



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					
2025-8-4		V1.0			

		1
1.	100	1
2.	RS485 ?	1
3.	ASCII RTU	1
4.	E610 CAN 603F	2
5.	RS485	2
6.		2
7.	TCP 502 5020	3
8.	Modbus TCP	3
9.	Socket	4
10.	485	5
11.	E600 485	6
12.		6
13.	ModbusTCP M	6
14.		6
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2.		7
3.		7
4.		8
5.	Q	8

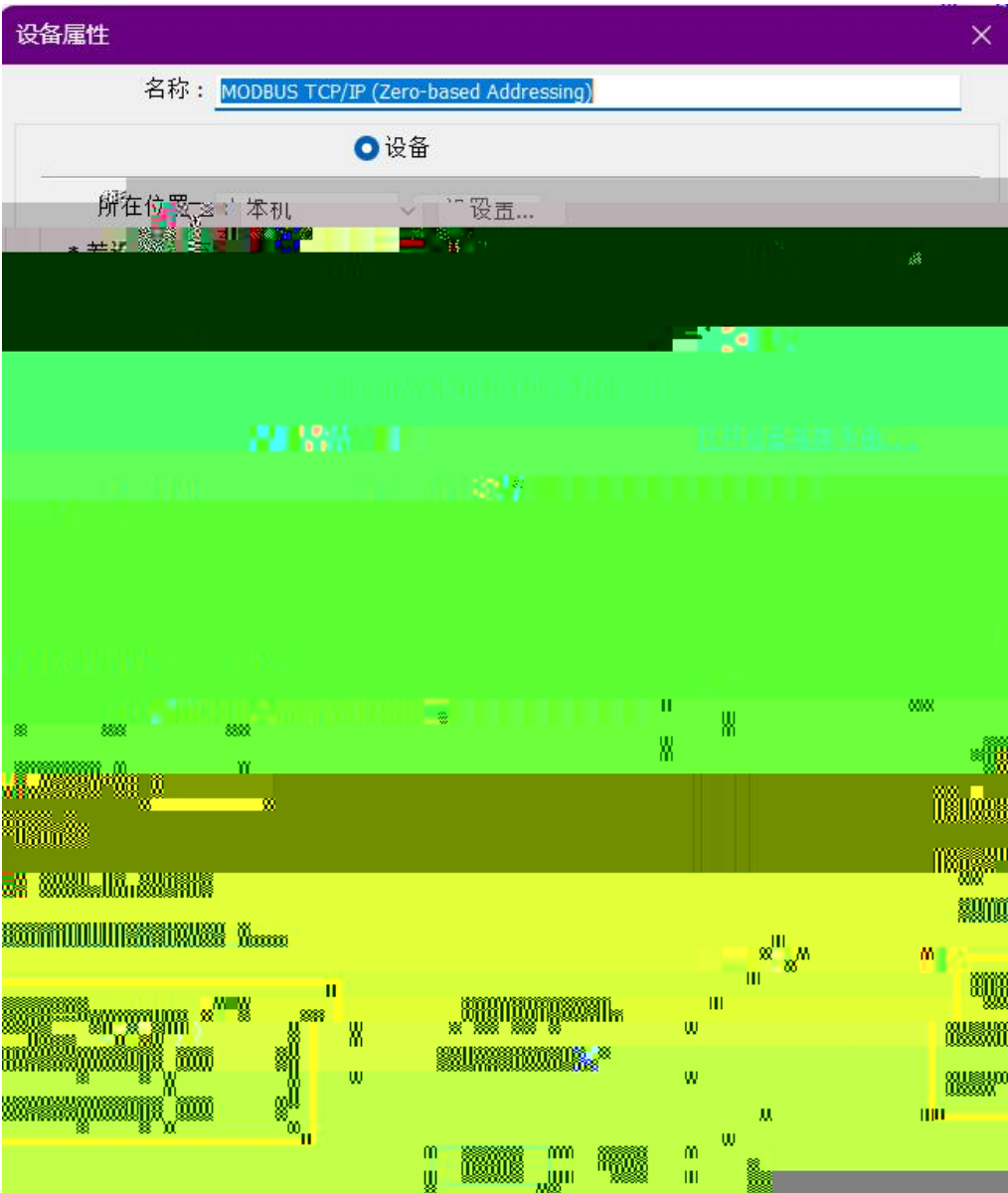
6.	M511S	M511	2104		8
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20.	16#2151		20
21.			20
22.			20
23. M511S	M511	4116	20

1.

104 WORD PLC 100WORD /

100word



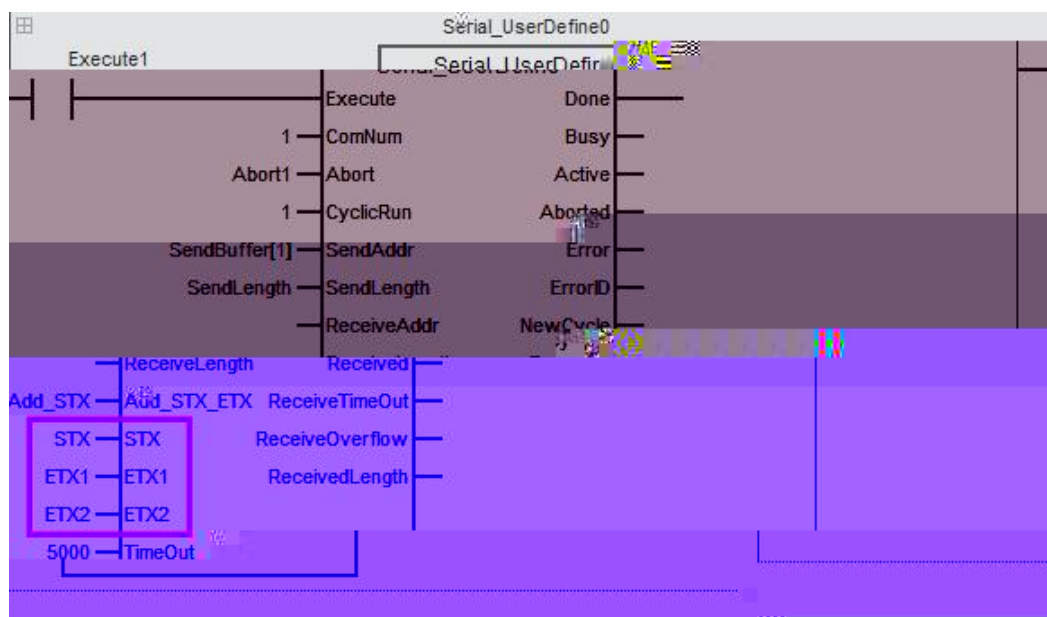
2.

RS485 ? ModbusRTU

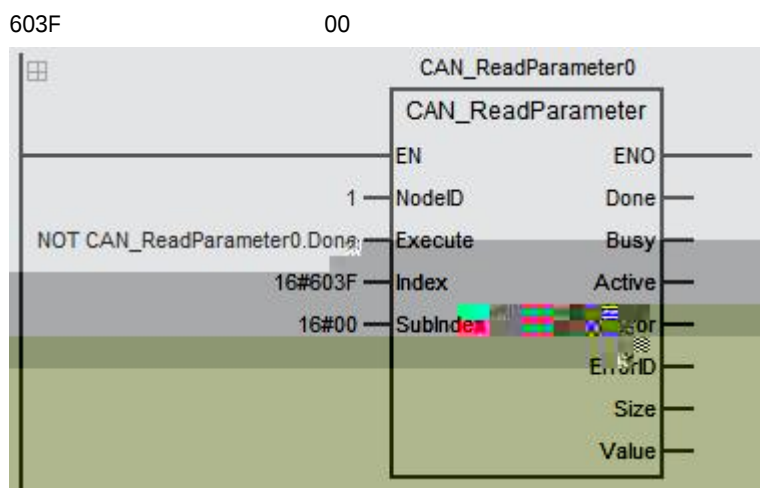
06 10 10

3.

