



DOCUMENTATION ISG-kernel

Funktionsbeschreibung Axis coupling via HLI

Short Description:
FCT-A9

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Preface

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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.

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

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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



Release Note

This description of functions is valid as of CNC Build V2.2800.

Task

Axis couplings are used to couple the movement of an axis to the movements of one or several other axis/axes.

Coupling is relative to the position of the axis when the coupling is activated. The dynamic limits of the target axis are not monitored.

Properties

The axis couplings are active after the functionality has been activated via the HLI interface.

Parametrisation

The coupling specifications are defined exclusively via the HLI interface. See the section Parameters [▶ 15].

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

Definitions

The definition of how movement of an axis influences another axis is referred to as a coupling specification.

Below, the axis whose position is influenced by other axes on the basis of the coupling specification is referred to as the **target axis**.

Axes that influence other axes via coupling specifications are referred to as **source axes**.

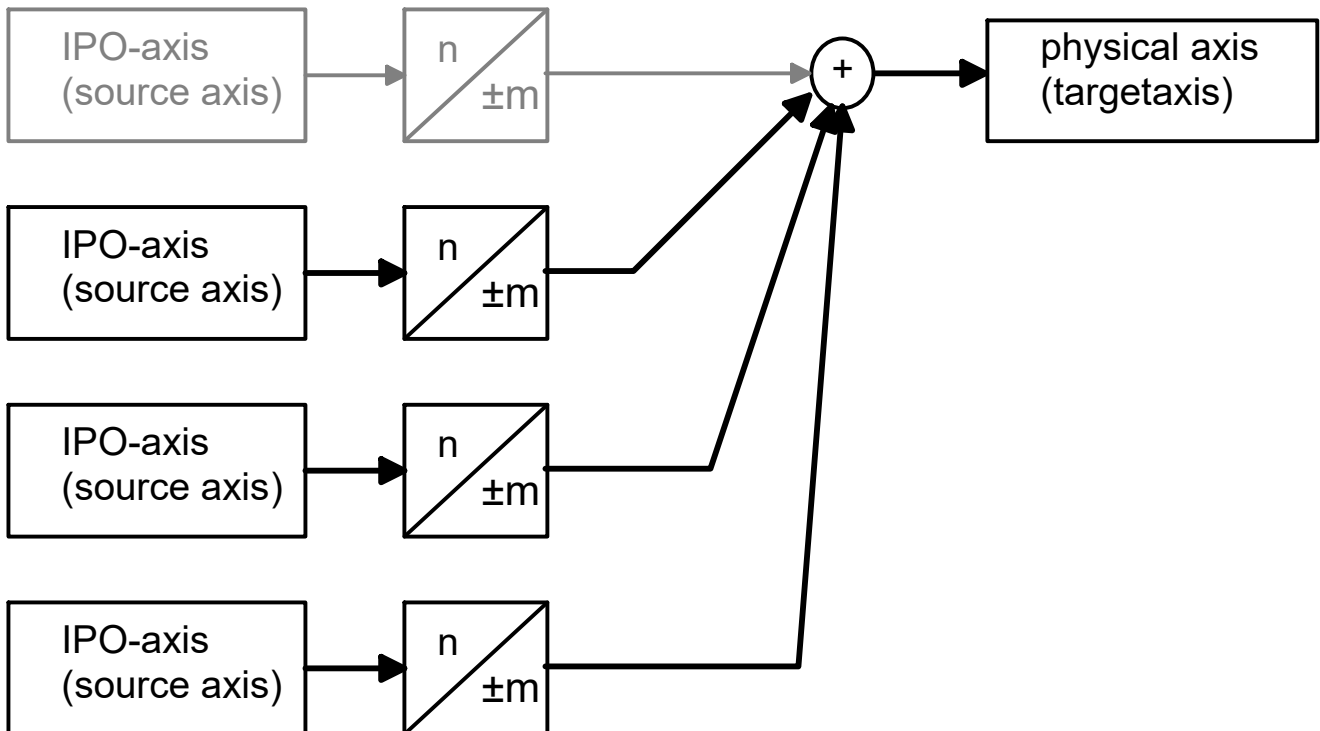


Fig. 1: View of the difference between source and target axis

In this example several source axes act on a physical target axis. The interpolator axis that normally moves the target axis need not necessarily belong to the source axes.



