



Programmable Automation Controllers
MELSEC MX Controller



Ezi-ROBO® CC-Link IE TSN
Precise Actuator System **CLA**

Ezi-SERVO® CC-Link IE TSN
Closed Loop Stepping System **4X**

접속 가이드

MELSEC MX Controller and

Ezi-ROBO® CC-Link IE TSN - **Ezi-SERVO**® CC-Link IE TSN
Precise Actuator System **CLA** Closed Loop Stepping System **4X**

미쓰비시 전기 제품

MXR300-16 / MXR300-32 / MXR300-64
MXR300-128 / MXR300-256 / MXF100-8
MXF100-16

파스텍 제품

Ezi-ROBO CC-Link IE TSN CLA
(Ezi-SERVO CC-Link IE TSN 4X)

시작하기 전에

- 저희 회사의 제품을 이용해 주셔서 감사합니다.
- Ezi-ROBO CLA의 제어부는 Ezi-SERVO CC-Link IE TSN 4X으로 이하 연결 가이드 설명은 Ezi-SERVO CC-Link IE TSN 4X으로 합니다.
- Ezi-SERVO CC-Link IE TSN 4X는 32비트 고성능 ARM 프로세서를 탑재한 드라이브와 다양한 모터로 구성된 스테핑모터 유닛으로, CC-Link IE TSN 네트워크에서 리모트국으로 사용됩니다.
- Ezi-SERVO CC-Link IE TSN 4X는 산업용 제품입니다. 다른 용도로는 사용하지 말아 주십시오. 이를 준수하지 않아 손해가 발생한 경우에 저희 회사에서는 어떠한 책임도 지지 않습니다.
- 저희 회사에서 제공하는 이 접속 가이드는 미쓰비시 전기의 MELSEC MX 컨트롤러에 Ezi-SERVO CC-Link IE TSN 4X를 연결하는 방법을 안내하는 자료로, CSP+ 파일 등록과 시스템 구성, 파라미터 설정, 프로그램 방법 등을 설명합니다.
- PLC 프로그램을 작성하기 전에 이 접속 가이드를 반드시 읽고, 내용을 정확히 이해하신 후 제품을 올바르게 사용하시기 바랍니다.
- 이 접속 가이드는 예고 없이 변경될 수 있습니다. 최신 버전이 필요하신 경우에는 저희 회사의 CC-Link IE TSN 홈페이지 (cltsn.fastech-motions.com)를 참고하시기 바랍니다.

매뉴얼 정보

- Ezi-SERVO CC-Link IE TSN 4X 매뉴얼은 파스텍 홈페이지에서 다운로드할 수 있습니다.

<https://cltsn.fastech-motions.com/download/quick>

매뉴얼 명칭	매뉴얼 번호
[매뉴얼][CC-Link IE TSN][Ezi-SERVO 4X] Closed Loop Stepping System	
[접속가이드][CC-Link IE TSN][MELSEC MX Controller][Ezi-ROBO CLA Ezi-SERVO 4X]	

- MELSEC MX 컨트롤러 매뉴얼은 미쓰비시 전기 홈페이지에서 다운로드할 수 있습니다.

<https://www.mitsubishielectric.com/fa/index.html>

매뉴얼 명칭	매뉴얼 번호
MELSEC MX Controller (MX-R Model) User's Manual	SH-082640
MELSEC MX Controller (MX-R Model) Programming Manual	SH-082643
GX Works3 Operating Manual	SH-081214

용어

- 접속 가이드에서 사용되는 용어와 관련된 내용입니다.

용어	내용
CC-Link IE TSN	표준 이더넷 규격을 확장한 'TSN(Time-Sensitive Networking)'을 채택하여, 실시간성을 확보한 제어와 다른 오픈 네트워크의 정보를 동시에 처리할 수 있는 오픈 네트워크입니다.
마스터국(매니저국)	네트워크 전체를 관리하는 국으로, 모든 국과 사이클릭 전송 및 트랜지언트 전송을 할 수 있습니다. MELSEC MX 컨트롤러가 이에 해당합니다.
리모트국	비트 단위의 입출력 신호와 워드 단위의 입출력 데이터를 사이클릭 전송하는 국으로, 트랜지언트 전송도 가능합니다. Ezi-SERVO CC-Link IE TSN 4X가 이에 해당합니다.
PDO	Process Data Object의 약칭입니다. 여러 CANopen 노드 간에 주기적으로 전송되는 애플리케이션 오브젝트의 집합체입니다.
오브젝트	CANopen에 대응하는 디바이스국이 보유한 다양한 데이터입니다.

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- [동작확인] 원점복귀 방법 변경
- [동작확인] 원점복귀
- [동작확인] Jog 운전
- [동작확인] 트러블 슈팅
- [파라미터] 원점복귀 파라미터 설정

1. 개 요

1-1. 개요

- MELSEC MX 컨트롤러와 Ezi-SERVO CC-Link IE TSN 4X 접속 가이드

◆ 마스터국: MXR300-16 / MXR300-32 / MXR300-64 / MXR300-128 / MXR300-256
MXF100-8 / MXF100-16

PLCopen®Motion Control FB(Function Block)

- 국제 표준 규격인 PLCopen Motion Control FB 라이브러리를 사용하여 제어 프로그램을 쉽게 작성할 수 있습니다.
- 이 프로그램은 제3자도 내용을 쉽게 파악할 수 있기 때문에 설계 및 유지보수 시간을 크게 단축할 수 있습니다.

◆ 엔지니어링 소프트웨어

- GX Works3 : Ver. 1.105K 이상
- 최신 파일은 미쓰비시 전기 홈페이지를 참조하시기 바랍니다.
(<https://www.mitsubishielectric.com/fa/download/index.html>)

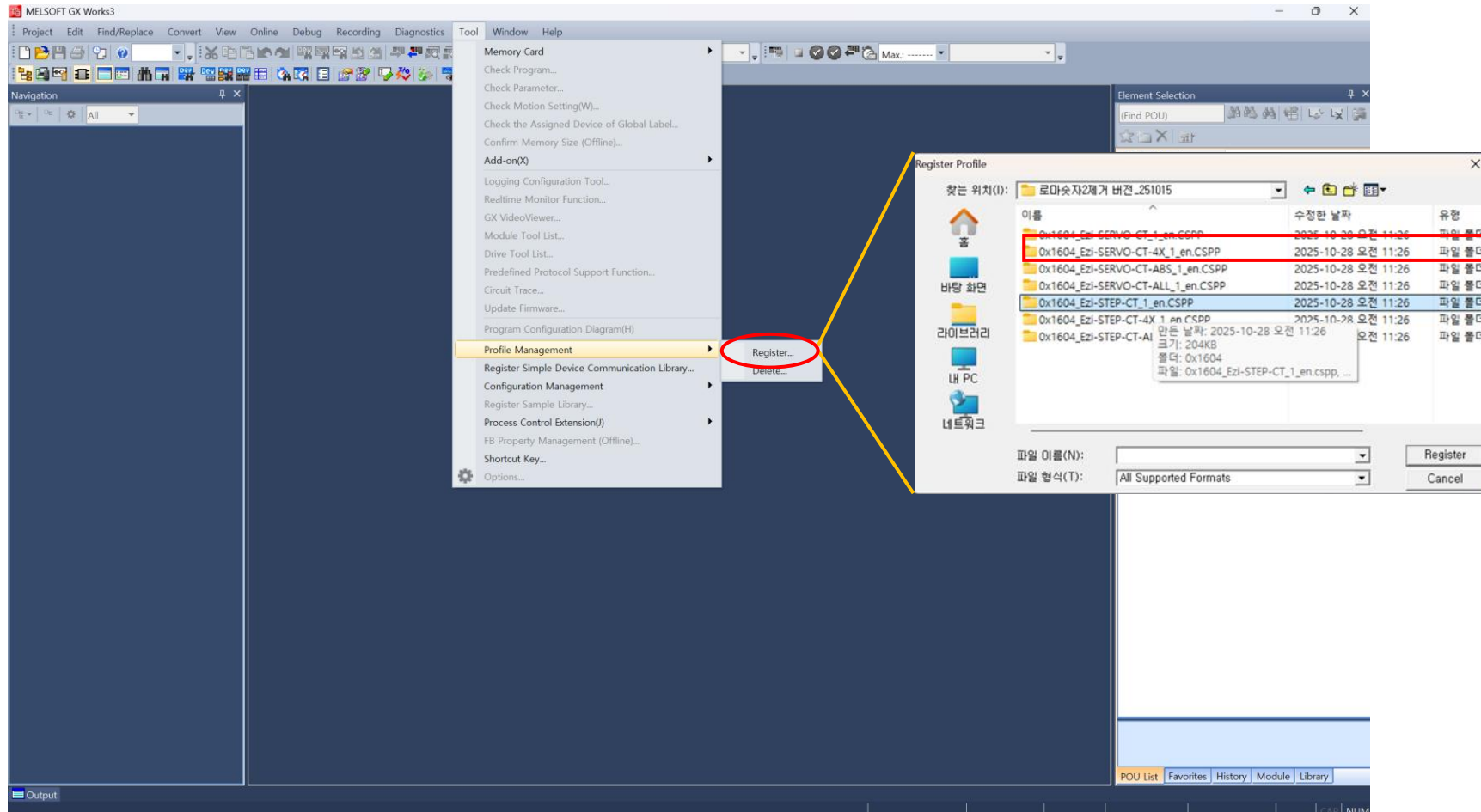
◆ 리모트국: Ezi-SERVO CC-Link IE TSN 4X

- CSP+ 파일 다운로드 주소: <https://cltsn.fastech-motions.com/download/quick>
- 파일명 : 0x1604_Ezi-SERVO-CT-4X_1_en_CSPP

1-2. Ezi-SERVO CC-Link IE TSN 4X CSP+ 파일 등록

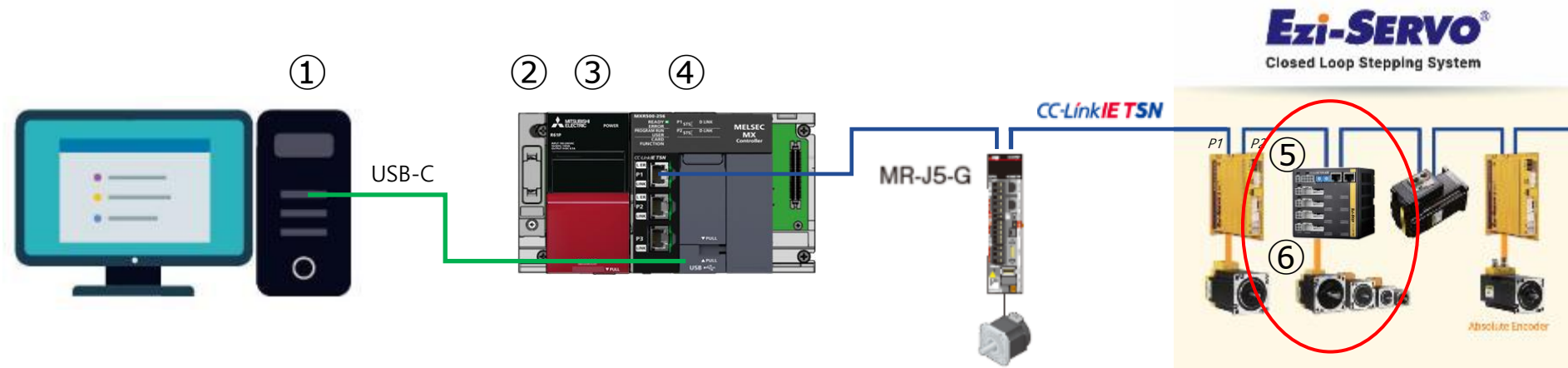
● CSP+ 등록

- [GX Works3] Tool / Profile Management / Register ※ Project를 열기 전에만 등록할 수 있습니다.



1-3. CC-Link IE TSN 구성

- 시스템 구성



구성	품명	IP 주소
①	엔지니어링 소프트웨어	GX Works3
②	기본 베이스	R33B
③	전원 모듈	R61P
④	컨트롤러	MXR300-16
⑤	드라이브	EzS2-CT-4X
⑥	모터	EzM2-42S-A

1-3. CC-Link IE TSN 구성

- Ezi-SERVO 규격

항목		규격
통신 프로토콜		CC-Link IE TSN Class B
통신 속도		1Gbps / 100Mbps
동작 모드		CiA402 드라이브 프로파일 : 사이클릭 동기 위치 모드 (CSP) / 프로파일 위치 모드 (PP) / 원점복귀 모드 (HM)
동기 방식	시각 동기 방식	IEEE1588 / IEEE802.1AS
	통신 주기	최소 250 μ s
	네트워크 동기 통신	동기 통신 (CSP, PP, HM) / 비동기 통신 (PP, HM)
인코더 타입		인크리멘탈 타입

1-4. 설정 순서

● Ezi-SERVO, MX 컨트롤러 파라미터 설정

No.	항목	내용
1	Ezi-SERVO 설정 	드라이브 설정 프로그램(Ezi-CT Manager)을 이용하여 파라미터를 설정합니다. 설정 프로그램과 사용 방법은 (주)파스텍 홈페이지에서 다운로드하시기 바랍니다. ※ 주소: https://cltsn.fastech-motions.com/download/quick
2	MX 컨트롤러 설정 	GX-Works3를 사용해 MX 컨트롤러의 프로젝트를 만든 다음, 유닛 파라미터(통신 방식, 접속 대상)와 축 파라미터(모션 제어용)를 설정합니다.
3	MX 컨트롤러 + Ezi-SERVO 동작 확인 	MX 컨트롤러와 Ezi-SERVO가 올바르게 설정되어 있는지 확인하기 위한 프로그램을 작성합니다. 라벨을 조작해 모터가 정상적으로 작동하는지 확인합니다

1-4. 설정 순서

● Ezi-SERVO 설정 참고 사항

항목	내용
IP 주소 설정	① 드라이브의 로터리 스위치로 설정 ② 로터리 스위치 → '00', IP address (Index: 2101h, Subindex: 01~04h) 값으로 설정
드라이브 원점복귀 방법 설정	① Homing method (Index: 6098h, Subindex:00h) 설정 - '0'(초깃값) → '33' 등 원점복귀 방법 설정 ※ [부록] 원점복귀 방법 참조 ② Home offset (Index: 607Ch, Subindex:00h) → '0' 설정 필요 주의) 0이 아닌 값을 설정하면, 원점복귀가 완료될 때 급가속하거나 급감속하는 경우가 있습니다.
리미트 정지 방법 설정	① Limit stop method (Index:2003h, Subindex:00h) 설정 - 0: PP, HM → 급정지 / CSP → 정지하지 않음 - 1: PP, HM → 감속 정지 / CSP → 정지하지 않음 ② '0' 또는 '1'이 아닌 값을 설정하면, 하드웨어 스트로크 리미트를 감지할 때 '1ED0H: 드라이브 오류'가 발생할 수 있습니다
인포지션 범위	① In-position range (Index:2B21h, Subindex:00h, Data type:Unsigned32) 설정 - 사용 환경을 고려하여 인포지션 범위(5~20000 pulse) 내의 값을 등록 ② [Md.102: 편차 카운터 값]이 이 설정값보다 작을 경우, [Md.108: 서보 상태 1: 인포지션]이 ON됩니다. 이 오브젝트는 공개하지 않는 것이 원칙이므로 FX5 CPU 모듈의 서보 트랜지언트 전송 기능을 이용하여 설정해 주십시오.

