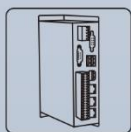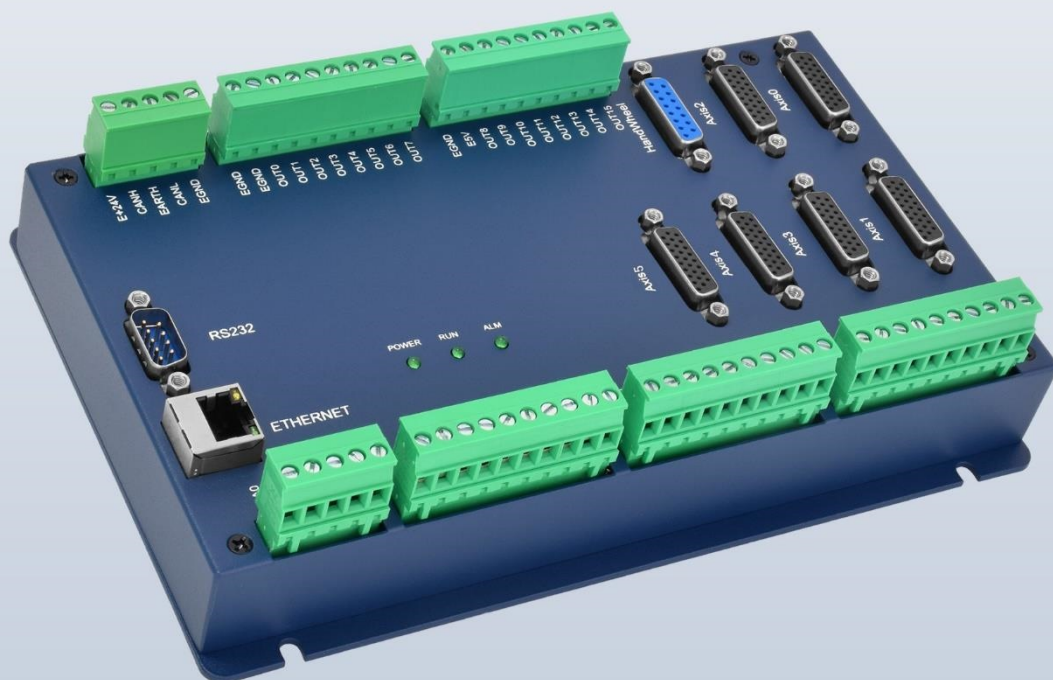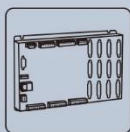# Network Motion Control Card
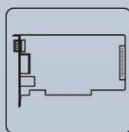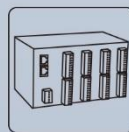
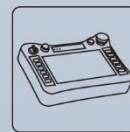# ECI2618

Vision Motion Controller   Motion Controller   Motion Control Card   IO Expansion Module   HMI

✚ **Foreword**

Zmotion®

The motion controller provides rich interface, and it has excellent motion control performance, which can meet the expansion requirements of various projects.

This manual is copyrighted by Shenzhen Technology Co., Ltd., without the written permission of the Zmotion Technology, no person shall reproduce, translate and copy any content in this manual. The above-mentioned actions will constitute an infringement of the copyright of the company's manual, and Zmotion will investigate legal responsibility according to law.

For details about the ZMC controller software and the introduction and routine of each command, please refer to the ZBASIC software manual.

Information contained in this manual is only for reference. Due to improvements in design and functions and other aspects, Zmotion Technology reserves the final interpretation! Subject to change without notice!

Pay attention to safety when debugging the machine!

Please be sure to design an effective safety protection device in the machine, and add an error handling program in the software, otherwise Zmotion has no obligation or responsibility for the loss caused.

In order to ensure the safe, normal and effective use of the product, please be sure to read this product manual carefully before installing and using the product.

⊹ Safety Statement

- This chapter describes the safety precautions required for the correct use of this product. Before using this product, please read the instructions for use and correctly understand the relevant information on safety precautions.
- This product should be used in an environment that meets the design specifications, otherwise it may cause equipment damage or personal injury, and malfunctions or component damage caused by failure to comply with relevant regulations are not within the scope of product quality assurance.
- Zmotion will not take any legal responsibility for personal safety accidents and property losses caused by failure to comply with the contents of this manual or illegal operation of products.

⊹ Safety Level Definition

According to the level, it can be divided into " Danger " and " Caution ". Failure to operate as required may result in moderate injury, minor injury or equipment damage.

Please keep this guide in a safe place for reading when needed, and be sure to hand this manual to the end user.

Install	
⚠️ Danger	◆ When the controller is disassembled, all external power supplies used by the system should be disconnected before operation, otherwise it may cause misoperation or damage to the equipment. ◆ It is forbidden to use in the following places: places with dust, oil fume, conductive dust, corrosive gas and flammable gas; places exposed to high temperature, condensation, wind and rain; places with vibration and shock. Electric shock, fire and misuse can cause product damage and deterioration.
⚠️ Notice	◆ Avoid metal shavings and wire ends falling into the hardware circuit board during installation. ◆ After installation, ensure that there are no foreign objects on the hardware circuit board. ◆ When installing, make it tightly and firmly with the mounting frame.

	◆ Improper installation of the controller may result in misoperation, failure and fire.
<td colspan="2" align="center" style="background-color:red;color:white;">**Wiring**</td>	
Danger	◆ The specifications and installation methods of the external wiring of the equipment shall comply with the requirements of local power distribution regulations. ◆ When wiring, all external power supplies used by the system should be disconnected before operation. ◆ When powering on and running after the wiring work is completed, the terminals attached to the product must be installed. ◆ Cable terminals should be well insulated to ensure that the insulation distance between cables will not be reduced after the cables are installed on the terminal block.
Notice	◆ Avoid metal shavings and wire ends falling into the hardware circuit board during installation. ◆ The cable connection should be carried out correctly on the basis of confirming the type of the connected interface. ◆ It should be confirmed that the cables pressed into the terminals are in good contact. ◆ Do not bundle the control wires and communication cables with the main circuit or power supply wires, etc., and the distance between the wires should be more than 100 mm, otherwise noise may cause malfunction. ◆ If the controller is not installed properly, it may cause electric shock or equipment failure or malfunction.

Content

Chapter I Production Information

1.1. Product Information

ECI is the abbreviation of the network motion control card model launched by Zmotion Technology.

ECI2000 series economical multi-axis motion control card is a kind of network motion control card that belongs to pulse type and modular type. Control card itself supports 6 axes at most, but motion control can be extended to 12 axes to achieve some simple trajectory control requirements, such as, linear interpolation, space arc, helical interpolation, electronic cam, electronic gear, synchronization follow, virtual axes, robotic arm instruction, etc., and real-time motion control can be achieved through optimized network communication protocol.

ECI2000 series economical multi-axis motion control card can be used in those pulse applications within 12 axes, such as, electronic semiconductor equipment (testing equipment, assembly equipment, locking equipment, soldering machine), dispensing equipment, assembly line, etc.

1.2. Function Features

◆ Motion control can be expanded to 12 axes.

◆ Pulse output mode: pulse / direction or dual pulses.

◆ AXIS interface supports encoder position measurement, which can be configured as handwheel input mode.

◆ Specialized handwheel input interface.

◆ Maximum pulse frequency output of each axis: 10MHZ.

◆ 256 isolation inputs and 256 isolation outputs can be extended at most through CAN bus.

◆ Axis position limit signal / origin signal port can be configured as any input at will.

◆ The maximum output current of general digital outputs can reach 300mA, which can directly drive some kinds of solenoid valves.

◆ Interfaces: RS232, Ethernet.

◆ Support linear interpolation, any circular interpolation, helical interpolation of 12 axes at most.

◆ Support point to point, electronic cam, linear interpolation, circular interpolation, continuous interpolation, robotic arm instructions.

◆ Multi-file and multi-task programming in ZBasic.

◆ A variety of program encryption methods to protect the intellectual property rights of customers.

1.3. System Frame
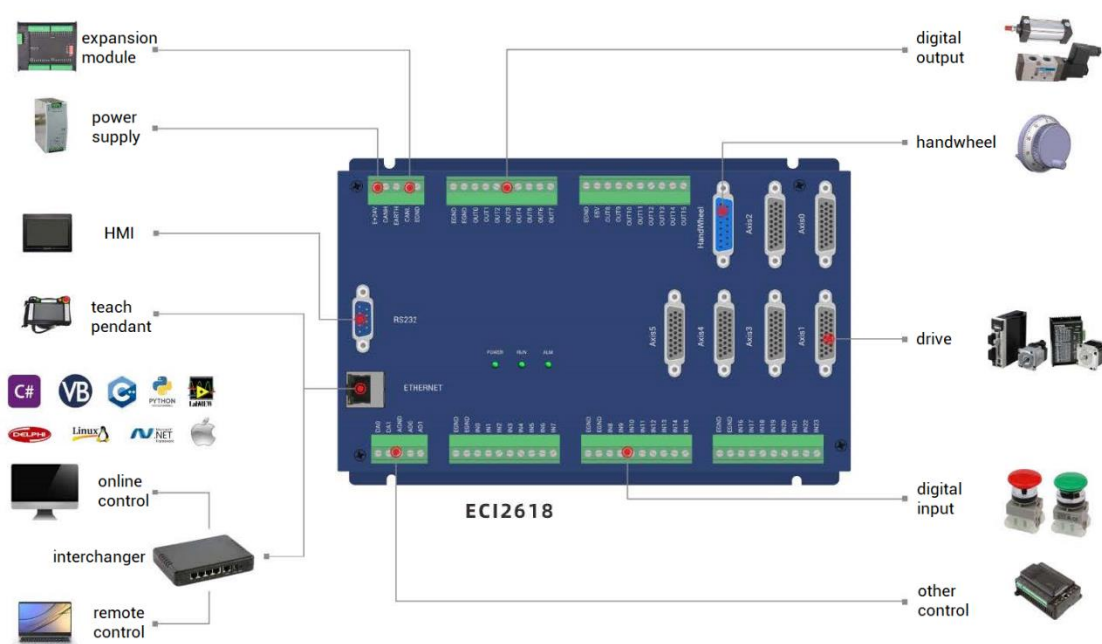
1.4. Hardware Installment

ECI2618 economical multi-axis motion control card adopts the horizontal installation method of screw fixing, and each controller should be installed with 4 screws for fastening.
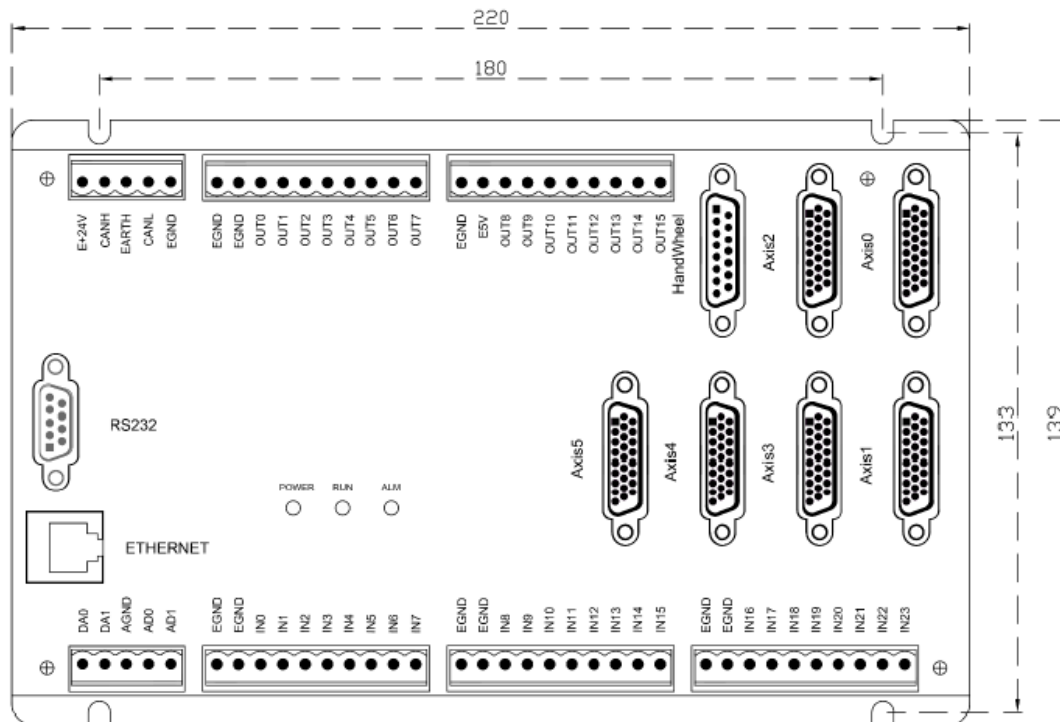
→ Unit: mm   → Installment Hole Diameter: 4.5mm   → Thickness: 52mm

⚠️ **Installation attention**	• Non-professionals are strictly prohibited to operate. Specifically, professionals who had been trained related electrical equipment, or who master electrical knowledge. • Please be sure to read the product instruction manual and safety precautions carefully before installation. • Before installation, please ensure that the product is powered off. • Do not disassemble the module, otherwise the machine may be damaged. • Avoid direct sunlight installation. • In order to facilitate ventilation and controller replacement, 2-3cm should be left between the upper and lower parts of the controller and the installation environment and surrounding components.

| | ● Considering the convenient operation and maintenance of the controller, please do not install the controller in the following places:

a) places where the surrounding ambient temperature exceeds the range of -10°C-55°C

b) places where the ambient humidity exceeds the range of 10%-95% (non-condensing)

c) places with corrosive gases and flammable gases

d) places with many conductive powders such as dust and iron powder, oil mist, salt, and organic solvents |

Chapter II Product Specification

2.1. Basic Specification

Item	Description
Model	ECI2618
Basic Axes	6
Max Extended Axes	12
Basic Axes Type	Pulse/encoder
Digital IO	General IO: there are 24 inputs and 16 outputs. Axis interface IO: there are 12 inputs and 6 outputs on 6 AXIS axis interfaces.
Max Extended IO	256 inputs, 256 outputs
AD/DA	2 general ADs and 2 general DAs.
Max Extended AD/DA	128 ADs, 64 DAs
Pulse Bit	32
Encoder Bit	32
Speed Acceleration Bit	32
Pulse Max Frequency	10MHz
Motion Axis Buffer	128
Array Space	2000
Program Space	4KByte
Flash Space	128KByte
Power Supply Input	24V DC input
Communication Interfaces	RS232, Ethernet, CAN.
Dimensions	220mm*139mm

2.2. Order Information

Model	Description
ECI2610	6 axes, point to point, electronic cam, invalid for interpolation.
ECI2612	6 axes, point to point, electronic cam, linear interpolation.
ECI2616	6 axes, point to point, electronic cam, linear interpolation, circular interpolation.
ECI2618	6 axes, point to point, electronic cam, linear interpolation, circular interpolation, continuous interpolation, robotic arm instruction.

