

Ocean Controls KTA-193 Modbus Programmable Stepper Motor Controller

The Ocean Controls Modbus Programmable Stepper Motor Controller is a four axis multifunction programmable stepper motor controller which utilises the modbus protocol for communications.

The Modbus Programmable Stepper Motor Controller is designed for use as an alternative to an expensive PLC for simple process type applications. It can be used as a standalone controller to control up to 4 stepper motors and I/O or in conjunction with a PLC to control stepper motors

Using a PC and the supplied program "StepModb" a user can develop a program and then download it via a RS232 serial link, into the controllers non volatile (EEPROM) memory. Alternatively the controller can be controlled via a PLC using the modbus protocol. The controller communicates at **9600 baud, 8 data, Even Parity and 1 Stop bit.**

Up to four stepper motors can be used concurrently. Each Motor has its own direction and step outputs. If a motor is not being used the two outputs for the motor can be used as general outputs for control purposes. Four digital inputs are present and these can be used as limit switches for the stepper motors or as general inputs for program control. Additionally, two SPST relays rated to 5A at 277VAC or 30VDC have been added and are controlled by the Dig On/Off command.

Instructions available are:

Name	Description
Absolute move	Moves motors to an absolute position. Tripping the limit switch stops the motor moving and advances to the next instruction. Allowed values: -32767 to 32767
Relative move	Moves motors a number of steps relative to the current position. Tripping the limit switch stops the motor moving and advances to the next instruction. Allowed values: -32767 to 32767
Relative move then wait for Lim Sw	Moves motors relative to the current position and then waits for the limit switch to be tripped. Allowed values: -32767 to 32767
Wait Milliseconds	Waits a number of milliseconds x 0.07 (approx). Allowed values: 1 to 32767
Digital Output On/Off	Sets unused outputs on or off according to the value. Allowed values: see note for output on parameter
Max rate of stepping	Sets the maximum rate of stepping for each of the motors, in milliseconds x 0.07 (approx). Allowed values: 1 to 9999
Start rate	Sets the minimum rate of stepping for each of the motors, in milliseconds x 0.07 (approx). Allowed values: 0 to 9999
Acceleration increment	Sets the increment used when accelerating from the start rate to the maximum rate, in milliseconds x 0.07 (approx). Allowed values: 1 to 9999
Set Position	Set the current position of the motors to a new value. Allowed values: -32767 to 32767
Jump to instruction	Jump to any instruction Allowed values: 1 to 127
Wait for input	Wait for a limit switch to be high, rising edge or falling edge. Allowed values: see note for input parameter
Conditional Jump	Jumps to an instruction if a certain input is present. The single parameter defines which input must be present and which instruction to jump to.

Holding Registers:

Instructions are loaded into the controllers memory to what are called Modbus Holding Registers. The registers 1 to 20 are control registers and the registers 21 to 276 are available for program space.

The Holding Registers are:

No.	Description	Read/Write
1	Parameter 1 of current instruction	R
2	Parameter 2 of current instruction	R
3	Parameter 3 of current instruction	R
4	Parameter 4 of current instruction	R
5	Function code of current instruction	R
6	Status of Motor 1	R
7	Status of Motor 2	R
8	Status of Motor 3	R
9	Status of Motor 4	R
10	Position of Motor 1	R
11	Position of Motor 2	R
12	Position of Motor 3	R
13	Position of Motor 4	R
14	Line Number of current instruction	R
15	Single Stepping Enable	R/W
16	Single Stepping Step	R/W
17	Single Stepping Ready	R
18	Stop	R/W
19	No of motors (1 to 4)	R/W
20	Control Register	R/W
21-276	Program space	R/W

- 1-4: These registers hold the parameters of the current instruction being executed
5: This is the type of instruction
6-9: The status of each motor is shown, each bit in the status registers represents the following

Bit	16	8	4	2	1
Desc.	Limit Switch A	Done	Limit Switch B	Direction	Moving

Limit Switch A is current status of limit switch 1 = ON

Done is 1 if this parameter has finished executing

Limit Switch B is 1 if the limit switch has gone from off to on in this instruction

Direction is 0 if forward and 1 if reverse

Moving is 1 if the motor is moving

- 10-13: These registers hold the current position of each of the motors
14: This is the number of the instruction currently being executed
15: Write 1 to this register to allow the controller to single step through instructions
16: Write 1 to this register to execute one instruction when in single stepping mode
17: This register is 1 when the program is ready to execute the next instruction when in single stepping mode
18: If 1 the controller will not perform any operation
19: The number of motors to use
20: This is the Control Register. Writing 0 to this register will make the program stop executing, a positive number will make the program execute that number of times and a negative number will make the program run indefinitely.
21-276: This is the program space

Memory Allocation:

Program space is allocated in the following manner.

