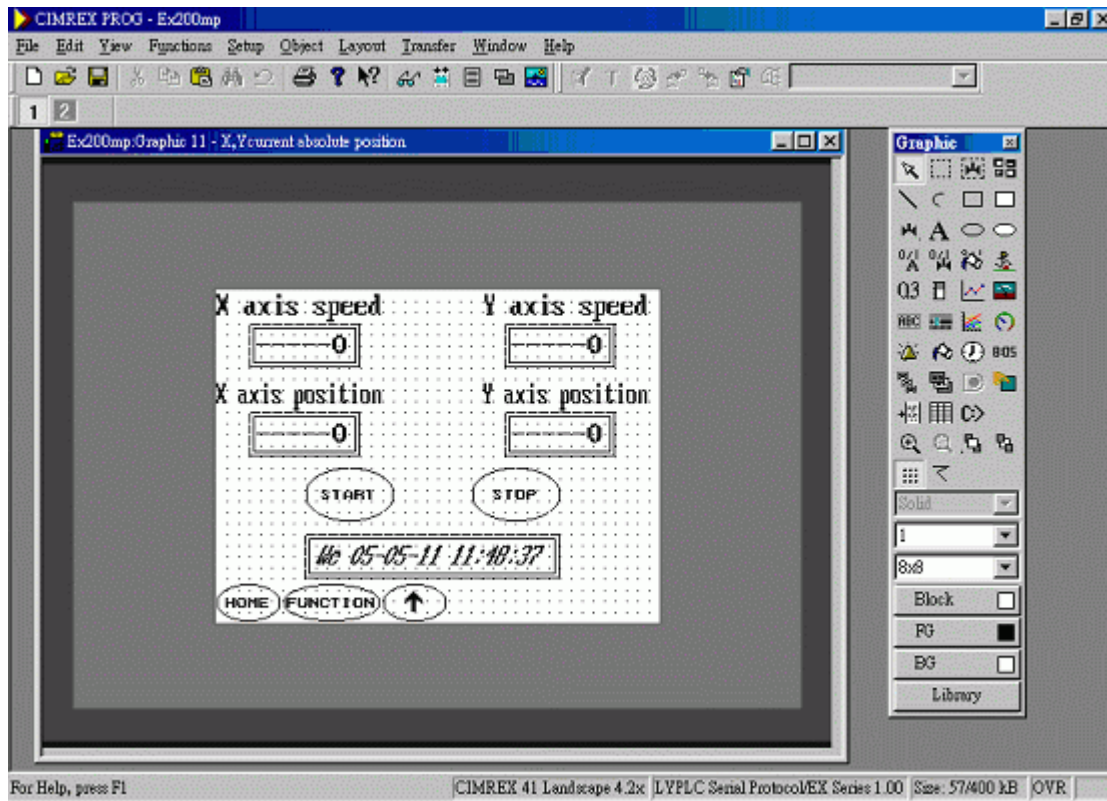


◎ Interpolation

◆Diagram :



◆ Action description

1. Instruction list :

D1000(Z)	D1002(Z)	D1004(Z)	D1006(Z)	D1008(Z)	D1010(Z)	Note
0						End
1	speed	position	Acc/Deceleration time			Only X axis move
2	speed	position	Acc/Deceleration time			Only Y axis move
3	speed	position	Acc/Deceleration time			X,Y axes move together
4	speed	X target coordinate	Y target coordinate			Linear Interpolation action
5	speed	X target coordinate	Y target coordinate	X circle center coordinate	Y circle center coordinate	Circular Interpolation Clockwise mode
6	speed	X target coordinate	Y target coordinate	X circle center coordinate	Y circle center coordinate	Circular Interpolation Counterclockwise mode
7	speed	X target coordinate	Y target coordinate	radius length		Circular Interpolation Clockwise input length mode
8	speed	X target coordinate	Y target coordinate	radius length		Circular Interpolation Counterclockwise input length mode
9	speed					Zero-return

Y0 = X axis Y1 = Y axis

2. Flag setting list:

M8142	M8143	Function
0	0	X,Y operate independently
1	0	Linear Interpolation action
0	1	Clockwise Circular Interpolation action
1	1	Counterclockwise Circular Interpolation action
M8134	M8135	Function
0	0	Y0,Y1 relative position operate
0	1	Y0 relative position operate,Y1 absolute position operate
1	0	Y1 relative position operate,Y0 absolute position operate
1	1	Y0 ,Y1 absolute position operate
M8134	Y0 relative / absolute position operation flag	
M8135	Y1 relative / absolute position operation flag	
M8142	Linear Interpolation enable flag	
M8143	Circular Interpolation enable flag	

3.PLC program action procedure:

Set instruction action to D1000 register as follows,

When set X axis move independently :

D1000(Z) = code D1002(Z) = speed D1004(Z) = position D1006(Z) = Acc/Deceleration time

When set Clockwise Circular Interpolation action :

D1000(Z) = code D1002(Z) = speed D1004(Z) = X Target coordinate D1006(Z) = Y Target coordinate

D1008(Z) = X Circle center coordinate D1010(Z) = Y Circle center coordinate

Other instruction action as above (please refer to instruction list)

After finish instruction setting, PLC program will determine action S100~S109 by code (D1000(Z)) setting.

If assign Radius input Circular Interpolation mode, then Start coordinate and Target coordinate can not be the same.

If it is the same, then it will not act.

◆ Wiring

