

Kullanılan set

Kullanılan Yazılım

[MotionworksIEC](https://www.yaskawa.com/motionworksiec)

Kullanılan kütüphaneler



Takip ekseni

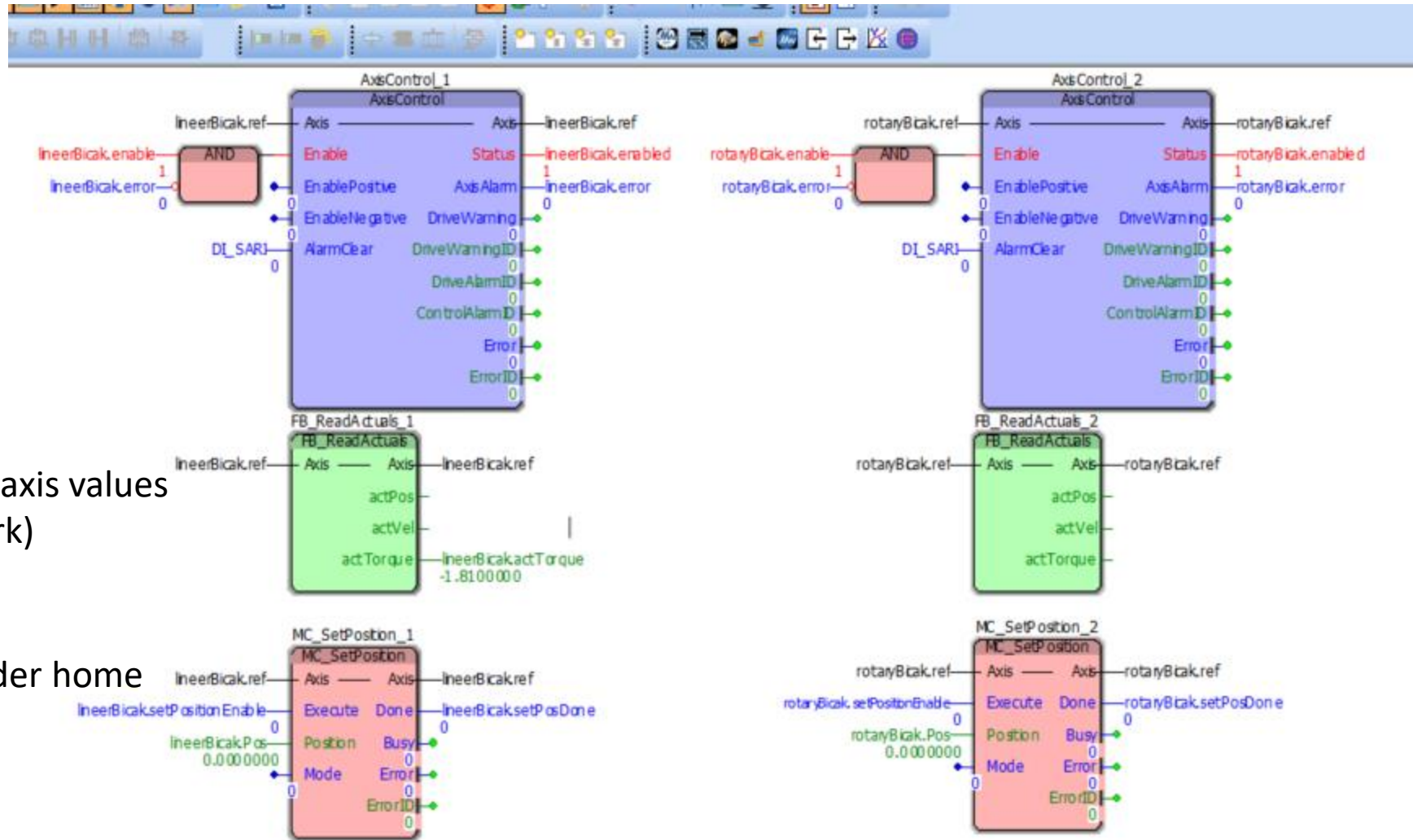
Akan ürün

YASKAWA

PowerON

Read actual axis values  
(pos, vel, tork)

Servo/encoder home  
home=0mm



10:

```

(*makina home olmus mu?*)
linearBicak.setPositionEnable := TRUE;
rotaryBicak.setPositionEnable := TRUE;
konveyor.setPositionEnable := TRUE;
if TON_10.Q then
    linearBicak.setPositionEnable := FALSE;
    rotaryBicak.setPositionEnable := FALSE;
    konveyor.setPositionEnable := FALSE;
    makina.homeDone := TRUE;
    HedefBoy := makina.set.boy; (*ilk cycle'da*)
    iStepMakina := 20;
end_if;