RTU ASCII RTU M -



4. E610 CAN 603F



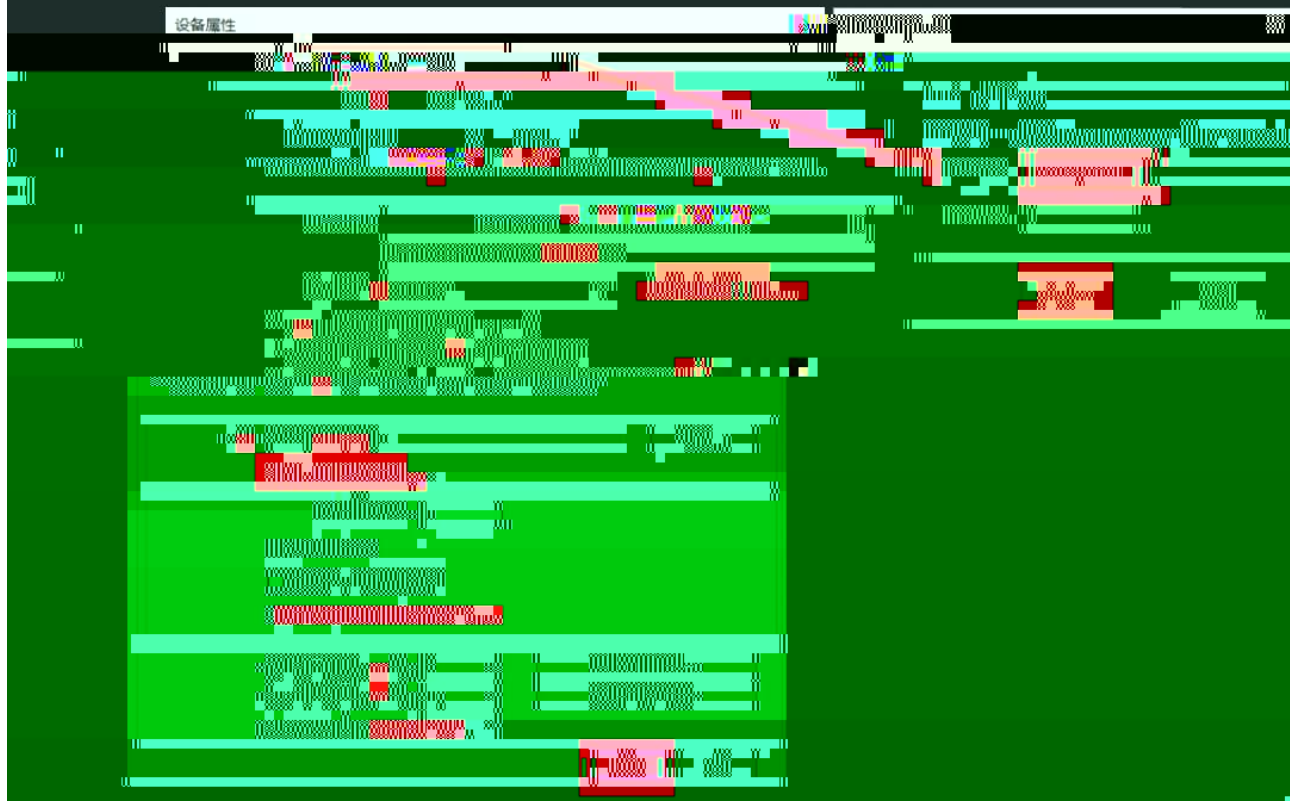
5. RS485

地址	数据类型	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	Bool	默认触发	循环	读寄存器	默认	%MW1000	16#0001	1
10000	Bool	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。

