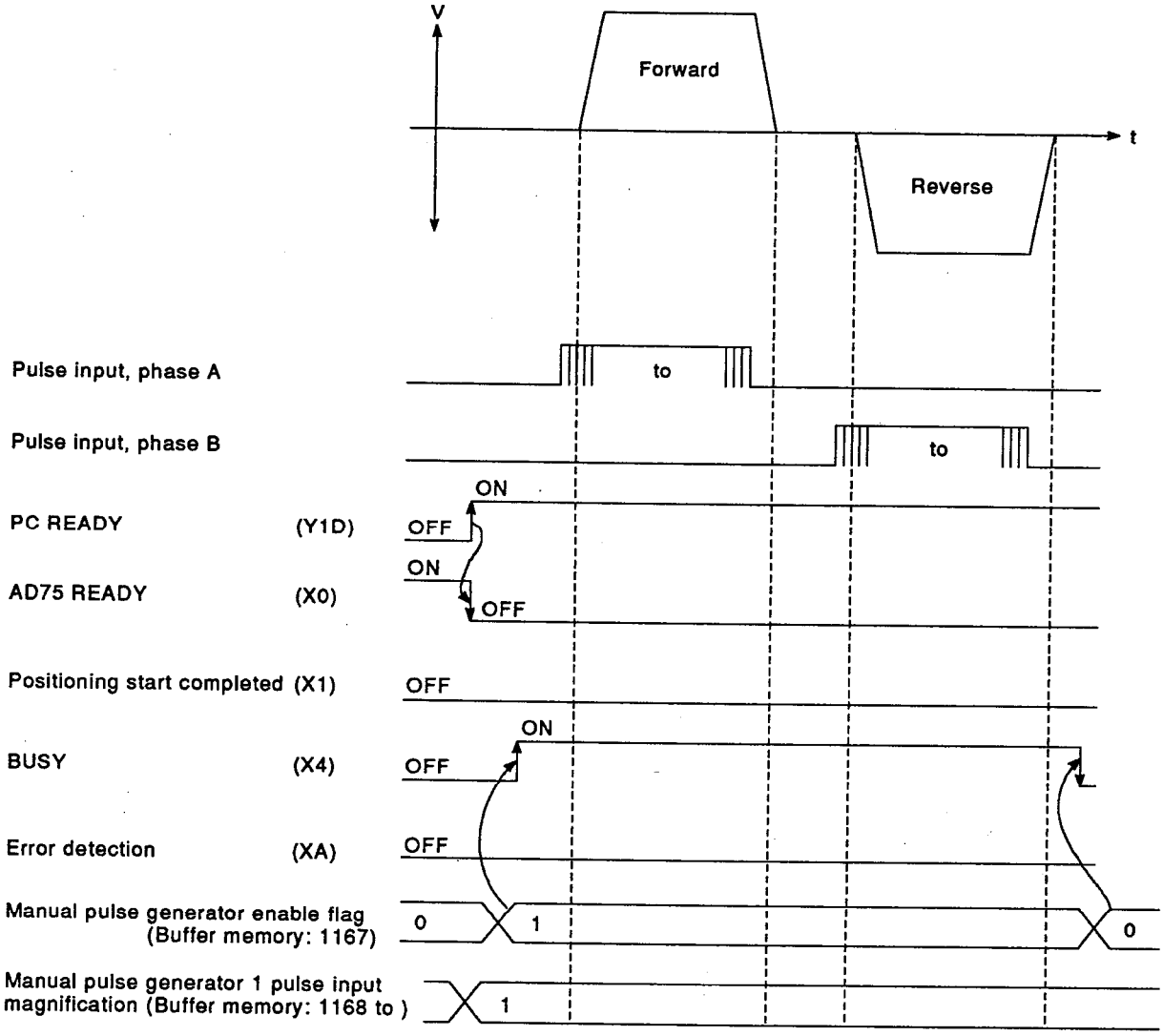
(2) Program example

- The program shown below executes the pre/post-processing for a manual pulse generator operation at axis 1.

(a) Data transfer



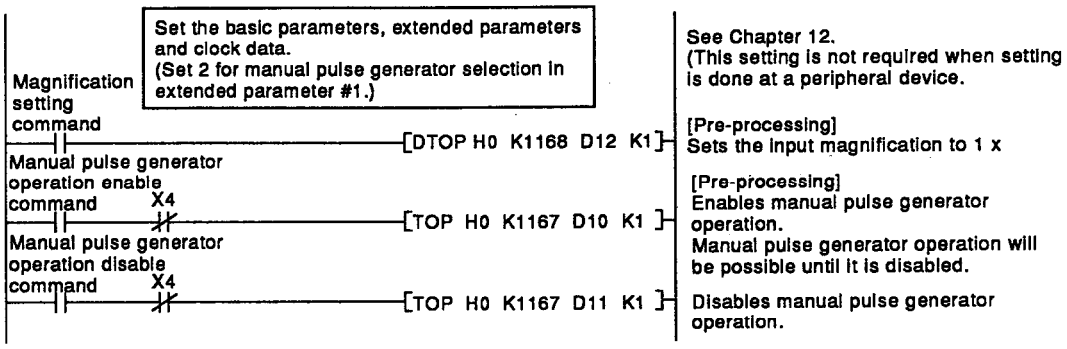
(b) I/O signals



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.

(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.

[Travel value] = (Number of input pulses) x (Manual pulse generator 1 pulse input magnification setting) x (Travel value per pulse)

[Output speed] = (Number of input pulses per control cycle time) x (Manual pulse generator 1 input magnification setting) x (Travel value per pulse)

(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.

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.

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.

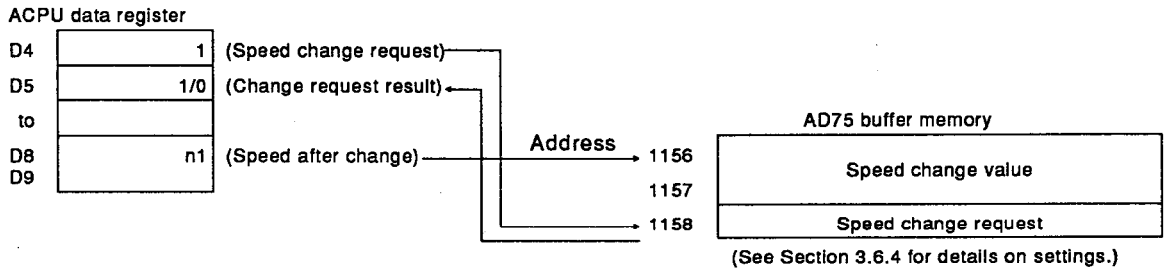
(1) Conditions

- Set a speed change value before issuing a speed change request.

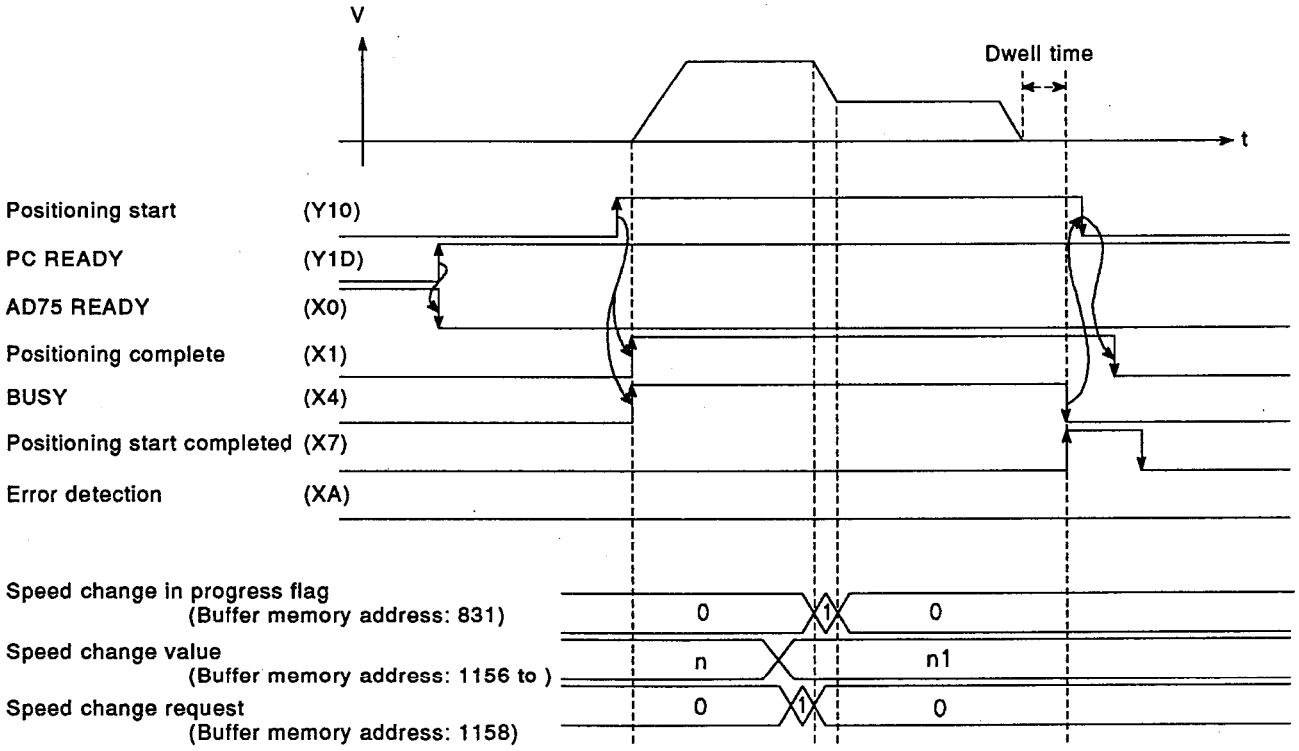
(2) Program example

- The program shown here issues a speed change request for axis 1.

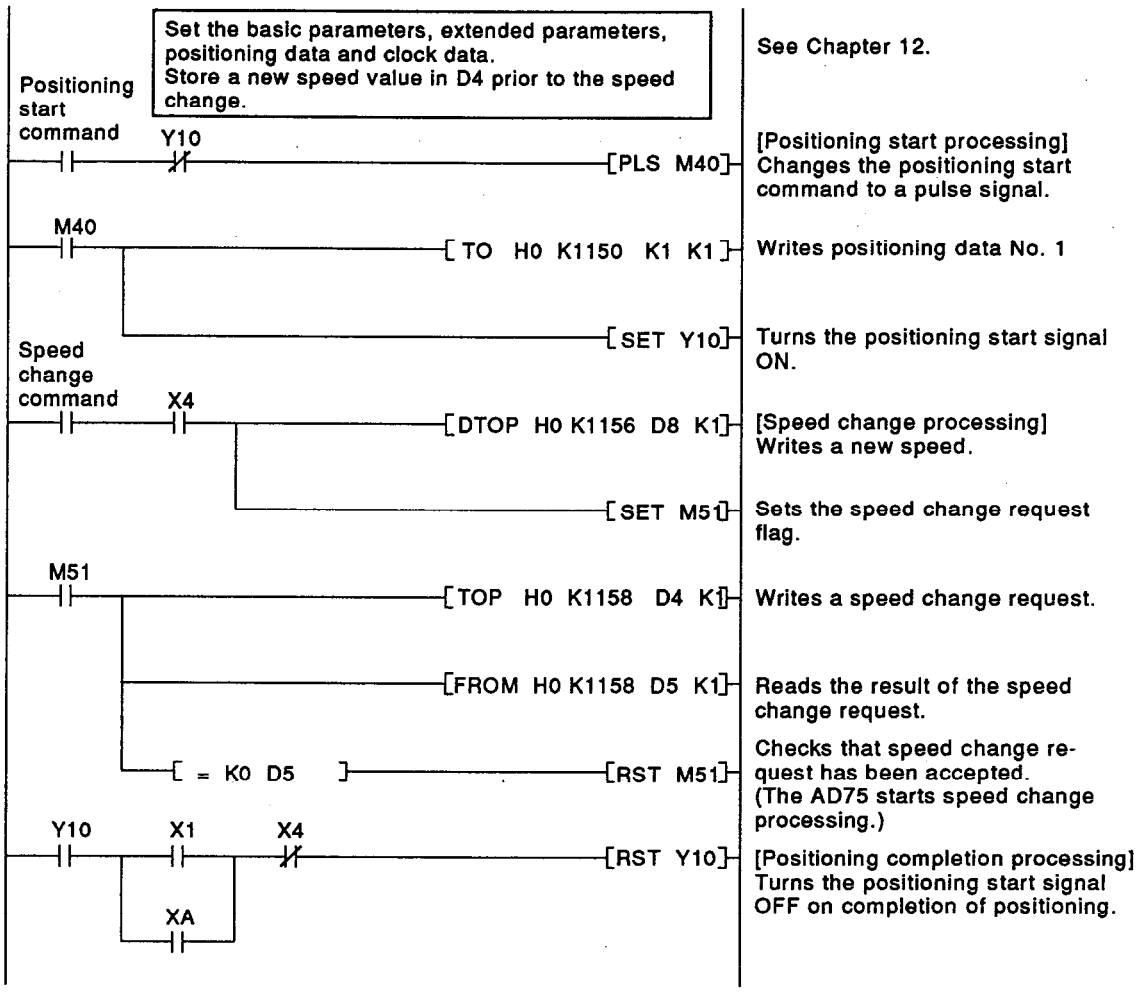
(a) Data transfer



(b) I/O signals



(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.

10.1.2 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.

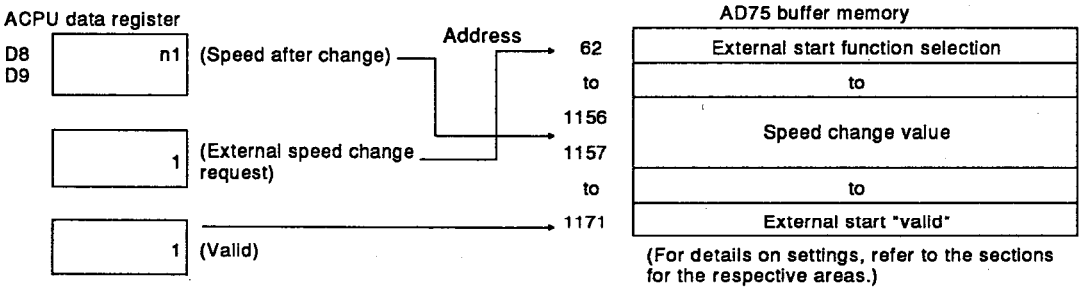
(1) Conditions

- 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.

