



M

100

M	M100 M200 M300 M500 M500S	-
-		2025-08-4

M	Sysctrl Studio 2.4 M100 M200 M300 M500 M500S HCMXB-CAN-BD HCMXB-RTC-BD HCMXB-2RS232-BD HCMXB-2RS485-BD	M
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2025-8-4	V1.0		
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1.

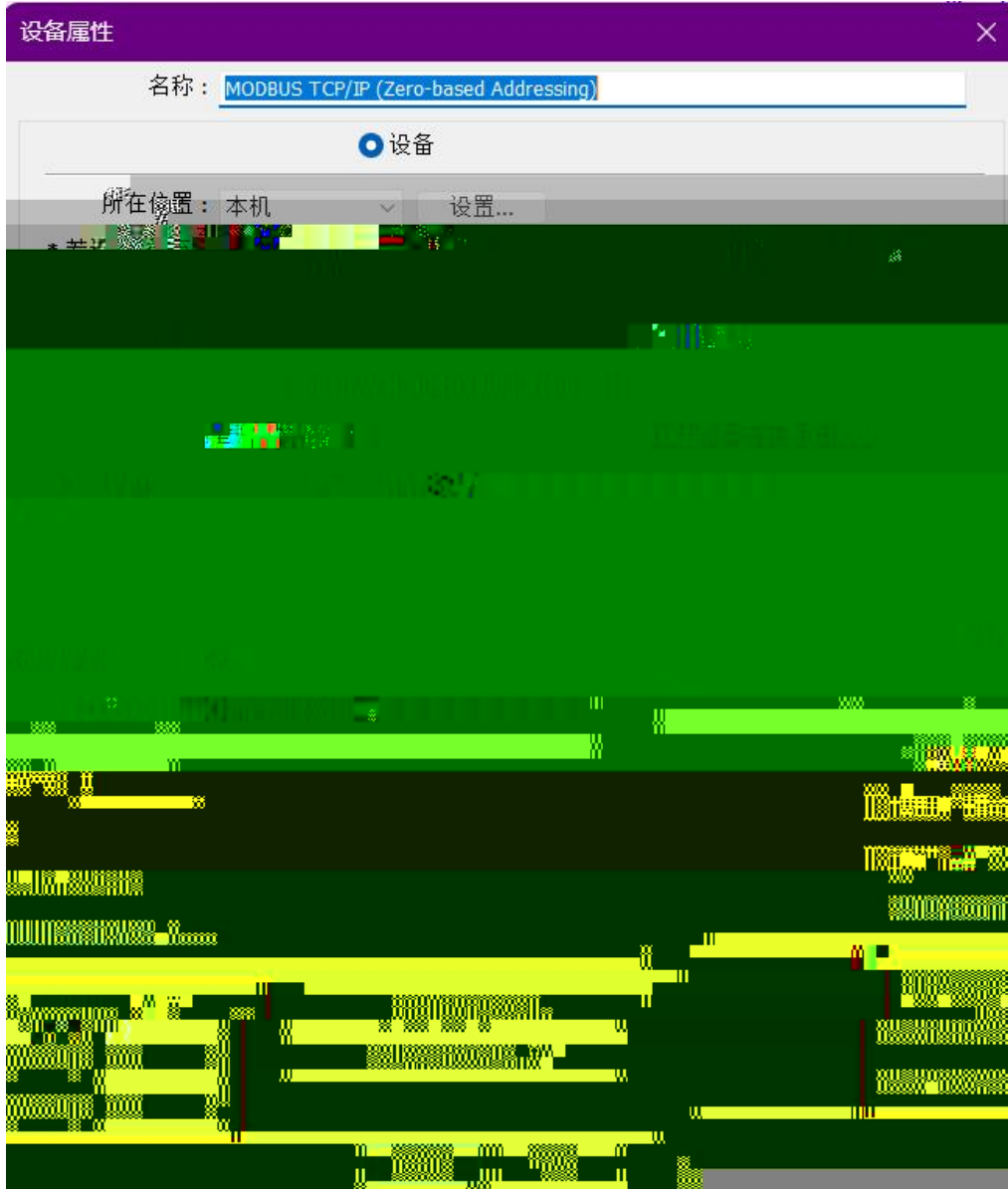
100

104 WORD PLC

100WORD

/

100word



2.

RS485

?

ModbusRTU

06

10

10

3.