➢ ECI2618 motion control card doesn't support hardware comparison output function.

2.3. Interface Definition
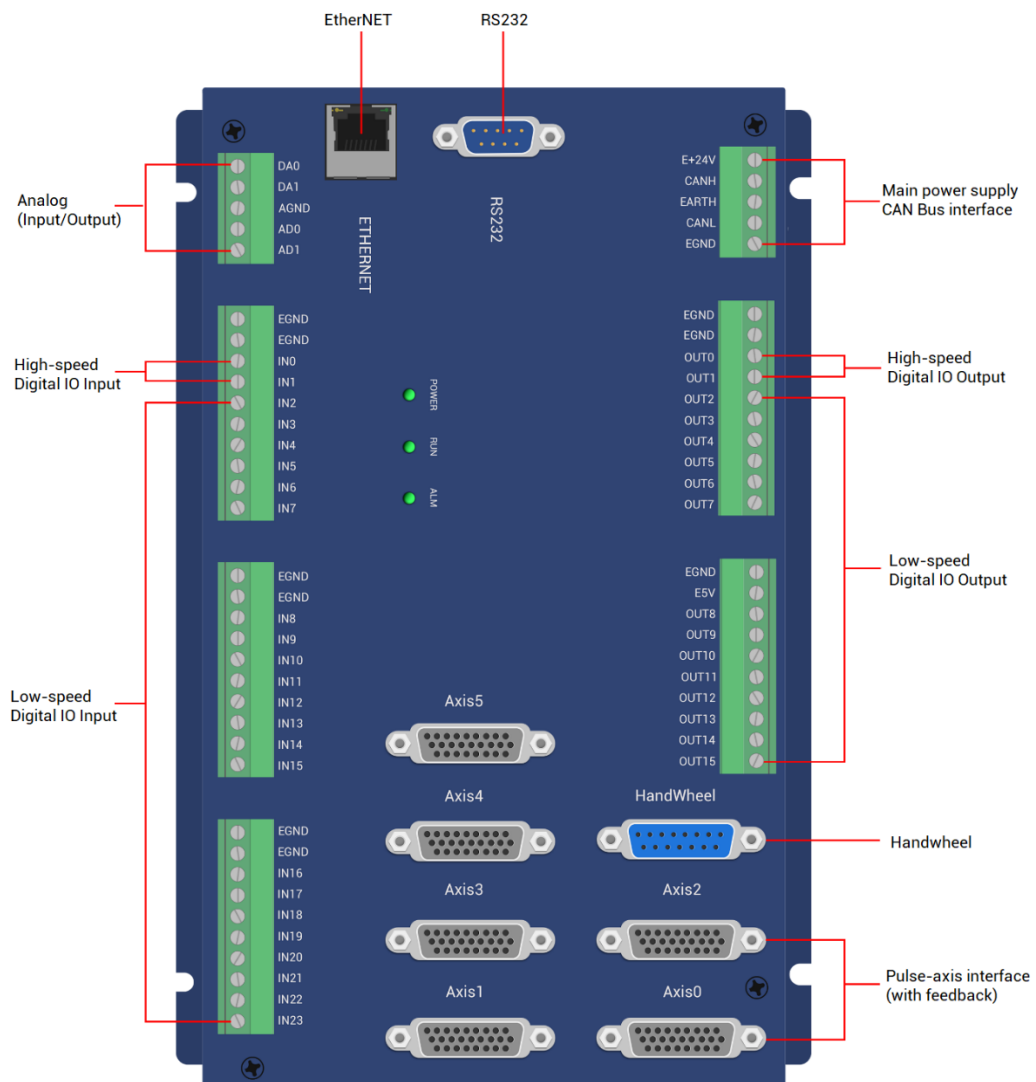
→ Interface Description

Mark	Interface	Number	Description
POW	Status Indication Led	1	Power indicator: it lights when power is conducted.
RUN		1	Run indicator: it lights when runs normally
ALM		1	Error indicator: it lights when runs abnormally
RS232	RS232 serial port	1	Use MODBUS_RTU protocol
ETHERNET	Net port	1	Use MODBUS_TCP protocol, expand Ethernet through interchanger, the number of net port channels can be checked through "?*port", default IP address id 192.168.0.11

E+24V	Main power	1	24V DC power supplies for controller
CAN	CAN bus interface	1	Connect CAN expansion module and CAN equipment of other standards
IN	Digital IO input	24	NPN leakage type, internal 24V supply power.
OUT	Digital IO output	16	NPN leakage type, internal 24V supply power.
AD	Analog input	2	Resolution: 12 bits, 0-10V
DA	Analog output	2	Resolution: 12 bits, 0-10V
AXIS	Pulse axis	6	It includes differential pulse output and differential encoder input
Handwheel	Handwheel	1	5-24V handwheel signal input.

2.4. Work Environment

Item		Parameters
Work Temperature		-10℃-55℃
Work relative Humidity		10%-95% non-condensing
Storage Temperature		-40℃～80℃ (not frozen)
Storage Humidity		Below 90%RH (no frost)
vibration	Frequency	5-150Hz
	Displacement	3.5mm(directly install)(<9Hz)
	Acceleration	1g(directly install)(>9Hz)
	Direction	3 axial direction
Shock (collide)		15g, 11ms, half sinusoid, 3 axial direction
Degree of Protection		IP20
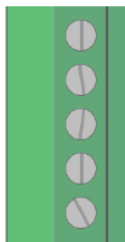
Chapter III Wiring, Communication Configuration &

3.1. Power Input, CAN Communication Interface

The power supply input adopts a 5Pin (there are all 5 terminals) screw-type pluggable wiring terminal, and the interval (means the gap distance between two ports) should be 5.08mm. This 5Pin terminal is the power supply shared by controller and CAN communication.

→ Terminal Definition:

Terminal	Name	Type	Function
E+24V CANH EARTH CANL EGND	E+24V	Input	Power 24V input
	CANH	Input/Output	CAN differential data +
	EARTH	Grounding	Shield
	CANL	Input/Output	CAN differential data -
	EGND	Input	Power ground

3.1.1. Power Supply Specification

→ Specification

Item	Description
Voltage	DC24V (-10%~10%)
Current to open	≤0.5A
Current to work	≤0.4A
Anti-reverse connection	Valid
Overcurrent Protection	Valid

3.1.2. CAN Communication Specification & Wiring

The CAN interface of the controller adopts the standard CAN communication protocol, which mainly includes three ports, CANL, CANH and the public end. And it supports connecting CAN expansion modules and other standard CAN devices.

→ Specification

Item	Description
Max Communication Rate (bps)	1M
Terminal Resistor	120Ω
Topology	Daisy chain connection structure
The number of nodes can be extended	Up to 16
Communication Distance	Longer communication distance, lower communication rate, max 100m is recommended.

→ Wiring Reference

Connect the CANL and CANH of the standard CAN module to the CANL and CANH of the other side correspondingly. And public ends of the CAN bus communication both parties are connected together. In CAN bus left and right sides, connect a 120Ω resistor respectively (please see below graphic).
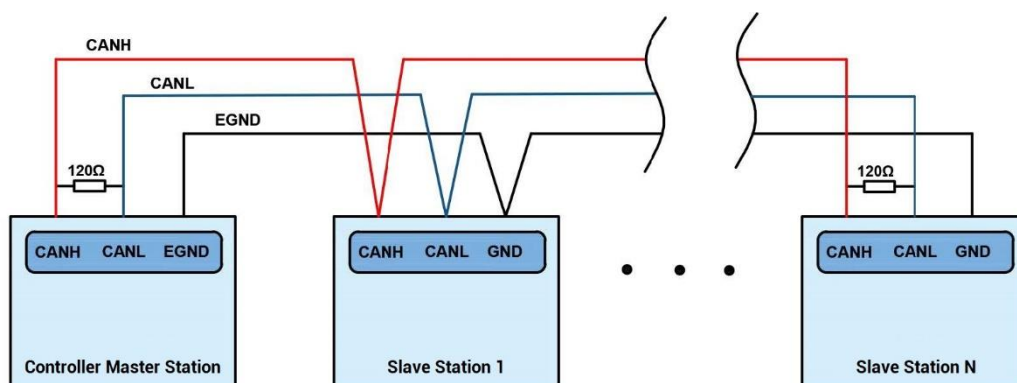
→ Wiring Notes:

● As above, the daisy chain topology is used for wiring (the star topology structure cannot be used). When the use environment is ideal and there are no many nodes, the branch structure also can be used.

● Please connect a 120Ω terminal resistor in parallel to each end of the CAN bus for matching the circuit impedance and ensuring communication stability.

● Please be sure to connect the public ends of each node on the CAN bus to prevent the CAN chip from burning out.

● Please use STP (Shielded Twisted Pair), especially in bad environments, and make sure the shielding layer is fully grounded.

● When on-site wiring, pay attention to make the distance between strong current and weak current, it is recommended for the distance to be more than 20cm.

● It should be noted that the equipment grounding (chassis) on the entire line must be good, and the grounding of the chassis should be connected to the standard factory ground pile.

→ Cable Requirements:

Shielded Twisted Pair, and the shielded cable is grounded.
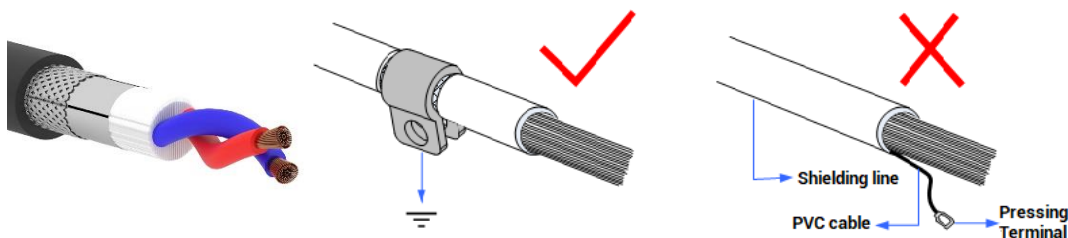
3.1.2. Basic Usage Method

(1) Please follow the above wiring instructions to wiring correctly.

(2) After powered on, please use ETHERNET or RS232 to connect to ZDevelop.

(3) Please use the "CANIO_ADDRESS" command to set the master's "address" and "speed" according to the needs, and use the "CANIO_ENABLE" command to enable or disable the internal CAN master function, or through "ZDevelop/Controller/State the Controller/Communication Info" to view the CAN status intuitively, and refer to the "ZBasic Programming Manual" for details.
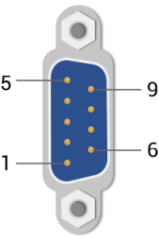
```
CAN communication settings:
CANIO_ADDRESS = 32, CANIO_ENABLE = 1
ZCAN Master
CAN baud: 500KBPS
CAN enable: ON

Serial port configuraton:
Port0:(RS232) is ModbusSlave Mode.
Address:1, variable:2
Baud:38400
DataBits:8
StopBits:1
Parity:0
```

(4) Correctly set the "address" and "speed" of the slave station expansion module according to the manual of the slave station.

(5) After all the settings are completed, restart the power supply of all stations to establish communication.

(6) Note that the "speed" settings of each node on the CAN bus must be consistent, and the "address" settings cannot cause conflicts, otherwise the "ALM" alarm light will be on, and the communication establishment will fail or the communication will be disordered.

3.2. RS232 Serial Port

RS232 is in one standard DB9 male socket and supports MODBUS_RTU protocol and custom communication.

→ Interface Definition

Terminal	PIN	Name	Type	Function
	1、4、6、7、8	NC	Spare	Reserved
	2	RXD	Input	RS232 signal, receive data
	3	TXD	Output	RS232 signal, send data
	5	EGND	Output	Negative pole output of 5V power, and output for the public end
	9	E5V	Output	Positive pole output of 5V power, maximum is 300mA

3.2.1. RS232 Interface Specification & Wiring

→ Specification:

Item	RS232
Maximum Communication Rate (bps)	115200
Terminal Resistor	No
Topology Structure	Connect correspondingly (1 to 1)
The number of nodes can be extended	1
Communication Distance	The Longer communication distance is, the lower communication rate is, maximum 10m is recommended.