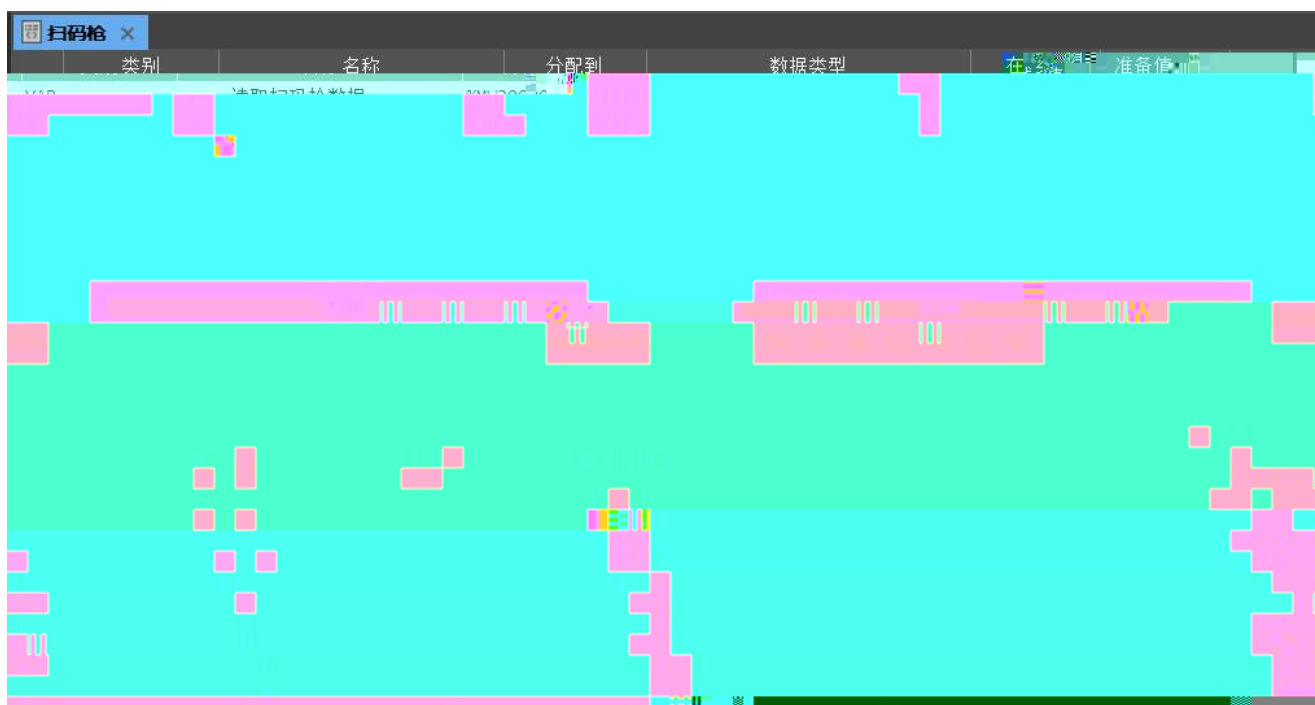


7. TCP 502 5020

socket 5020 TCP

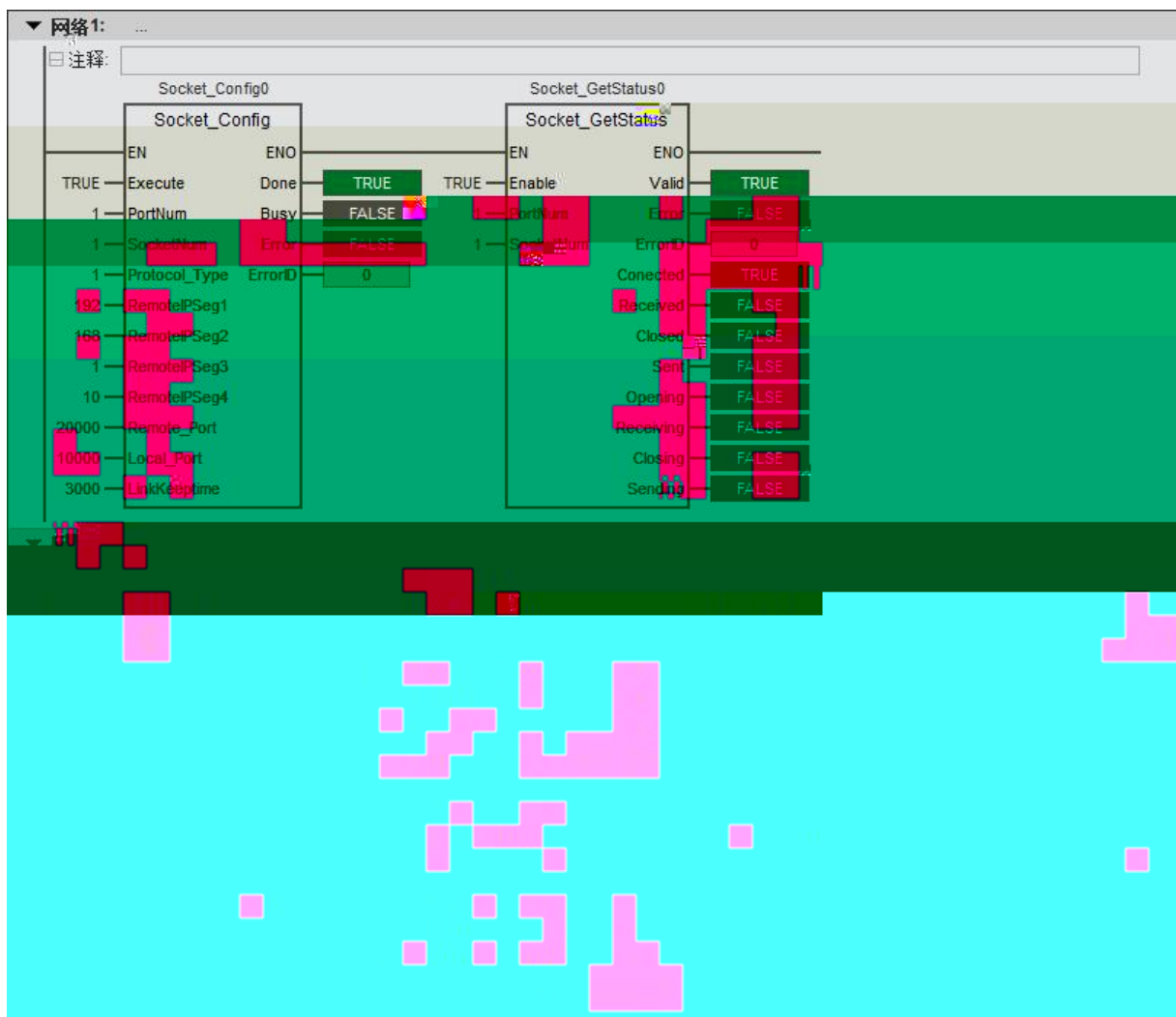
8. Modbus TCP

TCP 6 ASCII ACK 0 ASCII
0 ASCII 0



9. ket

G
O O
O O



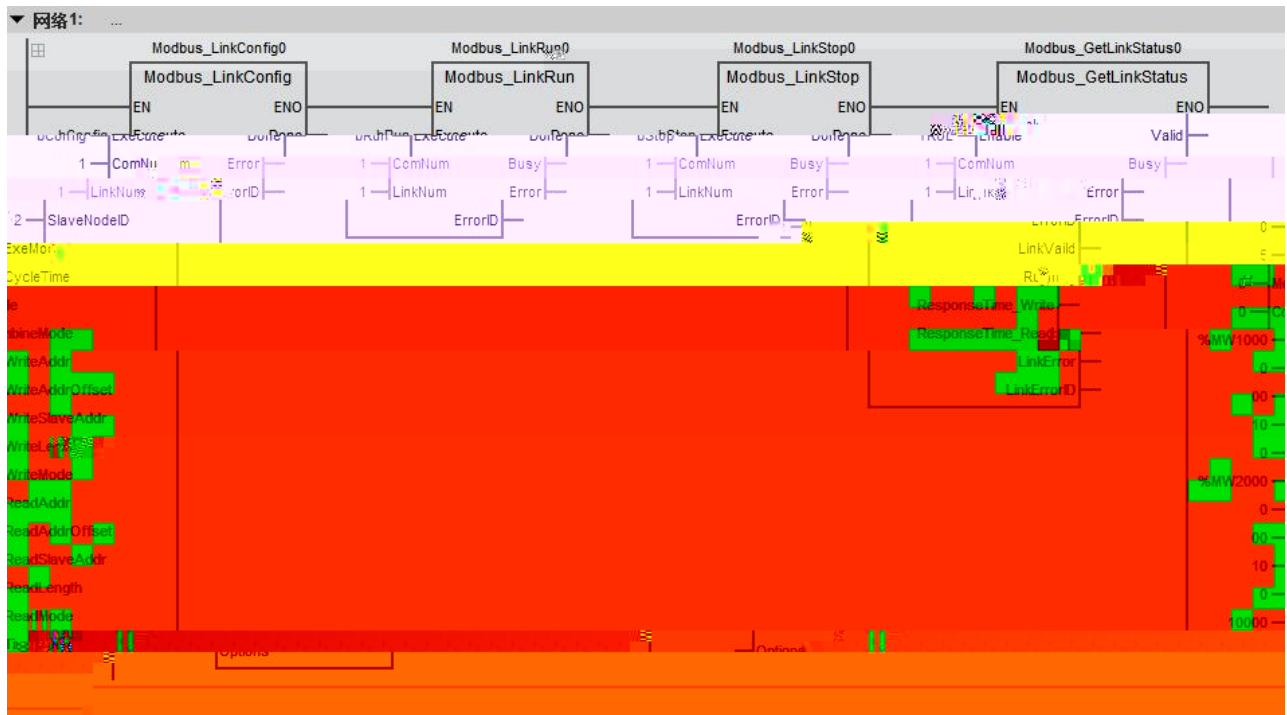
10.

485

LINKCONFIG

1-Modbus_LinkConfig 2-Modbus_LinkRun 3-Modbus_GetLinkStatus 4-

5-Modbus_LinkStop



11. E600

1.