Each command begins with the function code of the instruction in the first register, and then a number of parameters consecutively in the next registers. The number of parameters is always equal to the number of motors. This means that the start of each command is at registers

- 21,23,25,27... For 1 motor
- 21,24,27,30... For 2 motors
- 21,25,29,33... For 3 motors
- 21,26,31,36... For 4 motors

This allows for more commands to be stored in memory, if fewer motors are used.

The number of commands available in each case are:

No. of motors	Max no. of commands
1	120
2	80
3	60
4	50

The Function Codes and parameters of the instructions are

No.	Description	Param1	Param2	Param3	Param4
1	Absolute move	Target 1	Target 2	Target 3	Target 4
2	Relative move	Target 1	Target 2	Target 3	Target 4
3	Relative move then wait for Lim Sw	Target 1	Target 2	Target 3	Target 4
4	Wait Milliseconds	Time to wait	DC	DC	DC
5	Dig On/Off	Output Param	DC	DC	DC
6	Max rate of stepping	Max Rate 1	Max Rate 2	Max Rate 3	Max Rate 4
7	Start rate	Start rate 1	Start rate 2	Start rate 3	Start rate 4
8	Acceleration increment	Increment 1	Increment 2	Increment 3	Increment 4
9	Set Position	Position 1	Position 2	Position 3	Position 4
10	Jump to instruction	Instruction No.	DC	DC	DC
11	Wait for input	Input Param	DC	DC	DC
12	Conditional Jump	Input No. and Instruction No.	DC	DC	DC
Anything Else	Jump to instruction 1	DC	DC	DC	DC

DC=Don't Care

Note: There must be a register space for the DC

The Output Parameter determines which digital outputs to turn on or off

Bit	128	64	32	16	8	4	2	1
Desc.	REL2	REL1	S2	D2	S3	D3	S4	D4

1=output on 0=output off

Only outputs which are not being used as motors can be used.

The Input Parameter determines which of the switches to wait for

Bit	2048	1024	512	256	128	64	32	16	8	4	2	1
Desc.	L1F	L1R	L1H	L2F	L2R	L2H	L3F	L3R	L3H	L4F	L4R	L4H

F=Falling R=Rising H=High

If multiple bits are set, any of the conditions being met will make the program advance to the next instruction.

The Conditional Jump Parameter is one 16 bit number split into 12 and 4 bits. The 4 LSB's define which limit switch input or inputs must be present to allow the jump to take place, the 12 MSB's will determine the instruction number to Jump to.

MSB	16	8	4	2	1
12 bits for instruction number			L1	L2	L3	L4

Assembly & Testing the Kit:

All the components are mounted on the dual layer PCB. The list of parts is shown on page 7 of this manual.

Start by soldering the resistors and diodes and then the capacitors and crystal. Next add the IC sockets, voltage regulator and DIP switch. Finally add the terminals and 9 pin D connectors, noting the placement of the male and female connectors.

To test the controller, connect 12V (or 24V for KTB-193) positive to the Vs Terminal and negative to the COM terminal and measure the voltage across pins 10 and 20 of the socket for the 74HC245, ensuring that it is 5V. If this is ok remove the power and insert the microcontroller, MAX232 and solder in the 74HC245.

Using the controller:

The controller requires 9-26VDC to power it. Apply the supply positive to the Vs Terminal and negative to the COM terminal.

A connection to a PC should be made using a **standard RS-232 D9-pin straight through Male to Female cable.**

Limit switches need to be normally open (NO) switches, which are connected between the limit switch input (L1-L4) and a COM terminal.

Motor driver step inputs are connected to the step outputs (S1-S4) of the controller and direction connections are connected to the dir outputs (D1-D4). A common connection will need to be made as well and this is done by connecting to a COM terminal.