→ Wiring Reference:
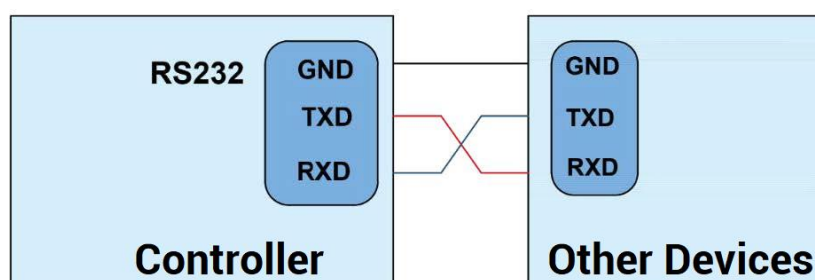
→ **Wiring Notes:**

● The wiring of RS232 is as above, it needs to cross-wiring for sending and receiving signals, and it is recommended to use a double-female head cross line when connecting to a computer.

● Please be sure to connect the public ends of each communication node to prevent the communication chip from burning out.

● Please use STP, especially in bad environments, and make sure the shielding layer is fully grounded.

3.2.2. Basic Usage Method

(1) Please follow the above wiring instructions to wiring correctly.

(2) After powered on, please use any ETHERNET or RS232 (there is default parameter, which can be connected directly) to connect to ZDevelop.

(3) Please use the "ADDRESS" and "SETCOM" commands to set and view the protocol station number and configured parameters, see "ZBasic Programming Manual" for details.

(4) According to their respectively instructions, correctly set the relevant parameters of the third-party equipment to match the parameters of each node.

(5) When all is configured, it can start to do communicating.

(6) Communication data of RS232 can be directly viewed through "ZDevelop / Controller / State the Controller / CommunicationInfo".

```
CAN communication settings:
CANIO_ADDRESS = 32, CANIO_ENABLE = 1
ZCAN Master
CAN baud: 500KBPS
CAN enable: ON

Serial port configuration:
Port0:(RS232) is ModbusSlave Mode.
Address:1, variable:2
Baud:38400
DataBits:8
StopBits:1
Parity:0
```
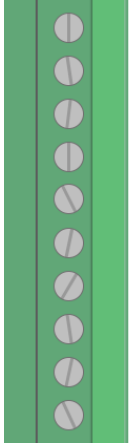
3.3. IN Digital Input & High-Speed Latch Port

The digital input adopts 3 groups of 10Pin (there are 3 groups of 10 terminals) screw-type pluggable terminals, and the gap distance between terminals should be 5.08mm. In addition, the high-speed latch function is integrated in digital input signal.

→ Wiring Definition

Terminal	Name	Type	Function 1	Function 2
EGND EGND IN0 IN1 IN2 IN3 IN4 IN5 IN6 IN7	EGND	/	External power ground (don't connect to switch power)	/
	EGND	/		/
	IN0	NPN leakage type, high-speed input	Input 0	High Speed Latch A
	IN1		Input 1	High Speed Latch B
	IN2	NPN leakage type, low-speed input	Input 2	/
	IN3		Input 3	/
	IN4		Input 4	/
	IN5		Input 5	/
	IN6		Input 6	/
	IN7		Input 7	/
	EGND	/	External power ground (don't connect to switch power)	/
	EGND	/		/
	IN8	NPN leakage type, low-speed input	Input 8	/
	IN9		Input 9	/
	IN10		Input 10	/
	IN11		Input 11	/

EGND / IN8 / IN9 / IN10 / IN11 / IN12 / IN13 / IN14 / IN15 (terminal block)	IN12		Input 12	/
	IN13		Input 13	/
	IN14		Input 14	/
	IN15		Input 15	/
EGND / EGND / IN16 / IN17 / IN18 / IN19 / IN20 / IN21 / IN22 / IN23 (terminal block)	EGND	/	External power ground (don't connect to switch power)	/
	EGND	/		/
	IN16	NPN leakage type, low-speed input	Input 16	/
	IN17		Input 17	/
	IN18		Input 18	/
	IN19		Input 19	/
	IN20		Input 20	/
	IN21		Input 21	/
	IN22		Input 22	/
	IN23		Input 23	/

3.3.1. Digital Input Specification & Wiring

→ Specification

Item	High-Speed Input (IN0-1)	Low-Speed Input (IN2-23)
Input mode	NPN leakage type, the input is triggered when there is low-electric level	
Frequency	< 100kHz	< 5kHz
Impedance	3.3KΩ	4.7KΩ
Voltage level	DC24V	DC24V
The voltage to open	<15V	<14.5V
The voltage to close	>15.1V	>14.7V
Minimal current	-2.3mA (negative)	-1.8mA (negative)
Max current	-7.5mA (negative)	-6mA (negative)
Isolation mode	optoelectronic isolation	optoelectronic isolation
Note: the above parameters are standard values when the voltage of controller power		

supply (E+24V port) is 24V.

→ **Wiring Reference**
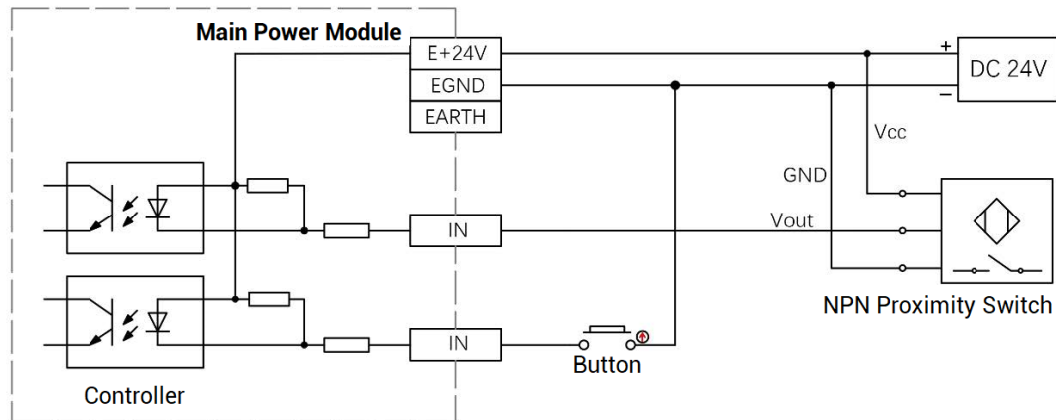
→ **Wiring Note:**

- The wiring principle of high-speed digital input IN (0-1) and low-speed digital input IN (2-23) is shown in the figure above. The external signal source can be an optocoupler, a key switch or a sensor, etc., all can be connected as long as the requirements on output of electric level can be achieved.

- For the public end, please connect the "EGND" port on the power supply to the "COM" terminal of the external input device. If the signal area power supply of the external device and the power supply of the controller are in the same power supply system, this connection also can be omitted.

3.3.2. **Basic Usage Method**

(1) Please follow the above wiring instructions to wiring correctly.

(2) After powered on, please select ETHERNET or RS232 to connect to ZDevelop.

(3) State values of relative input ports can be read directly through "IN" command, also, it can be read through "ZDevelop/View/In". Please refer to "ZBasic" for details.

0	●	●	rev_in(0)
1	●	●	rev_in(1)
2	●	●	rev_in(2)
3	●	●	fwd_in(0)
4	●	●	fwd_in(1)
5	●	●	fwd_in(2)
6	●	●	alm_in(0)
7	●	●	alm_in(1)
8	●	●	alm_in(2)
9	●	●	
10	●	●	
11	●	●	
12	●	●	

(4) Latch function can be set and triggered through "REGIST" instruction, in software, use REG_INPUTS to configure. Please refer to "ZBasic" for details.

3.4. OUT: Digital Output & PWM Terminal

The digital output adopts 2 sets of 10Pin screw-type pluggable terminals with a spacing of 5.08mm, and the PWM function is integrated in digital output signal.

→ Wiring Definition

Terminal	Name	Type	Function 1	Function 2
EGND EGND OUT0 OUT1 OUT2 OUT3 OUT4 OUT5 OUT6 OUT7	EGND	/	External power ground	/
	EGND	/		/
	OUT0	NPN Leakage type, high-speed output	Output 0	PWM Output 0
	OUT1		Output 1	PWM Output 1
	OUT2	NPN Leakage type, low-speed output	Output 2	/
	OUT3		Output 3	/
	OUT4		Output 4	/
	OUT5		Output 5	/
	OUT6		Output 6	/
	OUT7		Output 7	/

	EGND	/	External power ground	/
	E5V		Output of 5V power, max is 300mA	/
	OUT8		Output 8	/
	OUT9		Output 9	/
	OUT10		Output 10	/
	OUT11	NPN Leakage type, low-speed output	Output 11	/
	OUT12		Output 12	/
	OUT13		Output 13	/
	OUT14		Output 14	/
	OUT15		Output 15	/

Note:

✧ OUT 0-1 are high-speed outputs, they support PWM output function. The E5V power output port is used for PWM or common anode wiring of single-ended axis. It is not recommended for other purposes due to lower power.

✧ "EGND" on input port and output port are external power ground, they can't be connected to power supply of switch.

3.4.1. Digital Output Specification & Wiring

→ Specification

| Item	High Speed Output (OUT0-1)	Low Speed Output (OUT2-15)
Output mode	NPN leakage type, it is 0V when outputs	
Frequency	< 400kHz	< 8kHz
Voltage level	DC24V	DC24V
Max output current	+300mA	+300mA
Max leakage current when off	25μA	25μA
Respond time to conduct	1μs (resistive load typical value)	12μs
Respond time to close	3μs	80μs
Overcurrent protection	Support	Support
Isolation method	optoelectronic isolation	optoelectronic isolation

> **Note:**
>
> ✧   The times in the form are typical based on the resistive load, and may change when the load circuit changes.
>
> ✧   Due to the leak-type output, the shutdown of the output will be obviously affected by the external load circuit, and the output frequency should not be set too high in the application. For high-speed output, it is recommended to be lower than 400KHz, for low-speed output, it is recommended to be lower than 8HKz. If there needs higher speed, please contact us to adjust parameter or custom hardware.

→ Wiring Reference
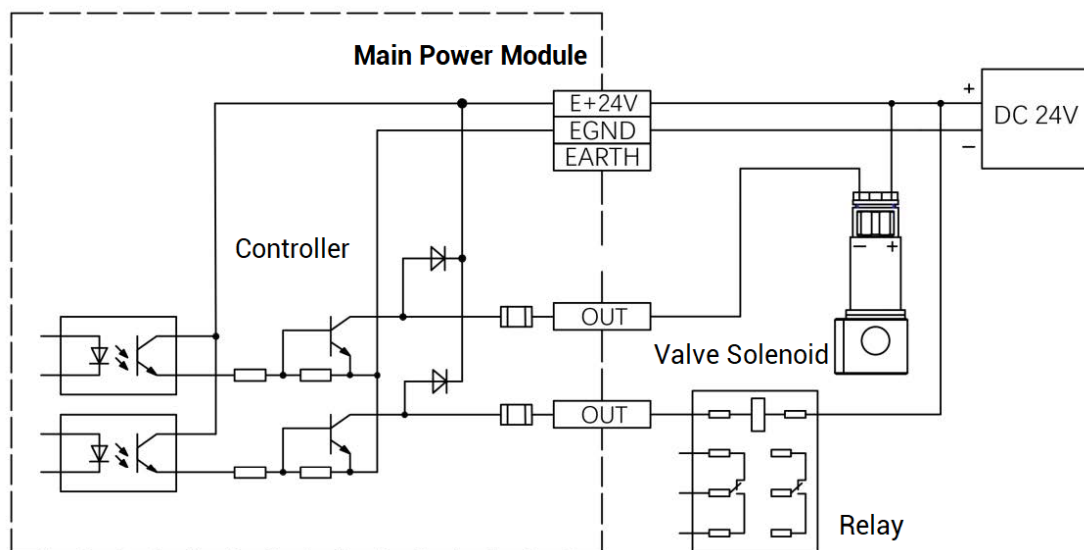
→ Wiring Note:

●   The wiring principle of high-speed digital output OUT (0-1) and low-speed digital output OUT (2-15) is shown in the figure above. The external signal receiving end can be an optocoupler or a relay or solenoid valve, all can be connected as long as the input current does not exceed 300mA.

●   For the connection of the public end, please connect the "EGND" port on the power supply to the negative pole of the DC power supply of the external input device. If the DC power supply of the external device and the controller power supply are in the same power supply system, this connection can also be omitted.

3.4.2. Basic Usage Method

(1) Please follow the above wiring instructions to wiring correctly.

(2) After powered on, please use ETHERNET or RS232 to connect to ZDevelop.

(3) Open or close output port directly through "OP" command, also, it can be opened or closed through "ZDevelop/View/Op". Please refer to "ZBasic" for details.
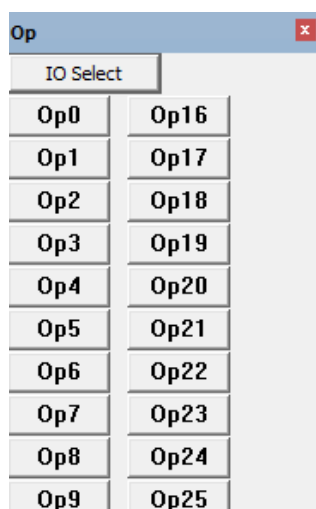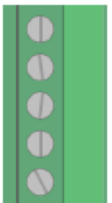

(4) The PWM function, set the frequency and duty cycle through "PWM_FREQ" and "PWM_DUTY". Please refer to ZBasic for details.