1-5. 제약 사항

● 모션 제어 기능 제약 사항 (MX 컨트롤러와 Ezi-SERVO)

항목	제약 사항
토크 제한 기능	드라이브가 아래 오브젝트를 지원하지 않아 토크 제한 기능을 사용할 수 없습니다. • Positive torque limit value (Index:60E0h, Subindex:00h) • Negative torque limit value (Index:60E1h, Subindex:00h)
절대 위치 시스템	인코더가 인크리멘탈 타입이기 때문에 절대 위치 시스템을 사용할 수 없습니다.
가상 서보 앰프 기능	MR-J5-G로 에뮬레이트됩니다.
마크 검출 기능	[Pr.800: 마크 검출 신호 설정]에 드라이브의 TPR1(터치 프로브 1)을 사용할 수 없습니다.
임의 데이터 모니터 기능	임의 데이터 모니터 기능을 사용할 경우, [Pr.91~94: 임의 데이터 모니터 데이터 종류 설정 1~4]와 [Pr.591~594: 임의 데이터 모니터 데이터 종류 확장 설정 1~4]에 모니터링할 오브젝트를 설정해 주십시오. 초깃값은 "0: 미설정"입니다. 따라서 [Md.109~112: 임의 데이터 모니터 출력 1~4]는 '0'이 됩니다.

1-5. 제약 사항

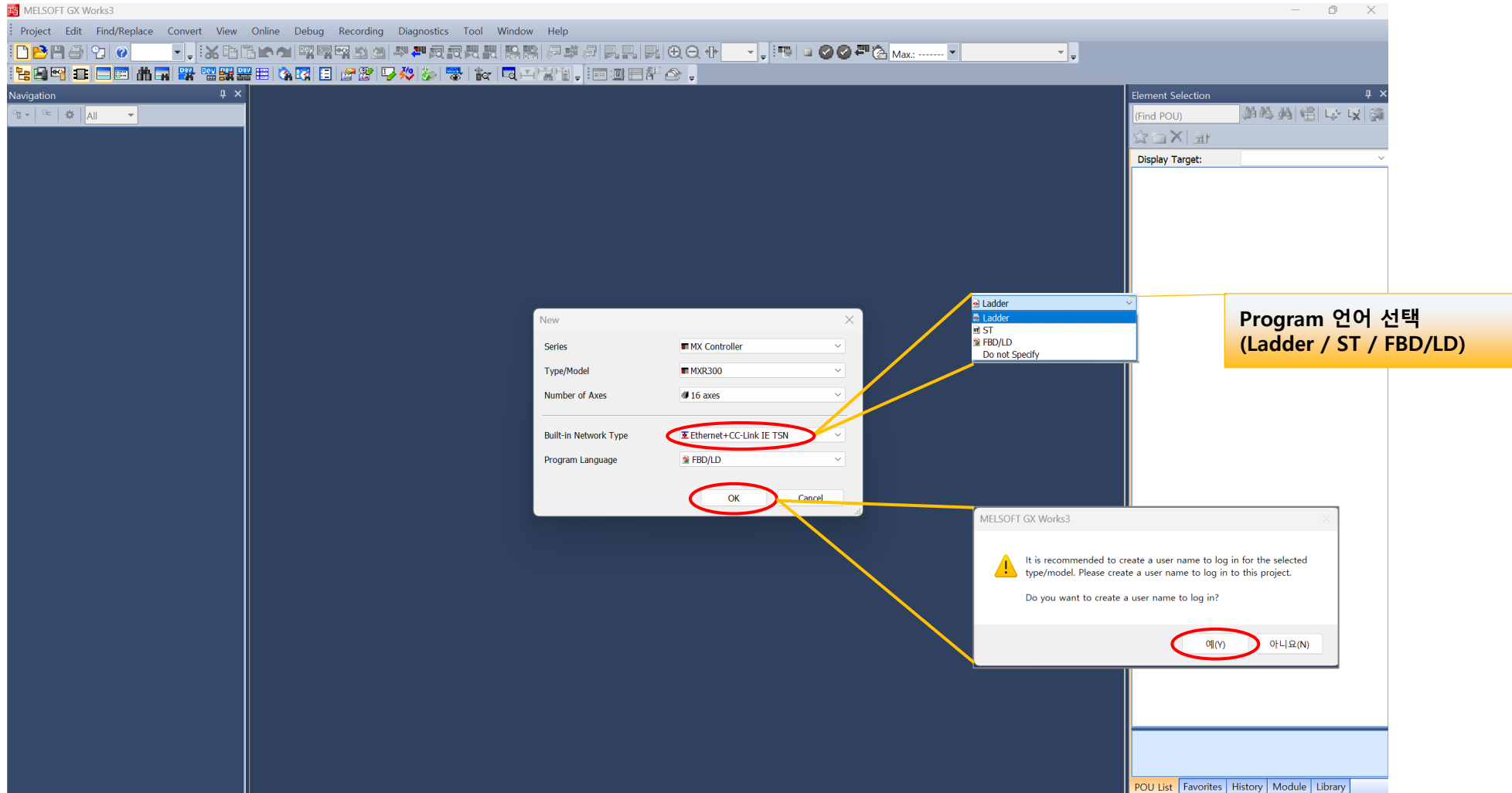
● 모션 제어 기능 제약 사항 (MX 컨트롤러와 Ezi-SERVO)

항목	제약 사항
Md.103: 모터 회전수	드라이브가 'SI unit velocity (Index:60A9h, Subindex:00h)'를 지원하지 않기 때문에 pulse/s 단위로 모터 회전수를 출력합니다.
Md.104: 모터 전류값	드라이브가 'Torque actual value (Index:6077h, Subindex:00h)'를 지원하지 않기 때문에 항상 "0"으로 표시됩니다.
Md.108: 서보 상태 1	모니터 데이터 중 아래 비트는 항상 'OFF' 상태입니다. · 게인 전환 중 (b4) · 풀 클로즈드 제어 전환 중(b5) · 토크 제한 중(b13) · 절대 위치 소실 중 (b14) · 경고 중(b15)
Md.119: 서보 상태 2	모니터 데이터 중 아래 비트는 항상 'OFF' 상태입니다. · 영점 통과(b0) · 영속도 중(b3) · 속도 제한 중(b4) · PID 제어 중(b8)
Md.115: 서보 알람 상세 번호	지원되지 않습니다. 이 모니터 데이터는 항상 '0'으로 표시됩니다
Cd.108: 게인 전환 명령 플래그	지원되지 않습니다. MELSERVO만 이 데이터에 대응합니다.
Cd.133: 세미-풀 전환 요구	지원되지 않습니다. MELSERVO만 이 데이터에 대응합니다..
Cd.136: PI-PID 전환 요구	지원되지 않습니다. MELSERVO만 이 데이터에 대응합니다.

2. MX 컨트롤러 설정

2-1. Project 생성

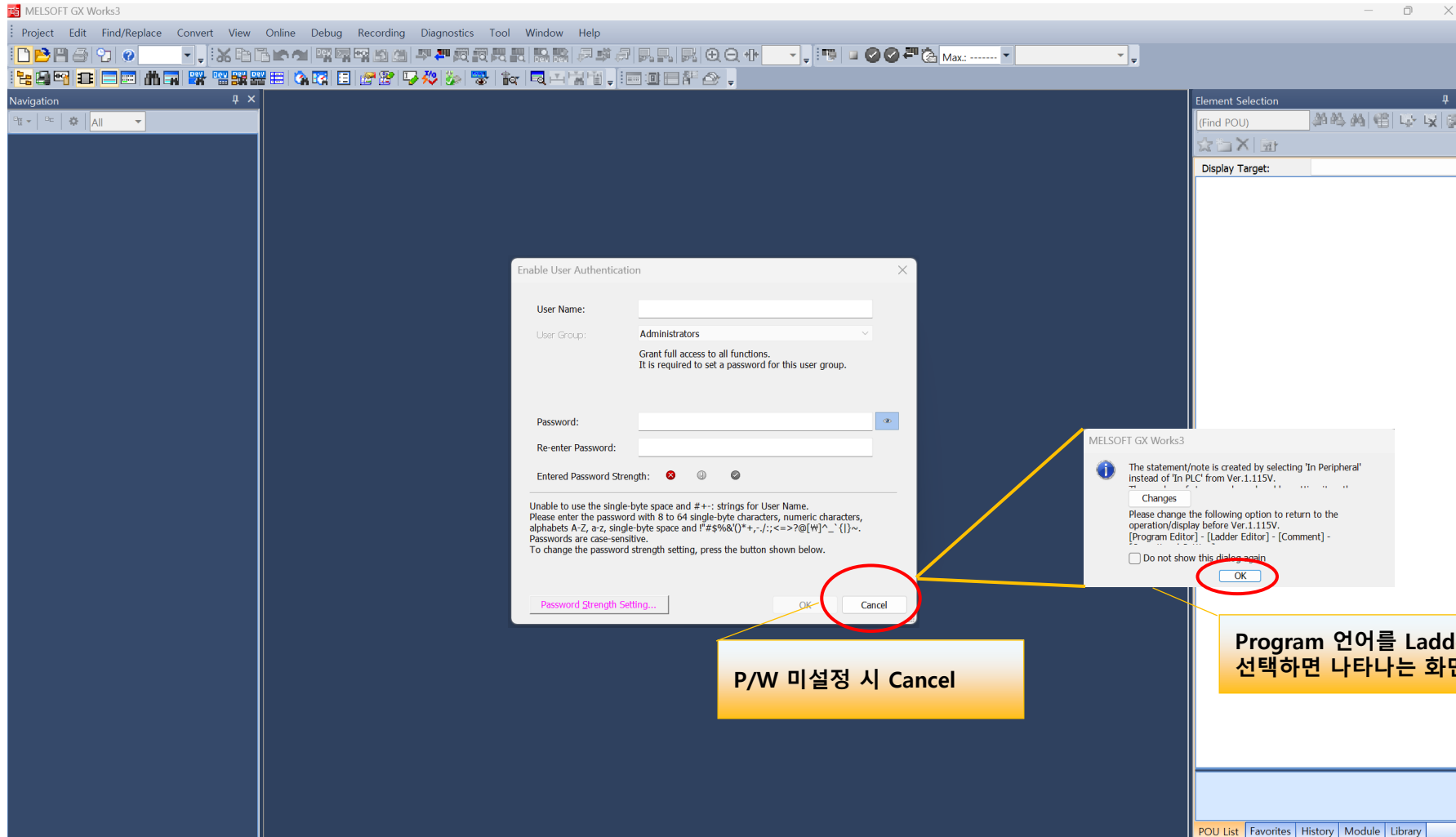
- 신규 Project 생성 시 MX Controller, 모델명, 사용 축수, Program 언어를 선택



2-2. User Authentication 설정

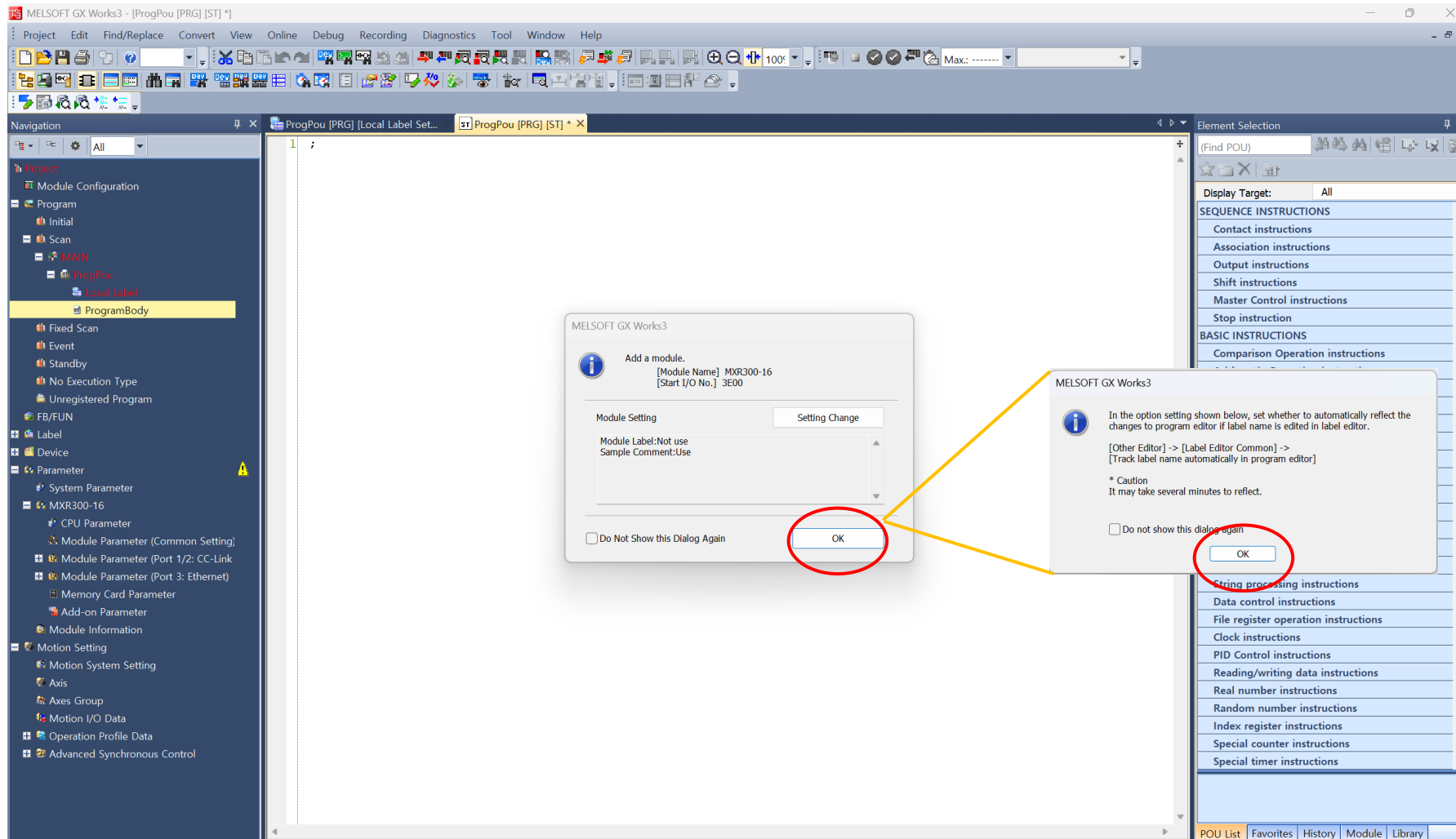
- 비밀번호 설정

※ 이 장에서는 Password 미설정으로 Cancel합니다.