POU					
	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
10					

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[5] (Set:=ton缺料提示延时.Q, Reset:=HMI_故障复位, Q:=HMI_故障报警[104] );

```

3.

EXT_GetModuleStatus



4.

PG

5.

Q



6.

M511S

M511

2104

CPU

类别	名称	分配到	数据类型	初始值
变量	nFeedPaperVel	REAL	送纸速度	
变量	nFeedPaperAcc	REAL	送纸加速度	
变量	nFeedPaperDec	REAL	送纸减速度	
变量	nFeedPaperPos	REAL	送纸位置	
变量	nFeedPaperVelLimit	REAL	送纸速度限制	
变量	nFeedPaperAccLimit	REAL	送纸加速度限制	
变量	nFeedPaperDecLimit	REAL	送纸减速度限制	
变量	nFeedPaperPosLimit	REAL	送纸位置限制	
变量	nFeedPaperVelLimitH	REAL	送纸速度限制高	
变量	nFeedPaperAccLimitH	REAL	送纸加速度限制高	
变量	nFeedPaperDecLimitH	REAL	送纸减速度限制高	
变量	nFeedPaperPosLimitH	REAL	送纸位置限制高	
变量	nFeedPaperVelLimitL	REAL	送纸速度限制低	
变量	nFeedPaperAccLimitL	REAL	送纸加速度限制低	
变量	nFeedPaperDecLimitL	REAL	送纸减速度限制低	
变量	nFeedPaperPosLimitL	REAL	送纸位置限制低	
变量	nFeedPaperVelLimitH1	REAL	送纸速度限制高1	
