

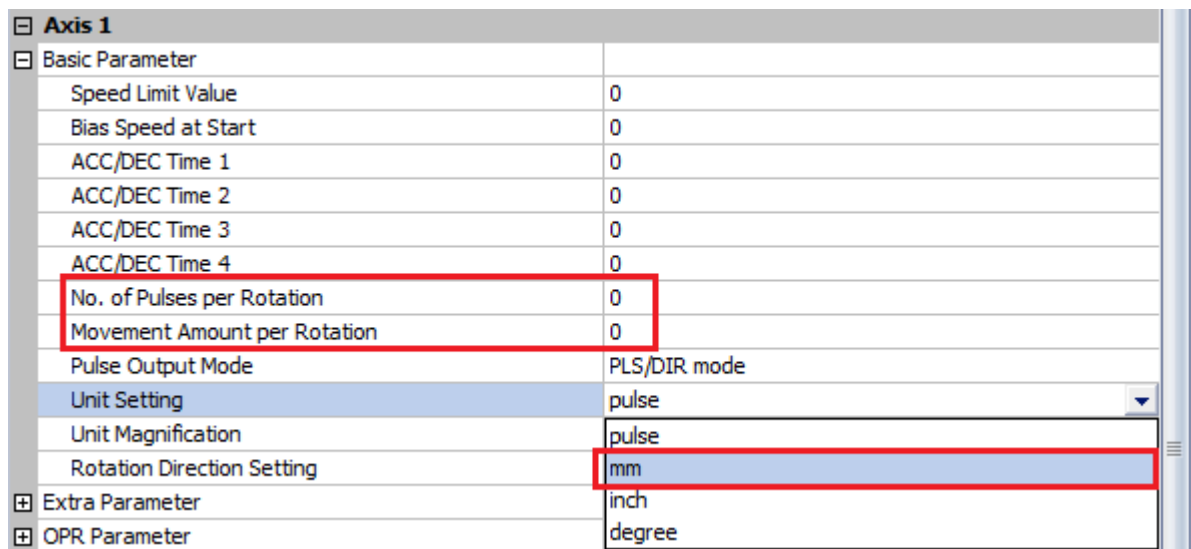
Q How to switch positioning unit from pulse to mm for CIMON PLC?

A The desired positioning unit can be selected in Basic Parameter.

[How to do]

Select the unit “mm.”

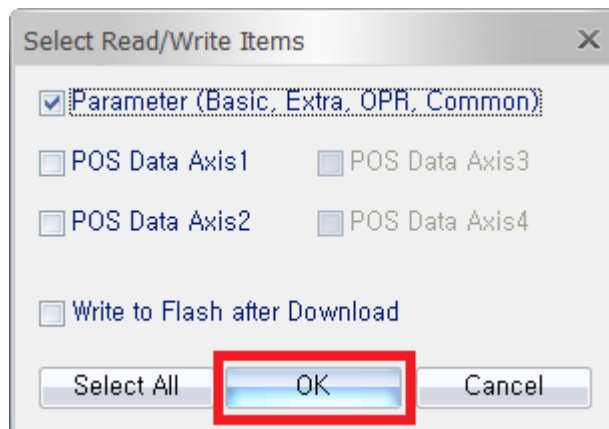
Enter the number of pulses and the moving distance in “mm” per rotation.



The target position is applied in “mm” for POSCTRL command.

Driving speed is in mm/s.

Download the Basic Parameter.



The positioning unit has been switched from pulse to mm.

Base: Local Slot: Slot 0 Ver 1.31 Monitor On Stop Monitor

Basic I/O External Input Status Monitor Data Control Data

| | Current Value: | Current Speed: | Operation Status: |
|---------|----------------|----------------|-------------------|
| Axis 1: | 0 mm | 0 mm/m | Idle |
| Axis 2: | 0 mm | 0 mm/m | Idle |
| Axis 3: | 0 pulse | 0 pulse/m | Idle |
| Axis 4: | 0 pulse | 0 pulse/m | Idle |

| | POS Data No. | Operation Pattern | Axis to be Interpolated | ACC Time No. | DEC Time No. | Control System | M code | Warn | Error |
|-------|--------------|-------------------|-------------------------|--------------|--------------|----------------|--------|------|-------|
| Axis1 | 0 | | | | | | | 0 | 0 |
| Axis2 | 0 | | | | | | | 0 | 0 |
| Axis3 | 0 | | | | | | | 0 | 0 |
| Axis4 | 0 | | | | | | | 0 | 0 |

Flash Write Counter 0