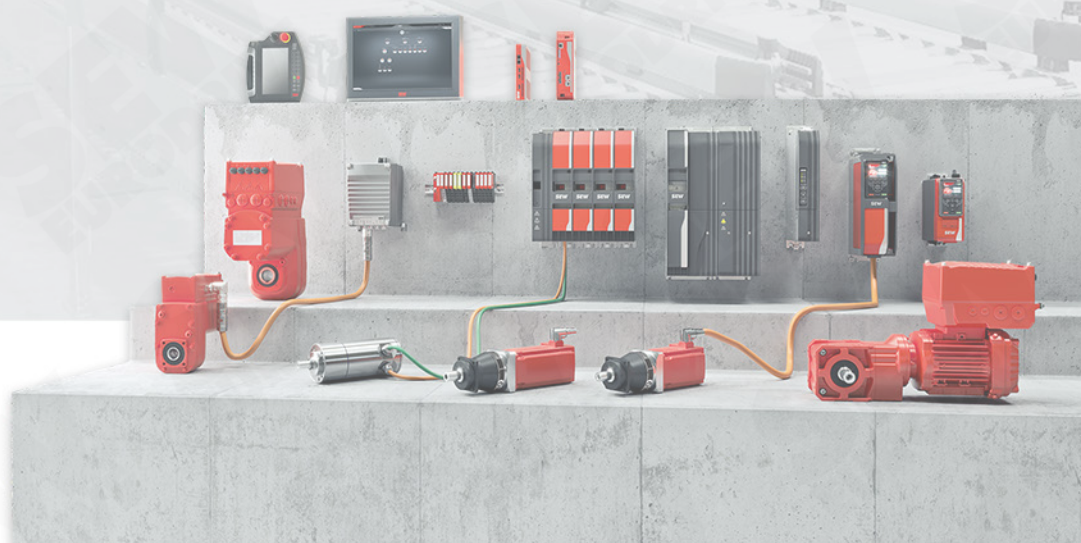


Product Training Workbook

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MOVI-C® Automation System
MOVIKIT® RotaryKnife Software Module
Parameterization and Diagnostics

C140

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Ensure that the operating instructions are made available in legible condition to those responsible for the system and its operation, as well as to personnel working on the device independently.

Objectives of this training document

- In this workbook, you will learn to start up the cross cutter application on a training model and control it via the process data interface.

Additional documents

- MOVIKIT® RotaryKnife software module manual
- MOVIKIT® RotaryKnife brief information

The product training team will be happy to assist you if you have any questions or suggestions.

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Meaning of the symbols:

Operating notes



Information



Safety-relevant information



Tip



Diagnostics and troubleshooting



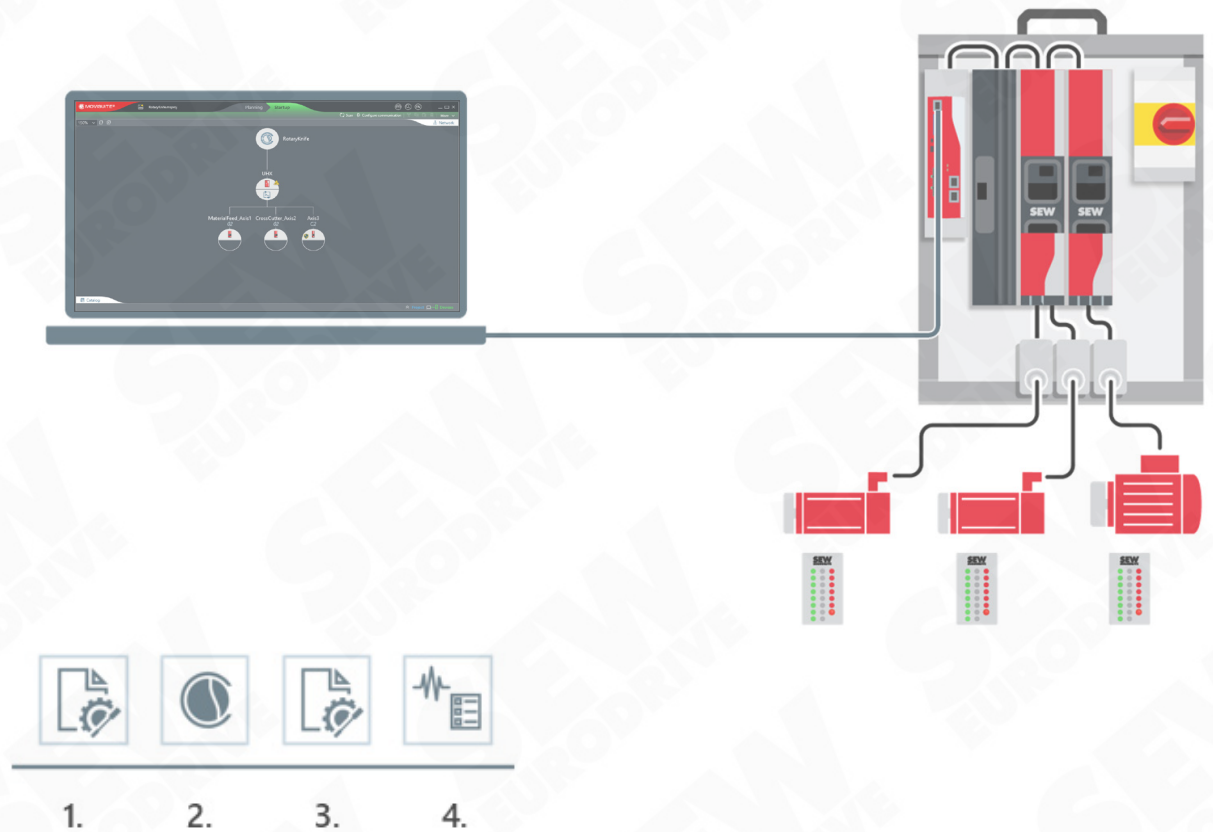
Practical task



Additional documentation

1	Introduction to the cross cutter application	1
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1.2	Training model	3
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2.1	Creating the MOVISUITE® project	5
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Workbook steps



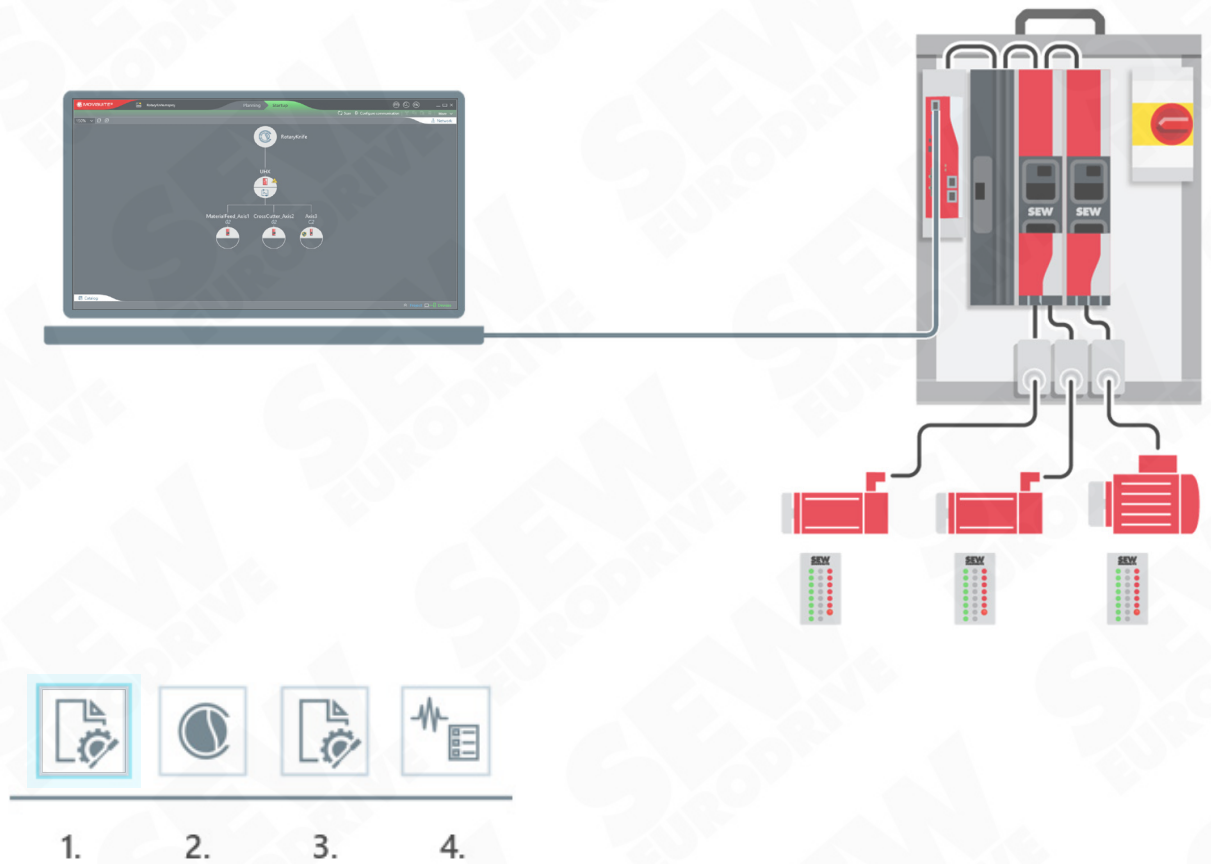
1. Introduction to the cross cutter application
2. Project setup and device configuration in MOVISUITE®
3. Master configuration (material feed)
4. Slave configuration (cross cutter)
5. Creation and Start of the IEC project
6. Control via the MOVILINK® Process data monitor



