Changes for the Better

MITSUBISHI ELECTRIC

CNC
MELDAS 60/60S Series
MELDAS MAGIC 64

PLC INTERFACE MANUAL

BNP-B2211D(ENG)

Introduction

This manual describes the various signal interfaces and functions required when creating MELDAS 60/60S Series or MELDASMAGIC 64 sequence programs (built-in PLC).
This manual also describes the standard PLC (device fixed) that controls the signals between the control unit and the machine.
Read this manual thoroughly before programming.
Thoroughly study the "Safety Precautions" on the following page to ensure safe use of the MELDAS 60/60S Series and MELDASMAGIC 64.

* The "MELDAS60 Series" includes the M64A, M64, M65, M66 and M65V.
* The "MELDAS60S Series" includes the M64AS, M64S, M65S and M66S.

Details described in this manual

⚠ CAUTION

⚠ For items described in "Restrictions" or "Usable State", the instruction manual issued by the machine maker takes precedence over this manual.
⚠ Items not described in this manual must be interpreted as "not possible".
⚠ This manual is written on the assumption that all option functions are added. Refer to the specifications issued by the machine maker before starting use.
⚠ Some screens and functions may differ or may not be usable depending on the NC version.

General precautions

The following documents are available as documents related to the contents of this manual. Refer to these as required.

(1) MELDAS 60/60S Series

MELDAS 60/60S Series PLC Onboard Instruction Manual BNP-B2213
MELDAS 60/60S Series PLC Program Development Instruction Manual
(Personal Computer Section) BNP-B2215
MELDAS 60/60S Series PLC Programming Manual
(Ladder section) BNP-B2212
MELDAS 60/60S Series PLC Programming Manual
(Ladder section with MELSEC) BNP-B2269
MELDAS 60/60S Series DDB Interface Manual BNP-B2214

(2) MELDASMAGIC 64

MELDASMAGIC 64 PLC Onboard Instruction Manual BNP-B2213
MELDASMAGIC 64 PLC Program Development Instruction Manual
(Personal Computer Section) BNP-B2215
MELDASMAGIC 64 PLC Programming Manual
(Ladder section)..... BNP-B2212
MELDASMAGIC 64 DDB Interface Manual..... BNP-B2214

Precautions for Safety

Always read the specifications issued by the machine maker, this manual, related manuals and attached documents before installation, operation, programming, maintenance or inspection to ensure correct use. Understand this numerical controller, safety items and cautions before using the unit.
This manual ranks the safety precautions into "DANGER", "WARNING" and "CAUTION".

⚠ **DANGER**	When there is a great risk that the user could be subject to fatalities or serious injuries if handling is mistaken.
⚠ **WARNING**	When the user could be subject to fatalities or serious injuries if handling is mistaken.
⚠ **CAUTION**	When the user could be subject to injuries or when physical damage could occur if handling is mistaken.

Note that even items ranked as "⚠ **CAUTION**" may lead to major results depending on the situation. In any case, important information that must always be observed is described.

⚠ **DANGER**
There are no "Danger" items in this manual.

⚠ **WARNING**
1. Items related to prevention of electric shocks ⚠ Do not operate the switches with wet hands, as this may lead to electric shocks. ⚠ Do not damage, apply excessive stress, place heavy things on or sandwich the cables, as this may lead to electric shocks.

⚠ CAUTION

1. Items related to product and manual

⚠ For the items described in the "Restrictions" and "Usable State", the instruction manual issued by the machine maker takes precedence over this instruction manual.

⚠ Items not described in this manual must be interpreted as "not possible".

⚠ This manual has been written on the assumption that all options are provided.

⚠ Check the specifications issued by the machine maker before starting use.

⚠ Some screens and functions may differ or may not be usable depending on the NC system version.

2. Items related to connection

❗ When using an inductive load such as relays, always contact a diode in parallel to the load as a noise measure.

❗ When using a capacitive load such as a lamp, always connect a protective resistor serially to the load to suppress rush currents.

3. Items related to design

⚠ Always turn the spindle phase synchronization complete signal ON before chucking both ends of the workpiece to the basic spindle and synchronous spindle. If the spindle phase synchronization signal is turned ON when both ends of the workpiece are chucked to the basic spindle and synchronous spindle, the chuck or workpiece could be damaged by the torsion that occurs during phase alignment.

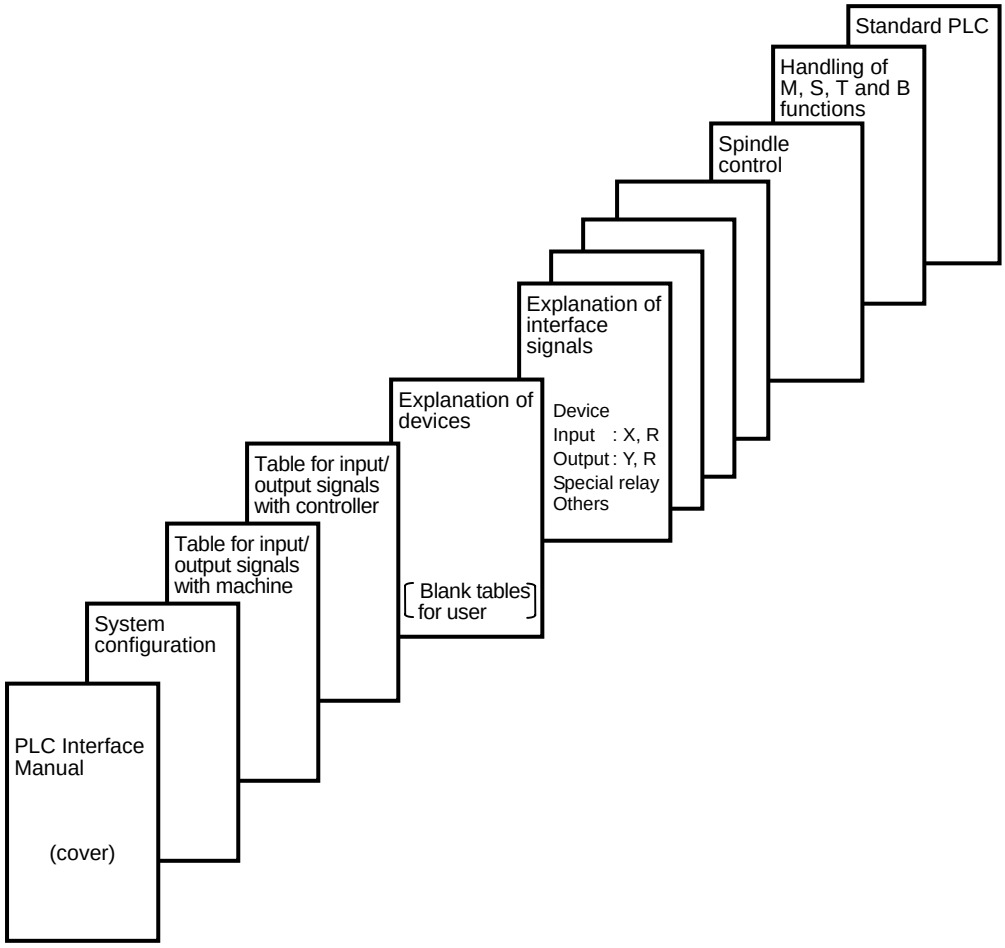
❗ If the temperature rise detection function is invalidated with the parameters, the control could be disabled when the temperature is excessive. This could result in machine damage or personal injuries due to runaway axis, and could damage the device. Enable the detection function for normal use.