Notice

A change in axis coupling must take place when all the axes involved are at standstill.

If this is not the case, stop occurs with error message P-ERR-70200.

Standstill of all axes involved means that axis velocity must be 0. This affects both the target axis and all coupled source axes.



Notice

If a coupled axis is also programmed in the NC program, the target axis must be coupled to itself as source axis.

The coupling specification stipulates: source axis = target axis with coupling factor 1

Response with setpoint request

Corresponding to the coupling instructions on drive level, an active gear coupling leads to an offset of the axis positions to the programmed command positions in NC channel. The axis positions and program coordinates are newly initialised at restart of program or by an explicitly programmed position request (#CHANNEL INIT [CMD-POS]). The ACS position (position on drive plane) is returned by default.

If the target axis setpoint is requested directly after activating an axis coupling, the returned value corresponds to the mechanical axis position.

The axis parameter P-AXIS-00436 defines the setting that the input coordinates of the gear link are recalculated by forward mapping when a setpoint request occurs.

If forward mapping of drive positions is activated with parameter P-AXIS-00436 the mapping is calculated by default relative to the activation position of the axis coupling..

The parameter P-AXIS-00460 can define the setting that the axis positions are regarded as absolute coordinates when a setpoint request occurs. In other words, it is assumed that the axis coupling is activated both for the master and for the slave axis at axis position 0.

Restrictions when using P-AXIS-00436

If the axis parameter P-AXIS-00436 is set, the target axis may not be coupled to itself as source axis either directly or indirectly.

When the coupling is activated, a check is made for coupling loops such as these. If one is discovered, the error message P-ERR-70410 is output and the coupling is not executed.



Notice

When the parameters P-AXIS-00436 and P-AXIS-00460 are used, the channel must always be initialised.

Schematic of a coupling

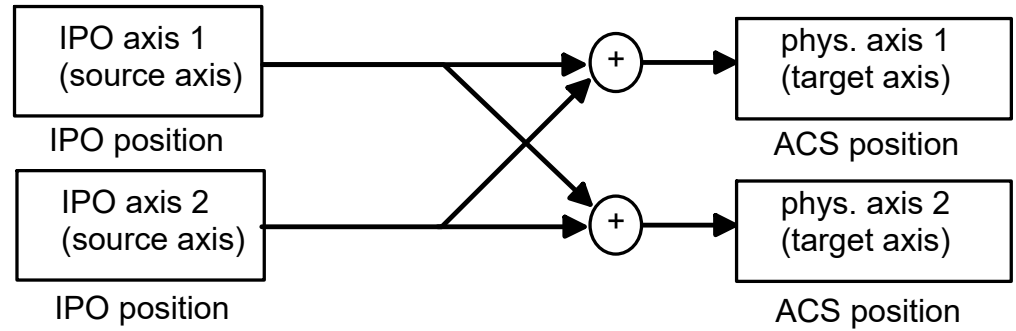


Fig. 2: Schematic of coupling specification

To calculate the IPO position of axis 2, the IPO position of axis 1 must already be known. The deadlock cannot be resolved and results in the output of error message P-ERR-70410.

General

The coupling specifications of a target axis are defined via an axis-specific control unit of the HLI.

In this control unit of the target axis, the coupling specifications are defined by specifying the logical axis number of the source axis and the coupling mode. If coupling mode HLI_AXIS_COUPLING_FRACT is used, the coupling factor must also be specified as a fraction.

Several coupling specifications can be commanded. They are defined as an array in the commanded value of of the control unit. The indices of the array elements are within the interval [0 -HLI_AX_COUPLING_MAXIDX]

The entered coupling specifications are activated by setting an HLI signal.

After evaluating the coupling specifications and checking for errors, the NC kernel resets the trigger signal.