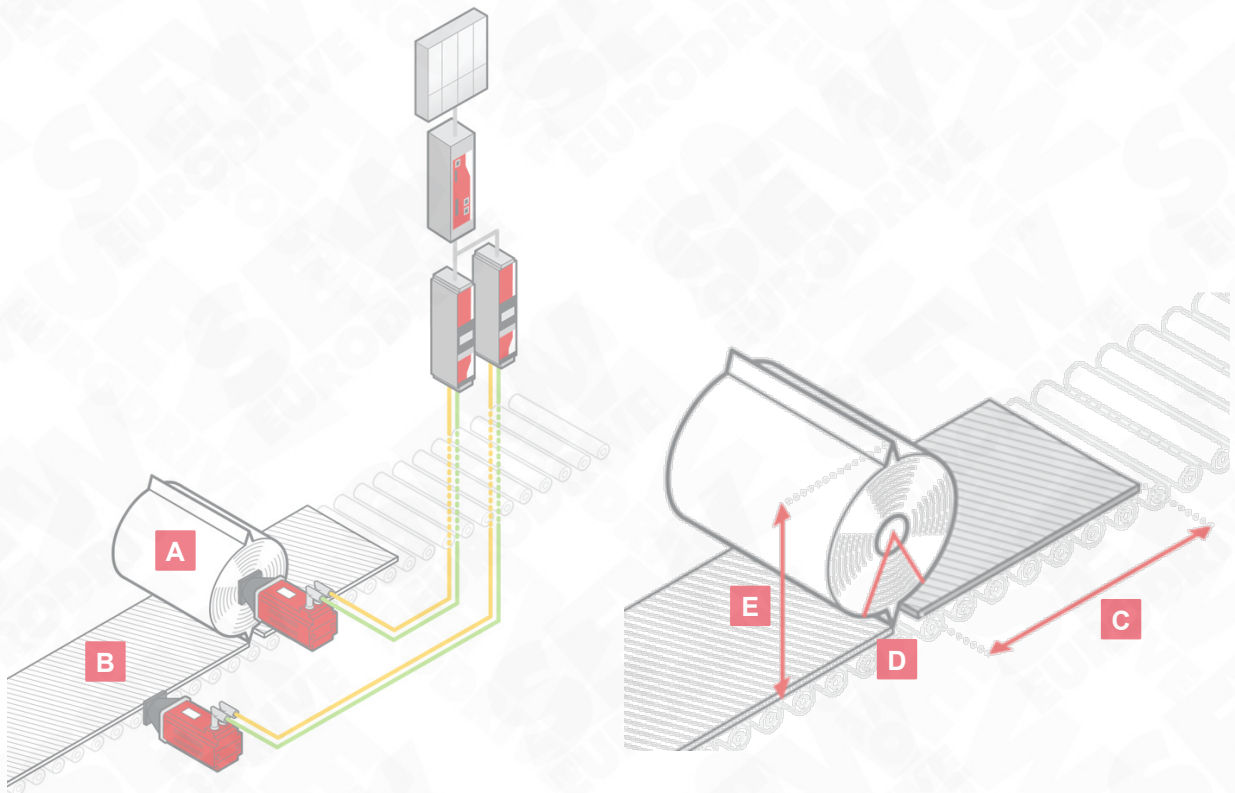
For the following exercises, the drives must be started up and optimized correctly in CFC or VFC^{PLUS} control mode. For information on startup and operation of MOVISUITE®, refer to **Workbook C101 MOVISUITE® – Practice on the Inverter.**

1 Introduction to the cross cutter application

- Objectives:**
- Being familiar with the cross cutter as a typical application for the MOVIKIT® RotaryKnife
 - Being familiar with the system configuration of the training model and software used



1.1 Cross cutter application

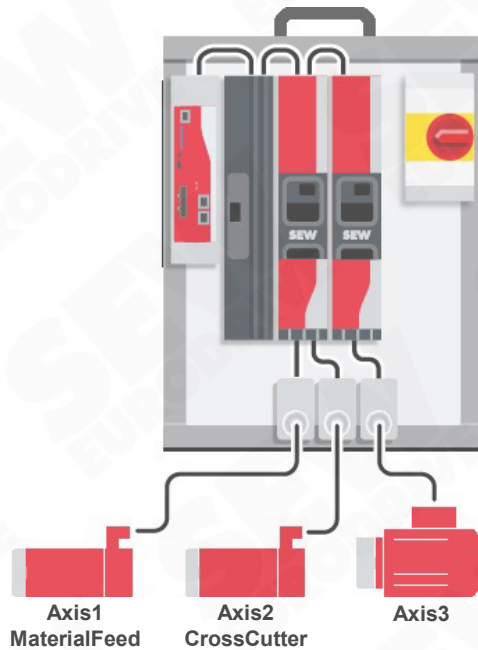


Application:

A common industrial application for the MOVIKIT® RotaryKnife is the cross cutter. It cuts thin material such as paper, cardboard, or metal into individual products without stopping the production line.

- A Cross cutter:** The cross cutter consists of a cylinder with knife blades fastened along the longitudinal axis. While the cylinder is rotating, the knife cuts the material running under it.
- B Material feed:** The material is continuously moved forward depending on the machine speed.
- C Cutting length:** The cutting length can be influenced by the speed of the cross cutter. To adjust the cutting length, the cross cutter is decelerated or accelerated after the cut.
- D Cutting position:** The cross cutter moves synchronously to the material at the cutting position or at a specific angle (synchronous angle).
- E Knife diameter:** Diameter of the rotary knife when there are 2 Knives

1.2 Training model



Axis1 / Master **MaterialFeed_Axis1**: Drive with motor encoder => MOVIKIT® Gearing
Axis2 / Slave **CrossCutter_Axis2**: Drive with motor encoder => MOVIKIT® RotaryKnife
Axis3: Drive with motor encoder => not used



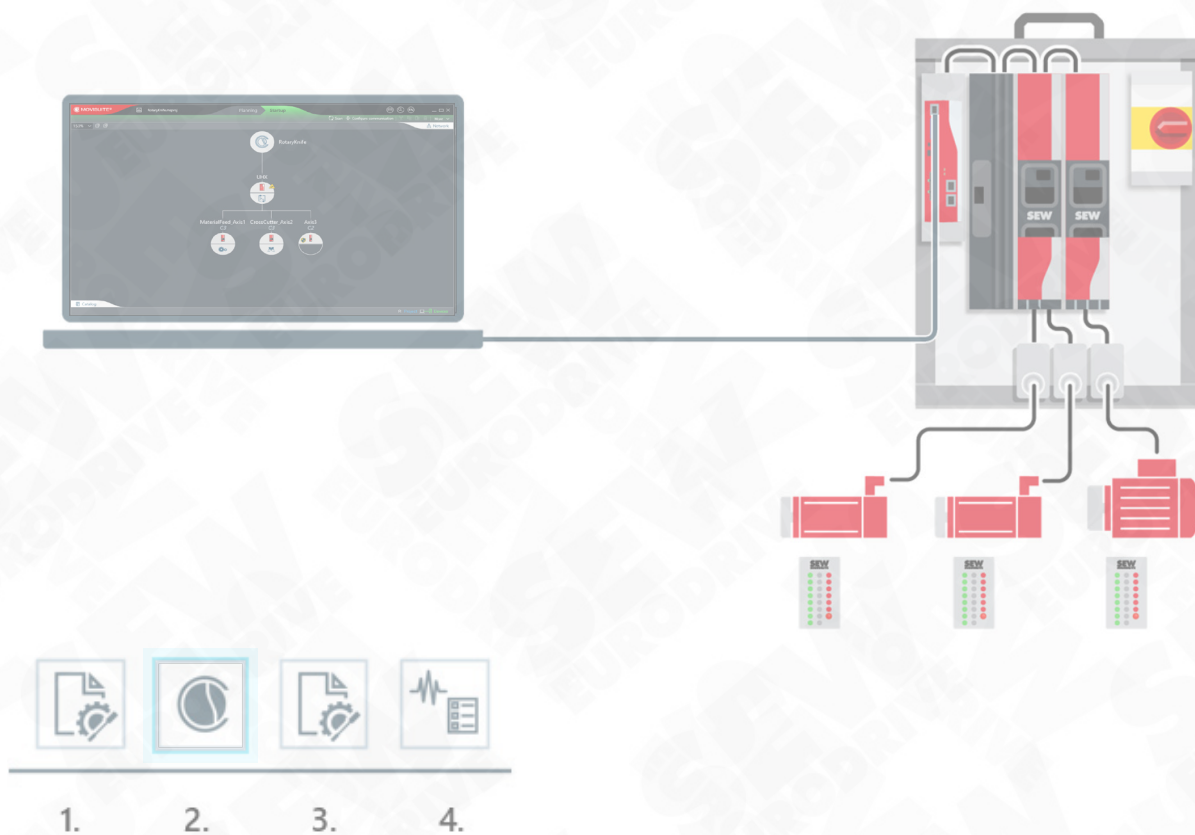
If the training model is not available, the exercises can also be done using any MOVI-C® CONTROLLER and MOVIDRIVE® modular/system with drive. The hardware configuration must then be adapted according to the hardware being used. If no inverter/drive hardware is available, the axes can be operated in a simulation.

Software:

- MOVISUITE® 2.50
- IEC Editor 3.5.18.2
- MOVIKIT® RotaryKnife 9.0.16.200
- MOVIKIT® Gearing 9.0.22.200

2 Project setup and device configuration in MOVISUITE®

- Objectives:**
- Being able to set up the MOVISUITE® project and configure the devices
 - Being able to configure MOVIKIT® software modules



2.1 Creating the MOVISUITE® project



1. Create a new project and rename the devices



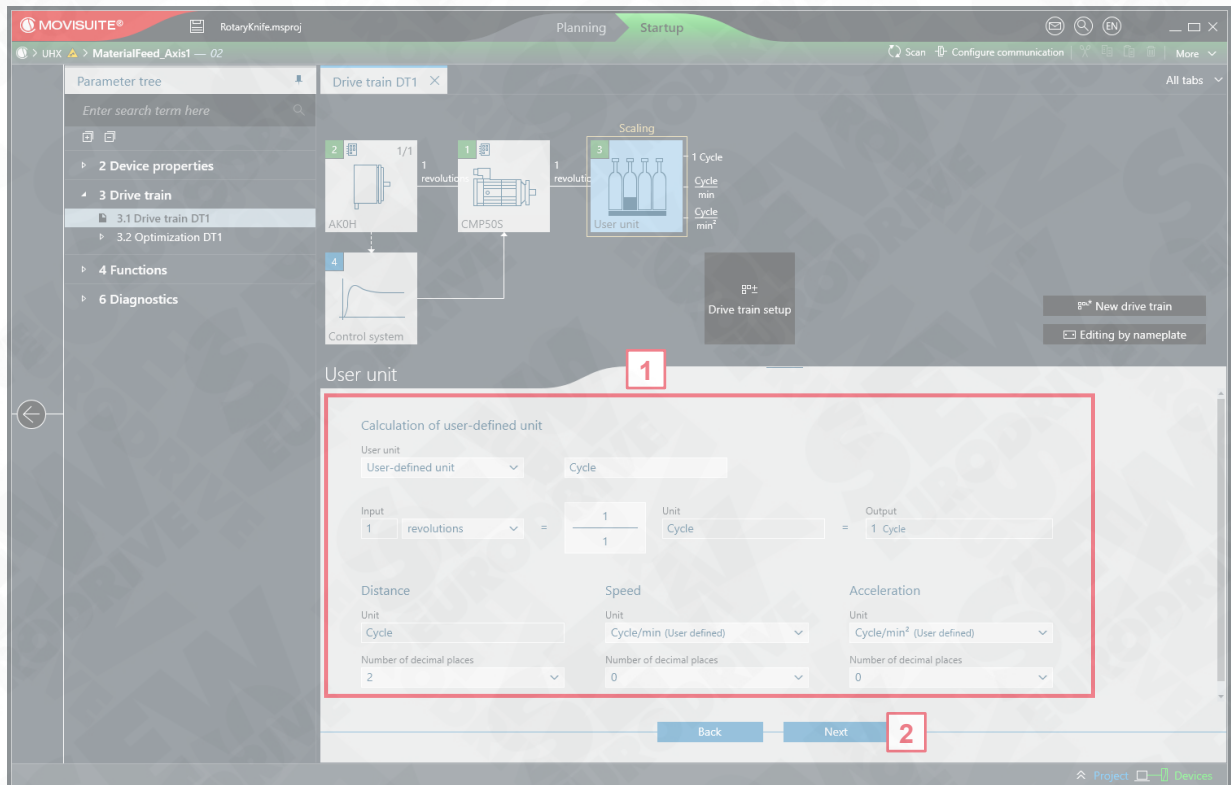
1 Create a new project from network scan and save it as RotaryKnife.

