MODEL 2. MULTI-AXIS SERVO SYSTEM USING AC SERVO MOTORS AND MOTION CONTROL MODULE

1. CONTENTS

- ✓ AC servo motors and drivers
- ✓ PLC Mitsubishi programming
- ✓ Motion controller FX3U-20SSC-H
- ✓ Linear and circular interpolation

2. INTRODUCTION TO DEVICE

2.1. Hardware system

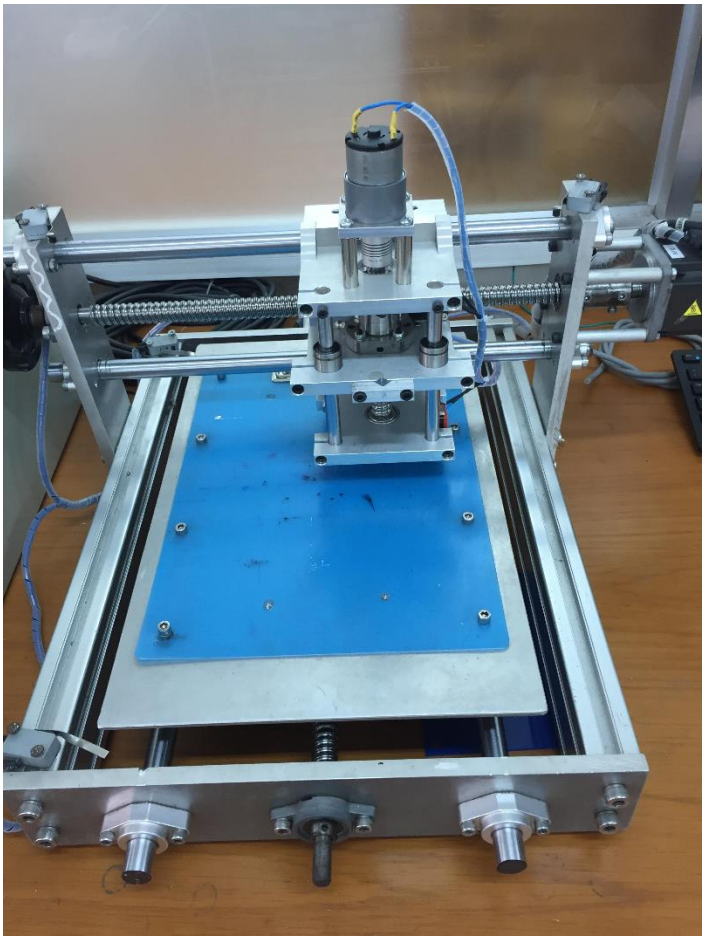


Fig. 2.1: 3-axis servo system using the Mitsubishi modules

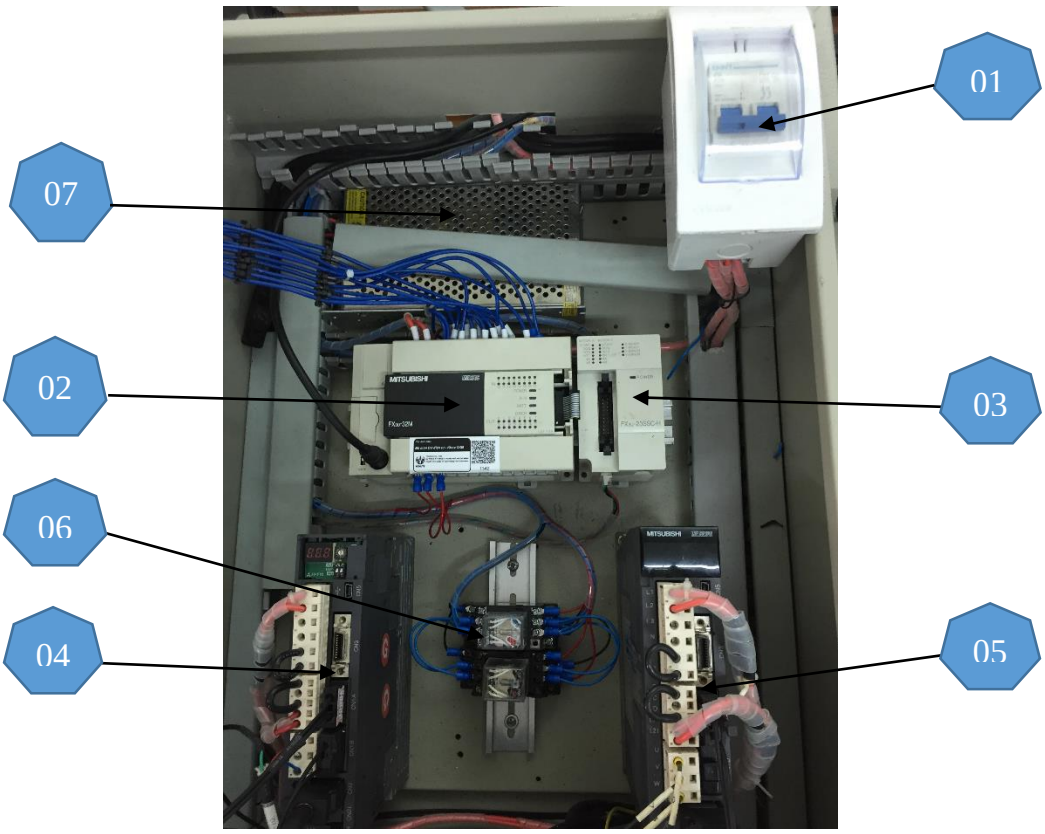


Fig. 2.2: The controller of the system

- **Components in the model**

01: Main CB

02: PLC Mitsubishi (FX_{3U}-32M)

03: Module FX_{3U}-20SSC-H

04, 05: Servo Drivers (MR-J3-□B)

06: Relays

07: Power supply 24VDC, 10A

2.2. 2–Axis motion control FX_{3U}-20SSC-H

2.2.1 Introduction

FX3U-20SSC-H is a special function block that controls position, speed of AC servo motors via SSCNETIII cable; compatible with AC Servo MR-J3- □B. It can control up to 2 AC servo motors with line and circular interpolations.

Fig. 2.3: Module FX_{3U}-20SSC-H

***Technical specifications*:**

- Number of control axis: 2 axes
- Applicable PLC: FX3U/FX3UC
- Connectable servo amplifiers: MELSERVO J3-□B, J3W-□B, J3-□BS
- Long distance cord length: up to 50m
- Servo bus: SSCNET III

**** Look up the manual for the detail configuration***

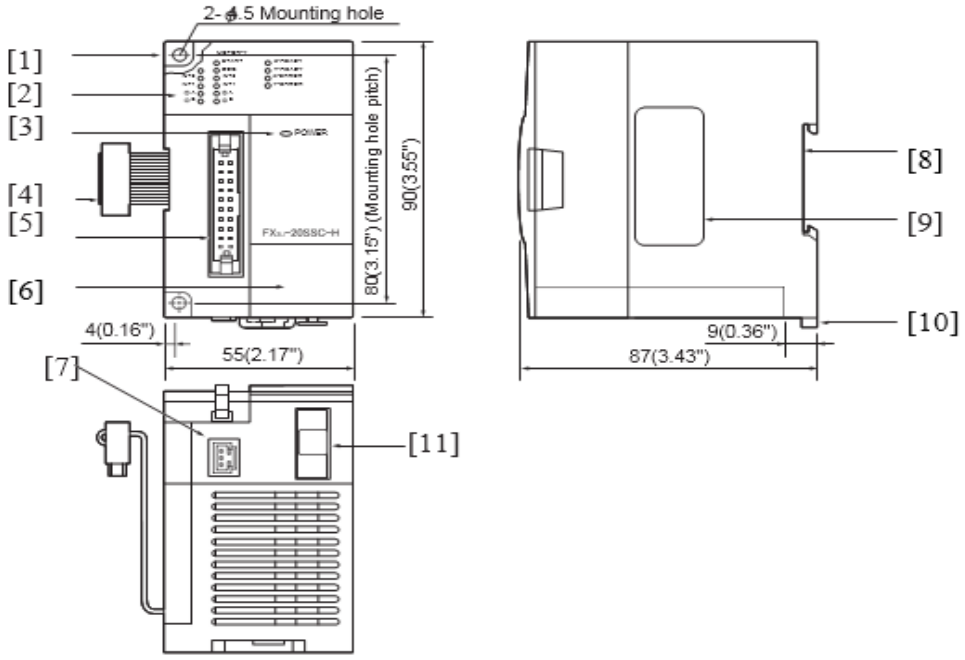


Fig. 2.4: Layout and connections of FX_{3U}-20SSC-H

External dimensions and part names

[1] Direct mounting hole: 2 holes of Ø4.5 (0.18") (mounting screw: M4 screw)

[2] Status LEDs

[3] POWER LED (green)

[4] Extension cable

[5] Input connector

[6] Top cover

[7] Power supply connector

[8] DIN rail mounting groove [DIN rail: DIN46277 35 mm (1.38”) wide]

[9] Name plate

[10] DIN rail mounting hook

[11] SSCNET III connector

Power and Status LED

Table 2.1: *Power and Status LED on FX_{3U}-20SSC-H*

LED display	Color	Status	Description
POWER	Green	OFF	Power is not being supplied from the external power supply or the PLC
		ON	Power is being supplied from the external power supply or the PLC
X-READY Y-READY	Green	OFF	Error is occurring or positioning is being executed on the X/Y axis
		ON	Various operation commands are acceptable on the X/Y axis
X-ERROR Y-ERROR	Red	OFF	X/Y axis is operating normally
		Flicker	Error is occurring on the X/Y axis
		ON	CPU error is occurring on the X/Y axis
X-START	Red	OFF	Start input OFF

Y-START		ON	Start input ON
X-DOG Y-DOG	Red	OFF	DOG input OFF
		ON	DOG input ON
X-INT0 Y-INT0 X-INT1 Y-INT1	Red	OFF	Interrupt input OFF
		ON	Interrupt input ON
X- ø A Y- ø A	Red	OFF	Manual pulse generator A-phase input OFF
		ON	Manual pulse generator A-phase input ON
X- ø B Y- ø B	Red	OFF	Manual pulse generator B-phase input OFF
		ON	Manual pulse generator B-phase input ON

Connection with PLC

FX_{3U}-20SSC-H is connected with PLC by the extension

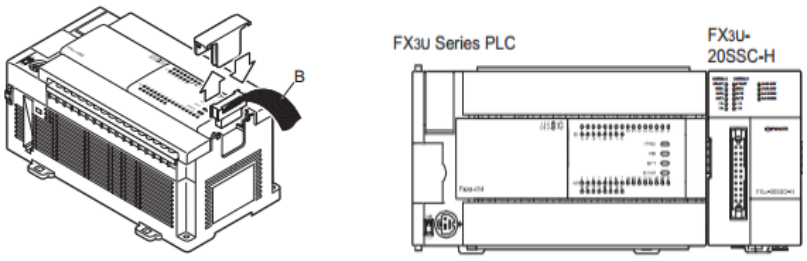


Fig. 2.5: Connection of FX3U-20SSC-H with PLC

Buffer memory (BFM)

The PLC can access the buffer memory directly, using sequence programs. The 20SSC-H uses positioning parameters and data in this area to execute the positioning control. The data types and their applications are described briefly in the following table. For the detail specifications, please look up the 20SSC-H manual.

Data type	Application	BFM number		
		X-axis	Y-axis	X-/Y-axis
Monitor data	Data indicating the control state. The monitor data is stored in the buffer memory. Monitor the data when necessary. → **For details, refer to Section 11.3**	BFM #0 to #99	BFM #100 to #199	-
Control data	The user controls the positioning control system, using the control data. The control data is related to operation-related settings, speed change command during positioning operation, stop operation, restart, etc. → **For details, refer to Section 11.4**	BFM #500 to #599	BFM #600 to #699	-
Positioning parameters	The positioning parameters specify the unit, speed and other features of the positioning control. Enter data according to the mechanical equipment and applicable motor. → **For details, refer to Section 11.1**	BFM #14000 to #14199	BFM #14200 to #14399	-
Servo parameters	The servo parameters depend on the servo amplifier to be used, and are used to control the servomotor. Enter data according to the specifications to be used. → **For details, refer to Section 11.2**	BFM #15000 to #15199	BFM #15200 to #15399	-
Table information	The table information is used for table type positioning control. Positioning control is based on the data specified in each table (operation information, position information, speed information, m code information). Up to 300 positioning table points per table can be defined. → **For details, refer to Section 11.5**	BFM #1000 to #3999	BFM #4000 to #6999	BFM #7000 to #12999

2.2.2. Melservo MR-J3-□B

Introduction

The Mitsubishi MELSERVO-J3 series, the general-purpose AC servo, has further higher performance and higher functions compared to the current MELSERVO-J2-Super series.

The torque limit with clamping circuit is put on the servo amplifier in order to protect the power transistor of main circuit from the over current caused by rapid acceleration/deceleation or overload. In addition, torque limit value can be changed to desired value in the controller.

The MELSERVO MR-J3 has a USB communication function, which uses an installed PC to perform parameter setting, monitoring, status monitoring, gain control, and AC servo via MR Configurator software.

MELSERVO-J3-□B has absolute position coding with ***262144 pulse / loop resolution*** to ensure more accurate control over the MELSERVO-J2-Super.

