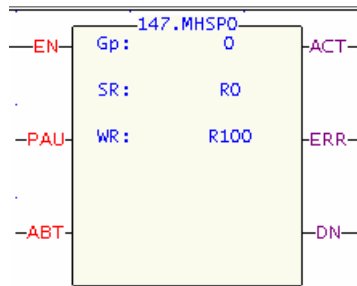


WinProladder V2.35 ChangeNote

1. Add FUN147.MHSP0(Multi-Axis high speed pulse output)



2. Add Multi Axis positioning table

Table Edit

Table Properties

Table Type: Multi-Axis positioning table

Table Name: LINE

Table starting address: R6000

Edit Length: 62

Table Capacity: ☒ Dynamic Allocation ☐ Fixed Length

☒ Load Table From PLC ☐ Load Table From ROR

Description

OK Cancel

Multi-Axis positioning table - [LINE]

Calculator(C) Setup(S) Monitor(M)

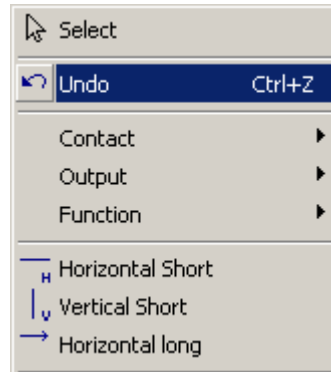
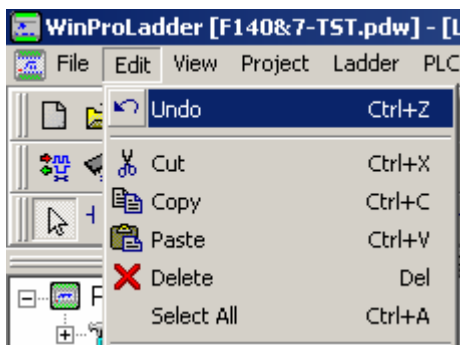
Step	Speed	Movement Action	Wait	Go To
1	SPD R300	LIN ADR, R400, R500, R600, R700,Ps	WAIT TIME, 0	GOTO NEXT
2	SPD R300	LIN ADR, R402, R502, R602, R702,Ps	WAIT TIME, 0	GOTO NEXT
3	SPD R300	LIN ADR, R404, R504, R604, R704,Ps	WAIT TIME, 0	GOTO NEXT
4	SPD R300	LIN ADR, R406, R506, R606, R706,Ps	WAIT TIME, 0	GOTO NEXT