2-3. Module 등록

- MXR300-xx 등록

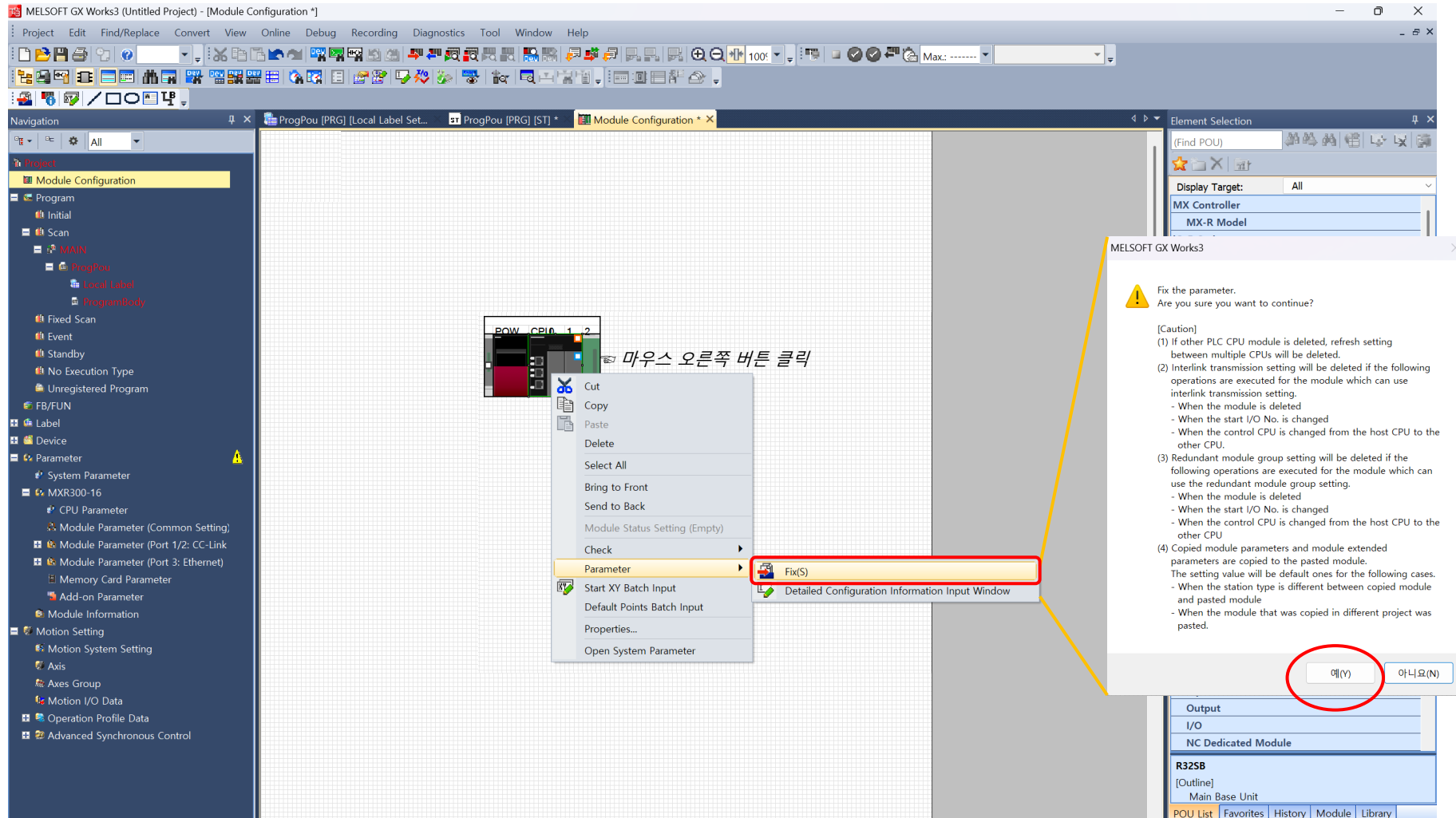


- 마우스로 클릭&드래그 하여 Main Base, CPU Module, Power Supply를 구성



2-4. Module Configuration – H/W

- 마우스의 오른쪽 버튼을 클릭하여 Fix(S) 선택으로 Module 구성을 완료



2-5. Module Parameter

- Station No./IP Address Setting : 예) IP Address → 192.168.3.253

MELSOFT GX Works3 (Untitled Project) - [MXR300-16 Module Parameter (Port 1/2: CC-Link IE TSN)]

Navigation: Project, Edit, Find/Replace, Convert, View, Online, Debug, Recording, Diagnostics, Tool, Window, Help

Setting Item List

Setting Item

Item	Setting
Station Type	Master Station
Network No.	1
Parameter Setting Method	Parameter Editor
Station No./IP Address Setting Method	Parameter Editor
Station No.	0
IP Address Setting	192.168.3.253
IP Address	192.168.3.253
Subnet Mask	
Default Gateway	

Element Selection

(Find POU)

Display Target: All

IP Address : 192.168.3.253
※ 참고: Ezi-SERVO-4X
Default IP: 192.168.3.xxx

Explanation

Set the IP address for the own node.
Ensure that the own node and the external device to be communicated with have the same class and subnet address.
Set the IP address to use for CC-Link IE TSN communication.

[Setting Range]
0.0.0.1 to 223.255.255.254 (00.00.00.01 to FF.FF.FF.FE)

Item List Find Result

Check Restore the Default

Apply

2-5. Module Parameter – N/W Configuration

● Network Configuration Settings

The screenshot displays the MELSOFT GX Works3 interface for configuring the MXR300-16 module. The main window is titled 'MELSOFT GX Works3 (Untitled Project) - [MXR300-16 Module Parameter (Port 1/2: CC-Link IE TSN)]'. The interface is divided into several panes:

- Project Tree (Left):** Shows the project structure. The 'Module Parameter' folder is expanded, and 'Module Parameter (Port 1/2: CC-Link)' is selected, indicated by a red box and callout 1.
- Setting Item List (Center):** Lists the configuration items. The 'Basic Settings' folder is expanded, and 'Network Configuration Settings (CC-Link IE TSN)' is selected, indicated by a red box and callout 2.
- Detailed Setting Window (Right):** Shows the configuration details for 'Network Configuration Settings (CC-Link IE TSN Configuration)'. The '<Detailed Setting>' link is highlighted with a red box and callout 3. The window includes a 'Module List' pane on the right showing the selected module: 'CC-Link IE TSN Module (Mitsubishi Ele)'. Below this, the 'Network Label' and 'Output' status are displayed.

The detailed configuration window shows the following settings:

Item	Setting
Network Configuration Settings (CC-Link IE TSN Configuration)	
Refresh Settings	
Network Topology	
Communication Period Setting	
Basic Period Setting	
Setting in Units of 1us	Not Set
Communication Period Interval Setting (Do not Set it in Units of 1us)	2000.00 us
Communication Period Interval Setting (Set it in Units of 1us)	2000.00 us
System Reservation Time	20.00 us
Cyclic Transmission Time	1000.00 us
Transient Transmission Time	980.00 us
Multiple Period Setting	
Normal-Speed	x4
Low-Speed	x16
Connection Device Information	
CC-Link IE TSN Class Setting	CC-Link IE TSN Class B Only
CC-Link IE TSN Class A Group Send Upper Limit Size Setting	2K bytes
TSN HUB Setting	Not to Use TSN HUB
Device Station Setting	
Disconnection Detection Setting	4 times

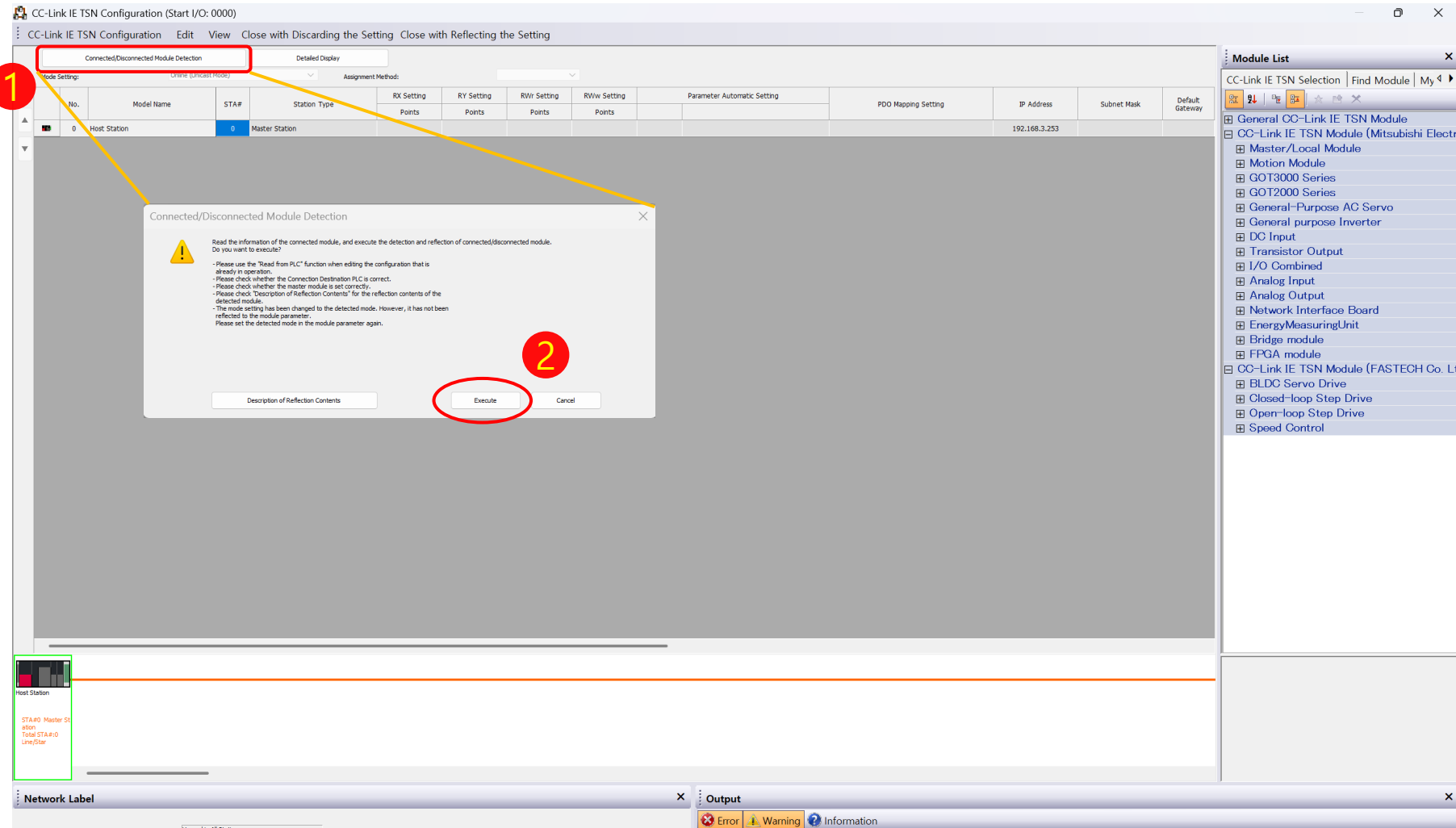
The 'Module List' pane shows the following modules:

- General CO-Link IE TSN Module
- CC-Link IE TSN Module (Mitsubishi Ele)
- Master/Local Module
- Motion Module
- GOT3000 Series
- GOT2000 Series
- General-Purpose AC Servo
- General purpose Inverter
- DC Input
- Transistor Output
- I/O Combined
- Analog Input

The 'Network Label' and 'Output' status are displayed at the bottom right. The 'Network Label' status is 'Unused in All Stations'. The 'Output' status shows 'Error', 'Warning', and 'Information' icons.

2-5. Module Parameter – CC-Link IE TSN Configuration

- N/W 연결된 상태 : CC-Link IE TSN Module을 자동으로 찾아서 구성



2-5. Module Parameter – CC-Link IE TSN Configuration

- N/W 연결된 상태 : CC-Link IE TSN Module을 자동으로 Ezi-SERVO CC-Link IE TSN 4X를 찾아서 구성

The screenshot displays the 'CC-Link IE TSN Configuration' window. The main table lists the detected modules:

No.	Model Name	STA#	Station Type	RX Setting	RY Setting	RWr Setting	RWw Setting	Parameter Automatic Setting	PDO Mapping Setting	IP Address	Subnet Mask	Default Gateway
0	Host Station	0	Master Station							192.168.3.253		
1	Ezi-SERVO-CT-4X	1	Remote Station				16	16	<Detail Setting>	192.168.3.17		
2	Ezi-SERVO-CT-4X	2	Remote Station				16	16	<Detail Setting>	192.168.3.18		
3	Ezi-SERVO-CT-4X	3	Remote Station				16	16	<Detail Setting>	192.168.3.19		
4	Ezi-SERVO-CT-4X	4	Remote Station				16	16	<Detail Setting>	192.168.3.20		

A yellow starburst callout points to the table with the text: "자동으로 찾은 Module" (Module found automatically).

A confirmation dialog box is shown in the center:

MELSOFT GX Works3

Connected/Disconnected Module Detection is completed.
Please execute Write to PLC if necessary.

- Please execute system configuration check because the system configuration is changed.

확인 (Confirm)

A yellow callout box on the right provides the IP addresses for the 4 modules:

[Ezi-SERVO CC-Link IE TSN 4X 4축 구성 예]
[Ezi-SERVO CC-Link IE TSN 4X 드라이버에
설정된 IP Address]

1. 192.168.3.1
2. 192.168.3.2
3. 192.168.3.3
4. 192.168.3.4

The bottom of the window shows a 'Network Label' section with a diagram of the station configuration, including STA#0 Master and STA#1-4 Remote Stations, each with an Ezi-SERVO-CT-4X module.

2-5. Module Parameter – CC-Link IE TSN Configuration

- N/W 미연결 상태 : CC-Link IE TSN Module을 수동(클릭 & 드래그)으로 구성

The screenshot shows the 'CC-Link IE TSN Configuration' window. The main table lists modules with their IP addresses. A red box highlights the IP address column, and a yellow callout box provides instructions for manual assignment.

No.	Model Name	STA#	Station Type	RX Setting	RY Setting	RW Setting	RWw Setting	Parameter Automatic Setting	PDO Mapping Setting	IP Address	Subnet Mask	Default Gateway
0	Host Station	0	Master Station							192.168.3.253		
1	Ezi-SERVO-CT-4X	1	Remote Station				16	16	<Detail Setting>	192.168.3.17		
2	Ezi-SERVO-CT-4X	2	Remote Station				16	16	<Detail Setting>	192.168.3.18		
3	Ezi-SERVO-CT-4X	3	Remote Station				16	16	<Detail Setting>	192.168.3.19		
4	Ezi-SERVO-CT-4X	4	Remote Station				16	16	<Detail Setting>	192.168.3.20		

[Ezi-SERVO CC-Link IE TSN 4X IP Address 임의로 수정]

1. 192.168.3.17
2. 192.168.3.18
3. 192.168.3.19
4. 192.168.3.20

※ IP Address 변경 후 전원 RESET 필요

[참고] Ezi-SERVO CC-Link IE TSN 4X IP Address 설정 16진수 로터리 스위치

The diagram shows the physical modules and their connection points. The 'Station Type' is set to 'Remote Station'.

2-5. Module Parameter – CC-Link IE TSN Configuration

- CC-Link IE TSN Module PDO Mapping Setting (축별 설정)

CC-Link IE TSN Configuration (Start I/O: 0000)

CC-Link IE TSN Configuration Edit View Close with Discarding the Setting Close with Reflecting the Setting

Mode Setting: Online (Unicast Mode) Assignment Method:

No.	Model Name	STA#	Station Type	RX Setting	RY Setting	RW Setting	RWw Setting	Parameter Automatic Setting	PDO Mapping Setting	IP Address	Subnet Mask	Default Gateway
0	Host Station	0	Master Station							192.168.3.253		
1	Ea-SERVO-CT	1	Remote Station			16	16		<Detail Setting>	192.168.3.17		
2	Ea-SERVO-CT	2	Remote Station			16	16		<Detail Setting>	192.168.3.18		
3	Ea-SERVO-CT	3	Remote Station			16	16		<Detail Setting>	192.168.3.19		

등록에 따라 생성됨

PDO Mapping Setting

Link Device Points

PDO Mapping Parameter

PDO Mapping Pattern Selection (1/2)

Please select the TPDO mapping pattern assigned in link device (RW).

Link Device (RW) Points: 16

No.	Pattern Name	Used Points
1	1st TPDO (CSP Mode)	8 Points
2	2nd TPDO (ProfilePosition Mode)	10 Points

Back Next Cancel

PDO Mapping Pattern Selection (2/2)

Please select the RPDO mapping pattern assigned in link device (RW).

Link Device (RW) Points: 16

No.	Pattern Name	Used Points
1	1st RPDO (CSP Mode)	7 Points
2	2nd RPDO (ProfilePosition Mode)	13 Points

Back OK Cancel

Network Label

Host Station

STA#1 STA#2 STA#3 STA#4

STA#0 Master Station
Total STA#13
UnitStar

Ea-SERVO-CT-4K Ea-SERVO-CT-4K Ea-SERVO-CT-4K Ea-SERVO-CT-4K

Module List

CC-Link IE TSN Selection Find Module My 4

- General CC-Link IE TSN Module
- CC-Link IE TSN Module (Mitsubishi Electric)
- Master/Local Module
- Motion Module
- GOT3000 Series
- GOT2000 Series
- General-Purpose AC Servo
- General-purpose Inverter
- DC Input
- Transistor Output
- I/O Combined
- Analog Input
- Analog Output

Board Init

Module (FASTECH Co. Ltd.)