2 Assign the names for the devices as shown.

2.2 Configuring MaterialFeed_Axis1

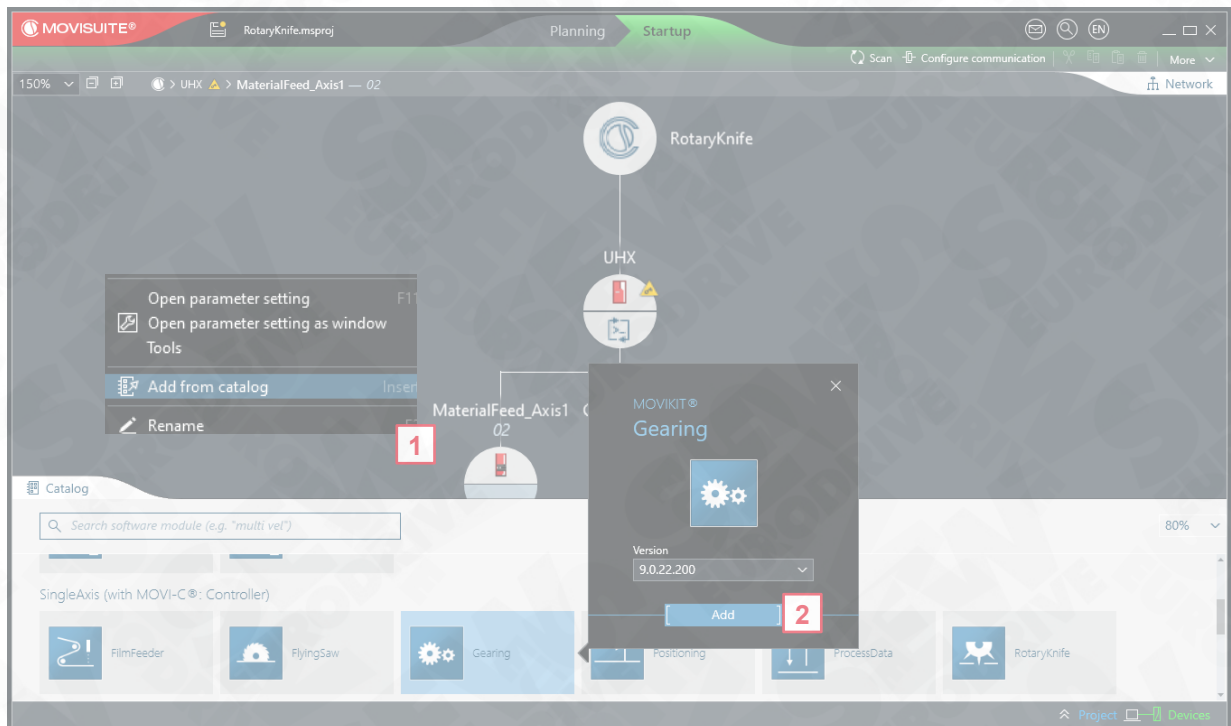


1. Configure the drive train



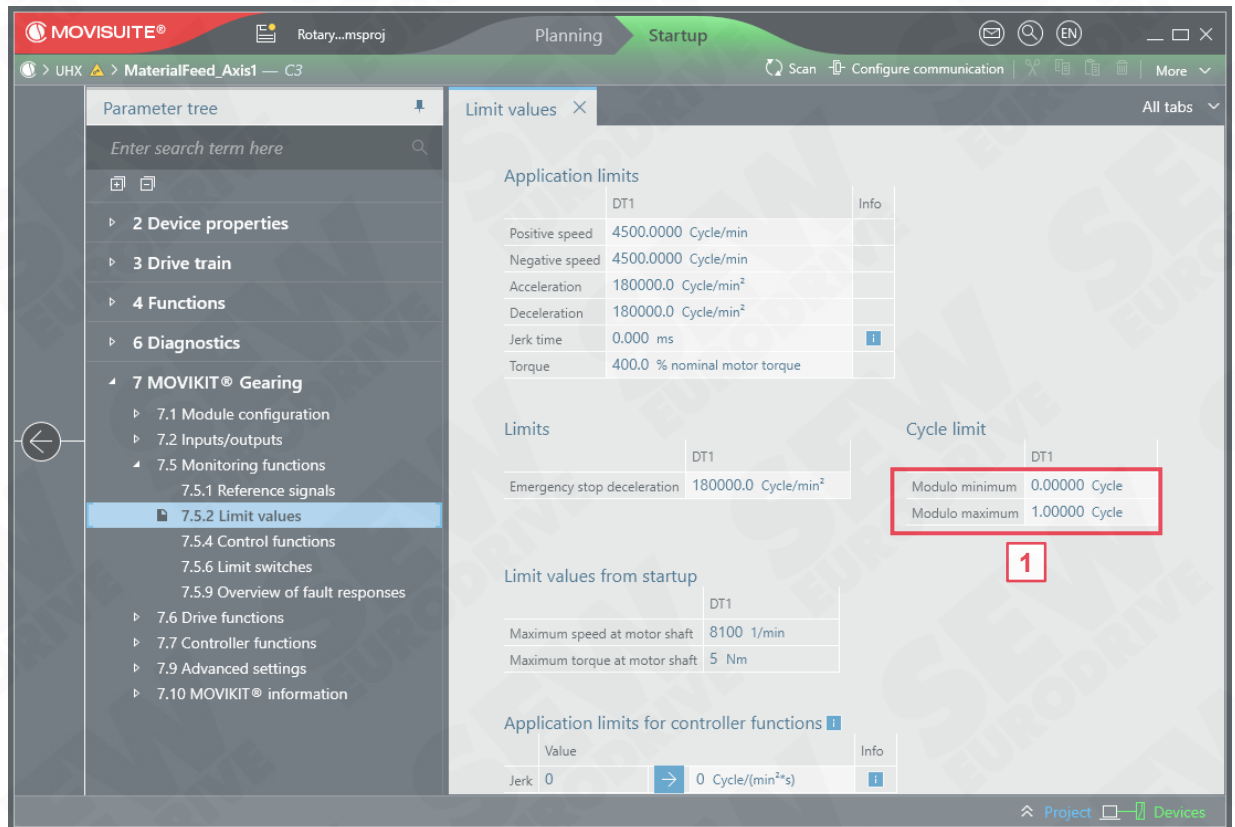
- 1 Configure the user units for the material feed as shown. The number of decimal places will be set automatically by the following MOVIKIT® software module.
- 2 Click **Next > Transfer data to device**.

2. Assign the MOVIKIT® Gearing software module



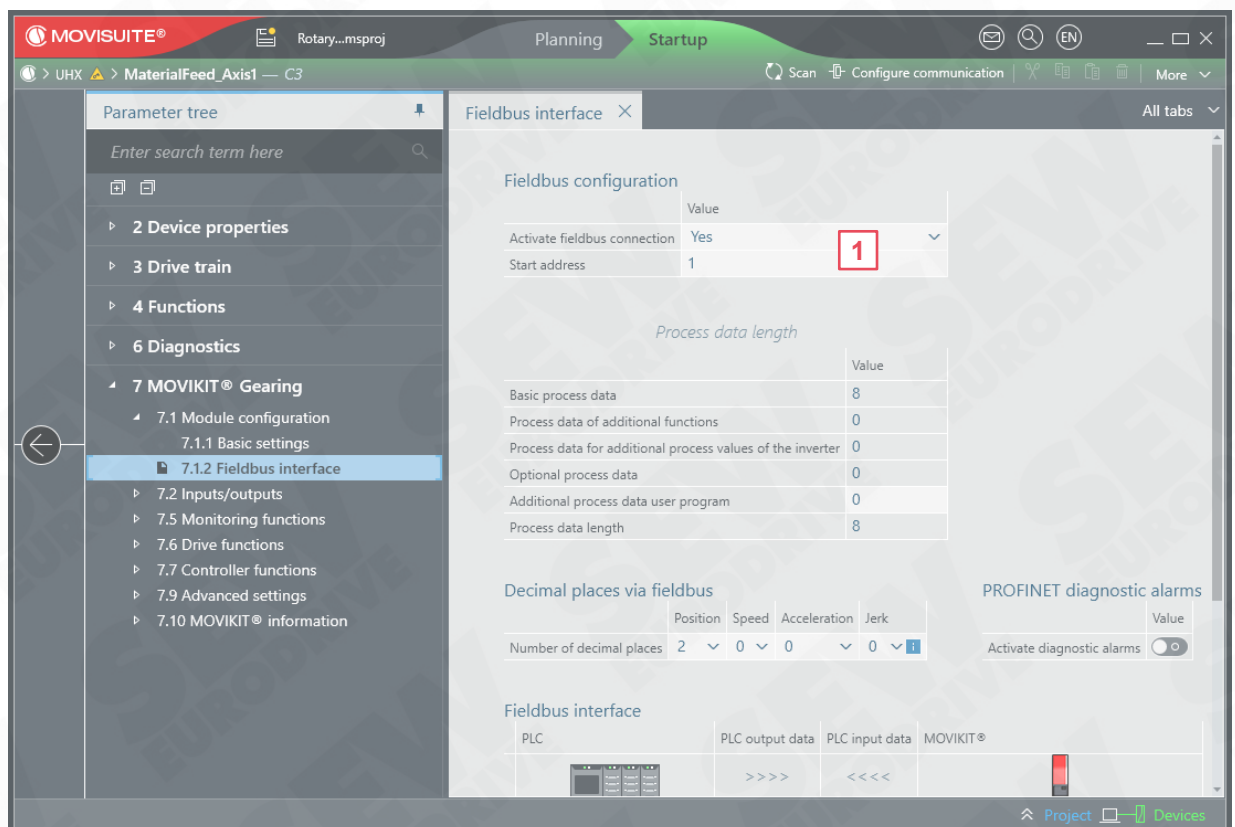
- 1 Right-click MaterialFeed_Axis1 and select **Add from catalog**.
- 2 Add MOVIKIT® Gearing, then reset the following error E-34.01.

