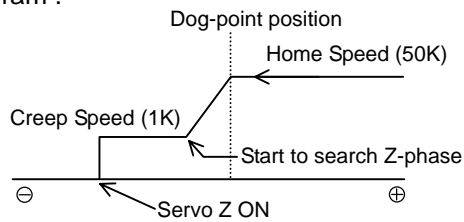◎   Zero Return forward mode – reverse (from positive to negative coordinate) to search zero-point

♦ Diagram :

Dog-point position
Home Speed (50K)
Creep Speed (1K)
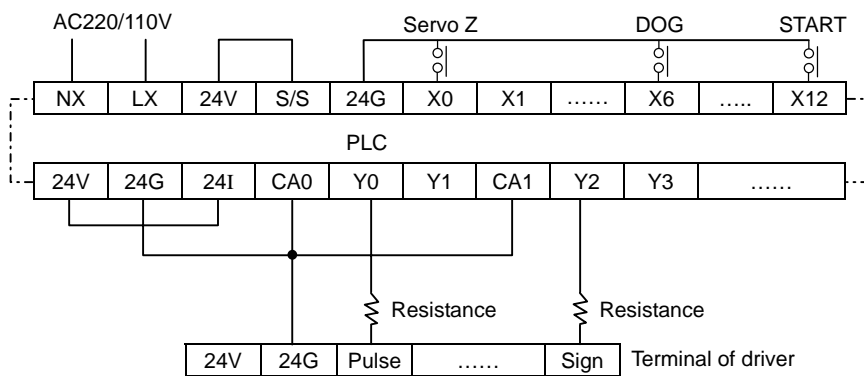Start to search Z-phase
⊖   ⊕
Servo Z ON

♦ Action description

X12 ON, search dog-point (reverse) by 50K speed (Home Speed).

X6(DOG) ON, decelerate to 1K speed (Creep Speed) to search zero-point.

♦ Wiring

| NX | LX | 24V | S/S | 24G | X0 | X1 | …… | X6 | ….. | X12 |

PLC

| 24V | 24G | 24I | CA0 | Y0 | Y1 | CA1 | Y2 | Y3 | …… |

Resistance   Resistance

| 24V | 24G | Pulse | …… | Sign | Terminal of driver

♦ Program


```
M8002
 ┤├                                    [DMOV    K100000        D8156      ] Maximum speed
                                       [DMOV    K50000         D116       ] Home Speed
                                       [DMOV    K1000          D118       ] Creep Speed
                                       [MOV     K100     D8168 ] Bias speed
                                       [MOV     K100     D8164 ] Acceleration/Deceleration time
                                       [MOV     K2       D8169 ] Search number of Z-phase
                                       [ZRST    M100     M119  ]
X012
 ┤↑├                                   [SET     M112   ] Start
                                       [RST     M8152  ] Zero-return point finish flag
                                       [RST     M8158  ] decide running direction by M8156
                                       [SET     M8156  ] Reverse flag
                                       [SET     M8154  ] Forward mode flag
X012
 ┤↓├                                   [RST     M112   ] stop midway
M112
 ┤├            [DZRN    D116     D118        X6        Y000      ]
              M8029    M8152
               ┤├       ┤├             [RST     M112   ]
                                       [RST     M8029  ]
                                       [ END    ]
```