Drive

Closed-Loop :
4X Closed-Loop :
ABS Closed-Loop :
ALL Closed-Loop :
Drive

[Outline]
Step Drive
[Specification]
Closed-Loop Step Drive
Motor: Max. NEMA 24
Mode: Homing, CSP, PP
CC-Link IE TSN Class B
[Manufacturer Name]
FASTECH Co. Ltd.
[Station Type]
Remote Station

Output

Error:0 Warning:0 Information:0

2-5. Module Parameter – CC-Link IE TSN Configuration

- CC-Link IE TSN Module PDO Mapping Setting (축별 설정)

등록에 따라 생성됨

PDO Mapping Setting

Link Device Points: 16

PDO Mapping Parameter

Link Device	Index [Hexadecimal]	Sub-Index [Hexadecimal]	Entry Name	Comment	Data Type
RW0000	1002	01	Watchdog counter UL 1		UNSIGNED16
RW0001	6041	00	Statusword		UNSIGNED16
RW0002	6061	00	Modes of operation display		INTEGER8
RW0003	603F	00	Error code		UNSIGNED16
RW0004	6064	00	Position actual value		INTEGER32
RW0005	6064	00	Position actual value		INTEGER32
RW0006	60F2	00	Digital Inputs		UNSIGNED32
RW0007	60F2	00	Digital Inputs		UNSIGNED32
RW0008					
RW0009					
RW000a					
RW000b					
RW000c					
RW000d					
RW000e					
RW000f					

PDO Mapping Pattern Selection...

OK Cancel

Module List

- CC-Link IE TSN Selection
- Find Module
- My 4
- General CC-Link IE TSN Module
- CC-Link IE TSN Module (Mitsubishi Electr
- Master/Local Module
- Motion Module
- GOT3000 Series

PDO 설정 완료되면 검정색으로 변경됨
<Detail Setting> → <Detail Setting>
반복으로 모든 축 PDO 설정

[Outline]
Step Drive
[Specification]
Closed-Loop Step Drive
Motor: Max. NEMA 24
Mode: Homing, CSP, PP
CC-Link IE TSN Class B
[Manufacturer Name]
FASTECH Co. Ltd
[Station Type]
Remote Station

Network Label

Output

Error:0 Warning:0 Information:0

2-5. Module Parameter – CC-Link IE TSN Configuration

- CC-Link IE TSN Module Setting 반영

The screenshot displays the 'CC-Link IE TSN Configuration' software window. The main configuration table lists stations 0 through 3, including their model names, station types, and various settings like RX, RY, RW, and RVW. A red circle highlights the 'Close with Reflecting the Setting' button in the top menu bar. A yellow arrow points from this button to a warning dialog box that appears in the center. The dialog box contains the text: 'Warning(s) in the CC-Link IE TSN Configuration. Are you sure you want to close the CC-Link IE TSN Configuration window?'. The '예(Y)' (Yes) button is circled in red. The background of the main window shows a network diagram with a host station and four remote stations (STA#1 to STA#4) connected by a line. The right sidebar shows a 'Module List' with various modules like 'General CC-Link IE TSN Module', 'CC-Link IE TSN Module (Mitsubishi Electric)', 'Master/Local Module', 'Motion Module', 'GOT3000 Series', 'GOT2000 Series', 'General-Purpose AC Servo', 'General purpose Inverter', 'DC Input', 'Transistor Output', 'I/O Combined', 'Analog Input', 'Analog Output', 'Network Interface Board', 'EnergyMeasuringUnit', 'Bridge module', 'FPGA module', 'CC-Link IE TSN Module (FASTECH Co. Ltd.)', 'BLDG Servo Drive', 'Closed-loop Step Drive', 'Ezi-SERVO-CT', 'Ezi-SERVO-CT-4X', 'Ezi-SERVO-CT-ABS', 'Ezi-SERVO-CT-ALL', 'Open-loop Step Drive', and 'Speed Control'. The bottom status bar shows 'Error:0', 'Warning:0', and 'Information:0'.

No.	Model Name	Station Type	RX Setting Points	RY Setting Points	RW Setting Points	RVW Setting Points	Parameter Automatic Setting	PDO Mapping Setting	IP Address	Subnet Mask	Default Gateway
0	Host Station	Master Station							192.168.3.253		
1	Ezi-SERVO-CT	Remote Station			16	16		<Detail Setting>	192.168.3.17		
2	Ezi-SERVO-CT	Remote Station			16	16		<Detail Setting>	192.168.3.18		
3	Ezi-SERVO-CT	Remote Station			16	16		<Detail Setting>	192.168.3.19		

등록에 따라 생성됨

MELSOFT GX Works3

Warning(s) in the CC-Link IE TSN Configuration.
Are you sure you want to close the CC-Link IE TSN Configuration window?

예(Y) 아니오(N)

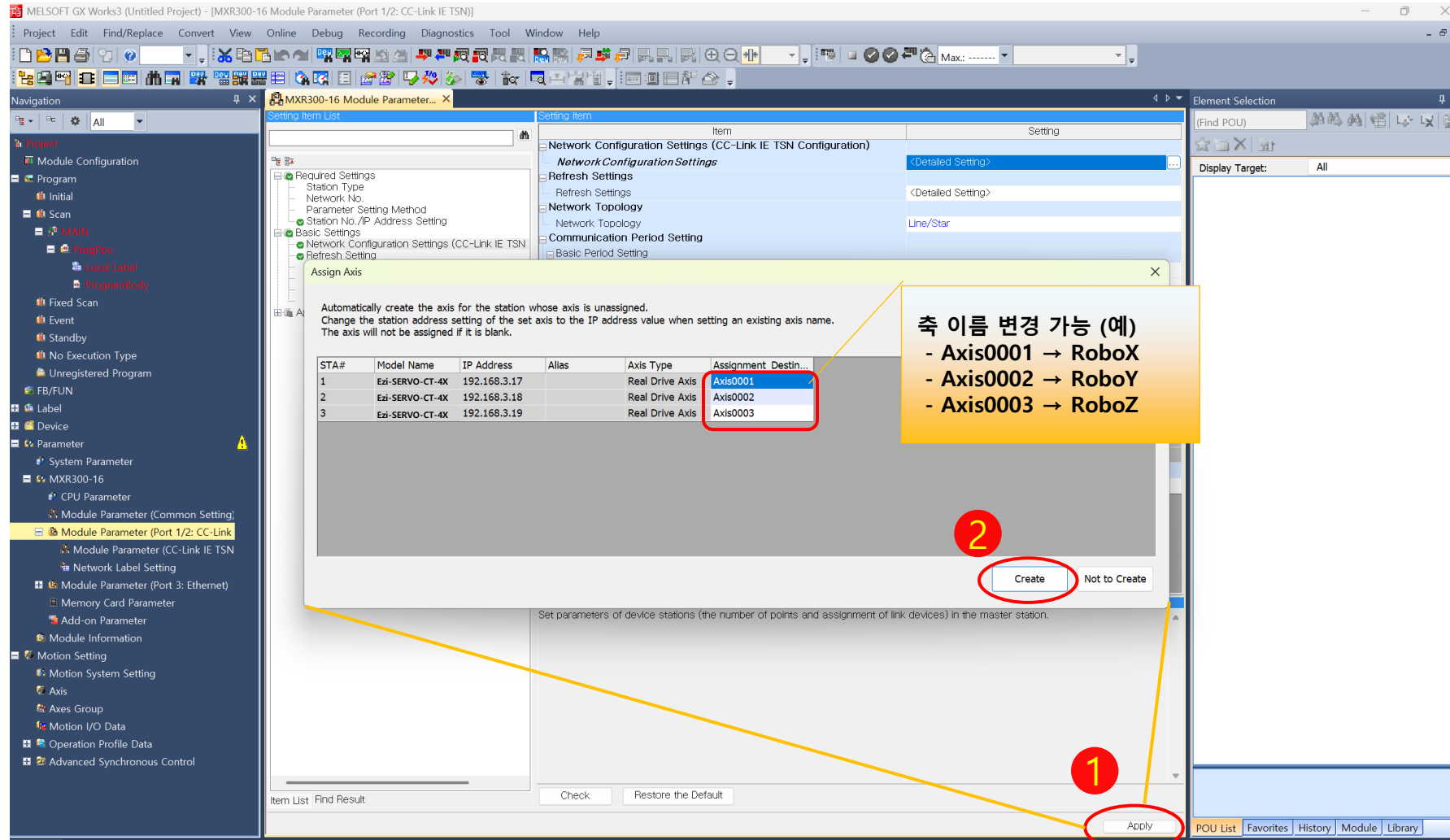
Network Label

Output

Error:0 Warning:0 Information:0

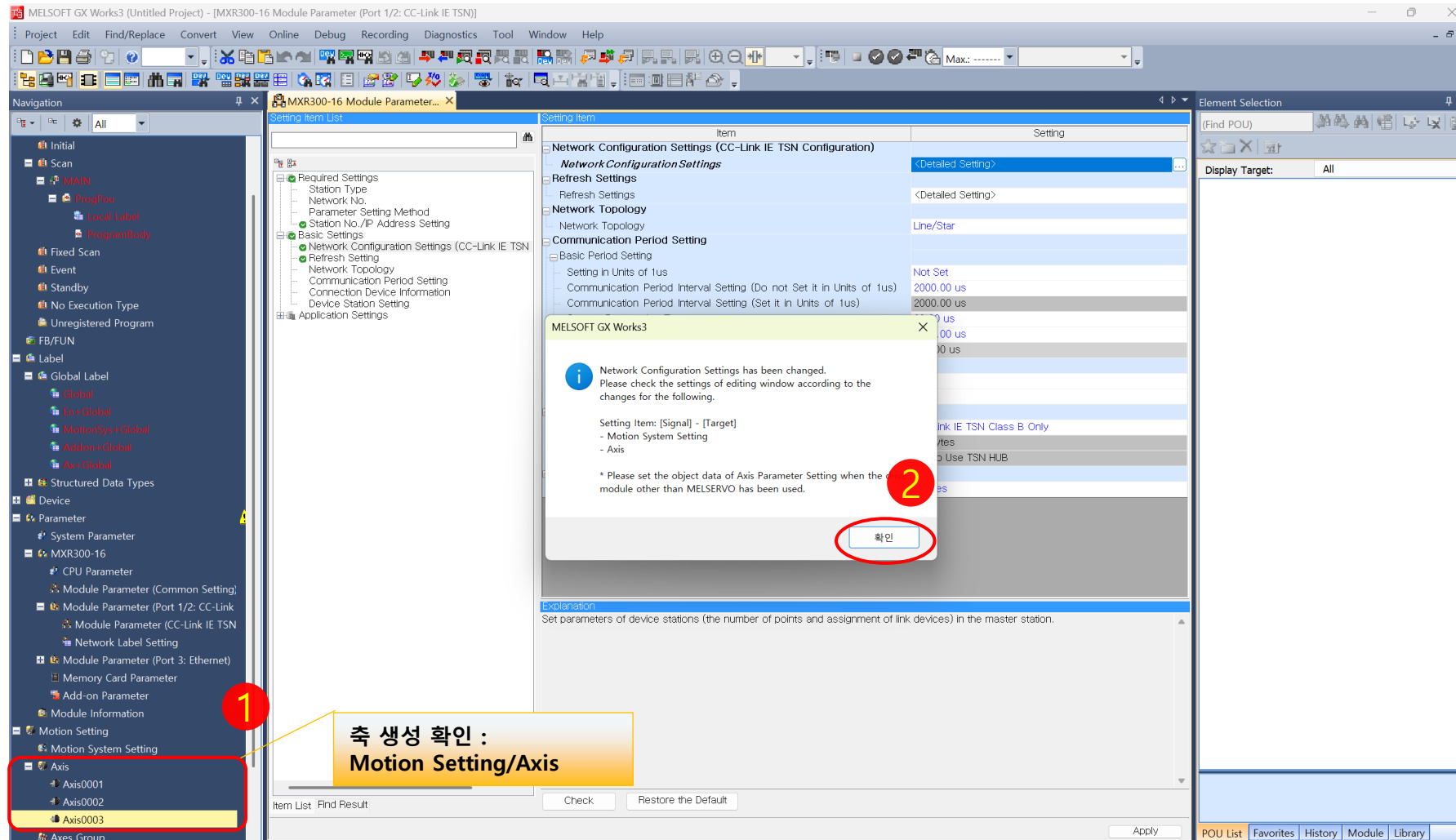
2-5. Module Parameter – CC-Link IE TSN Configuration

● 축 생성



2-5. Module Parameter – CC-Link IE TSN Configuration

- 축 생성 확인



2-5. Module Parameter – CC-Link IE TSN Configuration

● Network Label Setting – 축별 Digital In/Output 설정

The screenshot displays the MELSOFT GX Works3 interface with the 'Network Label Setting' window open. The window shows a table of I/O data for three servo modules (Ezi-SERVO_CT_001, Ezi-SERVO_CT_002, and Ezi-SERVO_CT_003). The table columns include IP Address, Model Name, Device Label/Structure, Data Type, Labeling Target, Arranged Target, Label Data Type, Label Name, and English Display. Red circles and numbers 1, 2, and 3 highlight specific areas: 1 points to the 'Labeling Target' column, 2 points to the 'Create Label' button, and 3 points to the 'Start creating the label on the basis of the following content.' dialog box.

N	IP Address	Model Name	Device Label/Structure	Data Type	Labeling Target	Arranged Target	Label Data Type	Label Name	English Display
1	192.168...	Ezi-SERV...	Ezi-SERVO_CT_001	Entire D...			Word [Unsigned/Bit Str...	Ezi-SERVO_CT_001_WatchdogCount...	RWw0
				RWw1			Word [Unsigned/Bit Str...	Ezi-SERVO_CT_001_Controlword	RWw1
				RWw2			Word [Signed]	Ezi-SERVO_CT_001_ModesOfOperation	RWw2
				RWw3			Double Word [Signed]	Ezi-SERVO_CT_001_TargetPosition	RWw3
				RWw5			Double Word [Unsigned...	Ezi-SERVO_CT_001_PhysicalOutputs	RWw5
				RWr0			Word [Unsigned/Bit Str...	Ezi-SERVO_CT_001_WatchdogCount...	RWr0
				RWr1			Word [Unsigned/Bit Str...	Ezi-SERVO_CT_001_Statusword	RWr1
				RWr2			Word [Signed]	Ezi-SERVO_CT_001_ModesOfOperati...	RWr2
				RWr3			Word [Unsigned/Bit Str...	Ezi-SERVO_CT_001_ErrorCode	RWr3
				RWr4			Double Word [Signed]	Ezi-SERVO_CT_001_PositionActualVa...	RWr4
				RWr6			Double Word [Unsigned...	Ezi-SERVO_CT_001_DigitalInputs	RWr6
2	192.168...	Ezi-SERV...	Ezi-SERVO_CT_002	Entire D...			Word [Unsigned/Bit Str...	Ezi-SERVO_CT_002_WatchdogCount...	RWw0
				RWw1			Word [Unsigned/Bit Str...	Ezi-SERVO_CT_002_Controlword	RWw1
				RWw2			Word [Signed]	Ezi-SERVO_CT_002_ModesOfOperation	RWw2
				RWw3			Double Word [Signed]	Ezi-SERVO_CT_002_TargetPosition	RWw3
				RWw5			Double Word [Unsigned...	Ezi-SERVO_CT_002_PhysicalOutputs	RWw5
				RWr0			Word [Unsigned/Bit Str...	Ezi-SERVO_CT_002_WatchdogCount...	RWr0
				RWr1			Word [Unsigned/Bit Str...	Ezi-SERVO_CT_002_Statusword	RWr1
				RWr2			Word [Signed]	Ezi-SERVO_CT_002_ModesOfOperati...	RWr2
				RWr3			Word [Unsigned/Bit Str...	Ezi-SERVO_CT_002_ErrorCode	RWr3
				RWr4			Double Word [Signed]	Ezi-SERVO_CT_002_PositionActualVa...	RWr4
				RWr6			Double Word [Unsigned...	Ezi-SERVO_CT_002_DigitalInputs	RWr6
3	192.168...	Ezi-SERV...	Ezi-SERVO_CT_003	Entire D...			Word [Unsigned/Bit Str...	Ezi-SERVO_CT_003_WatchdogCount...	RWw0
				RWw1			Word [Unsigned/Bit Str...	Ezi-SERVO_CT_003_Controlword	RWw1
				RWw2			Word [Signed]	Ezi-SERVO_CT_003_ModesOfOperation	RWw2
				RWw3			Double Word [Signed]	Ezi-SERVO_CT_003_TargetPosition	RWw3
				RWw5			Double Word [Unsigned...	Ezi-SERVO_CT_003_PhysicalOutputs	RWw5
				RWr0			Word [Unsigned/Bit Str...	Ezi-SERVO_CT_003_WatchdogCount...	RWr0
				RWr1			Word [Unsigned/Bit Str...	Ezi-SERVO_CT_003_Statusword	RWr1
				RWr2			Word [Signed]	Ezi-SERVO_CT_003_ModesOfOperati...	RWr2
				RWr3			Word [Unsigned/Bit Str...	Ezi-SERVO_CT_003_ErrorCode	RWr3
				RWr4			Double Word [Signed]	Ezi-SERVO_CT_003_PositionActualVa...	RWr4
				RWr6			Double Word [Unsigned...	Ezi-SERVO_CT_003_DigitalInputs	RWr6

Explanation

The I/O data exchanged between the device stations of built-in CC-Link IE TSN and the CPU module by cyclic communication can be registered. If 'Create Label' is executed, the label selected in 'Labeling Target' will be registered to the global label list (NW+Global).

