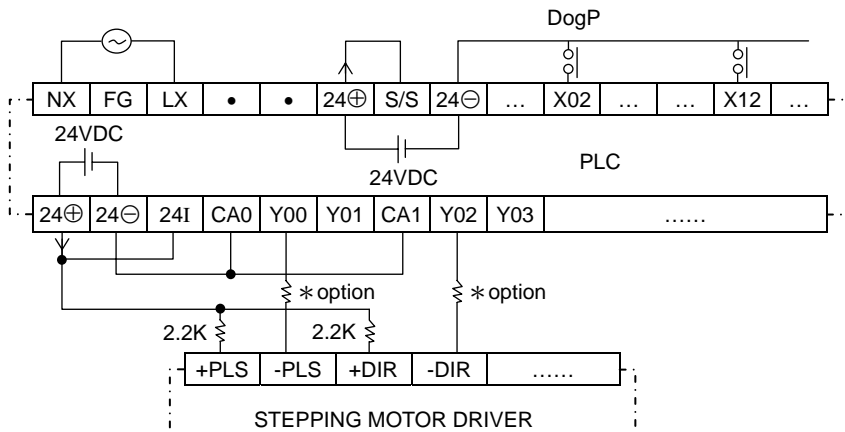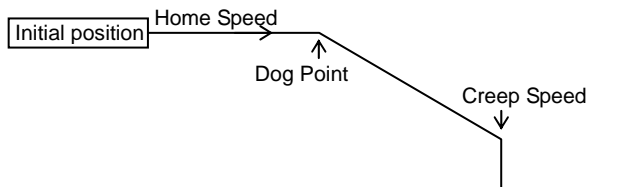# Zero Return : Forward mode forward direction – Stepping motor

♦Wiring

♦Action

<First direction forward>

♦Sample Program

M8002	[MOV	K100	D8168] Y0 bias speed
	[MOV	K2000	D8164] Y0 acc/deceleration time
	[DMOV K10000	D8156	] Y0 maximum speed
M8002	[DMOV K5000	D116	] ZRN Home speed
	[DMOV K500	D118	] ZRN Creep speed
	[MOVP	K0	D8169] K=0, for stepping motor
X012 ↑		[SET	M112]
		[RST	M8152] clear ZRN finish flag
		[RST	M8158] 1st DIR by flag M8156
		[RST	M8156] 1st DIR forward
		[SET	M8154] Forward mode
X012 ↓		[RST	M112]

M112 [S1.]=Home, [S2.]=Creep, [S3.]=DogP

M112	[DZRN D116	D118	X002	Y000]
M8029 M8152			[RST	M112]
			[RST	M8029]

When FNC(156) ZRN execute, D8168=Creep speed

[END]