3. Configure the Cycle limit



1 Configure the Cycle limit as shown.

4. Activate the fieldbus interface

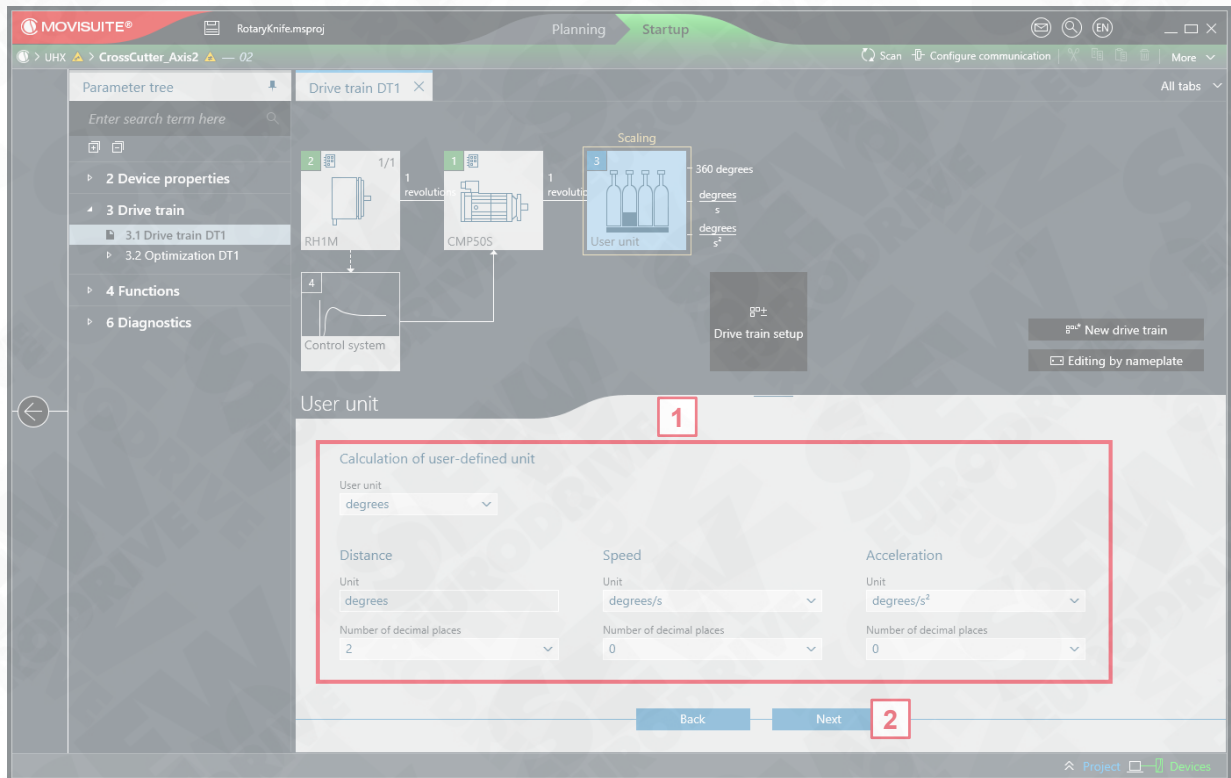


1 Activate the fieldbus connection and keep the default start address **1**.

2.3 Configuring CrossCutter_Axis2



1. Configure the drive train



- 1 Configure the user units for the material feed as shown. Here, too, the number of decimal places will be set by the following MOVIKIT® software module.
- 2 Click **Next > Transfer data to device**.

2. Assign the MOVIKIT® RotaryKnife software module



- 1 Assign MOVIKIT® RotaryKnife to CrossCutter_Axis2 and reset the following error E-34.01 again.

3. Configure the Cycle limit

The screenshot shows the MOVISUITE® software interface. The left sidebar contains a 'Parameter tree' with the following structure:

- 2 Device properties
- 3 Drive train
- 4 Functions
- 6 Diagnostics
- 7 MOVIKIT® RotaryKnife
 - 7.1 Module configuration
 - 7.5 Monitoring functions
 - 7.5.1 Reference signals
 - 7.5.2 Limit values (highlighted)
 - 7.5.9 Overview of fault r...
 - 7.6 Drive functions
 - 7.7 Controller functions
 - 7.9 Advanced settings
 - 7.10 MOVIKIT® information

The main area displays 'Limit values' for 'DT1'. It includes three tables:

Application limits		Info
Positive speed	27000.0000 degrees/s	
Negative speed	27000.0000 degrees/s	
Acceleration	18000.00 degrees/s ²	
Deceleration	18000.00 degrees/s ²	
Jerk time	0.000 ms	
Torque	400.0 % nominal motor torque	

Limits	
Emergency stop deceleration	18000.00 degrees/s ²

Limit values from startup	
Maximum speed at motor shaft	8100 1/min
Maximum torque at motor shaft	5 Nm

The 'Cycle limit' section is highlighted with a red box and a red '1'. It contains the following data:

Cycle limit	
Modulo minimum	0.000 degrees
Modulo maximum	360.000 degrees

1 Configure the Cycle limit as shown.

4. Configure the Master source

The screenshot shows the MOVISUITE® software interface. The left sidebar contains a 'Parameter tree' with the following structure:

- 2 Device properties
- 3 Drive train
- 4 Functions
- 6 Diagnostics
- 7 MOVIKIT® RotaryKnife
 - 7.1 Module configuration
 - 7.1.1 Basic settings
 - 7.1.2 Fieldbus interface
 - 7.5 Monitoring functions
 - 7.6 Drive functions
 - 7.7 Controller functions
 - 7.7.12 Rotary knife (highlighted)
 - 7.9 Advanced settings
 - 7.10 MOVIKIT® information

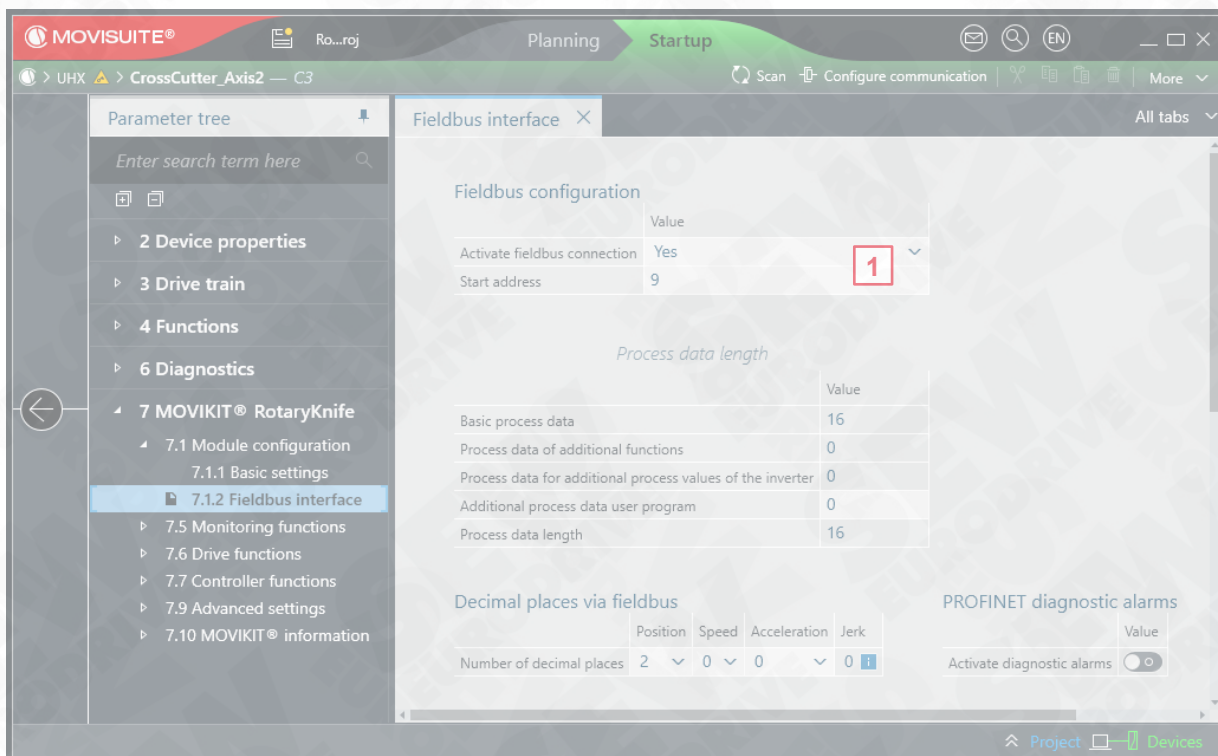
The main area displays 'Rotary knife' configuration. The 'Master source' dropdown menu is highlighted with a red box and a red '1'. It contains the following data:

	Value
Master source	Configured axis
Master axis name	MaterialFeed_Axis1
Master axis type	Modulo axis – cyclic position

1 Set the master source as shown.

MOVIKIT® RotaryKnife requires a modulo axis as the master.

5. Activate the fieldbus interface

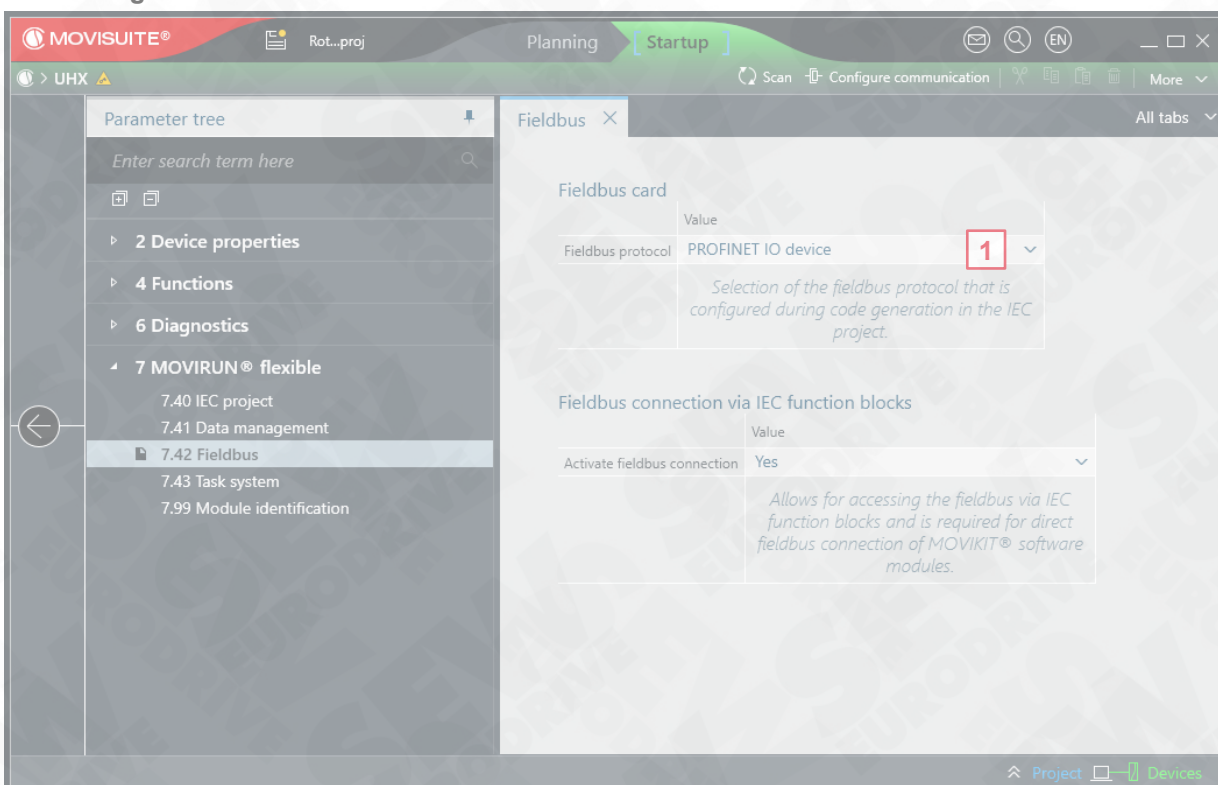


- 1 Activate the fieldbus connection and set the start address 9.

