| Case name | Shihlin SDA on bar feeder | | | | |
|---|---|---|---|---|---|
| Department | FA engineering group | date | 2013-06-13 | page | 2 |
| product | SDA series | | | | |

## 1.Machine photo
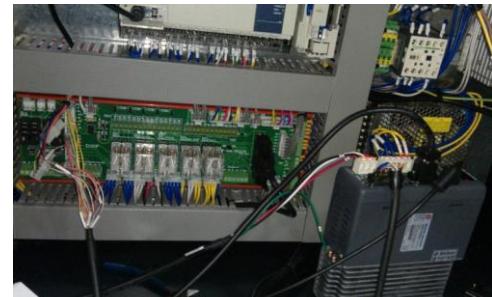


## 2.Requirement

◆ Servo drives require speed, position, torque and mixing control.

◆ Commonly used mixed mode control: speed / position switching, torque / position switching.

◆ The customer uses the PLC I/O terminal to control speed and position to achieve mode switching. The DA module outputs 0-10V voltage to control speed and torque. 3.Wiring
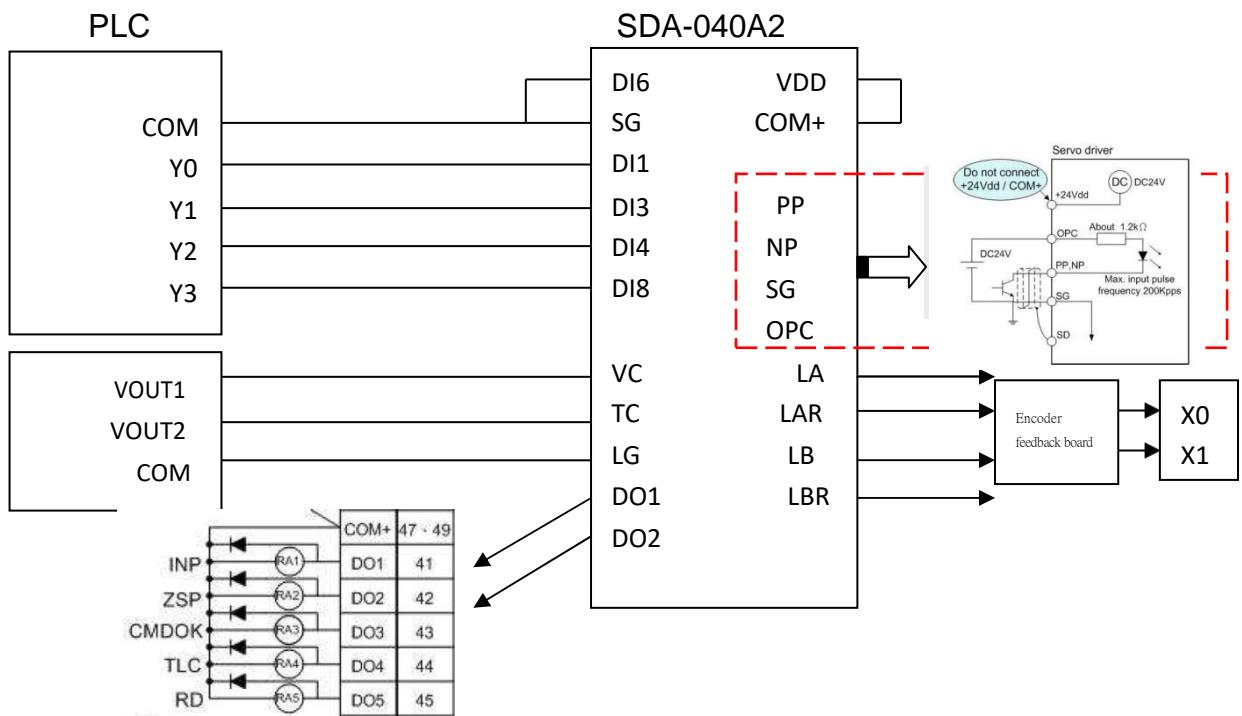


Note：DI1(14PIN)：SON；DI3(16PIN)forward\ DI4(17PIN)reverse；DI6(19PIN):TL；DI8(21PIN):mode switch（LOP）

## 4.Parameters

| parameter | description | setting | parameter | description | setting |
|---|---|---|---|---|---|
| PA01 | Control mode | 0001 | PC01 | Acceleration time constant | 100 |
| PA03 | Auto-tuning response level setting | 7 | PC02 | Deceleration time constant | 100 |
| PA05 | Internal torque limit | 30 | PC03 | S-pattern acc./dec. time constant | 50 |
| PA06 | Electronic gear ratio numerator | 10000 | PC18 | Stop option and power interruption restart option | 0000 |
| PA07 | Electronic gear ratio denominator | 7786 | PD01 | Digital input signal auto-ON option 1 | 1110 |
| PA13 | Pulse command select | 0012 | PD07 | Digital input 6 option | 0004 |
| PA14 | Encoder output pulses | 500 | | | |
| PA39 | Motor rotary direction option | 0011 | | | |

## 5.Adjustment suggestion

1. Make sure all pins are wired correctly and never short circuit.

2. Restore the drive to factory settings and PA40=0088, and power off for 5 seconds.

3. Use the SDA debug software to detect if all I/O terminals are correct. " closed should be ON, open should be OFF"

4. Use the SDA debugging software to do JOG operation and observe whether the motor direction is normal.