```

20: (\*makina home done - gear in pos execute\*)

```

if makina.alarm.acil then
    iStepMakina := 1000;
else
    makina.g_in.masterSyncPos := HedefBoy;
    makina.g_in.slaveSyncPos := makina.set.boy / LREAL#10.0;
    makina.g_in.MasterStartDist := makina.g_in.slaveSyncPos*LREAL#1.05;

    makina.g_in.execute := TRUE;

    TON_sync(IN:=makina.g_in.InSync,PT:=t#200ms); (*case disinda cagirilir*)
    if TON_sync.Q then
        linearBicak.posExecute := TRUE;
        makina.g_in.execute := FALSE;
        iStepMakina := 30;
    end_if;
end_if;

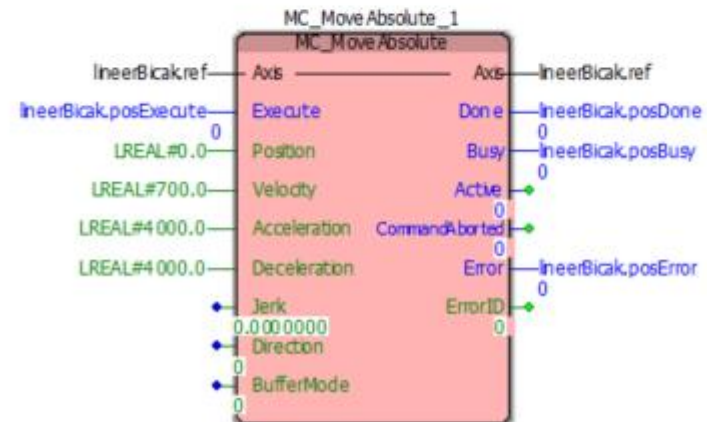
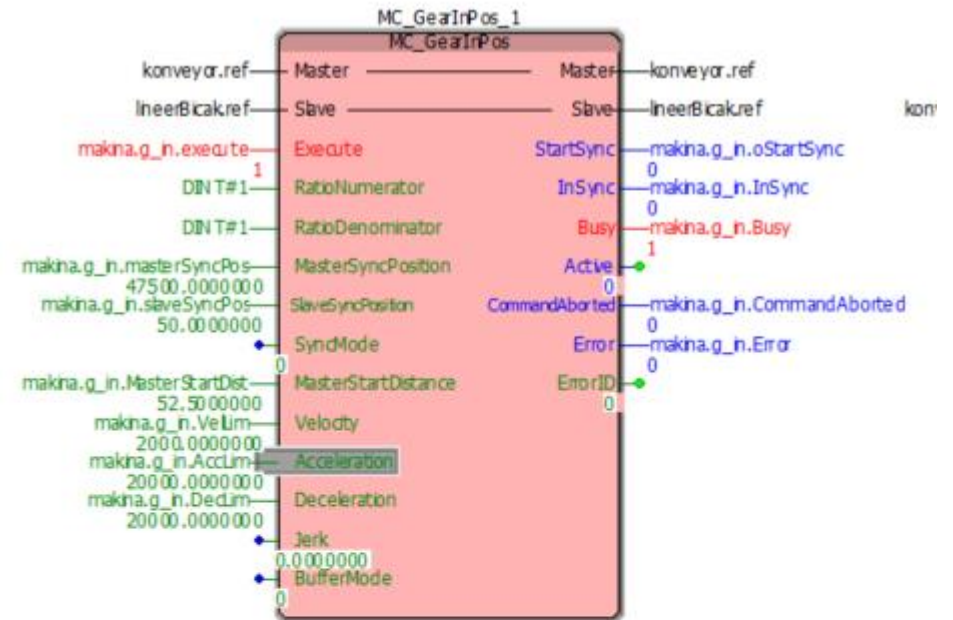
```