CONTENTS

1. OUTLINE

This manual is prepared to assist you to understand the various control signals necessary for creating the sequence program for the MELDAS 60/60S Series or MELDASMAGIC 64.

The manual is composed as shown below. Refer to related sections as necessary to gain the maximum benefit from the manual.



(Caution)

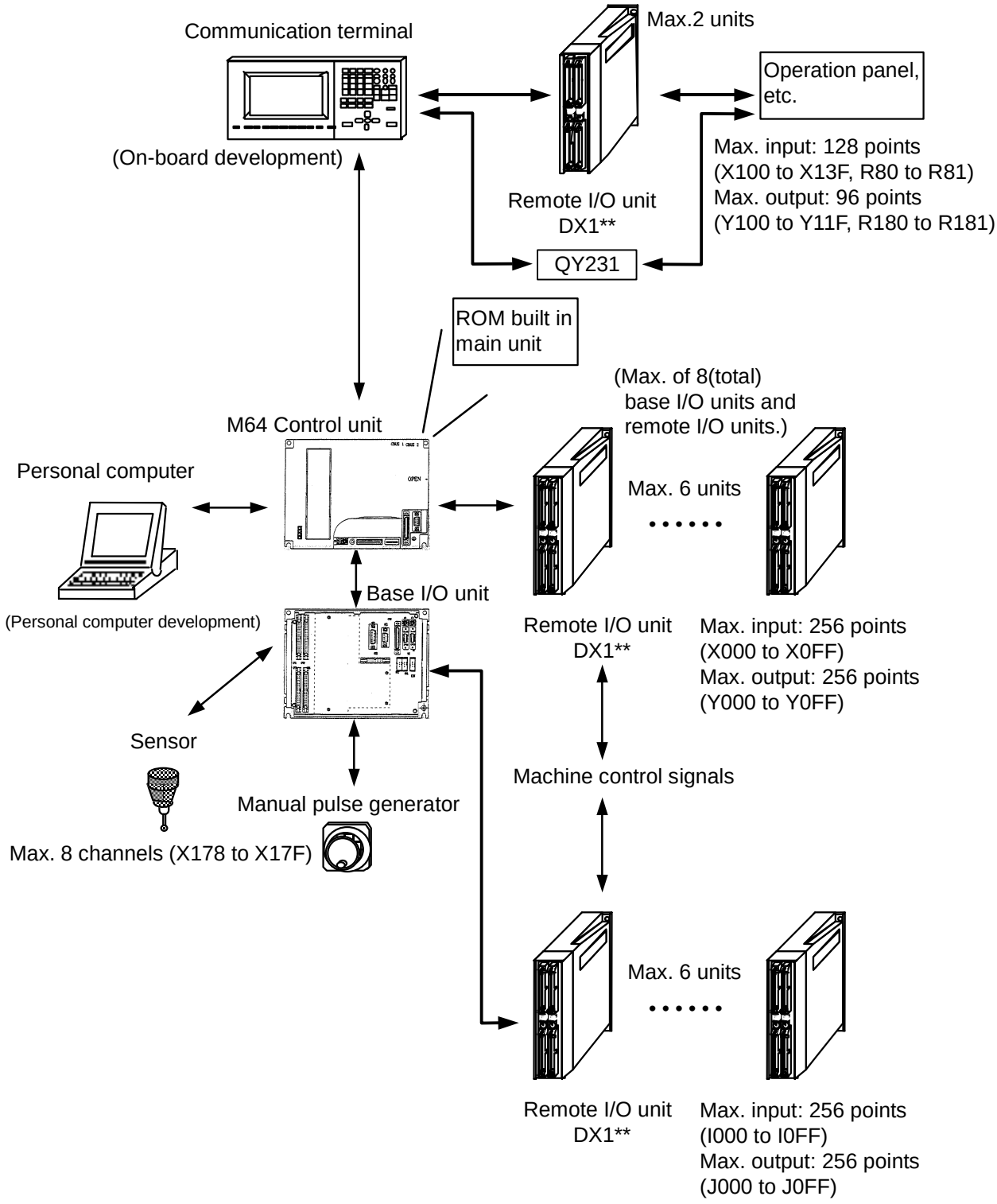
Please note that the specifications referred to in the text represents the maximum specifications which include also those under development.

(Note) The "controller" mentioned in this manual indicates the "NC card" for the MELDASMAGIC 64.