[Caution]

- If 'Create Label' is executed, the all labels/structured data types created from this window last time will be deleted and new labels/structured data types will be created.
- The background of 'No.' in the window will be displayed in yellow for the device for which addition/change exists in the network configuration.
- 'Create Label' again if necessary.
- If 'Create Label' is not executed, the edited content in this window will not be saved in the project.

Start creating the label on the basis of the following content.

Are you sure you want to continue?

예(Y) 아니요(N)

Create Label

2-5. Module Parameter – CC-Link IE TSN Configuration

- Network Label Setting – 축별 Digital In/Output Enable *Limit SW, ORG SW, DIO 사용 가능 설정

MELSOFT GX Works3 C:\Work\테스트샘플\connectionGuide.gx3 - [NW+Global1 [Global Label Setting]]

Navigation: Project, Module Configuration, Program, FB/FUN, Label, Global Label, En+Global, MotionSys+Global, Addon+Global, Ax+Global, NW+Global1, Structured Data Types, Device, Parameter, System Parameter, MXR300-16, Module Information, Motion Setting, Motion System Setting, Axis, Axis0001, Axis0002, Axis0003, Axes Group, Motion I/O Data, Operation Profile Data, Advanced Synchronous Control

Network Label Setting: MXR300-16 Module Parameter...

Label Name	Data Type	English(Display Target)	Access from External Device
1. Ezi-SERVO_CT_001_PhysicalOutputs	Double Word (Unsigned) Bit String (32bit)	RWw5	☒
2. Ezi-SERVO_CT_001_DigitalInputs	Double Word (Unsigned) Bit String (32bit)	RWw5	☒
3. Ezi-SERVO_CT_002_PhysicalOutputs	Double Word (Unsigned) Bit String (32bit)	RWw5	☒
4. Ezi-SERVO_CT_002_DigitalInputs	Double Word (Unsigned) Bit String (32bit)	RWw5	☒
5. Ezi-SERVO_CT_003_PhysicalOutputs	Double Word (Unsigned) Bit String (32bit)	RWw5	☒
6. Ezi-SERVO_CT_003_DigitalInputs	Double Word (Unsigned) Bit String (32bit)	RWw5	☒

1

Ezi-SERVO CC-Link IE TSN 4X DIO 사용 Check (Limit SW, ORG, DIO Enable)

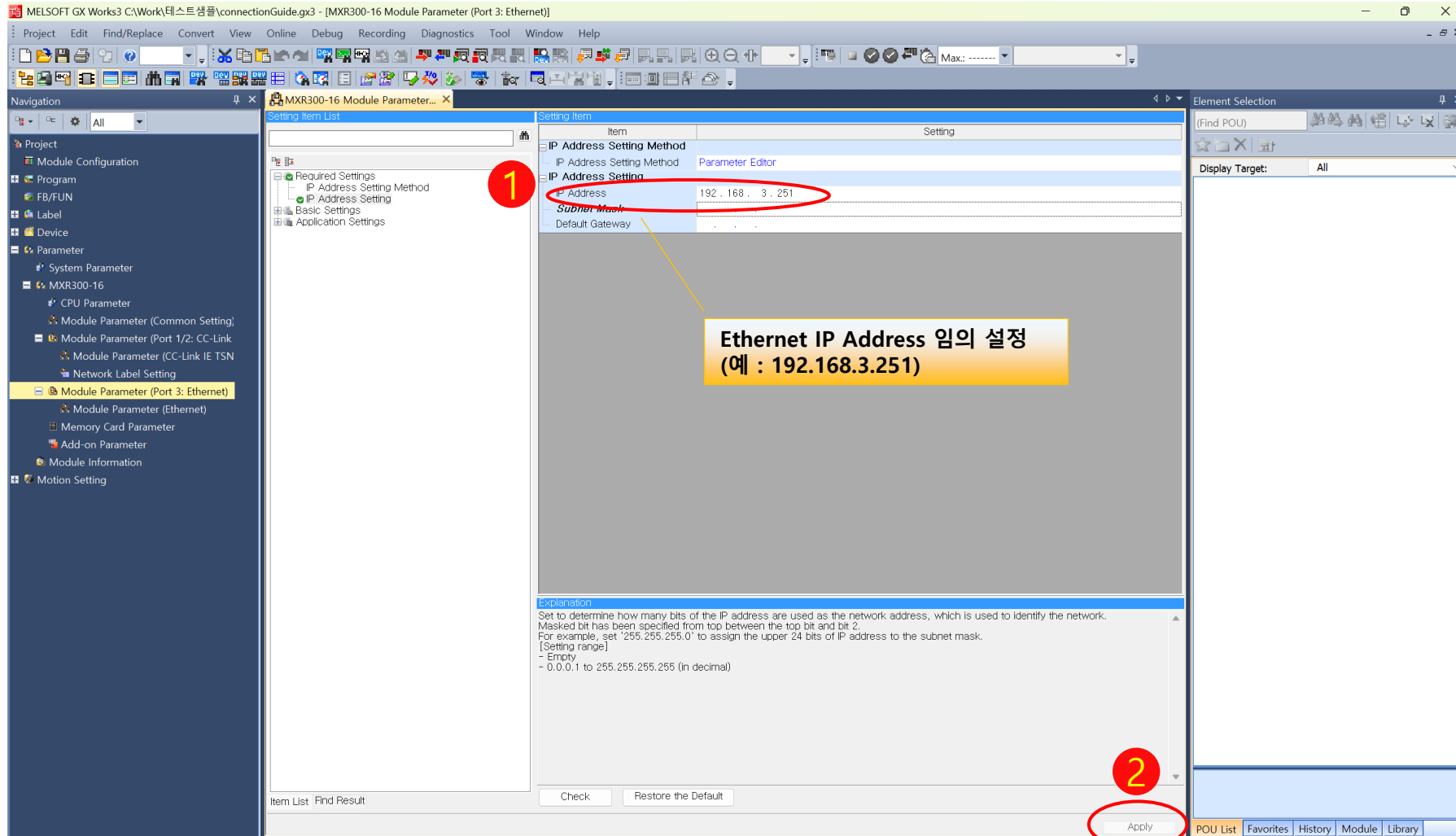
Output

Extended Display: Do Not Show Always

POU List | Favorites | History | Module | Library

2-5. Module Parameter – Port 3 : Ethernet

● Ethernet IP Address Setting



2-6. Motion Setting – Basic Parameter

- Real Drive Axis / Basic Parameter / Object Data 설정(1/3) *Ezi-SERVO CC-Link IE TSN 4X Object Data 등록

The screenshot illustrates the configuration process in MELSOFT GX Works3 for a real drive axis. The navigation tree on the left (1) shows the path: **Axis** > **Axis0001** > **Basic Parameter** > **Object Data**. The main window displays the **Axis Parameter Setting** for Axis0001, with the **ControlWord** parameter (3) selected. The **Object Data Setting (Axis0001)** dialog box (4) is open, showing the **ControlWord** parameter and its associated object data values. The **Restore the Data** button is highlighted. The **Set default data.** dialog box (5) is shown, asking for confirmation to set default values. The **MELSOFT GX Works3** warning dialog box (6) is also visible, indicating that the specified station address refers to a non-MELSERVO device.

Ezi-SERVO CC-Link IE TSN 4X Object Data

Set default data.
Are you sure you want to continue?

예(Y) 아니요(N)

MELSOFT GX Works3

The specified station address refers to a non-MELSERVO device.
Do you want to set to generic default values?
Yes: Set to generic default values
No: Set to default values for MELSERVO

예(Y) 아니요(N) 취소



2-6. Motion Setting – Basic Parameter

- Real Drive Axis / Basic Parameter / Object Data 설정(3/3) *Ezi-SERVO CC-Link IE TSN 4X Object Data 등록

The screenshot shows the 'Axis Parameter Setting' window in MELSOFT GX Works3. The 'Object Data' tab is selected, and a table of object data is displayed. A red circle highlights the 'Object Data' table, and a yellow callout box points to it with the text 'Ezi-SERVO CC-Link IE TSN 4X 모든 축 [OBJ] 변경된 내용 확인'. The 'Apply' button at the bottom right is also circled in red.

Item	Axis0001	Axis0002	Axis0003
Set Axis Information			
Axis No.	1	2	3
Set Basic Parameter			
Station Address Setting	192.168.3.17	192.168.3.18	192.168.3.19
Axis Type Setting	0:Real Drive Axis	0:Real Drive Axis	0:Real Drive Axis
Axis Emulation Enabled	0:Disabled	0:Disabled	0:Disabled
Control Cycle Setting	0:Automatic setting	0:Automatic setting	0:Automatic setting
Object Data			
ControlWord	[OBJ]0x6040001	[OBJ]0x6040001	[OBJ]0x6040001
EncoderIncrements	[OBJ]0x608F012	[OBJ]0x608F012	[OBJ]0x608F012
FollowingErrActualValue	[OBJ]0x60F4002	[OBJ]0x60F4002	[OBJ]0x60F4002
GearRatioMotorRevolutions	[OBJ]0x607C002	[OBJ]0x607C002	[OBJ]0x607C002
HomeOffset	[OBJ]0x6080002	[OBJ]0x6080002	[OBJ]0x6080002
MaxMotorSpeed	[OBJ]0x6072001	[OBJ]0x6072001	[OBJ]0x6072001
MaxTorque	[OBJ]0x6060000	[OBJ]0x6060000	[OBJ]0x6060000
ModesOfOpDisp	[OBJ]0x6061000	[OBJ]0x6061000	[OBJ]0x6061000
NegativeTorqueLimitValue	[OBJ]0x60E1001	[OBJ]0x60E1001	[OBJ]0x60E1001
Polarity	[OBJ]0x607E000	[OBJ]0x607E000	[OBJ]0x607E000
PosActualValue	[OBJ]0x6064002	[OBJ]0x6064002	[OBJ]0x6064002
PosEncoderResolution	[OBJ]0x608F000	[OBJ]0x608F000	[OBJ]0x608F000
PosEncoderResolutionMotorRevolutions	[OBJ]0x608F022	[OBJ]0x608F022	[OBJ]0x608F022
StrokeLimit	[OBJ]0x60E0001	[OBJ]0x60E0001	[OBJ]0x60E0001
Driver	[OBJ]0x60A8002	[OBJ]0x60A8002	[OBJ]0x60A8002
Other	[OBJ]0x60A9002	[OBJ]0x60A9002	[OBJ]0x60A9002
PosActualValue	[OBJ]0x6041001	[OBJ]0x6041001	[OBJ]0x6041001
PosEncoderResolution	[OBJ]0x6502002	[OBJ]0x6502002	[OBJ]0x6502002

Request the drive unit to switch status.
The setting values depending on the drive unit connected. Check the manual of object data settings.

Apply

2-6. Motion Setting – Basic Parameter

- Real Drive Axis / Basic Parameter / Absolute Position Control Setting - Disable 선택

MELSOFT GX Works3 C:\Work\테스트\샘플\connectionGuide.gx3 - [Axis Parameter Setting]

Navigation: Project, Module Configuration, Program, FB/FUN, Label, Device, Parameter, System Parameter, MXR300-16, CPU Parameter, Module Parameter (Common Setting), Module Parameter (Port 1/2: CC-Link), Module Parameter (CC-Link IE TSN), Network Label Setting, Module Parameter (Port 3: Ethernet), Memory Card Parameter, Add-on Parameter, Module Information, Motion Setting, Motion System Setting, Axis.

Setting Item List: Input the Setting Item to Search, Select Folder, Display All Data.

Axis Information: Set Axis Information, Axis No. 1, 2, 3.

Basic Parameter: Set Basic Parameter, Station Address Setting, Axis Type Setting, Axis Emulation Enabled, Control Cycle Setting, Object Data.

Absolute Position Control Setting: 0:Disable Absc, -1:Automatic Set, -1:Automatic Set, 0:Disable Absolute Position System, -1:Automatic Setting (Acquire from Connected Device), -10000000000.0, -10000000000.0, -10000000000.0, pulse, pulse, pulse, U/s, 0.0 pulse/s, 0.0 pulse/s, 0.0 pulse/s, 1 pulse, 1 pulse, 1 pulse, 1 pulse, 1 pulse, 1 pulse.

Limit Parameter: Set Limit Parameter, Torque Limit Maximum Value, Torque Limit Initial Value, Negative Direction Torque Limit Initial Value.

Explanation: <Axis Parameter Constant>, Axis.PrConst.PosRestoration_AbsPosEnable, Set the absolute position control setting, [Setting Range], 0:Disable Absolute Position System, 1:Enable Absolute Position System, -1:Automatic Setting (Acquire from Connected Device).

Apply

Ezi-SERVO CC-Link IE TSN 4X는 Disable Absolute Position System으로 선택

2-6. Motion Setting – Basic Parameter

- Real Drive Axis / Basic Parameter / Position Command Unit 설정 (Ezi-SERVO CC-Link IE TSN 4X 인코더 10,000ppr)

Ezi-SERVO CC-Link IE TSN 4X의 Encoder Resolution Setting Range는 10,000 pulse/rev

기어비 설정 방법은 기존방법과 동일함

1 Select Folder: Display All Data

2 Position Command Unit: degree

3 Encoder Resolution: 10000 [pulse/rev]

4 Calculate Axis Parameters

5 Reflects the calculation result to the axis parameters. Values currently set will be deleted and updated to the values of calculation result. Are you sure? 예(Y) 아니오(N)

2-6. Motion Setting – Basic Parameter

- Real Drive Axis / Basic Parameter / Position Command Unit 설정 (Ezi-SERVO CC-Link IE TSN 4X 인코더 10,000ppr)

The screenshot displays the MELSOFT GX Works3 interface for setting axis parameters. The left sidebar shows the project structure, with 'Axis0001' selected under 'Motion Setting'. The main window shows the 'Set Basic Parameter' table for Axis0001, Axis0002, and Axis0003. The 'Position Command Unit' section is highlighted with a red box, showing settings for degree, mm, and mm. The 'Driver Unit Conversion Numerator' and 'Driver Unit Conversion Denominator' are also highlighted with a red box, showing values of 10000 pulse and 360 degree, 5 mm, and 10 mm respectively. The right sidebar shows the 'Element Selection' panel with 'Display Target' set to 'All'.

