

# JOEMARS

เปลี่ยน Servo Drive กับ AC Servo Motor ให้กับแกน V เครื่อง ไวร้คัท รุ่น WT455S อายุ 11-12 ปี เนื่องจาก Servo Drive เดิมๆนั้น หยุดผลิตไปแล้ว ดังนั้นจึงต้องเปลี่ยนรุ่น จากเดิมเป็นรุ่นใหม่ขึ้น ของ Panasonic.....จึงต้องทำการปรับ Parameters กันใหม่ให้ เหมาะสมกันระหว่าง Mechanics กับการสั่ง Servo Drive ให้ทำงานให้ถูกต้อง

JOEMARS Brand Wire Cut Machine.....Thailand Exclusive Agent by Siam Elmatech Co., Ltd.



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#
#[this file]
#F:DRIVERV.prm5
#dayTime:2015/4/13 14: 08:33:45
#
#assortment,no,value      ,memo
#
0.0,1      ,#Rotational direction setup
0.0,0      ,#Control mode setup
0.0,0      ,#Real-time auto-gain tuning se
0.0,16     ,#Selection of machine stiffness
0.4,350    ,#Inertia ratio
0.0,0      ,#Selection of command pulse in
0.0,0      ,#Command pulse rotational dire
#Command pulse input mode setu
0.0,2      ,#Command pulse counts per one
0.8,10000  ,#1st numerator of electronic g
0.9,0      ,#Denominator of electronic gea
0.10,10000 ,#Output pulse counts per one #
0.12,0     ,#Reversal of pulse output logi
0.13,300   ,#1st torque limit
0.14,640000 ,#Position deviation excess set
0.15,1     ,#Absolute encoder setup
0.16,3     ,#External regenerative resist
0.17,0     ,#Load factor of external rege
1.0,1080   ,#1st gain of position loop
1.1,600    ,#1st gain of velocity loop
1.2,500    ,#1st time constant of velocit
1.3,0      ,#1st filter of speed detectio
1.4,38     ,#1st time constant of torque
1.5,1260  ,#2nd gain of position loop
1.6,600    ,#2nd gain of velocity loop
1.7,9999   ,#2nd time constant of velocit
1.8,0      ,#2nd filter of speed detectio
1.9,31     ,#2nd time constant of torque
1.10,0     ,#Velocity feed forward gain
1.11,50    ,#Velocity feed forward filter
1.12,0     ,#Torque feed forward gain
1.13,0     ,#Torque feed forward filter
1.14,0     ,#2nd gain setup
1.15,0     ,#2nd gain setup

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2.22,2    ,#Positional command smoo
2.23,0    ,#Positional command FIR f
3.0,0     ,#Speed setup, Internal/Ex
3.1,0     ,#Speed command rotational
3.2,500   ,#Input gain of speed comm
3.3,1     ,#Reversal of speed command
3.4,0     ,#1st speed of speed setup
3.5,0     ,#2nd speed of speed setup
3.6,0     ,#3rd speed of speed setup
3.7,0     ,#4th speed of speed setup
3.8,0     ,#5th speed of speed setup
3.9,0     ,#6th speed of speed setup
3.10,0    ,#7th speed of speed setup
3.11,0    ,#8th speed of speed setup
3.12,0    ,#Acceleration time setup
3.13,0    ,#Deceleration time setup
3.14,0    ,#Sigma acceleration/ decele
3.15,0    ,#Speed zero-clamp function sei
3.16,0    ,#Selection of torque level
3.17,0    ,#Torque command direction sele
3.18,0    ,#Input gain of torque command
3.19,0    ,#Speed reversal of torque comm
3.20,0    ,#Speed limit value 1
3.21,0    ,#Speed limit value 2
3.22,0    ,#External scale selection
3.23,0    ,#Numerator of external scale div
3.24,0    ,#Denominator of external scale di
3.25,0    ,#Reversal of direction of externa
3.26,0    ,#Hybrid deviation excess setup
3.27,0    ,#Hybrid deviation clear setup
3.28,0    ,#Input selection
3.29,0    ,#Input selection
3.30,0    ,#Input selection
3.31,0    ,#Input selection
3.32,0    ,#Input selection
3.33,0    ,#Input selection
3.34,0    ,#Input selection
3.35,0    ,#Input selection
3.36,0    ,#Input selection
3.37,0    ,#Input selection
3.38,0    ,#Input selection
3.39,0    ,#Input selection
3.40,0    ,#Input selection
3.41,0    ,#Input selection
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4.99,0    ,#Input selection
5.00,0    ,#Input selection

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