2. SYSTEM CONFIGURATION

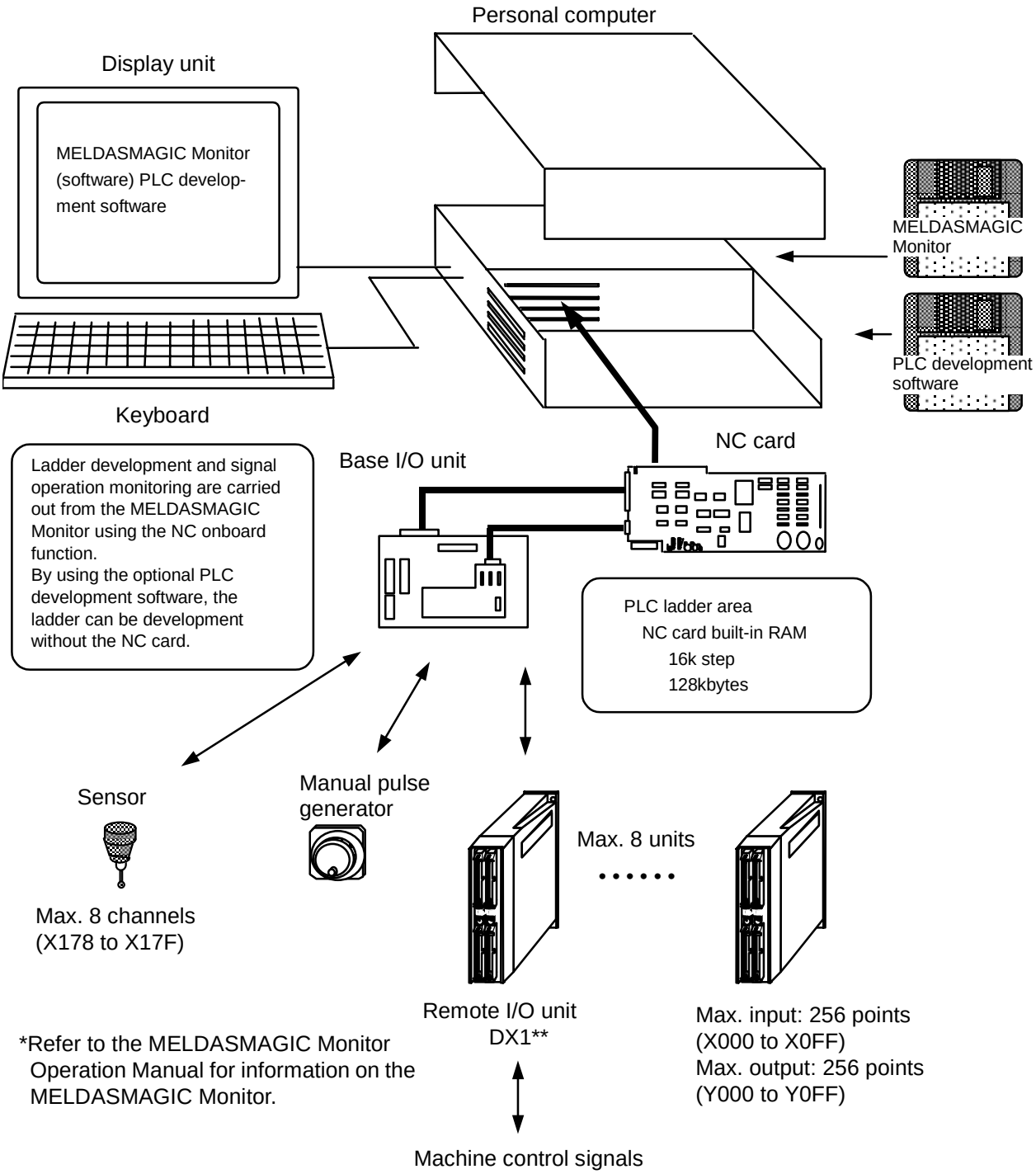
(1) For MELDAS 60/60S

The system configuration for PLC development is shown below.