ASCII

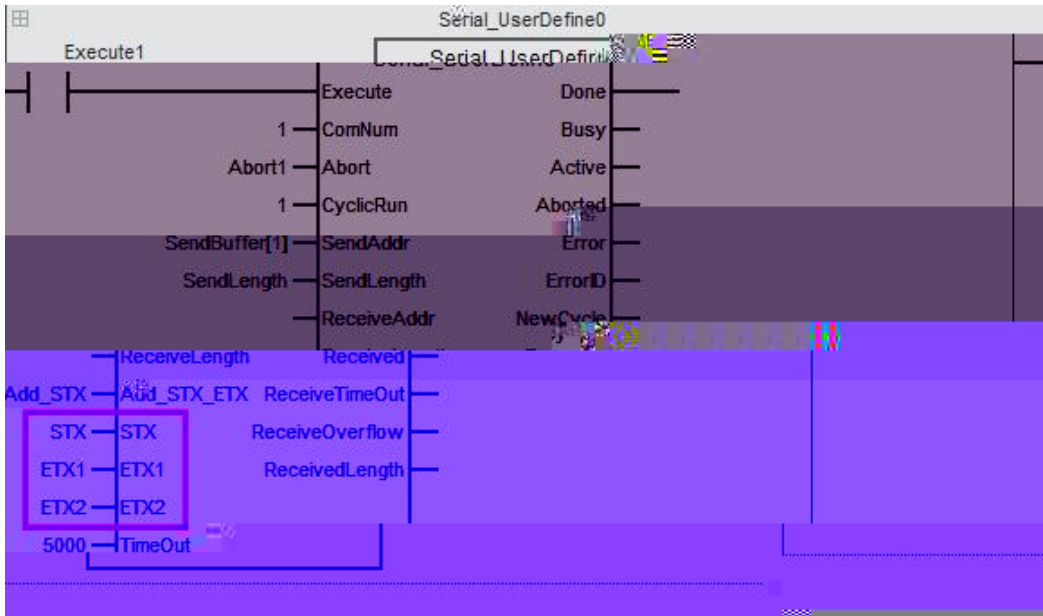
RTU

RTU

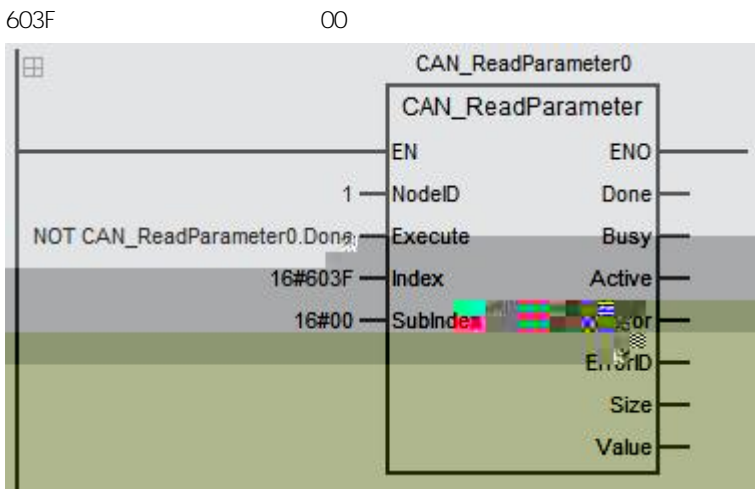
ASCII

M

-



4. E610 CAN 603F

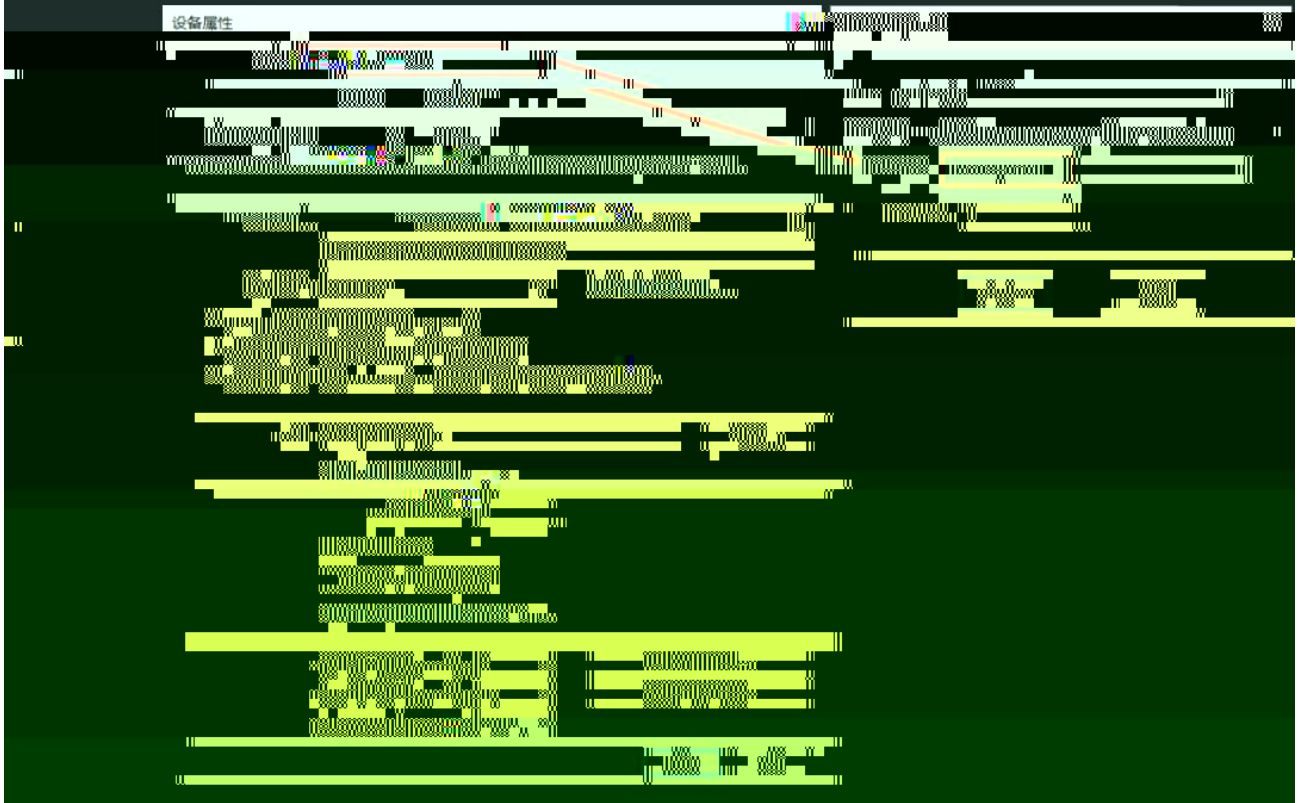


5. RS485

地址	名称	触发方式	执行方式	读写类型	功能码	主站地址	从站地址	数量
1000		默认触发	循环	读寄存器	默认	%MW1000	16#0001	1
10000		默认触发	循环	写寄存器	默认	%MW10000	16#6001	1

