



DOCUMENTATION ISG-kernel

Functional description Axis position monitoring

Short Description:
FCT-A3

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Preface

Legal information

This documentation was produced with utmost care. The products and scope of functions described are under continuous development. We reserve the right to revise and amend the documentation at any time and without prior notice.

No claims may be made for products which have already been delivered if such claims are based on the specifications, figures and descriptions contained in this documentation.

Personnel qualifications

This description is solely intended for skilled technicians who were trained in control, automation and drive systems and who are familiar with the applicable standards, the relevant documentation and the machining application.

It is absolutely vital to refer to this documentation, the instructions below and the explanations to carry out installation and commissioning work. Skilled technicians are under the obligation to use the documentation duly published for every installation and commissioning operation.

Skilled technicians must ensure that the application or use of the products described fulfil all safety requirements including all applicable laws, regulations, provisions and standards.

Further information

Links below (DE)

<https://www.isg-stuttgart.de/produkte/softwareprodukte/isg-kernel/dokumente-und-downloads>

or (EN)

<https://www.isg-stuttgart.de/en/products/softwareproducts/isg-kernel/documents-and-downloads>

contains further information on messages generated in the NC kernel, online help, PLC libraries, tools, etc. in addition to the current documentation.

Disclaimer

It is forbidden to make any changes to the software configuration which are not contained in the options described in this documentation.

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General and safety instructions

Icons used and their meanings

This documentation uses the following icons next to the safety instruction and the associated text. Please read the (safety) instructions carefully and comply with them at all times.

Icons in explanatory text

➤ Indicates an action.

⇒ Indicates an action statement.



⚠ DANGER

Acute danger to life!

If you fail to comply with the safety instruction next to this icon, there is immediate danger to human life and health.



⚠ CAUTION

Personal injury and damage to machines!

If you fail to comply with the safety instruction next to this icon, it may result in personal injury or damage to machines.



Attention

Restriction or error

This icon describes restrictions or warns of errors.



Notice

Tips and other notes

This icon indicates information to assist in general understanding or to provide additional information.



Example

General example

Example that clarifies the text.



Programing Example

NC programming example

Programming example (complete NC program or program sequence) of the described function or NC command.



Release Note

Specific version information

Optional or restricted function. The availability of this function depends on the configuration and the scope of the version.

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1 Overview

Task

When a target position is approached, the position monitoring function monitors whether the actual position reaches an exact stop window (tolerance range) within a specific time.

If a configurable limit is exceeded, the CNC generates an error message and the axis is stopped.

Characteristics

The position lag monitor checks the correct functioning of the position controller.

For example, this can identify the following problems:

- Mechanical changes to axes, e.g. increased friction due to damaged bearings or guides
- Errors in the axis position measuring systems

Parametrisation

The position monitor is configured for each individual axis in the axis parameter list.

Mandatory note on references to other documents

For the sake of clarity, links to other documents and parameters are abbreviated, e.g. [PROG] for the Programming Manual or P-AXIS-00001 for an axis parameter.

For technical reasons, these links only function in the Online Help (HTML5, CHM) but not in pdf files since pdfs do not support cross-linking.

2 Description

Process

Position monitoring consists of the following steps:

1. When the axis command position reaches the programmed target position, the timeout is started (time t_1).
2. Timeout is deactivated when the actual position of the axis is located within the exact stop window (time t_2). The exact stop window is configured by P-AXIS-00236.
3. The actual position must be located within the time t configured in P-AXIS-00532 in t_3 the exact stop window.

