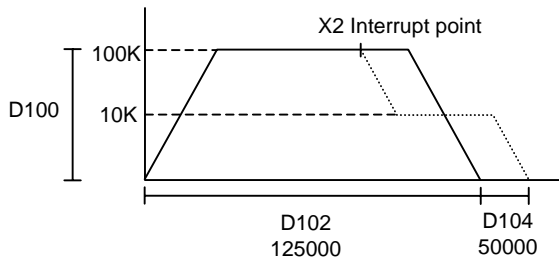


◎ With target running, Mark Interrupt speed-change position-change (PLSV)

◆Diagram :



Relative flag and register
 M8132 = 0 With slope running flag
 When M8140 or M8141 = 1, target position change.
 D100: Speed register
 D102: First section position
 D104: Second section position

◆Action description:

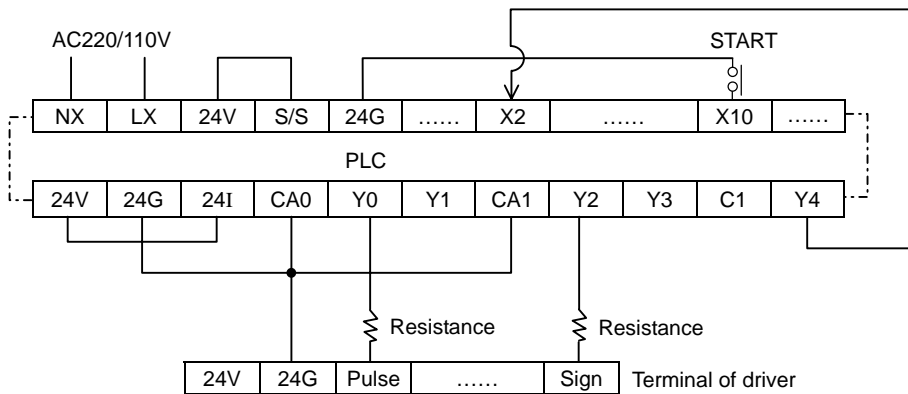
X10 start, running by 100Kpps.

When X2 ON, execute Mark, speed decrease to 10K, then the move distance change to (relative move position + [D104]).
 If executing position in the running of D102, X02 all OFF, then regard it as without mark signal, move the distance of D102 to stop.

This example use Y04 ON to contact X02, simulate proximal switch to input interrupt signal, actual application place can be canceled.

This example develop to that if it have to stop running immediately after mark, then only add SET M8132 in Interrupt program.

◆Wiring



◆Program