6. M HMI

(1) 名称需要和【生成HMI符号表】-【连接路径】命名一致。

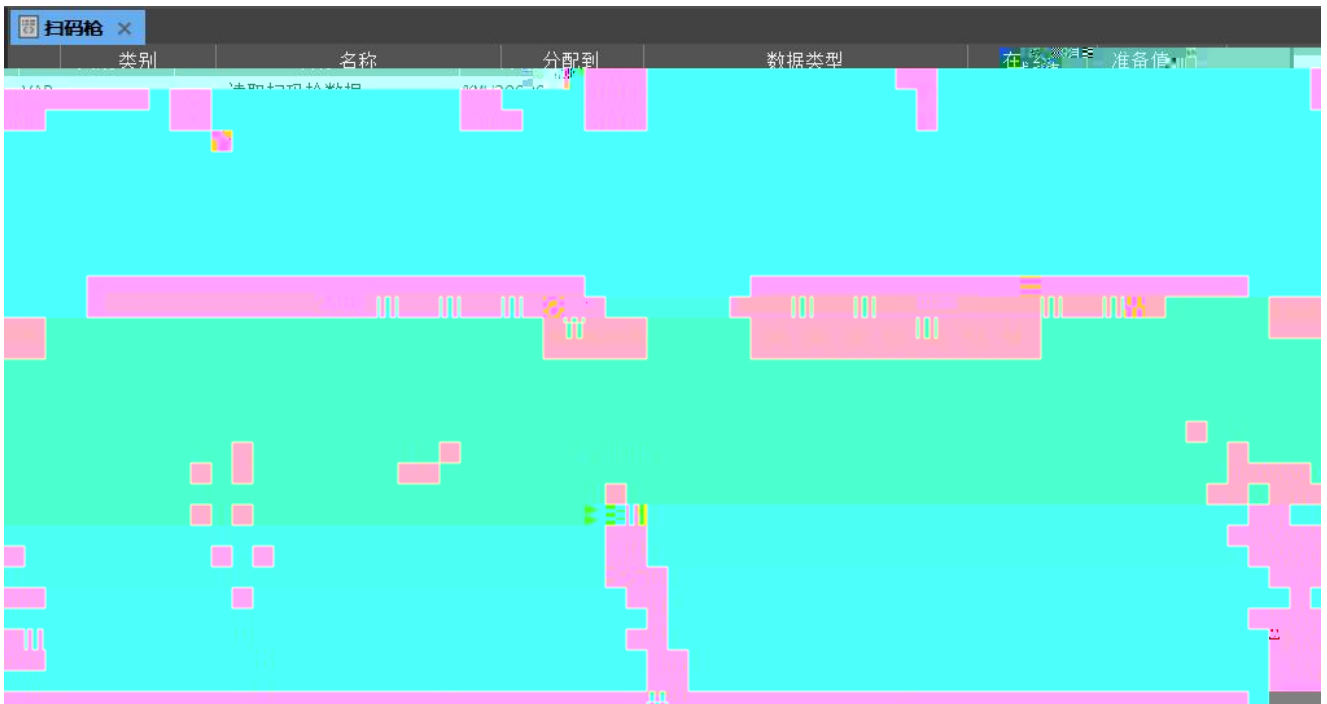


7. TCP 502 5020

socket 5020 TCP

8. ModbusTCP

TCP 6 ASCII ACK 0 ASCII  
0 ASCII 0



9. tcket

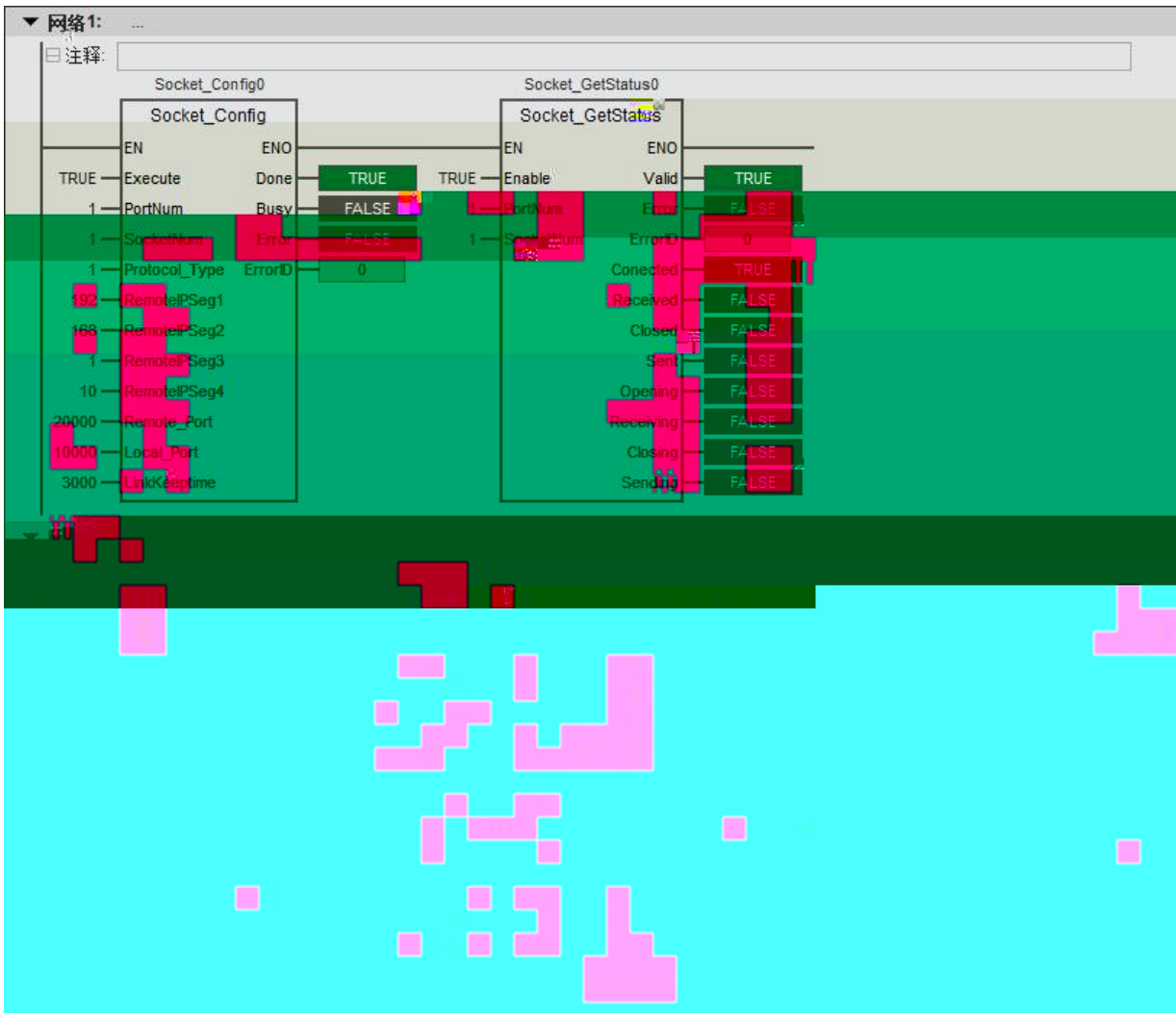
G

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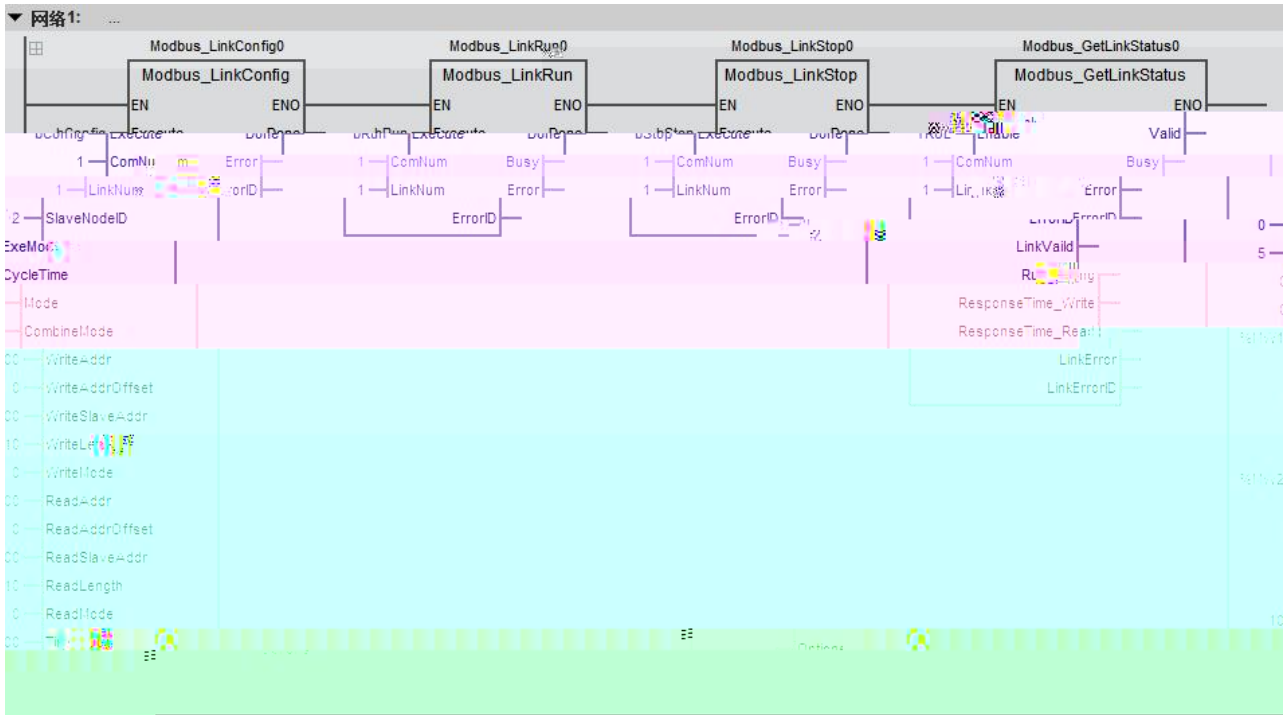


10.

485

LINKCONFIG

1-Modbus\_LinkConfig 2-Modbus\_LinkRun 3-Modbus\_GetLinkStatus 4- 5-Modbus\_LinkStop



11. E600

1.

