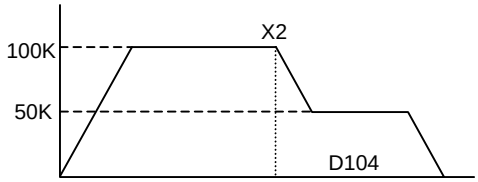
◎ Without target running, Mark interrupt speed-change, then move a distance (PLSV)

♦Diagram :



Relative register
D102 =0, D104 ≠ 0
D100 : Speed register
D102 : Set to ”0”, assign to Without target running
D104 : Second section position register
M8132 : With slope flag (=0 with slope, =1 Without slope)

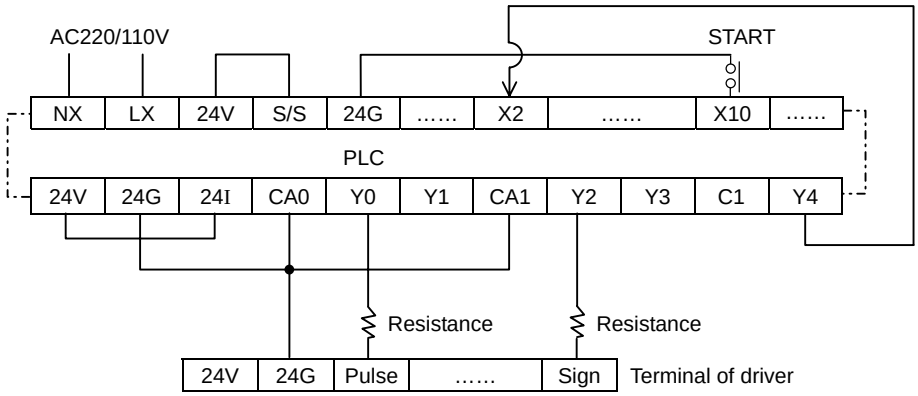
♦Instruction:

	(S.)	(D1.)	(D2.)
DPLSV	D100	Y00	Y02

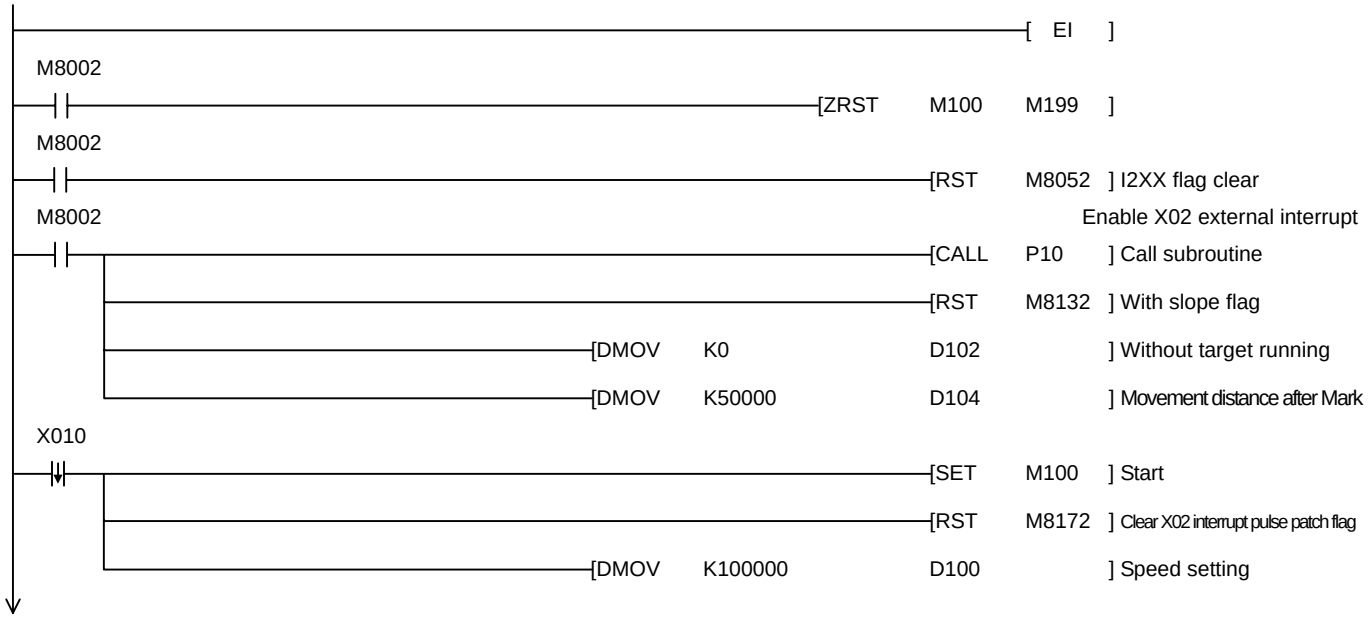
♦Action description

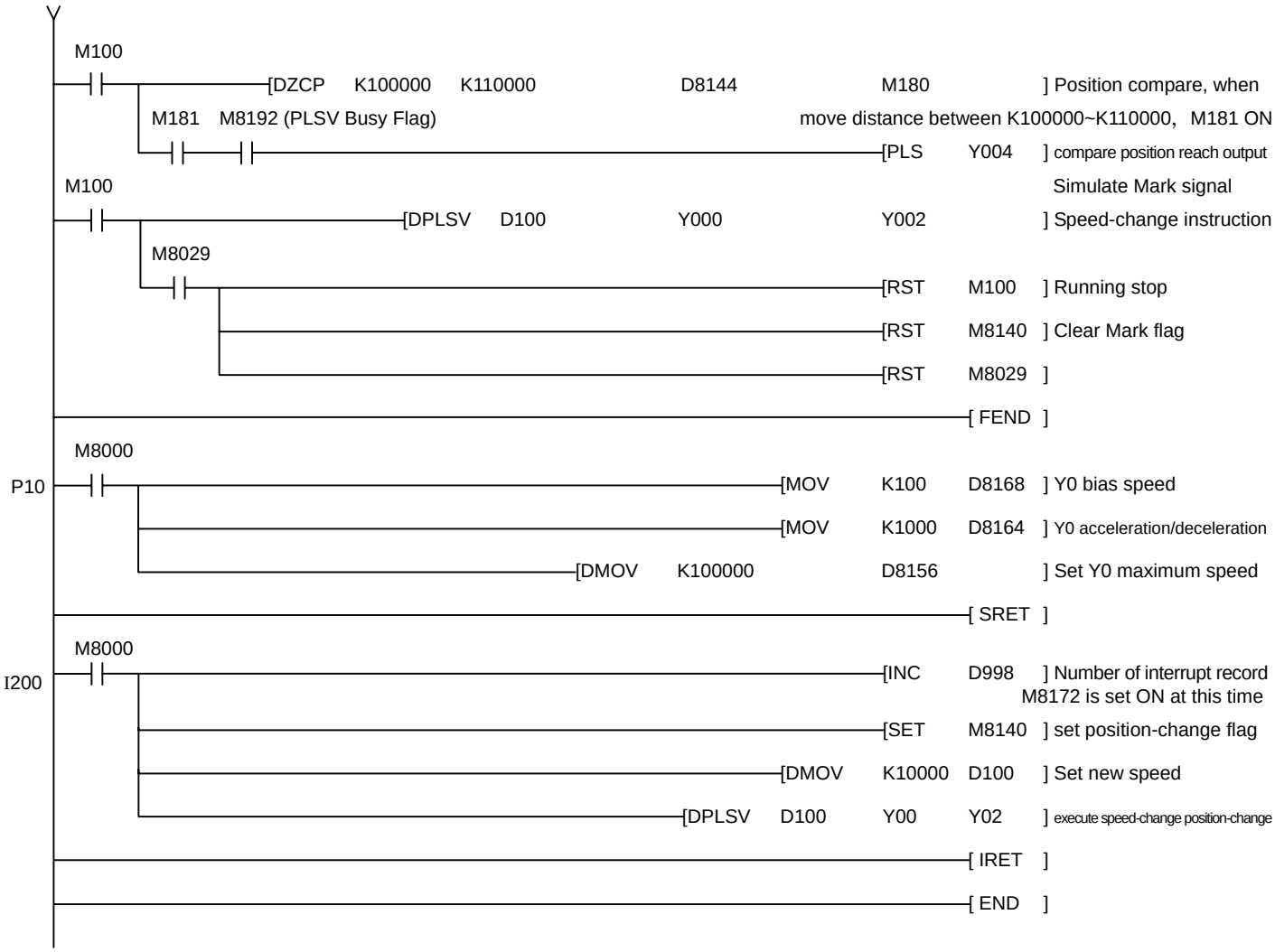
X10 start, running by 100Kpps speed, proceed position compare at this time. When distance move between 100,000 to 110,000, Y04 ON, contact X02 interrupt, M8140 mark flag ON.
When main program instruction execute to DPLSV, speed decelerated to 10K, and movement distance change to (Relative movement position+[D104])。
This example use Y04 ON to contact X02, simulate proximal switch input interrupt signal actual application place can be canceled.

♦Wiring



♦Program




M100
[DZCP K100000 K110000 D8144 M180] Position compare, when
M181 M8192 (PLSV Busy Flag)
move distance between K100000~K110000, M181 ON
[PLS Y004] compare position reach output
M100
Simulate Mark signal
[DPLSV D100 Y000 Y002] Speed-change instruction
M8029
[RST M100] Running stop
[RST M8140] Clear Mark flag
[RST M8029]
[FEND]
M8000
P10
[MOV K100 D8168] Y0 bias speed
[MOV K1000 D8164] Y0 acceleration/deceleration
[DMOV K100000 D8156] Set Y0 maximum speed
[SRET]
M8000
I200
[INC D998] Number of interrupt record
M8172 is set ON at this time
[SET M8140] set position-change flag
[DMOV K10000 D100] Set new speed
[DPLSV D100 Y00 Y02] execute speed-change position-change
[IRET]
[END]