The start address 9 results from the start address (1) plus the number of process data words (8) of the previous axis MaterialFeed_Axis1.

Configuring MOVI-C® CONTROLLER

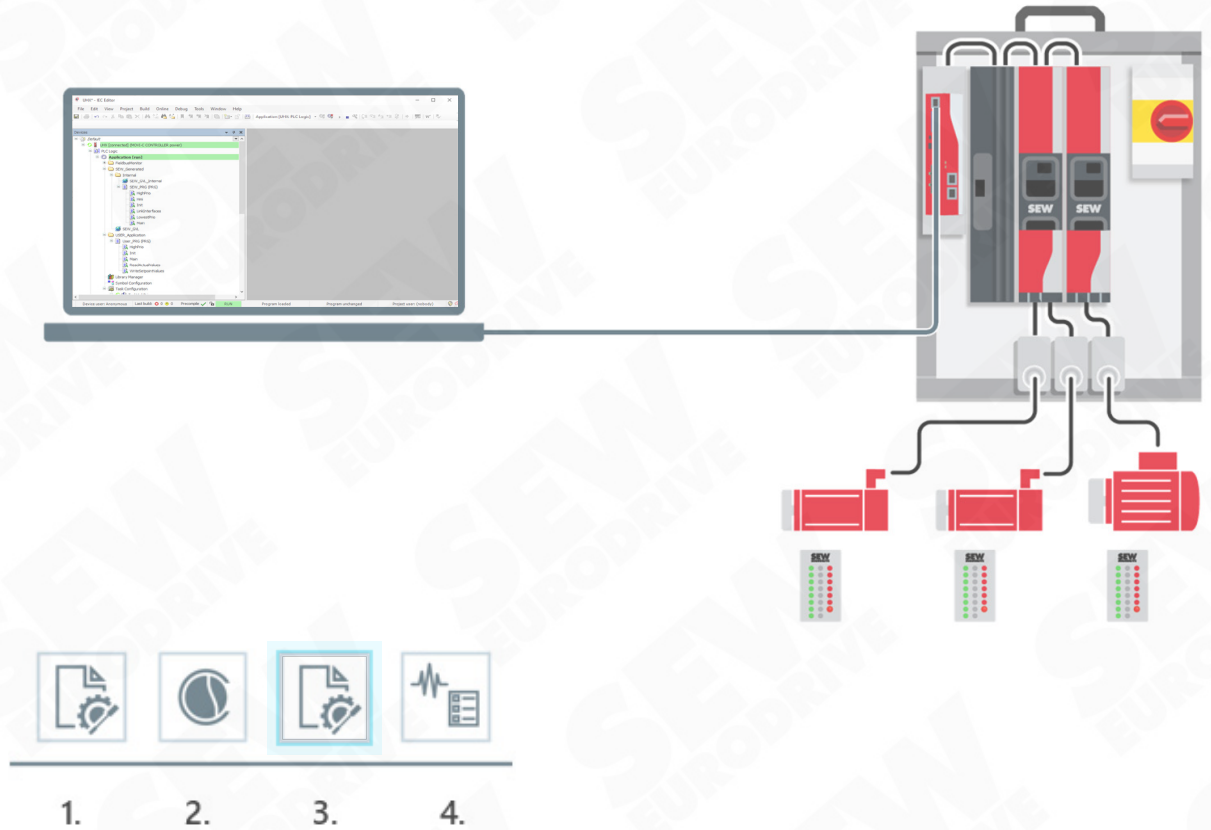
1. Configure the fieldbus interface



- 1 Select the appropriate **Fieldbus protocol**. The fieldbus connection will be automatically activated.

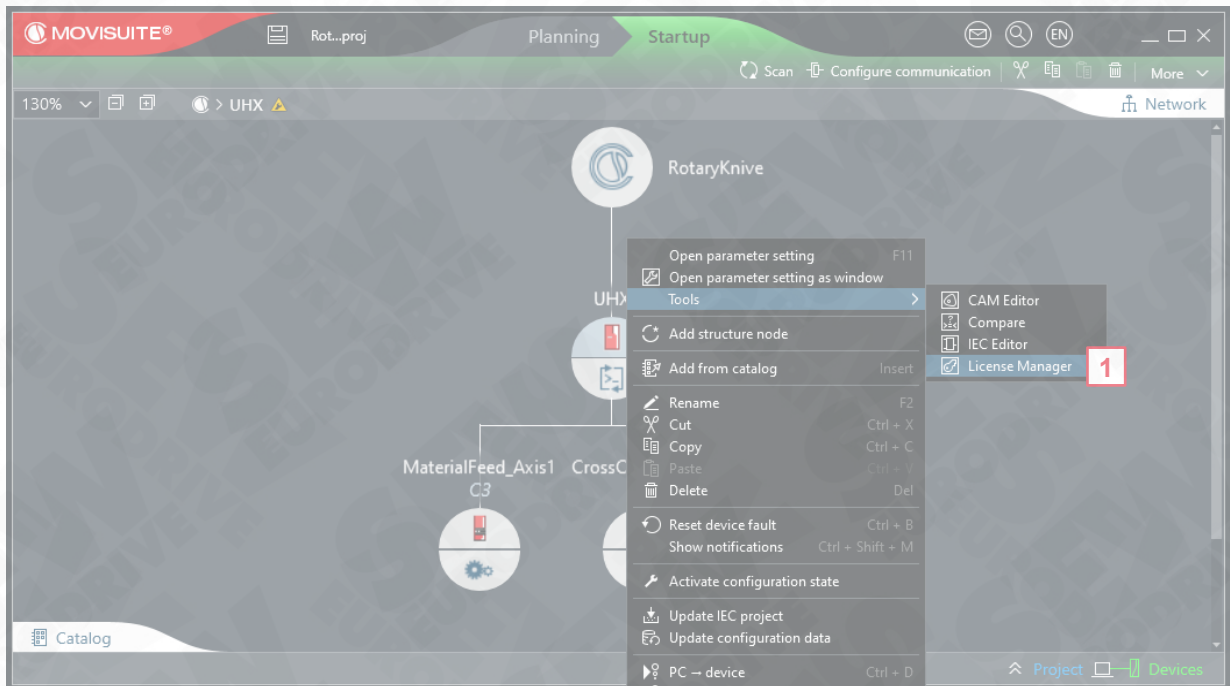
3 Creation and start of the IEC project

- Objectives:**
- Being able to configure the fieldbus interface of the MOVI-C® CONTROLLER
 - Being able to select and activate the appropriate licenses
 - Be able to create and start an IEC project



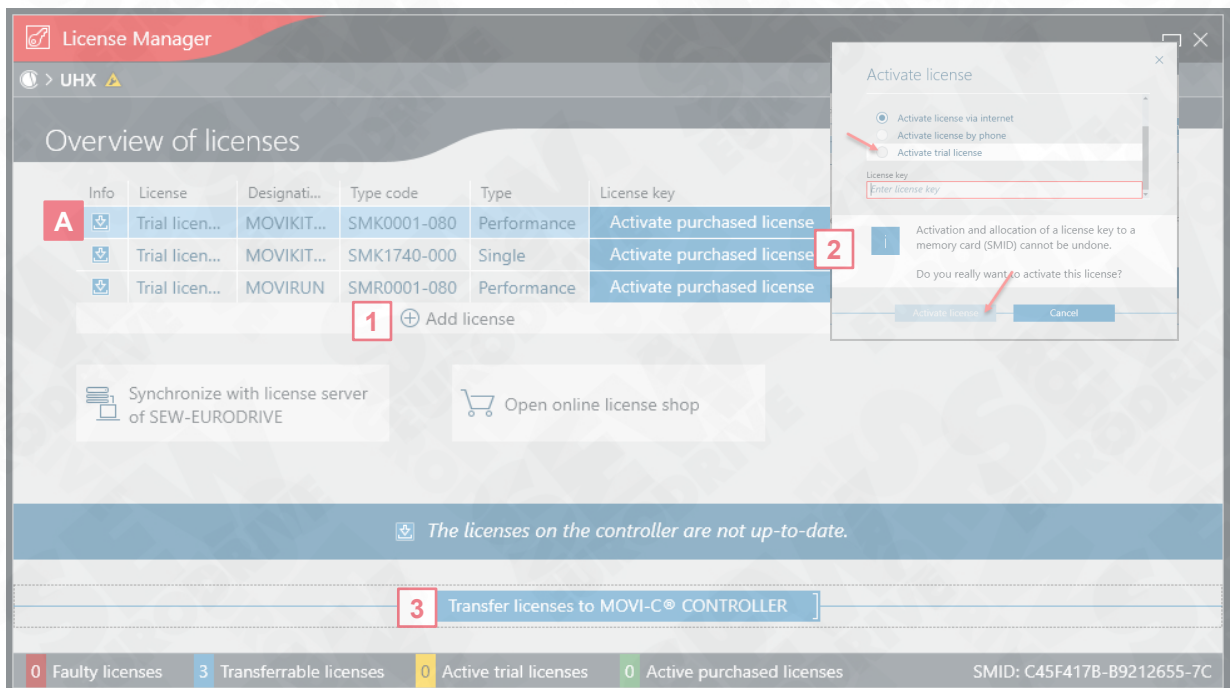
3.1 Licensing the MOVI-C® CONTROLLER

1. Start the License Manager



- 1 Right-click the MOVI-C® CONTROLLER and select the **License Manager**.