Item	Axis0001	Axis0002	Axis0003
Axis Information	Set Axis Information		
Axis No.	1	2	3
Station Address Setting	192.168.3.17	192.168.3.18	192.168.3.19
Axis Type Setting	0:Real Drive Axis	0:Real Drive Axis	0:Real Drive Axis
Axis Emulation Enabled	0:Disabled	0:Disabled	0:Disabled
Control Cycle Setting	0:Automatic settin	0:Automatic settin	0:Automatic settin
Object Data	Set Object Data		
Absolute Position Control Setting	0:Disable Absolut	0:Disable Absolut	0:Disable Absolut
Current Position Restore Reference	-1:Automatic judg	-1:Automatic judg	-1:Automatic judg
Ring Counter Enabled Selection	0:Disabled	0:Disabled	0:Disabled
Ring Counter Upper Limit Value	10000000000.0	10000000000.0	10000000000.0
Ring Counter Lower Limit Value	-10000000000.0	-10000000000.0	-10000000000.0
Position Command Unit	degree	mm	mm
Velocity Command Unit	U/s	U/s	U/s
Velocity Bias Value	0.0 degree/s	0.0 mm/s	0.0 mm/s
Driver Unit Conversion Numerator	10000 pulse	10000 pulse	10000 pulse
Driver Unit Conversion Denominator	360 degree	5 mm	10 mm
Limit Parameter	Set Limit Parameter		
Torque Limit Maximum Value	1000.0 %	1000.0 %	1000.0 %
Negative Direction Torque Limit Initial Value	300.0 %	300.0 %	300.0 %
Positive Direction Torque Limit Initial Value	300.0 %	300.0 %	300.0 %
Upper Limit Signal	Set Upper Limit Signal		
Signal Target	0:Detection at TRL 0:Detection at TRL 0:Detection at TRL		
Signal Detection Method	0:Detection at TRL 0:Detection at TRL 0:Detection at TRL		
Compensation Time	0.0 s	0.0 s	0.0 s

Robot or Stage 이동 단위 선택

Ezi-SERVO CC-Link IE TSN 4X Encoder 10,000 pulse/rev

모터 1회전당 이동 거리/각도 설정

Apply

2-6. Motion Setting – Basic Parameter

● Real Drive Axis / Basic Parameter / Limit Parameter

Ezi-SERVO CC-Link IE TSN 4X +Limit Switch 설정은 Ezi_SERVO_CT_001_DigitalInputs.1

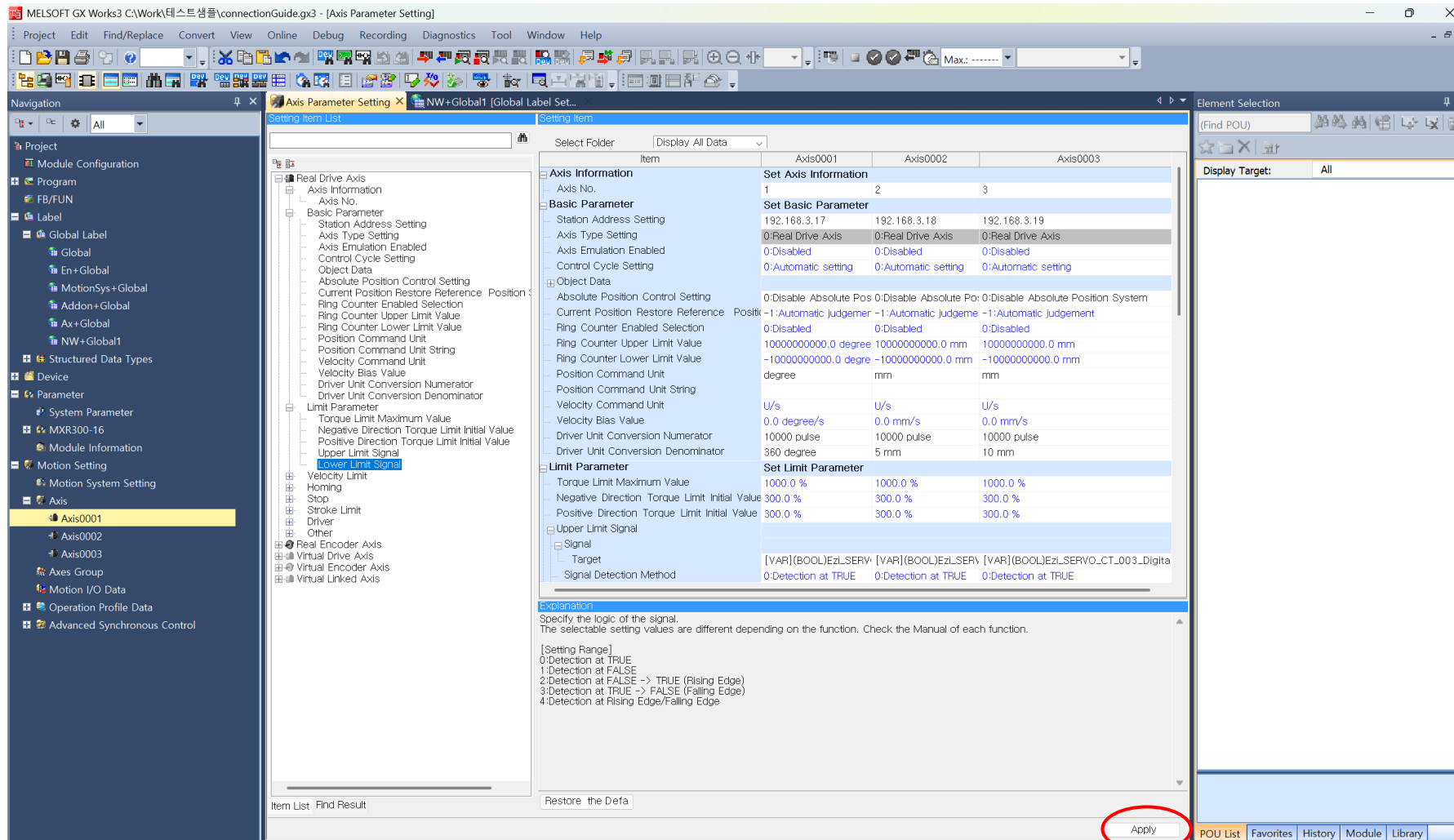
Ezi-SERVO CC-Link IE TSN 4X -Limit Switch 설정은 Ezi_SERVO_CT_001_DigitalInputs.0

주) Ezi_SERVO_CT_001_DigitalInputs.x 라벨 설정이 안될 경우
 1. PDO Mapping Setting 확인 (16~17page)
 2. Network Label Setting 확인 (21~22page)

Apply

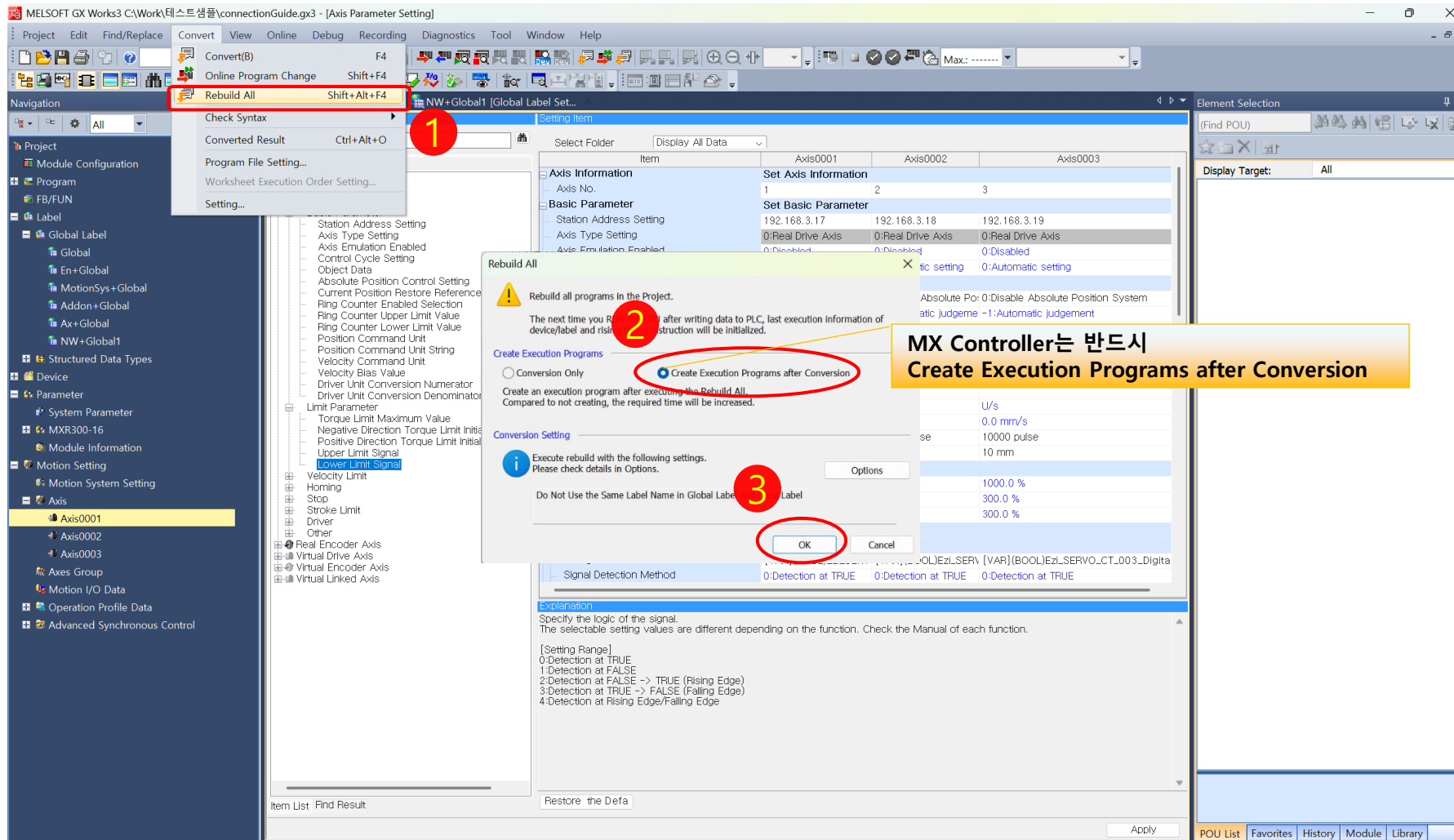
2-6. Motion Setting – Parameter 등록

- Parameter 등록으로 Motion Setting 완료



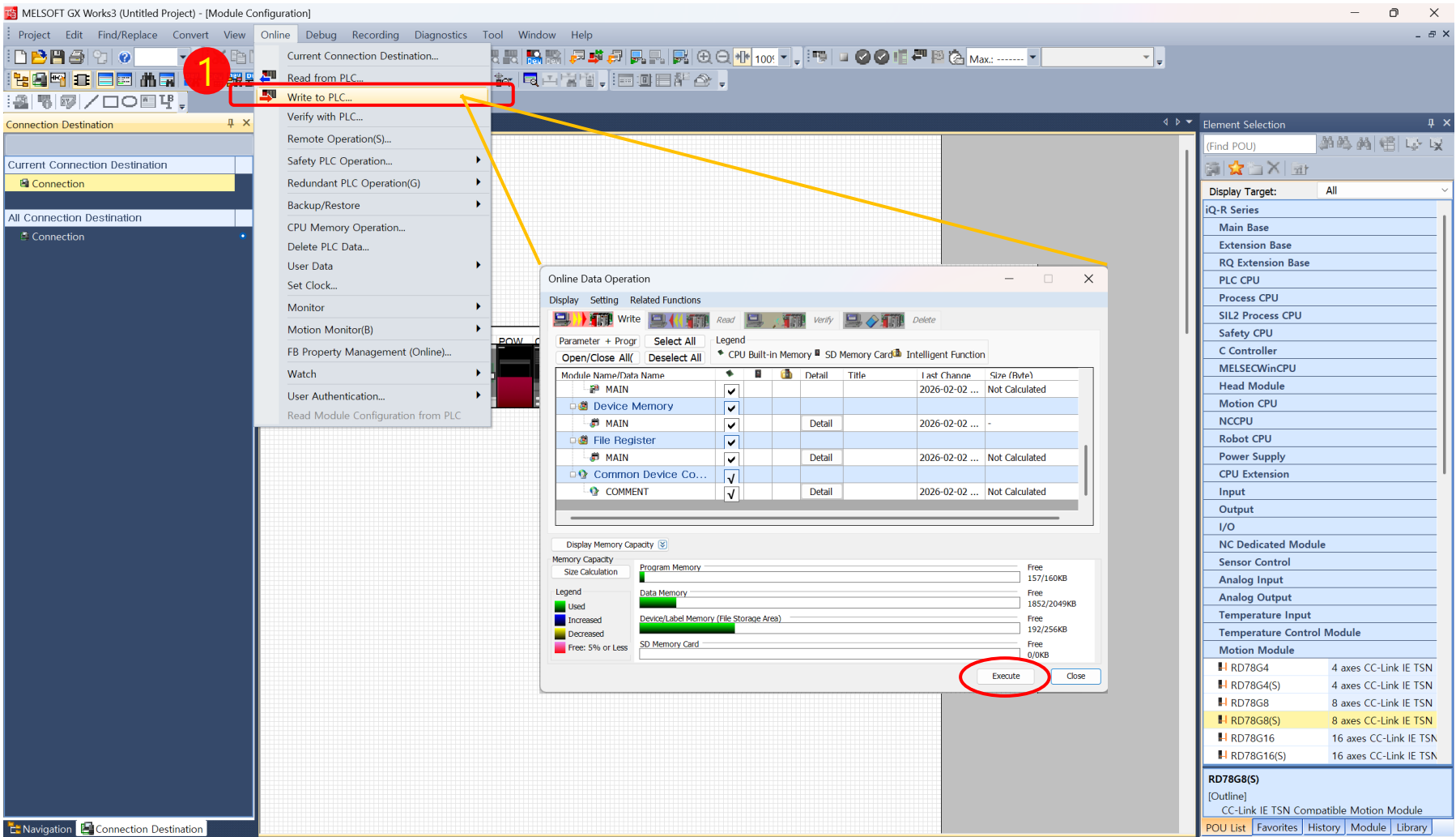
2-7. Convert

- Parameter 설정 등에 대하여 “Create Execution Programs after Conversion” 하기



2-8. Write to PLC

- Online Data Operation



3. Program 따라 하기

3-1. Motion 제어 명령어 살펴보기

● Motion Control Function/Function Block 명령어 – Element Selection (좌측 메뉴)

The screenshot shows the MELSOFT GX Works3 interface. The main window displays a ladder logic program with a 'MC_Power 1' block. A red box highlights the 'Motion Control Function/Function Block' section in the right-hand 'Element Selection' panel. A yellow dotted arrow points from the 'MC_Power 1' block in the ladder logic to the 'MC_Power' block in the selection list. The text '마우스 클릭 & 드래그' (Mouse click & drag) is written near the arrow.