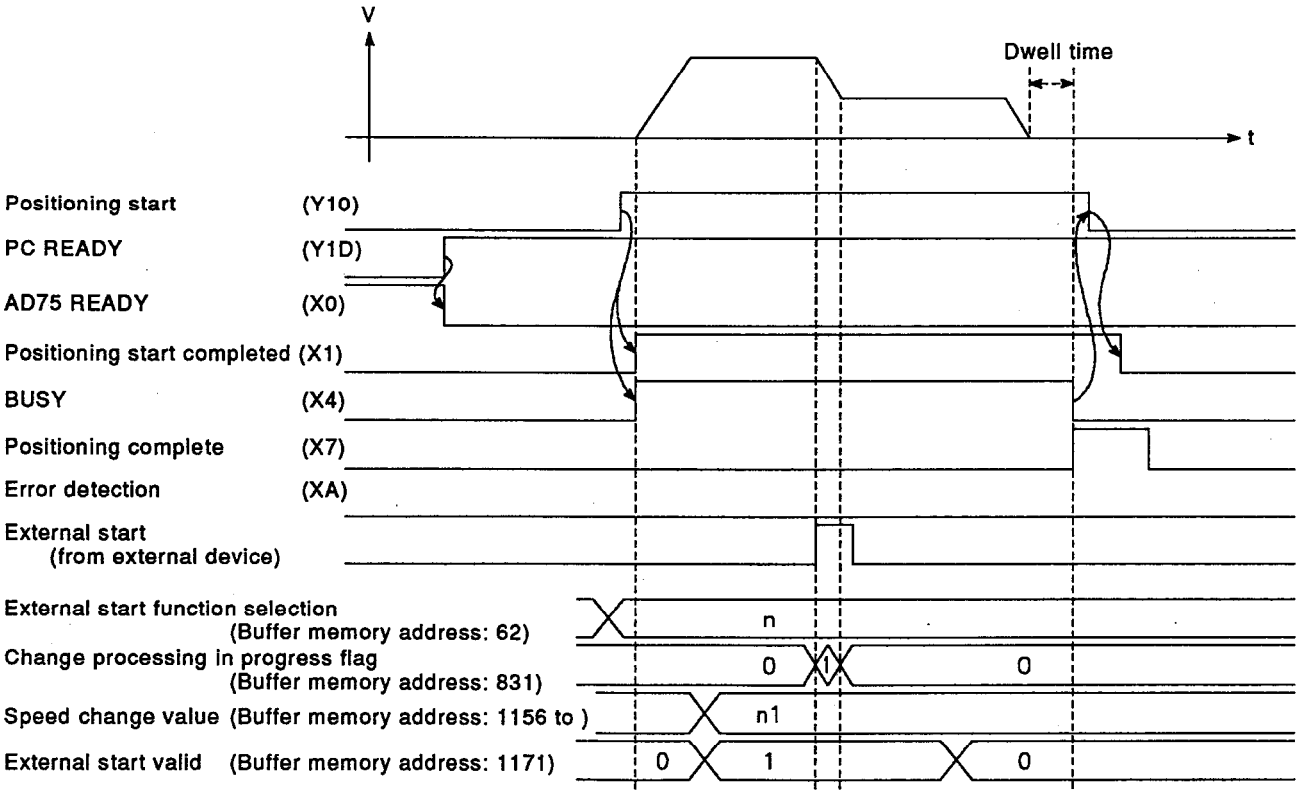
(2) Program example

- The program shown here issues a speed change request from an external device to axis 1.

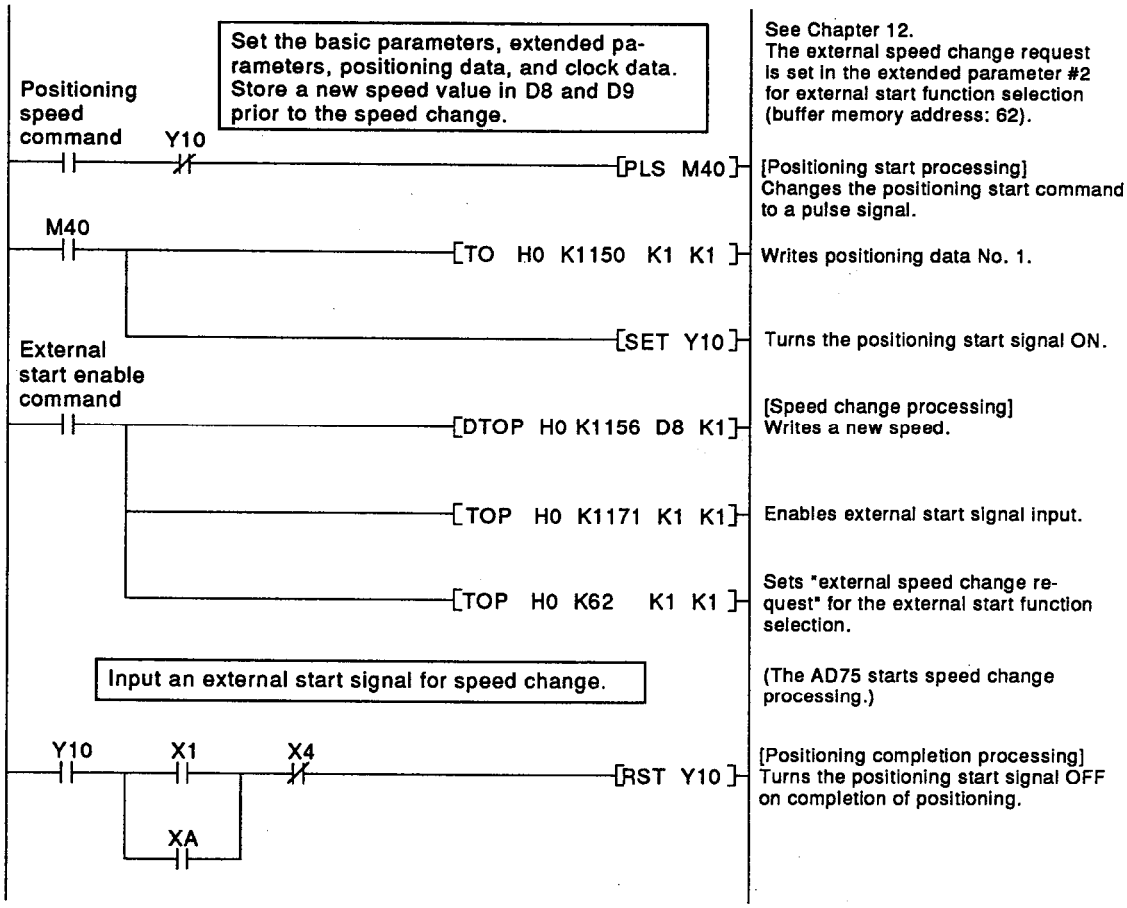
(a) Data transfer



(b) I/O signals



(c) Program



POINTS

(1) 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.

10.2 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

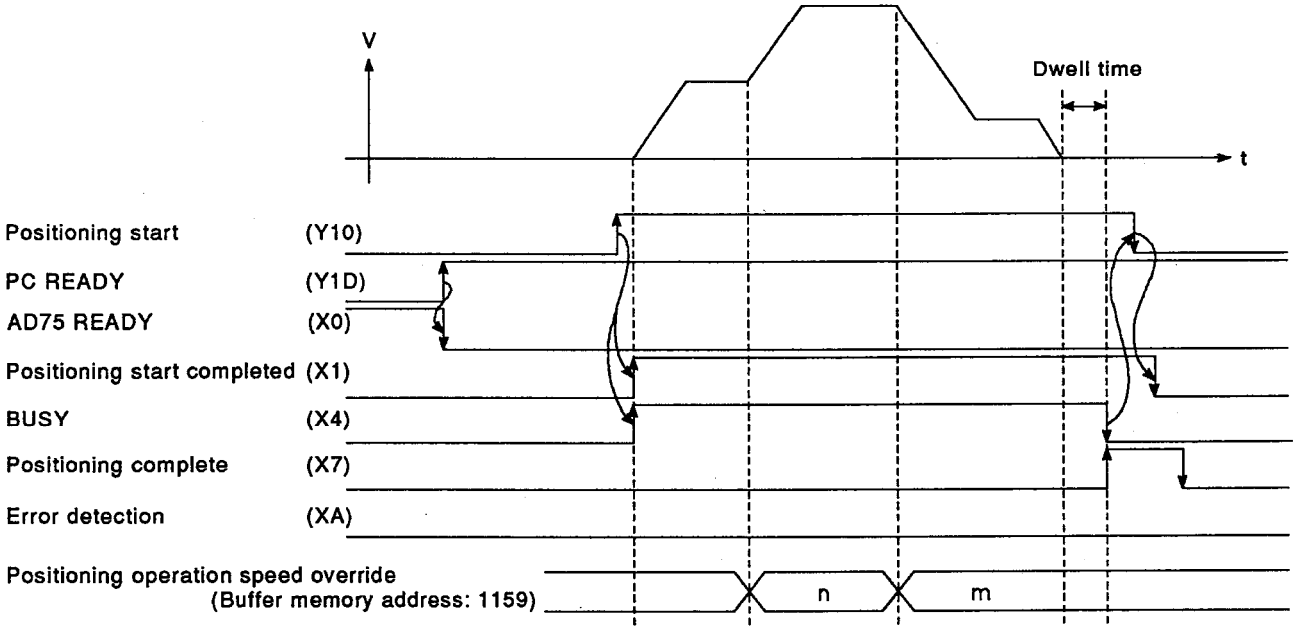
- Set a positioning speed override value during positioning.

(2) Program example

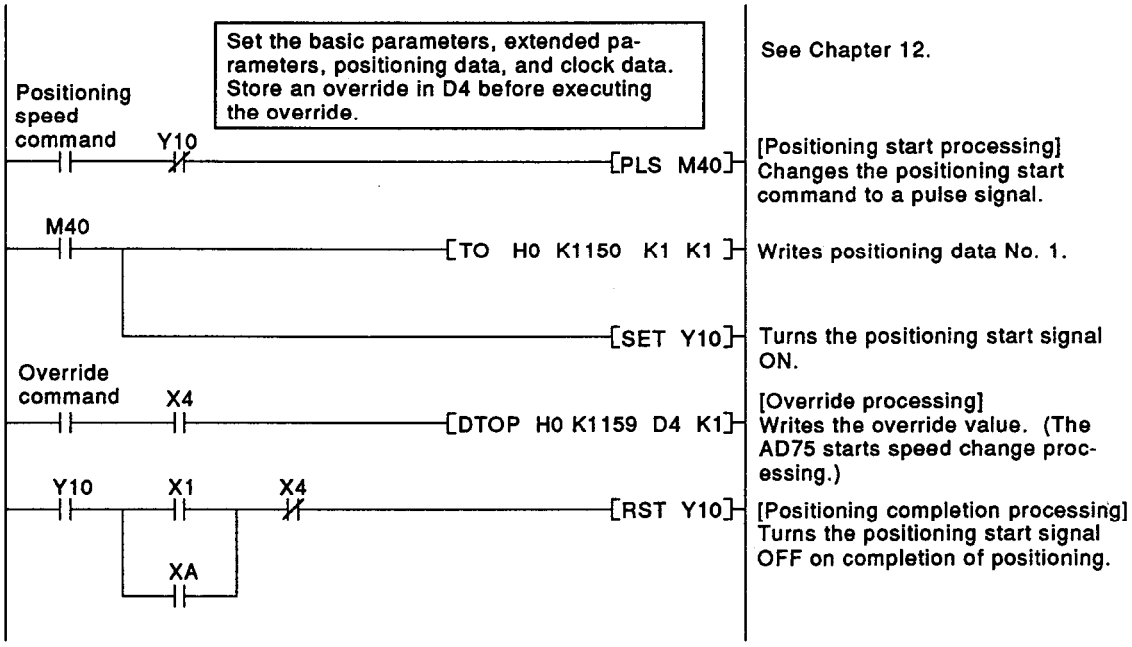
- The program shown here changes the positioning speed of axis 1.

(a) Data transfer

(b) I/O signals



(c) Program



POINTS

(1) 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.

MEMO

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

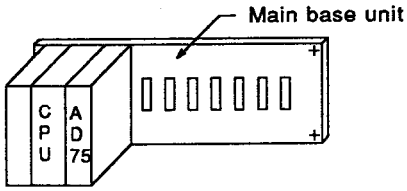
1) *1: The positioning start number area is located at the following buffer memory addresses. (See Section 3.6.4.)

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/Y00H to X/Y1FH
(when the AD75 is loaded at slot 0 of the main base unit)



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.

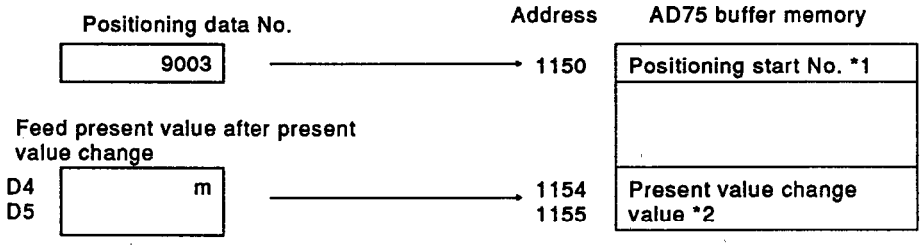
(1) Condition

- Set a new present value in the present value change value area prior to present value change.

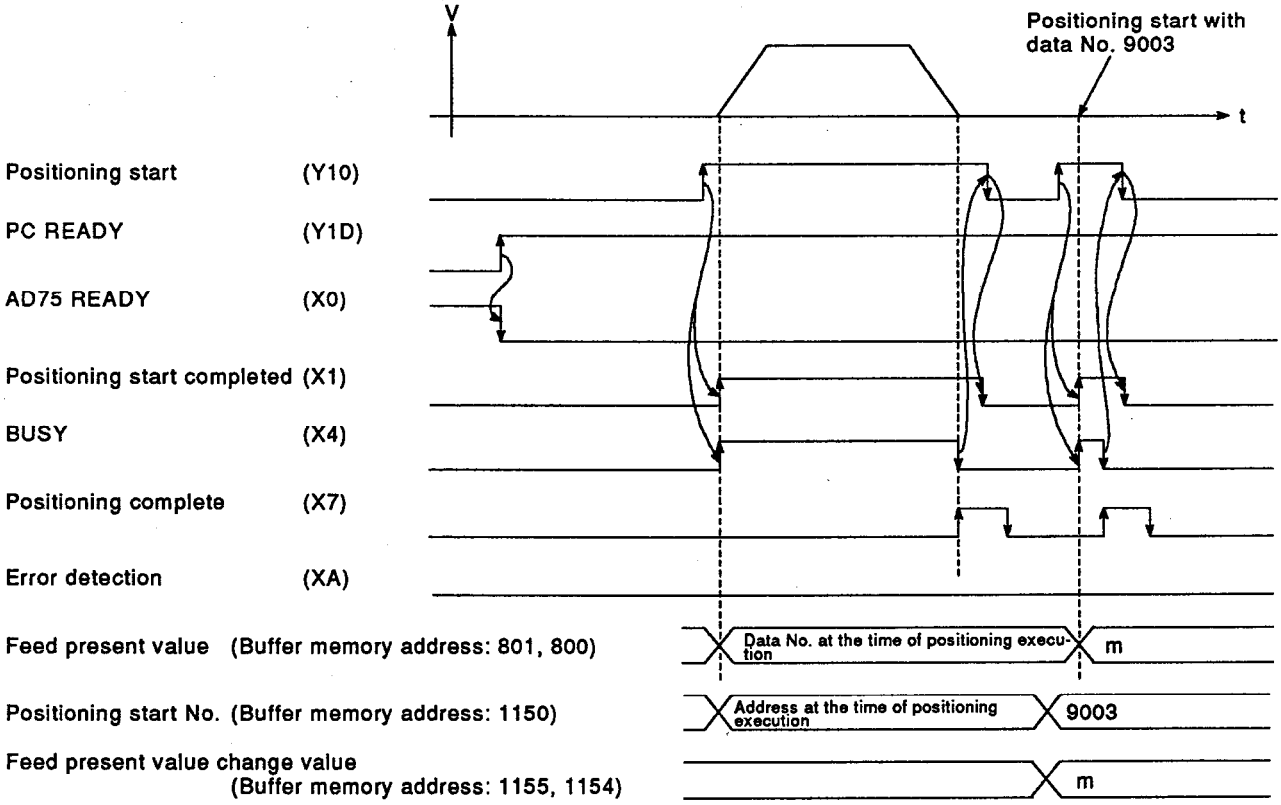
(2) Program example

- The program shown here changes the present value of axis 1.