类别	名称	分配到	数据类型	在线值
1	VAR	AA	ARRAY [1..7] OF REAL	
2	VAR	AA[1]	REAL	24675
3	VAR	AA[2]	REAL	24675
4	VAR	AA[3]	REAL	24675
5	VAR	AA[4]	REAL	24675
6	VAR	AA[5]	REAL	24675
7	VAR	AA[6]	REAL	24675
8	VAR	AA[7]	REAL	24675
9	VAR	BBB	BOOL	FALSE

```

for I := 1 to 7 DO
    ...
END_FOR
    
```

2.

```

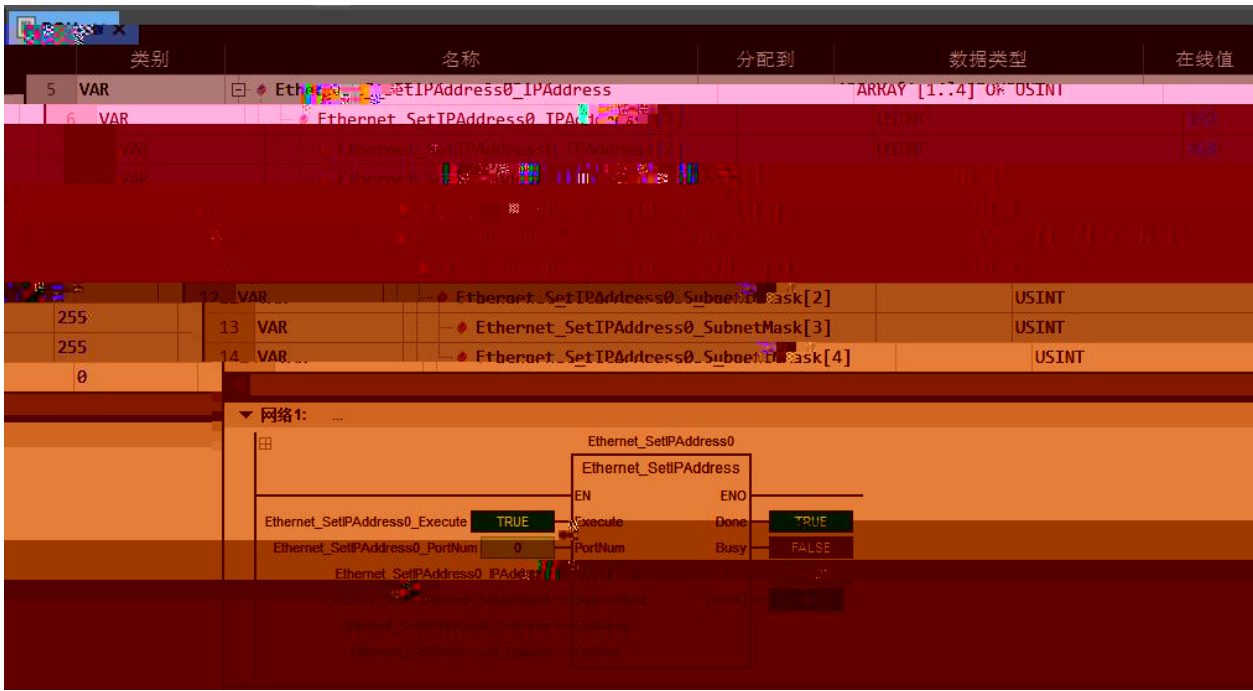
9 VAR 测试 BOOL
10 VAR 转盘故障 BOOL
11 VAR edge_back_val1 BOOL

18 FOR I := 1 TO 7 DO
19   St_RealAxis[I].IN.ib_轴复位 := Axis[I].AxState = 2 AND HMI_故障复位;
20 END_FOR;
21 //-----警告手动不停机101-150
22 //Err101-----缺料警告
23 //缺料提示延时(IN:=(Gby_整机状态字=自动) AND NOT DI_纸堆检测 AND DO_吸纸允许,PT:=REAL_TO_TIME(hmi缺料提示延时*))
24 //警告触发[51](Set:=ton缺料提示延时Q,Reset:=HMI_故障复位,Q=>HMI_故障报警[151]);
25 //Err015-----废纸道报警,废品当断于信号
    
```

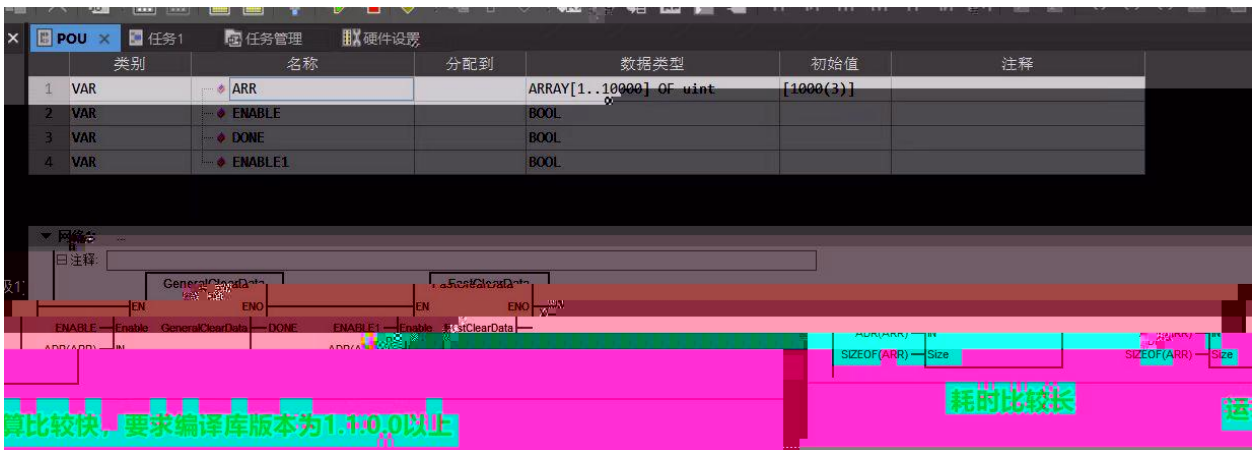
3.

EXT\_GetModuleStatus





8.



9.

Time to DINT

DINT

6



类别	名称	分配到	数据类型	在线值
1	VAR	bStart	BOOL	TRUE
2	VAR	edge_back_val	BOOL	FALSE
3	VAR	AA	INT	1122
4	VAR	Int_1	ARRAY [0..1] OF BYTE	
5	VAR	Byt	USINT	98
6	VAR	Byt[0]	USINT	4
7	VAR	Byt[1]	USINT	98
8	VAR	AA	INT	25092
9	VAR	Byt	ARRAY [0..1] OF BYTE	
10	VAR	Byt[0]	USINT	4
11	VAR	Byt[1]	USINT	98

15. TIME

TIME modbus

16.

