

# Yaskawa Sigma EtherCAT<sup>®</sup> Drives Supported by EDGE<sup>®</sup> Connect CNC

Application Note

809910 | Revision 4 | November 2025

**Hypertherm, Inc.**

21 Great Hollow Road, P.O. Box 5010  
Hanover, NH 03755 USA  
603-643-3441 Tel (Main Office)  
603-643-5352 Fax (All Departments)  
info@hypertherm.com (Main Office)

**800-643-9878 Tel (Technical Service)**

technical.service@hypertherm.com (Technical Service)

**800-737-2978 Tel (Customer Service)**

customer.service@hypertherm.com (Customer Service)

**Hypertherm México, S.A. de C.V.**

52 55 5681 8109 Tel  
52 55 5681 7978 Tel  
soporte.tecnico@hypertherm.com (Technical Service)

**Hypertherm Plasmatechnik GmbH**

Sophie-Scholl-Platz 5  
63452 Hanau  
Germany  
00 800 33 24 97 37 Tel  
00 800 49 73 73 29 Fax

**31 (0) 165 596900 Tel (Technical Service)****00 800 4973 7843 Tel (Technical Service)**

technicalservice.emeia@hypertherm.com (Technical Service)

**Hypertherm (Singapore) Pte Ltd.**

Solaris @ Kallang 164  
164 Kallang Way #03-13  
Singapore 349248, Republic of Singapore  
65 6841 2489 Tel  
65 6841 2490 Fax  
marketing.asia@hypertherm.com (Marketing)  
techsupportapac@hypertherm.com (Technical Service)

**Hypertherm Japan Ltd.**

Level 9, Edobori Center Building  
2-1-1 Edobori, Nishi-ku  
Osaka 550-0002 Japan  
81 6 6225 1183 Tel  
81 6 6225 1184 Fax  
htjapan.info@hypertherm.com (Main Office)  
techsupportapac@hypertherm.com (Technical Service)

**Hypertherm Europe B.V.**

Laan van Kopenhagen 100  
3317 DM Dordrecht  
Nederland  
31 165 596907 Tel  
31 165 596901 Fax  
31 165 596908 Tel (Marketing)  
**31 (0) 165 596900 Tel (Technical Service)**  
**00 800 4973 7843 Tel (Technical Service)**  
technicalservice.emeia@hypertherm.com (Technical Service)

**Hypertherm (Shanghai) Trading Co., Ltd.**

B301, 495 ShangZhong Road  
Shanghai, 200231  
PR China  
86-21-80231122 Tel  
86-21-80231120 Fax

**86-21-80231128 Tel (Technical Service)**

techsupport.china@hypertherm.com (Technical Service)

**South America & Central America: Hypertherm Brasil Ltda.**

55 11 5116-8015 Tel  
tecnico.sa@hypertherm.com (Technical Service)

**Hypertherm Korea Branch**

#3904. APEC-ro 17. Heaundae-gu. Busan.  
Korea 48060  
82 (0)51 747 0358 Tel  
82 (0)51 701 0358 Fax  
marketing.korea@hypertherm.com (Marketing)  
techsupportapac@hypertherm.com (Technical Service)

**Hypertherm Pty. Limited**

Level 57, 25 Martin Place  
Sydney, New South Wales, 2000.  
+61 (02) 9238 2138 Tel  
www.hyperthermassociates.com

**Hypertherm (India) Thermal Cutting Pvt. Ltd**

A-18 / B-1 Extension,  
Mohan Co-Operative Industrial Estate,  
Mathura Road, New Delhi 110044, India  
91-11-40521201 / 2 / 3 Tel  
91-11 40521204 Fax  
htindia.info@hypertherm.com (Main Office)  
technicalservice.emeia@hypertherm.com (Technical Service)

## Introduction

---

The following information is provided to Hypertherm channel partners for reference purposes only, to help you select and configure an EtherCAT® drive that is supported by EDGE Connect® CNCs.