(a) Data transfer



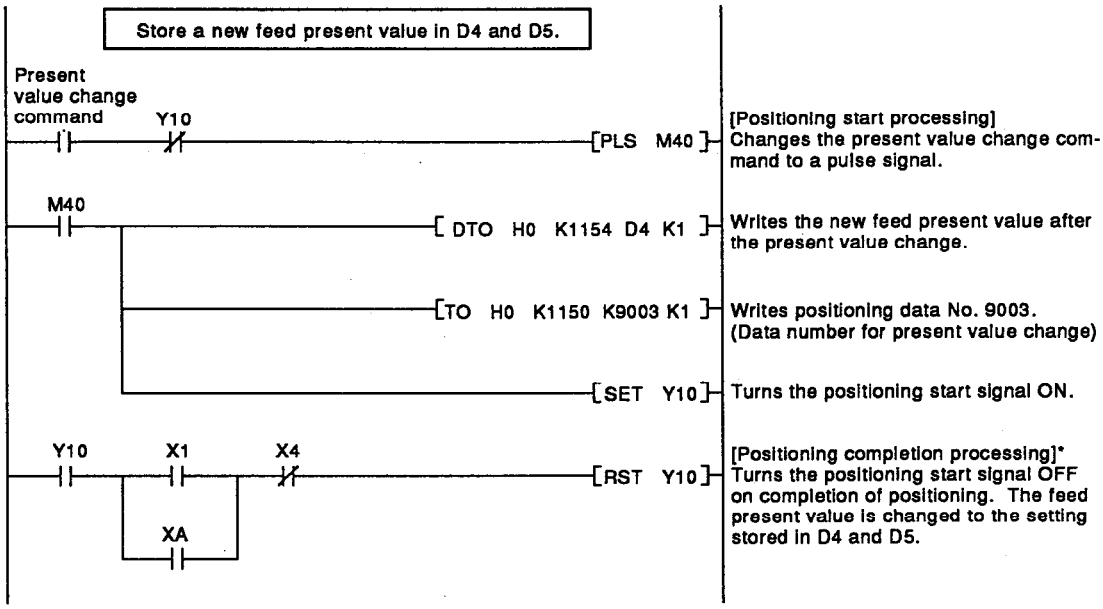
(b) I/O signals



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.

(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.

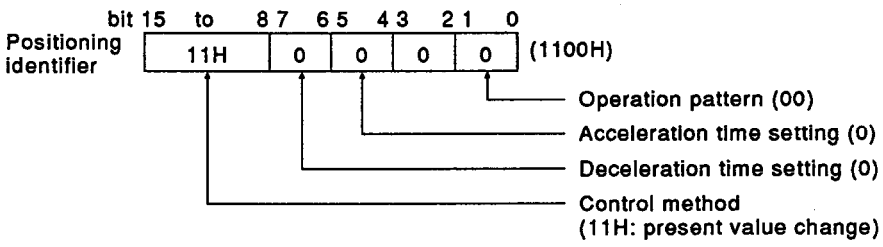
(4) A new present value outside the stroke limit range does not cause an error.
However, an "operation start outside software stroke limit range" error will occur at the beginning of the following positioning.

11.2 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 1100H (present value change) is set as the control method of the positioning identifier.

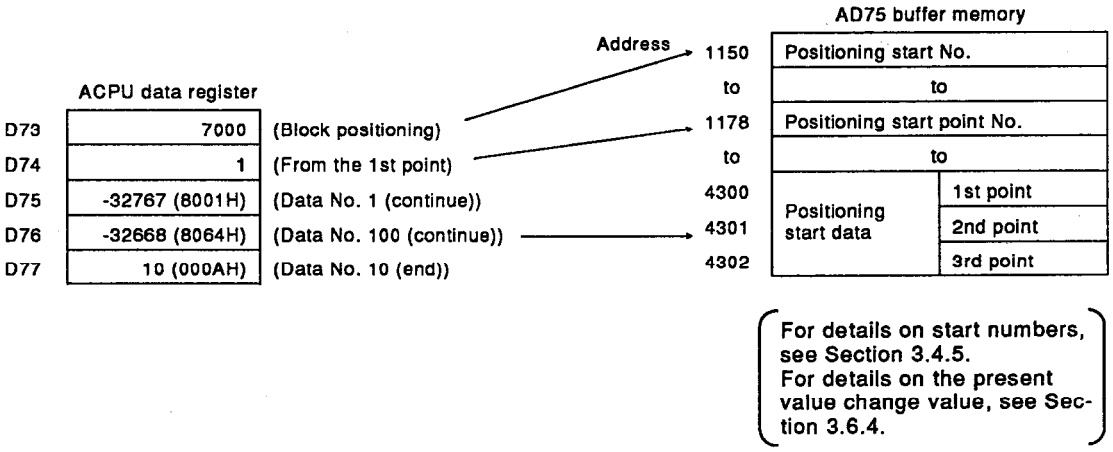


- Set a new present value for the positioning address.

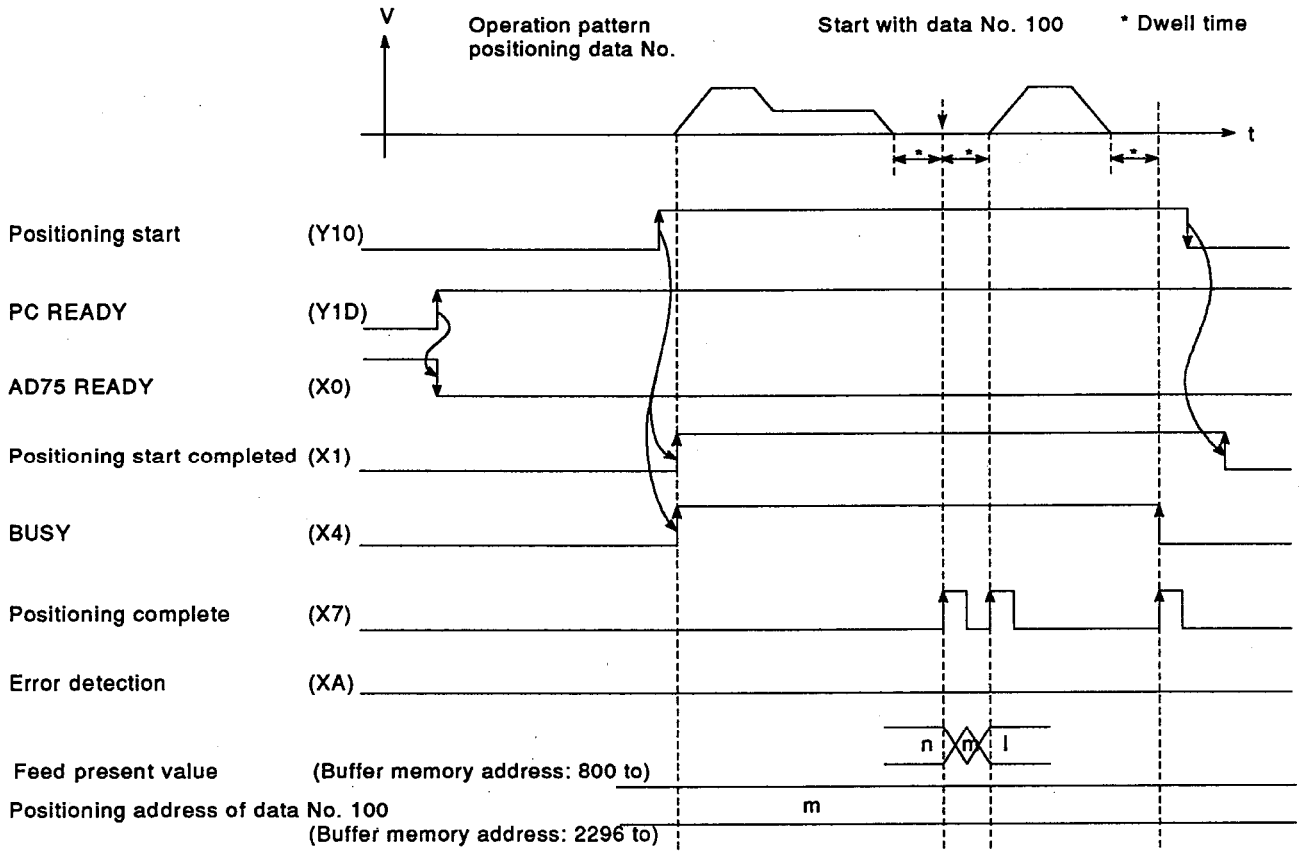
(2) Program example

- The program shown here changes the present value of axis 1 using positioning data No. 100.

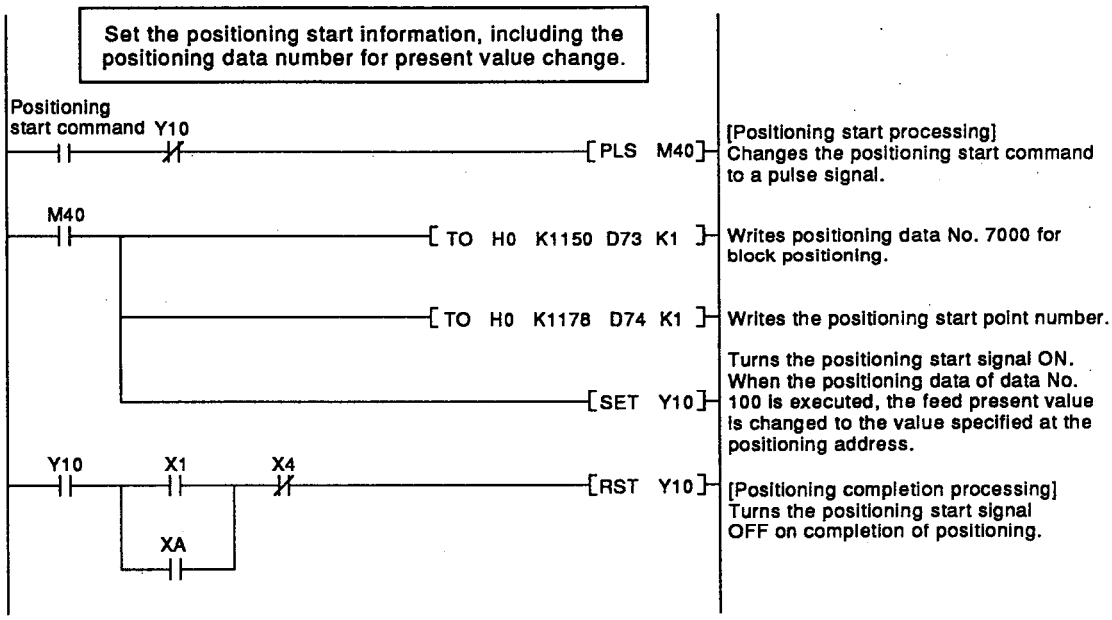
(a) Data transfer



(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

(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.

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

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

12.1 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.

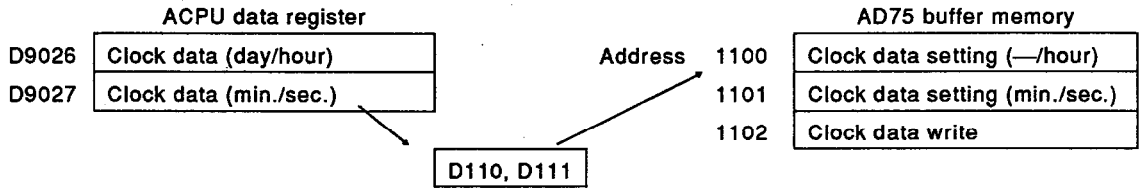
(1) Setting conditions

- There are no particular conditions to be set.

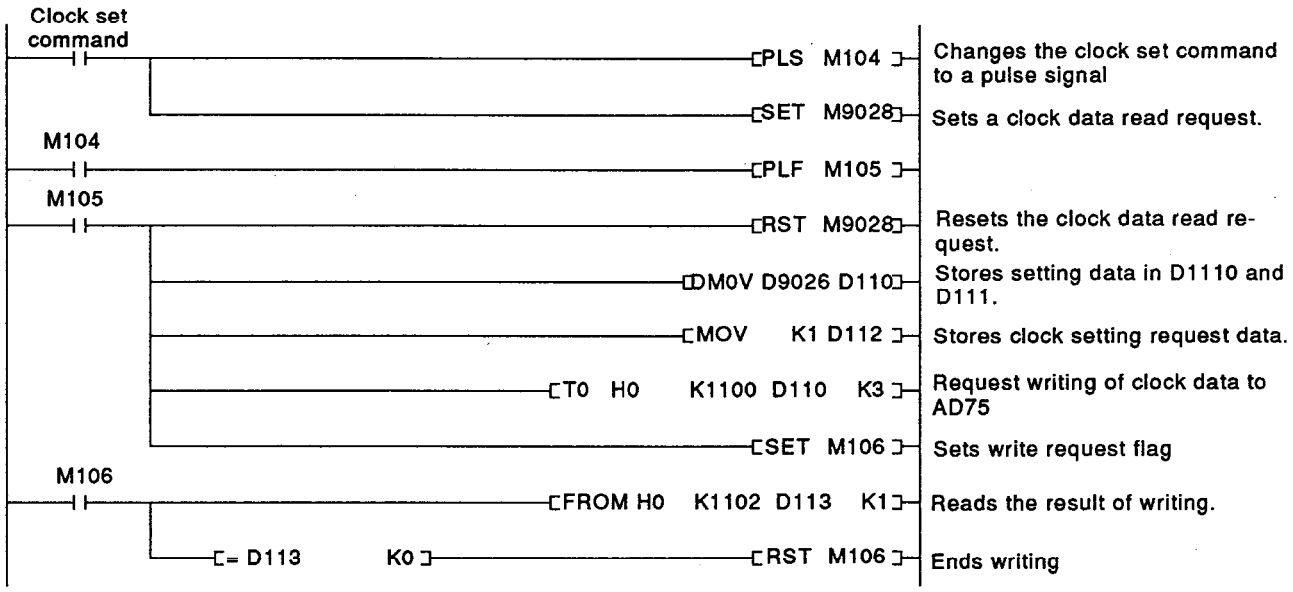
(2) Program example

- 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.