2. Select, activate and transfer the licenses



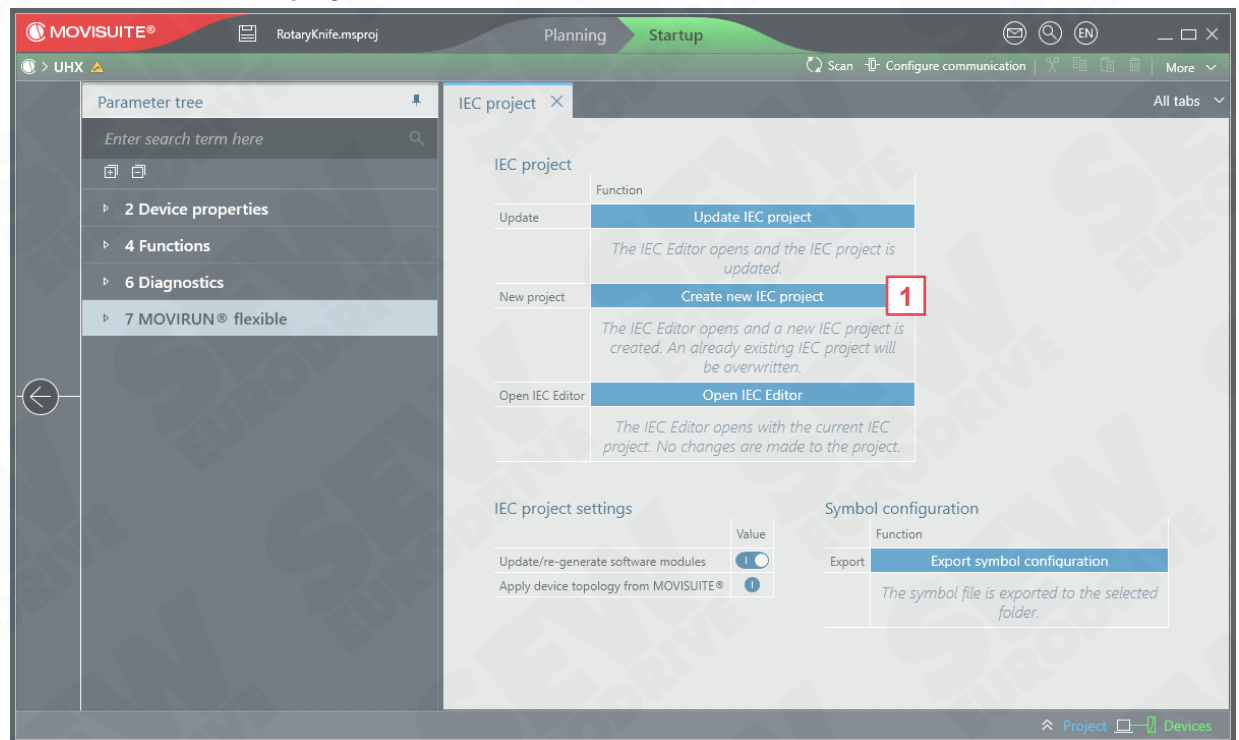
- 1 Click **Add license** and select the required licenses as shown.
- 2 Click **Activate purchase license** and activate trial licenses.
- 3 Transfer the licenses.
- A The MOVIKIT® MultiMotion Camming license contains the license for MOVIKIT® Gearing.

A trial license allows software functions to be tested before purchase. It is valid for 7 days and can be reactivated at any time. After the trial license expires, the program continues to run. A message regarding the expired trial license will be displayed on the MOVI-C® CONTROLLER.

3.2 Creating and starting the IEC project



1. Create a new IEC project

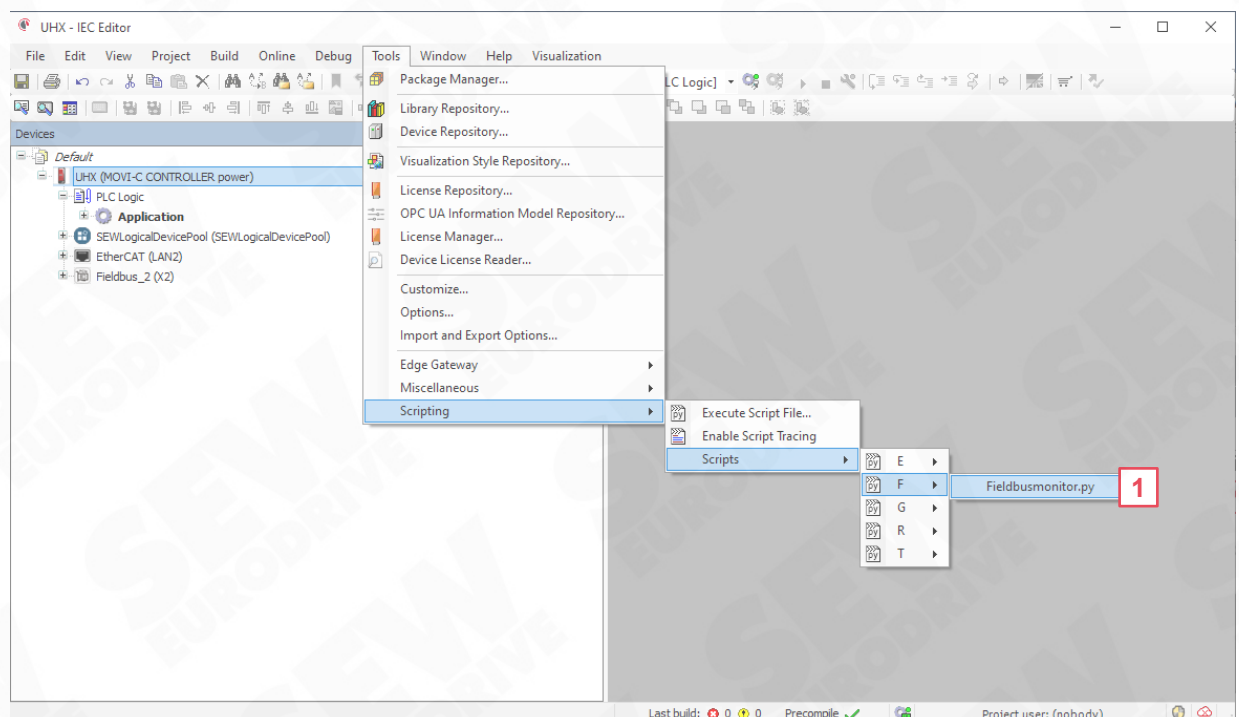


1 Click **Create new IEC project** to start the code generation process.



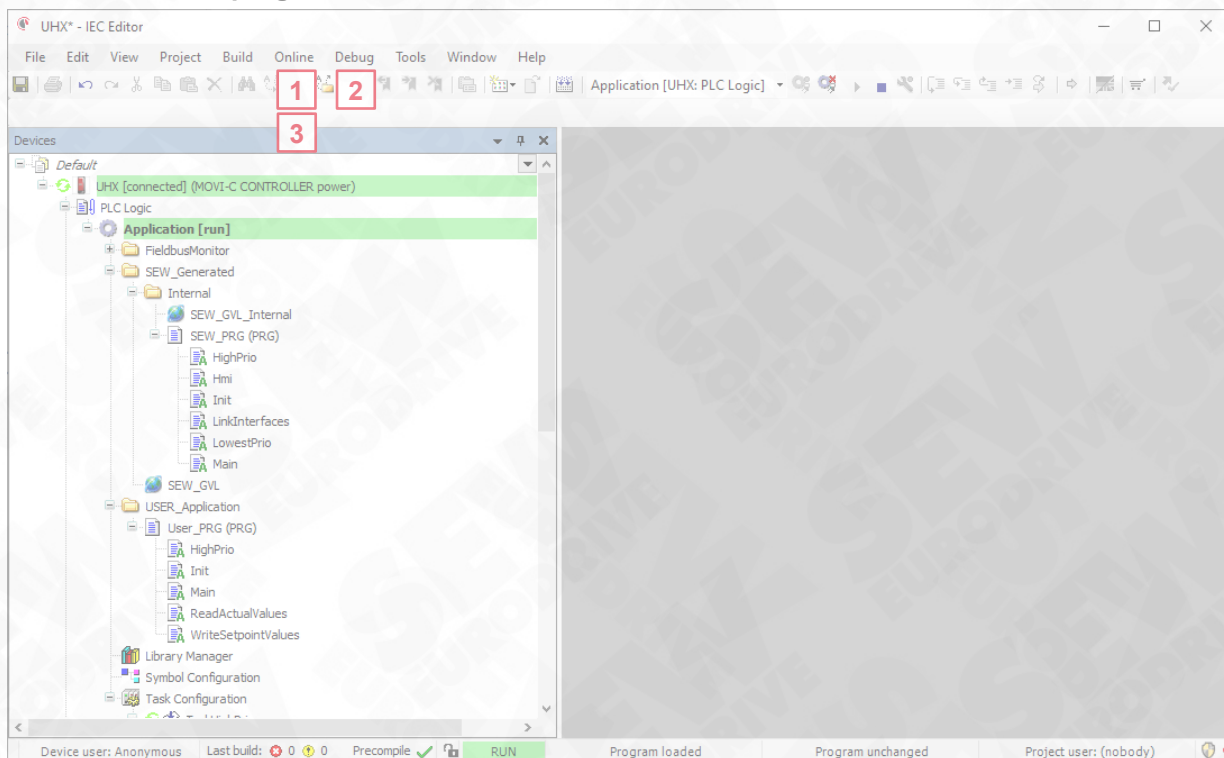
When you create a new IEC project, the existing project will be deleted. A self-programmed part then will also be overwritten/deleted.