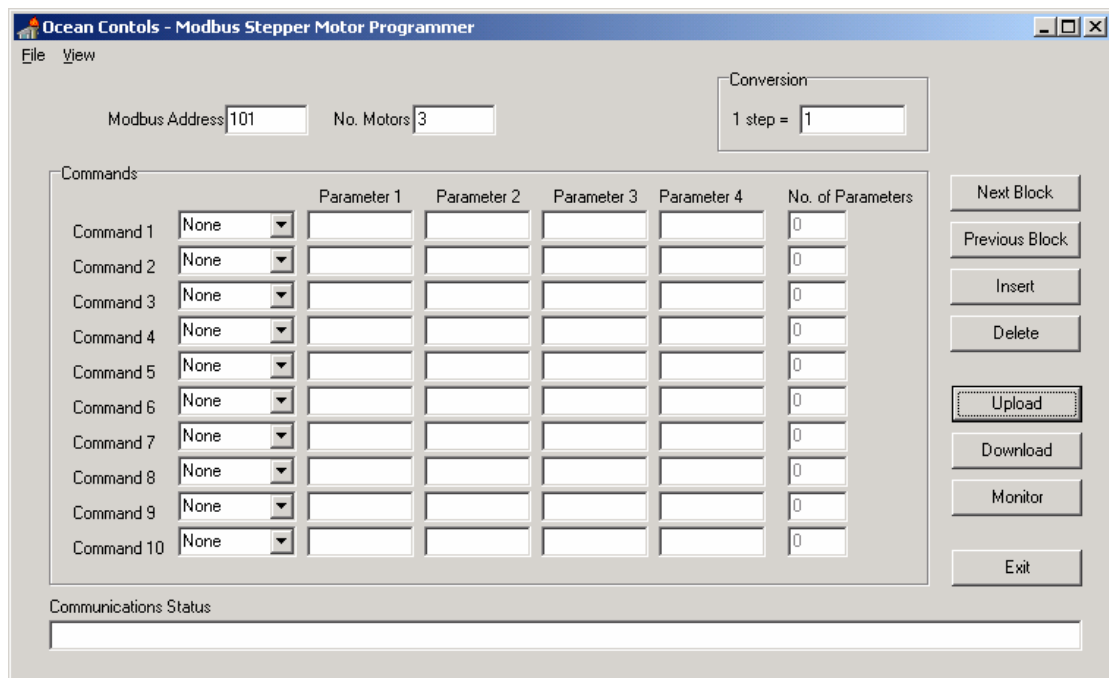
If less than four motors are used the motors are connected to the lowest numbered outputs. The unused outputs will be available for digital control.

The modbus address of the controller is set by the DIL switches, as shown in the following table.

S1	S2	Address
0	0	101
0	1	102
1	0	103
1	1	104

This allows up to four controllers to be used on the one serial port.

The software provided the CD called StepModb.exe can be used to program the controller. The main screen of the software is shown in the figure below.



First set the Comm Port to match the Comm port to which the controller is attached. Do this by going to View-> Comm Port and then select the correct port number from the list. **Also set the Parity to Even.**

Set the Modbus Address to match the address of the controller you wish to use, and then set the number of motors.

The conversion parameter can be used as a scaling factor. For example you may wish to work in millimeters and you know 1 Step =0.5mm. So enter 0.5 in the conversion box.

Writing Programs

The program can now be written for the controller. To get you started quickly an example program called "Example" is provided on the CD. To load the program Click File->Load then select Example from the list of files. A program will be displayed showing the commands for setting the Start Rate and Rate and then moving the motor 1 to position 10000, waiting and then back to position 0

To enter an instruction in the program select an instruction from the drop down list and add the parameters you require. The No. of Parameters box indicates how many parameters are associated with the command.

The window displays 10 commands at a time to move to the Next 10 commands click on the Next Block button. To move to the Previous 10 commands click on the Previous Block button. Commands can be inserted or removed by using the Insert and Delete buttons.

Programs can be stored on the PC by going to File-> Save.

To load a program saved earlier, go to File-> Load.

To view the program in the controller click Upload.

Once all the commands required have been entered, click Download to send the program to the controller. **Communications to the card is OK if characters received from the card are displayed in the communications status box.**

When a program has been downloaded turn the power off to the KTA-193 and then on again.

Running the Program

Once the program has downloaded click Monitor to bring up the Monitoring Window, shown below.

Set the number of times you wish the program to run in the Passes textbox. Use -1 if you wish the program to run indefinitely. Click Start to run the program.