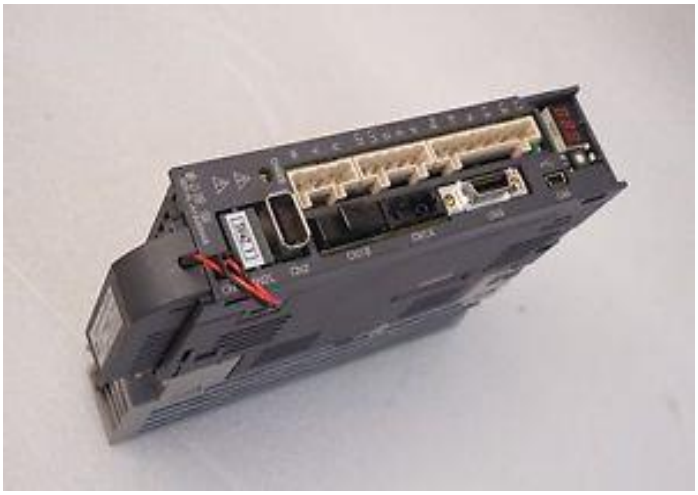


Fig. 2.6: Melservo MR-J3-20B

- **Structure**

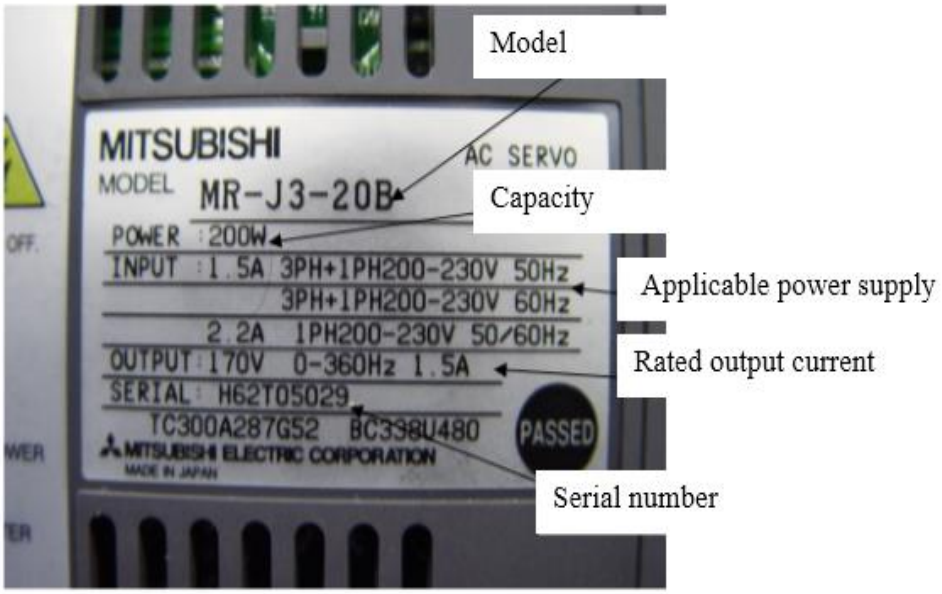


Fig. 2.7: Definition code of an AC Servo MR-J3-20B

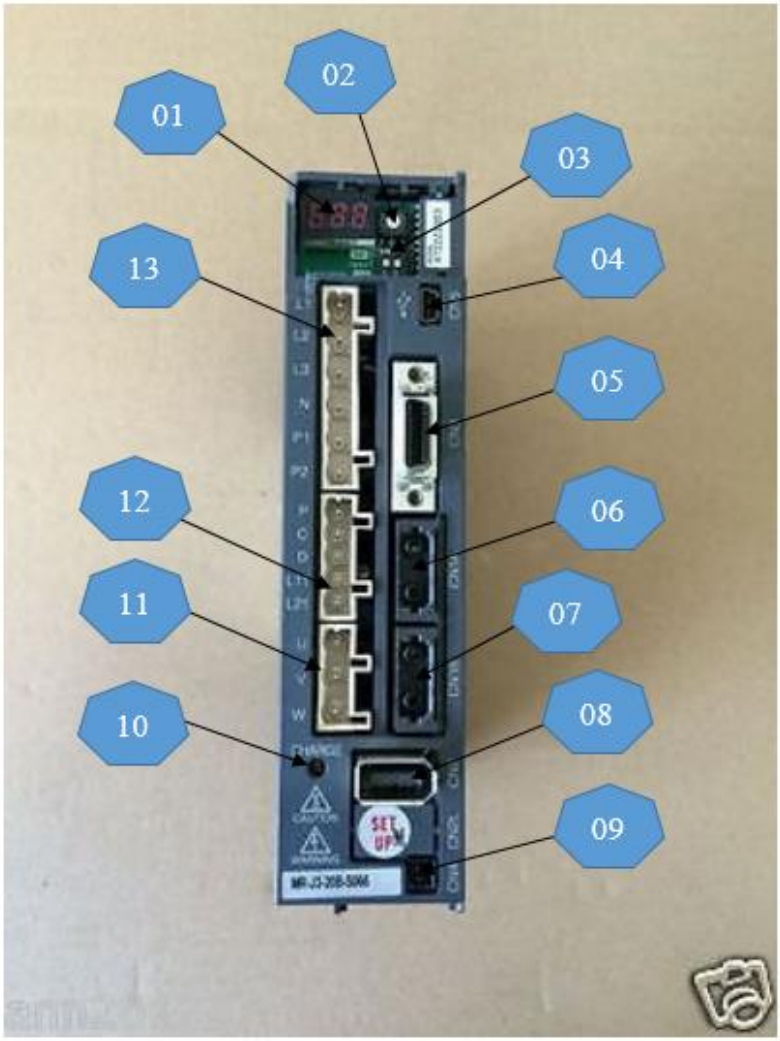


Fig. 2.8: Structure of Melservo MR-J3-20B

01: The 3-digit display, showing the servo status and alarm numbers.

02: Rotary axis setting switch (**SW1**)

Used to set the axis No. of servo amplifier

03: Test operation select switch (**SW2-1**)

Used to perform the test operation mode by using MR Configurator;

SW2-2: *Spare* (be sure to set to the "Down" position)

04: USB communication connector (CN5) (*connect to the personal computer*)

05: I/O signal connector (CN3)

Used to connect digital I/O signals. Moreover an analog monitor is output

06: SSCNET cable connector (CN1A)

Used to connect the servo system controller or the front axis servo amplifier.

07: SSCNET cable connector (CN1B)

Used to connect the rear axis servo amplifier. *For the final axis, putting a cap.*

08: Encoder connector (CN2)

Used to connect the servo motor encoder.

09: Battery connector (CN4)

Used to connect the battery for absolute position data backup.

10: Charge lamp; lit to indicate that the main circuit is charged. *While this lamp is lit, do not reconnect the cables.*

11: Servo motor power connector (CNP3)

12: Control circuit connector (CNP2)

Connect the control circuit power supply/ regenerative option

13: Main circuit power supply connector (CNP1)

Connect the input power supply.

- **Hardware connection to FX_{3U}-20SSC-H**

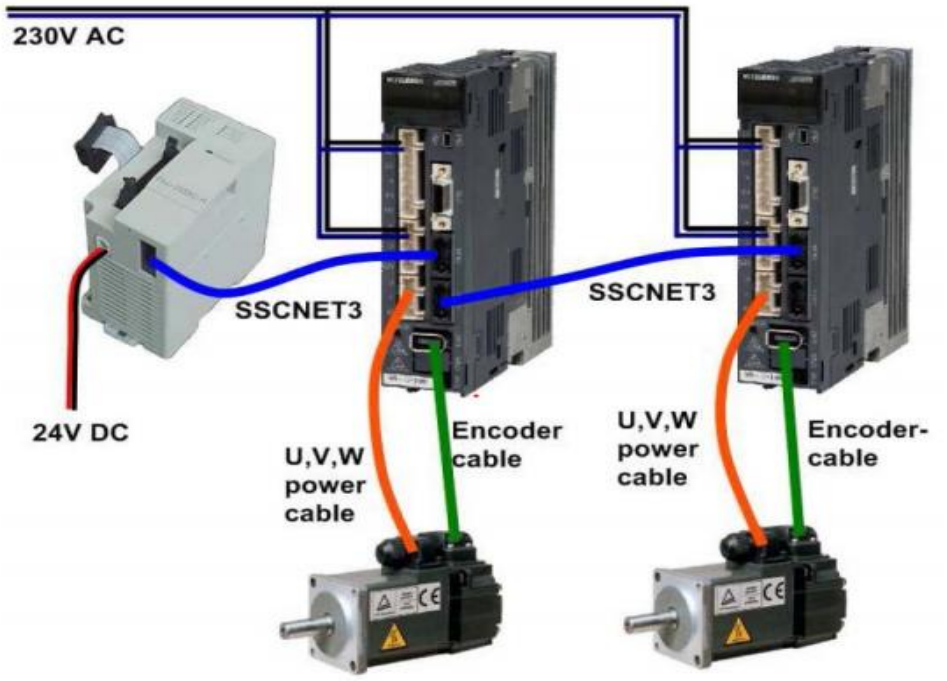


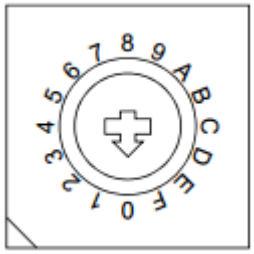
Fig. 2.9: Connection diagram between Melservo and FX_{3U}-20SSC-H

MR-J3-□B servo amplifier directly reads the position data from the encoder. The servo motor's speed /direction control and positioning accuracy with high precision are achieved by reading data from the FX3U-20SSC-H module via the SSCNETIII cable. ***SSCNETIII significantly improves communication speed and noise resistance by using optical communication systems.***

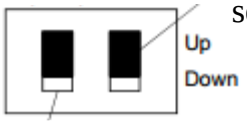
Selection of control axis

Use the rotary axis setting switch (SW1) to set the control axis number for the servo. If the same numbers are set to different control axes in a single communication system, the system will not operater properly. The control axes may be set independently of the SSCNET cable connection sequence.

Rotary axis setting switch (SW1)



SW2



SW2-2: ***Spare*** (be sure to set to the "Down" pos.)

Test operation select switch (SW2-1)
Set the test operation select switch to the "Up" performing the test operation mode by using MR Configurator.

Table 2.2: Status table of the switch on MelServo MR-J3-□B

Spare	Rotary axis setting switch (SW1)	Description	Display
Down (Be sure to set to the "Down" position.)	0	Axis No.1	01
	1	Axis No.2	02
	2	Axis No.3	03
	3	Axis No.4	04
	4	Axis No.5	05

	5	Axis No.6	06
	6	Axis No.7	07
	7	Axis No.8	08
	8	Axis No.9	09
	9	Axis No.10	10
	A	Axis No.11	11
	B	Axis No.12	12
	C	Axis No.13	13
	D	Axis No.14	14
	E	Axis No.15	15
	F	Axis No.16	16

Example:

Table 2.3: Set axis number on the model

Model	Axis Control	Hardware	
		SW1	Axis select
MR-J3-☐B, MR-J3-☐BS, MR-J4-☐B	X-axis	0	Axis No.1
	Y-axis	1	Axis No.2
MR-J3W-☐B, MR-J4W2-☐B	X-axis	0	Axis No.1 (A- Axis)
	Y-axis		Axis No.2 (B- Axis)

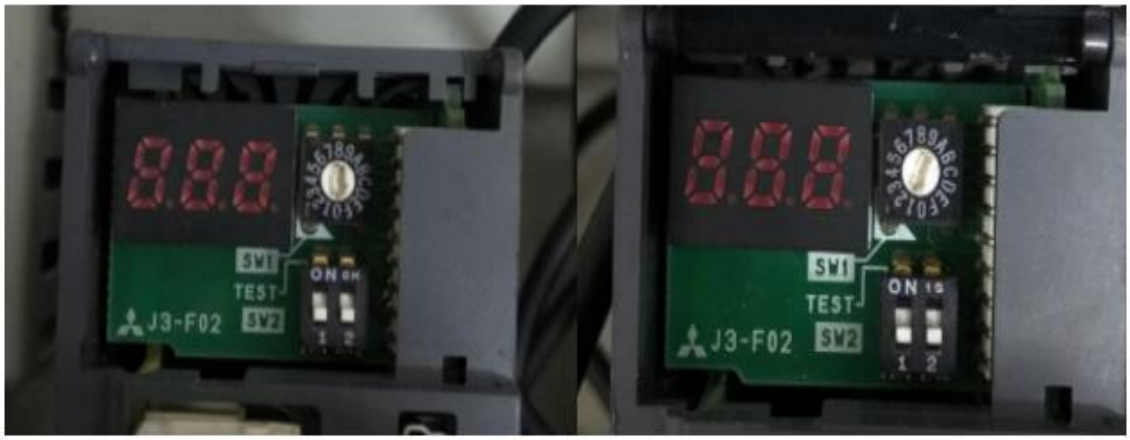


Fig. 2.10: Adjust the number of axis on the model

Note: *When running* ***JOG*** *on the MR-Configrutor software,* ***set SW1 to 0, SW2-1 to ON****.*

- **Servo amplifier display on the Melservo MR-J3-□B**

Ab	Waiting for servo system controller power to switch ON
Ab.	(SSCNET communication)
AC	Initial data communication with servo system controller (Initialization
Ad	
AE	
AF	
AH	
b01	Ready OFF/servo OFF
C01	Ready ON/servo OFF
d01	Ready ON/Servo ON
50	Flicker display at occurrence of overload
E1	Flicker display at occurrence of overload warning
E7	Flicker display during controller forced stop
E6	Flicker display during forced stop
AA	Servo system controller power OFF to ON

On the display of a servo amplifier MR-J3-□B, let's check the communication status with a controller when the power is ON; check the no. of axis, and diagnose errors when having alarms.

2.2.3. SSCNET III cable

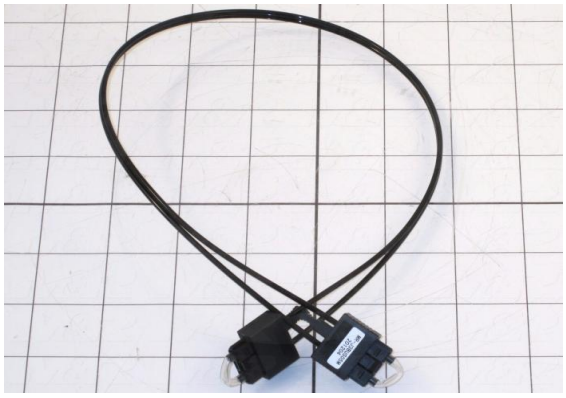


Fig. 2.11: SSCNET III cable

SSCNET III cable uses optical communication, two-way communication with high transfer rate. This is a specialized cable that can be connected and disconnected easily, because using optical communication method should be capable of high interference.

With a ***transfer rate of up to 150 Mbps***, the SSCNET III cable can handle up to three times faster than traditional transmission methods.

Note when using cable SSCNET III:

- ✓ Do not let the SSCNET III cable near the main cable, power lines, and installation standards 100mm (3.94") away from the large power lines, which can cause excitation or interference wave.
- ✓ When removing the SSCNET III cable from the FX3U-20SSC-H port, be sure to attach the protection caps to the cable connectors.
- ✓ Do not remove the SSCNET III cable from its port while not disconnecting the FX3U-20SSC-H or Melservo MR-J3-20B power supply. Do not look directly at the optical fiber head or SSCNET III port, as doing so can cause eye damage.
- ✓ When handling the SSCNET III cable, do not let them be bumped, side pressure, excessive tension. Do not allow oils, solvents near the SSCNET III connector.
- ✓ Do not remove the protection cap from the FX3U-20SSC-H connector until the SSCNET III cable is connected. To avoid the dust coming in, this affects the speed of the cable.