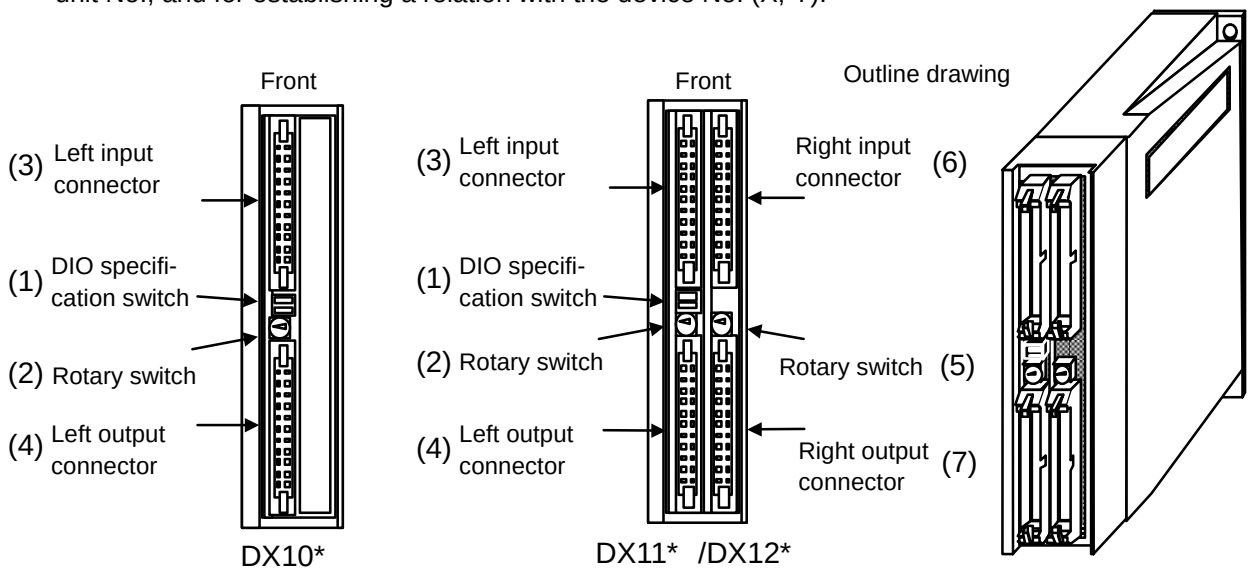
(2) For MELDASMAGIC 64

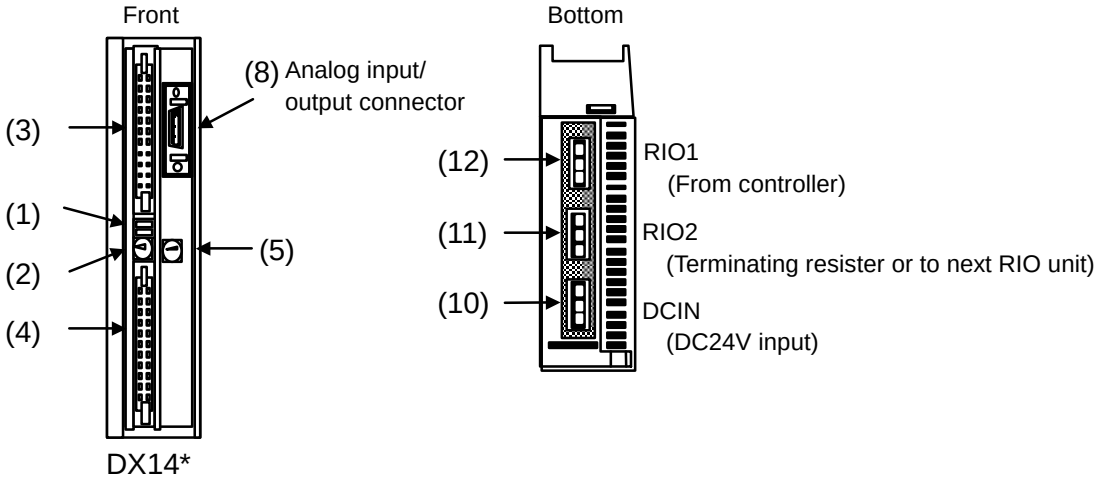
The system configuration for PLC development is shown below.



2.1 Relation of RIO Unit and Devices

Eight types of remote I/O units (hereafter RIO unit) are available as shown below. The specifications of each, DX10*, DX11*, DX12* and DX14* (* is "0" or "1") differ. Each unit has a rotary switch for setting the unit No., and for establishing a relation with the device No. (X, Y).





No. of remote I/O unit input/output points

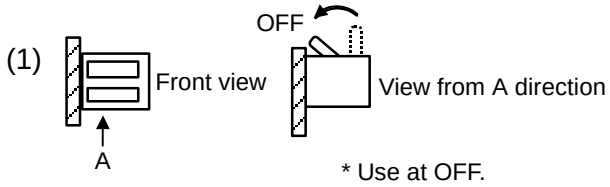
Unit model	Compatible machine control signal	Left	Right	Total
DX10* (FCUA-DX10*)	Digital input signal (DI) (Photocoupler insulation) Digital output signal(DO) (Non-insulated)	32 points 32 points	—	32 points 32 points
DX11* (FCUA-DX11*)	Digital input signal (DI) (Photocoupler insulation) Digital output signal(DO) (Non-insulated)	32 points 32 points	32 points 16 points	64 points 48 points
DX12* (FCUA-DX12*)	Digital input signal (DI) (Photocoupler insulation) Digital output signal(DO) (Non-insulated) Analog output (AO)	32 points 32 points —	32 points 16 points 1 point	64 points 48 points 1 point
DX14* (FCUA-DX14*)	Digital input signal (DI) (Photocoupler insulation) Digital output signal(DO) (Non-insulated) Analog input (AI) Analog output (AO)	32 points 32 points — —	— — 4 points 1 point	32 points 32 points 4 points 1 point

(Note) The * mark in the table is 0 when the output is a sink type, and is 1 when the output is a source type. The input is changeable.
Items (1) to (7) are described in the following pages.

2.1.1 DIO Specification Setting Switch

This switch is not used currently, and must always be set to OFF.

DIO specification setting switch



2.1.2 Rotary Switch for Channel No. Setting

Rotary switch for channel No. setting (2) (5)


Set between 0 and 7.

The device used by the PLC is determined by the setting of the rotary switch for channel No. setting.

Rotary switch No.	Device No. read in	Output device No.	Analog output (AO)
	RIO channel 1	RIO channel 1	RIO channel 1
0	X00 to X1F	Y00 to Y1F(Y0F)	The rotary switches correspond to the file registers R100 to R103 in order of small numbers.
1	X20 to X3F	Y20 to Y3F(Y2F)	
2	X40 to X5F	Y40 to Y5F(Y4F)	
3	X60 to X7F	Y60 to Y7F(Y6F)	
4	X80 to X9F	Y80 to Y9F(Y8F)	
5	XA0 to XBF	YA0 to YBF(YAF)	
6	XC0 to XDF	YC0 to YDF(YCF)	
7	XE0 to XFF	YE0 to YFF(YEF)	

Rotary switch No.	Device No. read in		Output device No.		Analog output (AO)
	RIO channel 2		RIO channel 2		RIO channel 2
	PLC4B	GX-Developer	PLC4B	GX-Developer	
0	I00 to I1F	X640 to X65F	J00 to J1F(J0F)	Y740 to Y75F(Y74F)	Not possible (Both input and output are not possible)
1	I20 to I3F	X660 to X67F	J20 to J3F(J2F)	Y760 to Y77F(Y76F)	
2	I40 to I5F	X680 to X69F	J40 to J5F(J4F)	Y780 to Y79F(Y78F)	
3	I60 to I7F	X6A0 to X6BF	J60 to J7F(J6F)	Y7A0 to Y7BF(Y7AF)	
4	I80 to I9F	X6C0 to X6DF	J80 to J9F(J8F)	Y7C0 to Y7DF(Y7CF)	
5	IA0 to IBF	X6E0 to X6FF	JA0 to JBF(JAF)	Y7E0 to Y7FF(Y7EF)	
6	IC0 to IDF	X700 to X71F	JC0 to JDF(JCF)	Y800 to Y81F(Y80F)	
7	IE0 to IFF	X720 to X73F	JE0 to JFF(JEF)	Y820 to Y83F(Y82F)	

The values shown in parentheses are the device range of the card mounted to the right side of the unit.