(5) High-speed comparison output can be set and used through "HW_PSWITCH2" command. Please refer to ZBasic for details.

3.5. AD/DA: Analog Input / Output

The analog port adopts a set of 5Pin screw-type pluggable terminals with a spacing of 5.08mm.

→ Wiring Definition

Terminal	Name	Type	Function
	DA0	Output	Analog output terminal AOUT(0)
	DA1		Analog output terminal AOUT(1)
	AGND	Public end	Unique analog public end

	AD0	Input	Analog input terminal AIN(0)
(connector with DA0, DA1, AGND, AD0, AD1)	AD1		Analog input terminal AIN(1)

3.5.1. Analog Input / Output Specification & Wiring

→ Specification

Item	AD (0-1)	DA (0-1)
Resolution	12-bit	12-bit
Data range	0-4095	0-4095
Signal range	0V-10V input	0V-10V output
Data refresh	1kHz	1kHz
Voltage input impedance / output load	>300KΩ (voltage input impedance)	>1KΩ (voltage output load)

→ Wiring Reference
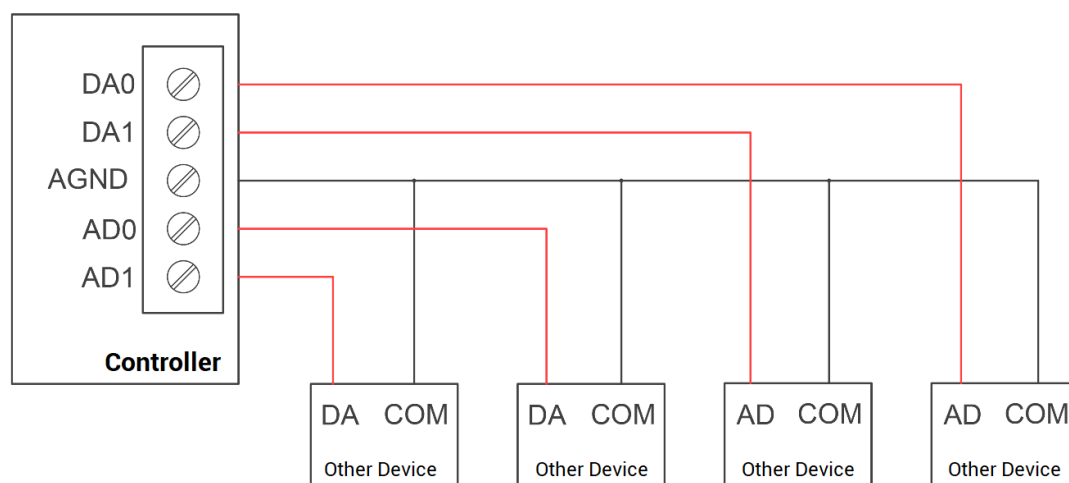
→ Wiring Note:

● The analog input/output wiring method is as shown in the figure above, and the external load signal range must match with this signal range.

● Please use STP, especially in bad environments, and make sure the shielding layer is
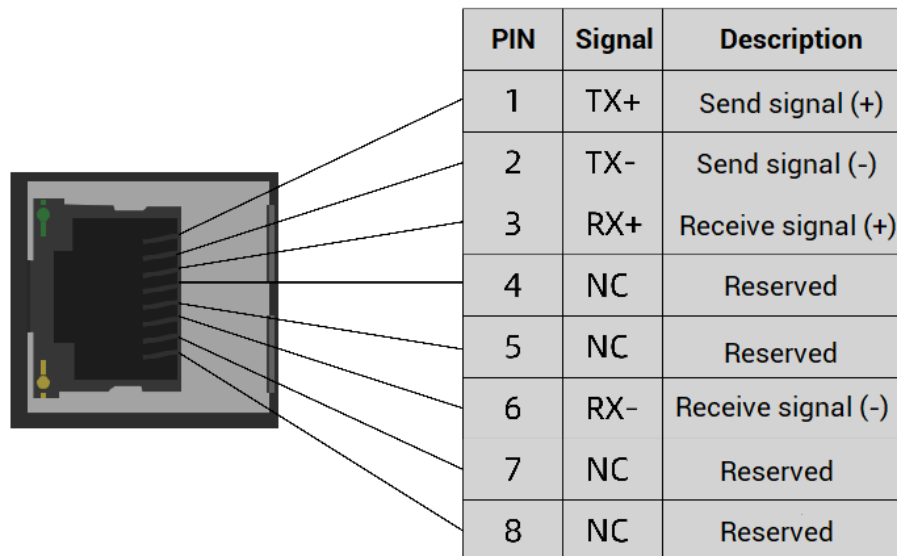
fully grounded.

3.5.2. Basic Usage Method

(1) Please follow the above wiring instructions to wiring correctly.

(2) After powered on, please use ETHERNET or RS232 to connect to ZDevelop.

(3) Analog input voltage can be read through "AIN" command and corresponding analog voltage can be output through "AOUT" command, also, data of each channel can be checked through "ZDevelop/View/AD/DA". Please refer to "ZBasic" for details.

AD:

通道号	大小	刻度值	电压或电流值	最大刻度值	电压或电流范围
0	0%	4	0.010	4095	0~10V
1	0%	8	0.020	4095	0~10V

DA:

| 通道号	大小	刻度值	电压或电流值	最大刻度值	电压或电流范围
0	0%	0	0.000	4095	0~10V
1	0%	0	0.000	4095	0~10V

3.6. ETHERNET

ECI2618 motion controller has an Ethernet port, and it supports MODBUS_TCP protocol and custom communication, and the default IP address is 192.168.0.11. The pin definition is as follows:

PIN	Signal	Description
1	TX+	Send signal (+)
2	TX-	Send signal (-)
3	RX+	Receive signal (+)
4	NC	Reserved
5	NC	Reserved
6	RX-	Receive signal (-)
7	NC	Reserved
8	NC	Reserved

The Ethernet port of the controller can be connected to a computer, HMI, etc. through an Ethernet cable, and using point to point connection method. The schematic diagram is as follows:
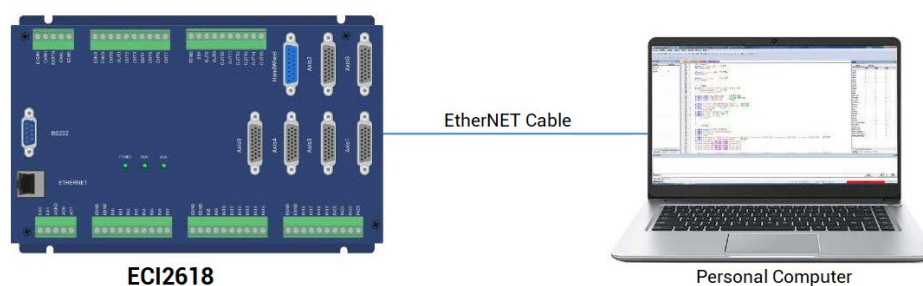

The controller can also be connected to the interchanger through an Ethernet cable, and then use interchanger to connect to other devices, then multi-point connection can be achieved. The schematic diagram is as follows:
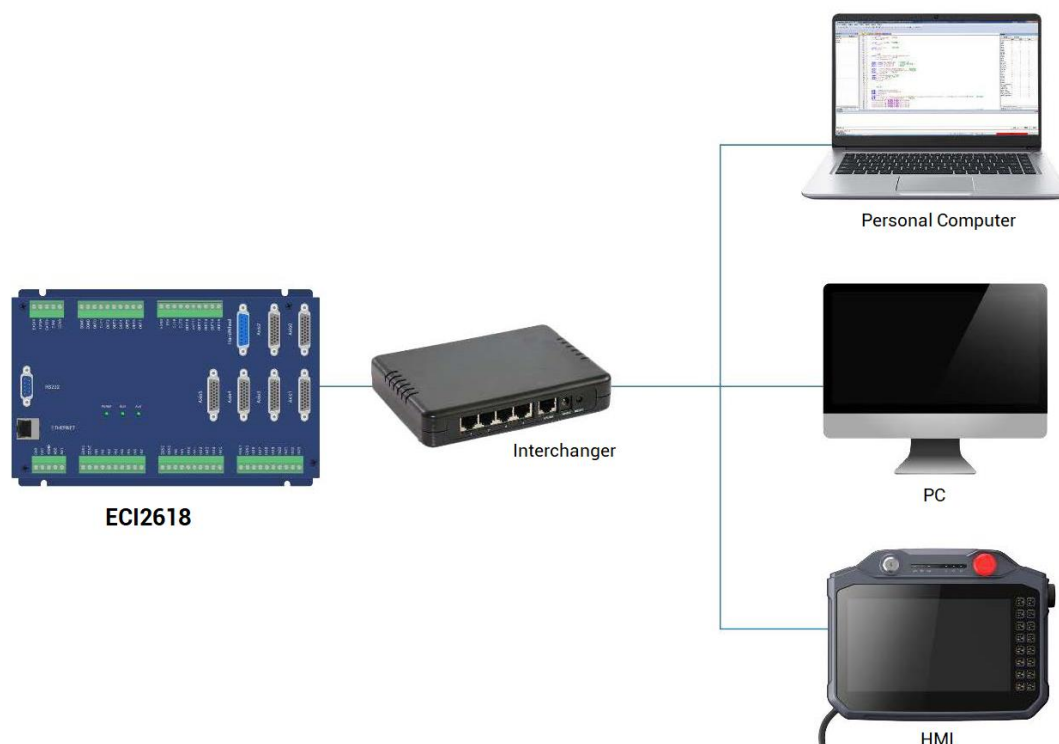
→ Communication Cable Requirements

ETHERNET communication interface adopts standard Ethernet RJ45 interface.

The network cable adopts Category 5e STP, and the crystal head has a metal shell to reduce interference and to prevent information from being eavesdropped. As shown below:
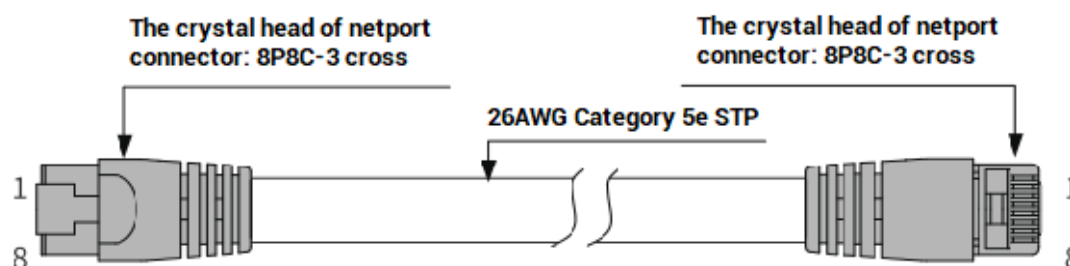
Item	Specification
Cable type	Flexible crossover cable, Category 5e
traverse	twisted pair
Line pairs	4
Isolation	cross skeleton
Connector	Crystal head with iron shell
Cable material	PVC

Cable length	Less than 100m

Use RJ45 network cable connection method:

● When installing, hold the crystal head that is with the cable and insert it into the RJ45 interface until it makes a "click" sound (kada).

● In order to ensure the stability of communication, please fix the cables with cable ties.

● When disassembling, press the tail mechanism of the crystal head, and pull out the connector and the module in a horizontal direction.
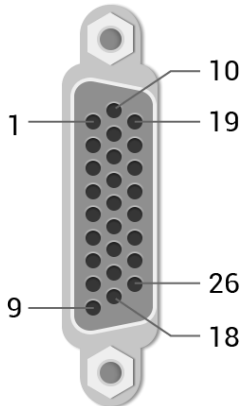
Please use tube-type pre-insulated terminals and cables with appropriate wire diameters to connect the user terminals.

3.7. Axis Interface

This product provides 6 local differential pulse axis interfaces, each interface is a standard DB26 female socket. Each terminal provides 0V and +5V output, which can provide 5V power for the encoder.

Before the axis is used, the use mode of the axis must be configured through the ATYPE parameter.

→ Interface Definition

Interface	Pin	Signal	Description
	1	EGND	Negative pole of 24V digital IO power
	2	IN24-29/ALM	General input (recommended as driver alarm)
	3	OUT16-21ENABLE	General output (recommended as driver enable)
	4	EA-	Encoder differential input signal A-
	5	EB-	Encoder differential input signal B-
	6	EZ-	Encoder differential input signal Z-
	7	+5V	Positive pole of 5V power of pulse/encoder signal

	8	Reserved	Reserved
	9	DIR+	Servo or step directional output (differential signal)
	10	GND	Negative pole of 5V power of pulse/encoder signal
	11	PUL-	Servo or step pulse output (differential signal)
	12	Reserved	Reserved
	13	GND	Negative pole of 5V power of pulse/encoder signal
	14	OVCC	Positive pole of IO 24V power
	15	Reserved	Reserved
	16	IN30-35/INPOS	General input (recommended as on-position signal)
	17	EA+	Encoder differential input signal A+
	18	EB+	Encoder differential input signal B+
	19	EZ+	Encoder differential input signal Z+
	20	GND	Negative pole of 5V power of pulse/encoder signal
	21	GND	
	22	DIR-	Servo or step directional output (differential signal)
	23	PUL+	Servo or step pulse output (differential signal)
	24	GND	Negative pole of 5V power of pulse/encoder signal
	25	Reserved	Reserved
	26	Reserved	Reserved

Note:

✧ ENABLE is recommended to be used as axis IO, because the drive capacity is small.