30:

```

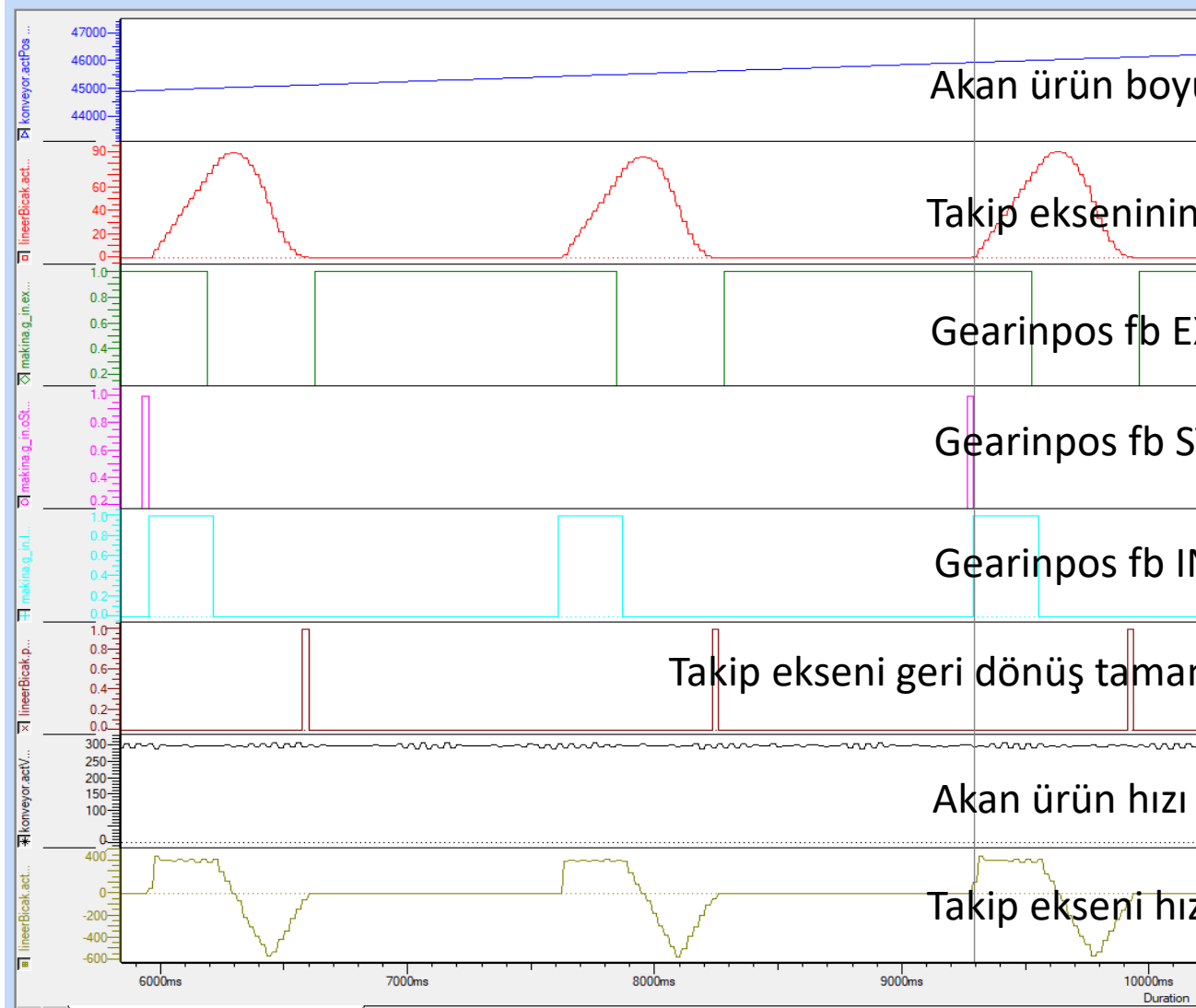
if makina.alarm.acil then
    iStepMakina := 1000;
else
    if linearbicak.posDone then
        linearBicak.posExecute := FALSE;
        HedefBoy := HedefBoy + makina.set.boy; (*ilk cycle'dan sonra ekleye ekleye devam*)
        iStepMakina := 20;
    end_if;
end_if;

```





# Gearinpos ile boykesme uygulaması



Akan ürün boyu – enkoderden gelen pozisyon bilgisi (mm)

Takip ekseninin pozisyonu (mm) – sıfır konumundan başlar, sıfıra döner

Gearinpos fb EXECUTE girişi

Gearinpos fb STARTSYNC çıkışı

Gearinpos fb INSYNC çıkışı

Takip eksenini geri dönüş tamamlandı bilgisi

Akan ürün hızı (mm/sn)

Takip eksenini hızı (mm/sn)

Data	Current Ruler
Duration	9291ms
konveyor.actPos - MedTsk.Main	45950.5
lineerBicak.actPos - MedTsk.Main	0.681791
makina.g_in.execute - MedTsk.Main	1
makina.g_in.oStartSync - MedTsk...	0
makina.g_in.InSync - MedTsk.Main	1
lineerBicak.posDone - MedTsk.Main	0
konveyor.actVel - MedTsk.Main	296.322
lineerBicak.actVel - MedTsk.Main	106.707

Gearinpos inSync geldiğinde takip eksenini hızı ile akan ürün hızı henüz aynı olmamış olabilir. Kontrol edin.