80+1 1 modbus

名称	数据类型	初始值	注释
1	STRUCT		
2	STRING		
3	STRING		
4	STRING		
5	STRING		
6	STRING		

名称	数据类型	初始值	注释
TTT	STRUCT		
AA	STRING[79]		
BB	STRING[79]		
CC	STRING[79]		
DD	STRING[79]		
EE	STRING[79]		

17. ID ID

ID PLC

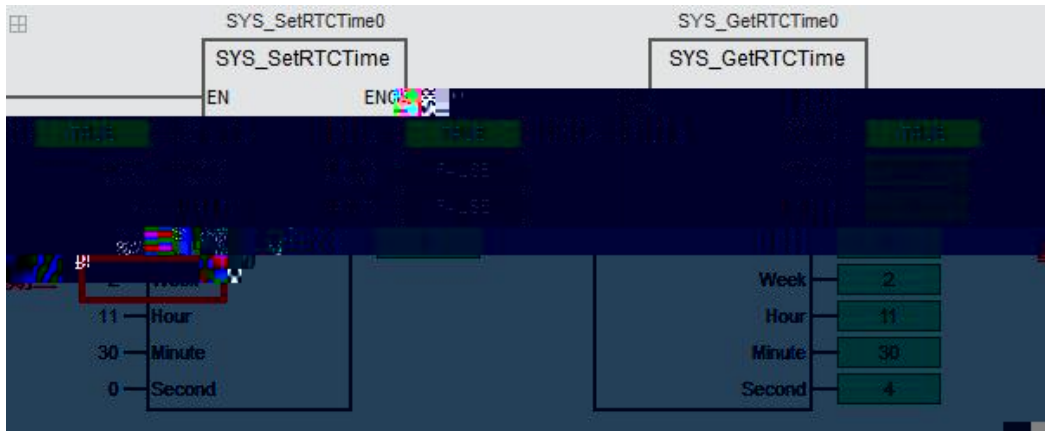
18. M RTC

Sysctrl Studio 2.4.0.1705 SYS\_SetRTCTime M100 M200 M300 M500

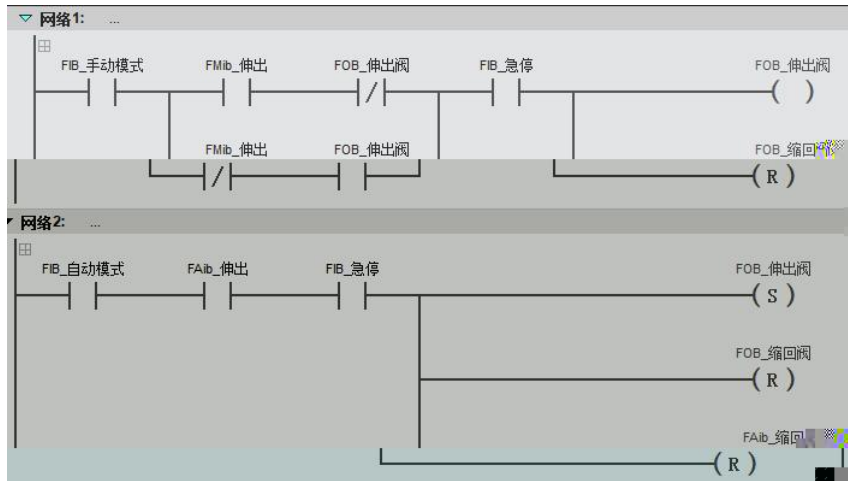
M500S

19. RTC 16690

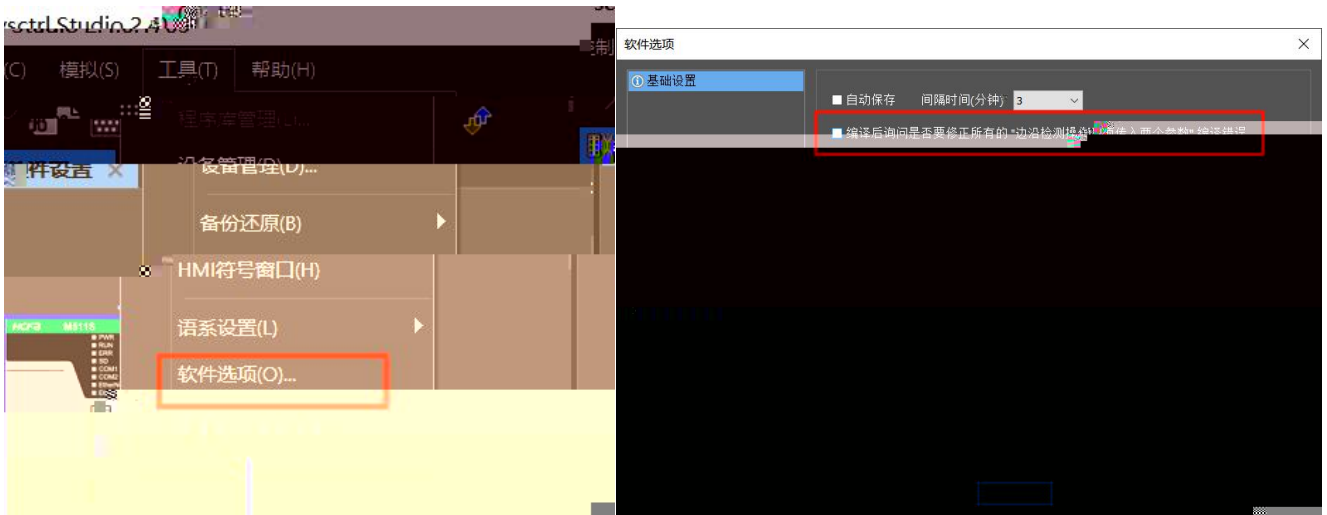
week 1-7



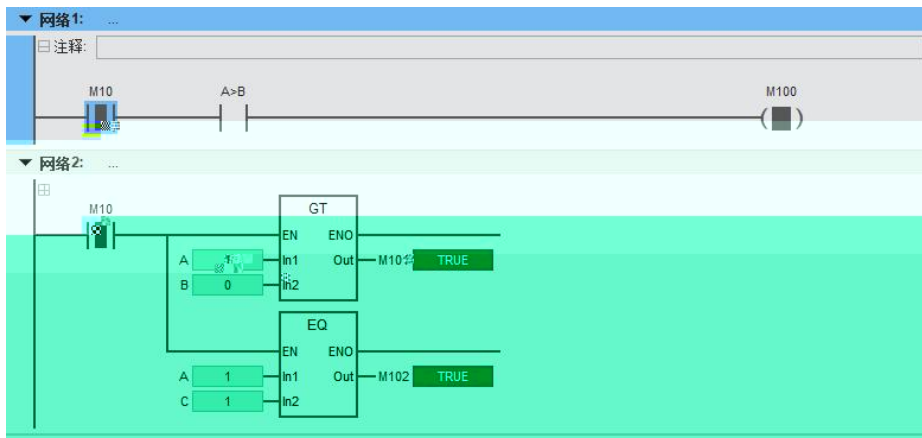
20.



21.