Activation

Mit $axis_idx = [0..HLI_SYS_AX_MAXIDX]$

$coupl_idx = [0..HLI_AX_COUPLING_MAXIDX]$

Axis-specific control unit of HLI:

$gpAx[axis_idx]^lr_mc_control.axis_coupling$

Defining the logical axis number of the source axis:

$gpAx[axis_idx]^lr_mc_control.axis_coupling.command_w.desc[coupl_idx].ax_nr$

Defining the coupling mode for this source axis:

$gpAx[axis_idx]^lr_mc_control.axis_coupling.command_w.desc[coupl_idx].mode$

Definition of coupling factor:

$gpAx[axis_idx]^lr_mc_control.axis_coupling.command_w.desc[coupl_idx].fract_num$

gpAx[axis_idx]^lr_mc_control.axis_coupling.command_w.desc[coupl_idx].fract_denom

Activating trigger signal

gpAx[axis_idx]^lr_mc_control.axis_coupling.command_w.semaphor_rw := TRUE

Programming of target axis

When axis couplings are used, all source axes acting on a target axis must be specified. If a target axis is also to be programmed in an NC program, a coupling specification must be defined for the logical axis number of the target axis on the HLI. For the programmed axis a coupling specification must be defined between its own source axis and its own target axis.

(See example 2 [▶ 13])

Coupling modes

The following coupling modes can be specified for a coupling specification:

Coupling identifier	Value	Meaning
HLI_AXIS_COUPLING_INACTIVE	0	The coupling specification is inactive. All subsequent coupling specifications are also inactive. If the first coupling specification is defined as inactive, all coupling specifications are deactivated.
HLI_AXIS_COUPLING_ZERO	1	Coupling factor 0 This mode can be used to shut down an axis. A shut-down axis can nevertheless be used as a source axis for other axes.
HLI_AXIS_COUPLING_DIRECT	2	The coupling factor between the source and target axis is 1.
HLI_AXIS_COUPLING_MIRROR	3	The coupling factor between the source and target axis is -1.
HLI_AXIS_COUPLING_FRACT	4	The coupling factor [▶ 7] K is a fraction and is defined by a nominator and a denominator

Coupling factor

The coupling factor K is defined as

$$K = \frac{\text{coupling factor nominator}}{\text{coupling factor denominator}}$$

Defining the coupling factor:

Nominator: desc[coupl_idx [▶ 9]].fract_num

Denominator: desc[coupl_idx [▶ 9]].fract_denom

the permissible value range for the coupling factor nominator is: [-32768 ... 32767]. A value of 0 has the same effect as using coupling mode HLI_AXIS_COUPLING_ZERO.

The permissible value range for the coupling factor denominator is [-32768 to 32767] excluding 0. A value of 0 causes the output of error message P-ERR-70396.

The absolute value of the coupling factor is limited to the value of HLI_AXIS_COUPLING_FACT_MAX. If the configured value for the coupling factor is greater than this value, the error message P-ERR-70397 is output.

Software limit switches

When the coupling mode `HLI_AXIS_COUPLING_FRACT` is used, the target axis command position resulting from the active couplings is monitored to the configured software limit switches (`P-AXIS-00177/P-AXIS-00178`) provided the axis is referenced.

Here, a check is made whether the axis can be stopped from the current velocity using the emergency stop deceleration (`P-AXIS-00003`) in front of the configured software limit switches. If the software limit switch is exceeded, the error message `P-ERR-70195` is output and the axis is stopped.

Deactivation

The axis couplings of an axis can be deactivated by setting the coupling mode of the first coupling entry in HLI_AXIS_COUPLING_INACTIVE.



Example

Deactivating a coupling with several couplings on an axis

Coupling no.	Source axis	Target axis	Coupling mode	Coupling active
1	X2	X2	2	yes
2	X	X2	2	yes
3	Y	X2	0	No
4	Z	X2	2	No

In the example the third coupling is deactivated. The consequence is that all subsequent couplings are deactivated.

Status display

In the control unit the status of the axis with regard to axis couplings is indicated in the

`gpAx[axis_idx [▶ 9]]^.lr_mc_control.axis_coupling.state_r` structure.

The `active_r` structure element indicates whether an axis coupling is active for the axis. If a coupling is active, the element has the value TRUE.

When axis coupling is active, the couplings defined for this axis are indicated in the `desc[]` field.

An element of the `desc[]` field represents a coupling specification and consists of the following subelements.

