


TB0442 Removing Slot Overrun on Beckhoff AX8000 Drives

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 Difficulty **Medium**

 Duration **30 minute(s)**

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Introduction

The AX8000 compact drives used on refurb machines from 2019 need to be tuned in a similar way to the AX5000 drives using the Velocity Time Constant. On Ax5000 drives, this was an SoE parameter S101 that was changed from 8ms to 0.8ms

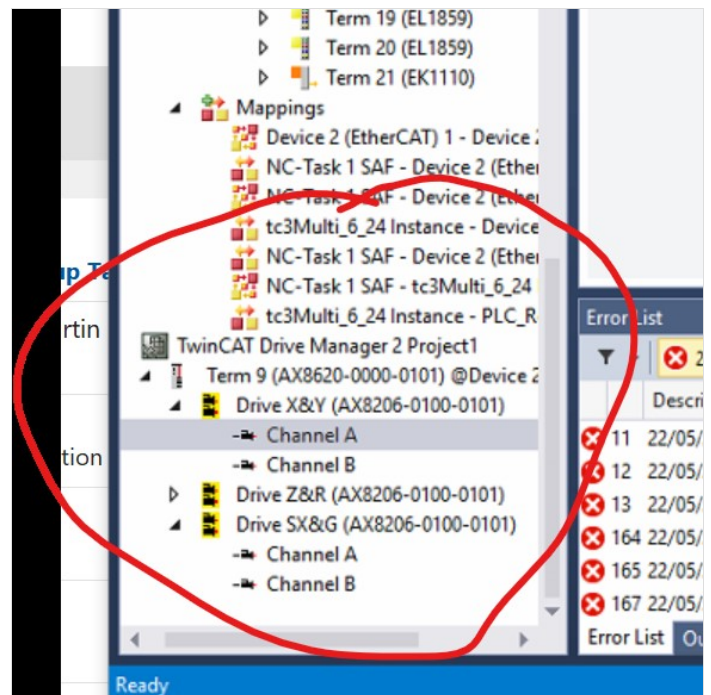
Photo shows the result of the overrun without this parameter – holes do not come out square.

Solution below:

Step 1 - Select the drive then channel

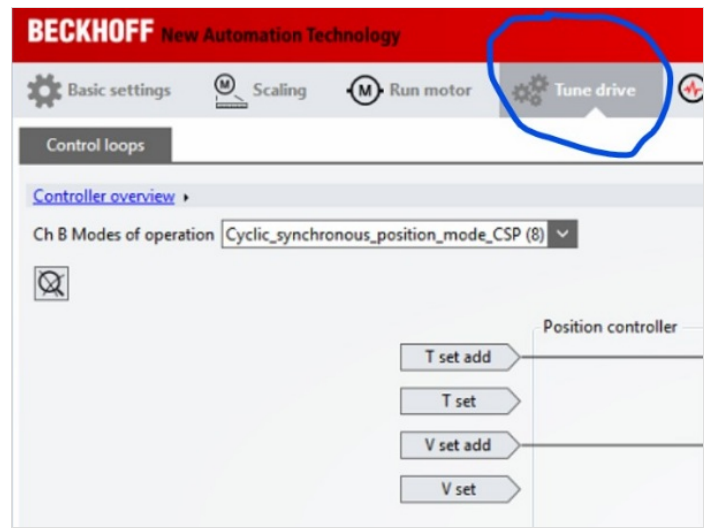
The control setup for AX8000 drives is no longer in the Drive Manager – A “Measurement Project” is automatically created at the end of the Visual Studio Solution

Select the drive in question and then the channel



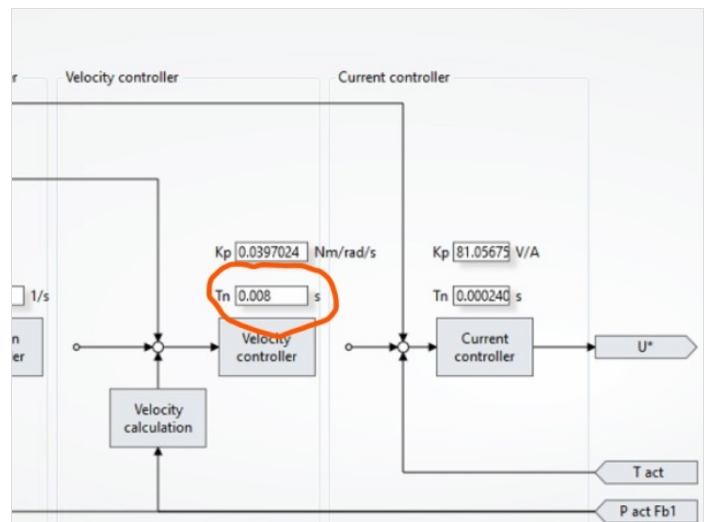
Step 2 - Select the Tune Drive tab

Select the Tune Drive Tab. The Velocity constant is Tn. This screen shows it in seconds (0.008s = 8ms)



Step 3 - Change the value

Change the value to 0.0008 to improve the accuracy. Press enter and the value changes to red.



Step 4 - Download the drive

Download to the drive by keying Ctrl-Enter, the colour changes back to black to demonstrate it is downloaded.