The Halt button in the Emergency Stop group will stop the controller mid instruction and the Normal button will return the controller to normal operation.

Current Instruction			
Pass Number	-1	Passes	-1
Line Number	3	Start	Return
Function Code	Input	Emergency Stop	
Parameter 1	16	<input type="checkbox"/> Stopped	Halt Normal
Parameter 2		Single Stepping	
Parameter 3		<input type="checkbox"/> Enable	Enable Disable
Parameter 4		<input type="checkbox"/> Ready	Step

Motor Status			
Motor 1 Status	0	Motor 1 Position	0
Motor 2 Status	0	Motor 2 Position	0
Motor 3 Status	0	Motor 3 Position	0
Motor 4 Status	16	Motor 4 Position	

The Monitoring Window shows various parameters on the status of the controller including the current motor positions and status, as well as information on the instruction currently being executed.

In the **Single Stepping** group, click Enable to put the controller into single stepping mode. When the Ready box is checked the controller has completed its first command and is ready to start the next one. Click Step to execute the next command. The Ready checkbox will become unchecked until the controller has finished executing the command, at which point the Ready checkbox will be checked again and the process can be repeated.

Please Note- After downloading a new program. Turn off and on the power to the card to ensure the program restarts at command 1

Example Process Programs:

1. Injection Molding Process

In this example a single stepper motor drives a syringe which slowly pushes material into a mould, and then quickly returns to its home position, where an indicator is lit and the controller waits for an operator to push a button to restart the process.

Set the number of motors to 1.

Connect the stepper motor to the S1, D1 and COM terminals.

Connect an 'Operate' Switch between the L4 and COM terminals.

Connect a 'Go' Pushbutton between the L3 and COM terminals.

Connect a 'Ready' indicator and power to the REL1 terminals.

Command No.	Instruction	Parameter	Description
1	Wait	100	Wait 100 ms so that command 2 can work properly
2	Wait Input	2	Wait for the Operate switch to go from Off to On (In the event of power failure, this ensures that the machinery does not operate until the operator has ensured the machinery is in the start position and the switch is switched Off and then On again)
3	Set Posn	0	Sets the current position of the motor to be the home position
4	Start Rate	20	Set the starting rate of the stepper motor to 20
5	Accel Incr	1	Set the acceleration increment to 1
6	Wait Input	1	Wait for the Operate switch to be in the On position
7	Dig On/Off	64	Turn on the Ready indicator
8	Wait Input	16	Wait for the Go button to go from Off to On
9	Dig On/Off	0	Turn off the Ready indicator
10	Rate	10	Set the speed of the motor to 10 (slow)
11	Abs Move	1000	Move slowly forwards 1000 steps (Injection)
12	Rate	1	Set the speed to 1ms (fast)
13	Abs Move	0	Go back to the home position quickly
14	Jump To	5	Jump to command 5

Enter these commands and click Download.

Put -1 in the No. of Passes box and click Start to make the controller run indefinitely.

PLC Control:

To use the Modbus Stepper Motor Controller with a PLC follow these steps:

1. Write the number of motors to holding register 19
2. Write 0 to register 20
3. Disconnect and reconnect power to the stepper motor controller
4. Write the instructions (Function code and Parameters) to be executed, to the registers beginning at 21 (see earlier section on allocation of program space)
5. Write 0 to the register following the final register of the instruction which was written
6. Write 1 to register 20 to begin execution
7. Wait for register 20 to return to 0
8. Repeat steps 4 to 8 for each group of instructions

Writing anything other than 0 to register 18 will halt program execution immediately, normal operation will only return when register 18 is 0. This register is stored in memory and is retained if power is lost.

November 2006

The top speed of the Modbus programmable stepper motor controller has been increased to approximately 4.7KHz. All parameters previously measured in milliseconds are now approximately 0.2 x Value in milliseconds. This gives the higher top speed and more discrete speeds can be used.

September 2007

The "Conditional Jump" command has been added, this allows the program to jump or branch to a different section of program if certain input conditions are met.