**NOTE:** Work in partnership with your drive manufacturer to select and configure the drives for your cutting system. Refer to your drive manufacturer's drive documentation for technical information about the drives.

When possible, the following information is provided to support integration of the drives with the cutting system and the CNC.

- Drive model supported
- Firmware revision supported
- Example drive amplifier file
- Setup and parameter notes

Setup files and parameters provided by Hypertherm can be used for the initial machine setup. We expect these files and parameters to be modified by the installer for the specific cutting system configuration and desired performance.

**NOTE:** Make sure to follow the guidelines and instructions provided by the drive manufacturer.

## Supported Yaskawa Sigma drives

---

Series	Model	Firmware	Notes
Sigma-5	SGDV	<ul style="list-style-type: none"> <li>• 5.0</li> <li>• 5.04</li> <li>• 6.00</li> </ul>	<ul style="list-style-type: none"> <li>• Analog input is not supported on the drive. An I/O module is required.</li> </ul>
Sigma-7	SGD7S	<ul style="list-style-type: none"> <li>• 0023 - Drive software</li> <li>• 8.04 - EtherCAT (CoE)</li> </ul>	<ul style="list-style-type: none"> <li>• 12 Digital Inputs and 3 Digital Outputs are supported.</li> </ul>
Sigma-X	SGDXS	000F or newer	<ul style="list-style-type: none"> <li>• 1 axis</li> <li>• 7 Digital Inputs and 2 Digital Outputs are supported.</li> </ul>

**NOTE:**

- Mixing different brands of drives in one system is not supported.
- All drives must support and be configured for a 1 ms update rate.
- Many drive amplifiers have I/O available for use. The need for additional I/O modules depends on the total number of I/O and the I/O style required. For a list of supported I/O modules, see the *EtherCAT® Drives and I/O Modules Supported by EDGE® Connect CNCs* Application Note (809660).

- Analog input and Analog output is not supported on the drive. An I/O module is required.

## Drive inputs

**NOTE:** To use Yaskawa digital I/O, set it for general purpose use.

Drive series	Digital inputs	Description
Sigma-5 and Sigma-7	DIN1	Negative limit switch
	DIN2	Home switch
	DIN3	Positive limit switch
	DIN4	SI0:CN1-13pin
	DIN5	SI1:CN1-7pin
	DIN6	SI2:CN1-8pin
	DIN7	SI3:CN1-9pin
	DIN8	SI4:CN1-10pin
	DIN9	SI5:CN1-11pin
	DIN10	pin21
	DIN11	HWBB1 not useable as GPIO
	DIN 12	HWBB2 not useable as GPIO
Sigma-X	DIN1	SI0:CN1-13pin
	DIN2	SI1:CN1-7pin
	DIN3	SI2:CN1-8pin
	DIN4	SI3:CN1-9pin
	DIN5	SI4:CN1-10pin
	DIN6	SI5:CN1-11pin
	DIN7	SI6:CN1-12pin

## Drive outputs

**NOTE:** To use Yaskawa digital I/O, set it for general purpose use.

Drive series	Digital Outputs	Description
Sigma-5 and Sigma-7	DOUT1	SO1: CN1 1-2 pin
	DOUT2	SO2: CN1 23-24 pin
	DOUT3	SO3: CN1 25-26 pin
Sigma-X	DOUT1	SO2:CN1 23-24pin
	DOUT2	SO3:CN1 25-26pin

## Setup and parameters

---

From a high level, the process of setting up your drives is as follows.

1. Install the firmware using the drive software.
2. Set up the drive parameters per the drive manufacturer's instructions.
3. Make sure the drives are communicating on the network.

This section provides assistance with setting up the drive parameters. Work in partnership with your drive manufacturer to set up the drives for your cutting system. Refer to your drive manufacturer's drive documentation for more technical information about the drives.

Also refer to the following sections of the *EDGE® Connect Installation and Setup Manual* (809340).