Navigation

- Project
 - Module Configuration
 - Program
 - Initial
 - Scan
 - MAIN
 - ProgPou
 - Local Label
 - ProgramBody
 - Fixed Scan
 - Event
 - Standby
 - No Execution Type
 - Unregistered Program
- Label
- Device
- Parameter
 - System Parameter
 - MXR300-16
 - CPU Parameter
 - Module Parameter (Common Setting)
 - Module Parameter (Port 1/2: CC-Link)
 - Module Parameter (CC-Link IE TSN)
 - Network Label Setting
 - Module Parameter (Port 3: Ethernet)
 - Memory Card Parameter
 - Add-on Parameter
 - Module Information
 - Motion Setting
 - Motion System Setting
 - Axis
 - Axis0001
 - Axis0002
 - Axis0003
 - Axis Group
 - Motion I/O Data
 - Operation Profile Data

Element Selection

(Find POU)

Display Target: All

Selection

String

Bit Shift

Edge Detection

Counter

Timer

Bistable

Motion Control Function/Function Block

- Administrative
 - MC_AbortTrigger Touch Probe Disabled
 - MC_CamTableSelect Cam Table Selection
 - MC_DigitalCamSwitch Outputs the digital ca
 - MC_GroupDisable Axes Group Disabled
 - MC_GroupEnable Axes Group Enabled
 - MC_GroupReset Axes Group Error Resi
 - MC_GroupSetOverri Axes Group Override
 - MC_Power Operation Available
 - MC_ReadParameter Parameter Read
 - MC_Reset Axis Error Reset
 - MC_SetOverride Override Value Setting
 - MC_SetPosition Current Position Chan
 - MC_TouchProbe Touch Probe Enabled
 - MC_WriteParameter Parameter Write
 - MCv_AdvCamSetPos Advanced Synchron
 - MCv_AdvPositionPe Advanced Synchron
 - MCv_AllPower All Axes Operation Av
 - MCv_ChangeCycle Current Value Change
 - MCv_MotionErrorRe Motion Error Reset
 - MCv_SetTorqueLimi Torque Limit Value
 - MCv_SyncOperation Control Operation Cyc
- Motion - Individual
- General FB

MC_AbortTrigger

[Version]

00A

POU List Favorites History Module Library

3-2. [Ladder] SERVO Enable, SERVO ON

- Ezi-SERVO Enable/SERVO ON Program

The screenshot displays the MELSOFT GX Works3 interface for a ladder logic program. The main workspace shows a ladder logic diagram with the following components:

- Read Mtrr** (Block 1): (0)
- DUT: Axis** (Block 6): MC_Power 1 (MC_Power)
- B: Enable** (Block 3): bAx1SrvEnbl
- B: ServoON** (Block 4): bAx1SrvOn
- END** (Block 8): (9)

A yellow callout box contains the following text:

SERVO ON/OFF FB은 2종

- 개별 On/Off : MC_Power
- 일괄 On/Off : MCv_AllPower

The right sidebar shows the **Element Selection** panel with the following categories:

- Display Target:** All
- Selection**
 - String
 - Bit Shift
 - Edge Detection
 - Counter
 - Timer
 - Bistable
- Motion Control Function/Function Block**
 - Administrative**
 - MC_AbortTrigger (Touch Probe Disabled)
 - MC_CamTableSelect (Cam Table Selection)
 - MC_DigitalCamSwitch (Outputs the digital ca)
 - MC_GroupDisable (Axes Group Disabled)
 - MC_GroupEnable (Axes Group Enabled)
 - MC_GroupReset (Axes Group Error Resi)
 - MC_GroupSetOverri (Axes Group Override)
 - MC_Power (Operation Available)
 - MC_ReadParameter (Parameter Read)
 - MC_Reset (Axis Error Reset)
 - MC_SetOverride (Override Value Setting)
 - MC_SetPosition (Current Position Chan)
 - MC_TouchProbe (Touch Probe Enabled)
 - MC_WriteParameter (Parameter Write)
 - MCv_AdvCamSetPos (Advanced Synchron)
 - MCv_AdvPositionPe (Advanced Synchron)
 - MCv_AllPower (All Axes Operation Av)
 - MCv_ChangeCycle (Current Value Change)
 - MCv_MotionErrorRe (Motion Error Reset)
 - MCv_SetTorqueLimi (Torque Limit Value)
 - MCv_SyncOperation (Control Operation Cyc)
- Motion - Individual**
- General FB**
- MC_AbortTrigger**
 - [Version]
 - 00A

The bottom of the sidebar shows the **POU List** with tabs for Favorites, History, Module, and Library.

3-3. [Ladder] Ezi-SERVO 원점복귀 방법 지정

원점복귀 방법은 Homing method(6098h)에 설정한 값에 따라 다음과 같이 분류됩니다.

- 원점복귀 방법 지정하기 (MC_WriteParameter, 33: Homing index pu)

설정값	내용
1	Homing on negative limit switch and index pulse
2	Homing on positive limit switch and index pulse
7	Homing on home switch (positive direction, negative edge) and index pulse
10	Homing on home switch (positive direction, positive edge) and index pulse
11	Homing on home switch (negative direction, positive edge) and index pulse
14	Homing on home switch (negative direction, negative edge) and index pulse
17	Homing on negative limit switch
18	Homing on positive limit switch
24	Homing on home switch (positive direction, negative edge)
25	Homing on home switch (positive direction, positive edge)
28	Homing on home switch (negative direction, positive edge)
29	Homing on home switch (negative direction, negative edge)
33	Homing index pulse (negative direction)
34	Homing index pulse (positive direction)
35	Set the current position origin
37	Set the current position origin and reset current position
-3	Homing on negative mechanical limit
-4	Homing on positive mechanical limit
-5	Homing on negative mechanical limit and index pulse
-6	Homing on positive mechanical limit and index pulse

The screenshot displays the MELSOFT GX Works3 interface. The main window shows a ladder logic program for the 'ProgPou [PRG] [LD] (Read Only...)' project. A function block 'MC_WriteParameter' is highlighted with a red circle and labeled 'FB : MC_WriteParameter'. The ladder logic includes a normally open contact labeled 'bAx1WParam' and a coil labeled 'MC_WriteParameter_1 (MC_...)'. The right side of the screen shows the 'Comparison' table with various motion control function blocks. The bottom right corner shows the 'MC_WriteParameter' block with its parameters.

Comparison	Time Data Type	Single Numeric Variable	Selection	String	Bit Shift	Edge Detection	Counter	Timer	Bistable	Motion Control Function/Function Block
Administrative										
MC_AbortTrigger	Touch Probe Disabled									
MC_CamTableSelect	Cam Table Selection									
MC_DigitalCamSwitc	Outputs the digital ca									
MC_GroupDisable	Axes Group Disabled									
MC_GroupEnable	Axes Group Enabled									
MC_GroupReset	Axes Group Error Rese									
MC_GroupSetOverri	Axes Group Override									
MC_Power	Operation Available									
MC_ReadParameter	Parameter Read									
MC_Reset	Axis Error Reset									
MC_SetOverride	Override Value Setting									
MC_SetPosition	Current Position Chan									
MC_TouchProbe	Touch Probe Enabled									
MC_WriteParameter	Parameter Write									

MC_WriteParameter
[Version]
00A

POU List Favorites History Module Libra

3-4. [Ladder] Ezi-SERVO 원점복귀 실행

- 원점복귀 실행 (MC_Home)

The screenshot displays the MELSOFT GX Works3 interface for a Mitsubishi PLC program. The main window shows a ladder logic diagram for the 'MC_Home' function. The program is organized into a table with columns for step numbers (1-12) and various data fields including DUT, Axis, B, L, UD, and ErrorID.

Program Structure:

- MC_WriteParameter_1 (MC_...)**: This block is used to write parameters to the MC module. It includes fields for DUT, Axis, B, L, UD, and ErrorID.
- MC_Home_1 (MC_Home)**: This block is the main function for the home return operation. It includes fields for DUT, Axis, B, L, UD, and ErrorID.

Ladder Logic Details:

- Step 12**: Initial setup for the MC module.
- Step 13**: Ladder logic involving **bAx1WParam** and **bAx1ParamD...**.
- Step 14**: Ladder logic involving **bAx1HomeSL** and **bAx1HomeDo**.
- Step 15**: Ladder logic involving **bAx1Home**.
- Step 16**: Ladder logic involving **bAx1Home**.
- Step 17**: Ladder logic involving **bAx1Home**.
- Step 18**: Ladder logic involving **bAx1Home**.
- Step 19**: Ladder logic involving **bAx1Home**.
- Step 20**: Ladder logic involving **bAx1Home**.
- Step 21**: Ladder logic involving **bAx1Home**.
- Step 22**: Ladder logic involving **bAx1Home**.
- Step 23**: Ladder logic involving **bAx1Home**.
- Step 24**: Ladder logic involving **bAx1Home**.
- Step 25**: Ladder logic involving **bAx1Home**.
- Step 26**: Ladder logic involving **bAx1Home**.
- Step 27**: Ladder logic involving **bAx1Home**.
- Step 28**: Ladder logic involving **bAx1Home**.
- Step 29**: Ladder logic involving **bAx1Home**.

Right Panel (Element Selection):

- Display Target:** All
- Standard Function/Function Block:** Bit Type Boolean, Type Conversion, Arithmetic Operation, Comparison, Time Data Type, Single Numeric Variable, Selection, String, Bit Shift, Edge Detection, Counter, Timer, Bistable.
- Motion Control Function/Function Block:** Administrative, Motion - Individual.
- Motion - Individual:** MC_CamIn, MC_CombineAxes, MC_GearIn, MC_GroupStop, MC_Home, MC_MoveAbsolute, MC_MoveRelative, MC_MoveVelocity, MC_Stop, MC_TorqueControl, MCv_AdvancedSync, MCv_BacklashComp, MCv_CyclicPosition.
- MC_Home:** [Version] 00A.

Bottom Panel: POU List, Favorites, History, Module, Library.

3-5. [Ladder] Ezi-SERVO 이동 동작 실행

- 이동 동작 실행 (MC_MoveAbsolute)

임의 설정 이동 Position

- bAx1PosPos1 ON → 3600.0
- bAx1PosPos1 ON → 0.0
- ※ 3,600 – 10회전

The screenshot shows the MELSOFT GX Works3 interface with a ladder logic program for MC_MoveAbsolute. The program is organized into steps (1-18) and includes various logic elements such as bAx1Pos1, bAx1Pos2, bAx1Run, and bAx1MoveDone. A red circle highlights the EDMOV instruction in step 11, which is set to 3600.0 and edAx1Pos1. A yellow callout box provides additional information about the position setting.

MC_MoveAbsolute_1 (MC_M...)

Parameter	Value	Unit	Comment
DUT: Axis	Axis: DUT		
B: Execute	Done	B	
B: Continuou...	Busy	B	
L: Position	Active	B	
L: Velocity	Command...	B	
L: Accelerati...	Error	B	
L: Decelerati...	ErrorID	UD	
L: Jerk			
W: Direction	K3		
W: BufferMo...			
UD: Options			

MC_MoveAbsolute

[Version]

00A

POU List Favorites History Module Library

3-6. [Ladder] Ezi-SERVO DIO 동작 실행

- Digital Input, Output 동작 실행

The screenshot displays the MELSOFT GX Works3 interface for a ladder logic program. The main workspace shows a ladder logic diagram with various parameters and digital inputs/outputs. The left sidebar contains a project tree with folders for Project, Module Configuration, Program, Initial, Scan, MAIN, ProgPou, Local Label, ProgramBody, Fixed Scan, Event, Standby, No Execution Type, Unregistered Program, FB/FUN, Label, Device, Parameter, System Parameter, MXR300-16, CPU Parameter, Module Parameter (Common Setting), Module Parameter (Port 1/2: CC-Link), Module Parameter (CC-Link IE TSN), Network Label Setting, Module Parameter (Port 3: Ethernet), Memory Card Parameter, Add-on Parameter, Module Information, Motion Setting, Motion System Setting, and Axis. The right sidebar shows the 'Ezi_SERVO_CT_001_DigitalInputs' and 'Ezi_SERVO_CT_001_PhysicalOutputs' sections. The ladder logic diagram includes a 'DMOV' instruction and a 'D2' instruction. The parameters are defined in the top right: L: Decelerati... (180000.0), L: Jerk (0.0), W: Direction (K3), W: BufferMode, and UD: Options. The digital inputs are connected to SM400 and the digital outputs are connected to bAx1Out[0] to bAx1Out[4].

Ezi_SERVO_CT_001_DigitalInputs

Ezi_SERVO_CT_001_PhysicalOutputs

3-6. [Ladder] Ezi-SERVO DIO 맵 - 참조

- Digital Inputs

비트 31	비트 30	비트 29	비트 28	비트 27	비트 26	비트 25	비트 24
-	Motor Power	TQOFF2	TQOFF1	-	-	User input 6	User input 5
비트 23	비트 22	비트 21	비트 20	비트 19	비트 18	비트 17	비트 16
User input 4	User input 3	User input 2	User input 1	Reserved	Reserved	Reserved	
비트 15	비트 14	비트 13	비트 12	비트 11	비트 10	비트 9	비트 8
-	-	-	-	-	-	-	-
비트 7	비트 6	비트 5	비트 4	비트 3	비트 2	비트 1	비트 0
-	-	-	-	-	Origin switch	Positive limit switch	Negative limit switch

- Physical Outputs

비트 31	비트 30	비트 29	비트 28	비트 27	비트 26	비트 25	비트 24
-	-	-	-	-	-	-	-
비트 23	비트 22	비트 21	비트 20	비트 19	비트 18	비트 17	비트 16
-	-	-	User output 5	User output 4	User output 3	User output 2	User output 1
비트 15	비트 14	비트 13	비트 12	비트 11	비트 10	비트 9	비트 8
-	-	-	-	-	-	-	-
비트 7	비트 6	비트 5	비트 4	비트 3	비트 2	비트 1	비트 0
-	-	-	-	-	-	-	Set brake

부 록

[동작 확인] Axis Monitor

- 각 축의 상태, 위치, 원점복귀, Error 등을 모니터

MELSOFT GX Works3 C:\Work\테스트샘플\connectionGuide.gx3 - [MoveProgram [PRG] [LD] 57Byte]

Axis Monitor(CPU (PLC No. 1) Start I/O No. 3E00)

Display Selection: Upper Pane
Monitor Type: Real Drive Axis
Monitor Item Selection
Monitor Axis Selection

Font Size: 9pt

Display Selection: Lower Pane
Monitor Type: Real Drive Axis
Monitor Item Selection
Monitor Axis Selection

	Axis #1	Axis #2	Axis #3	Axis #4	Axis #5
Axis Name	Axis0001	Axis0002	Axis0003	Axis0004	Axis0005
Axis Status	4:Standstill	4:Standstill	4:Standstill	4:Standstill	4:Standstill
Control Cycle	1	1	1	1	1
Position Command Unit Display	degree	degree	degree	degree	degree
Velocity Command Unit Display	degree/s	degree/s	degree/s	degree/s	degree/s
Set Position	0.10058283805847 d...	0.0 degree	0.0 degree	0.0 degree	0.0 degree
Actual Position	0.1003303527832 de...	0.0 degree	0.0 degree	0.0 degree	0.0 degree
Commanded Position	0.0 degree	0.0 degree	0.0 degree	0.0 degree	0.0 degree
Set Velocity	0.0 degree/s	0.0 degree/s	0.0 degree/s	0.0 degree/s	0.0 degree/s
Actual Velocity	-0.31650066375732 d...	0.0 degree/s	0.0 degree/s	0.0 degree/s	0.0 degree/s
Commanded Velocity	0.0 degree/s	0.0 degree/s	0.0 degree/s	0.0 degree/s	0.0 degree/s
Negative Direction Velocity Limit Value	2500000000.0 degree/s	2500000000.0 degree/s	2500000000.0 degree/s	2500000000.0 degree/s	2500000000.0 degree/s
Positive Direction Velocity Limit Value	2500000000.0 degree/s	2500000000.0 degree/s	2500000000.0 degree/s	2500000000.0 degree/s	2500000000.0 degree/s
Automatically Decelerating Command In-position	FALSE	FALSE	FALSE	FALSE	FALSE
Negative Direction Torque Limit Value	300.0 %	300.0 %	300.0 %	300.0 %	300.0 %
Positive Direction Torque Limit Value	300.0 %	300.0 %	300.0 %	300.0 %	300.0 %
Execution Profile ID No.	0	0	0	0	0
Homing Completed	FALSE	FALSE	FALSE	FALSE	FALSE
Homing Request	TRUE	TRUE	TRUE	TRUE	TRUE
Start Permission at Homing Uncompleted	FALSE	FALSE	FALSE	FALSE	FALSE
Upper Limit Signal Status	FALSE	FALSE	FALSE	FALSE	FALSE
Lower Limit Signal Status	FALSE	FALSE	FALSE	FALSE	FALSE
Forced Stop Cancelling	TRUE	TRUE	TRUE	TRUE	TRUE
Axis Error Detection	FALSE	FALSE	FALSE	FALSE	FALSE
Axis Error Code	H0000	H0000	H0000	H0000	H0000
Axis Warning Detection	FALSE	FALSE	FALSE	FALSE	FALSE
Axis Warning Code	H0000	H0000	H0000	H0000	H0000
Driver Ready On Status	TRUE	TRUE	TRUE	TRUE	TRUE
Driver Servo On Status	TRUE	TRUE	TRUE	TRUE	TRUE
Driver Status	6:Operation Enable	6:Operation Enable	6:Operation Enable	6:Operation Enable	6:Operation Enable
Drive Unit Error Detection	FALSE	FALSE	FALSE	FALSE	FALSE
Drive Unit Error Code	H0000	H0000	H0000	H0000	H0000
Drive Unit Error Detail Code	H0000	H0000	H0000	H0000	H0000

Motion Common Monitor

Monitor Item Selection

- Ready
- Synchronization flag
- Operation Cycle Monitor[1].Processing Time: 41000 ns
- Operation Cycle Monitor[1].Maximum Processing Time: 69960 ns
- Operation Cycle Monitor[1].Setting Cycle: 2000000 ns
- Operation Cycle Monitor[1].Cycle Over
- Operation Cycle Monitor[2].Processing Time: 36800 ns
- Operation Cycle Monitor[2].Maximum Processing Time: 73120 ns
- Operation Cycle Monitor[2].Setting Cycle: 8000000 ns
- Operation Cycle Monitor[2].Cycle Over
- Operation Cycle Monitor[3].Processing Time: 44440 ns
- Operation Cycle Monitor[3].Maximum Processing Time: 95960 ns
- Operation Cycle Monitor[3].Setting Cycle: 32000000 ns
- Operation Cycle Monitor[3].Cycle Over
- Forced Stop Cancelling
- Motion Area System Error Detection
- Latest Motion Area System Error Code: H0000
- Motion Area System Warning Detection
- Latest Motion Area System Warning Code: H0000

[Version] 00A
POU List Favorites History Module Library

[동작 확인] 원점복귀 방법 변경

- 모션 제어 FB을 사용하여 원점복귀 방식 변경 가능

- ① ParameterNumber 지정 : H60980008
- ② Value(Homing Method) 지정 : 33.0
- ③ ExecutionMode : TRUE (쓰기)
- ④ Done : TRUE가 됨

원점복귀 방법은 Homing method(6098h)에 설정한 값에 따라 다음과 같이 분류됩니다.