August 2008

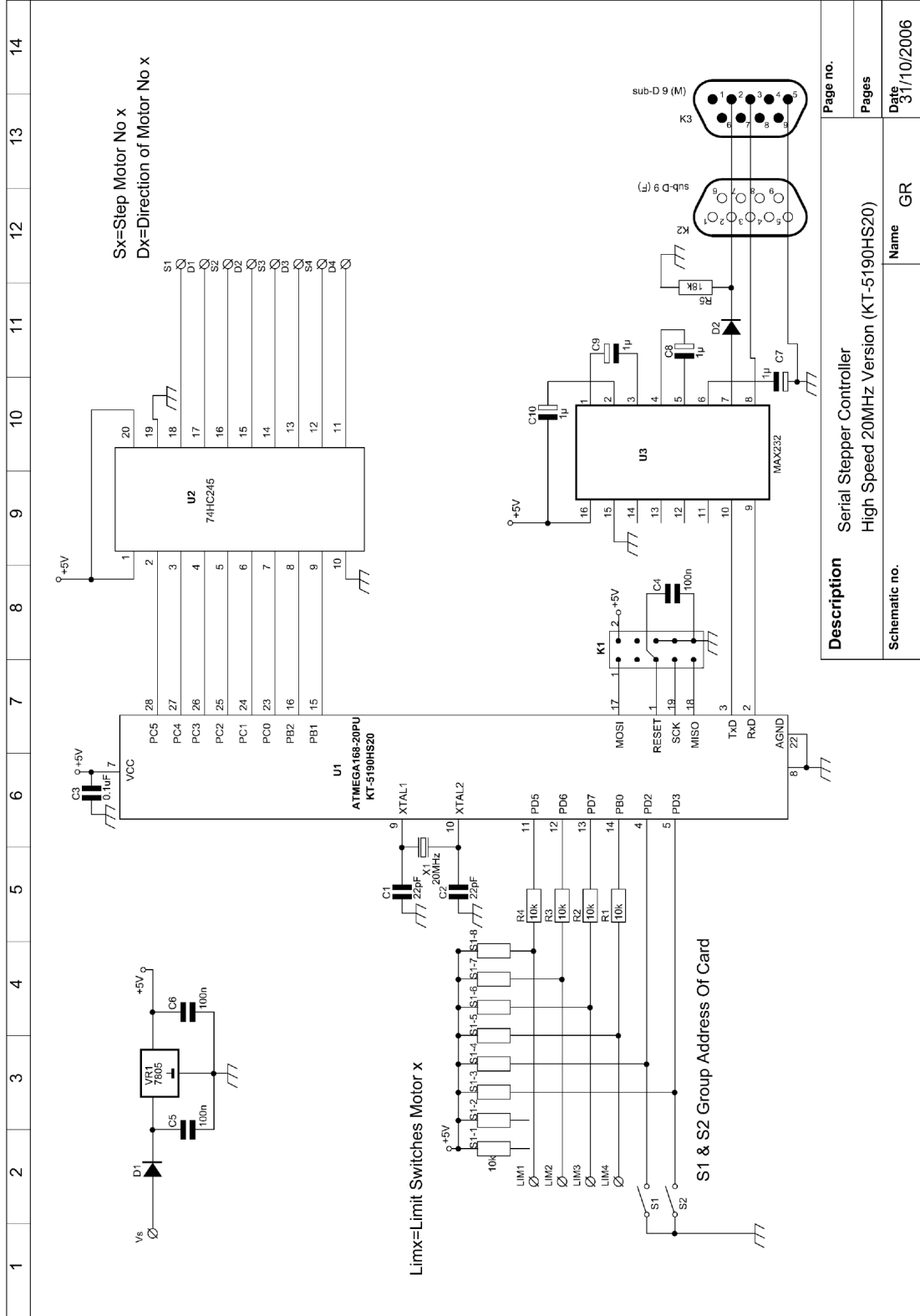
Two relays have been added, these are controlled by the Dig On/Off command. To accommodate for the relays, K3, the D9 male connector has been changed to IDC pins which means an additional cable is required to connect multiple units together. This cable is available separately.

The addition of the relays means the controller is now available as 12V or 24V DC powered. The 12V version is KTA-193 and the 24V version is KTB-193.

December 2008

The top speed of the Modbus programmable stepper motor controller has been increased to approximately 14.5KHz. All parameters previously measured in milliseconds are now approximately 0.07 x Value in milliseconds. This gives the higher top speed and more discrete speeds can be used.

Circuit Diagram:



Note: V3 Circuit shown, V4 Contains 2 x SPST Relays

Description	Serial Stepper Controller	Page no.
	High Speed 20MHz Version (KT-5190HS20)	Pages
Schematic no.	Name	Date
	GR	31/10/2006