3. OPERATION OF THE MODEL

3.1 General diagram of the system

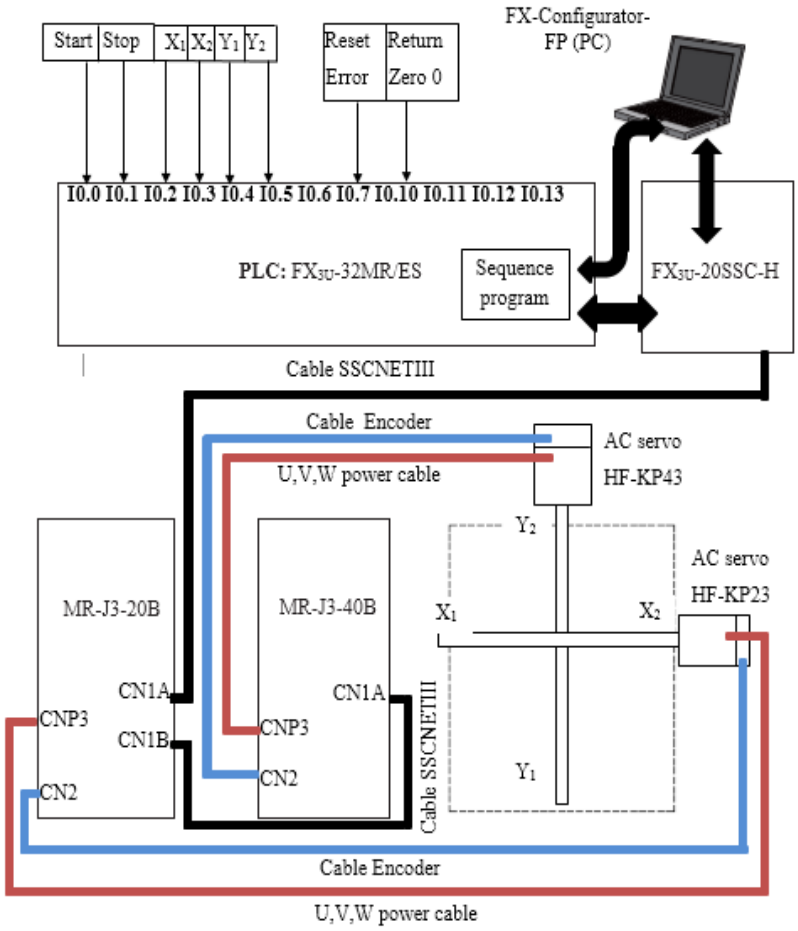


Fig. 2.12: Diagram of the control principle of the model

The X-axis and Y-axis operate in two ways: controlled by FX-Configrutor FP software or PLC programming.

3.2 Data transfer process

- ***Power-on data transfer process (A):***
  - ✓ The data in the 20SSC-H flash memory is transferred to the buffer memory (BFM).
  - ✓ The servo parameters are transferred to the servo amplifier.
- ***Data transfer between PLC and BFM (B):***
  - ✓ Applied instructions such as the MOV, or the FROM/TO instruction are used to read/write parameters and data between the PLC and buffer memory.
- ***Writing data to the flash memory (C)***

✓ Using ***FX Configurator-FP*** to modify the buffer memory data including positioning parameters, servo parameters and table information, then activate a save command from the buffer memory to the flash memory.

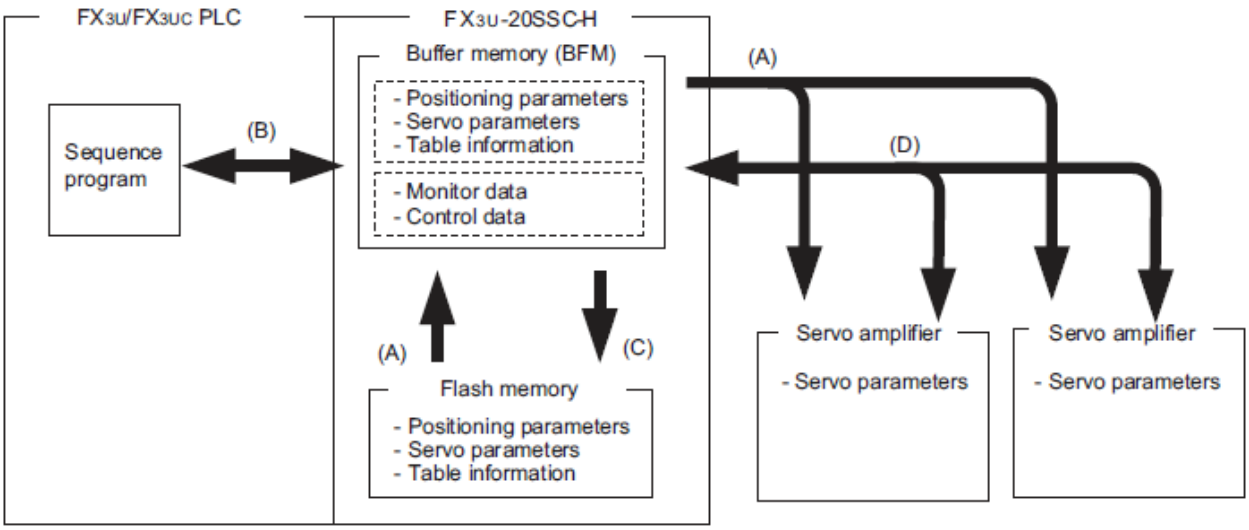


Fig. 2.13: Data transfer process between the modules

➢ ***Data transfer process between 20SSC and servo amplifier (D)***

✓ When servo parameters on the servo amplifier side are modified, the buffer memory of the 20SSC-H is (by default) automatically updated

3.2.1 FX-Configurator FP software

✓ The ***user table data*** are declared on the FX-Configurator FP software and loaded onto the Mitsubishi FX3U-20SSC-H.

✓ The software is switches to "Test Mode" which has control modes (positioning at 1-step speed, linear interpolation, X-axis table operation, XY-axis table operation,...)

✓ Select target address 1, operation step 1, click start -> the model will move to the address you selected via USB to RS422 adapter.

✓ SSCNETIII cables are adopted for data communication with dedicated Melservo (MR-J3-xB)

Note: ***This model uses screw-pitch with 5mm screws that means every rotation of the AC servo will make a displacement of 5mm, and with the dedicated module of FX3U-20SSC-H, 262144 PLS will make the motor turn a round.***

3.2.2 PLC FX3U-32M

- ✓ User program written on GX-Developer/Work2 software is loaded into the PLC.
- ✓ When users press the START button on the control pannel, the table data that the ones have declared will be extracted from the memory area of the FX3U-20SSC-H, and control the movements of axes according to given information. SSCNETIII cables are used for data communication.
- ✓ We also use PLC to communicate with the FX-Configurator FP software and read the whole information that input by users such as positions' coordinates, linear or circular movements.

4. EXPERIMENT

4.1. FX_{3U}-20SSC-H with FX Configurator-FP

➢ **<u>Step 1</u>:** Configuration for FX_{3U}-20SSC-H

- When setting up the FX_{3U}-20SSC-H for the first time or beginning a new project, it is recommended to ***clear the servo parameters, positioning parameters and table information, and then write the desired settings (as needed by the user application) to the controller***.
- The purpose of this section is to define basic settings for the initial testing of the FX_{3U}-20SSC-H using the FX Configurator-FP software. Using FX-Configurator FP to configure the system as follows:

1) Turn on the power

Confirm that the hardware is set up correctly and the PLC is in STOP mode. Turn the power ON. (Both of the servos should display 'Ab' when the power is turned ON for the very first time.)

2) Load the software

Open FX Configurator-FP from the Start menu [Start] → [MELSOFT Application] → [FX Configurator-FP] or from the Tools menu of GX Developer [Tools] → [FX special function utility] → [FX Configurator-FP] and create a New file by clicking on  in the Toolbar.

3) ***Expend the tree of folders*** in the [File data list] panel on the left-hand side by double clicking on [Unset file], [Edit], and [Monitor].

4) Verify communication

Go to [Online] → [Connection setup] → [Comm. Test]. Verify that the devices are communicating properly.

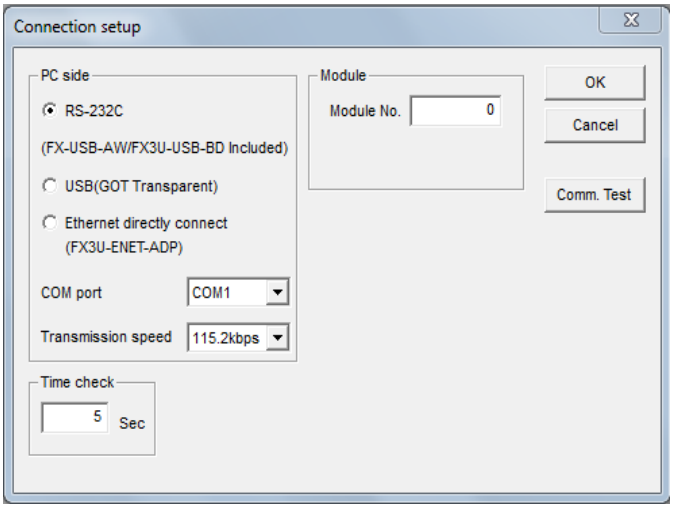


Fig. 2.14: Connection setup with FX_{3U}-20SSC-H

5) Initialize the module

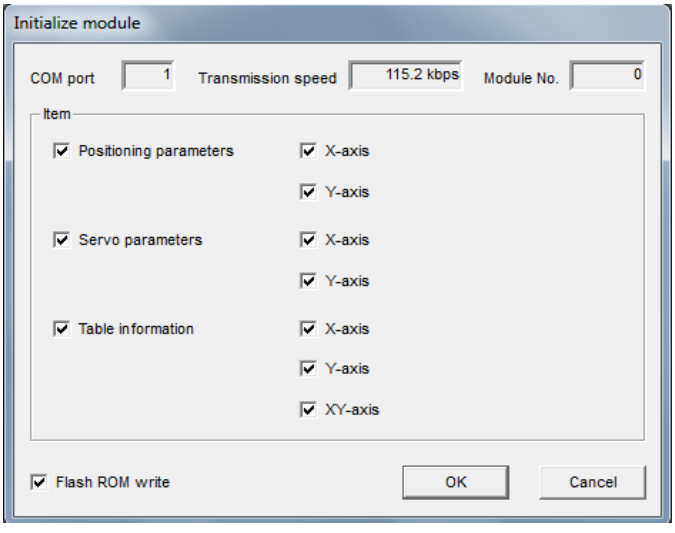


Fig. 2.15: Initialize the module

Go to [Online] → [Initialize module]. Select all servo parameters, positioning parameters and table information and place a check mark in [Flash ROM write]. Click the OK button and proceed with selecting 'Yes' and then 'OK'.

This overwrites all data in the FX_{3U}- 20SSC-H buffer memory and Flash ROM with the default.

6) Set the positioning parameters

Double click on [Positioning parameters] in the [File data list] panel on the left-hand side to modify the positioning parameters.

Change the following items from the [Item] column:

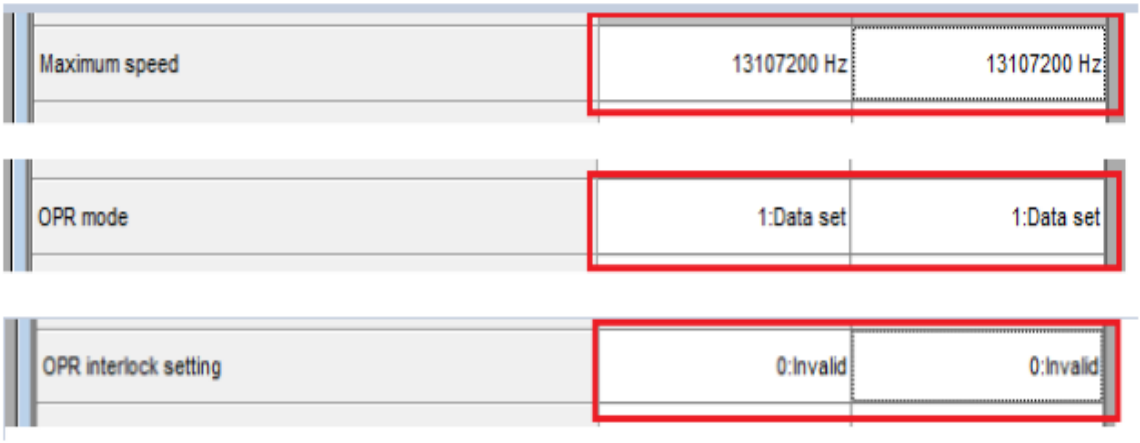


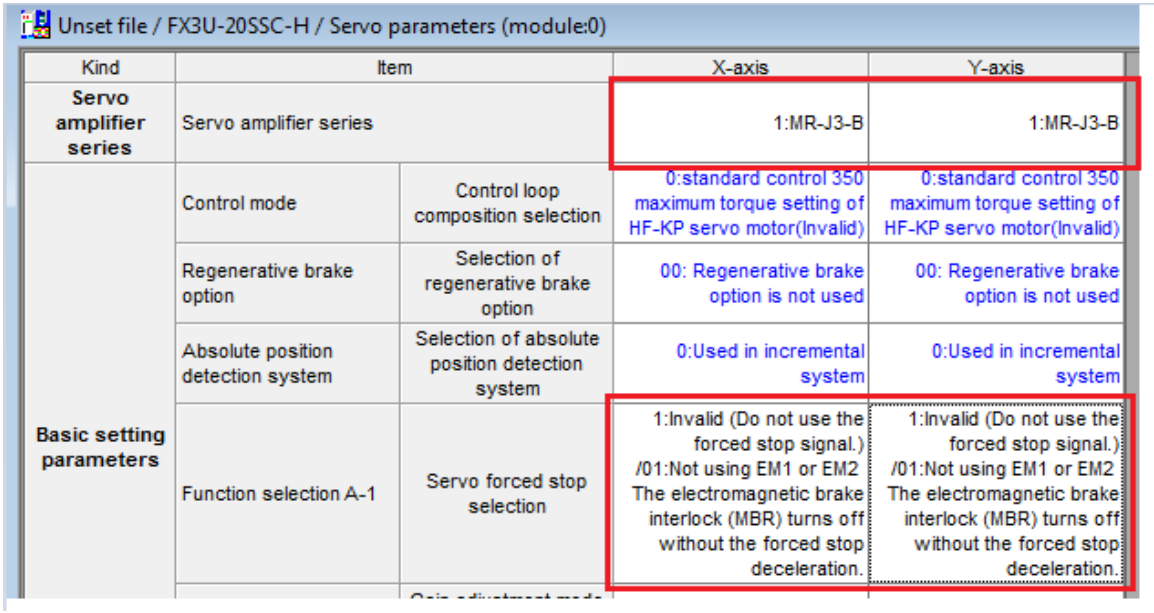
Fig. 2.16: Positioning parameters

(Note: Maximum speed = $V_{AC\ servo}$ x 262144 x $\frac{1}{60}$ = 3000 x262144:60 = 13107200)

7) Set the servo parameters

Assuming a forced stop switch is not used with the MR-J3-B servos, double click on [Servo parameters] in the [File data list] panel on the left-hand side to modify the servo parameters.

Set the following items from the [Kind] column for both the X- and Y- axes:



Kind	Item		X-axis	Y-axis
Servo amplifier series	Servo amplifier series		1:MR-J3-B	1:MR-J3-B
Basic setting parameters	Control mode	Control loop composition selection	0:standard control 350 maximum torque setting of HF-KP servo motor(Invalid)	0:standard control 350 maximum torque setting of HF-KP servo motor(Invalid)
	Regenerative brake option	Selection of regenerative brake option	00: Regenerative brake option is not used	00: Regenerative brake option is not used
	Absolute position detection system	Selection of absolute position detection system	0:Used in incremental system	0:Used in incremental system
	Function selection A-1	Servo forced stop selection	1:Invalid (Do not use the forced stop signal.) /01:Not using EM1 or EM2 The electromagnetic brake interlock (MBR) turns off without the forced stop deceleration.	1:Invalid (Do not use the forced stop signal.) /01:Not using EM1 or EM2 The electromagnetic brake interlock (MBR) turns off without the forced stop deceleration.

