

#### Four-axis control board for simple control flow instructions

##### 1. Setting parameters:

/

1aM1j16m50h30L100V16000aM2j16m50h30L100V16000aM3j16m50h30L100V16000aM4j16m50h30L100V16000R

##### 2. Parameter saving after power-off: / 1!

##### 3. Control each axis' rotation separately:

(1) Set axis 1 to rotate forward: / 1aM1P1000R

(2) Set axis 1 to rotate in the reverse direction: / 1aM1D1000R

(3) Set the forward and reverse rotation reference of other axes (1) and (2), just change aM1 among them to correspond to the axis, for example: positive direction of axis 2: / 1aM2P1000R

(4) Set the single-axis limit enable LED light off: / 1aM1n2R

(5) Set the single axis limit enable LED to light: / 1aM1n3R

(6) Setting the single-axis limit to disable the LED light: / 1aM1n0R

(7) Disable single-axis limit LED light: / 1aM1n1R

(8) When setting other axis limit enable conditions, refer to (4), (5), (6) and (7), just change the aM1 in it to the corresponding axis number, for example: the positive direction of axis 2 : / 1aM2n2R

(9) Return to the current motor position: / 1? 0 (This command will only return the position of the motor on the axis where the motion stopped at the latest when the multi-axis is synchronized, and it cannot return the position of the four-axis motor at the same time)

(10) Read the motor busy status: / 1? AS (For the return value data, please refer to the description of the instruction on page 15 of the manual)

(11) Read limit trigger status: / 1? 4 (The axis without limit switch defaults the bit to 1, the bit connected to the limit switch does not trigger to 0, the trigger is 1; where the instruction returns Value is decimal;)

##### 4. Multi-axis synchronous movement:

(1) Movement in the same direction: / 1P1000,1000,1000,1000R

(2) There is a reverse axis movement: / 1P1000, -1000, 1000, 1000R (if two or three axes have different directions, the corresponding data can be set to a negative number)

(3) Set multiple axis limit enable: / 1aM1n2aM2n2aM3n2aM4n2R (For the data value of n, refer to the 4, 5, 6, 7, 8 in 3.)

(4) Multi-axis read limit trigger instruction: / 1? 4 (The default value for the bit of the axis without limit switch is 1, the bit of the limit switch is not triggered as 0, and the trigger is 1. Among the instructions The return value is decimal;)

(5) Return the current motor position: / 1? 0 (This command will only return the position of the motor on the latest axis when the motion stops at the time of multi-axis synchronous motion, and it cannot return the position of the four-axis motor at the same time)

(6) Read the motor busy status: / 1? AS (for the return value data, please refer to the description of the instruction on page 15 of the manual)

Note: 1. The address station needs to be replaced when the controller is not powered on! !! After

the address station is changed, the command address needs to be changed to the newly set command value.

2. At present, the controller supports address sites: 1, 2, 4, 8; other sites are not yet open, please note!