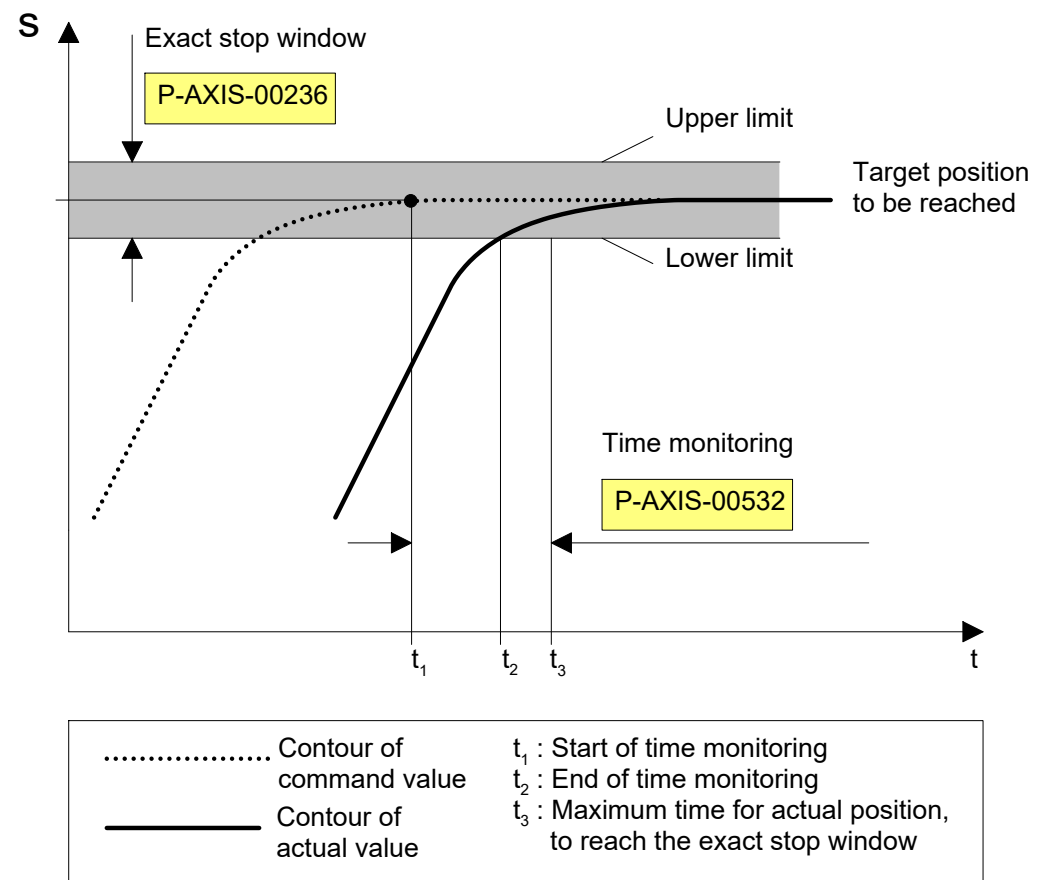


Fig. 1: Position monitoring process

Warnings, errors and reactions

Error message P-ERR-70082. The axis failed within the set time P-AXIS-00532 to reach the exact stop window P-AXIS-00236.

- Immediately stop the affected axis.
- Stop all axes that are interpolated with the affected axis in the path compound.
 - ⇒ Check the cause of the error message and rectify
 - ⇒ Resetting the controller

**Notice****Recommended parameterisation**

Position settling time: P-AXIS-00532 = 10000 to 200000 μ s

Exact stop window: P-AXIS-00236 $\geq 3 \cdot \Delta s_{\text{Standstill}}$;

$\Delta s_{\text{Standstill}}$: real position lag at standstill

**Notice**

When exact stop (G60) is programmed, an axis reaches the target position when the actual position is located within the same exact stop window.

3 Parameter

3.1 Overview of parameters

ID	Description
P-AXIS-00236	Position window for exact stop
P-AXIS-00532	Maximum permitted time until the exact stop window is reached

3.2 Axis parameters

P-AXIS-00236	Position window for exact stop	
Description	For the function 'Accuracy Stop' (or NC command G60 is described in [PROG], a range is defined in which the axis is assumed to be 'in Position' ($ \text{window} = \text{position lag} $). This monitoring is done in position controller if the axis is not interpolated.	
Parameter	getriebe[i].window	
Data type	SGN32	
Data range	$0 \leq \text{window} \leq \text{MAX}(\text{SGN32})$	
Axis types	T, R, S	
Dimension	T: 0.1 μm	R,S: 0.0001°
Default value	500	
Drive types	----	
Remarks		
P-AXIS-00532	Maximum permissible position settling time for exact stop window	
Description	<p>The parameter defines the maximum permissible transient time. If the window for accuracy stop for not interpolated axes has not been reached within this time an error message will be output.</p> <p>If the parameter is 0, the time monitoring is disabled.</p> <p>With a negative value for this parameter, the value of P-AXIS-00151 is used for transient time monitoring (backward compatibility)</p>	
Parameter	getriebe[i].position_settling_time	
Data type	SGN32	
Data range	$\text{MIN}(\text{SGN32}) \leq \text{position_settling_time} \leq \text{MAX}(\text{SGN32})$	
Axis types	T, R, S	
Dimension	T: μs	R,S: μs
Default value	-1	
Drive types	----	
Remarks	This parameter replaces the parameter P-AXIS-00151.	

Keyword index

P

P-AXIS-00236	9
P-AXIS-00532	9

4 Appendix

4.1 Suggestions, corrections and the latest documentation

Did you find any errors? Do you have any suggestions or constructive criticism? Then please contact us at documentation@isg-stuttgart.de. The latest documentation is posted in our Online Help (DE/EN):



QR code link: <https://www.isg-stuttgart.de/documentation-kernel/>

The link above forwards you to:

<https://www.isg-stuttgart.de/fileadmin/kernel/kernel-html/index.html>



Notice

Change options for favourite links in your browser;

Technical changes to the website layout concerning folder paths or a change in the HTML framework and therefore the link structure cannot be excluded.

We recommend you to save the above "QR code link" as your primary favourite link.

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