Fig. 2.17: Servo parameters

8) Write the servo and positioning parameters

Write  the servo parameters and positioning parameters to the FX_{3U}-20SSC-H by pressing the 'Write to module' button or by using [Online] → [Write to module (Ctrl+T)]. ***Select only the servo and positioning parameters and put a check mark in the [Flash ROM write] box as shown below***. The servos may lose communication since a power reset is needed.

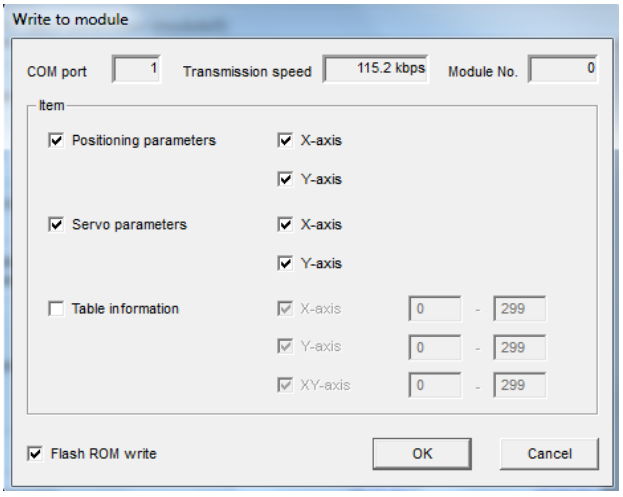


Fig. 2.18: Write parameters to module

9) Reset the power

Reboot the power to the system to enable communication to the MR-J3 servos. This

can be done with a hard boot, or by pressing the 'System reset'  button. Once communication is established, the servos will read '**d01**' and '**d02**'. If communication is not established, check the servo hardware and servo parameters again.

- **Step 2: Using TEST MODE**

Verify that the PLC is in STOP mode before proceeding with this section.

To enter TEST MODE, press the 'Test On/Off' button  in the Test toolbar or go to [Online] →[Test] → [Test On/Off]. Select 'Yes' and then 'OK'.

Open up the X- and Y- axis Operation test windows by clicking on the two buttons:  and  .

- **Step 3: JOG operation, X-axis**

In the [X-axis Operation test] window, click on the [JOG/MPG] tab. Click and hold down the FWD JOG button. Try changing the JOG speed and JOG instruction evaluation time.

(For more information on the JOG instruction evaluation time, refer to Chapter 8.2.1 in the FX3U-20SSC-H User's Manual (JY997D21301E))

If positioning does not begin, verify that Positioning and Servo parameters are set for the X- and Y- axes as described in (6) and (7) of *Step 1*.

- **Step 4: Setting the zero point**

When the zero-point is set, the current address data gets set to the zero-point value. This is accomplished by directly changing the current address to 0 (or some other address), or by activating the zero return command in the data-set type OPR mode.

Click on the X-axis and Y-axis [OPR] tabs and then click the [REQ. OPR] button and select 'Yes' anh 'OK'.

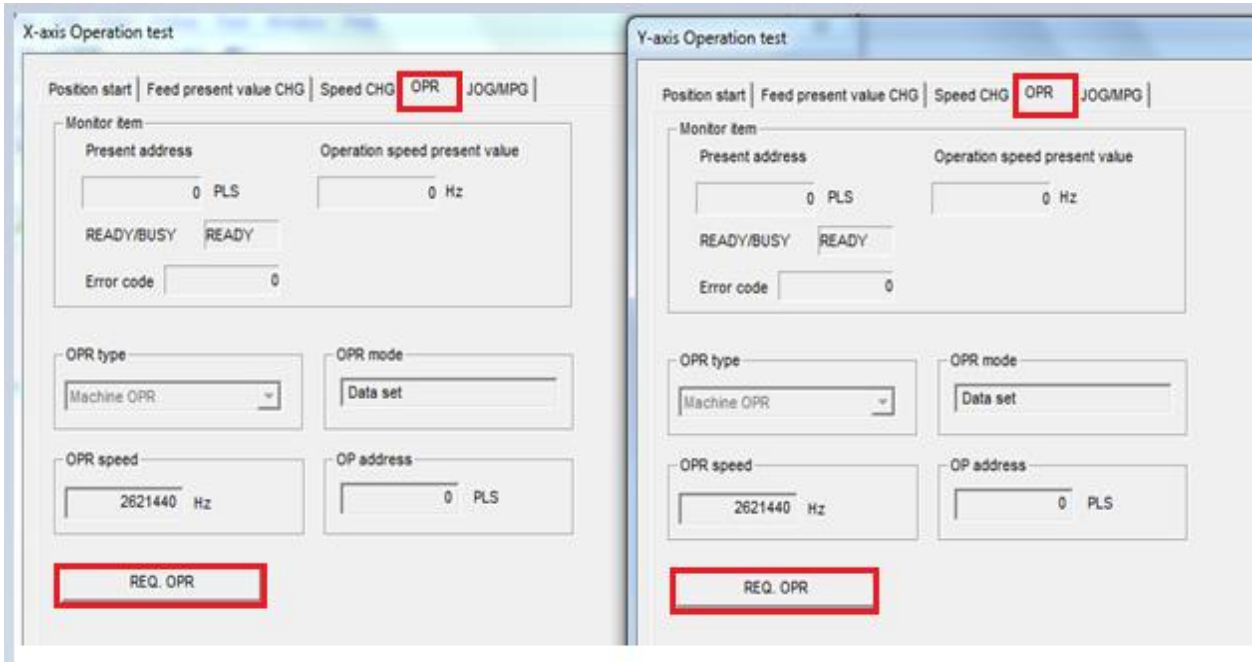


Fig. 2.19: Setting the zero point

➢ **<u>Step 5</u>: Positioning patterns, X-axis**

By default, the FX3U-20SSC-H is set to absolute positioning. If you want to place a relative position, use a table program (declared on FX-Configrutor FP software) or PLC program to specify [Incremental mode]. The following are some of the control modes on the FX-Configrutor FP software

- ***<u>Positioning at 1-step speed</u>***
  - ✓ Set the zero-point according to *Step 4: Setting the Zero Point* above if you haven't already done so.
  - ✓ Click on the [Position start] tab and select [Positioning at 1-step speed] in the X-axis Pattern drop-down menu. Set the following X-axis information:

Target address 1:	5,000,000 PLS
Operation speed 1:	1,000,000 Hz

  - ✓ Click on the [Start] button and observe the motor. Click 'Yes' and 'OK'.
  - ✓ If positioning does not begin, verify that Positioning and Servo parameters are set for the X and Y axes as described in (6) and (7) of *Step 1*.

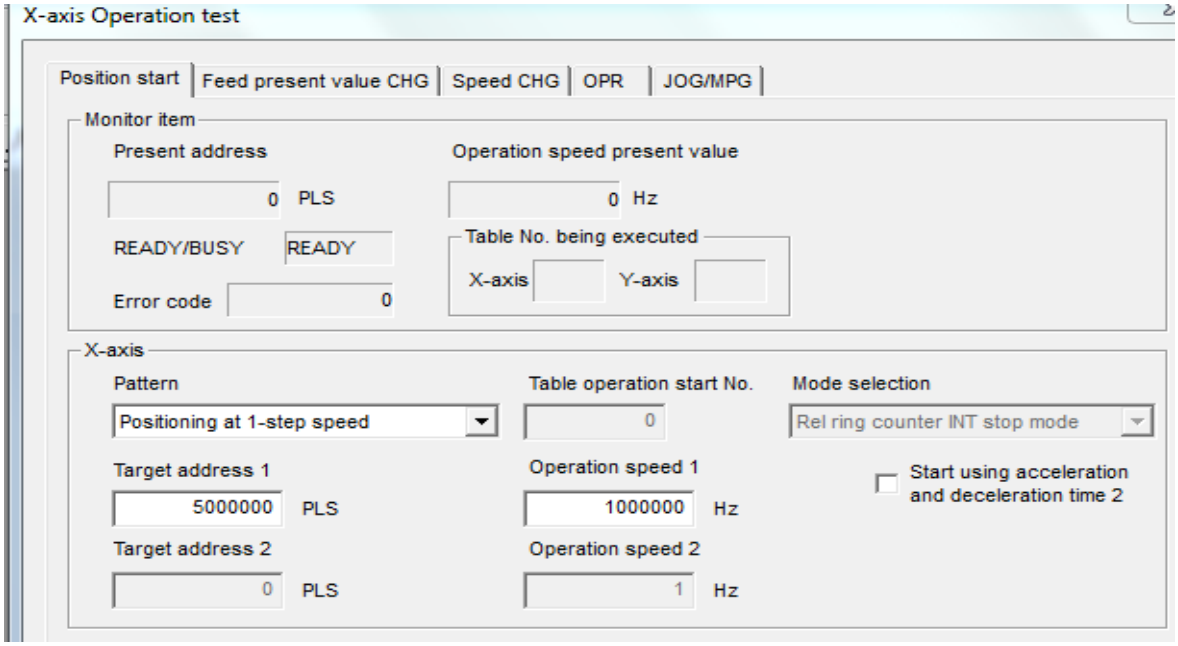


Fig. 2.20: Positioning at 1-step speed, X-axis

Positioning at 2-step speed

✓ Select [Positioning at 2-step speed] in the X-axis Pattern drop-down menu of the [Position start] tab. Set the following X-axis information:

Target address 1:	-2,000,000 PLS
Operation speed 1:	2,000,000 Hz
Target address 2:	0 PLS
Operation speed 2:	1,000,000 Hz

✓ Click on the [Start] button and observe the motor. Click ‘Yes’ and ‘OK’.

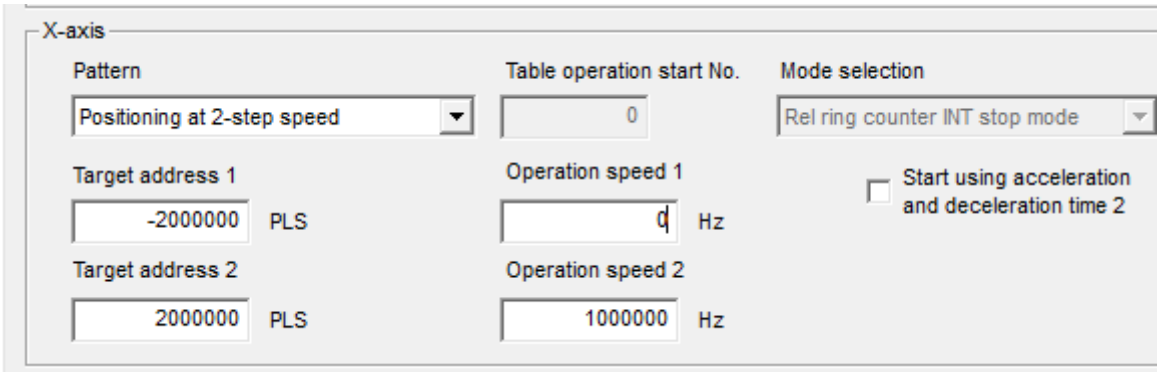


Fig. 2.21: Positioning at 2-step speed, X-axis

- ***Variable speed operation***

  - ✓ Select [Variable speed operation] in the X-axis Pattern drop-down menu of the [Position start] tab. Set the following X-axis information:

Operation speed 1:	5,000,000 Hz

  - ✓ Click on the [Start] button and then 'Yes' and 'OK'.
  - ✓ Now click on the [Speed CHG] tab to adjust the speed during operation. Try adjusting the [Speed override] setting by entering the following values into the [Speed override] box and pressing the [REQ. speed override] button.

3,000 (x0.1%)

500 (x0.1%)

10 (x0.1%)

Note: the speed changes that occur with each setting. Finally, click the [Stop] button, 'Yes,' and 'OK'.

- ***Linear interpolation***

  - ✓ Return the X- and Y- addresses to '0' by setting the zero-point according to ***Step 4: Setting the Zero Point.***
  - ✓ Select [Linear interpolation] in the X-axis Pattern drop-down menu of the [Position start] tab. Set the following X-axis information:

X-axis

Target address 1:	1,000,000 PLS
Operation speed 1:	1,000,000 Hz

Y-axis

Target address 1:	5,000,000 PLS

  - ✓ Click on the [Start] button and observe the motors. Click 'Yes' and 'OK'.
  - ✓ If positioning does not begin, verify that Positioning and Servo parameters are set for the X and Y axes as described in (6) and (7) of *Step 1*.

XY-axis table operation

✓ To operate the XY axis table, enter the data in the "XY- axis Table information" on the FX-Configrutor FP software. And write to the PLC. You can refer to the example table below

No.	Command Code	Address x:[PLS] y:[PLS]	Speed fx:[Hz] fy:[Hz]	Arc center i:[PLS] j:[PLS]	Time [10ms]	Jump No.	m code
0	Incremental address specification						-1
1	X-axis positioning at 1-step speed	2,000,000	1,000,000				-1
2	Y-axis positioning at 1-step speed						-1
		2,000,000	1,000,000				
3	XY-axis positioning at 1-step speed	5,000,000	1,000,000				-1
		-5,000,000	1,000,000				
4	Circular interpolation (CNT,CW)	0	1,500,000	500,000			-1
		0		500,000			
5	Dwell				30		-1
6	XY-axis positioning at 2-step speed	1,000,000	1,000,000				-1
		-1,000,000	1,000,000				
7	XY-axis positioning	-1,000,000	1,000,000				

	at 2-step speed						
		1,000,000	1,000,000				
8	Dwell				30		-1
9	XY-axis positioning at 2-step speed	1,000,000	1,000,000				-1
		-1,000,000	1,000,000				
10	XY-axis positioning at 2-step speed	-1,000,000	1,000,000				
		1,000,000	1,000,000				
11	Dwell				30		-1
12	Circular interpolation (CNT,CCW)	0	700,000	500,000			-1
		0		500,000			
13	Dwell				30		-1
14	XY-axis positioning at 2-step speed	1,000,000	1,500,000				-1
		5,000,000	750,000				
15	XY-axis positioning at 2-step speed	-5,000,000	750,000				

		-1,000,000	1,500,000				
16	Dwell				30		-1
17	Linear interpolation	2,000,000	262,144				-1
		-2,000,000					
18	Dwell				150		-1
20	End						

With PLS addresses, the numbers can be very large. To reduce the number size, the Position data magnification item can be changed to "3:x1000 times" in the **[Positioning parameters]**. If this is changed with data already entered in a table information window, the fields with addresses that lay outside the range –2,147,483,648 to 2,147,483,647 will be highlighted in RED, indicating they must be changed.

After entering the above table, click on the  button or use **[Online] →[Write to module (Ctrl+T)]**. Remove checkmarks from [Positioning parameters] and [Servo parameters] and put a checkmark in [Table information]. Unselect the [X-axis] and [Y-axis], put a checkmark in [XY- axis], and modify the table number range (table rows) to 0 – 25. This will decrease the download time to the FX_{3U}-20SSC-H. Unselect the [Flash ROM write] checkbox, click 'OK' and then 'OK' again.

