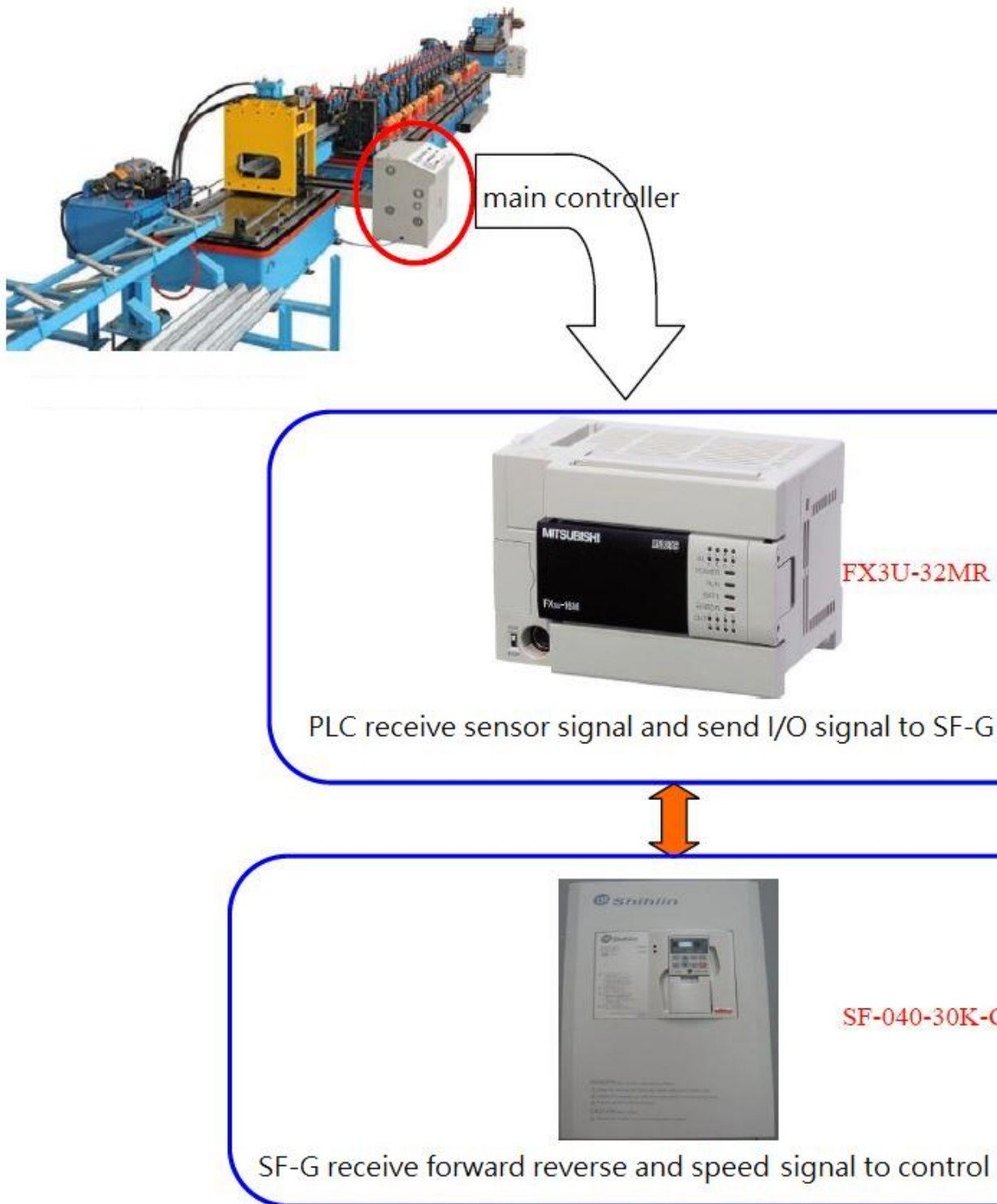


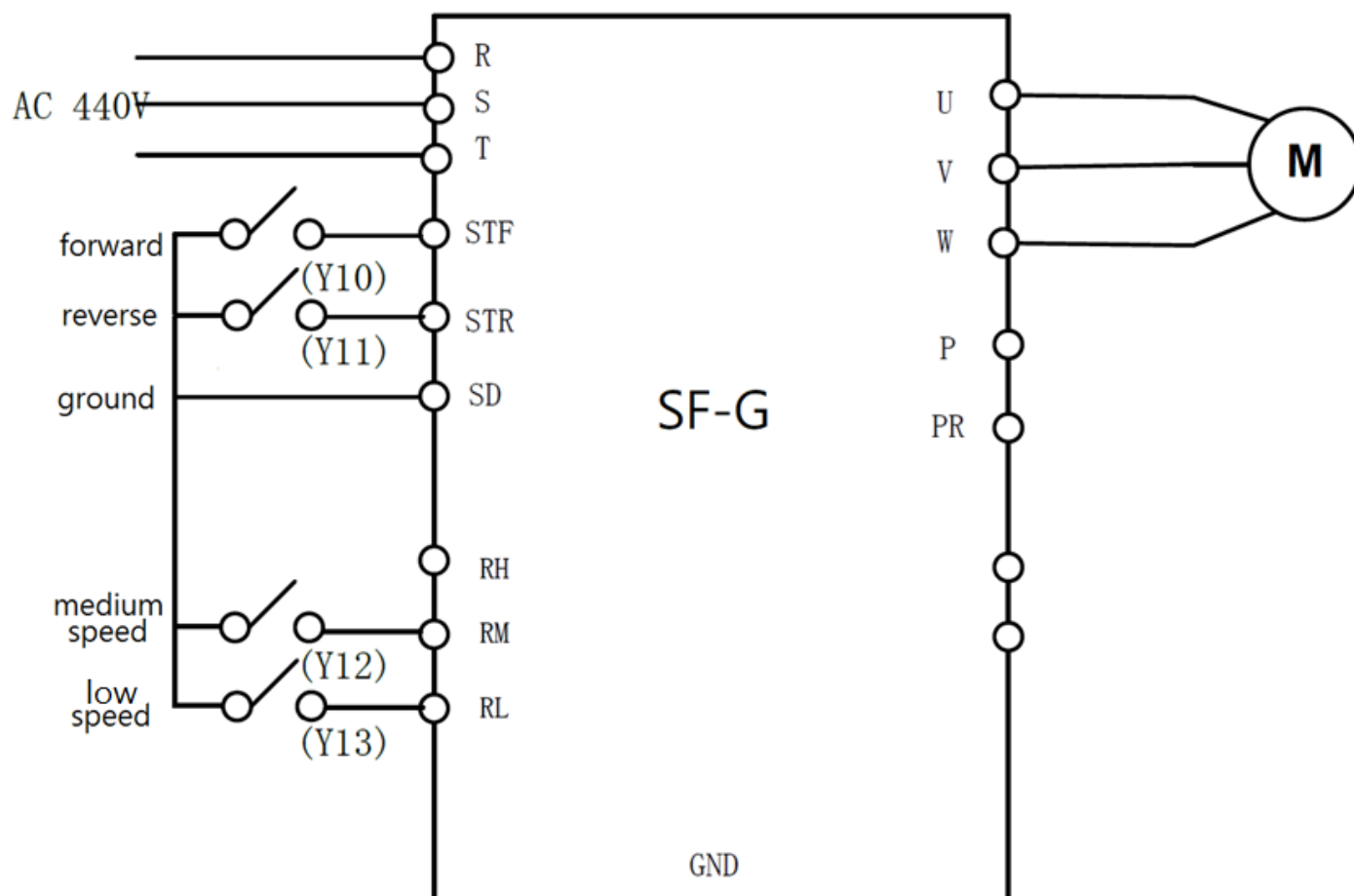
SF-G on roller forming machine with Mitsubishi PLC



Requirements:

1. PLC sending forward/reverse/low speed/medium speed/high speed signal to inverter.
2. Only four output terminals on PLC are available, five functions, four terminals.

Wiring diagram:



We use the built in terminal function for receiving I/O signal, and for the high speed function we use the same terminal as forward (set in **P.83**).

Parameters changed:

| Number | Name | Setting range | Default value | Set value |
|--------|-----------------------|---------------|---------------|-----------|
| P.4 | High speed | 0~400Hz | 60Hz | 40Hz |
| P.5 | Medium speed | 0~400Hz | 30Hz | 15Hz |
| P.6 | Low speed | 0~400Hz | 10Hz | 10 |
| P.79 | Operation mode | 0~8 | 0 | 2 |
| P.83 | STF terminal function | 0~71 | 0 | 18 |

We set the speed for the terminals, and we only use terminals to control so set **P.79=2** to disable keypad and communication commands. We use STF terminal for both STF and RH functions so set **P.83=18**.