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.

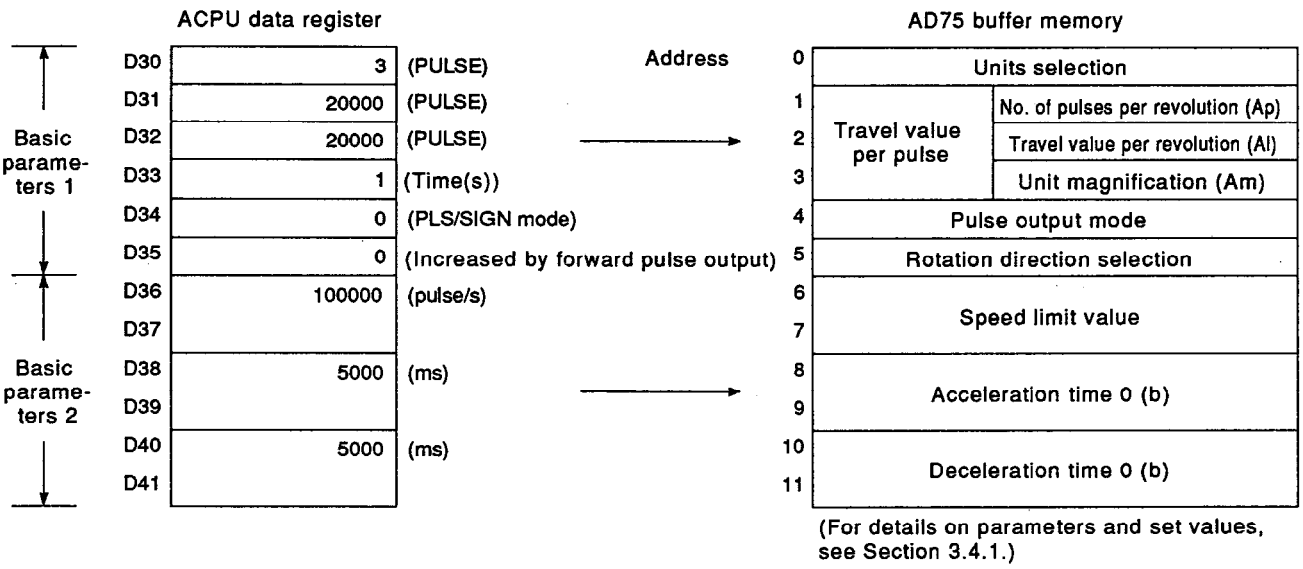
(1) Setting conditions

- 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

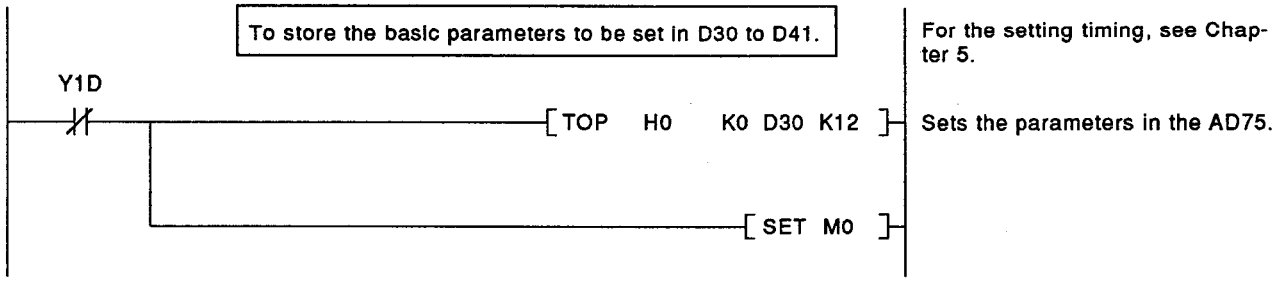
- The program shown here sets the basic parameter settings for axis 1, stored in D30 to D41, in the AD75.

(a) Data transfer



(For details on parameters and set values, see Section 3.4.1.)

(b) Program



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.

12.3 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

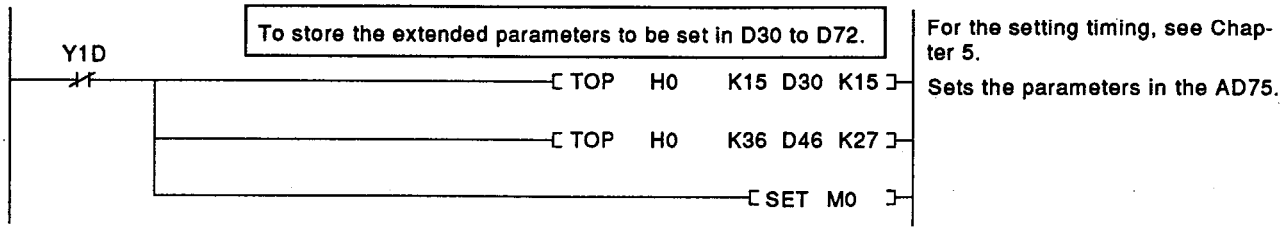
- The program shown here sets the extended parameter settings for axis 1, stored in D30 to D72, in the AD75.

(a) Data transfer

	ACPU data register			Address	AD75 buffer memory
Extended parameters 1	D30	10	(pulse)	15	Backlash compensation
	D31	1000000000	(pulse)	16	Upper software stroke limit
	D32			17	
	D33	0	(pulse)	18	Lower software stroke limit
	D34			19	
	D35	1	(Machine feed value designation)	20	Software stroke limit selection
	D36	1	(Valid)	21	Software stroke limit valid for JOG operations, etc.
	D37	20000	(pulse)	22	Command in-position range
	D38			23	
	D39	300	(%)	24	Torque limit set value
	D40	1	(AFTER mode)	25	M code ON signal output timing
	D41	0	(Standard speed switching)	26	Speed switching mode Speed change type
	D42	1	(Reference axis speed)	27	Interpolation speed designation method (interpolation mode)
	D43	0	(No update)	28	Feed present value update command in speed control
	D44	0	(No manual pulse generator operation)	29	Manual pulse generator selection
				30	
				to	
Extended parameters 2	D46	1000	(ms)	36	Acceleration time 1 (b)
	D47			37	
	to			to	
	D56	1000	(ms)	46	Deceleration time 3 (b)
	D57	100000		47	
	D58		(pulse/s)	48	JOG speed limit value
	D59			49	
	D60	0	(Select acceleration time 0)	50	JOG operation acceleration time selection
	D61	0	(Select deceleration time 0)	51	JOG operation deceleration time selection
	D62	0	(Trapezoidal acceleration/deceleration)	52	Acceleration/deceleration process selection
	D63	100	(%)	53	S-curve ratio
	D64	1000	(ms)	54	Rapid stop deceleration time
	D65			55	
	D66	1	(Rapid stop)	56	Stop group 1 rapid stop selection
	to			to	
	D70	100	(pulse)	60	Allowable error range for circular interpolation
	D71			61	
	D72	0	(External start)	62	External start function selection

(For details on parameters and set values, see Section 3.4.2.)

(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.

12.4 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.

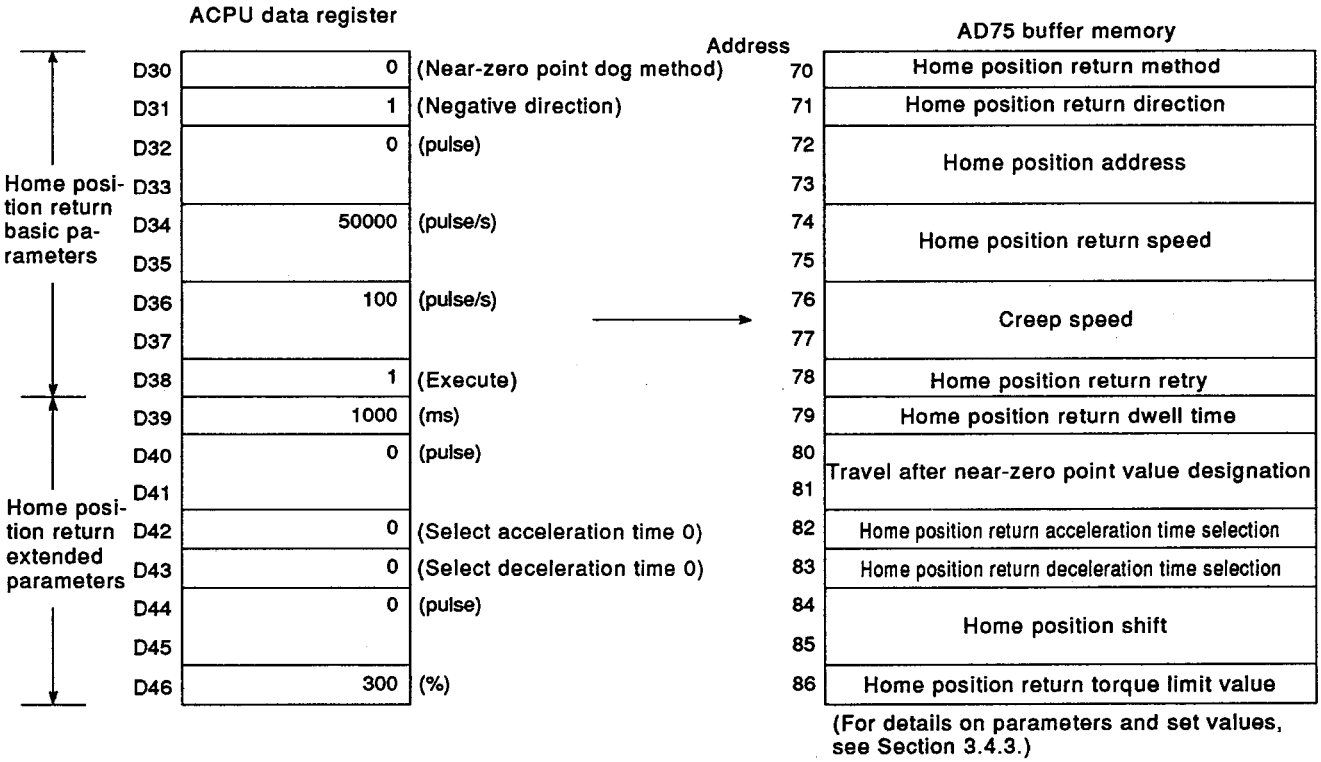
(1) Setting condition

- Write parameters when the PC READY signal (Y1D) is turned OFF.

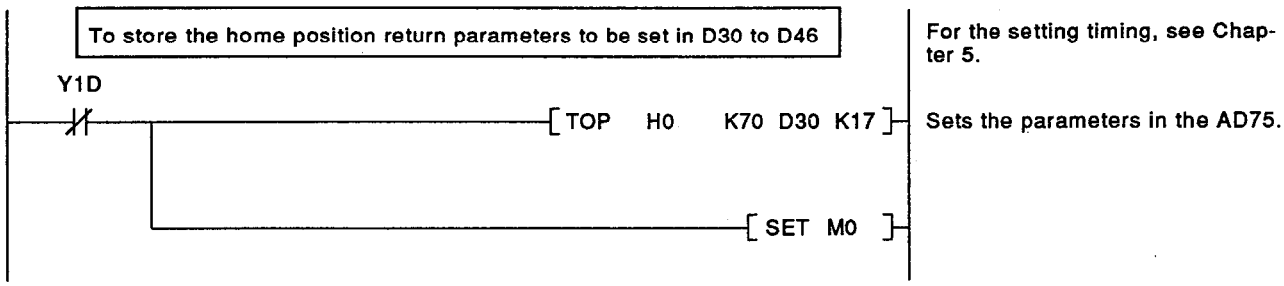
(2) Program example

- The program shown here sets the home position return settings for axis 1, stored in D30 to D46, in the AD75.

(a) Data transfer



(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.

12.5 Program for Setting Positioning Data

This section shows an example of a sequence program for setting AD75 positioning data from the ACPU.

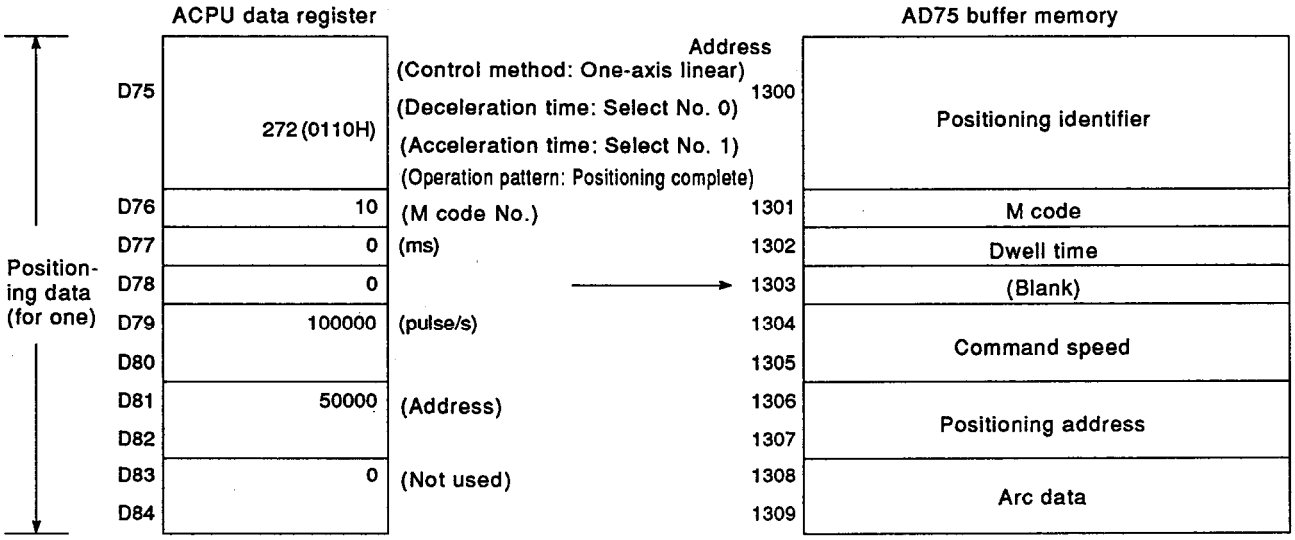
(1) Setting condition

- Write parameters when the relevant axis is not in operation.