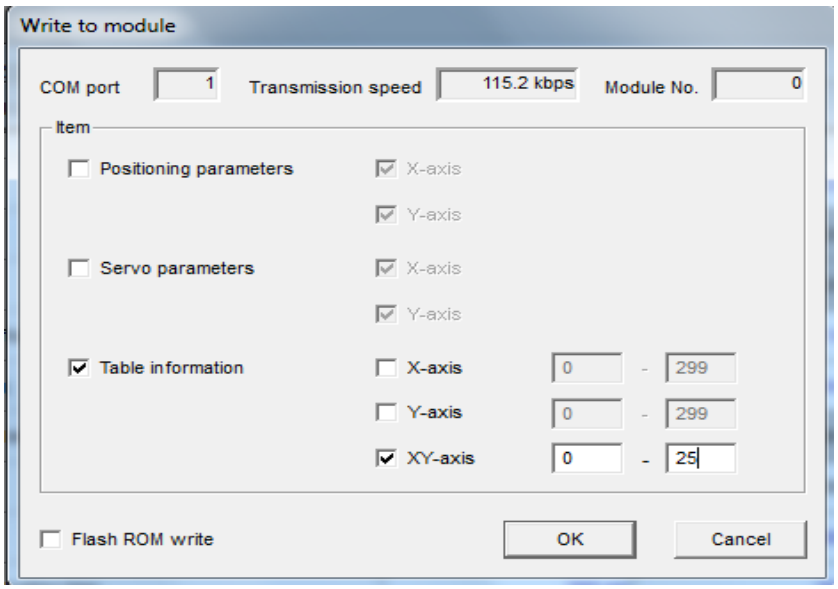


Fig. 2.22: Write information stable to PLC

Select [XY-axis table operation] in the X-axis Pattern drop-down menu of the [Position start] tab. Set the [Table operation start No.] as desired (0 in this example) and begin positioning by pressing the [Start] button, 'Yes,' and 'OK'.

If positioning does not begin, verify that Positioning and Servo parameters are set for the X and Y axes as described in (6) and (7) of ***Step 1***.

- **Step 6:** Using Monitor Model

  - To use operation monitor during positioning, first enable the XY-operation Table pattern in TEST MODE and begin its operation by following *Section XY-axis table operation* above. Do not stop the operation. Instead, click on the Close button to exit the X-axis Operation test window.

Press the 'Test On/Off' button  in the Test toolbar and click 'Yes' to turn TEST MODE off. Double-click on [Operation monitor] in the [File data list] panel on the left-hand side. Click on the [Monitor Start] button and experiment with the [X-axis Operation status] and [Y-axis Operation status] buttons to monitor axis control data such as target addresses and operation speeds and servo status. By clicking on the [Signal] button, the FX_{3U}-20SSC-H monitor data can be displayed for useful feedback. The Operation Monitor is also helpful for determining positioning errors.

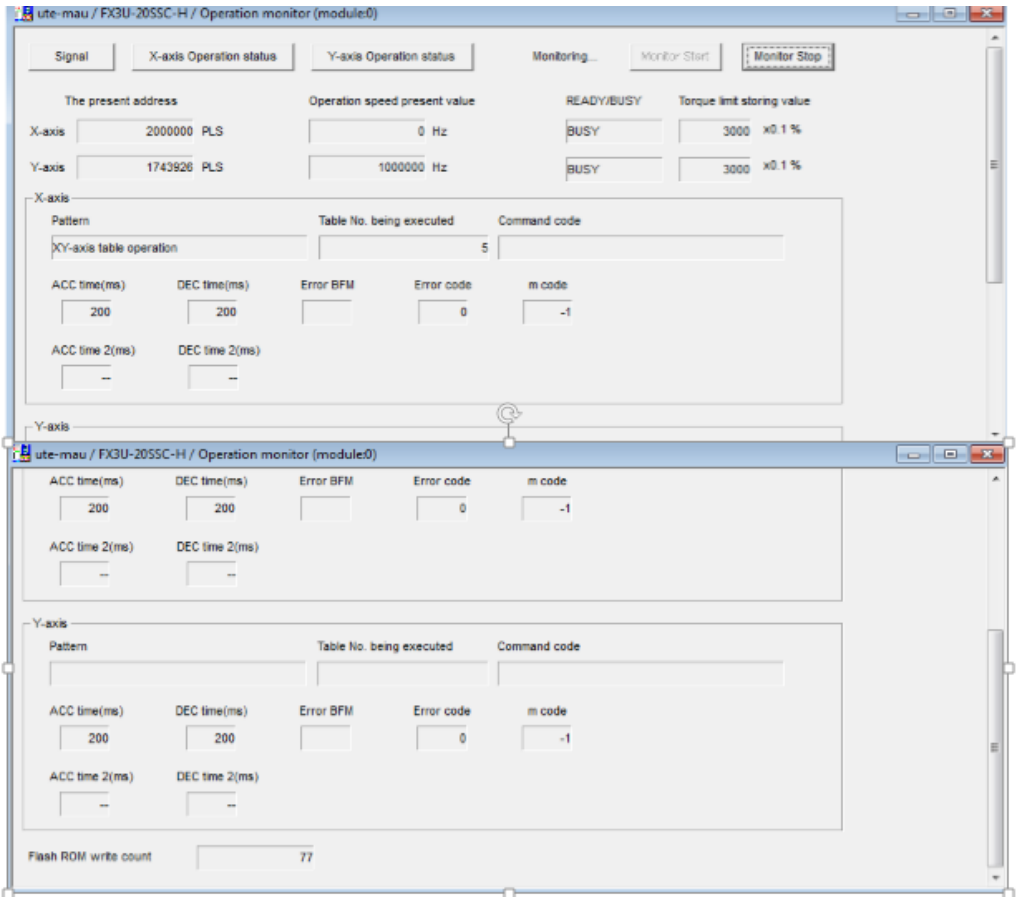


Fig. 2.23: Operation Monitor

4.2. FX3U-20SSC-H with GX Developer/Work2.

- **<u>Step 1</u>: Creat a new Project**
  - ✓ Open GX-Developer by clicking [Start] → [GX-Developer] or double-clicking on the GX-Developer software icon on the desktop. Click on display GX-Developer software or press ***"Ctrl+N"***

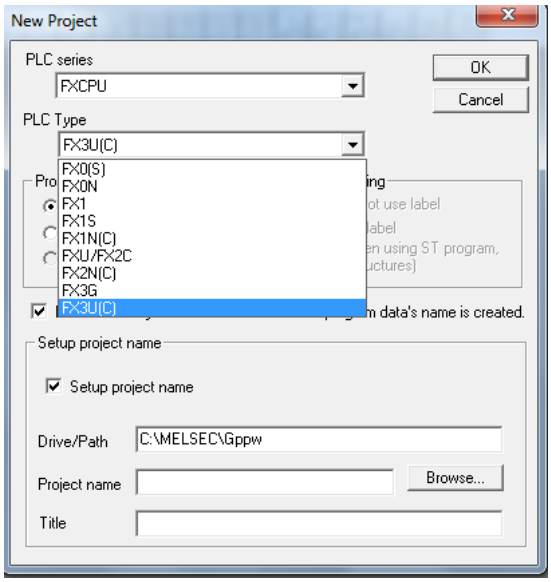


Fig. 2.24: Choose PLC series (FX3U)

- ✓ Select ***"FXCPU"*** in the item *"PLC series"*. Then select ***"FX3U(C)"*** in the item *"PLC Type"*
- ✓ Check ***'Ladder'***, choose setup project name then enter the project name, after that choose address of the folder you want to save this project. Then press Creat new

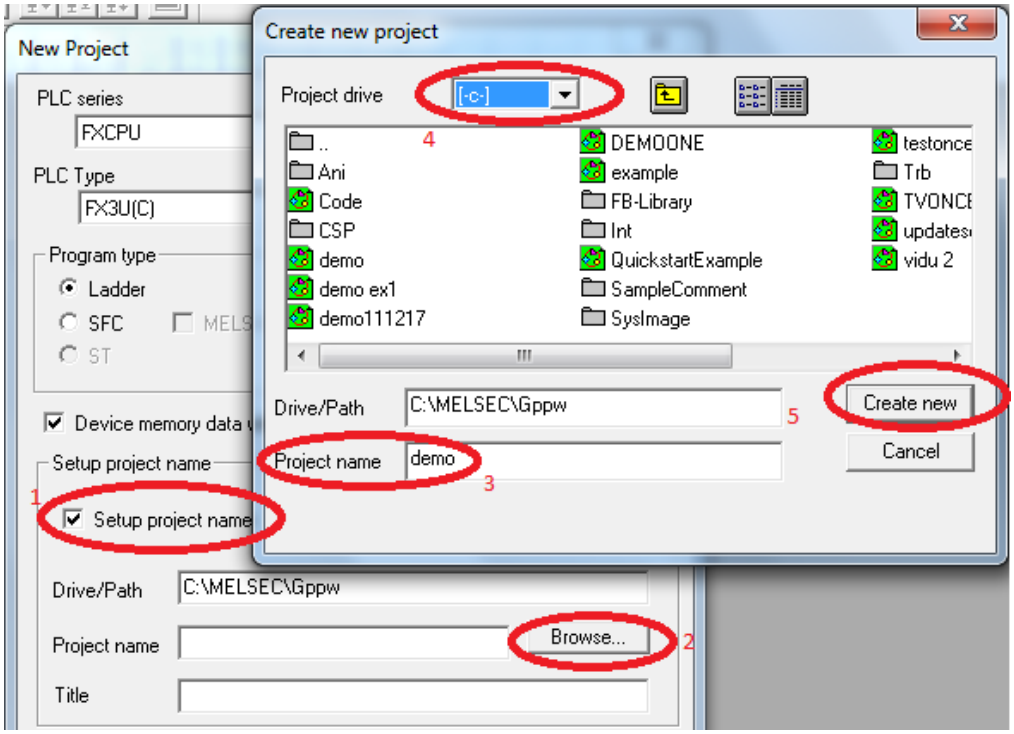


Fig. 2.25: Create a new project on GX-Developer

- ➢ **<u>Step 2</u>: PLC programming**
  - ✓ This is a sample program written on the GX-Developer software using: Start (X000), Stop (X001), Reset error (X007), Return Zero 0 (X010).
  - ✓ ***When press Start:*** The data information that you installed on the desk will be read from FX3U-20SSC-H, via SSCNETIII cable, transfer to Melservo MR-J3-20B; the control signal from encoder returned makes the AC servo rotate → The machine moves to the installed position on the FX-Configrutor-FP configuration.

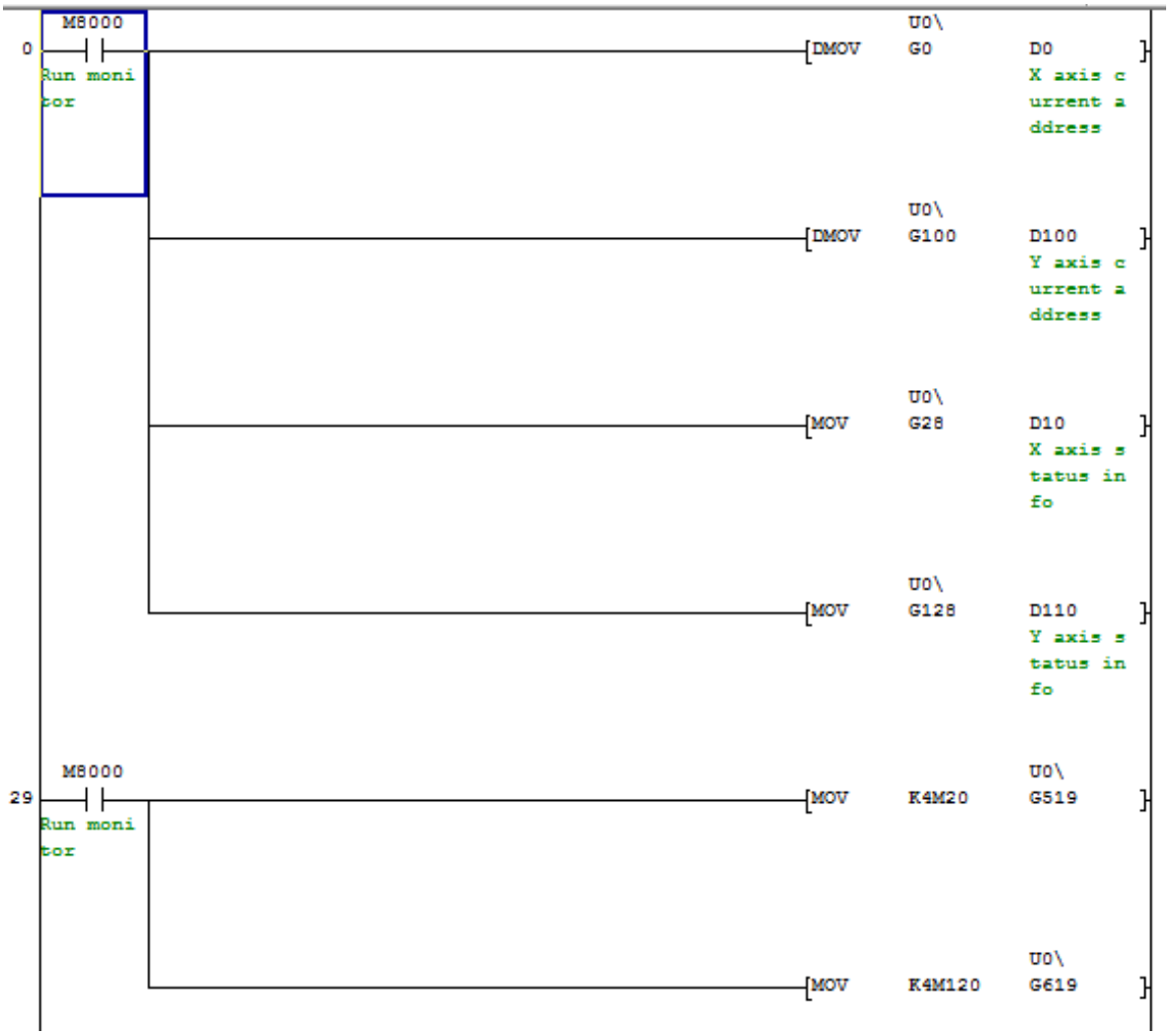
Table 2.5: PLC address assignments

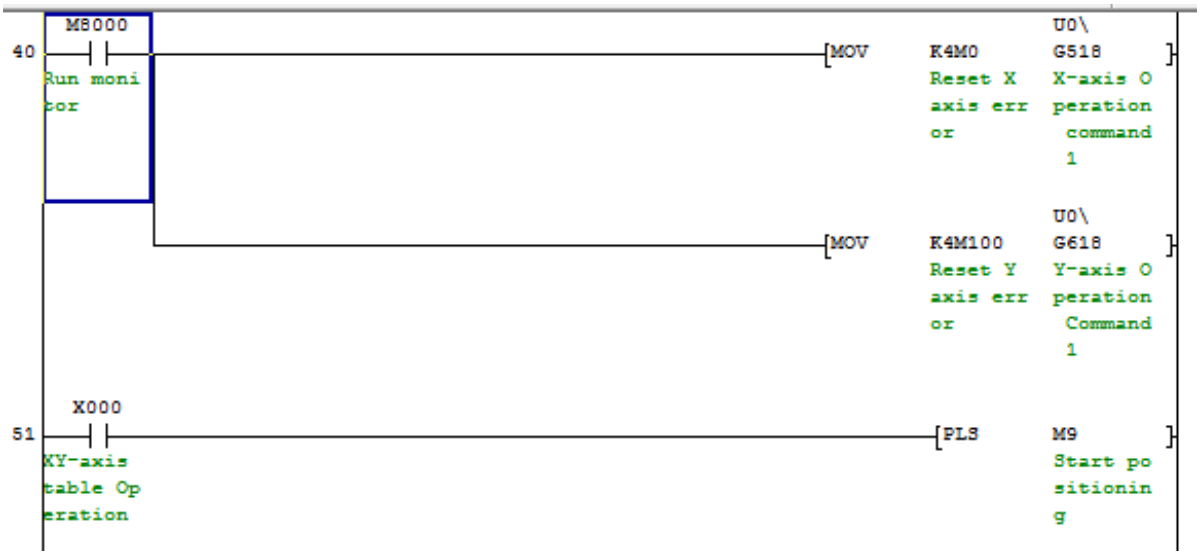
Address	Device name	Remark
X000	Start	NO
X001	Stop	NC