✧ OVCC, +5V are only used for communication between the controller and the servo driver, please do not use it as power supply for other places.

✧ Except axis 4, other axes are with independent encoder, and corresponding axis No.10 of axis 4 is used as handwheel axis No. by default.

3.7.1. AXIS Interface Signal Specification & Wiring

→ Specification:

Signal	Item	Description
PUL/DIR	Signal type	Differential output signal
	Voltage range	0-5V
	Maximum frequency	10MHz
EA/EB/EZ	Signal type	Differential input signal
	Voltage range	0-5V
	Maximum frequency	5MHz
IN24-35	Input method	NPN leak type, it is triggered when low electric level is input.
	Frequency	< 5kHz
	Impedance	6.8KΩ
	Voltage level	DC24V
	The voltage to open	<10.5V
	The voltage to close	>10.7V
	Minimal current	-1.8mA (negative)
	Maximum current	-4mA (negative)
	Isolation	optoelectronic isolation
OUT16-21	Output method	NPN leak type, it is 0V when outputs
	Frequency	< 8kHz
	Voltage level	DC24V
	Maximum current	+50mA
	Overcurrent protection	No
	Isolation	optoelectronic isolation
+5V，GND	Maximum output current for 5V	50mA
OVCC, EGND	Maximum output current for 24V	50mA

→ Wiring Reference:

Reference example of wiring with Panasonic A5/A6 servo driver:
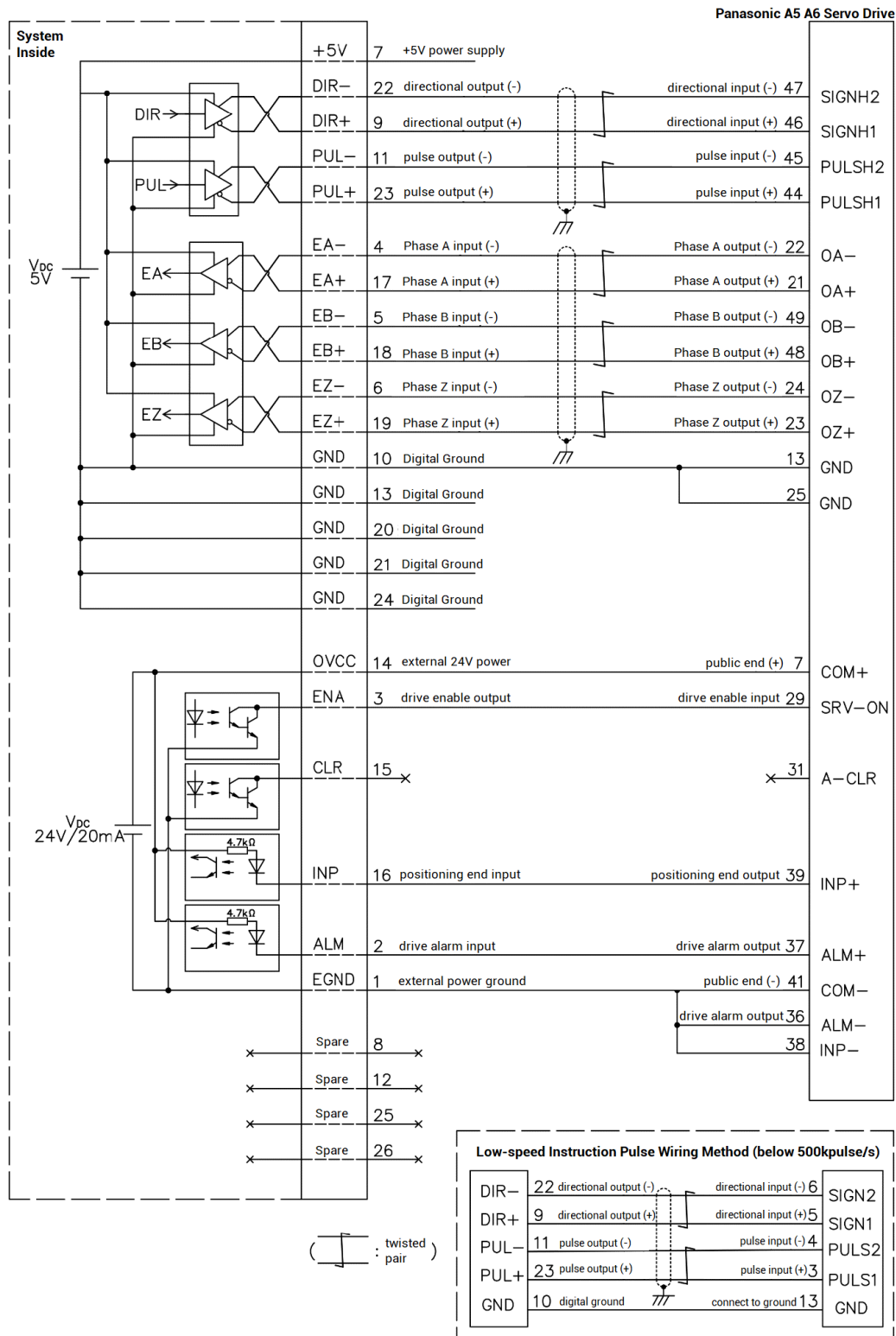
→ **Wiring Note:**

✧ The wiring principle of the differential pulse axis interface is shown in the figure above, and the wiring methods of different types of drivers are different, please connect carefully.

✧ If the speed can meet the requirements, use low-speed differential pulse port preferentially. When high-speed differential pulse interface is used, controller internal digital ground must be connected to drive high-speed pulse reference ground.

✧ If high-speed differential pulse or encoder is connected, GND and drive Pin25 GND must be connected together.

3.7.2. Basic Usage Method

(1) Please follow the above wiring instructions to wiring correctly.

(2) After power on, please use ETHERNET or RS232 (default parameter, it can be connected directly) to connect to ZDevelop.

(3) Set axis parameters, such as, ATYPE, UNITS, SPEED, ACCEL, FWD_IN, REV_IN, etc.

(4) There are many parameters related to pulse axis, they can be set and checked through relative instructions, please see "axis parameter and axis status" of "ZBasic", or see "ZDevelop/View/Axis parameter".

Axis Parameters ✕

Axis select	Parameter select			
	Axis0	Axis1	Axis2	Axis3
COMMENT				
ATYPE	0	0	0	0
UNITS	1	1	1	1
ACCEL	10000	10000	10000	10000
DECEL	0	0	0	0
SPEED	1000	1000	1000	1000
CREEP	100	100	100	100
LSPEED	0	0	0	0
MERGE	0	0	0	0
SRAMP	0	0	0	0
DPOS	0	0	0	0
MPOS	0	0	0	0
ENDMOVE	0	0	0	0
FS_LIMIT	200000000	200000000	200000000	200000000
RS_LIMIT	-200000000	-200000000	-200000000	-200000000
DATUM_IN	-1	-1	-1	-1
FWD_IN	-1	-1	-1	-1
REV_IN	-1	-1	-1	-1
IDLE	-1	-1	-1	-1
LOADED	-1	-1	-1	-1
MSPEED	0	0	0	0
MTYPE	0	0	0	0
NTYPE	0	0	0	0
REMAIN	0	0	0	0
VECTOR_BUFFERED	0	0	0	0
VP_SPEED	0	0	0	0
AXISSTATUS	0h	0h	0h	0h
MOVE_MARK	0	0	0	0
MOVE_CURMARK	-1	-1	-1	-1
AXIS_STOPREASON	0h	0h	0h	0h
MOVES_BUFFERED	0	0	0	0

Axis Parameters | Help | Property |

(5) Control corresponding motion through "View – Manual".

Manual ✕

Axis	ATYPE	UNITS	ACCEL	DECEL	SPEED	DPOS	LeftVMove	RightVMove	Distance	Absolute		MPOS	IDLE	AXISSTATUS	
0 ▾	0	1.000	10000.0	0.000	1000.00	0.000	Left	Right		☐	Move	0.000	-1	0h	Stop
1 ▾	0	1.000	10000.0	0.000	1000.00	0.000	Left	Right		☐	Move	0.000	-1	0h	Stop
2 ▾	0	1.000	10000.0	0.000	1000.00	0.000	Left	Right		☐	Move	0.000	-1	0h	Stop
3 ▾	0	1.000	10000.0	0.000	1000.00	0.000	Left	Right		☐	Move	0.000	-1	0h	Stop
4 ▾	0	1.000	10000.0	0.000	1000.00	0.000	Left	Right		☐	Move	0.000	-1	0h	Stop
5 ▾	0	1.000	10000.0	0.000	1000.00	0.000	Left	Right		☐	Move	0.000	-1	0h	Stop

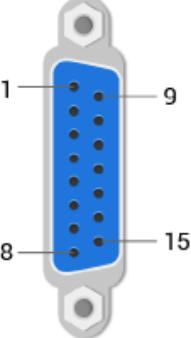**Refer to BASIC Routine:**

```
BASE(0,1)                 'select axis 0 and axis 1
ATYPE = 1,1               'set axis 0 and axis 1 as pulse axes
UNITS = 1000,1000         'set pulse amount as 1000 pulses
SPEED = 10,10             'set axis speed as 100*1000 pulse/s
ACCEL = 1000,1000         'set axis acceleration as 1000*1000 pulse/s/s
FWD_IN = -1,-1            'prohibit using axis positive hardware position limit
REV_IN = -1,-1            'prohibit using axis negative hardware position limit
MOVE(10) AXIS(0)          'axis 0 moves distance of 10*1000 pulses in positive
MOVE(-20) AXIS(0)         'axis 0 moves distance of 20*1000 pulses in negative
```

3.8. Handwheel Interface

This product provides one interface that is specialized for local handwheel encoder axis, and the interface is double standard DB15 female socket.

→ Interface Definition

Interface	Pin	Signal	Description
	1	H-5V	The positive pole of 5V power supply, which supplies power only for handwheel
	2	HA-	Encoder signal phase A (IN36)
	3	HB-	Encoder signal phase B (IN37)
	4	HEMGN	Emergency stop signal (IN47)
	5	NC	Spare (reserved)
	6	HX1	Select the ration as X1 (IN38)
	7	HX10	Select the ration as X10 (IN39)
	8	HX100	Select the ration as X100 (IN40)
	9	HSU	Select axis 3 (IN44)
	10	NC	Spare (reserved)
	11	EGND	External power ground
	12	NC	Spare (reserved)
	13	HSZ	Select axis 2 (IN43)
	14	HSY	Select axis 1 (IN42)
	15	HSX	Select axis 0 (IN41)

3.8.1. Handwheel Specification & Wiring

→ Specification

Item	IN(36-44, 47)
Input Mode	NPN leakage type, input will be triggered when there is low electric level
Frequency	<5kHz (recommendation)
Impedance	510Ω
Voltage (max)	24V
Voltage to open	<2.8
Voltage to close	>2.9V
Current (min)	-1.8mA (negative)
Current (max)	-5.5mA (negative)
Isolation	optoelectronic isolation
The max output current of 5V power (H-5V, EGND)	100mA

→ Wiring Reference
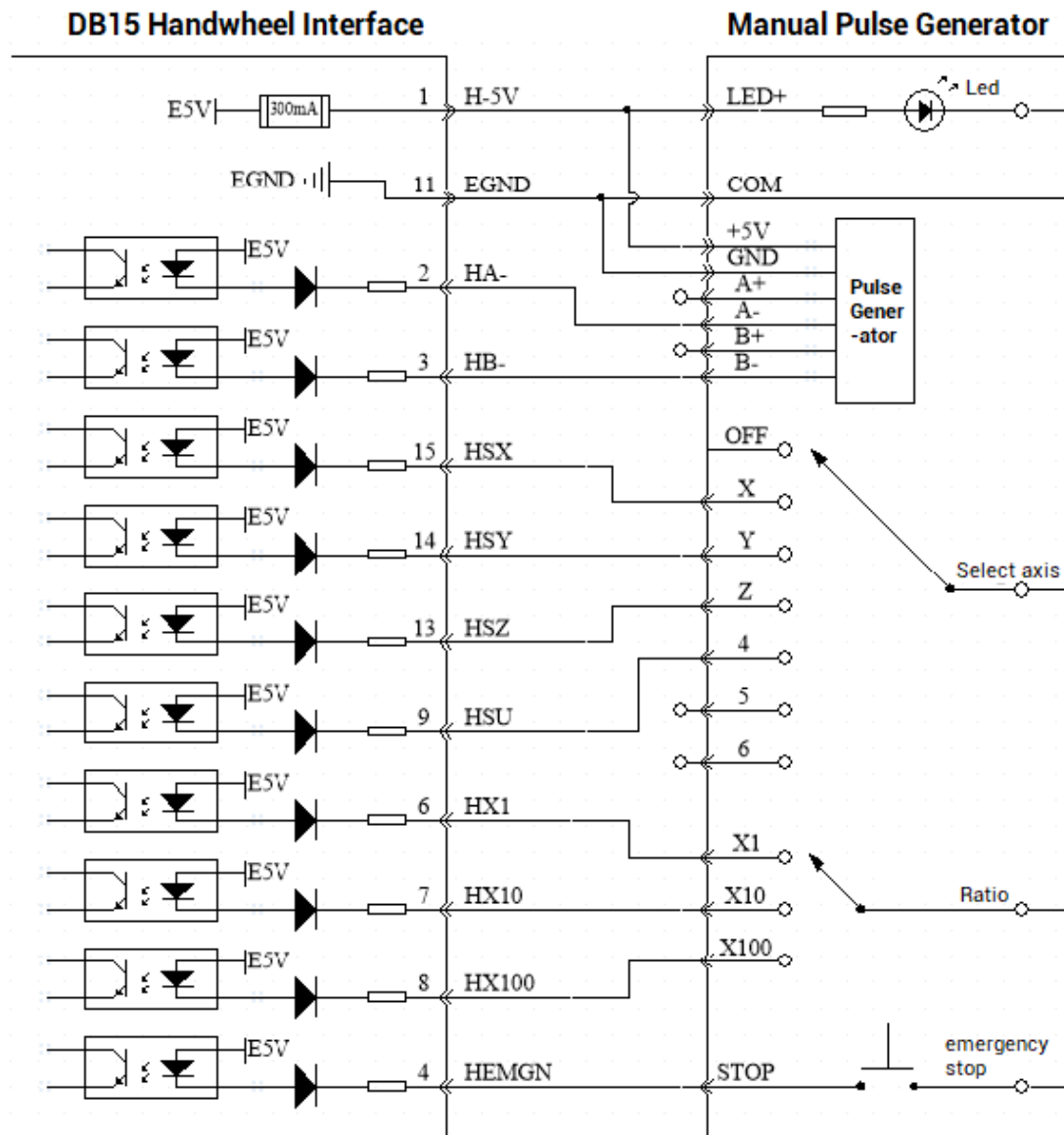
→ Wiring Note

● The wiring principle of handwheel encoder axis interface is shown above, the design of handwheel is very rich, please pay attention to do connection.