No. of points occupied by each unit

No. of occupied points	Unit name
1	DX100/DX101
2	DX110/DX111, DX120/DX121, DX140/DX141, Base I/O unit DX35*/45*

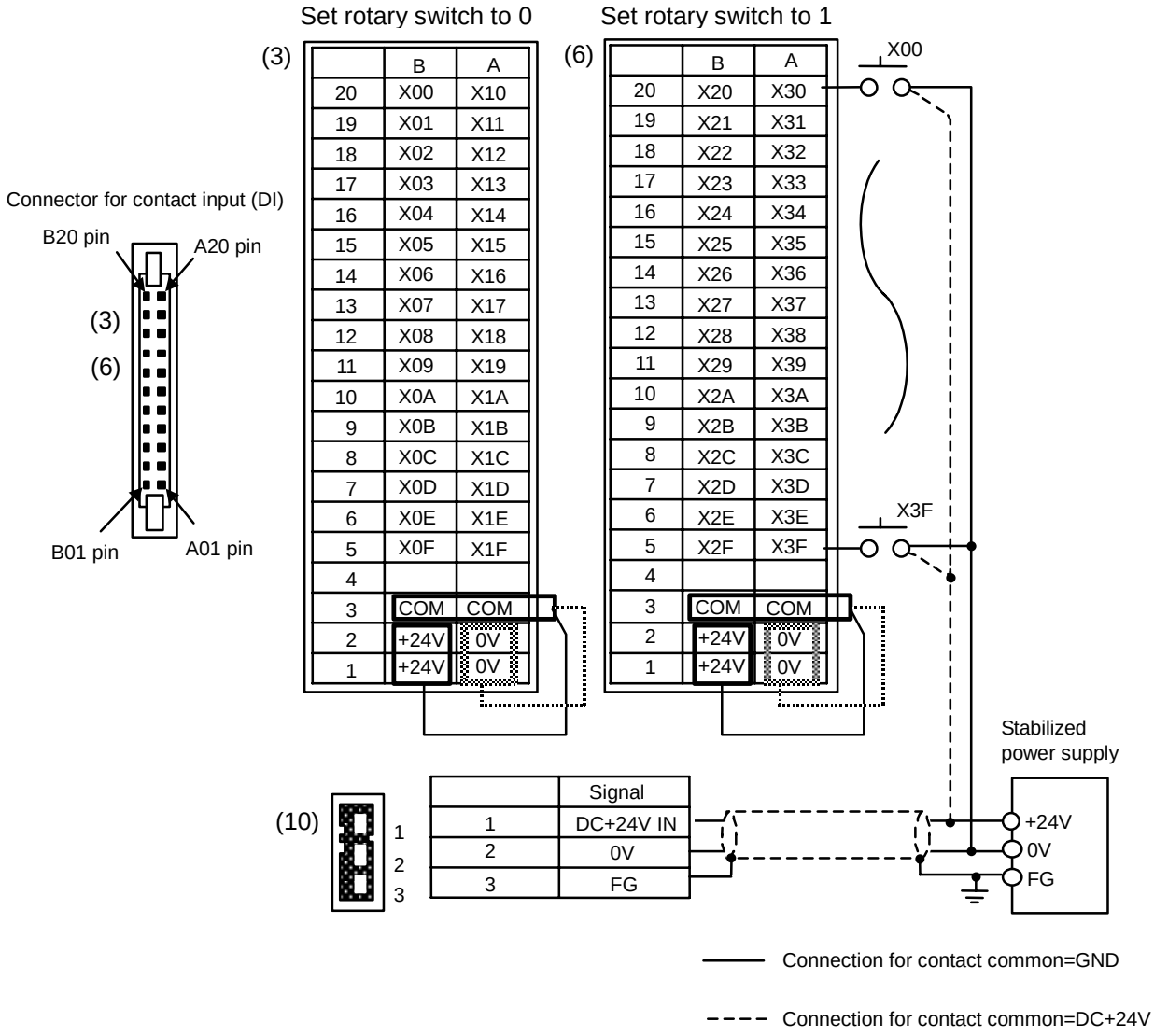
A max. of 8 units can be connected. The DX35*/45* base I/O units and DX11*/DX12*/DX14* units are counted as 2 occupied points, and DX100/DX101 unit is counted as 1 occupied point.

(Example 1) One base I/O unit (DX35*/45*) and three DX120 units.

(Example 2) One base I/O unit (DX35*/45*), one DX110 unit and four DX100 units.