(2) Program example

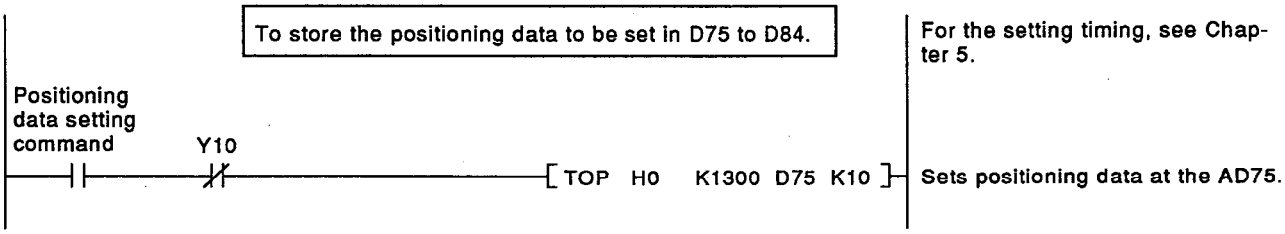
- The program shown here sets the positioning data for axis 1, stored in D0 to D9, in the AD75 using positioning data No. 1.

(a) Data transfer



(For details on positioning data and set values, see Section 3.4.4.)

(b) Program



POINTS

(1) A 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.

12.6 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.

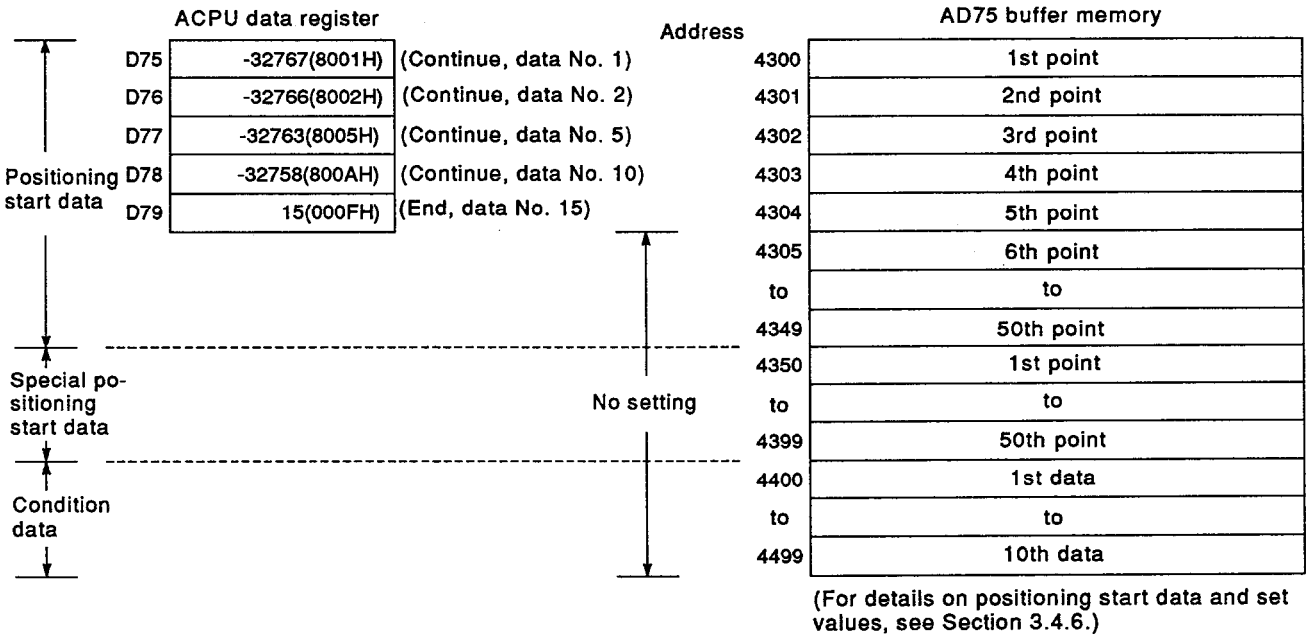
(1) Setting condition

- Write positioning start information when the relevant axis is not in operation.

(2) Program example

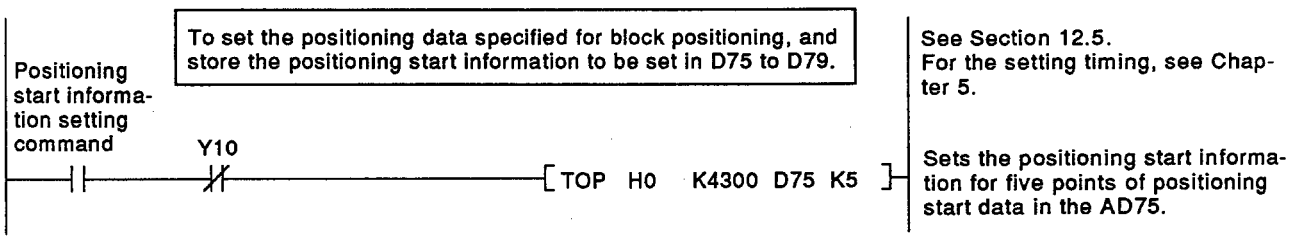
- The program shown here sets the positioning start data (5 points) for axis 1, stored in D75 to D79, in the AD75.
- In this example, no special positioning start or condition data corresponding to the positioning start data are set.

(a) Data transfer

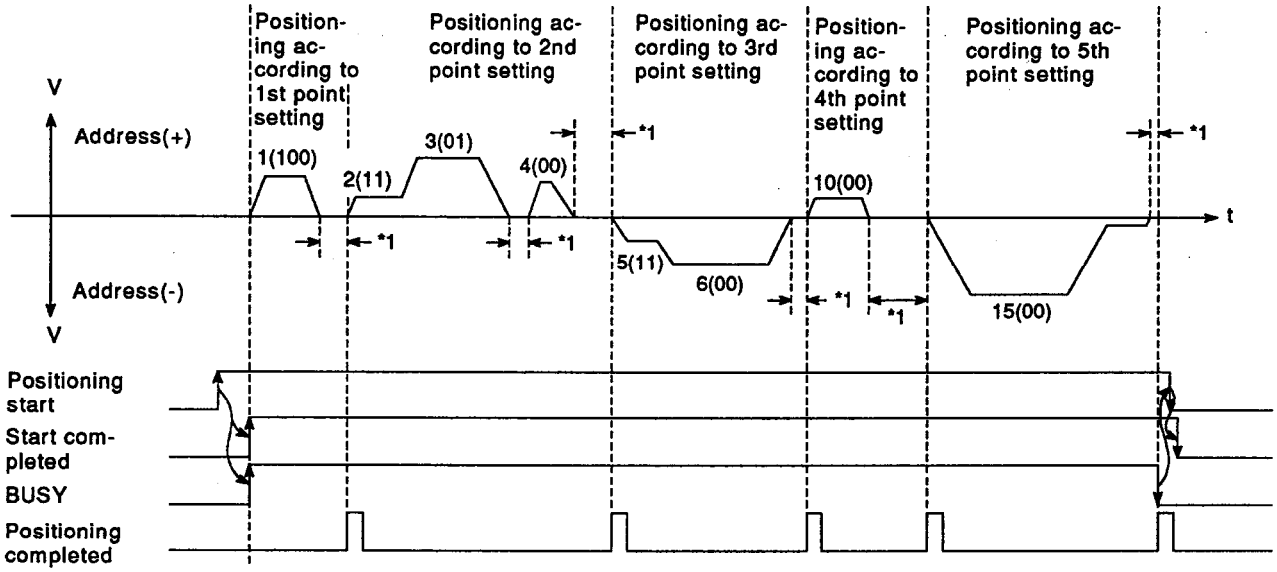


(For details on positioning start data and set values, see Section 3.4.6.)

(b) Program



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.

12.7 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.

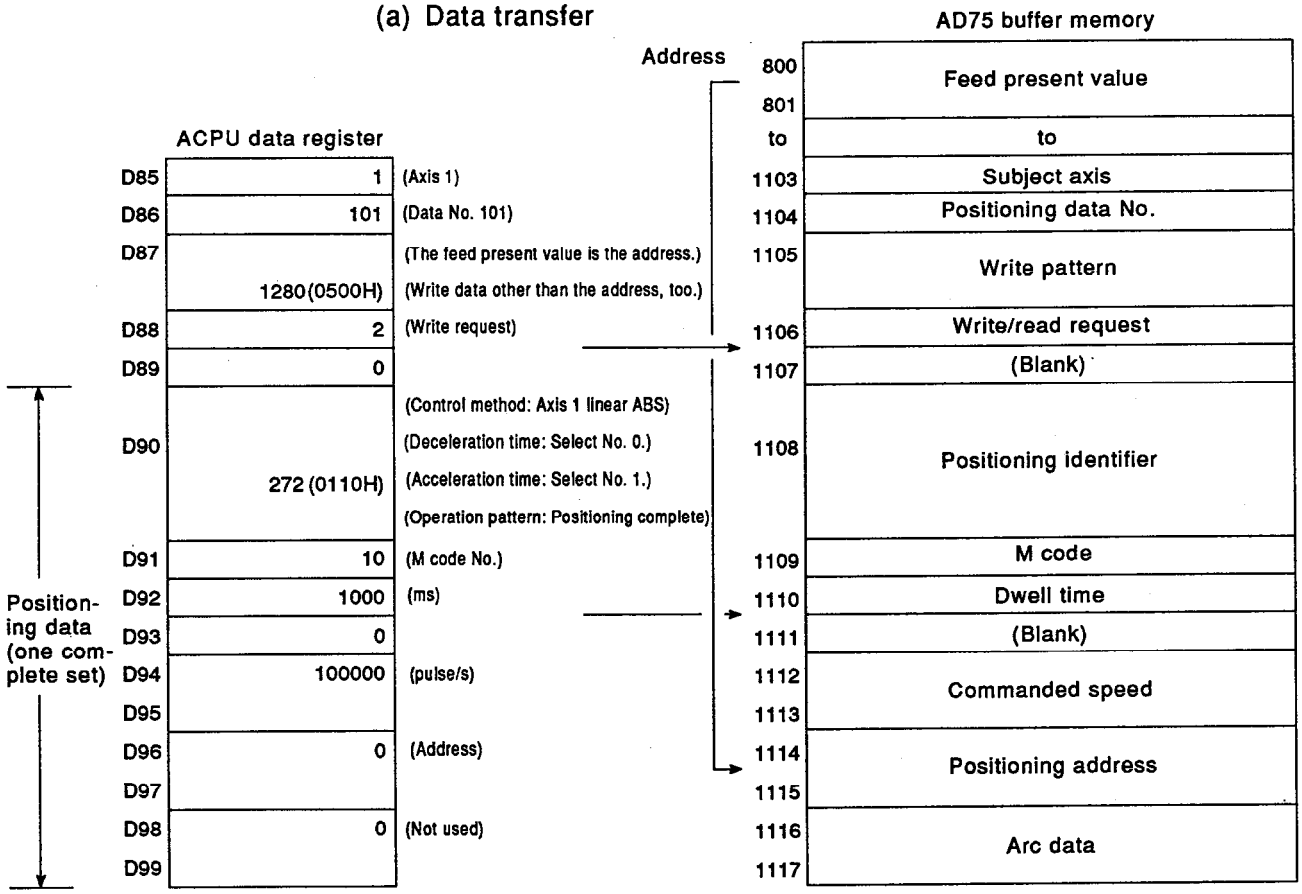
(1) Setting condition

- 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.

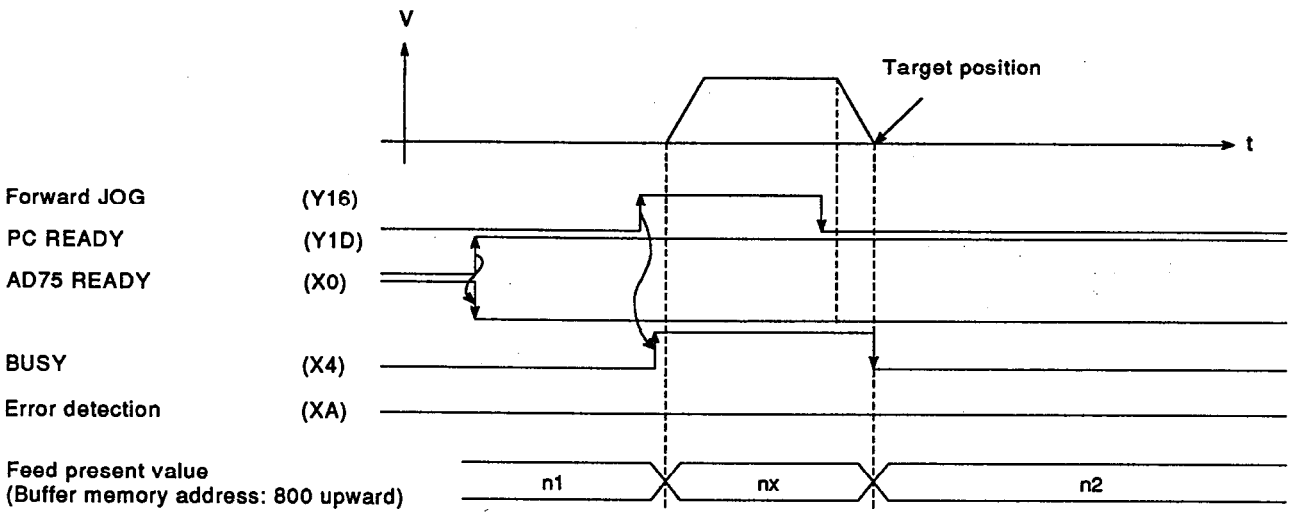
(2) Program example 1

- 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)).