● Please use STP, especially in bad environments, and make sure the shielding layer is fully grounded.

● IN36-IN47 on handwheel only support 5V electric level input, they can't be used as 24V general input. For products whose hardware ID after 1909***** could compatible 5-24V electric level, and they can be used as 24V standard general input.

3.8.2. Basic Usage Method

1.   Refer to above handwheel wiring graphic, correctly connect the handwheel and controller.

2.   After powered on, please select ETHERNET or RS232 to connect to ZDevelop.

3.   Configure axis No., if there is no default AXIS axis No. (axis 10, 11, 12, 13 are recommended) of controller handwheel interface, remapped must be done. Followings are processes (for ECI2618, handwheel axis is axis 6 by default, no need to remap):

4.   Configure IO: assign axis selection (HSX, HSY, HSZ, HSU) and ratio (HX1, HX10, HX100) and emergency stop (HEMGN) functions as required. These signals are essentially digital input signals with fixed numbers but no fixed functions. It needs ZDevelop development (the axis selection is the connected axis of "connect" synchronization motion, and the ratio is the "connect" ratio.

5.   When completed above steps, it can start to use handwheel.

BASIC Routine Reference:

```
BASE(6)                    'select axis 6
ATYPE(6) = 3               'set manual pulse axis type as quadrature encoder
UNITS(6) = 1               'set the unit as pulse for pulse amount of manual pulse axis
CONNECT(100,6) AXIS(0)
'axis 0 connects to manual pulse axis at the synchronous ration of 100
```

Chapter IV Expansion Module

The control card can expand digital IO and analogs AD/DA through CAN bus, ZIO series CAN bus expansion modules or ZMIO310-CAN series bus expansion modules can be selected. For details, please refer to corresponding user manuals.

4.1. CAN Bus Expansion Wiring

The ZIO expansion module is powered by the dual power supply. Except the main power supply, an additional IO power supply is required to supply independent power for IO. Both the main power supply and the IO power supply use 24V DC power supply. For ZAIO, it only needs to connect to the main power supply.

To prevent interference, separate the IO power supply from the main power supply.

Please select the expansion module according to the requirements, and select IO mapping or axis mapping according to the resources of the expansion module.

Wiring reference of connection between ZIO expansion module and control card and standard wiring of CAN bus are shown as below (take ZMC408SCAN and ZIO1616 as the example):
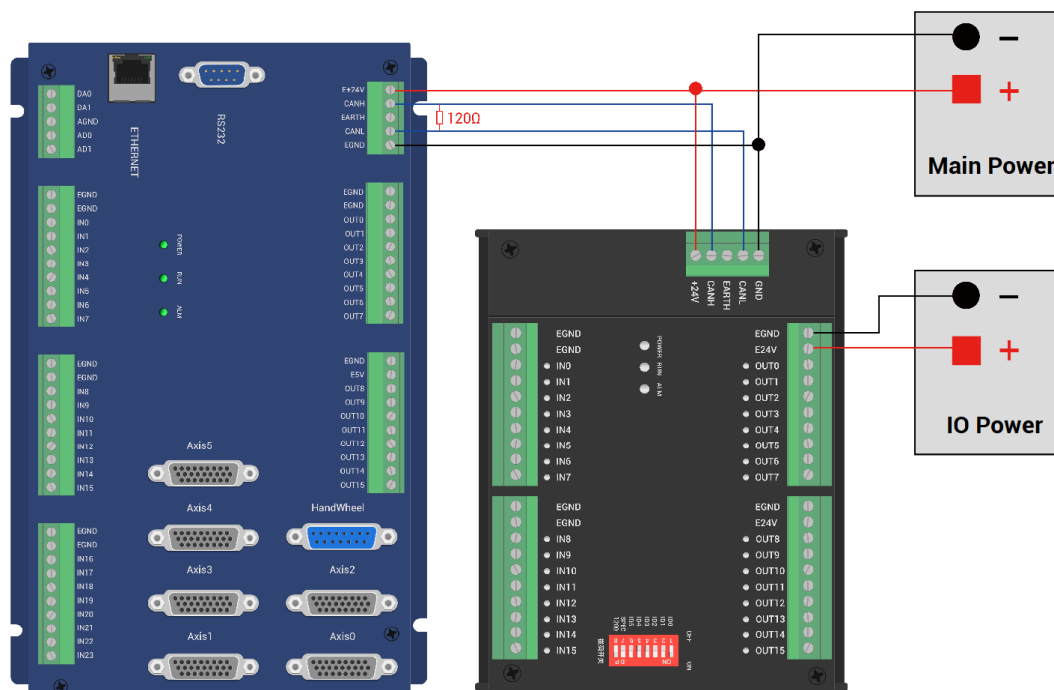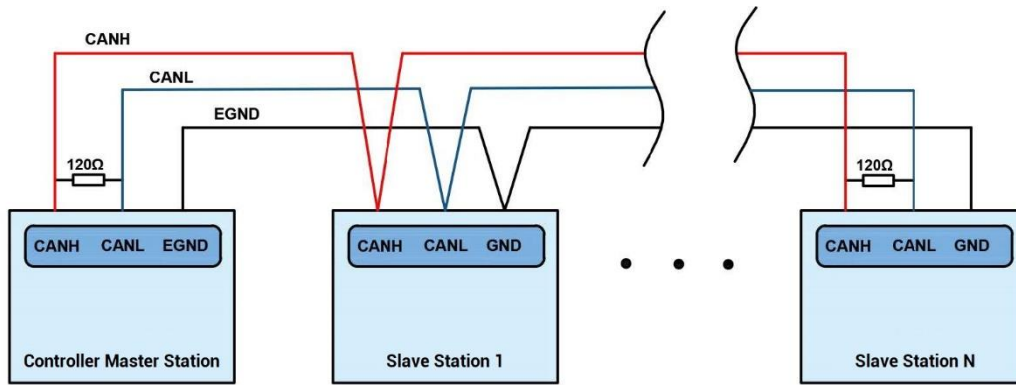
→ Wiring Note:

✧ ECI2618 control card uses dual-power, and ZIO expansion module uses dual-power. When using, main power supply of expansion module and main power supply of controller can share one power. When they use different power supplies, controller power EGND needs to connect to expansion module power GND, otherwise CAN may be burnt out.

✧ When connecting multiple ZIO expansion modules on the CAN bus, a 120-ohm resistor needs to be connected in parallel between the CANL and CANH terminals, for the ZIO expansion module that is with 8-digit dialing codes, the terminal resistor can be realized by dialing the code (DIP).

4.2. CAN Bus Expansion Resource Mapping
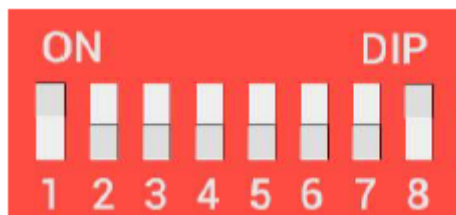
The ZCAN expansion module generally has an 8-bit DIP switch, dial ON to take effect, and the meaning of the DIP is as follows:

1-4: they are used for ZCAN expansion module IO address mapping, the corresponding value is 0-15.

5-6: CAN communication speed, corresponding value is 0-3, four different speeds are optional.

7: reserved.

8: 120 ohm resistor, dial ON means a 120 ohm resistor is connected between CANL and CANH.

The IO numbers of the entire control system cannot be repeated, and existed numbers must be avoided when mapping resources. And the DIP switch must be dialed before power-on, if re-dial after power-on, it is invalid. It needs to be powered on again to take effect.

Dial 1-4 to select the CAN address, and the controller sets the IO number range of the corresponding expansion module according to the CAN DIP address. When each is dialed as OFF, the corresponding value is 0, when it is ON , it corresponds to a value of 1, and the address combination value = dial 4 × 8 + dial code 3 × 4 + dial code 2 × 2+ dial code 1.

Dial code 5-6 to select CAN bus communication speed, speed combination value=dial code 6 × 2 + dial code 5×1, the combined value range is 0-3.

The corresponding speeds are as follows:

DIP 5-6 combination value	CANIO_ADDRESS high 8-bit value	CAN communication speed
0	0 (corresponds to decimal 128)	500KBPS (default value)
1	1 (corresponds to decimal 256)	250KBPS
2	2 (corresponding to decimal 512)	125KBPS
3	3 (corresponding to decimal 768)	1MBPS

The controller side sets the CAN communication speed through the CANIO_ADDRESS command. There are also four speed parameters that can be selected. The communication speed must be consistent with the communication speed of the expansion module that corresponds to the combination value, then they can communicate with each other.

The factory default communication speed is 500 KBPS on both sides, there is no need to set this, unless you need to change the speed.

The CANIO_ADDRESS command is a system parameter, and it can set the master-slave end of CAN communication. The default value of the controller is 32, that is, CANIO_ADDRESS=32 is the master end, and the slave end is set between 0-31.

The CAN communication configuration can be viewed in the "State the Controller" window.

→ IO Mapping:

the CAN expansion module uses bit1-4 of the DIP switch. According to the number of currently included IO points(the largest number in IN and OP must include IO point in the axis interface), use the bit 1-4 to set the ID, so as to determine the number range of IO

to be expanded.

If the controller itself contains 28 INs and 16 OPs, then the starting address set by the first extended board should exceed the maximum value of 28. According to below rule, the dial code should be set to the combination value 1 (binary combination value 0001, from right to left, dial code 1-4, at this time dial 1 is set to ON, and the others are set to OFF), the IO number on the expansion board = the expansion board number value + the initial IO number value, among them, the IOs that are vacant from 29-31 Numbers are not used. Subsequent extended boards continue to confirm the dial settings according to the IO points in turn.

The initial digital IO mapping number starts from 16 and increases in multiples of 16. The distribution of digital IO numbers corresponding to different dial IDs is as follows (expansion board DIP ID of ECI2168 motion control card starts from 2 at least, therefore, starting IO number should start from 48 at least):

DIP 1-4 combination value	Starting IO number	End IO number
0	16	31
1	32	47
2	48	63
3	64	79
4	80	95
5	96	111
6	112	127
7	128	143
8	144	159
9	160	175
10	176	191
11	192	207
12	208	223
13	224	239
14	240	255
15	256	271

The initial IO mapping number of the analog AD starts from 8 and increases in multiples of 8. The initial IO mapping number of the analog DA starts from 4 and increases in multiples of 4. The allocation of digital IO numbers corresponding to different dial code IDs is as follows:

DIP 1-4	Starting AD	End AD	Starting DA	End DA

combination value	number	number	number	number
0	8	15	4	7
1	16	23	8	11
2	24	31	12	15
3	32	39	16	19
4	40	47	20	23
5	48	55	24	27
6	56	63	28	31
7	64	71	32	35
8	72	79	36	39
9	80	87	40	43
10	88	95	44	47
11	96	103	48	51
12	104	111	52	55
13	112	119	56	59
14	120	127	60	63
15	128	135	64	67

→ Axis Mapping:

When the CAN bus expansion mode is used to expand the pulse axis, 2 pulses axes are extended. These two pulse axes need to be mapped and bound with the axis No., then access.

Extended axes need to perform axis mapping operations, using the AXIS_ADDRESS command to map, and the mapping rules are as follows:

AXIS_ADDRESS(axis No.)=(32*0)+ID

'the local axis interface of the expansion module AXIS 0

AXIS_ADDRESS(axis No.)=(32*1)+ID

'the local axis interface of the expansion module AXIS 1

The ID is the combined value of the DIP bit1-4 of the expansion module. After the mapping is completed and the axis parameters such as ATYPE are set, the expansion axis can be used.