2.1.3 Relation of Connector Pins and Device

(1) Input (DI) signal

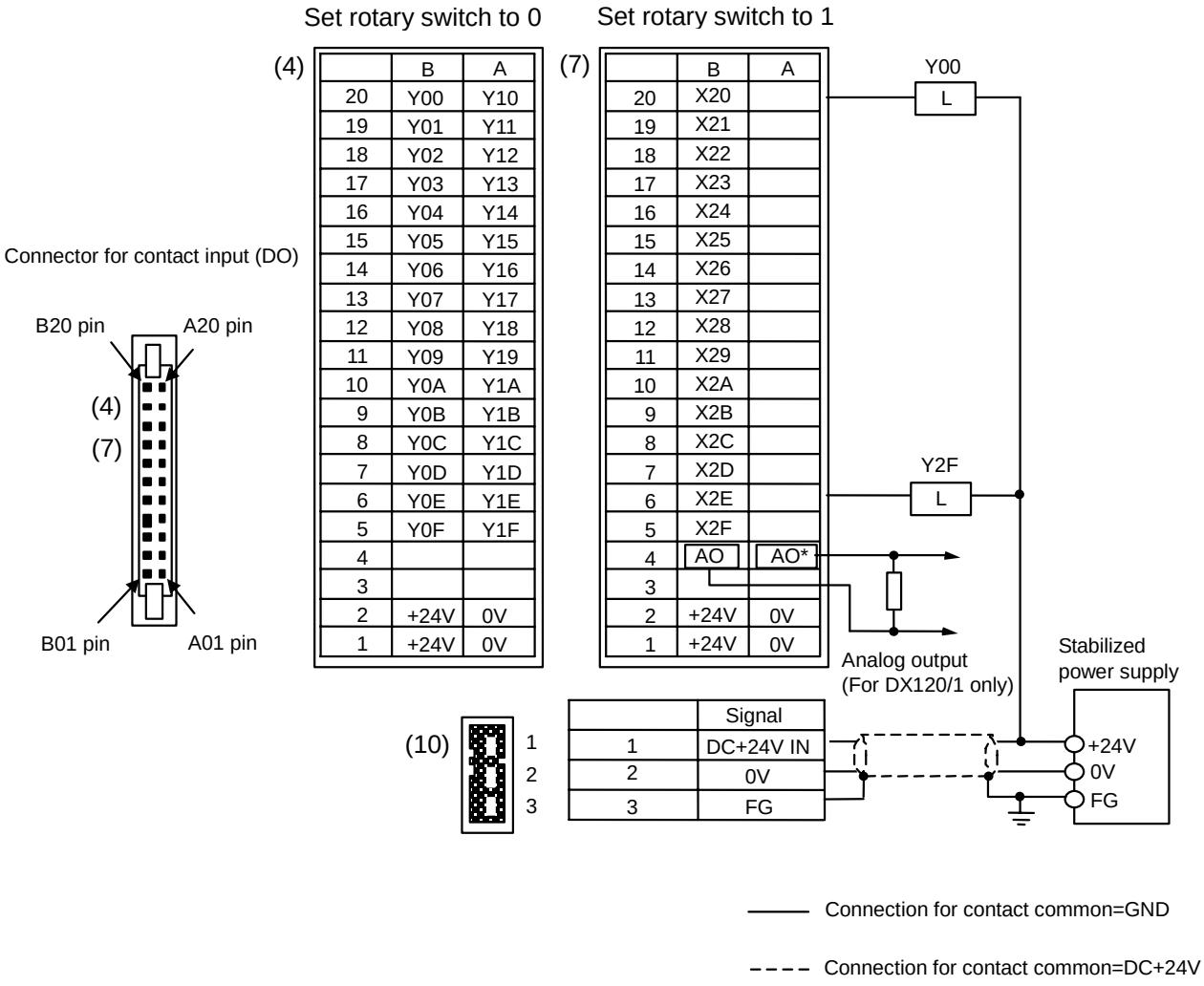


	B	A
20	X00	X10
19	X01	X11
18	X02	X12
17	X03	X13
16	X04	X14
15	X05	X15
14	X06	X16
13	X07	X17
12	X08	X18
11	X09	X19
10	X0A	X1A
9	X0B	X1B
8	X0C	X1C
7	X0D	X1D
6	X0E	X1E
5	X0F	X1F
4		
3	COM	COM
2	+24V	0V
1	+24V	0V

	B	A
20	X20	X30
19	X21	X31
18	X22	X32
17	X23	X33
16	X24	X34
15	X25	X35
14	X26	X36
13	X27	X37
12	X28	X38
11	X29	X39
10	X2A	X3A
9	X2B	X3B
8	X2C	X3C
7	X2D	X3D
6	X2E	X3E
5	X2F	X3F
4		
3	COM	COM
2	+24V	0V
1	+24V	0V

(Note 1) The No. of points (devices) will differ according to the RIO unit type.
(Note 2) The devices shown here show an example for when the rotary switch for channel No. setting on the RIO unit is set to "0" and set to "1".
Refer to section "2.1.2 Rotary Switch for Channel No. Setting" for details on the relation of the rotary switch and device No.

(2) Output (DO) signal



	B	A
20	Y00	Y10
19	Y01	Y11
18	Y02	Y12
17	Y03	Y13
16	Y04	Y14
15	Y05	Y15
14	Y06	Y16
13	Y07	Y17
12	Y08	Y18
11	Y09	Y19
10	Y0A	Y1A
9	Y0B	Y1B
8	Y0C	Y1C
7	Y0D	Y1D
6	Y0E	Y1E
5	Y0F	Y1F
4		
3		
2	+24V	0V
1	+24V	0V

	B	A
20	X20	
19	X21	
18	X22	
17	X23	
16	X24	
15	X25	
14	X26	
13	X27	
12	X28	
11	X29	
10	X2A	
9	X2B	
8	X2C	
7	X2D	
6	X2E	
5	X2F	
4	AO	AO*
3		
2	+24V	0V
1	+24V	0V

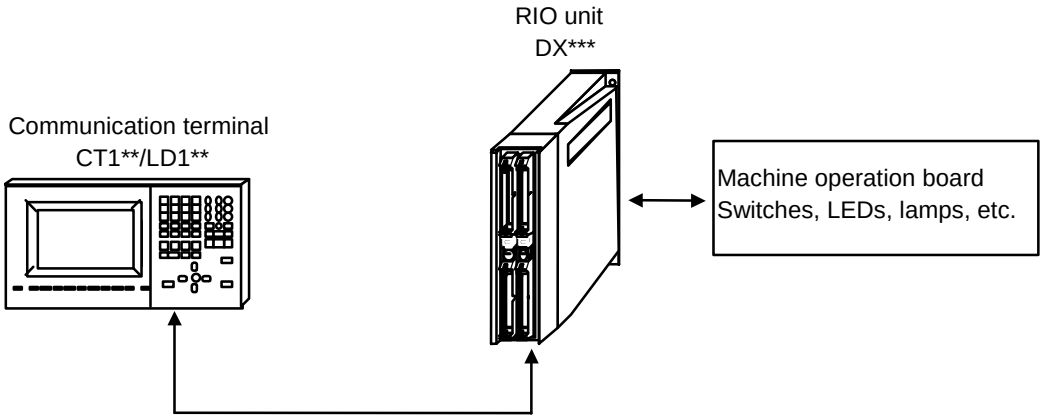
	Signal
1	DC+24V IN
2	0V
3	FG

(Note 1) The No. of points (devices) will differ according to the RIO unit type.

(Note 2) The devices shown here show an example for when the rotary switch for channel No. setting on the RIO unit is set to "0" and set to "1".
Refer to section "2.1.2 Rotary switch for setting No. of channels" for details on the relation of the rotary switch and device No.

(Note 3) The A4 and B4 pin analog output (AO, AO*) in the output connector (7) is found only on the RIO unit DX120/DX121.

2.2 Operation Board Remote I/O Unit (This cannot be used with the MELDASMAGIC 64.)



The remote I/O unit (hereafter, RIO unit) connected to the main unit can also be connected to the remote terminal side.
Allocate the devices with the rotary switch as when connecting to the main unit.
The switches can be set independently regardless of the RIO unit used with the main unit.