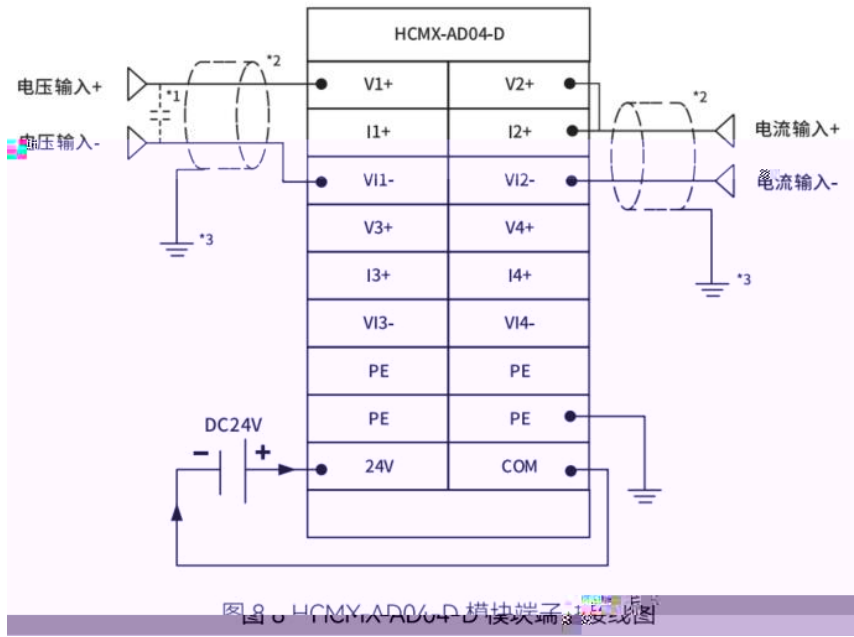


22.



23.

V+ I+



24. IF

Sysctrl Studio 2.4.1705 -

**FB\_Test**

类别	名称	分配到	数据类型
1 VAR_INPUT	reData		REFERENCE TO REAL
2 VAR_INPUT	reST		REFERENCE TO Test

```

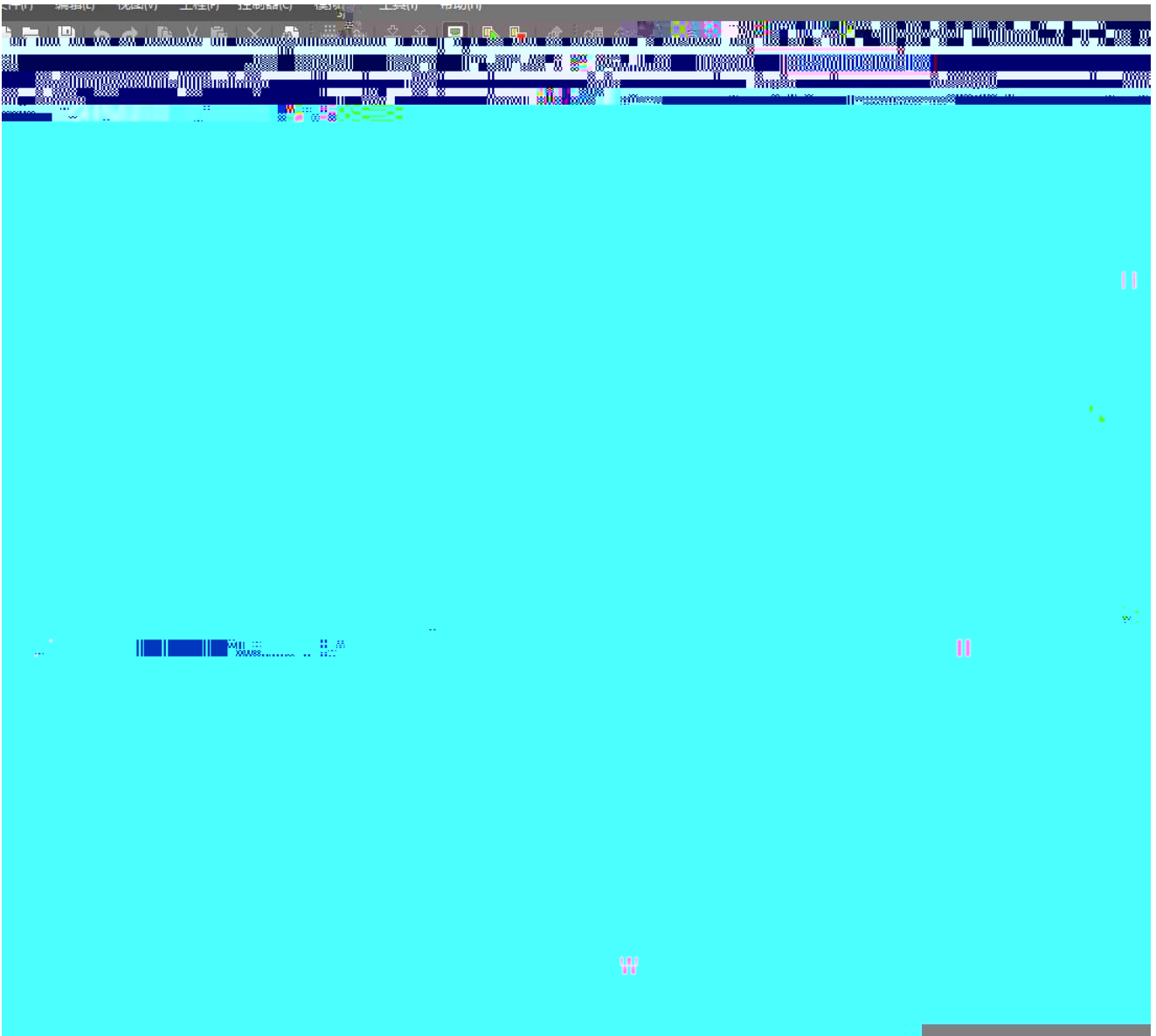
1
2 reData:=reData+1;
3
4 reST.Output:=reST.Input;
5
                
```

**POU**

类别	名称	分配到	数据类型
1 VAR	FB_Test0		FB_Test
3 VAR	FB_Test0 reData		REAL
VAR	FB_Test0 reST		Test

1. MC\_Setposition

MC\_Setposition

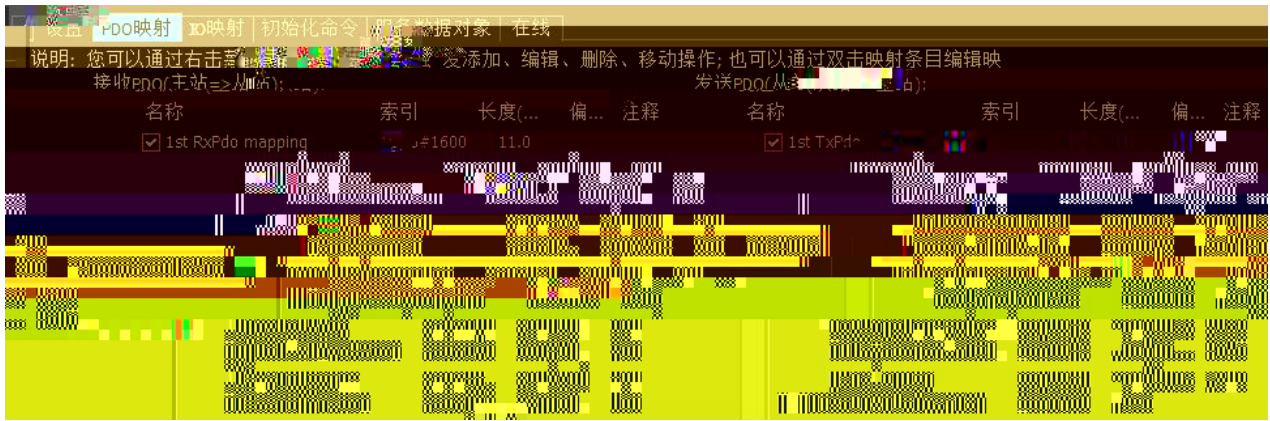


2. 6064 PLC

				6064		
1:400	23	1	8388608	230.4mm	6064	
	PLC	6064				
	23	+Y7S				
M			100000 Y7S	Pn78C	8388608	Pn78E 100000

3. M511S M511

M500	PLC	PDO	XML
PDO 6077	6071		



MC\_TorqueControlWithVelocity 6080 6080 0 0 10000



4.