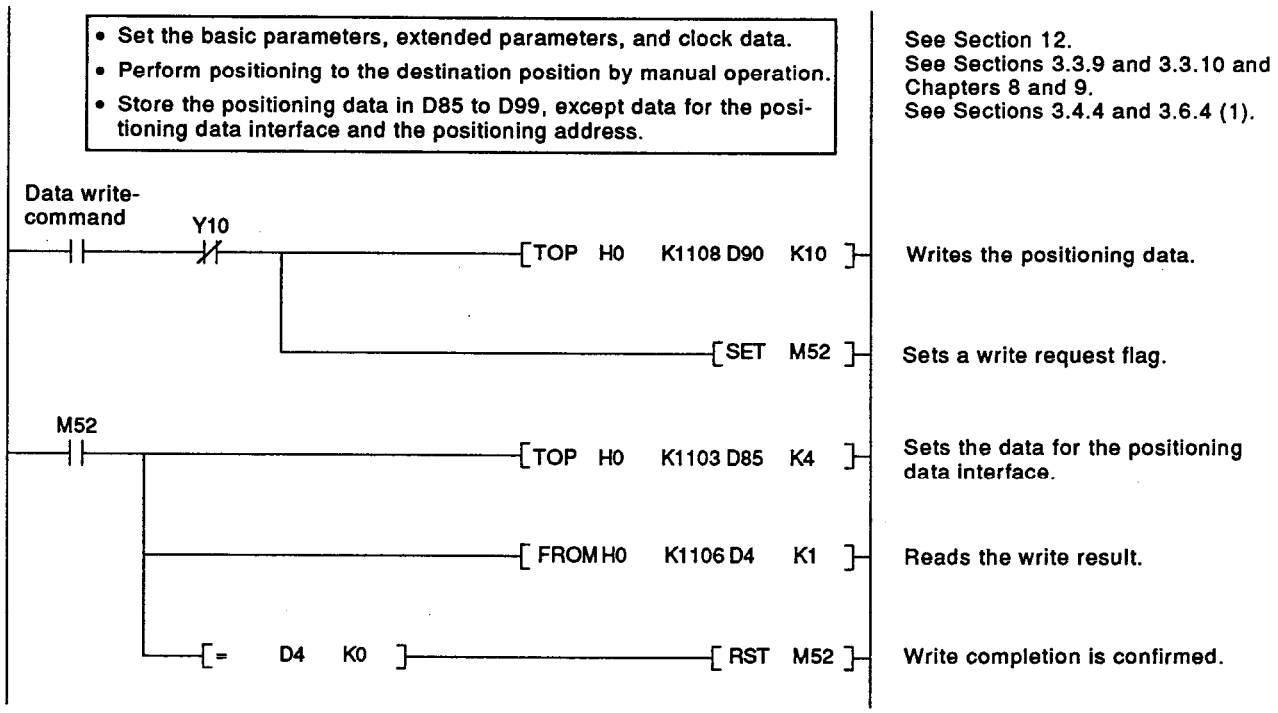
(a) Data transfer



(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).)



(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.

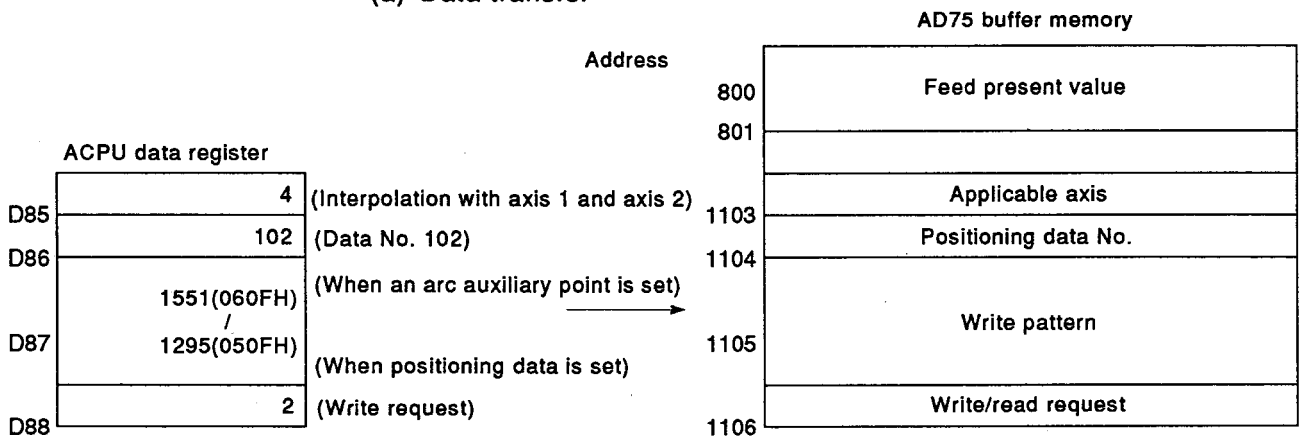
(3) The positioning address to be written is the absolute address (ABS) value.

(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.

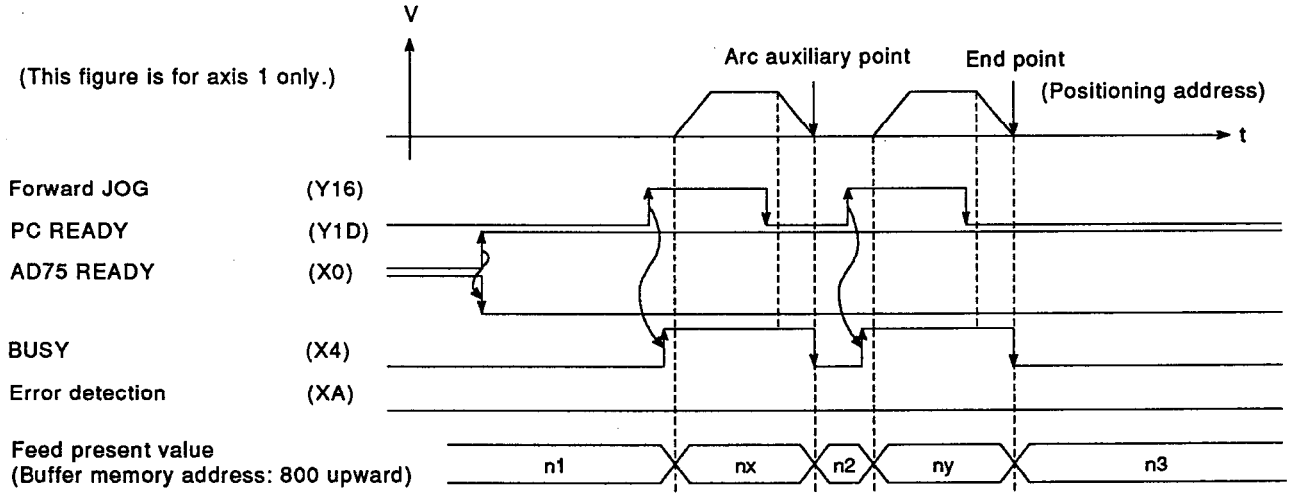
(3) Program example 2

- 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).



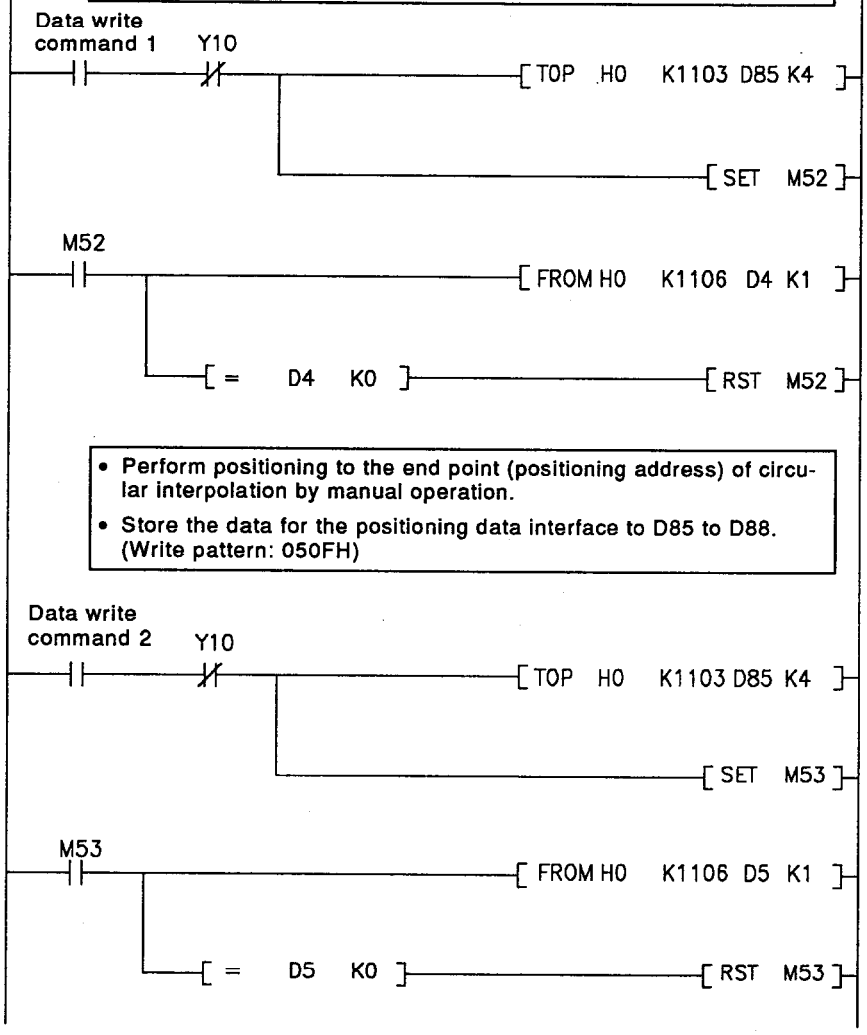
(b) Program

- Set the basic parameters, extended parameters, and clock data.
- Set the positioning data of data No. 102, except for the positioning address and the circular interpolation data.

See Chapter 12, Sections 3.4.4 and 3.4.6 (1) and [Program example 1].

- Perform positioning to the circular interpolation auxiliary point by manual operation.
- Store the data for the positioning data interface in D85 to D88. (Write pattern: 060FH)

See Sections 3.3.9 and 3.3.10, Chapters 8 and 9 and Section 3.6.4 (1).



Sets the data for the positioning data interface.

Sets the write request flag.

Reads the write result.

Confirms write completion.

- Perform positioning to the end point (positioning address) of circular interpolation by manual operation.
- Store the data for the positioning data interface to D85 to D88. (Write pattern: 050FH)

See Sections 3.3.9 and 3.3.10, Chapters 8 and 9 and Section 3.6.4 (1).

Sets the data for the positioning data interface.

Sets the write request flag.

Reads the write result.

Confirms completion of writing.

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.

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.

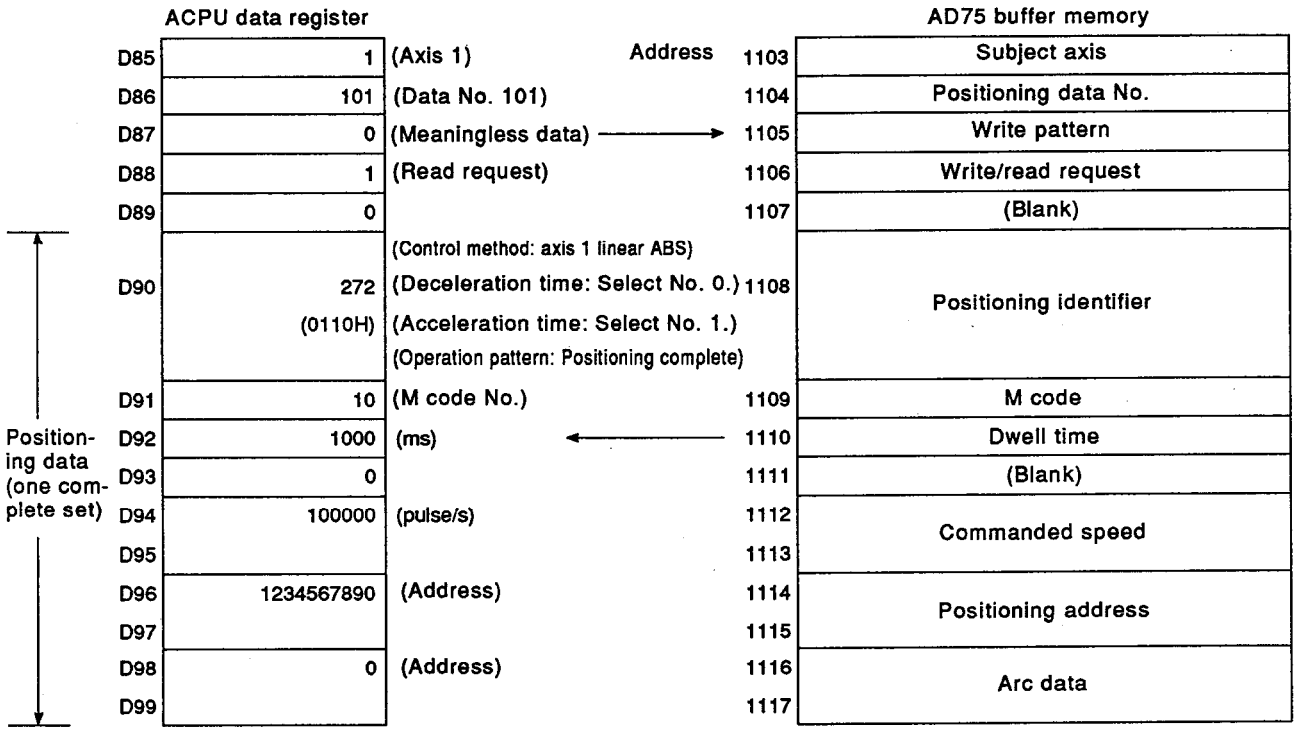
(1) Setting conditions

- There are no particular conditions to be set.

(2) Program example

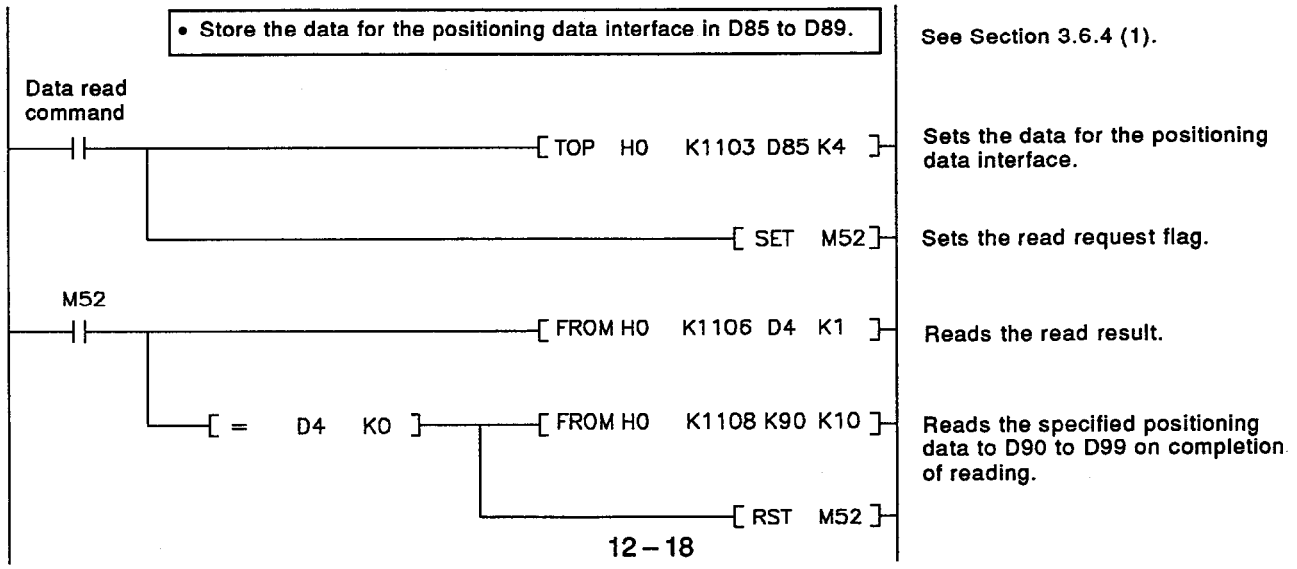
- The program shown here reads the positioning data of data No. 101 for axis 1 into D90 to D99.