- `ax_nr`: logical axis number of the source axis
- `mode`: the coupling mode defined for the source axis

Changing the axis coupling

Since it is only permitted to change an axis coupling if the target axis and all coupled source axes are at standstill, the PLC must first verify this when the coupling is changed.

In this case, for example, the current command velocity [10^{-3} mm/s or 10^{-3} degree/s] of the axis can be checked before the coupling is activated.

`gpAx[axis_idx [▶ 9]]^.lr_state.active_rev_r`

3 Examples

Precondition for all examples below: Coupling specifications are to be defined for the axis with logical axis number 8 and axis designator Y2:



Example

Example 1: Axis Y2 cannot be moved by the NC program.

```
desc[0].ax_nr:= 1
desc[0].mode:= HLI_AXIS_COUPLING_DIRECT
desc[1].ax_nr:= 0
desc[1].mode:= HLI_AXIS_COUPLING_INACTIVE
```

The axis moves in synchronicity with the axis with logical axis number 1. Since **no coupling specification is defined** for logical axis number 8, axis Y2 cannot be moved by the NC program.

Since coupling mode HLI_AXIS_COUPLING_FRACT is not used, the elements fract_num and fract_denom need not be defined in the coupling specification desc[0].

The coupling specification desc[1] indicates the end of the list of coupling specifications.



Example

Example 2: Axis Y2 is moved by the NC program.

```
desc[0].ax_nr:= 1
desc[0].mode:= HLI_AXIS_COUPLING_DIRECT
desc[1].ax_nr:= 8
desc[1].mode:= HLI_AXIS_COUPLING_DIRECT
desc[2].ax_nr:= 0
desc[2].mode:= HLI_AXIS_COUPLING_INACTIVE
```

The **axis Y2 can now also be moved by the NC program when the coupling specification desc[1] is added.**

Since coupling mode HLI_AXIS_COUPLING_FRACT is not used here, the elements fract_num and fract_denom need not be defined in the coupling specifications desc[0] and desc[1].

The coupling specification desc[2] indicates the end of the list of coupling specifications.



Example

Example 3: Axis Y2 with coupling factor

A coupling specification with coupling factor $-5/9$ is to be defined for the axis with logical axis number 8 and axis designator Y2. Axis Y2 is also to be programmable in the NC program:

```
desc[0].ax_nr:= 8
desc[0].mode:= HLI_AXIS_COUPLING_DIRECT

desc[1].ax_nr:= 1
desc[1].mode:= HLI_AXIS_COUPLING_FRACT
desc[1].fract_num:= -5
desc[1].fract_denom:= 9

desc[2].ax_nr:= 0
desc[2].mode:= HLI_AXIS_COUPLING_INACTIVE
```

Since coupling mode HLI_AXIS_COUPLING_FRACT is not used, the elements `fract_num` and `fract_denom` need not be defined in the coupling specification `desc[0]`.

The coupling specification `desc[2]` indicates the end of the list of coupling specifications.

4 Parameter

4.1 Overview

ID	Parameter	Description
P-AXIS-00003	getriebe[i].dynamik.a_emergency	Deceleration for an emergency stop
P-AXIS-00177	kenngr.swe_neg	Negative software limit switch
P-AXIS-00178	kenngr.swe_pos	Positive software limit switch
P-AXIS-00436	kenngr.recalc_link_main_input_position	Forward mapping of drive position
P-AXIS-00460	kenngr.recalc_input_position_absolute	Forward mapping of drive position with absolute coordinates

4.2 Description

P-AXIS-00003	Deceleration for an emergency stop	
Description	The parameter defines the used deceleration for an emergency stop. If errors of error reaction class 4 occur, the NC decelerates at the rate for specific axes. The path then leaves the trajectory.	
Parameter	getriebe[i].dynamik.a_emergency	
Data type	UNS32	
Data range	$1 \leq a_emergency \leq 2 * P-AXIS-00008$	
Axis types	T, R, S	
Dimension	T: mm/s ²	R,S: °/s ²
Default value	0	
Drive types	----	
Remarks	When the parameter has the value 0, it is assigned the value of P-AXIS-00008 (a_max).	