M



5.

200

50-80

MC\_TorqueControl

InTorque

Axis[]:ActTrq

6.

MC\_HomeByPLCIO

7.

On

8.

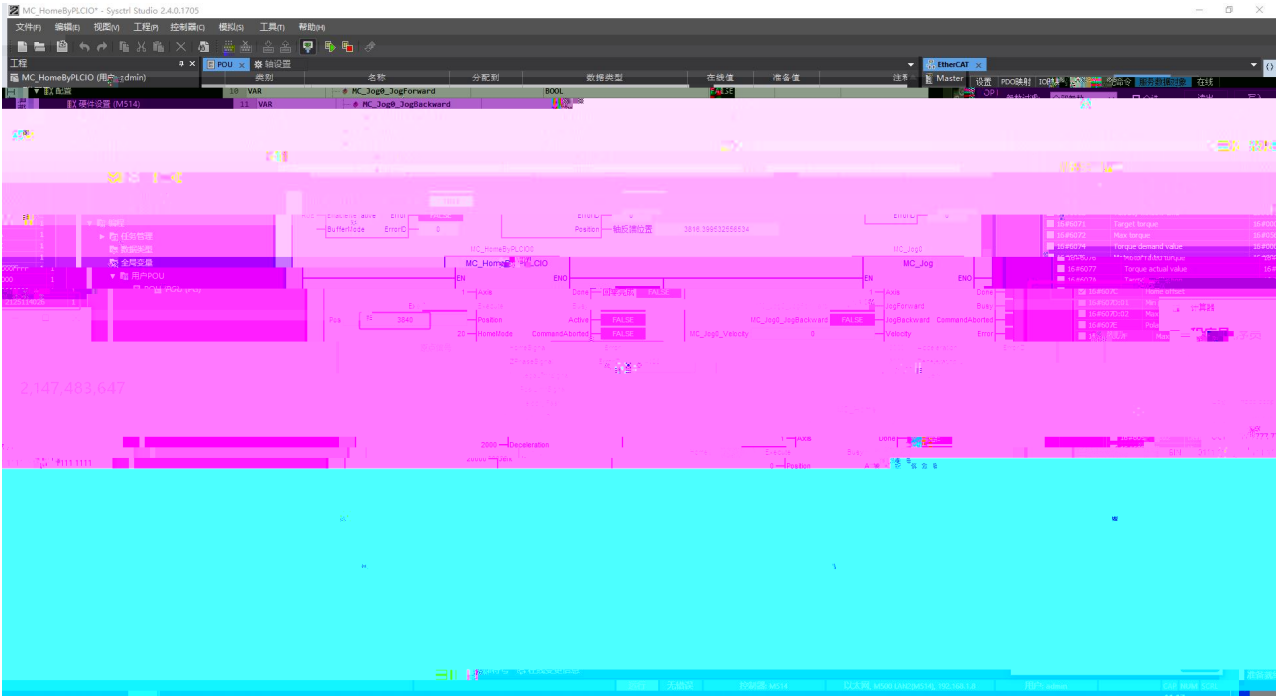
Jerk

Jerk

MC\_StopAtPhase

9. MC Stop MC\_MoveContinuousVelocity 5377  
 MC\_MoveContinuousVelocity stopping

10. MC\_HomeByPLCIO 20 4105 3839  
 8388608 1:10 150 3839  
 $3839/150 * 10 * 8388608 = 2146924407$  607C 2,147,487,744



11. 4612  
 50 0 50 0 0  
 0 MC\_Setposition 0

12. XY 20 4618



13. MC\_HomeByPLCIO homing

PDO 6060 PDO 6060 6061 6040 6041 607A 6064

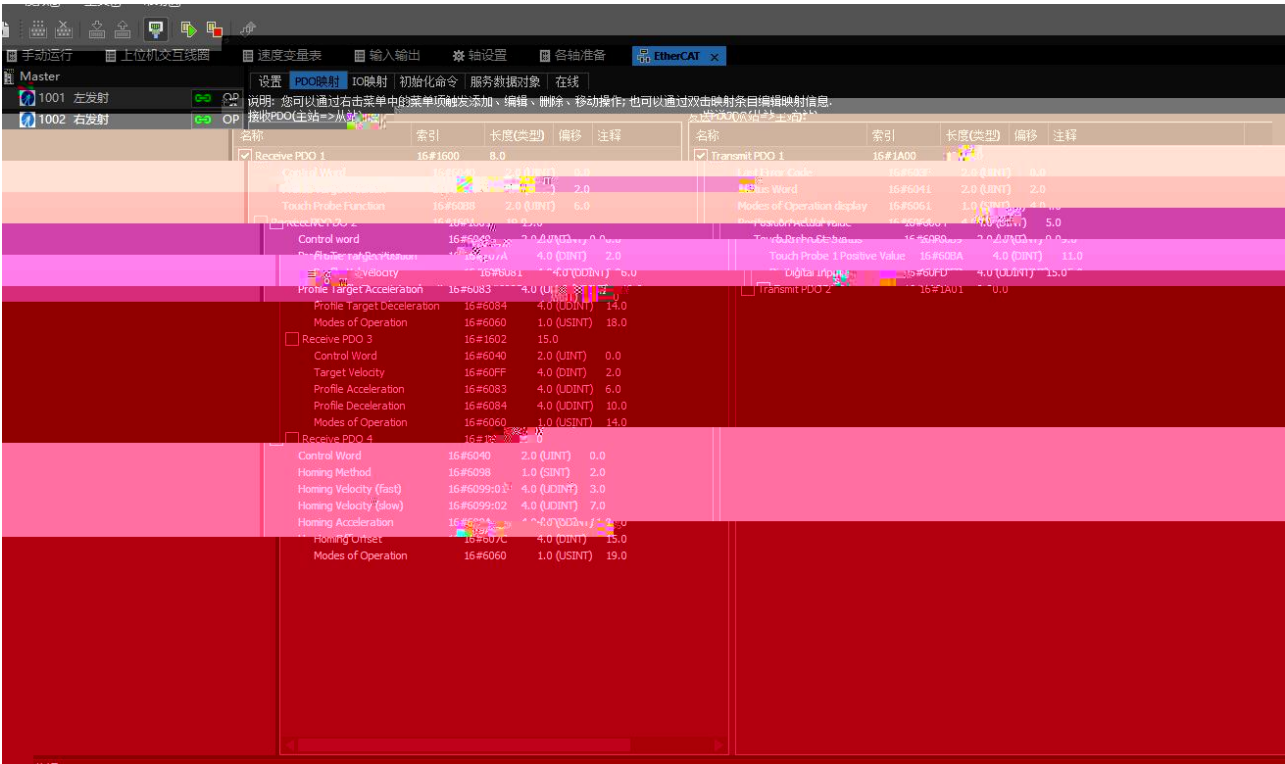
14.