설정값	내용
1	Homing on negative limit switch and index pulse
2	Homing on positive limit switch and index pulse
7	Homing on home switch (positive direction, negative edge) and index pulse
10	Homing on home switch (positive direction, positive edge) and index pulse
11	Homing on home switch (negative direction, positive edge) and index pulse
14	Homing on home switch (negative direction, negative edge) and index pulse
17	Homing on negative limit switch
18	Homing on positive limit switch
24	Homing on home switch (positive direction, negative edge)
25	Homing on home switch (positive direction, positive edge)
28	Homing on home switch (negative direction, positive edge)
29	Homing on home switch (negative direction, negative edge)
33	Homing index pulse (negative direction)
34	Homing index pulse (positive direction)
35	Set the current position origin
37	Set the current position origin and reset current position
-3	Homing on negative mechanical limit
-4	Homing on positive mechanical limit
-5	Homing on negative mechanical limit and index pulse
-6	Homing on positive mechanical limit and index pulse

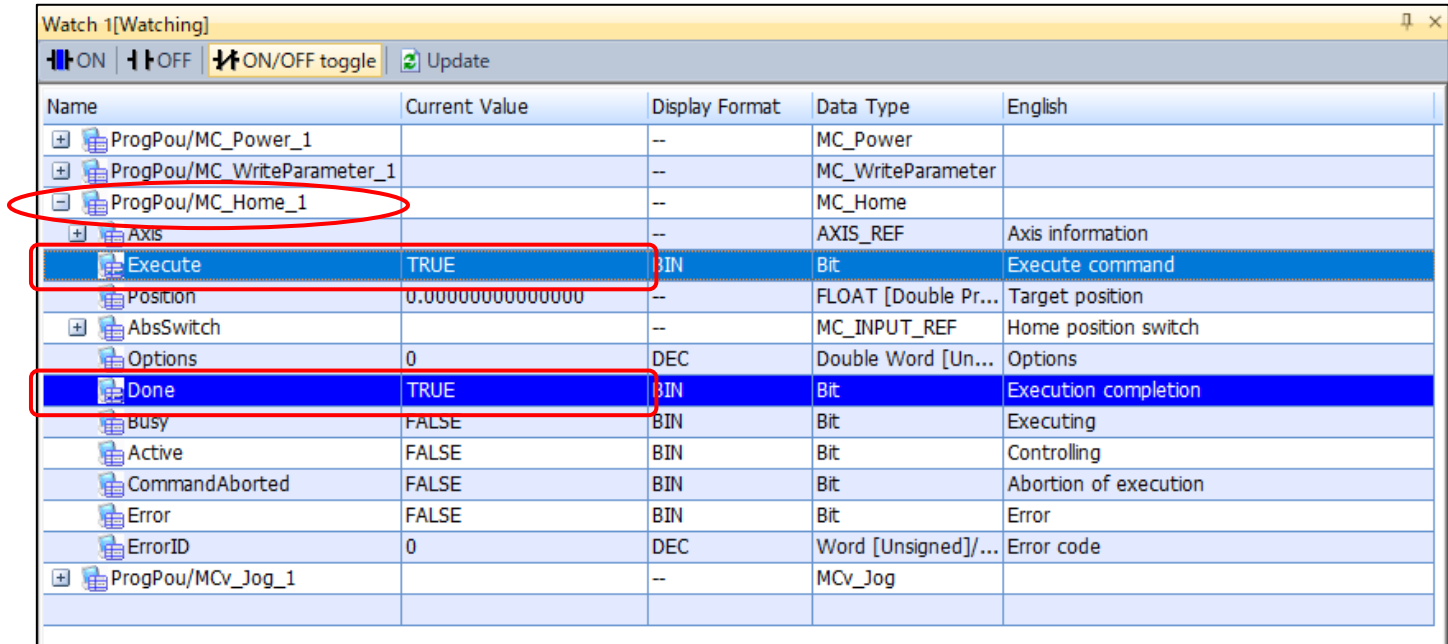
Watch 1[Watching]				
ON OFF ON/OFF toggle Update				
Name	Current Value	Display Format	Data Type	English
ProgPou/MC_Power_1		--	MC_Power	
ProgPou/MC_WriteParameter_1		--	MC_WriteParameter	
Axis		--	AXIS_REF	Axis information
Execute	TRUE	BIN	Bit	Execute command
ParameterNumber	H60980008	HEX	Word [Unsigned]/...	Setting value
Value	37.00000000000000	BIN	Double Word [Un...	Setting value
ExecutionMode	0	DEC	Word [Signed]	Execution mode
Options	0	DEC	Double Word [Un...	Options
Done	TRUE	BIN	Bit	Execution completion
Busy	FALSE	BIN	Bit	Executing
Error	FALSE	BIN	Bit	Error
ErrorID	H0000	HEX	Word [Unsigned]/...	Error code
SDOErrorID	H00000000	HEX	Double Word [Un...	Transient error code
SDOStatus	1	DEC	Word [Unsigned]/...	SDO transfer status
ProgPou/MC_Home_1		--	MC_Home	
ProgPou/MCv_Jog_1		--	MCv_Jog	

표시 형식 : HEX 선택

[동작확인] 원점복귀

- 모션 제어 FB을 사용하여 원점복귀 실행

- ① Execute → TRUE (쓰기)
- ② Done → TRUE가 됨



Name	Current Value	Display Format	Data Type	English
ProgPou/MC_Power_1		--	MC_Power	
ProgPou/MC_WriteParameter_1		--	MC_WriteParameter	
ProgPou/MC_Home_1		--	MC_Home	
Axis		--	AXIS_REF	Axis information
Execute	TRUE	BIN	Bit	Execute command
Position	0.0000000000000000	--	FLOAT [Double Pr...	Target position
AbsSwitch		--	MC_INPUT_REF	Home position switch
Options	0	DEC	Double Word [Un...	Options
Done	TRUE	BIN	Bit	Execution completion
Busy	FALSE	BIN	Bit	Executing
Active	FALSE	BIN	Bit	Controlling
CommandAborted	FALSE	BIN	Bit	Abortion of execution
Error	FALSE	BIN	Bit	Error
ErrorID	0	DEC	Word [Unsigned]/...	Error code
ProgPou/MCv_Jog_1		--	MCv_Jog	

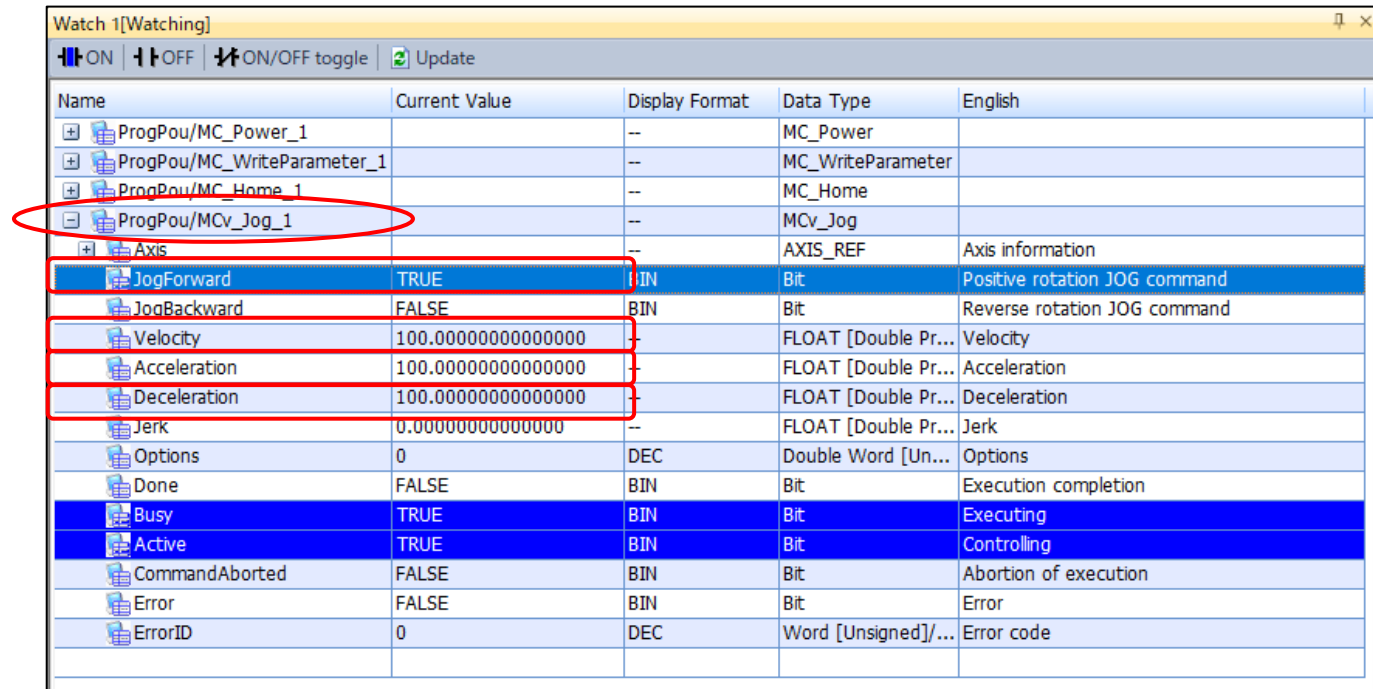
- Ezi-SERVO의 LIMIT+ / LIMIT- 신호를 하드웨어 스트로크 리밋으로 사용하는 경우, 기동(시작) 전에 아래의 축 제어 데이터를 설정해 주십시오.

[AxisName.Cd.HwStrokeLimit_Override] → 'DISABLE'

[동작 확인] Jog 운전

- 모션 제어 FB을 사용하여 Jog 운전 실행

- ① Velocity → 100.0
- ② Acceleration → 100.0
- ③ Deceleration → 100.0
- ④ JogForward → TRUE (쓰기)



Name	Current Value	Display Format	Data Type	English
ProgPou/MC_Power_1		--	MC_Power	
ProgPou/MC_WriteParameter_1		--	MC_WriteParameter	
ProgPou/MC_Home_1		--	MC_Home	
ProgPou/MCv_Jog_1		--	MCv_Jog	
Axis		--	AXIS_REF	Axis information
JogForward	TRUE	BIN	Bit	Positive rotation JOG command
JogBackward	FALSE	BIN	Bit	Reverse rotation JOG command
Velocity	100.00000000000000		FLOAT [Double Pr...	Velocity
Acceleration	100.00000000000000		FLOAT [Double Pr...	Acceleration
Deceleration	100.00000000000000		FLOAT [Double Pr...	Deceleration
Jerk	0.00000000000000	--	FLOAT [Double Pr...	Jerk
Options	0	DEC	Double Word [Un...	Options
Done	FALSE	BIN	Bit	Execution completion
Busy	TRUE	BIN	Bit	Executing
Active	TRUE	BIN	Bit	Controlling
CommandAborted	FALSE	BIN	Bit	Abortion of execution
Error	FALSE	BIN	Bit	Error
ErrorID	0	DEC	Word [Unsigned]/...	Error code

[동작 확인] 트러블슈팅

- 에러 발생 시에는 이벤트 이력(기록)에서 원인을 확인

① [Online] -> [Motion Monitor] -> [Event History]

The screenshot shows the 'Motion Control Setting Function (Untitled Project)' software. The 'Motion Monitor' menu is open, and 'Event History' is selected. The 'Event History: [0000RD78G64]' window is displayed, showing a table of events. A yellow callout box points to the 'Detailed Information' section of the event log.

No.	Occurrence Date	Event Type	Status	Event Code	Description
00001	2024/10/15 15:15:07.512	System	OK	00000	Homing Request (H-TO-DR)
00002	2024/10/15 15:15:07.512	System	OK	00001	Current Position Restoration Completion
00003	2024/10/15 15:15:07.512	System	OK	00002	servo System Emergency Stop
00004	2024/10/15 15:15:07.512	Operation	OK	00003	Follow-up Motion Execution

Detailed Information

Axis Type: Dual Drive Axis
Event Occurrence: 00000/00001/00002/00003/00004
Event Code: 00000

00000 Homing request was OK.
- Absolute position error in driver side was detected. (Detail Code: 00000)
- An absolute position error in the driver side was detected. (Detail Code: 00001)
- The axis type was changed. (Detail Code: 00002)
- Slave object: 'Polarity (00003)' b7 position polarity was changed. (Detail Code: 00003)
- Change of the direction of motion request was detected. (Detail Code: 00004)
- Machine homing was detected. (Detail Code: 00005)
- Driver unit connection (frictionless connection) of the axis was detected. (Detail Code: 00006)
- Machine homing has been detected after the system started. (Detail Code: 00007)

이벤트를 상세하게 확인

[동작 확인] 트러블슈팅

- “SLMP 통신 이상”(1C43h) 이 발생한 경우
→ 축 파라미터 설정을 참조하여 오브젝트 데이터를 설정해 주십시오.
- “MELSERVO 이외의 드라이브 유닛 접속 설정 오류 경고”(0D4Ch) 가 발생한 경우
→ 축 파라미터 설정을 참조하여 절대 위치 시스템을 비활성화해 주십시오.
- MC_Home을 기동하면 “제어 모드 전환 이상”(1A1Dh) 이 발생하는 경우
→ 네트워크 구성 설정(드라이버 추가)에서
Network Synchronous Communication을 **“Synchronous”**로 설정해 주십시오.
- 드라이브의 **LIMIT+ / -** 신호를 사용하는 방식으로 **MC_Home**을 기동하면, 상/하한 리밋 신호를 검출하여 정지
→ [AxisName.Cd.HwStrokeLimit_Override] 를 ‘DISABLE’ 로 설정하고,축 제어 데이터를 프로그램 등에서 설정해 주십시오.

[파라미터] 원점복귀 파라미터 설정

- 원점복귀와 관련된 각종 설정은 다음 오브젝트에서 수행
 - MC_WriteParameter를 사용하여 설정값을 기록합니다.
 - 각 오브젝트의 상세 내용은 Ezi-SERVO CC-Link IE TSN 4X 매뉴얼을 참조해 주십시오.

오브젝트 명	Index: Subindex	설정 내용
Home offset	Obj.607C: 00h	기계 좌표계의 제로 위치와 원점복귀 위치의 차이
Homing method	Obj.6098: 00h	원점복귀 방식
Homing speeds	Obj.6099: 01h	원점복귀 속도
Homing speeds	Obj.6099: 02h	원점복귀 중 Cliff 속도
Homing acceleration	Obj.609A: 00h	원점복귀 중 가속도



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