变量	nFeedPaperAccLimitH1	REAL	送纸加速度限制高1	
变量	nFeedPaperDecLimitH1	REAL	送纸减速度限制高1	
变量	nFeedPaperPosLimitH1	REAL	送纸位置限制高1	
变量	nFeedPaperVelLimitL1	REAL	送纸速度限制低1	
变量	nFeedPaperAccLimitL1	REAL	送纸加速度限制低1	
变量	nFeedPaperDecLimitL1	REAL	送纸减速度限制低1	
变量	nFeedPaperPosLimitL1	REAL	送纸位置限制低1	

7.

IP

Ethernet_SetIPAddress

IP

[illegible]

8.

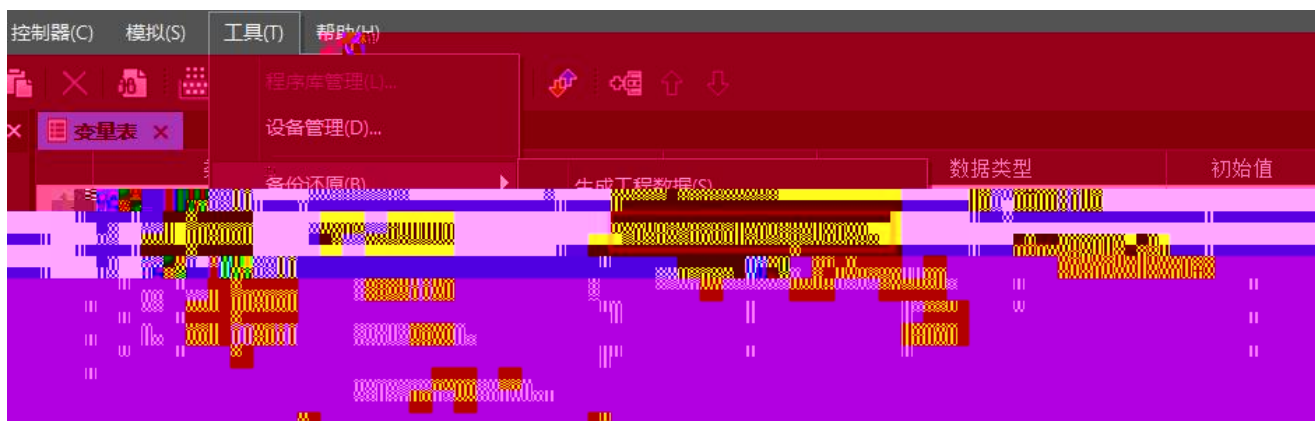
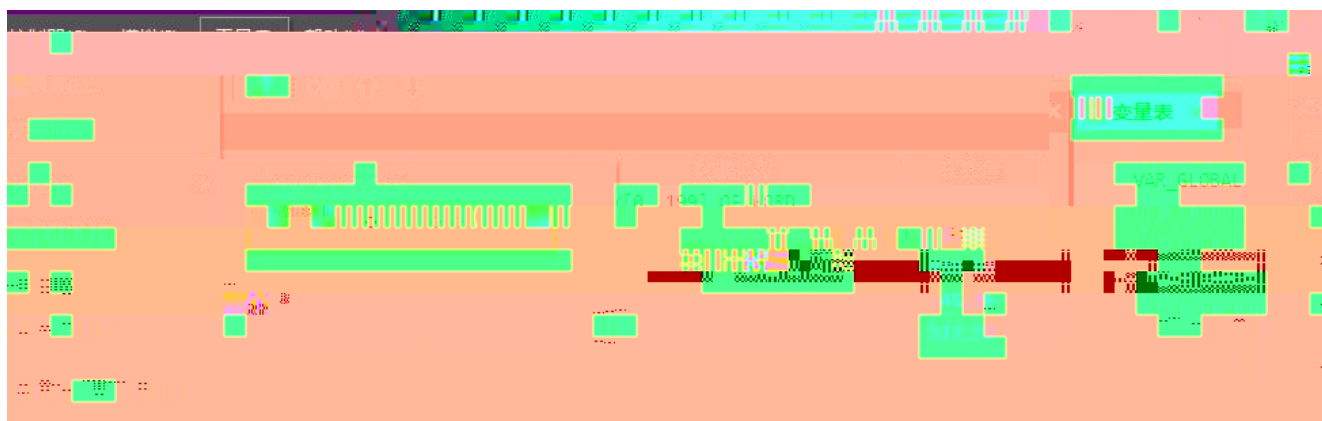
类别	名称	分配到	数据类型	初始值	注释
1	VAR	ARR	ARRAY[1..10000] OF uint	[1000(3)]	
2	VAR	ENABLE	BOOL		
3	VAR	DONE	BOOL		
4	VAR	ENABLE1	BOOL		

9.

Time to DINT

DINT

6



12. M514

13. 4-20ma 200 200 4-20ma 200

POU					
	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	Test_1		BOOL	
4	VAR	AA		INT	1122
5	VAR	Byt		ARRAY [0..1] OF BYTE	
6	VAR	Byt[0]		USINT	98
7	VAR	Byt[1]		USINT	4
8	VAR	Int_1		Test_1	
9	VAR	AA		INT	2509
10	VAR	Byt		ARRAY [0..1] OF BYTE	
11	VAR	Byt[0]		USINT	4