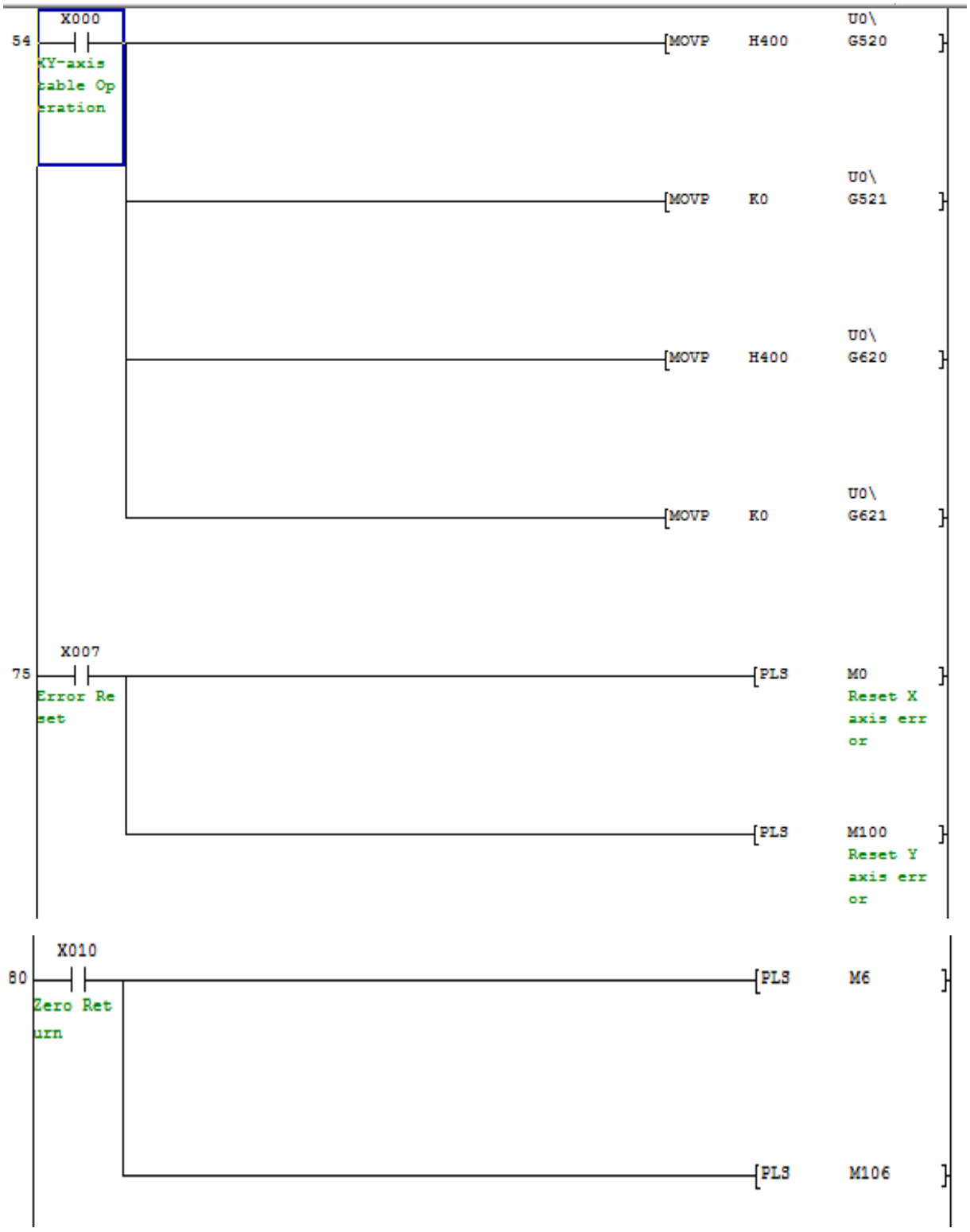
X002	Forward rotation limit (X-axis)	NO
X003	Reverse rotaion limit (X-axis)	NO
X004	Forward rotation limit (Y-axis)	NO
X005	Reverse rotaion limit (Y-axis)	NO
X006	X-axis JOG (+)	NO
X007	Reset Error	NO
X010	Return Zero 0	NO
X011	X-axis JOG (-)	NO
X012	Y-axis JOG (+)	NO
X015	Y-axis JOG (-)	NO
D0	X-axis current address	
D100	Y-axis current address	
U0\G28	X-axis status information	BFM#
U0\G128	Y-axis status information	BFM#
M9	Table operation	
M24	Position, parameter anable command	Enable the X-axis JOG speed
M124	Position, parameter anable command	Enable the Y-axis JOG speed

U0\G14012	BFM# (JOG speed)	X-axis (BFM#14012, #14013)
U0\G14212	BFM# (JOG speed)	Y-axis (BFM#14212, #14213)
M4	X-axis JOD(+) operation is being performed	
M5	X-axis JOD(-) operation is being performed	
M6	X-axis zero return	
M104	Y-axis JOD(+) operation is being performed	
M105	Y-axis JOD(-) operation is being performed	
M106	Y-axis zero return	
U0\G521	Table operation start No.	X-axis
U0\G621	Table operation start No.	Y-axis
U0\G519	Opertion command 2	X-axis
U0\G619	Opertion command 2	Y-axis

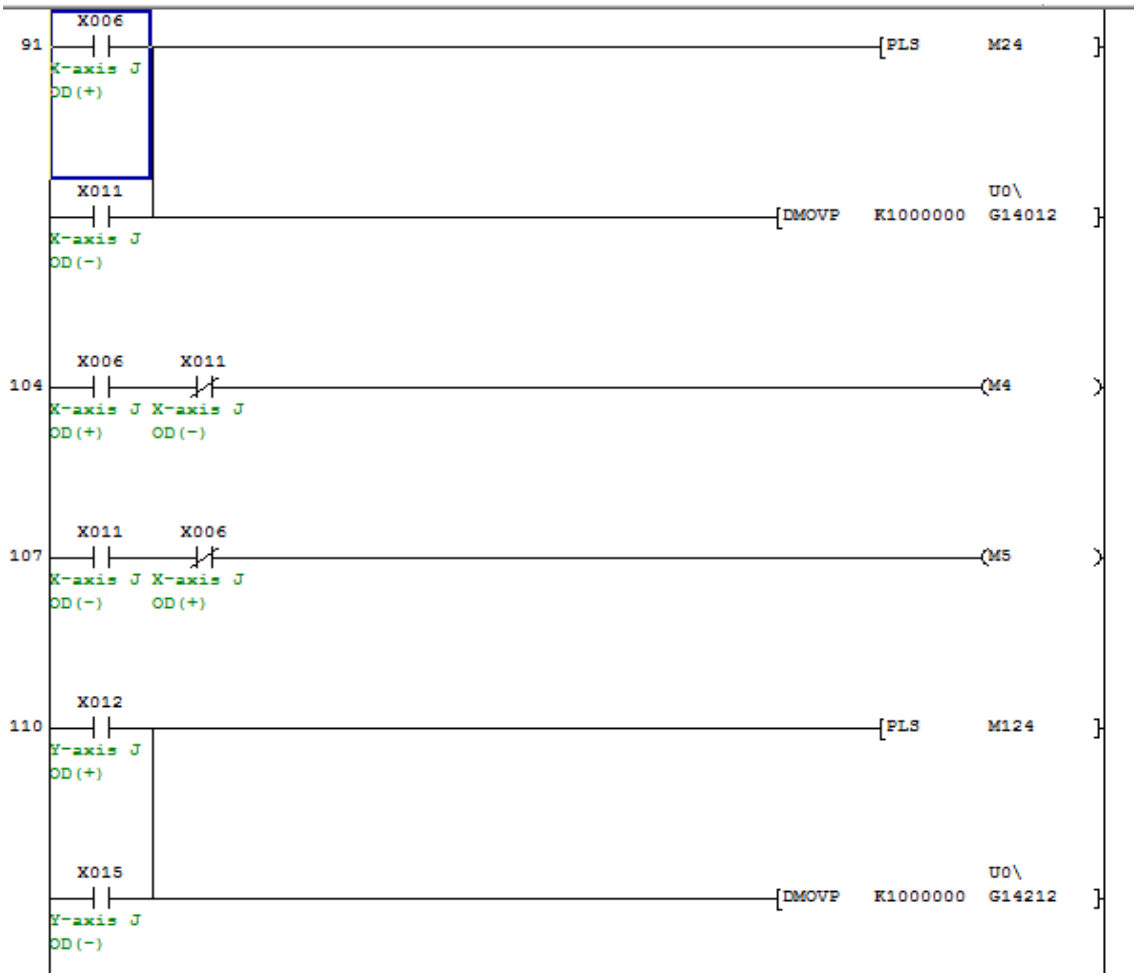
PLC program

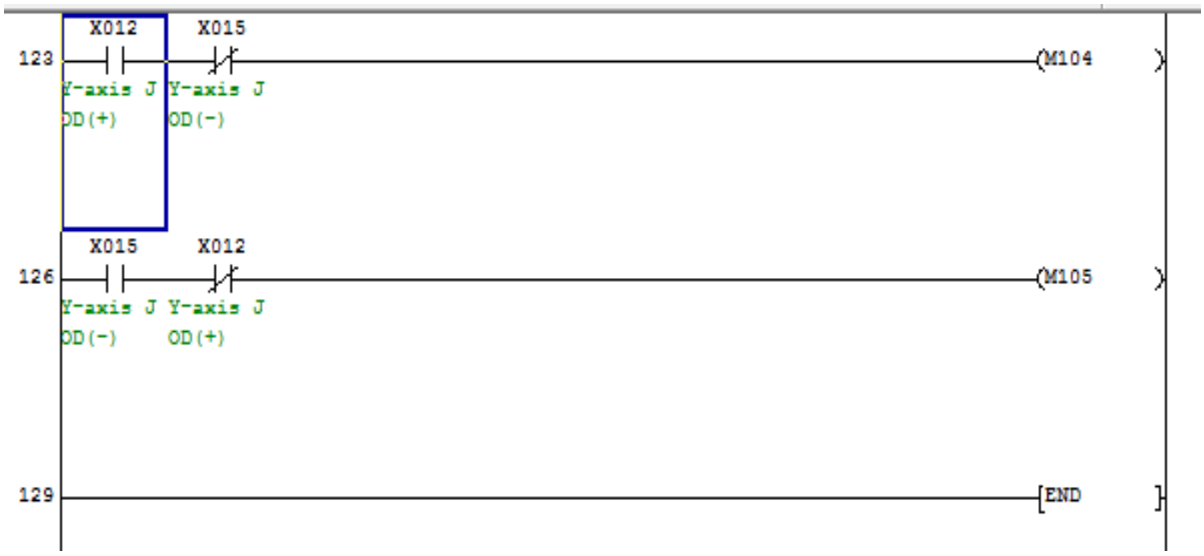

M8000
0
Run monitor
DMOV U0\G0 D0 X axis current address
DMOV U0\G100 D100 Y axis current address
MOV U0\G28 D10 X axis status info
MOV U0\G128 D110 Y axis status info
M8000
29
Run monitor
MOV K4M20 U0\G519
MOV K4M120 U0\G619


M8000
40
Run monitor
MOV K4M0 U0\G518 Reset X axis error X-axis Operation command 1
MOV K4M100 U0\G618 Reset Y axis error Y-axis Operation Command 1
X000
51
XY-axis table Operation
PLS M9 Start positioning


54
X000
XY-axis
table Op
eration
MOVP H400 U0\ G520
MOVP K0 U0\ G521
MOVP H400 U0\ G620
MOVP K0 U0\ G621
75
X007
Error Re
set
PLS M0
Reset X
axis err
or
PLS M100
Reset Y
axis err
or
80
X010
Zero Ret
urn
PLS M6
PLS M106


85
X001
Stop Ope
ration
M1
X002
Forward
rotation
limit X
X003
Reverse
rotation
limit X
X004
Forward
rotation
limit Y
X005
Reverse
rotation
limit Y


91
X006
X-axis J
OD(+)
PLS M24
X011
X-axis J
OD(-)
DMOVP K1000000 U0\
G14012
104
X006
X-axis J
OD(+)
X011
X-axis J
OD(-)
M4
107
X011
X-axis J
OD(-)
X006
X-axis J
OD(+)
M5
110
X012
Y-axis J
OD(+)
PLS M124
X015
Y-axis J
OD(-)
DMOVP K1000000 U0\
G14212



Note that the M8000 is always ON when the PLC is running

- **<u>Step 3</u>: Select the PLC connection method**

  - ✓ **Go online → Transfer Setup → Serial USB**. A PC side I/F serial setting will appear, select the COM port and data transfer speed..