Rotary switch No.	Device No. read in	Output device No.	Analog output (AO)
0	X100 to X11F	Y100 to Y11F (Y10F)	Not possible
1	X120 to X13F	Y120 to Y13F (Y12F)	
2	R80, R81	R180, R181	
3	R82, R83	R182, R183	

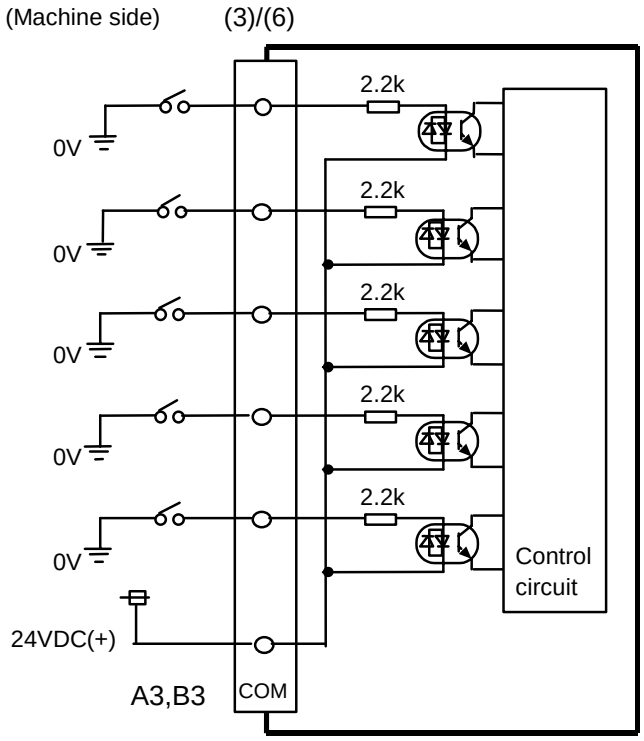
The values shown in parentheses are the device range of the card mounted to the right side of the unit.

(Note) Analog output is not possible even if DX120/DX121 is used.

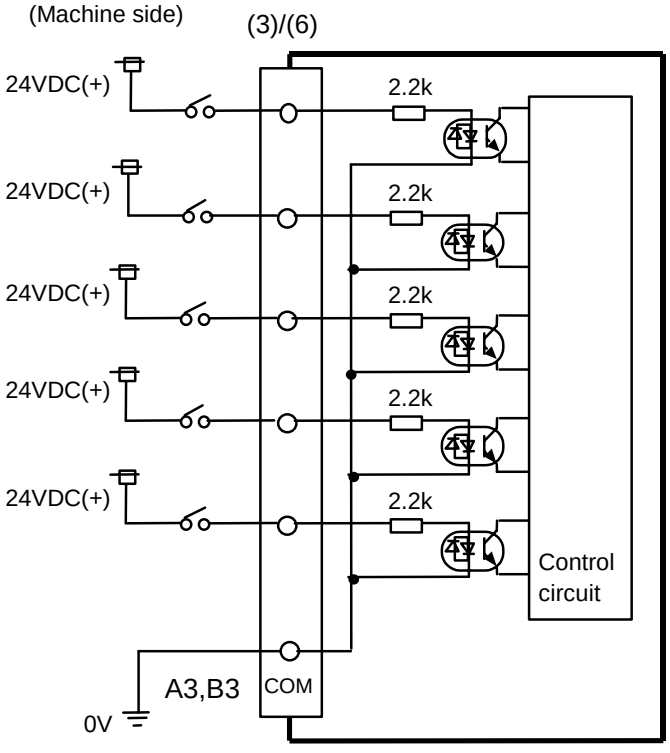
2.3 Outline of Digital Signal Input Circuit

There is a sink type digital signal input circuit and source type digital signal input circuit. Either method can be selected with each unit's card unit.

Input circuit



Sink type



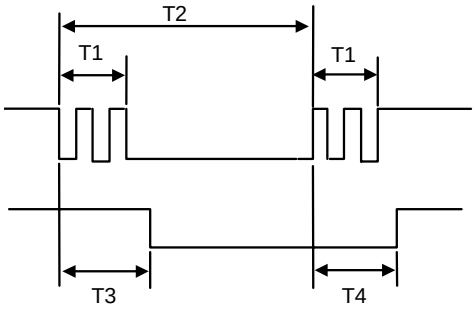
Source type

Input conditions

The input signal must be used within the conditions shown below.

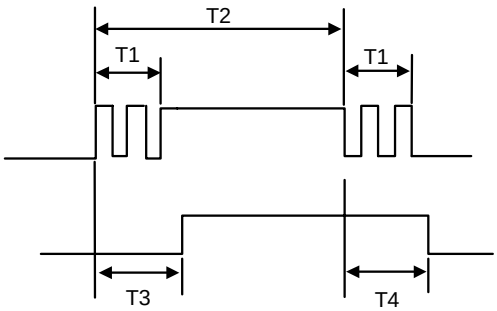
Sink type

Input voltage when external contact is ON	6V or less
Input current when external contact is ON	9mA or more
Input voltage when external contact is OFF	20V or more, 25.2V or less
Input current when external contact is OFF	2mA or less
Tolerable chattering time	3ms or less (Refer to T1 in drawing below)
Input signal hold time	40ms or more (Refer to T2 in drawing below)
Input circuit operation delay time	3ms <= T3 ≒ T4 <= 16ms
Machine side contact capacity	+30V or more, 16mA or more



Source type

Input voltage when external contact is ON	18V or more, 25.2V or less
Input current when external contact is ON	9mA or more
Input voltage when external contact is OFF	4V or less
Input current when external contact is OFF	2mA or less
Tolerable chattering time	3ms or less (Refer to T1 in drawing below)
Input signal hold time	40ms or more (Refer to T2 in drawing below)
Input circuit operation delay time	3ms <= T3 ≒ T4 <= 16ms
Machine side contact capacity	+30V or more, 16mA or more

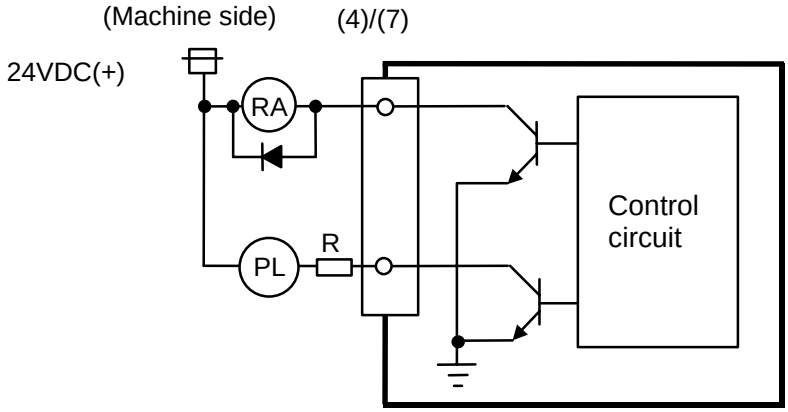


(Note) Input signal hold time : "40ms or more" is a standard value. Input signals cannot be recognized unless input signals are hold for the ladder processing cycle period or more.