P-AXIS-00177	Negative software limit switch	
Description	The parameter defines the possible traverse range in the negative direction (negative software limit switch position). The programmed command positions are always checked on 'kenngr.swe_neg', the actual positions on 'kenngr.swe_neg - kenngr.swe_toleranz'.	
Parameter	kenngr.swe_neg	
Data type	SGN32	
Data range	MIN(SGN32) < swe_neg < P-AXIS-00178	
Axis types	T, R	
Dimension	T: 0.1 µm	R: 0.0001°
Default value	-100000000	
Drive types	----	
Remarks	The value of the parameter is adopted on reset, mode change and axis replacement from the axis record.	

P-AXIS-00178	Positive software limit switch	
Description	The parameter defines the possible traverse range in the positive direction (positive software limit switch position). The programmed command positions are always checked on 'kenngr.swe_pos', the actual positions on 'kenngr.swe_pos + kenngr.swe_toleranz'.	
Parameter	kenngr.swe_pos	
Data type	SGN32	
Data range	P-AXIS-00177 < swe_pos < MAX(SGN32)	
Axis types	T, R	
Dimension	T: 0.1 µm	R,S: 0.0001°
Default value	100000000	
Drive types	----	
Remarks	The value of the parameter is adopted on reset, mode change and axis replacement from the axis record.	

P-AXIS-00436	Forward mapping of drive position	
Description	<p>Corresponding to the coupling instructions at drive level, an active gear coupling leads to an offset of the axis positions compared to the programmed command positions in NC channel.</p> <p>The gear coupling can be activated either by configuration in the axis parameters (see <code>multi_link[i]</code>) or via the HLI interface of the axis (see [FCT-A9 ▶ 6]).</p> <p>In the event of a program restart or an explicitly programmed request of axis positions (<code>#CHANNEL INIT [CMDPOS]</code>), the axis positions and the channel program coordinates are re-initialised. The parameter must be set to 1 if the input coordinates of the gear coupling (e.g. absolute program coordinates) are to be recalculated by forward mapping. See also P-AXIS-00460.</p>	
Parameter	<code>kenngr.recalc_link_main_input_position</code>	
Data type	BOOLEAN	
Data range	0: No forward mapping of drive position (default). 1: Forward mapping is executed.	
Axis types	T, R	
Dimension	T: ----	R: ----
Default value	0	
Drive types	----	
Remarks	<p>Configuration example: Forward mapping is active during gear coupling</p> <pre> kenngr.multi_link[0].lead_axis 4 kenngr.multi_link[0].factor_numerator 1 kenngr.multi_link[0].factor_denominator 2 kenngr.recalc_link_main_input_position 1 </pre> <p>Configuration example: Forward mapping with active gear coupling via the HLI</p> <pre> kenngr.recalc_link_main_input_position 1 </pre>	

P-AXIS-00460	Forward mapping of drive position with absolute coordinates	
Description	<p>If forward mapping of drive positions is activated with parameter P-AXIS-00436 , the mapping is calculated by default relative to the activation position of the axis coupling..</p> <p>This means that if immediately after the activation of an axis coupling the command positions are requested, the command position according to the mechanical axis position is returned.</p> <p>With parameter P-AXIS-00460 the axis positions are considered as absolute coordinates. This means the mapping is calculated as if the axes were coupled at position 0 for the master as well as for the slave axes.</p> <p>Example:</p> <p>At position X=40 mm and X1=50 mm the X1 axis is coupled each with a coupling factor of 1:1 to the X-axis and to itself.</p> <p>When P-AXIS-00460 is not set, the returned position for axis X1 is X1 = 50 mm on receipt of a command position request directly after activation of a coupling</p> <p>When P-AXIS-00460 is set, the returned axis position for the X1 axis is X1 = 10 mm.</p>	
Parameter	kenngr.recalc_input_position_absolute	
Data type	BOOLEAN	
Data range	0: Forward mapping relative to activation position (default). 1: Forward mapping with absolute positions.	
Axis types	T, R, S	
Dimension	T: ----	R,S: ----
Default value	0	
Drive types	----	
Remarks	<p>This parameter is only effective for axis couplings that are activated via the HLI.</p> <p>This parameter is only practical for use with axes that deliver an absolute position.</p>	

Keyword index

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5 Appendix

5.1 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/>

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