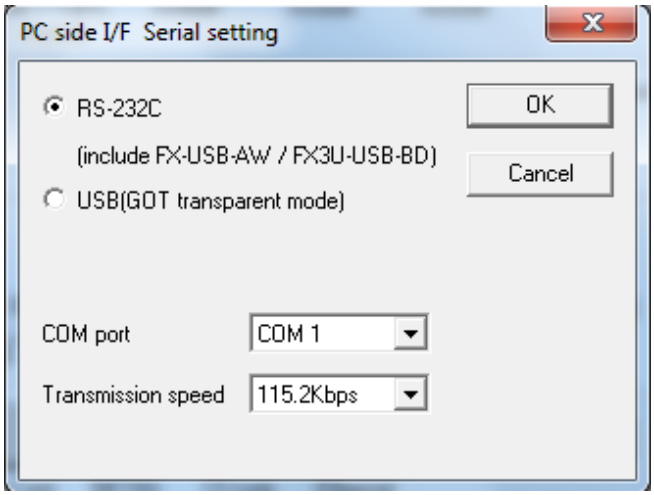


Fig. 2.26: PC side I/F serial setting

- **<u>Step 4</u>: Write a program to PLC**
  - ✓ **Click online→ chose Write to PLC**. Write to PLC will appear, tick main. Press Exucute → Yes → OK. Then click Close

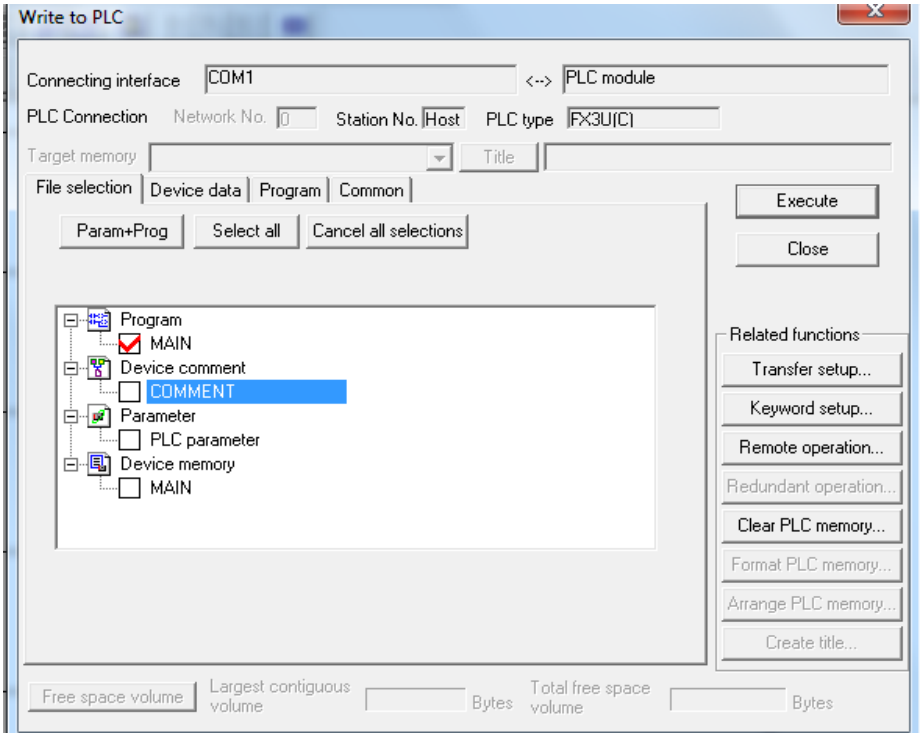


Fig. 2.27: Write a program to PLC

- **<u>Step 5</u>: Use device comment to set up input and output addresses**

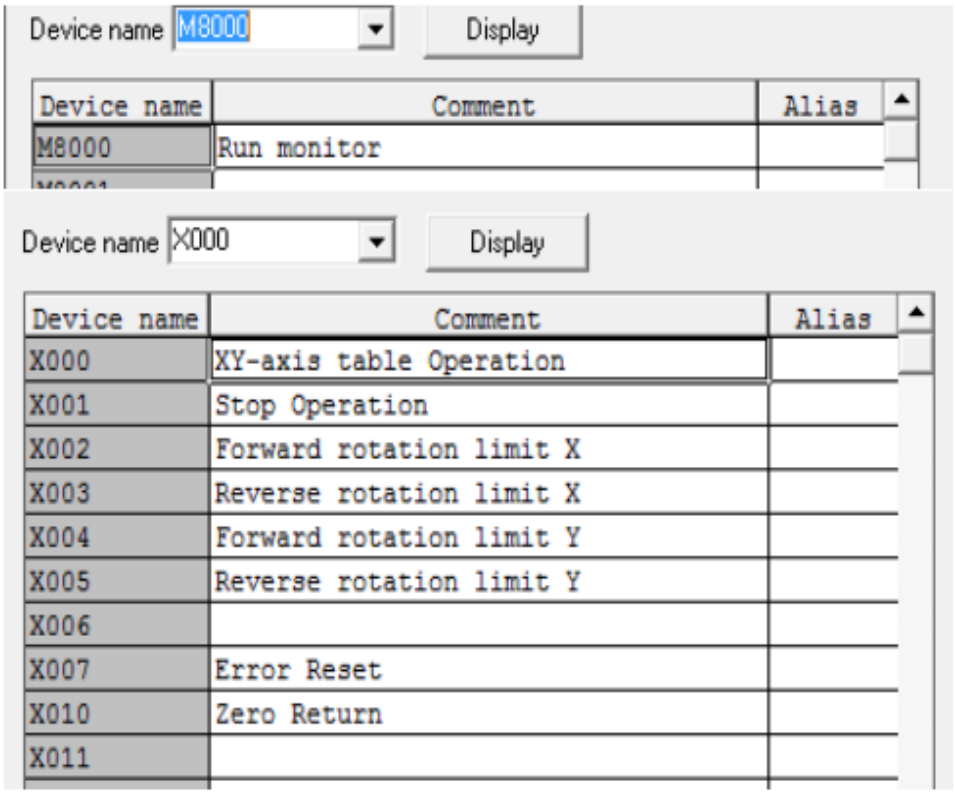


Fig. 2.28: Set up input and output addresses

An example of the interpolation results

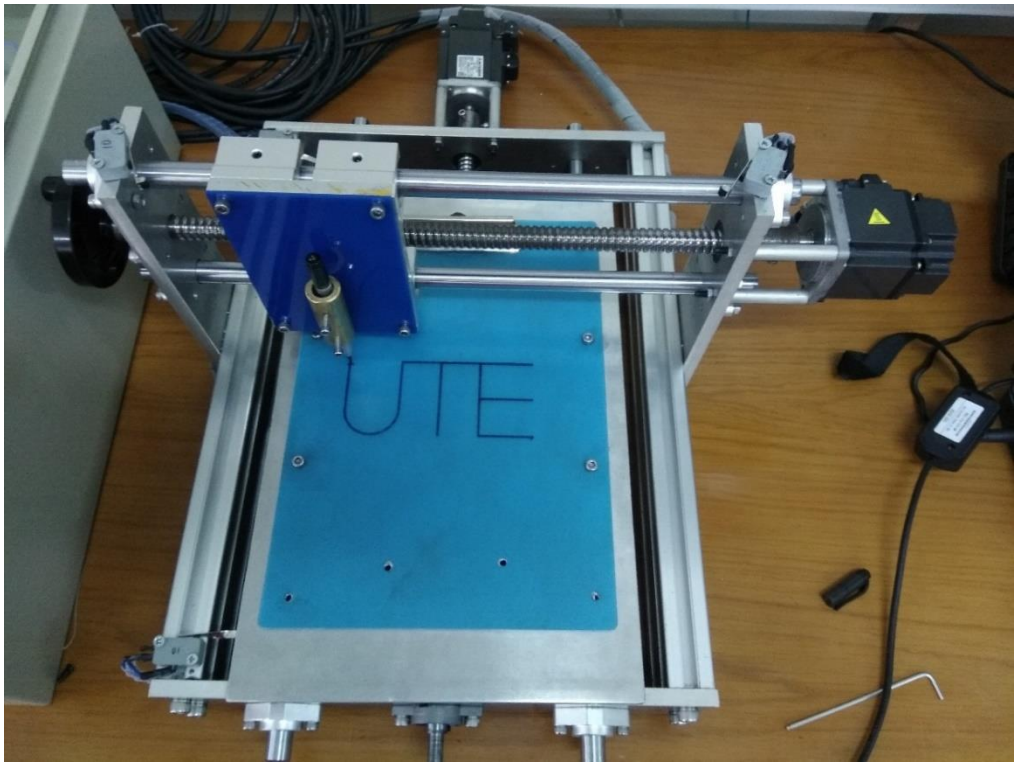


Figure 2.29: The 2 axis interpolation result

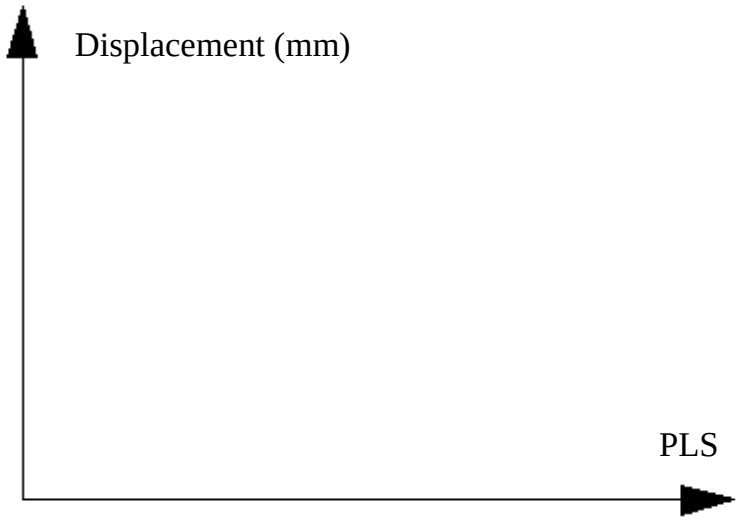
5. EXERCISES

Exe. 1: *Enter the position and frequency values of some points, measure the distance traveled on the model's table and fill in the following table:*

No.	Position and frequency (PLS; Hz)	Measure the distance traveled (mm)	**BLU**
1	200,000PLS; 1000000Hz		
2	500,000PLS; 1000000Hz		
3	600,000PLS; 1000000Hz		
4	700,000PLS; 1000000Hz		
5	900,000PLS; 1000000Hz		
6	1,000,000PLS; 1000000Hz		

7	1,200,000PLS; 1000000Hz		
8	1,500,000PLS; 1000000Hz		
9	2,000,000PLS; 1000000Hz		
10	2,500,000PLS; 1000000Hz		

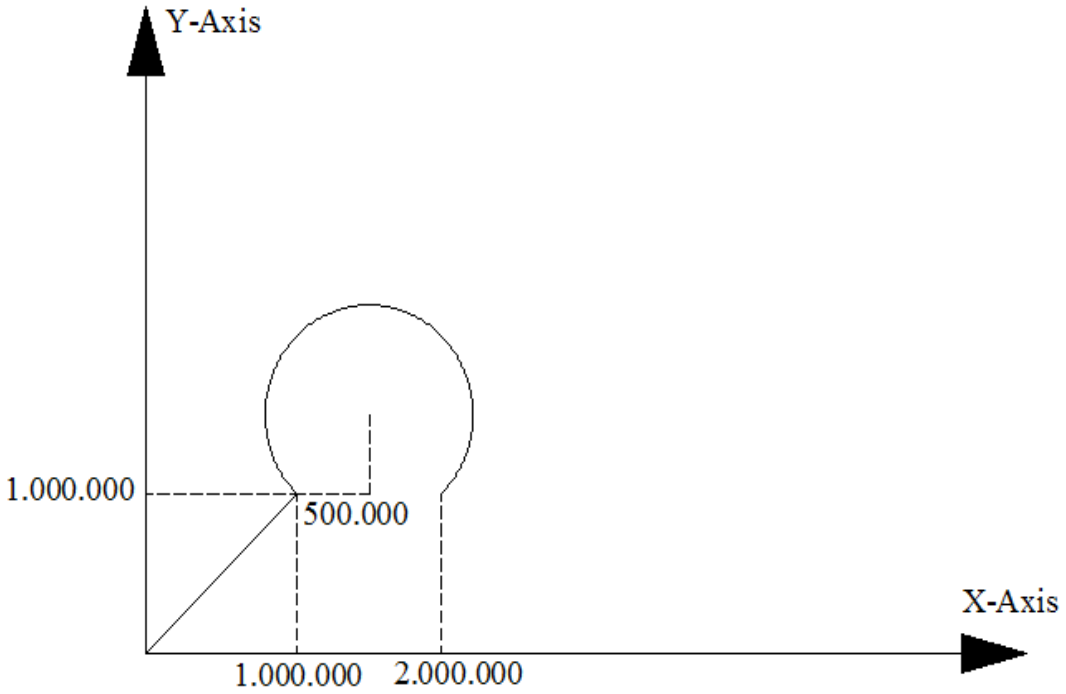
Exe. 2: *Plot and comment on the results from the data obtained in exe. 1*



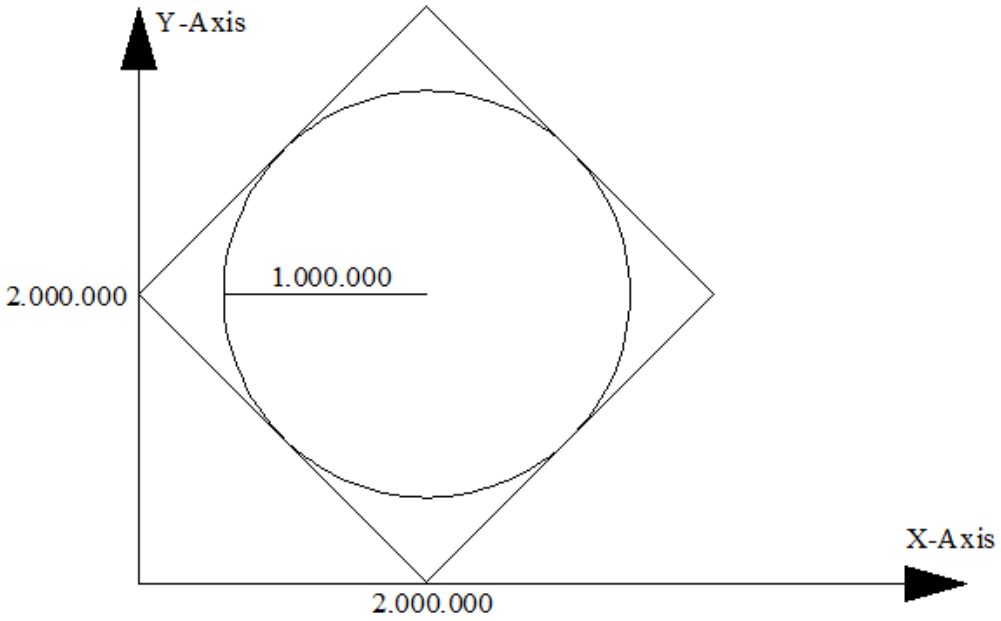
(With 262144 PLS will make AC servo turn 1 round. All vitmes have a screw pitch of 0.5mm)

Exe. 3: *Students do the following exercises by two methods* (manual control on FX-Configrutor-FP software and programming on GX-Developer/Work2)

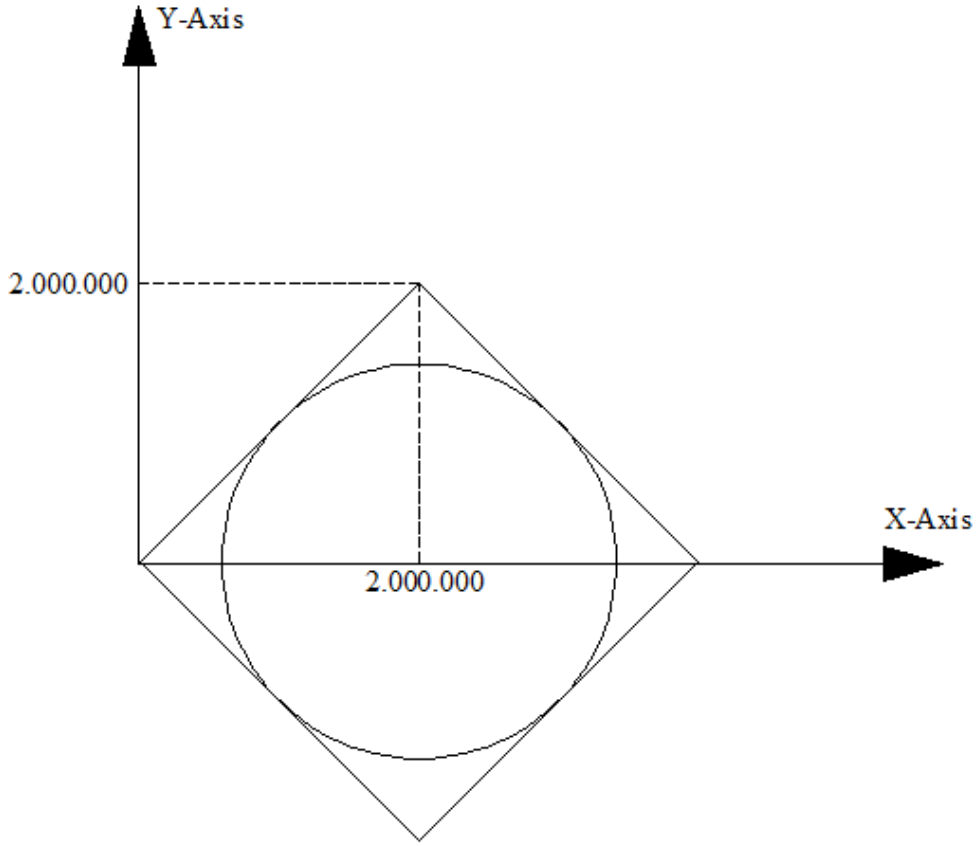
a.