Example:

ATYPE(6)=0   'set as virtual axis

AXIS_ADDRESS(6)=1+(32*0)

        'ZCAN expansion module ID 1 axis 0 is mapped to axis 6

ATYPE(6)=8   'ZCAN extended axis type, pulse direction stepping or servo

UNITS(6)=100 0 'pulse equivalent 1000

SPEED(6)=100   'speed 100uits/s

ACCEL(6)=1000   'acceleration 1000units/s^2

MOVE(100) AXIS(6) 'extended axis movement 100units

Extended resource viewing:

According to the CAN connection, after the power is turned on, and the wiring resistance dial code is set correctly, the power indication led (POWER) and the running indication led (RUN), the IO power indication led (IO POWER) are on, and the alarm indication led (ALM) is off. At the same time, the "Controller" - "State the controller" - "ZCanNodes" in the ZDevelop software displays the expansion module information and the extended IO number range.

The dial ID and the corresponding resource number when connecting multiple expansion modules are as follows:

Local	432-0(ZMC432)	32	30(0-29)	18(0-17)	0	2(0-1)
1	48(ZIO1632)	0	16(32-47)	32(32-63)	0	0
3	26(ZIO16082)	2	16(64-79)	8(64-71)	0	0
4	10(ZAIO0802)	0	0	0	8(40-47)	2(20-21)
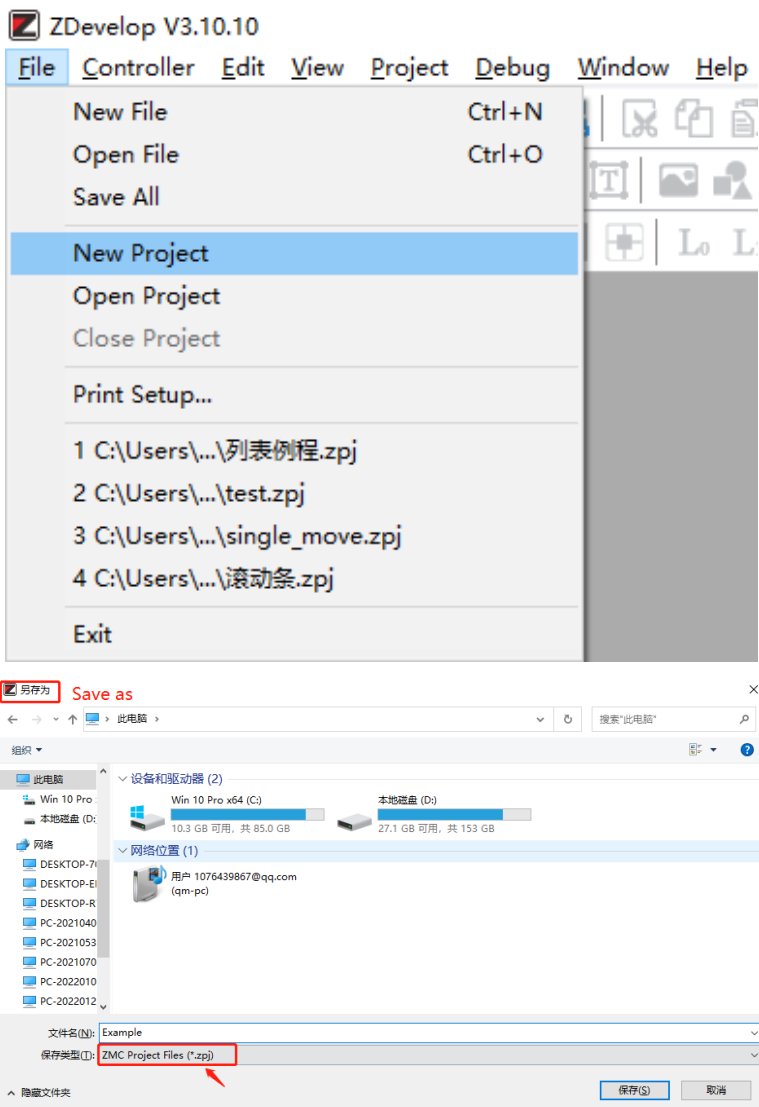
ALMRM indicator light is on, please check whether the wiring, resistor and dial setting are correct, and whether the CANIO_ADDRESS command of the controller is set as the master end (32), and whether the CAN communication speed is consistent.
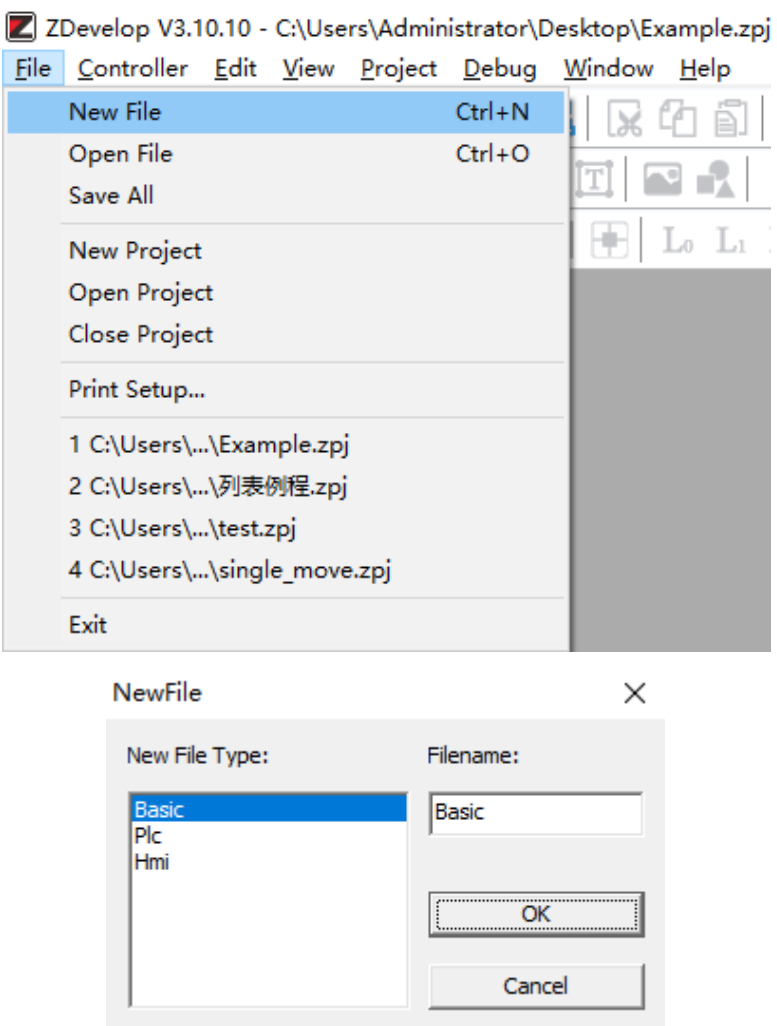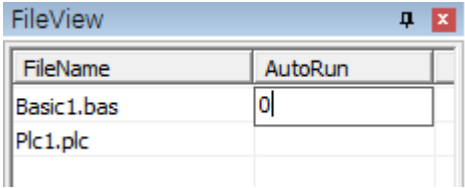
Chapter V Expansion Module
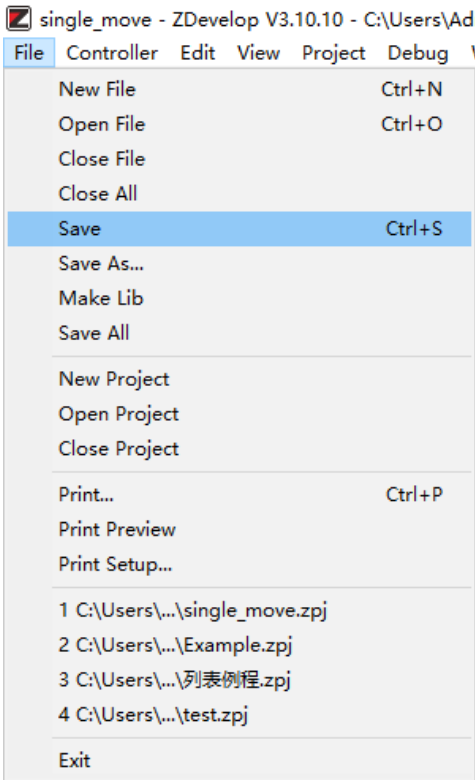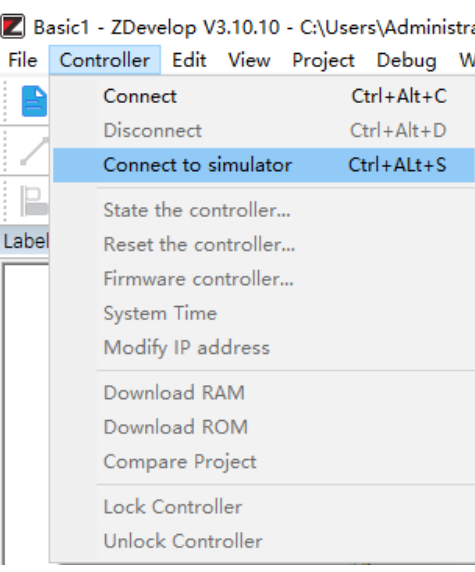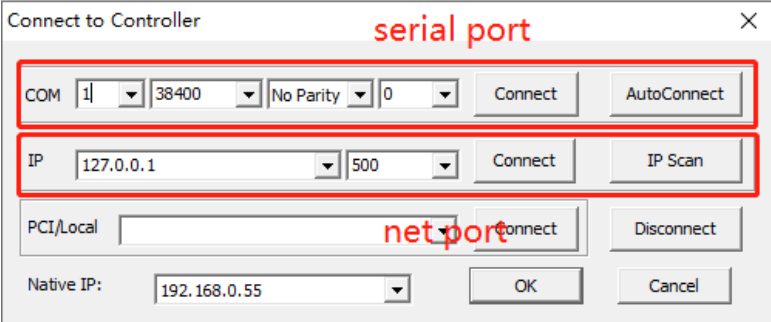
5.1. ZDevelop Software Usage
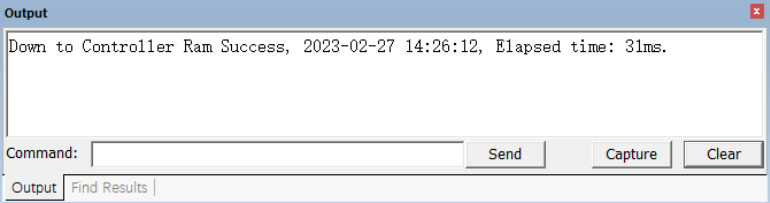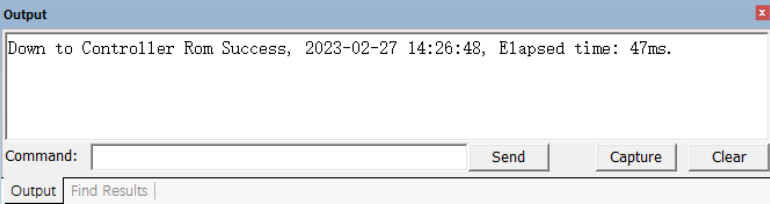
ZDevelop is a PC-side program development, debugging and diagnostic software for the ZMoiton series motion controllers of Zmotion Technology. Through it, users can easily edit and configure the controller program, quickly develop applications, diagnose system operating parameters in real time, and watch the motion controller. The running program is debugged in real time and supports Chinese and English bilingual environments.
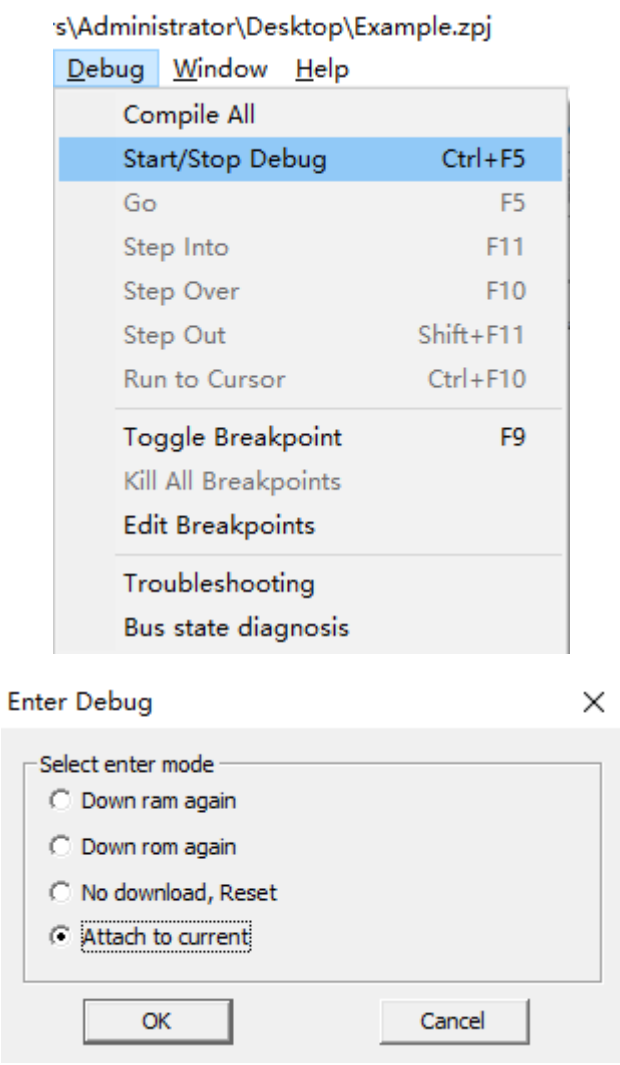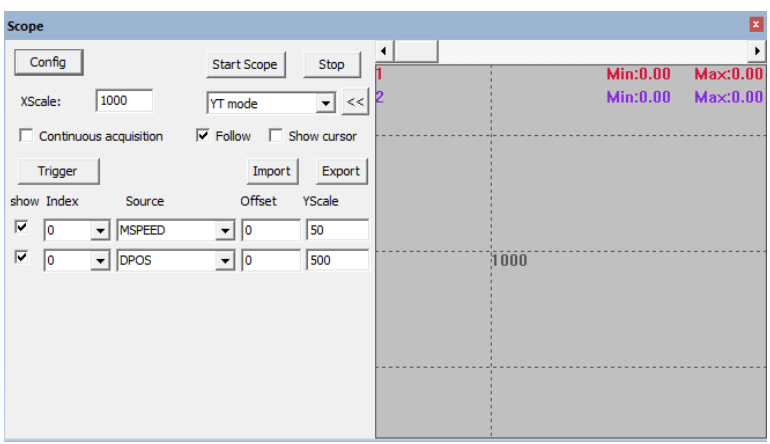
ZBasic, ZPLC and ZHMI can run multi-tasks, and ZBasic can run multi-tasks, and can be mixed with ZPLC and ZHMI.