Allow: 2072 words(Auto) Used: 62 words Position: R6000-R6061

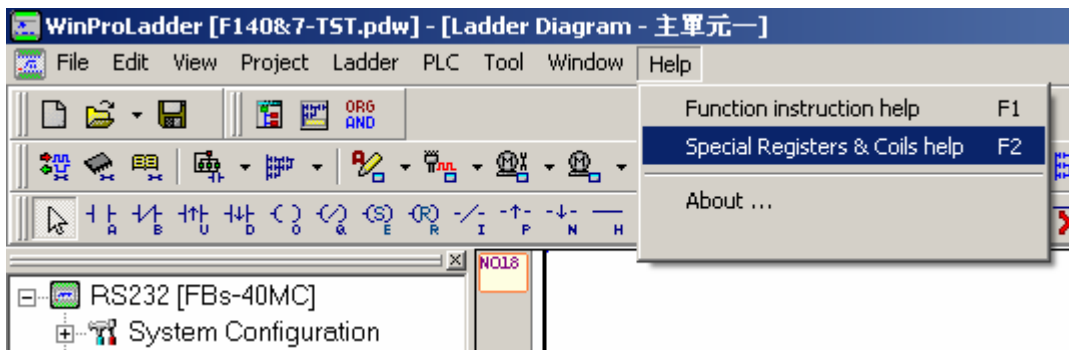
OK Cancel

Add Insert Edit Delete Move Up Move Down

3. Add "UNDO" Function



4. Add Special Registers & Special Coils help (F2)



Chm_SP relay®ister_en

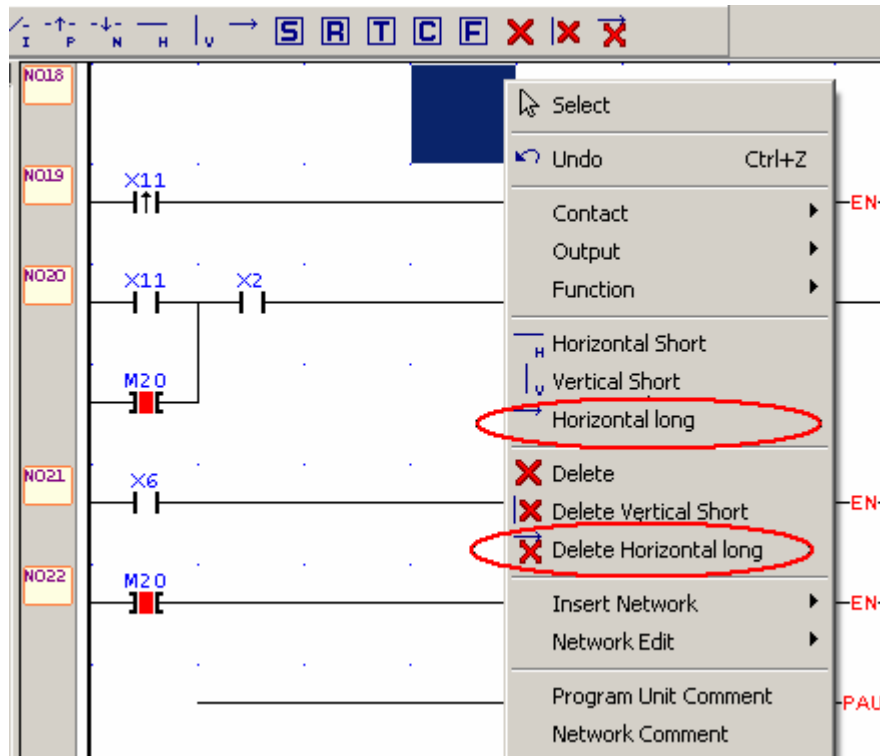
隱藏頁籤 上一頁 首頁 選項

內容 索引 搜

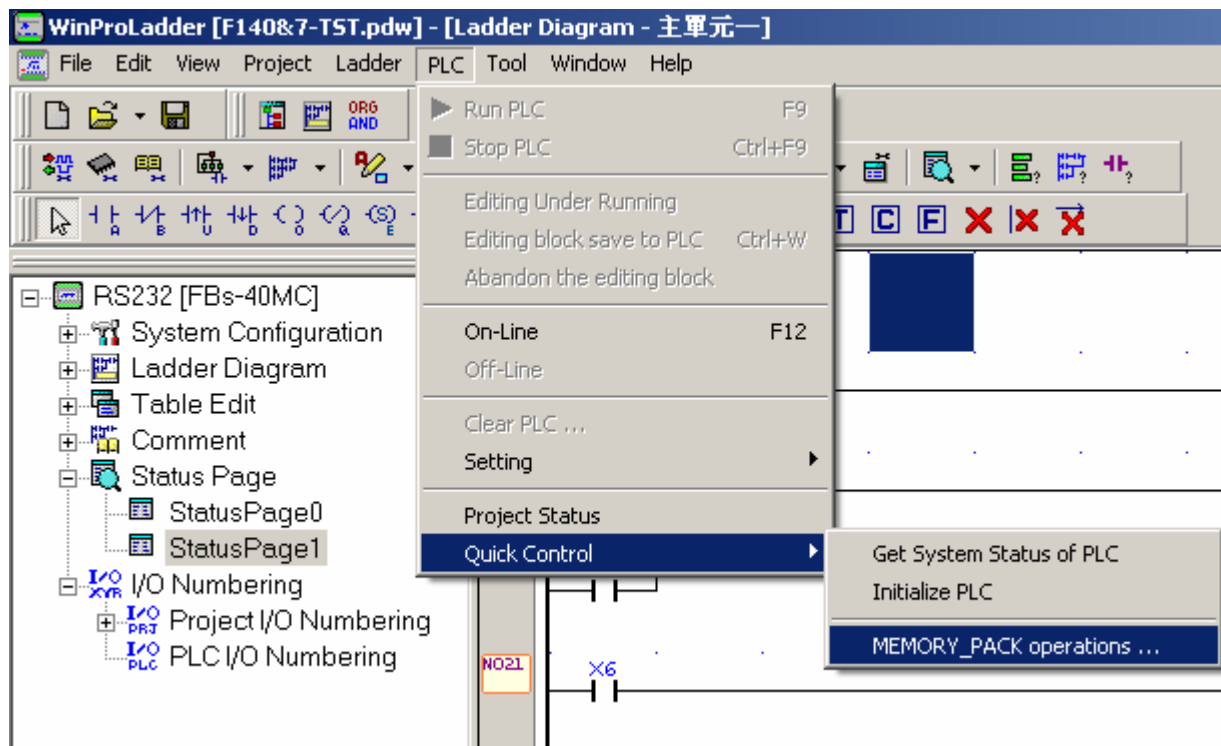
Special Registers Details
Special Relay Detail