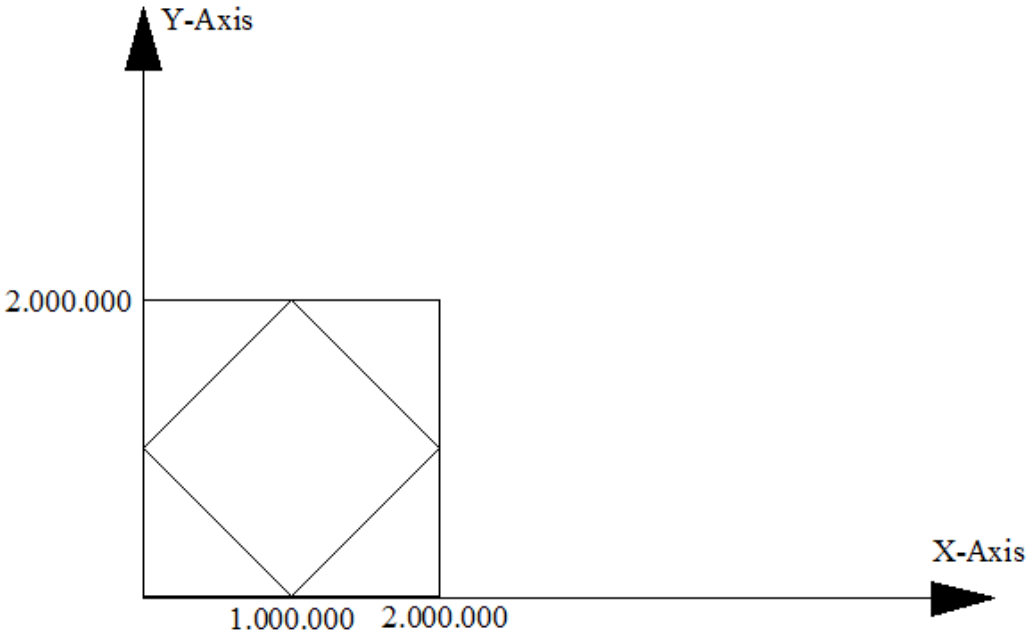
b.



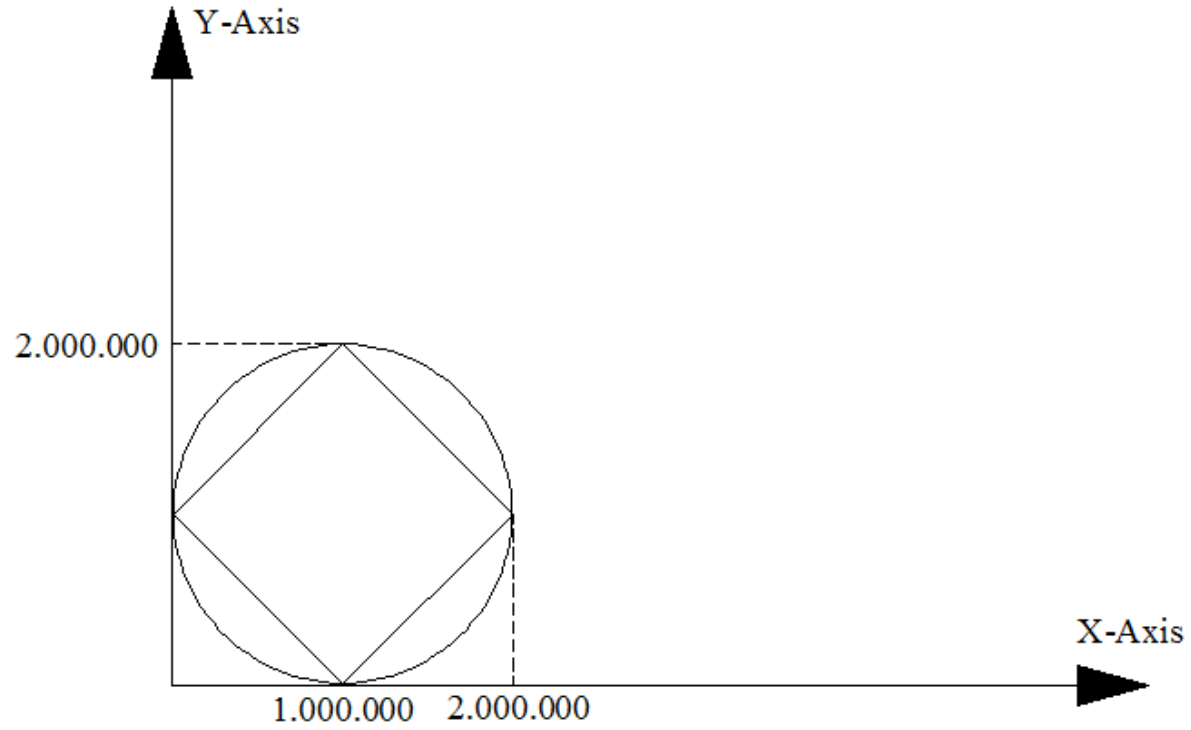
c.


Y-Axis
2.000.000
X-Axis
2.000.000

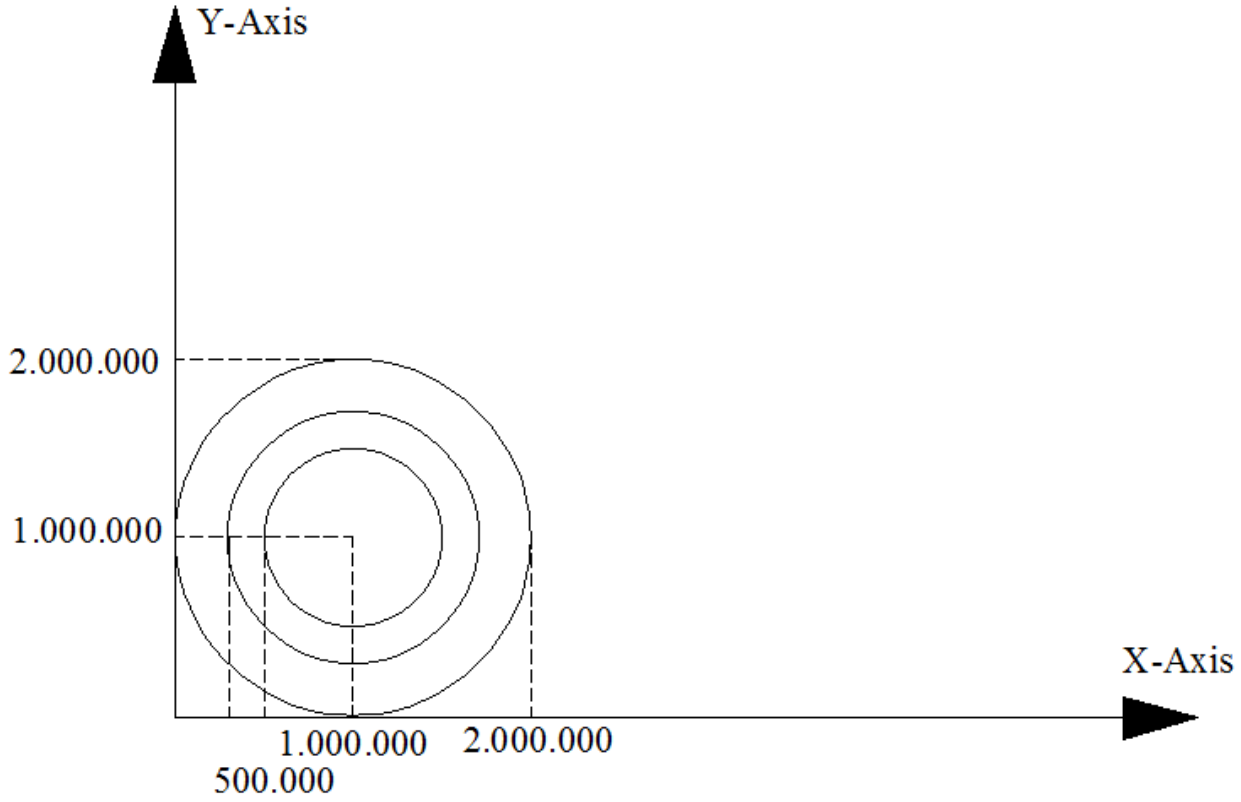
d.


Y-Axis
2.000.000
X-Axis
1.000.000
2.000.000

e.


Y-Axis
2.000.000
X-Axis
1.000.000
2.000.000

f.

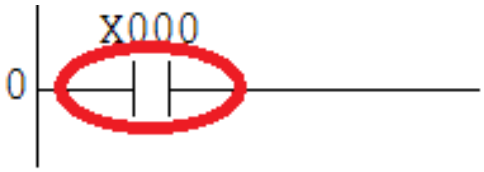

Y-Axis
2.000.000
1.000.000
X-Axis
1.000.000
2.000.000
500.000

APPENDIX.

FREQUENTLY USED COMMANDS IN THE EXPERIMENT

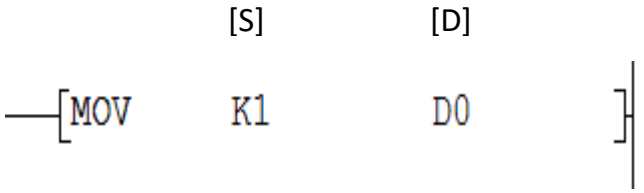
- **Command Load and Inverse Load**

Load (LD): Initialize the NO switch



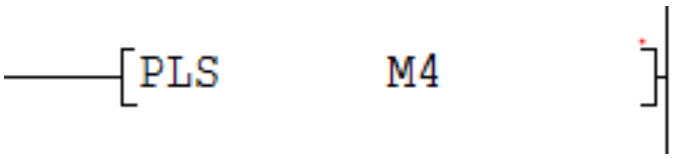
Inverse Load (LDI): Initialize the NC switch

- **Command MOV**



The contents of the source device (S) is copied to the destination (D) device when the control input is active. If the MOV instruction is not driven, no operation takes place.

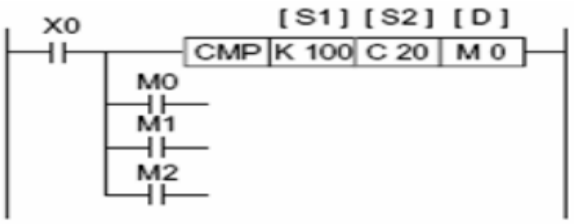
- **Command PLS**



Apply device: Y or M

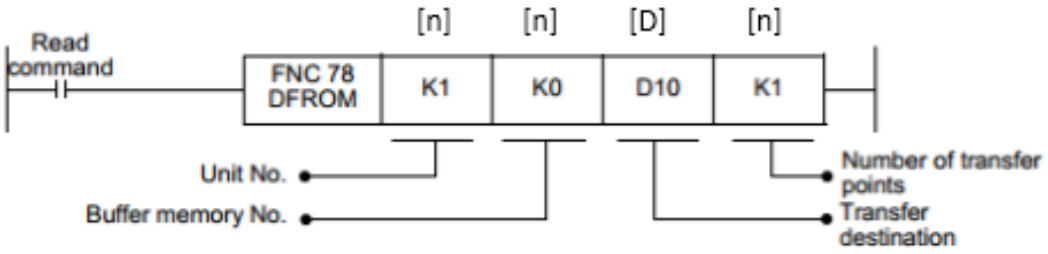
When PLS instruction is executed, object devices Y and M operate for one operation cycle after the drive input signal has turned ON.

- **Command CMP (compare)**



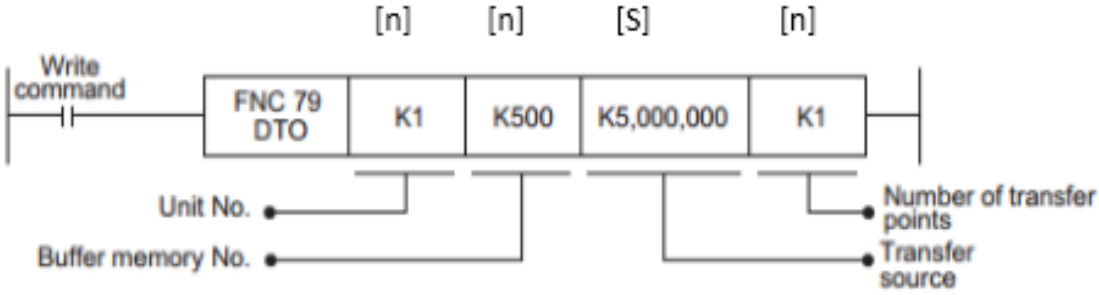
The data of S1 is compared to the data of S2. The result is indicated by 3 bit devices specified from the head address entered as D. The bit devices indicate: S2 is less than S1 - bit device D is ON, S2 is equal to S1 - bit device D+1 is ON.

➢ **Command From**



The FROM instruction reads n words of data starting from the buffer memory address m2 of the special function block with the logical block position specified as m1. The read data is stored in the PC at head address D for n word devices.

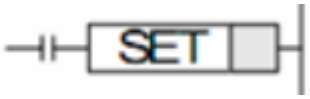
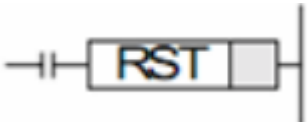
➢ **Command To**



The TO instruction writes n words of data to the head buffer memory address m2 of the special function block with the logical block position specified in m1. The written data is taken from the PCs head address S for n word devices.

➢ **Command SET and RESET**

Mnemonic	Function	Format	Devices

SET *(SET)*	Sets a bit device permanently On		Y, M, S
RST *(ReSeT)*	ReSets a bit device permanently OFF		Y, M, S, D, V, Z