2. Activate the Fieldbusmonitor



1 Select **Tools > Scripting > Scripts > F > Fieldbusmonitor.py**.

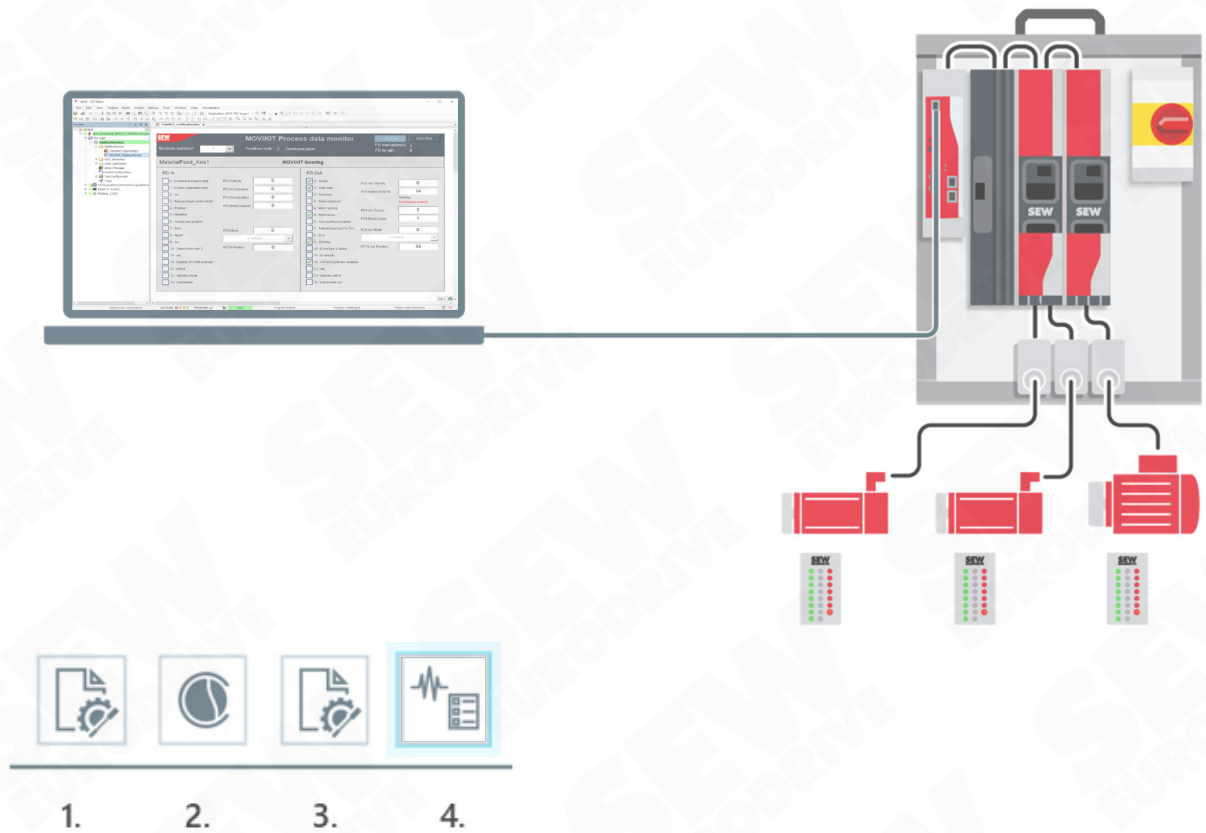
3. Start the IEC program



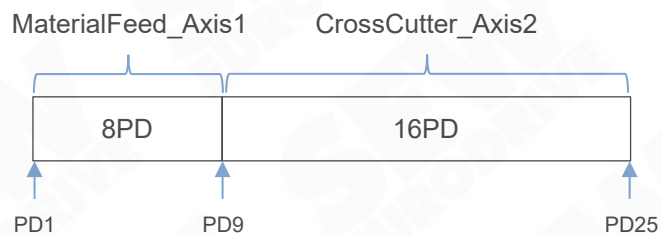
- 1 Compile and load the IEC program by clicking **Online > Login**.
- 2 Start the IEC program by clicking **Debug > Start**.
- 3 Save the program to the MOVI-C® CONTROLLER in a fail-safe manner **Online > Create Boot Application**.

4 Control via MOVIKIT® Process data monitor

Objectives: ▪ Control of the cross cutter application using the MOVIKIT® Process data monitor

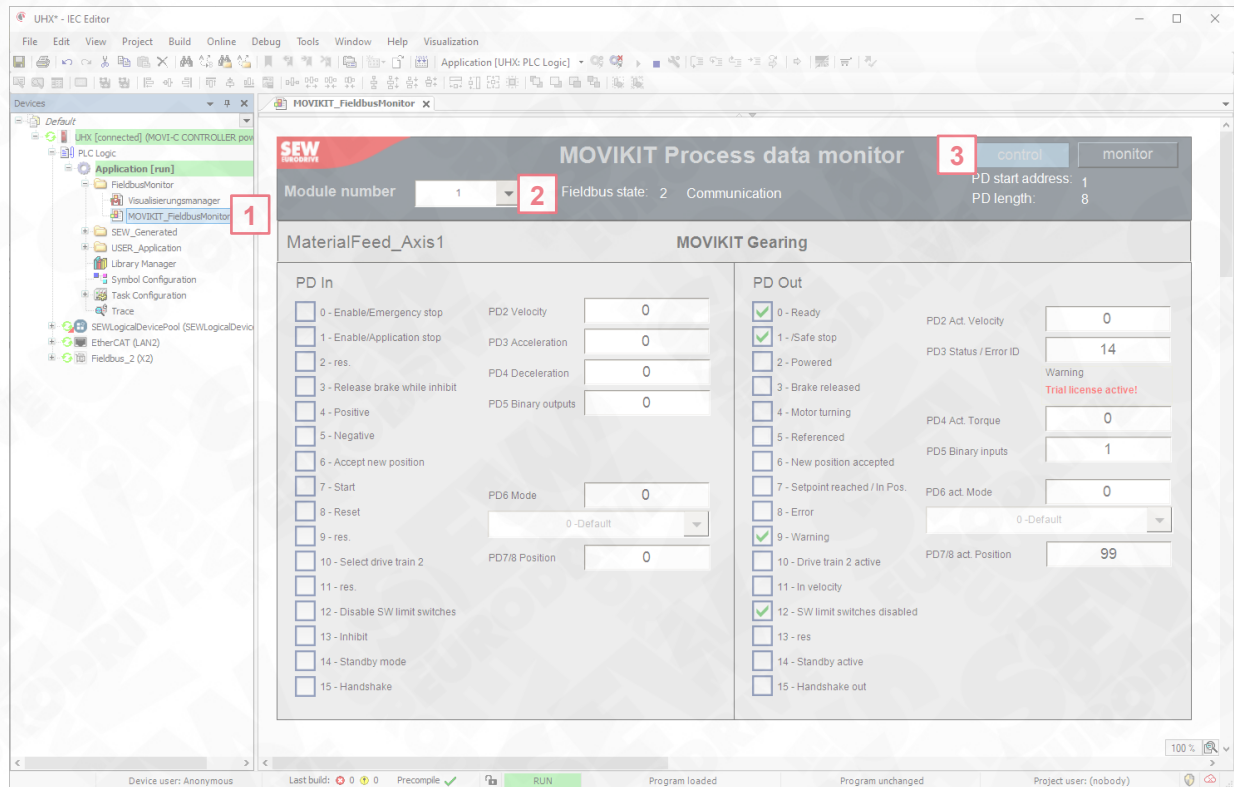


The configuration results in the following process data assignment:





1. Open the MOVIKIT® Process data monitor



- 1 Double-click **MOVIKIT_FieldBusmonitor**.
- 2 Select the process data monitor by selecting the module number:
 MaterialFeed_Axis1 / MOVIKIT® Gearing: Module number: **1**
 CrossCutter_Axis2 / MOVIKIT® RotaryKnife: Module number: **2**
- 3 Click **control** to switch to the control mode.

4.1 Referencing the axes



1. Reference MaterialFeed_Axis1

SEW EURODRIVE **MOVIKIT Process data monitor** control monitor

Module number: Fieldbus state: 2 Communication PD start address: 1 PD length: 8

MaterialFeed_Axis1 **MOVIKIT Gearing**

PD In	PD2 Velocity	PD3 Acceleration	PD4 Deceleration	PD5 Binary outputs	PD6 Mode	PD7/8 Position	PD Out	PD2 Act. Velocity	PD3 Status / Error ID	PD4 Act. Torque	PD5 Binary inputs	PD6 act. Mode	PD7/8 act. Position
<input type="checkbox"/> 0 - Enable/Emergency stop	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="300"/> 1	<input type="text" value="0"/>	<input checked="" type="checkbox"/> 0 - Ready	<input type="text" value="0"/>	<input type="text" value="14"/>	<input type="text" value="0"/>	<input type="text" value="1"/>	<input type="text" value="300"/>	<input type="text" value="0"/> B
<input type="checkbox"/> 1 - Enable/Application stop					300 - Homing offset configured		<input checked="" type="checkbox"/> 1 - /Safe stop						
<input type="checkbox"/> 2 - res.							<input type="checkbox"/> 2 - Powered						
<input type="checkbox"/> 3 - Release brake while inhibit							<input type="checkbox"/> 3 - Brake released						
<input type="checkbox"/> 4 - Positive							<input type="checkbox"/> 4 - Motor turning						
<input type="checkbox"/> 5 - Negative							<input checked="" type="checkbox"/> 5 - Referenced A						
<input type="checkbox"/> 6 - Accept new position							<input type="checkbox"/> 6 - New position accepted						
<input checked="" type="checkbox"/> 7 - Start 2							<input type="checkbox"/> 7 - Setpoint reached / In Pos.						
<input type="checkbox"/> 8 - Reset							<input type="checkbox"/> 8 - Error						
<input type="checkbox"/> 9 - res.							<input type="checkbox"/> 9 - Warning						
<input type="checkbox"/> 10 - Select drive train 2							<input type="checkbox"/> 10 - Drive train 2 active						
<input type="checkbox"/> 11 - res.							<input type="checkbox"/> 11 - In velocity						
<input type="checkbox"/> 12 - Disable SW limit switches							<input checked="" type="checkbox"/> 12 - SW limit switches disabled						
<input type="checkbox"/> 13 - Inhibit							<input type="checkbox"/> 13 - res						
<input type="checkbox"/> 14 - Standby mode							<input type="checkbox"/> 14 - Standby active						
<input type="checkbox"/> 15 - Handshake							<input type="checkbox"/> 15 - Handshake out						

- 1 Select the operating mode **PD6 Mode = 300**.
- 2 Start referencing.
- A Here you can see the reference status of the drive.
- B Here you can see the actual position of the axis (0 after referencing).

2. Reference CrossCutter_Axis2

SEW EURODRIVE **MOVIKIT Process data monitor** control monitor

Module number: Fieldbus state: 2 Communication PD start address: 9 PD length: 16

CrossCutter_Axis2 **MOVIKIT RotaryKnife**

PD In	PD2 Velocity	PD3 Acceleration	PD4 Deceleration	PD5 Binary outputs	PD6 Mode	PD7/8 Position	PD Out	PD2 Act. Velocity	PD3 Status / Error ID	PD4 Act. Torque	PD5 Binary inputs	PD6 act. Mode	PD7/8 act. Position
<input type="checkbox"/> 0 - Enable/Emergency stop	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="300"/> 1	<input type="text" value="0"/>	<input checked="" type="checkbox"/> 0 - Ready	<input type="text" value="2"/>	<input type="text" value="14"/>	<input type="text" value="0"/>	<input type="text" value="1"/>	<input type="text" value="300"/>	<input type="text" value="0"/> B
<input type="checkbox"/> 1 - Enable/Application stop					300 - Homing offset configured		<input checked="" type="checkbox"/> 1 - /Safe stop						
<input type="checkbox"/> 2 - res.							<input type="checkbox"/> 2 - Powered						
<input type="checkbox"/> 3 - Release brake while inhibit							<input type="checkbox"/> 3 - Brake released						
<input type="checkbox"/> 4 - Positive							<input type="checkbox"/> 4 - Motor turning						
<input type="checkbox"/> 5 - Negative							<input checked="" type="checkbox"/> 5 - Referenced A						
<input type="checkbox"/> 6 - Accept new position							<input type="checkbox"/> 6 - New position accepted						
<input checked="" type="checkbox"/> 7 - Start 2							<input type="checkbox"/> 7 - Setpoint reached / In Pos.						
<input type="checkbox"/> 8 - Reset							<input type="checkbox"/> 8 - Error						
<input type="checkbox"/> 9 - res.							<input type="checkbox"/> 9 - Warning						
<input type="checkbox"/> 10 - Select drive train 2							<input type="checkbox"/> 10 - Drive train 2 active						
<input type="checkbox"/> 11 - res.							<input type="checkbox"/> 11 - In velocity						
<input type="checkbox"/> 12 - Disable SW limit switches							<input checked="" type="checkbox"/> 12 - SW limit switches disabled						
<input type="checkbox"/> 13 - Inhibit							<input type="checkbox"/> 13 - res						
<input type="checkbox"/> 14 - Standby mode							<input type="checkbox"/> 14 - Standby active						
<input type="checkbox"/> 15 - Handshake							<input type="checkbox"/> 15 - Handshake out						

- 1 Reference the axis as shown.