M1919	Function output control	output state, even these instructions not been executed. ● If 1, the functional output of some function instructions will be disabled.
× M1918/M1919 can be set to 0 or 1 at will around the whole program to meet the control requirements.		
3. Pulse Signals		
M1920	0.01S Clock pulse----- (1)	T(M1920)=0.01S
M1921	0.1S Clock pulse----- (1)	T(M1921)=0.1S
M1922	1S Clock pulse----- (1)	T(M1922)=1S
M1923	60S Clock pulse----- (1)	T(M1923)=60S
M1924	Initial pulse (first scan)----- (2)	T is the pulse period t is the scan time
M1925	Scan clock pulses----- (3)	
M1926	Reserved	
M1927	CTS input status of communication port 1	● 0 : CTS True (ON) ● 1 : CTS False (OFF) ● When communication port 1 is used to connect with the PC, it can use this signal and a timer to detect whether the printer or the modem is ready.
4. Error Messages		
M1928	Reserved	
M1929	Reserved	
M1930	No expansion unit or exceed the limit	● 1: Indicating no expansion unit or exceed the limit on expansion unit

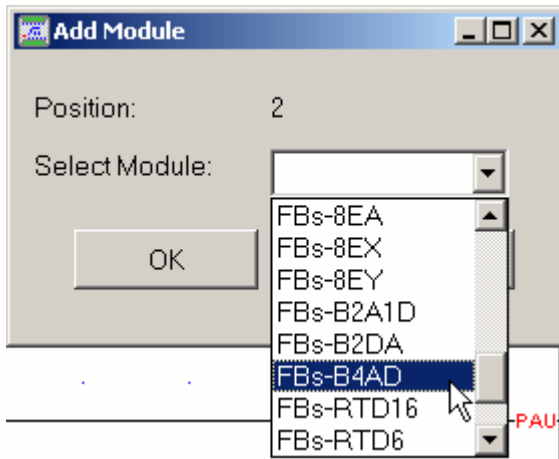
5. Add "Horizontal long" operation



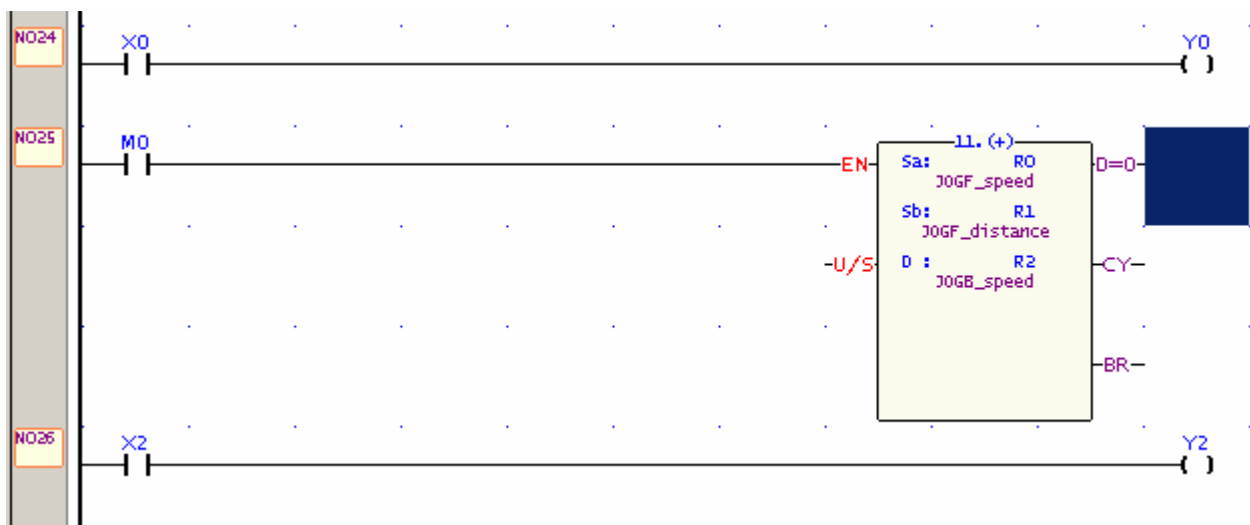
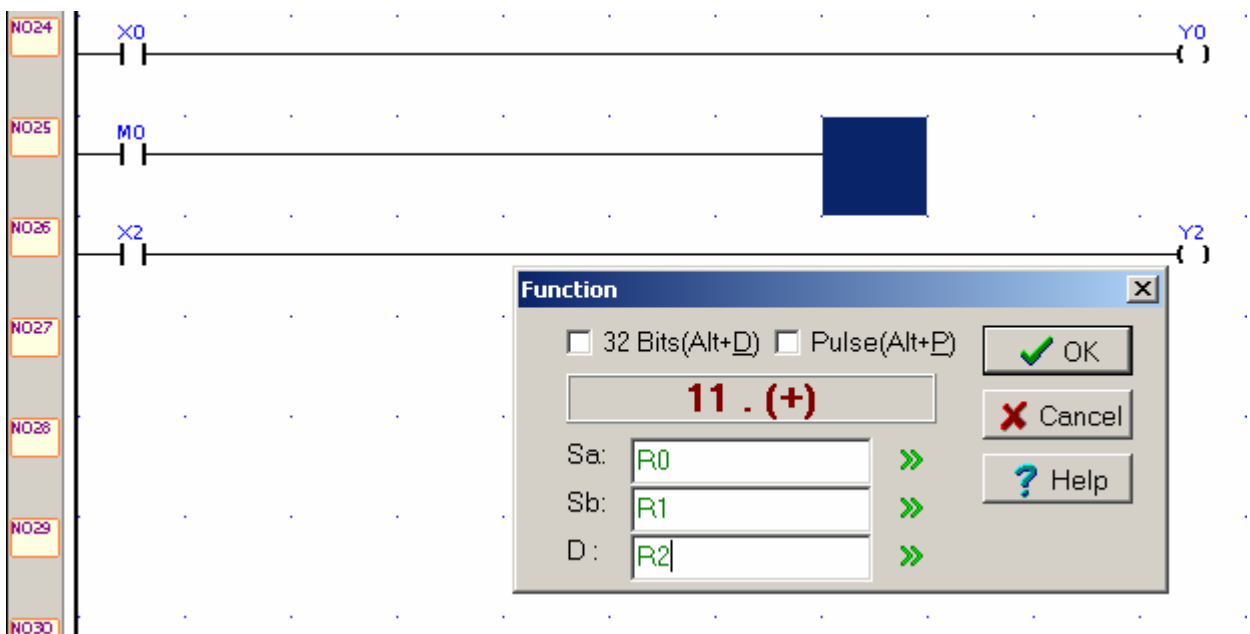
6. Add "MEMORY_PACK operations" in Quick Control