(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



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.

(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.

(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

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.

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.

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
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/deceleration selection setting error			
960	S curve ratio setting error			

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.

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
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.

13.3 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)

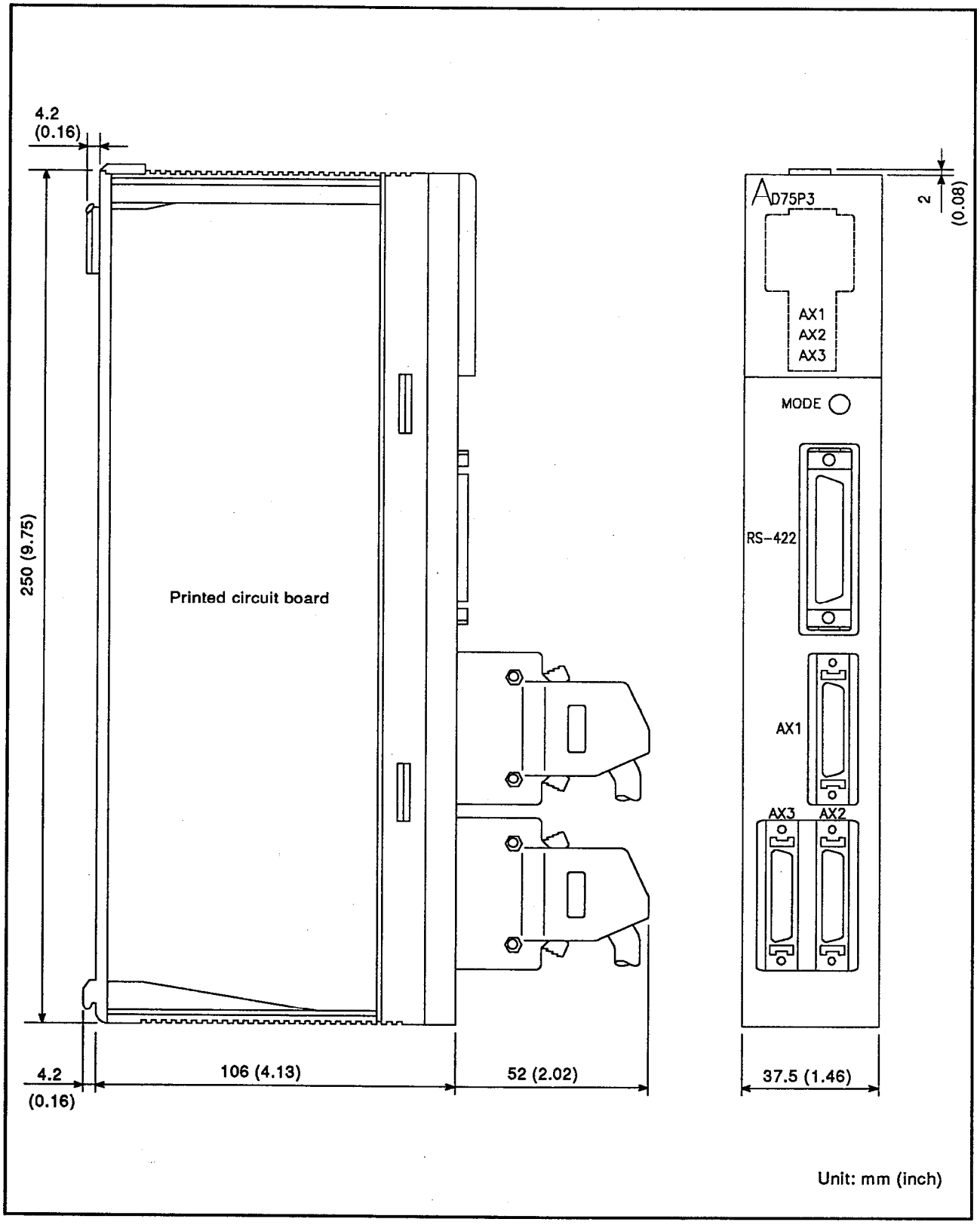
<Example of Display at Peripheral Device>

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

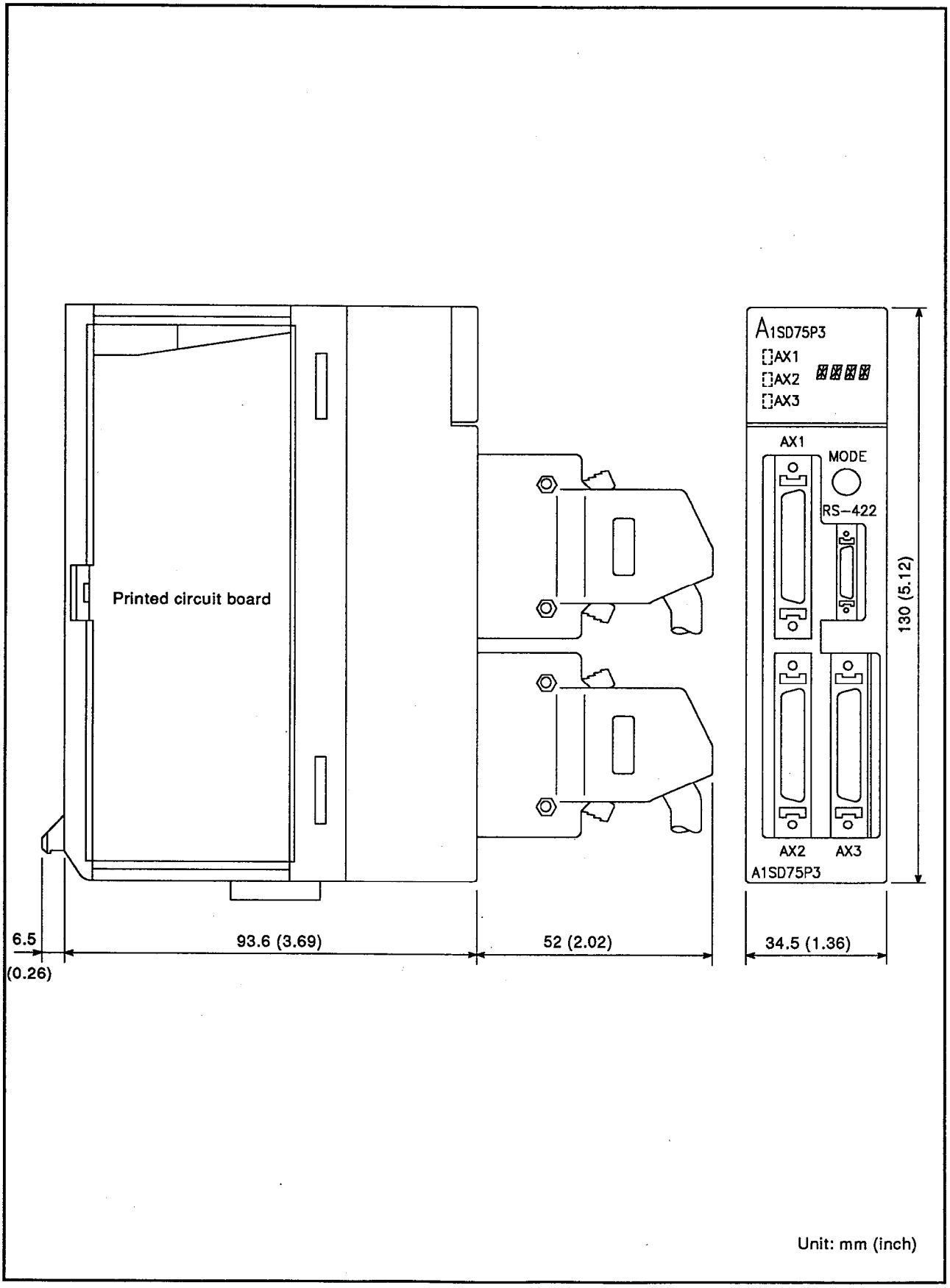
APPENDICES

APPENDIX 1 EXTERNAL DIMENSIONS

(1) AD75P1/P2/P3



(2) AISD75P1/P2/P3



APPENDIX 2 FORMAT CHART

2.1 Positioning Module Operation Chart

Axis address
mm, inch, degree, pulse

Axis address
mm
inch
degree
pulse

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			

	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) 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 Creep 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
	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 Home position return deceleration time selection	0 to 3			
	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
	0				
	0				
	0				
	1				
	1				
	0				
	0				
	0				
	0				
	0				
	0				
	300				

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							

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

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 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	High / Low	
	SING	High / Low	
CW/CCW pulse output	PULSE F	High / Low	
	PULSE R	High / Low	
A phase/B phase pulse output	A phase	High / Low	
	B phase	High / Low	

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

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.)

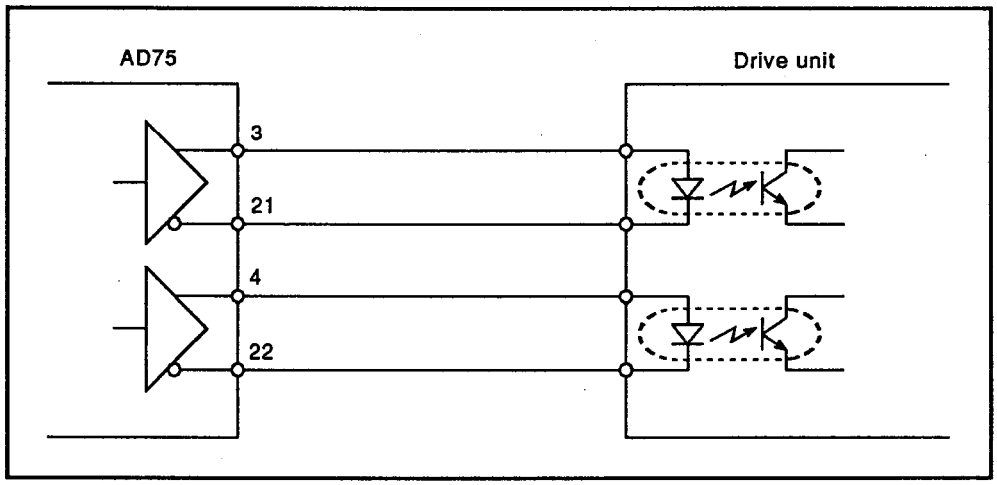


Fig. 5.1 Example Connection Using AD75 Differential Driver

(3) When connecting an AD75 and drive unit using the open collector system, wire as shown in Figure 5.2.

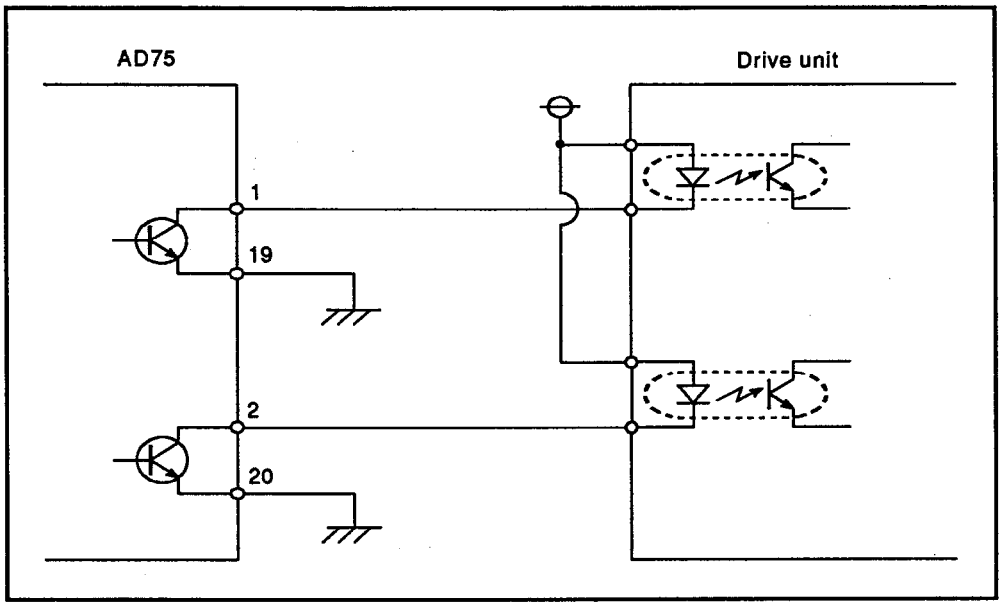


Fig. 5.2 Example Connection Using AD75 Open Collector

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.