12	VAR	Byt[1]		USINT	98

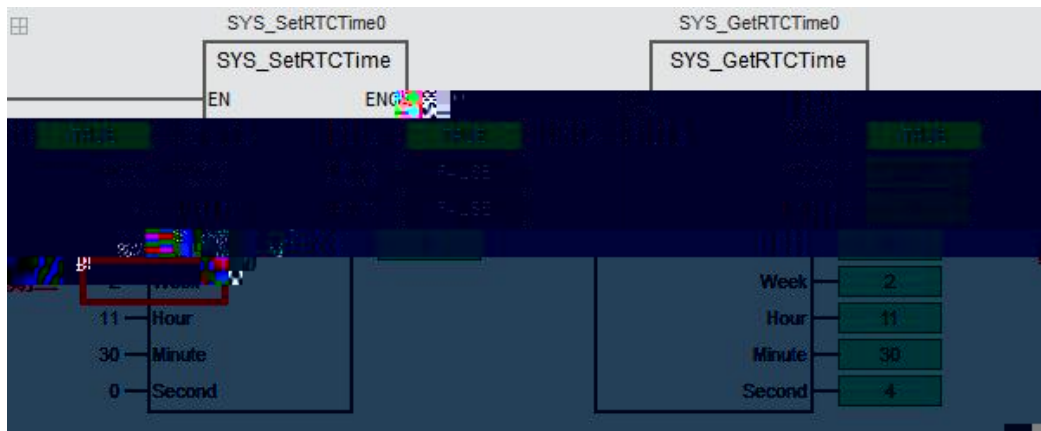
15. TIME modbus
16. TIME modbus

类型表				
	名称	数据类型	初始值	注释
1	TTT	STRUCT		
2	AA	STRING		
3	BB	STRING		
4	CC	STRING		
5	DD	STRING		
6	EE	STRING		

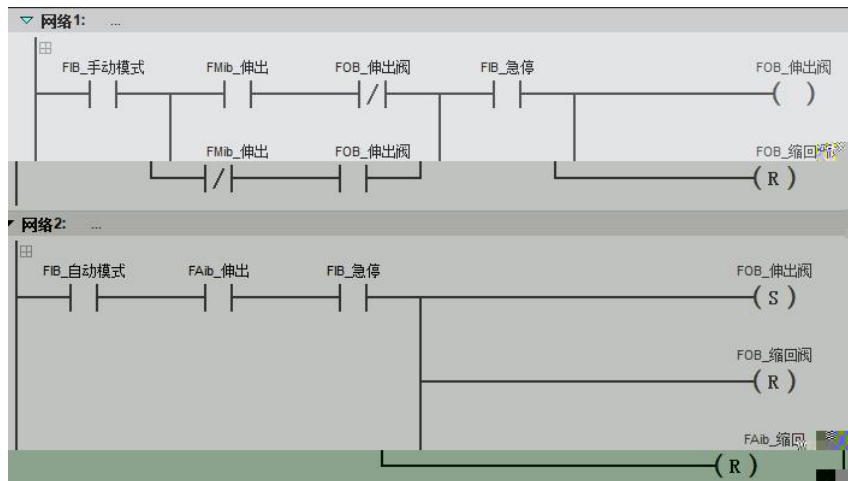
17. ID PLC

18. M RTC Sysctrl Studio 2.4.0.1705 SYS_SetRTCTime M100 M200 M300 M500 M500S

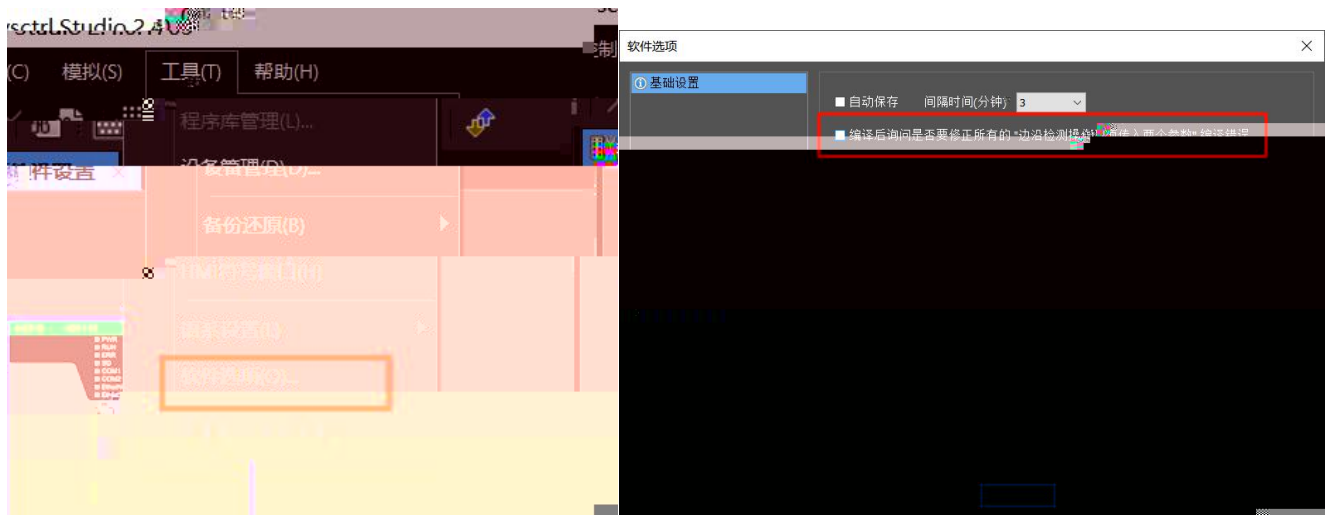
19. RTC 16690 week 1-7



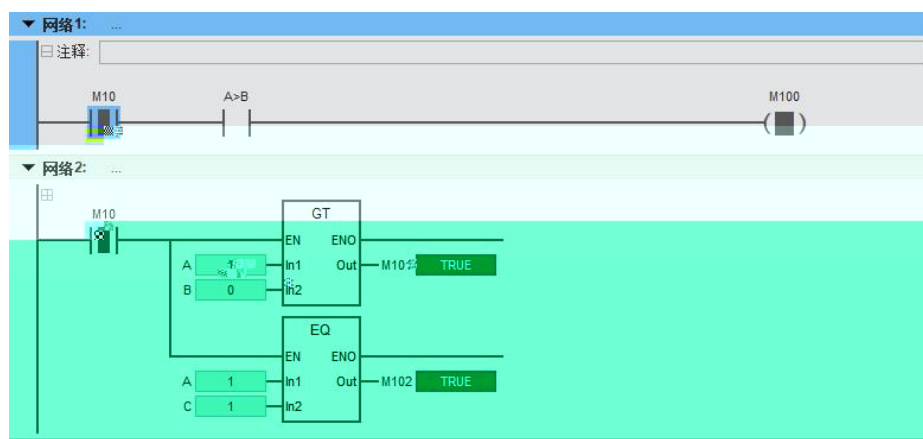
20.



21.

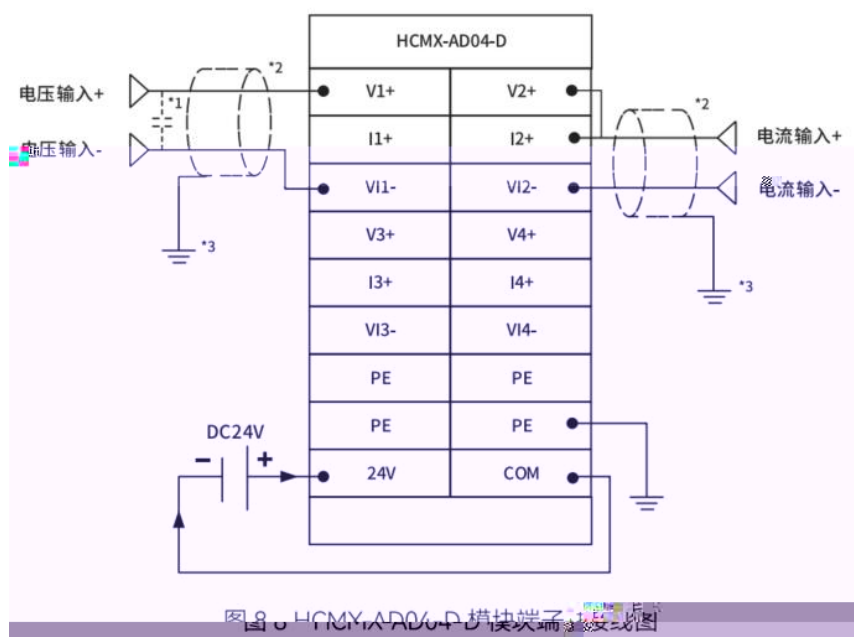


22.



23.

V+ I+



24. IF

Sysctrl Studio 2.4.1705 I17y

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

1.

MC_Setposition

MC_Setposition



2.

6064

PLC

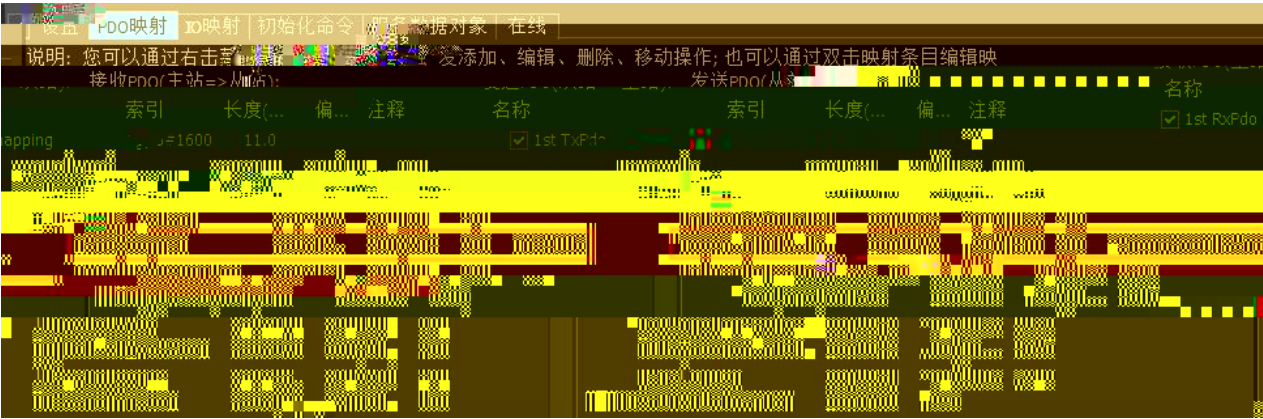
				6064				
1:400	23	1	8388608	230.4mm		6064		
PLC		6064						
23	+Y7S							
M			100000	Y7S	Pn78C	8388608	Pn78E	100000

3.

M511S

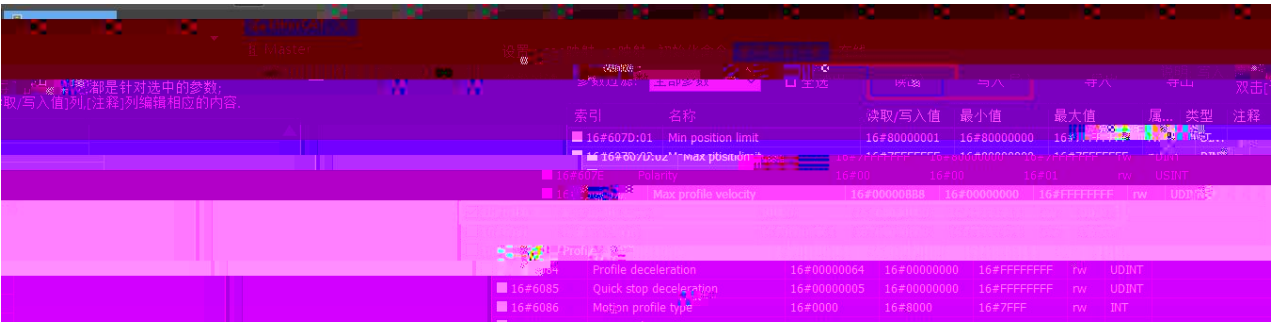