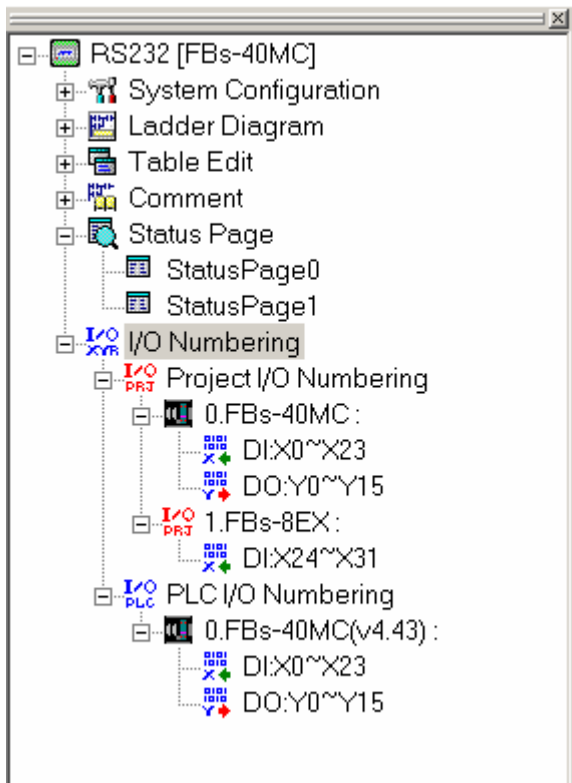
7. Add "FBs-B4AD" Module



8. "Auto-shift" while Function space not enough.



9. Modifying "I/O Numbering" state



10. Add register information in FUN141 table

Servo Parameter Table - [para]

Calculator(C) Setup(S)

R100	0.Unit :	1:Pulse	R113	10.+ Movement Compensation :	0	Ps
R101	1.Pulse/Rev.(16Bit):	2000	R114	11.- Movement Compensation :	0	Ps
DR102	2.Distance/Rev. :	2000	R115	12.Dec. Time :	0	mS
R104	3.Min. Unit :	2	R116	13.Interpolation Time Constant:	500	mS
DR105	4.Max. Speed :	460000	DR117	14.Pulse/Rev.(32Bit):	0	
DR107	5.Start/End Speed :	141	R119_LB	15_0.DOG Input:	Normal Oper	15 (X15)
R109	6.Creep Speed:	1000	R119_HB	15_1.Stroke Input:	Normal Close	14 (X14)
R110	7.Backlash Compensation :	0	R120_LB	15_2.PG0 Input:	Not Used	
R111	8.Acc./Dec. Time :	5000	R120_HB	15_3.CLR Output:	Not Used	
R112_LB	9_0.Direction Control :	0:Up	DR121	16.Machine Zero Point:	0	Ps
R112_HB	9_1.Zero Return Direction:	1:Down(Left)	R123	17.PG0 Count:	8	

Allow: 3740 words(Auto) Used: 24 words Position: R100-R123

Reset To Default OK Cancel