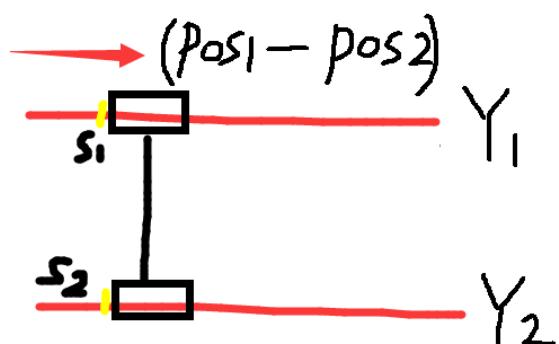
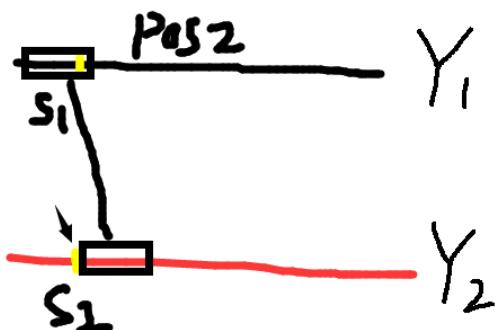
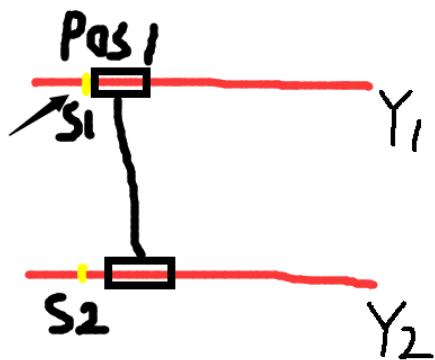


## Double y-axis automatic calibration example (M350)

Schematic diagram:

1



Y1 Y2: Y-axis drive motor;

S1:S2: The zero switch corresponding to Y1 and Y2;

## Hardware connection:

Y1 drive connection YP + YP- YD + YD-

Y2 driver connection 4P + 4P- 4D + 4D-

S1 S2 is connected to different input ports, respectively;

## parameter settings:

488 Parameters: x

489 parameter: Y

490 parameters: z

491 Parameters: Y

492 Parameters: 5th

Other parameters can be set according to regular;

## IO settings:

Stat	Port Name	Enable	Pin No.
● positive 5th-axis hard limit signal	x	NULL	
● X-axis zero signal	x	NULL	
● Y-axis zero signal	✓	IN02	
● Z-axis zero signal	x	NULL	
● 4th-axis zero signal	✓	IN04	
● 5th-axis zero signal	x	IN05	
● Fixed Probe signal	x	NULL	
● Floating Probe signal	x	NULL	
● extern key 1	x	IN01	
● extern key 2	x	NULL	
● extern key 3	x	NULL	
● extern key 4	x	NULL	
IN	IN01 IN02 IN03 IN04 IN05 IN06 IN07 IN08 IN09 IN10 IN11 IN12 IN14 IN15 IN16 IN17 IN18 IN19 IN20 IN21 IN22 IN23 IN24		
MPG	X1 X10 X100 HX HY HZ HA HB	0	
OUT	OUT01 OUT02 OUT03 OUT04 OUT05 OUT06 OUT07 OUT08 OUT09 OUT10 OUT11 OUT12 OUT14 OUT15 OUT16 OUT17 OUT18 OUT19 OUT20 OUT21		
	▲ Out Open Out Close Change Polarity		Te:

S2 uses the port number of the fourth axis;

**test:**

Load **double\_y\_double\_zero\_switch.nc** running;

Note: need to update 2022-04-11-01 version