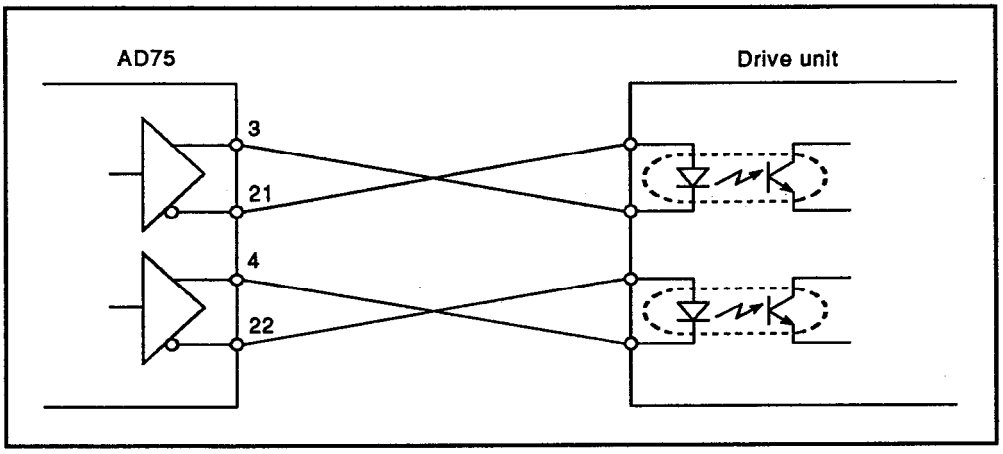


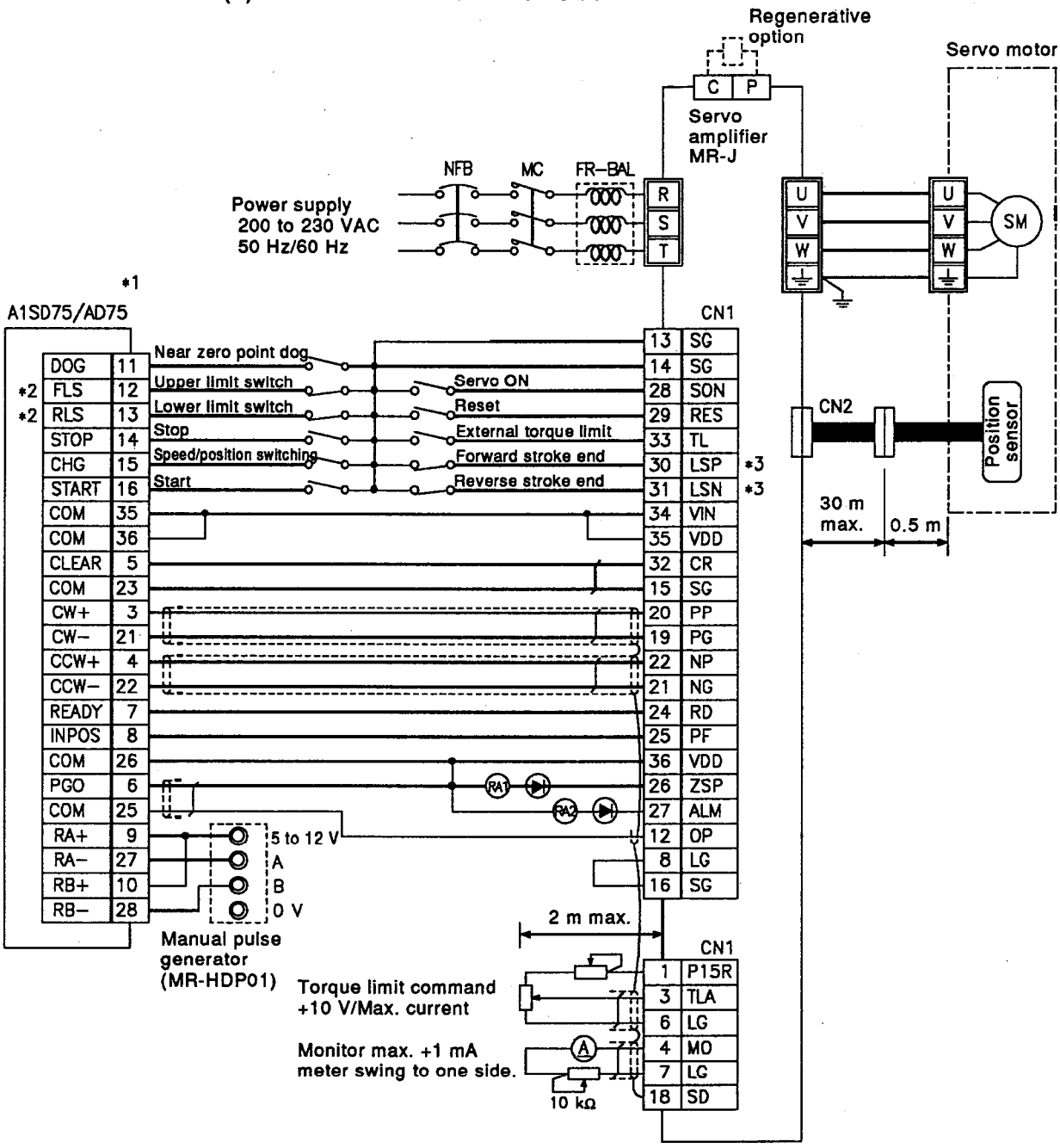
Fig. 5.3 Example of Wiring When the Command Pulse Logic Does Not Match

(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.

APPENDIX 6 EXAMPLE CONNECTION TO SERVO AMPLIFIER

6.1 Example of Connection Between A1SD75/AD75 and MR-J

(1) When differential driver is used



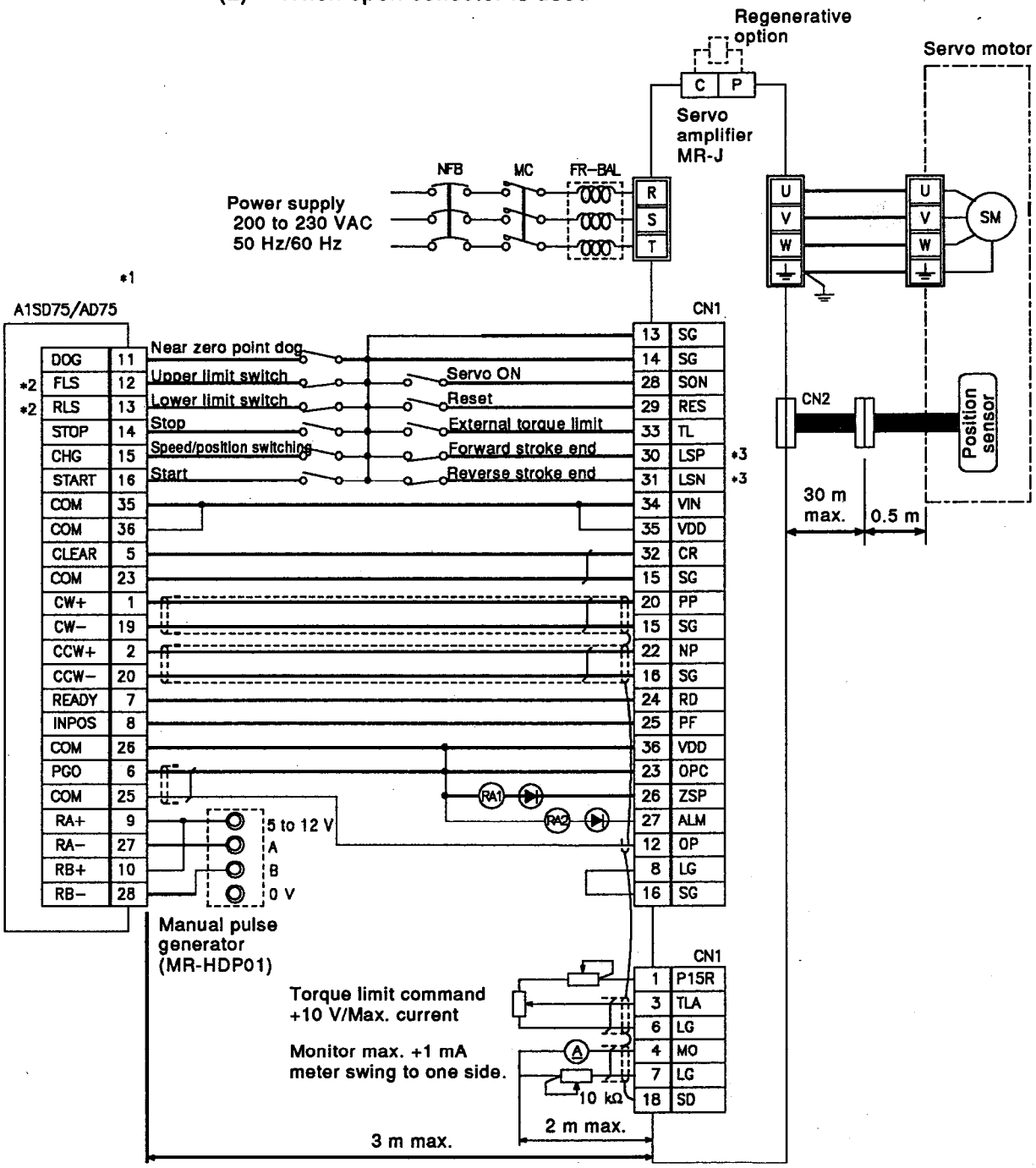
REMARKS

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).

(2) When open collector is used



REMARKS

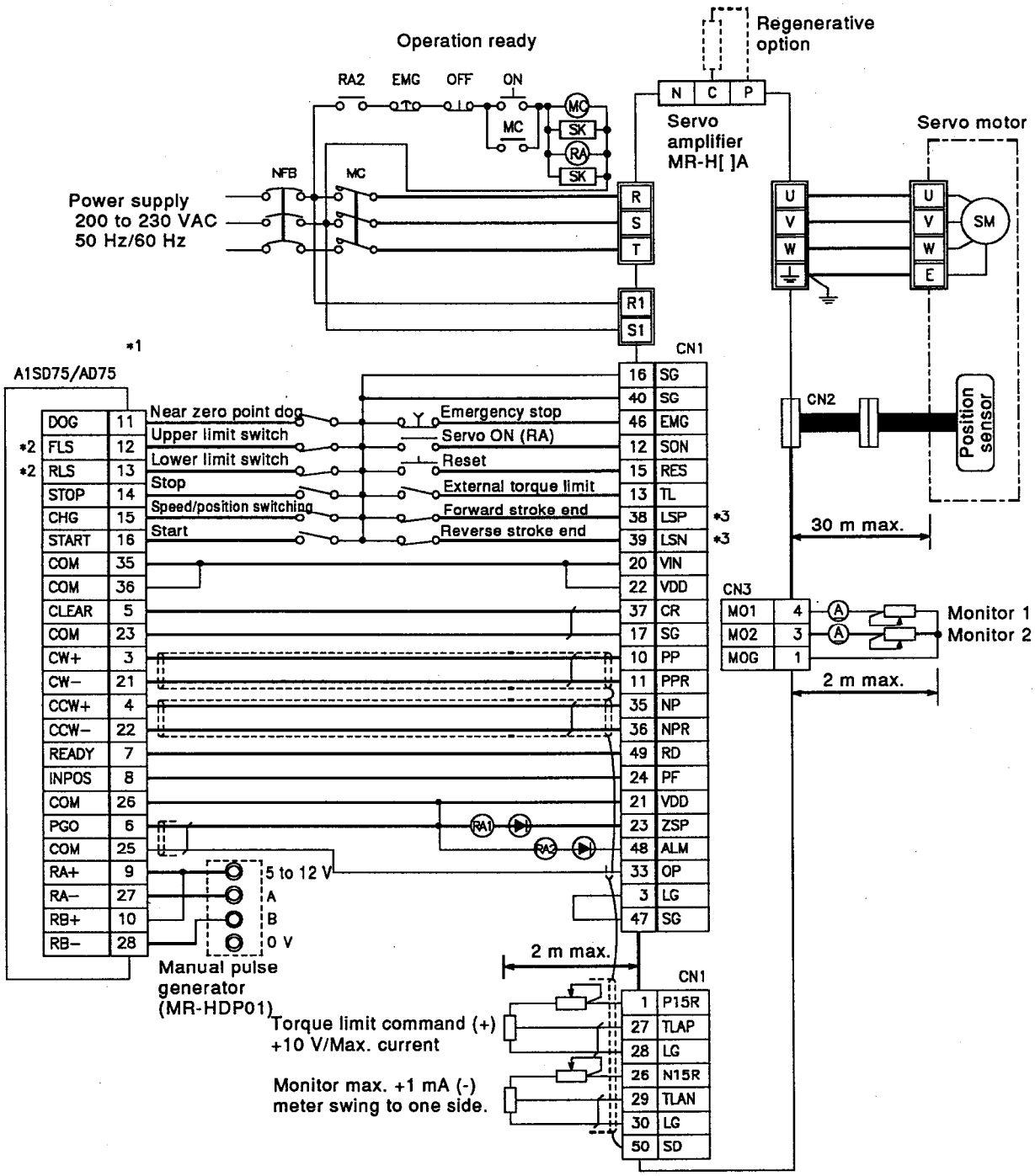
1) *1: The applications of the A1SD75/AD75 connector pin numbers are the same for axes 1 through 3.

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

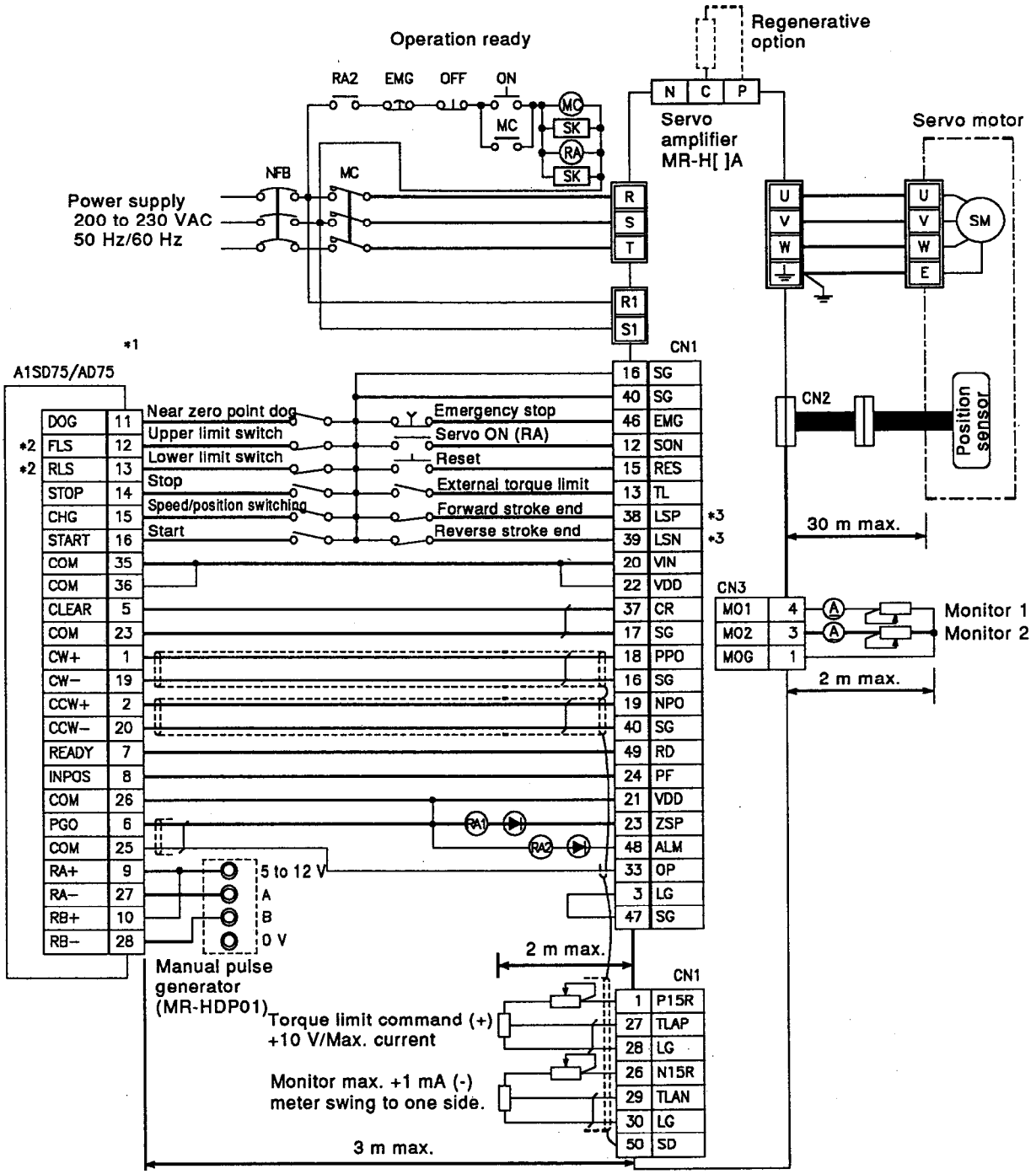
(1) When differential driver is used



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).

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.

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	

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