M511

M500	PLC	PDO	XML
PDO 6077	6071		

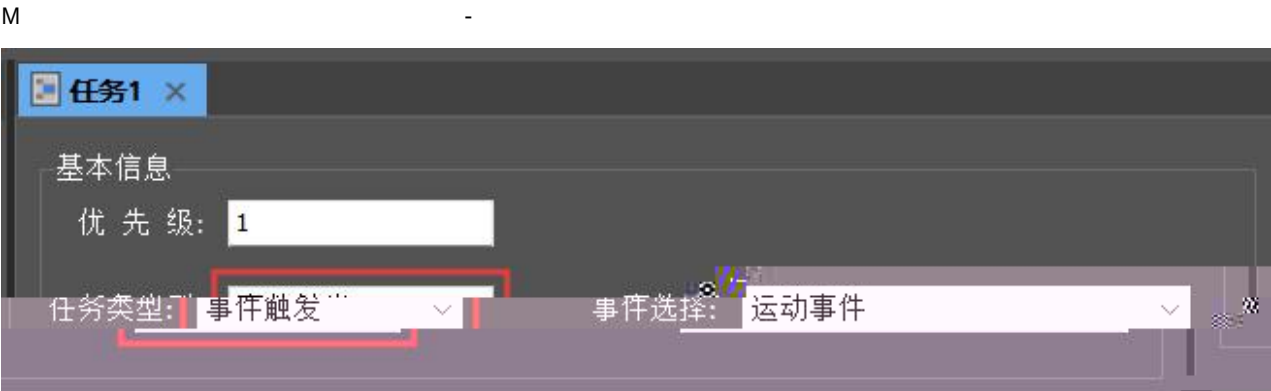


MC_TorqueControlWithVelocity 6080

6080 6080 6080 0 0 10000



4.



5.

200 50-80

MC_TorqueControl InTorque Axis[].ActTrq

6.

MC_HomeByPLCIO

On

7.

Jerk Jerk

8.

MC_StopAtPhase

9.

MC Stop

MC_MoveContinuousVelocity

5377

MC_MoveContinuousVelocity

stopping

10. MC_HomeByPLCIO

20

4105

8388608

1:10

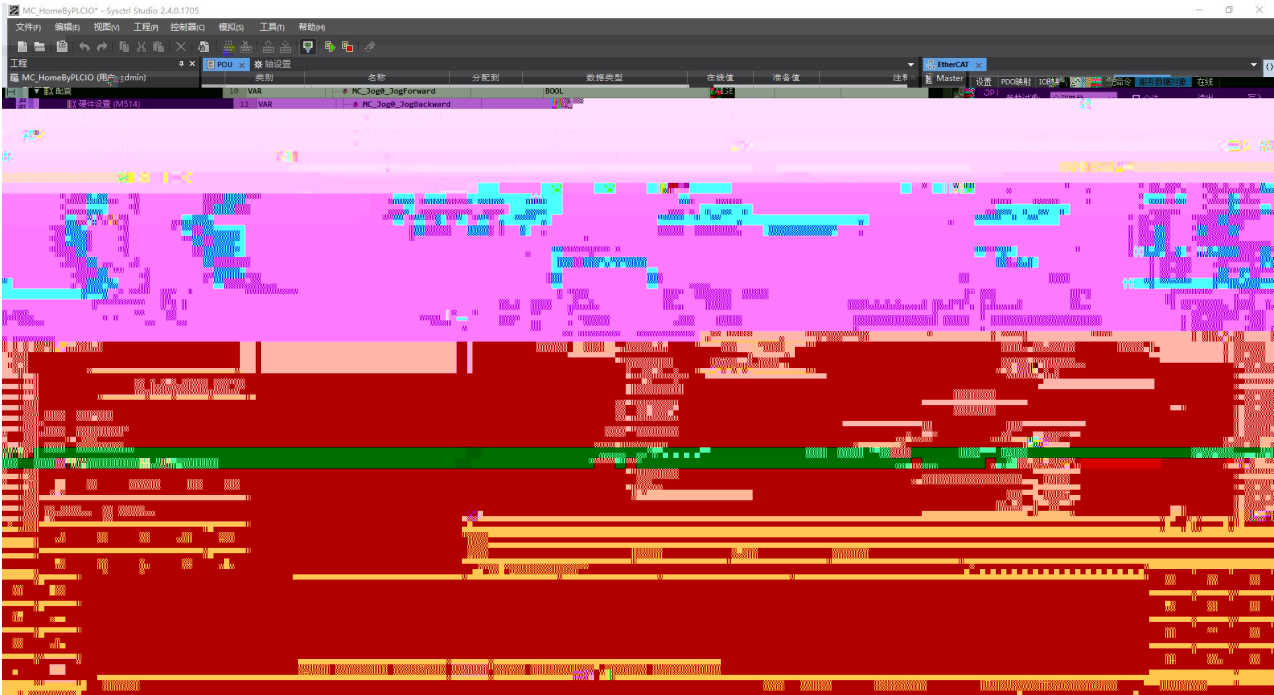
150

3839

$3839/150 \times 10 \times 8388608 = 2146924407$

607C

2,147,487,744



11.

50

0

50

0

0

0

0

MC_Setposition

0

12.

XY

20

4618



13.

MC_HomeByPLCIO

homing

PDO

6060

PDO

6060

6061

6040

6041

607A

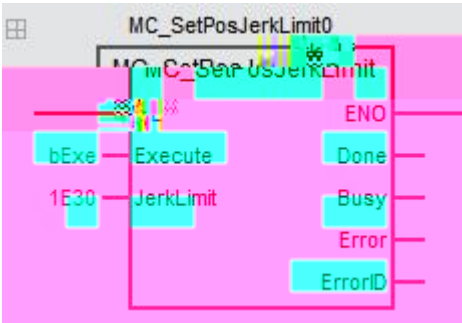
6064

14.

Jerk

JerkLimit

1E30

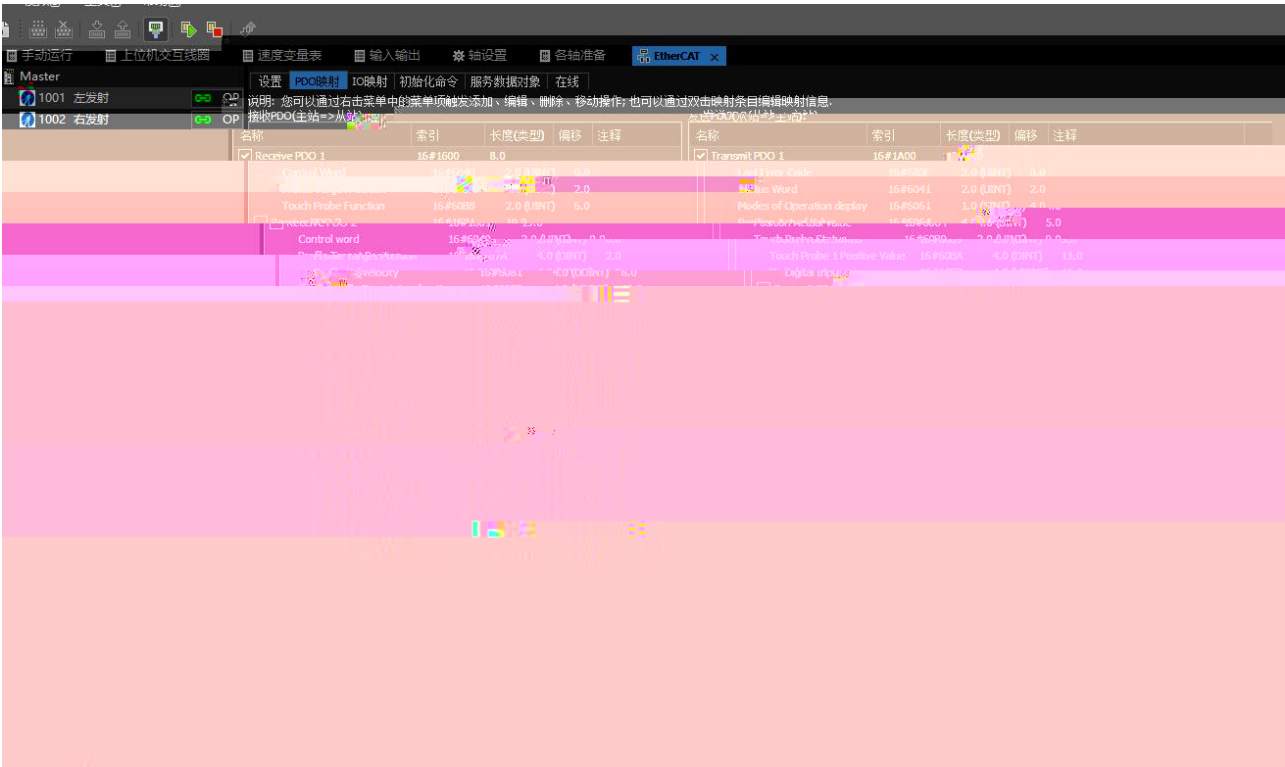


15. M512

op

pdo

pdo



16.

DI

ECAT_ReadParameter

DI

SDO



25.

6080

26.

JERK

1000