Step	Operations	Display Interface
1	Open ZDevelop, click "File" – "New Project", Save as window will pop up, then enter file name, save the project file with suffix "zpj.".	

2	Click "File" – "New File", select file type to build, here select Basic, click "OK".	
3	Double click "AutoRun", enter task number 0.	

4	Edit the program in program editing window, click "save", new built basic file will be saved under "zpj." project automatically. "Save all" means all files under this project will be saved.	
5	Click "controller – connect", if no controller, select connect to simulator.	
	Then, "connect to controller" window will pop up, you can select serial port or net port to connect, select matched serial port	

	parameters or net port IP address, then click "connect".	
6	Click "Ram/Rom" – "download RAM / download ROM", if it is successful, there is print indication, at the same time, program is downloaded into controller and runs automatically. RAM: it will not save when power off. ROM: it will save data when power off, and when the program is connected to controller again, running according to task number.	**Output** Down to Controller Ram Success, 2023-02-27 14:26:12, Elapsed time: 31ms. Command: [ ] Send Capture Clear Output Find Results **Output** Down to Controller Rom Success, 2023-02-27 14:26:48, Elapsed time: 47ms. Command: [ ] Send Capture Clear Output Find Results

7	Click "Debug" – "Start/Stop Debug" to call "Task" and "Watch" window, because it was downloaded before, here select "Attach the current".	
8	Click "View" – "Scope" to open oscilloscope.	

Note:

● When opening an project, choose to open the zpj file of the project. If only the Bas file is opened, the program cannot be downloaded to the controller.

● When the project is not created, only the Bas file cannot be downloaded to the controller.

● The number 0 in automatic operation represents the task number, and the program

	runs with task 0, and the task number has no priority.
●	If no task number is set for the files in the entire project, when downloading to the controller, the system prompts the following message WARN: no program set autorun

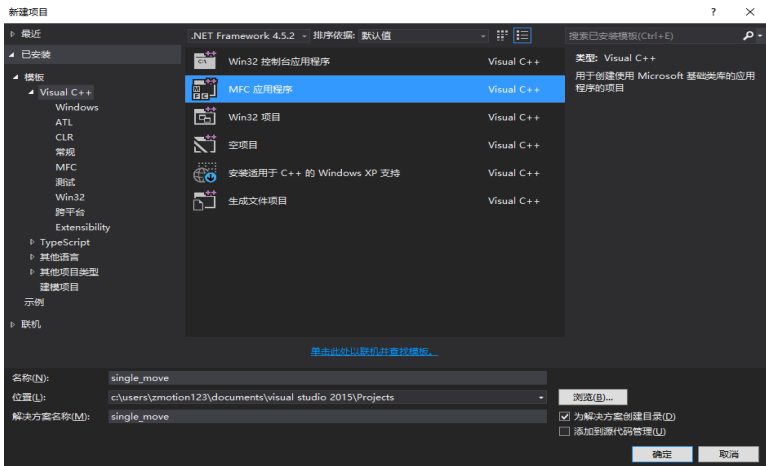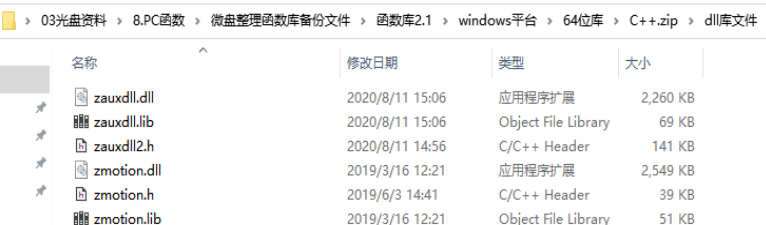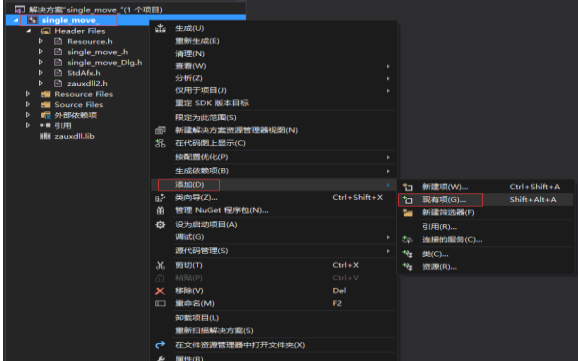# 5.2. PC Upper-Computer Program Application

The controller supports development under various operating systems such as windows, linux, Mac, Android, and wince, and provides dll libraries in various environments such as vc, c#, vb.net, and labview, as shown in the figure below. PC software programming refers to "ZMotion PC Function Library Programming Manual".

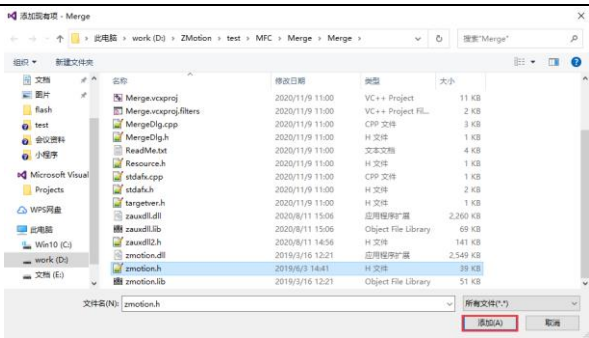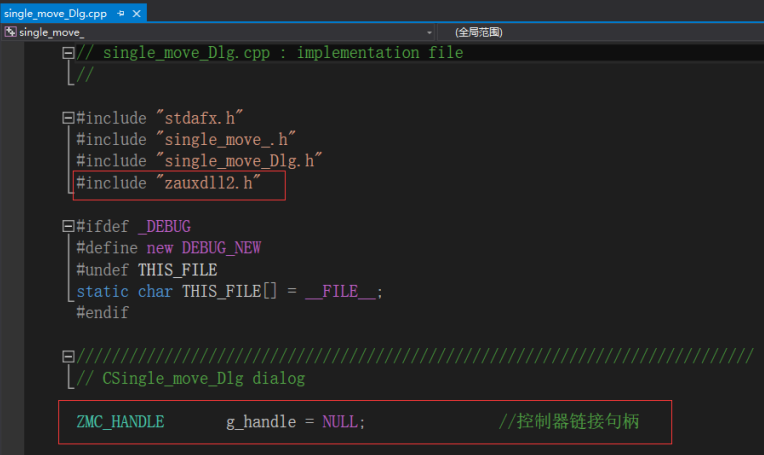The program developed using the PC software cannot be downloaded to the controller, and it is connected to the controller through the dll dynamic library. The dll library needs to be added to the header file and declared during development.

The c++ project development process in VS is as follows:

Step	Operations	Display Interface
1	Open VS, click "File" – "New" – "Project".	

2	Select development language as "Visual C++" and the select program type as "MFC application type".	
3	Select "Based on basic box", click "next" or "finish"	
4	Find C++ function library provided by manufacturer. Routine is below (64-bit library)	
5	Copy all DLL related library files under the above path to the newly created project.	
6	Add a static library and related header files to the project. Static library: zauxdll.lib,	1) Right-click the header file first, and then select: "Add" → "Existing	

	zmotion.lib	Item".	
	Related header files: zauxdll2.h, zmotion.h	2) Add static libraries and related header files in sequence in the pop-up window.	
7	Declare the relevant header files and define the controller connection handle, so far the project is newly created.		

Chapter VI Run and Maintain

The correct operation and maintenance of the device can not only guarantee and extend the life cycle of the equipment itself, but also take technical management measures according to the pre-specified plan or the corresponding technical conditions to prevent equipment performance degradation or reduce the probability of equipment failure.

6.1. Regular Inspection and Maintenance

The working environment has an impact on the device. Therefore, it is usually inspected regularly based on the inspection cycle of 6 months to 1 year. The inspection cycle of the device can be appropriately adjusted according to the surrounding environment to make it work within the specified standard environment.

Check item	Check content	Inspection standards
power supply	Check whether the voltage is rated	DC 24 V (-10%~10%)
surroundings	Whether the ambient temperature is within the specified range (when installed in the cabinet, the temperature inside the cabinet is the ambient temperature)	-10°C - 55°C
	Whether the ambient humidity is within the specified range (when installed in the cabinet, the humidity in the cabinet is the ambient humidity)	10%-95% non-condensing
	Is there direct sunlight	No
	With or without droplets of water, oil, chemicals, etc.	No
	Whether there is dust, salt, iron filings, dirt	No
	Whether there is corrosive gas	No
	Whether there are flammable and explosive gases or articles	No

	Whether the device is subjected to vibration or shock	Should be within the range of vibration resistance and impact resistance
	Is the heat dissipation good	Keep good ventilation and heat dissipation
Installation and Wiring Status	Whether the basic unit and the expansion unit are installed firmly	The mounting screws should be tightened without loosening
	Whether the connecting cables of the basic unit and the expansion unit are fully inserted	The connection cable cannot be loosened
	Are the screws of the external wiring loose	Screws should be tightened without loosening
	Whether the cable is damaged, aged, cracked	The cable must not have any abnormal appearance

6.2. Common Problems

Problems	Suggestions
Motor does not rotate.	6. Check whether the ATYPE of the controller is correct. 7. Check whether hardware position limit, software position limit, alarm signal work, and whether axis states are normal. 8. Check whether motor is enabled successfully. 9. Confirm whether pulse amount UNITS and speed values are suitable. If there is the encoder feedback, check whether MPOS changes. 10. Check whether pulse mode and pulse mode of drive are matched. 11. Check whether alarm is produced on motion controller station or drive station. 12. Check whether the wiring is correct. 13. Confirm whether controller sends pulses normally.
The position limit signal is	1. Check whether the limit sensor is working normally,

invalid.	and whether the "input" view can watch the signal change of the limit sensor. 2. Check whether the mapping of the limit switch is correct. 3. Check whether the limit sensor is connected to the common terminal of the controller.
No signal comes to the input.	1. Check whether the limit sensor is working normally, and whether the "input" view can watch the signal change of the limit sensor. 2. Check whether the mapping of the limit switch is correct. 3. Check whether the limit sensor is connected to the common terminal of the controller.
The output does not work.	1. Check whether IO power is needed. 2. Check whether the output number matches the ID of the IO board.
POWER led is ON, RUN led is OFF.	1. Check whether the power of the power supply is sufficient. At this time, it is best to supply power to the controller alone, and restart the controller after adjustment. 2. Check whether the ALM light flickers regularly (hardware problem).
RUN led is ON, ALM led is ON.	1. Program running error, please check ZDevelop error code, and check application program.
Fail to connect controller to PC through serial port.	1. Check whether the serial port parameters are modified by the running program, you can check all the current serial port configurations through ?*SETCOM. 2. Check whether the serial port parameters of the PC match the controller. 3. Open the device manager and check whether the serial driver of the PC is normal.
CAN expansion module cannot be connected.	1. Check the CAN wiring and power supply circuit, whether the 120 ohm resistor is installed at both ends.

	2. Check the master-slave configuration, communication speed configuration, etc. 3. Check the DIP switch to see if there are multiple expansion modules with the same ID. 4. Use twisted-pair cables, ground the shielding layer, and use dual power supplies for severe interference (the main power supply of the expansion module and the IO power supply are separately powered)
Fail to connect controller to PC through net port.	1. Check IP address of PC, it needs to be at the same segment with controller IP address. 2. Check controller IP address, it can be checked and captured after connection through serial port. 3. When net port led is off, please check wiring. 4. Check whether controller power led POWER and running indicator led RUN are ON normally. 5. Check whether the cable is good quality, change one better cable to try again. 6. Check whether controller IP conflicts with other devices. 7. Check whether controller net port channel ETH are all occupied by other devices, disconnect to other devices, then try again. 8. When there are multiple net cards, don't use other net cards, or change one computer to connect again. 9. Check PC firewall setting. 10. Use "Packet Internet Groper" tool (Ping), check whether controller can be Ping, if it can't, please check physical interface or net cable. 11. Check IP address and MAC address through arp-a.