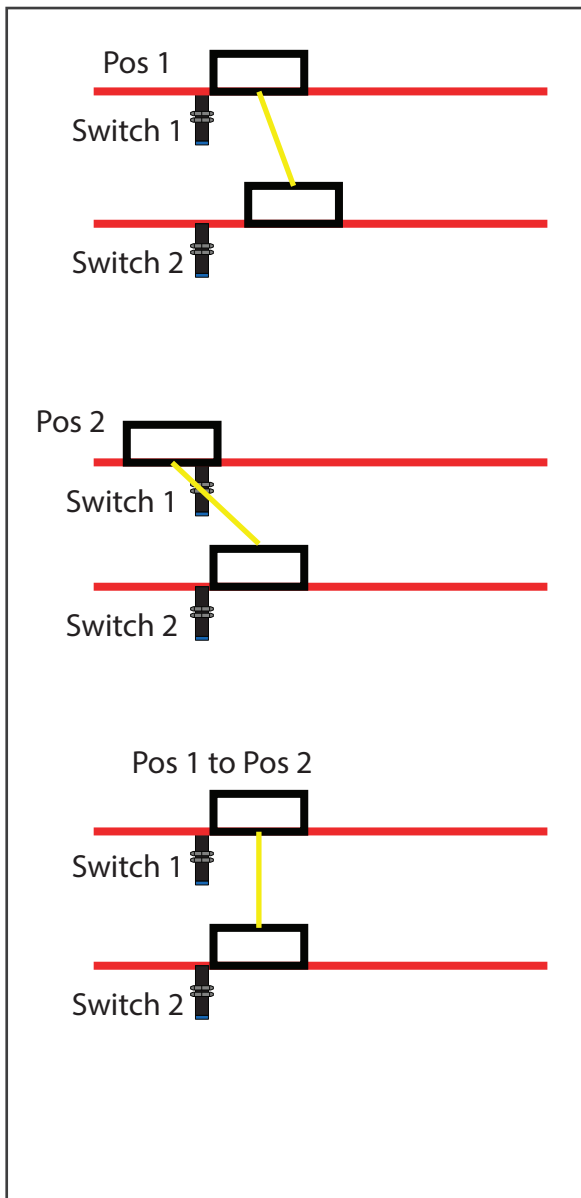


DDCS-Expert Double Y aixe Homing Movement Process (Example)



```
// Y1 Y2 define both the 2th axis and 4th axis as Y axis
#988=0
#989=1
#990=2
#991=1
#992=4

#100 = 1          //axis number
#101 = #[1045+#100*3] //input port number
#102 = #[1047+#100*3] // Effective level
#103 = #[607+#100] //Homing speed
#104 = #[612+#100] //Homing direction
#105 = 10         //Back distance

M98P503X#100 //Search for S1 limit switch
#[880+#100] = 0 //Y mechanical coordinate clear pos1
#655 = 0 // Cancel soft-limit
#106 = [1*[1-#104]]-#104 // Back direction
G91 G01 Y[#106*#105] F50; //Y axis back

//Search for S2 limit switch, the input port is for 4th Home signal
#101 = #[1045+3*3] //input port number
#102 = #[1047+3*3] //Effective level

M98P503X#100 //Search for S2 limit switch

//Record Pos2 position

//Run alone Y1
#988=0
#989=1
#990=2
#991=3
#992=4
G91 G01 Y[0-#[880+#100]] F50; //Y1 Calibrate (pos1-pos2)
#[880+#100] = 0 //Y mechanical coordinate clear

// Y1 Y2 synchronization
#988=0
#989=1
#990=2
#991=1
#992=4
G91 G01 Y[#106*#105] F50; //Y axis back distance
#[1515+#1]=1;Refresh Home symbol of each axis

#655 =1(active soft limit)
```

Wiring and configuration

- 1) Y1 Driver connect with YP+ YP- YD+ YD-; Y2 Driver connect with 4P+ 4P- 4D+ 4D-;
- 2) In the para page, configure the #488 to X; #489 to Y; #490 to Z; #491 to Y; 492 to 5th;
- 3) Wire the Switch 1 and Switch 2 to the input ports which you already defined for Y-axis zero signal and 4th axis zero signal in the IO page.

Test

- 1) Load the “Double Y Double Home switch.nc” and run;
- 2) Define the “Double Y Double Home switch.nc” as key (external key or K key) function.