Jerk JerkLimit 1E30



15. M512 op

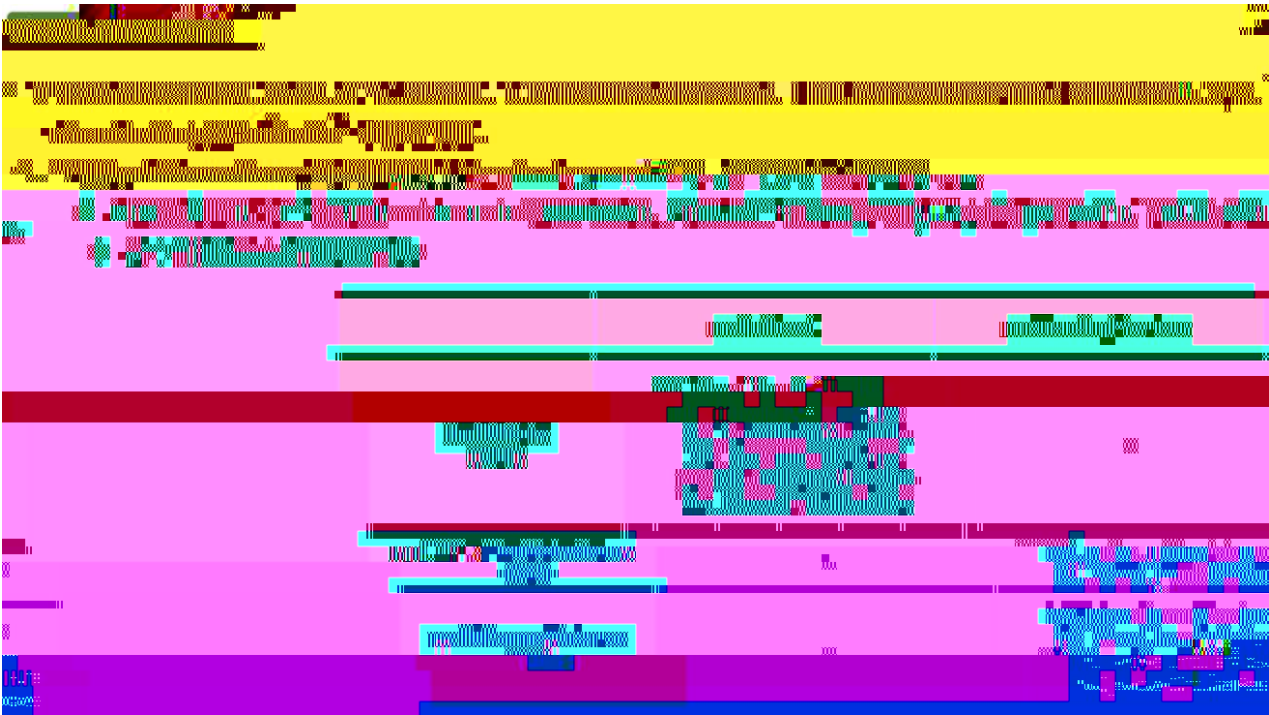
pdo pdo



16. DI

ECAT\_ReadParameter DI SDO





25.

6080

26.

JERK

1000

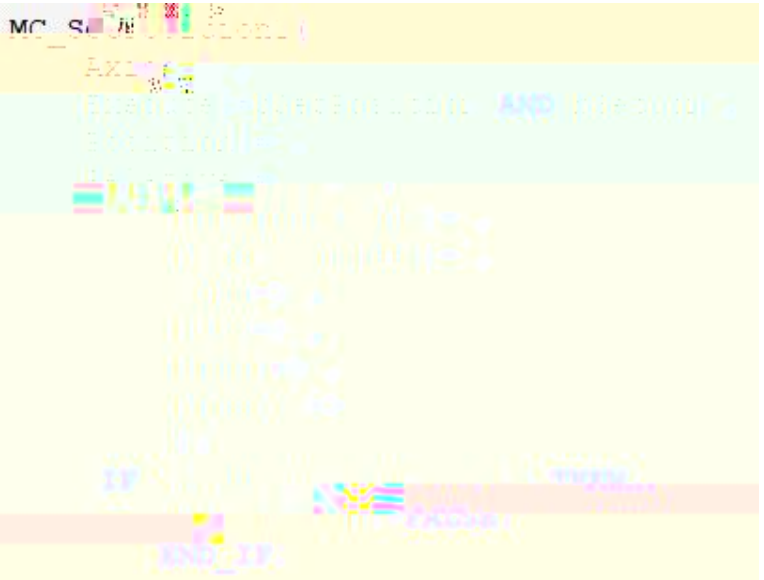
27. MC\_SetPosition

IF

```

IF bSetCon THEN
  MC_SetPosition1(
    Axis:=1 ,
    Execute:=bSetCon
  ,
    Position:= ,
    Relative:= ,
    ReferenceType:= ,
    ExecutionMode:= ,
    Done=> ,
    Busy=> ,
    Error=> ,
    ErrorID=>
  );
END_IF;
IF MC_SetPosition1.Done THEN
  bSetCon:=FALSE;

```



28.

MC\_SetPosition 0

Axis[].cmdPos 0

MC\_SetPosition MC\_ReadActualPosition

29.

AXIS[1].CMDPOS



31. M511 Y7S

10000 / plc 10000 / plc



32. M512

M500 PDO PDO 16#606C M



33. Z

Z Axis[1].CmdPos

34.

$1,000 \times 1 \div 69 \times 131,072 = 1,899,594.2028985$  200Khz

1000

35.

+SetPosition MC\_SetOverride 0

36.

4107

# B

37. buffermode 1 3 0

38. MC\_EncodeCompare M100 M200 M300 M500S  
 MC\_home 30 4105  
 30\*10\*8388608=2,516,582,400 607C

39. SV730W 4866  
 730W XML 6080 16#607F

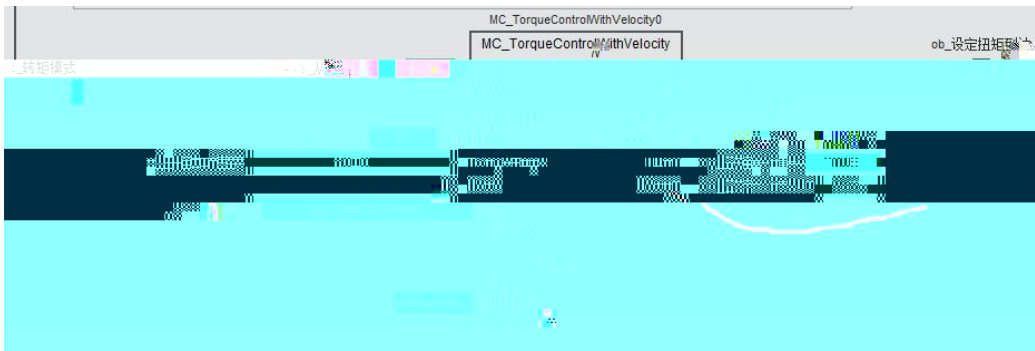
40. MC\_TorqueControlwithVelocity 4865

SDO PDO

1) 1ms SDO

2) SDO SDO

SDO SDO



41. MC\_SetCamPoint

MC\_GetCamPoint

42. 0

MC\_CAMIN MasterValueSource

1 1

43. CAM

44. 1:1

1 AB camin



1. —RUN

ERR

2. —

IP

STOP

3. —

Sysctrl Studio

4. —

PLC 0.0

5. M :

Sysctrl Studio

6. — M512

500

500

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