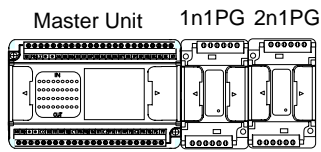


EX14-1. Fly cut (1) : Fixed length and Reverse mode

◆ Configuration



◆ Parameter setting of fly-cut mode operation

1. Set fixed-length mode or mark mode first, bit 5 of BFM#03.
2. Set BFM#99,98 start following point (through number of pulse which is relative to absolute zero-point, then slaver just start to operate)
3. Set BFM#97,96 master axis acceleration pulse number. System decide acceleration slope of slaver according to this pulse number.

◆ Fly-cut mode monitor

1. Monitor BFM#106, BFM#108, and BFM#110. It can get following situation of slaver
2. Monitor BFM#112. This value can not be negative value. If it is negative value, then that means it is too late to go back start point.

LIYAN PROGRAMMABLE LOGIC CONTROLLER

1PG-eapp0512v122a

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