27. MC_SetPosition

IF



28.

MC_SetPosition 0

Axis[].cmdPos 0

MC_SetPosition MC_ReadActualPosition

29.

AXIS[1].CMDPOS

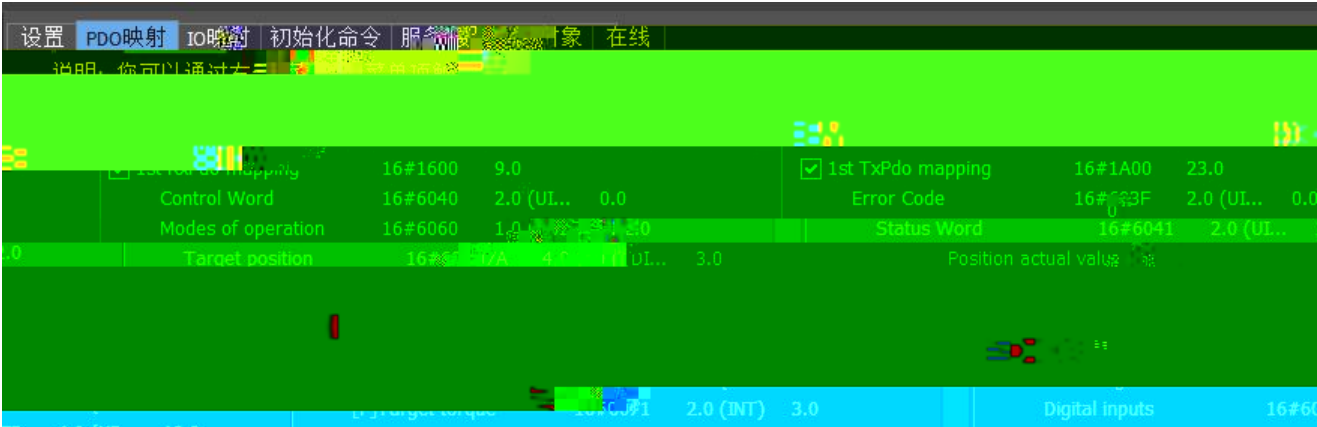
31. M511 Y7S

10000 / plc 10000 / plc



32. M512

M500 PDO PDO 16#606C M



33. Z

Z Axis[1].CmdPos

34.

$$1,000 \times 1 \div 69 \times 131,072 = 1,899,594.2028985 \quad 200\text{Khz}$$

1000

35.

+SetPosition MC_SetOverride 0

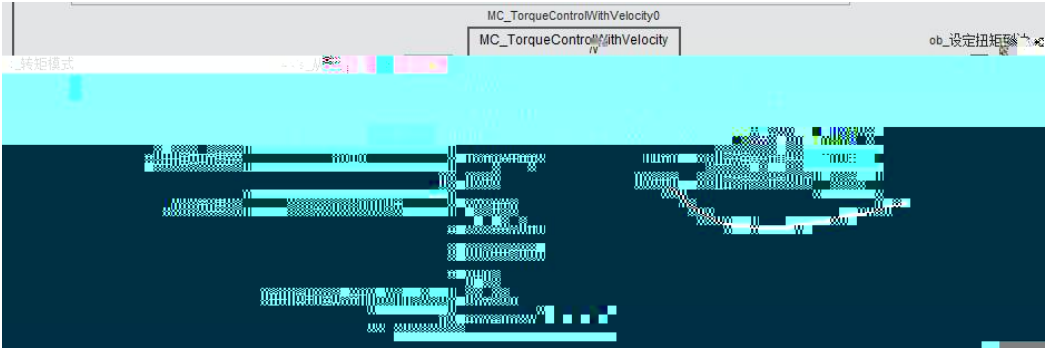
36. 4107

37. buffermode 1 3 0

38. MC_Encode 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

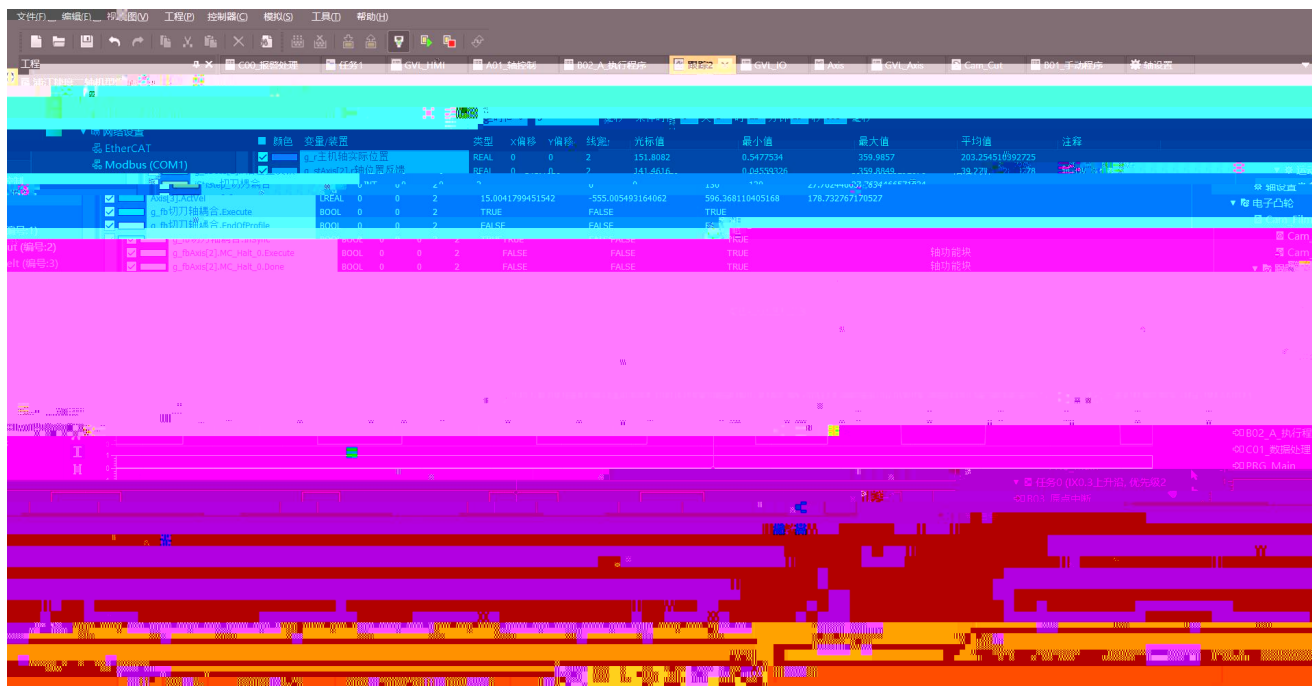


41. MC_SetCamPoint
MC_GetCamPoint

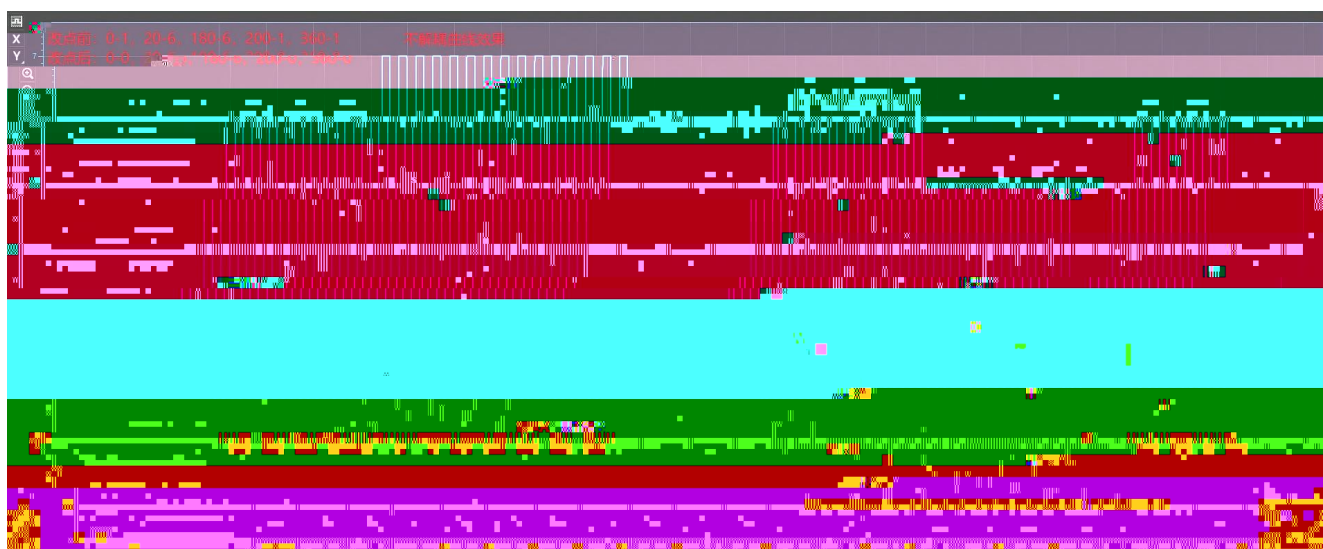
42. 0
MC_CAMIN MasterValueSource
1 1

43. CAM

44. 1:1
1 camin
AB



45.



1. — RUN

ERR

2. —

IP

STOP

3. —

Sysctrl Studio

4. —

PLC

0.0

5. M :

Sysctrl Studio

6. M512

I —

500

500

5 5 00 9-00

1*113'Y 0Y*1€