4.2 Controlling axes in Automatic mode



1. Control CrossCutter_Axis2 in automatic mode

SEW EURODRIVE **MOVIKIT Process data monitor** control monitor

Module number: Fieldbus state: 2 Communication PD start address: 9 PD length: 16

CrossCutter_Axis2 **MOVIKIT RotaryKnife**

PD In		PD Out
<input checked="" type="checkbox"/> 0 - Enable/Emergency stop	PD2 Velocity: <input type="text" value="100"/>	<input checked="" type="checkbox"/> 0 - Ready
<input checked="" type="checkbox"/> 1 - Enable/Application stop	PD3 Acceleration: <input type="text" value="1000"/>	<input checked="" type="checkbox"/> 1 - /Safe stop
<input type="checkbox"/> 2 - res.	PD4 Deceleration: <input type="text" value="1000"/>	<input checked="" type="checkbox"/> 2 - Powered
<input type="checkbox"/> 3 - Release brake while inhibit	PD5 Binary outputs: <input type="text" value="0"/>	<input checked="" type="checkbox"/> 3 - Brake released
<input type="checkbox"/> 4 - Positive	PD6 Mode: <input type="text" value="1400"/> 1	<input type="checkbox"/> 4 - Motor turning
<input type="checkbox"/> 5 - Negative	<input type="text" value="1400 - Application automatic"/>	<input checked="" type="checkbox"/> 5 - Referenced
<input type="checkbox"/> 6 - Accept new position	PD7/8 Position: <input type="text" value="0"/>	<input type="checkbox"/> 6 - New position accepted
<input checked="" type="checkbox"/> 7 - Start		<input checked="" type="checkbox"/> 7 - Setpoint reached / In Pos.
<input type="checkbox"/> 8 - Reset		<input type="checkbox"/> 8 - Error
<input type="checkbox"/> 9 - res.		<input checked="" type="checkbox"/> 9 - Warning
<input type="checkbox"/> 10 - Select drive train 2		<input type="checkbox"/> 10 - Drive train 2 active
<input type="checkbox"/> 11 - res.		<input type="checkbox"/> 11 - In velocity
<input type="checkbox"/> 12 - Disable SW limit switches		<input checked="" type="checkbox"/> 12 - SW limit switches disabled
<input type="checkbox"/> 13 - Inhibit		<input type="checkbox"/> 13 - res
<input type="checkbox"/> 14 - Standby mode		<input type="checkbox"/> 14 - Standby active
<input type="checkbox"/> 15 - Handshake		<input type="checkbox"/> 15 - Handshake out

PD2 Act. Velocity:
 PD3 Status / Error ID: B
 Warning: Trial license active!
 PD4 Act. Torque:
 PD5 Binary inputs:
 PD6 act. Mode:
 PD7/8 act. Position: A

3 **RotaryKnife Parameters**

PD9	Application Controlword	PD13 Diameter	PD13 reserved
PD10/11 Product Length	<input type="text" value="100000"/>	PD14 Sync.Angle	<input type="text" value="4500"/>
PD12 Tools	<input type="text" value="2"/>	PD15 Sync.Corr.	<input type="text" value="0"/>
		PD16 reserved	<input type="text" value="0"/>

PD9	Application Statusword	PD13 reserved
Gearing state	<input type="text" value="ACTIVE"/>	PD14 reserved
PD11 reserved	<input type="text" value="2"/>	PD15 reserved
PD12 Number of Cuts	<input type="text" value="0"/>	PD16 reserved

1 Set the mode with **PD6 Mode = 1400**.

2 Set the travel parameters.

3 Set the parameters for the RotaryKnife:

- **PD10/11 Product Length = 100000** > nominal cut length in [mm] with 2 decimal places
- **PD12 Tools = 2** > number of tools on the rotating knife
- **PD13 Diameter = 10000** > knife diameter in [mm] with 2 decimal places
- **PD14 Sync.Angle = 4500** > angle at which the rotating knife moves synchronously to the product. User unit [degrees] with two decimal places

4 Set the two enable bits **Bit 0 / Bit 1** and start automatic mode with **Bit 7**.

A When automatic mode is activated, the axis automatically aligns with the specified travel parameters to the start position 90°.

B In automatic mode, the **FCB10 Interpolated position control** is activated.

2. Control MaterialFeed_Axis1 in velocity mode

SEW EURODRIVE **MOVIKIT Process data monitor** control monitor

Module number: Fieldbus state: 2 Communication PD start address: 1 PD length: 8

MaterialFeed_Axis1 **MOVIKIT Gearing**

PD In		PD Out
<input checked="" type="checkbox"/> 0 - Enable/Emergency stop	PD2 Velocity: <input type="text" value="100"/>	<input checked="" type="checkbox"/> 0 - Ready
<input checked="" type="checkbox"/> 1 - Enable/Application stop	PD3 Acceleration: <input type="text" value="1000"/>	<input checked="" type="checkbox"/> 1 - /Safe stop
<input type="checkbox"/> 2 - res.	PD4 Deceleration: <input type="text" value="1000"/>	<input checked="" type="checkbox"/> 2 - Powered
<input type="checkbox"/> 3 - Release brake while inhibit	PD5 Binary outputs: <input type="text" value="0"/>	<input checked="" type="checkbox"/> 3 - Brake released
<input type="checkbox"/> 4 - Positive	PD6 Mode: <input type="text" value="200"/>	<input checked="" type="checkbox"/> 4 - Motor turning
<input type="checkbox"/> 5 - Negative	<input type="text" value="200 - Velocity"/>	<input checked="" type="checkbox"/> 5 - Referenced
<input type="checkbox"/> 6 - Accept new position	PD7/8 Position: <input type="text" value="0"/>	<input type="checkbox"/> 6 - New position accepted
<input checked="" type="checkbox"/> 7 - Start		<input type="checkbox"/> 7 - Setpoint reached / In Pos.
<input checked="" type="checkbox"/> 8 - Reset		<input type="checkbox"/> 8 - Error
<input type="checkbox"/> 9 - res.		<input type="checkbox"/> 9 - Warning
<input type="checkbox"/> 10 - Select drive train 2		<input type="checkbox"/> 10 - Drive train 2 active
<input type="checkbox"/> 11 - res.		<input checked="" type="checkbox"/> 11 - In velocity
<input type="checkbox"/> 12 - Disable SW limit switches		<input checked="" type="checkbox"/> 12 - SW limit switches disabled
<input type="checkbox"/> 13 - Inhibit		<input type="checkbox"/> 13 - res
<input type="checkbox"/> 14 - Standby mode		<input type="checkbox"/> 14 - Standby active
<input type="checkbox"/> 15 - Handshake		<input type="checkbox"/> 15 - Handshake out

PD2 Act. Velocity:
 PD3 Status / Error ID:
 PD4 Act. Torque:
 PD5 Binary inputs:
 PD6 act. Mode:
 PD7/8 act. Position:

- 1** Set the mode with **PD6 Mode = 200**.
- 2** Set the travel parameters.
- 3** Set the two enable bits **Bit 0 / Bit 1** and start velocity mode with **Bit 7**.



MaterialFeed_Axis1 is the master axis for automatic mode of the application.

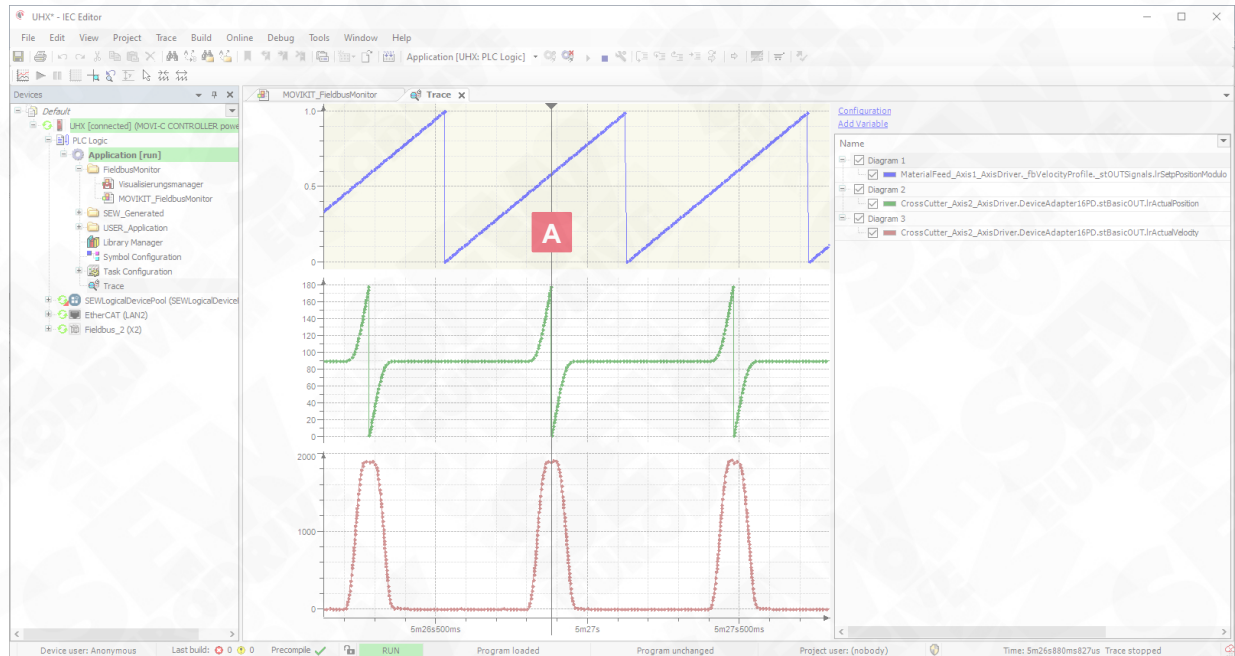
4.3 Performing Trace measurement of automatic mode



1. Configure a Trace measurement with the following variables from SEW_GVL_Internal:

- MaterialFeed_Axis1_AxisDriver_fbVelocityProfile_stOUTSignals.IrSetpPositionModulo
- CrossCutter_Axis2_AxisDriver.DeviceAdapter16PD.stBasicOUT.IrActualPosition
- CrossCutter_Axis2_AxisDriver.DeviceAdapter16PD.stBasicOUT.IrActualVelocity

2. Perform the Trace measurement



A

The cut starts in the middle of the cycle because the rotary knife was at the position of 90° before the master axis started.

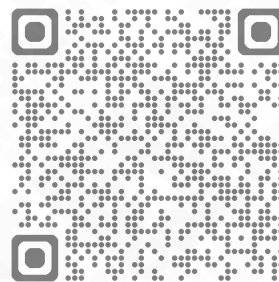
For more information on Trace, refer to **Workbook C105 Basics of IEC Programming / Workbook C103 MOVIKIT® Software Modules MultiMotion Category**.

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