- Section 3: *Machine stop strategies and table hardware*, for information about:
  - How the CNC enables and disables the drives, and stops motion
  - Drive enable signals
  - Drive Enable output and Drive Disabled input
  - Overtravel limits
  - Safety circuit
- Section 5: *Machine Axes*, for information about:
  - Axis orientation and positive motion
  - Axis assignment and setup
- Section 7: *I/O – Inputs and Outputs*, for information about:
  - How Phoenix® assigns I/O
  - Digital I/O and assignment
  - Analog I/O and assignment

### NOTE:

- All drives must be set up as linear axes.
- All drives must support and be configured for a 1 ms update rate.
- Sigma-7 provides 12 digital inputs and 3 digital outputs
- The drive amplifier firmware can be updated via Hypertherm EtherCAT Studio or TwinCat. Please work with your Yaskawa representative.
- Sigma-7 does NOT support analog outputs or analog inputs

**NOTE:** Phoenix does not support the EU numbering format of using decimal points (periods) as numerical separators. Using decimal points as numerical separators will result in incorrect settings. Example:

Correct - 200,000.00 = Two hundred thousand

Incorrect - 200.000,00 = Two hundred

## Parameters in Drive using Sigma-Win+

There is a limit to the maximum encoder feedback on the edge connect. The following is an example of how to determine the maximum speed vs resolution for your system.

Encoder counts/inch = 1,000,000                      Calculated Maximum Speed = 1966 IPM

Encoder counts/inch = 1,500,000                      Calculated Maximum Speed = 1310 IPM

Encoder counts/inch = 500,000                      Calculated Maximum Speed = 3932

Maximum Axis Speed = (32767\*60000)/Encoder Counts per User Unit

Sigma-Win+ ver7 for Sigma-7 drives and Sigma-Win software for Sigma-5 drives, Use the object editor to set the Motor revolutions object to allow the motor to reach maximum RPM. Then save to EEPROM.

When using Ethercat, set the drives encoder resolution to 20 bits for all encoders.

Entering a 4 into Motor Revolutions Parameter will divide the 1048576 counts/rev by 4 to give 262144 counts/rev over the EtherCAT network.

Parameter	Value
PnB02 Encoder Scaling Numerator	4
Pn002 Disable Absolute Encoder (optional)	X1XX
Pn50A Test Run without any external safety I/O	8881
Pn50B	8888
Pn20E (SigmaX) Encoder Scaling Numerator Note: Target of 252,144 counts/rev	20-bit encoder = 4 24-bit encoder = 64 26-bit encoder = 256

## Calculating encoder counts per mm (inch)

Encoder counts are a position scaling factor used by Phoenix. Refer to the drive manufacturer documentation for specific scaling information required by the drive.

In general, to determine the encoder counts per mm (inch), you need to know the following:

- Counts per revolution of the motor
- Gear ratio
- Distance of travel in one revolution of the pinion gear
- Diameter of the pinion gear when it engages the rack

### Metric example:

Below is an example using more specific sample Yaskawa SGD7S data.

- SGD7S drive with 1,048,576 encoder counts per revolution of the motor
- 4:1 gear ratio
- 150 mm pitch

$$\frac{1,048,576 \text{ encoder counts}}{1 \text{ motor revolution}} \times \frac{4 \text{ motor revolutions}}{1 \text{ pinion revolution}} \times \frac{1 \text{ pinion revolution}}{150 \text{ mm (pitch)}} = 27,962.03 \text{ encoder counts per millimeter}$$

### English example:

Below is an example using more specific sample Yaskawa SGD7S data.

- SGD7S drive with 1,048,576 encoder counts per revolution of the motor
- 4:1 gear ratio
- 5.91 in. pitch

$$\frac{1,048,576 \text{ encoder counts}}{1 \text{ motor revolution}} \times \frac{4 \text{ motor revolutions}}{1 \text{ pinion revolution}} \times \frac{1 \text{ pinion revolution}}{5.91 \text{ in. (pitch)}} = 709,696.11 \text{ encoder counts per inch}$$