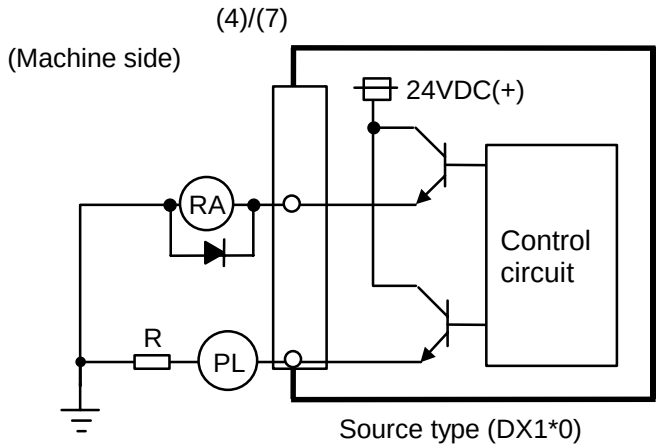
2.4 Outline of Digital Signal Output Circuit

There is a sink type (DX1*0) digital signal output circuit and source type (DX1*1) digital signal output circuit. Use this circuit within the range shown below.

Output circuit



Sink type (DX1*0)



Source type (DX1*0)

Output conditions

Insulation method	Non-insulating
Rated load voltage	+24VDC
Max. output current	60mA/1point
Output delay time	40μs

<Caution>

* When using a conductive load such as a relay, always connect a diode (withstand voltage 100V or more, 100mA or more) parallel to that load.
* When using a capacity load such as a lamp, connect a protective resistance (R=150ohm) serially to that load to limit the rush current. (Make sure that the current is lower than the tolerable current including the momentary current.)

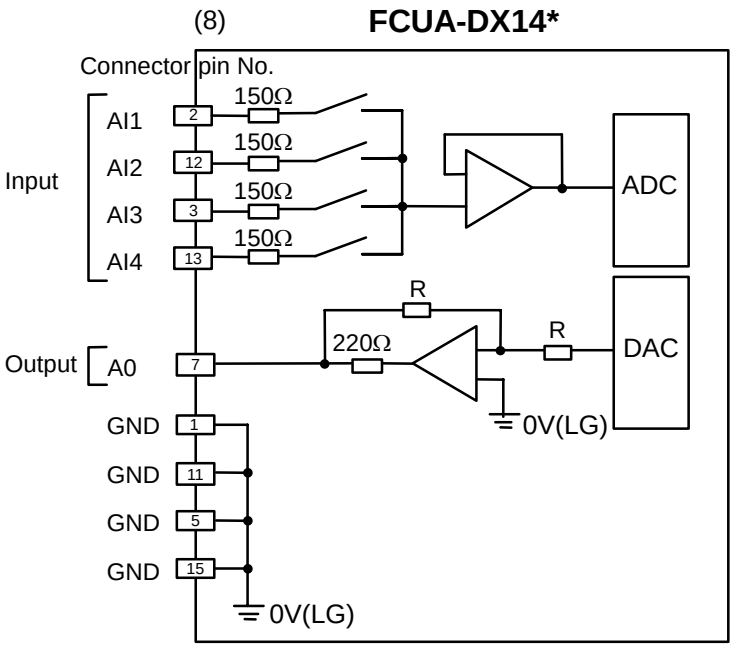
⚠CAUTION

- When using a conductive load such as relays, always contact a diode in parallel to the load as a noise measure.
- When using a capacity load such as a lamp, always connect a protective resistor serially to the load to suppress rush currents.

2.5 Outline of Analog Signal Input Circuit

The analog signal input circuit can be used only with the FCUA-DX140/DX141 unit.

Input circuit



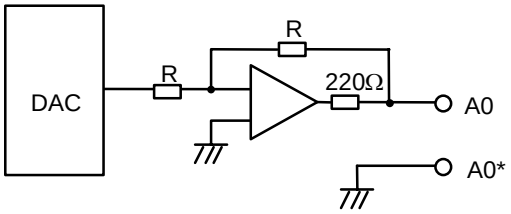
Input conditions

Input max. rate	± 15V
Resolution	10V/2000 (5mV)
Accuracy	± 25mV or less
AD input sampling time	14.2ms(AI0)/42.6ms(AI1 to 3)

2.6 Outline of Analog Signal Output Circuit

The analog signal circuit can be used only with the FCUA-DX120/DX121/DX140/DX141 unit.

Output circuit



Output conditions

Output voltage	-10V to +10V (±5%)
Resolution	2^{12} (1/4095)
Load conditions	10kohm load resistance (standard)
Output impedance	220ohm

2.7 Fixed Signals

The connector pin Nos. in the input signals that are fixed are shown below.
Note that using the methods below can ignore fixed signals and change the allocations.

Signal name	Device	Signal name	Device
Emergency stop	EMG of main unit	Stroke end -1	X20
Stroke end +1	X28	Stroke end -2	X21
Stroke end +2	X29	Stroke end -3	X22
Stroke end +3	X2A	Stroke end -4	X23
Stroke end +4	X2B	Stroke end -5	X64
Stroke end +5	X6C	Stroke end -6	X65
Stroke end +6	X6D	Stroke end -7	X66
Stroke end +7	X6E	Stroke end -8	X67
Stroke end +8	X6F		
Reference position return near-point detection 1	X18		
Reference position return near-point detection 2	X19		
Reference position return near-point detection 3	X1A		
Reference position return near-point detection 4	X1B		
Reference position return near-point detection 5	X5C		
Reference position return near-point detection 6	X5D		
Reference position return near-point detection 7	X5E		
Reference position return near-point detection 8	X5F		

(Note) When using the 2-part system and the 1st part system has 2 axes and the 2nd part system has 1 axis, the 1st axis in the 2nd part system will correspond to the 3rd axis above.

2.7.1 Ignoring Fixed Signals

The fixed signals can be used as other signals by ignoring them with file registers R156 and R157.

2.7.2 Changing the Addresses of Fixed Signals

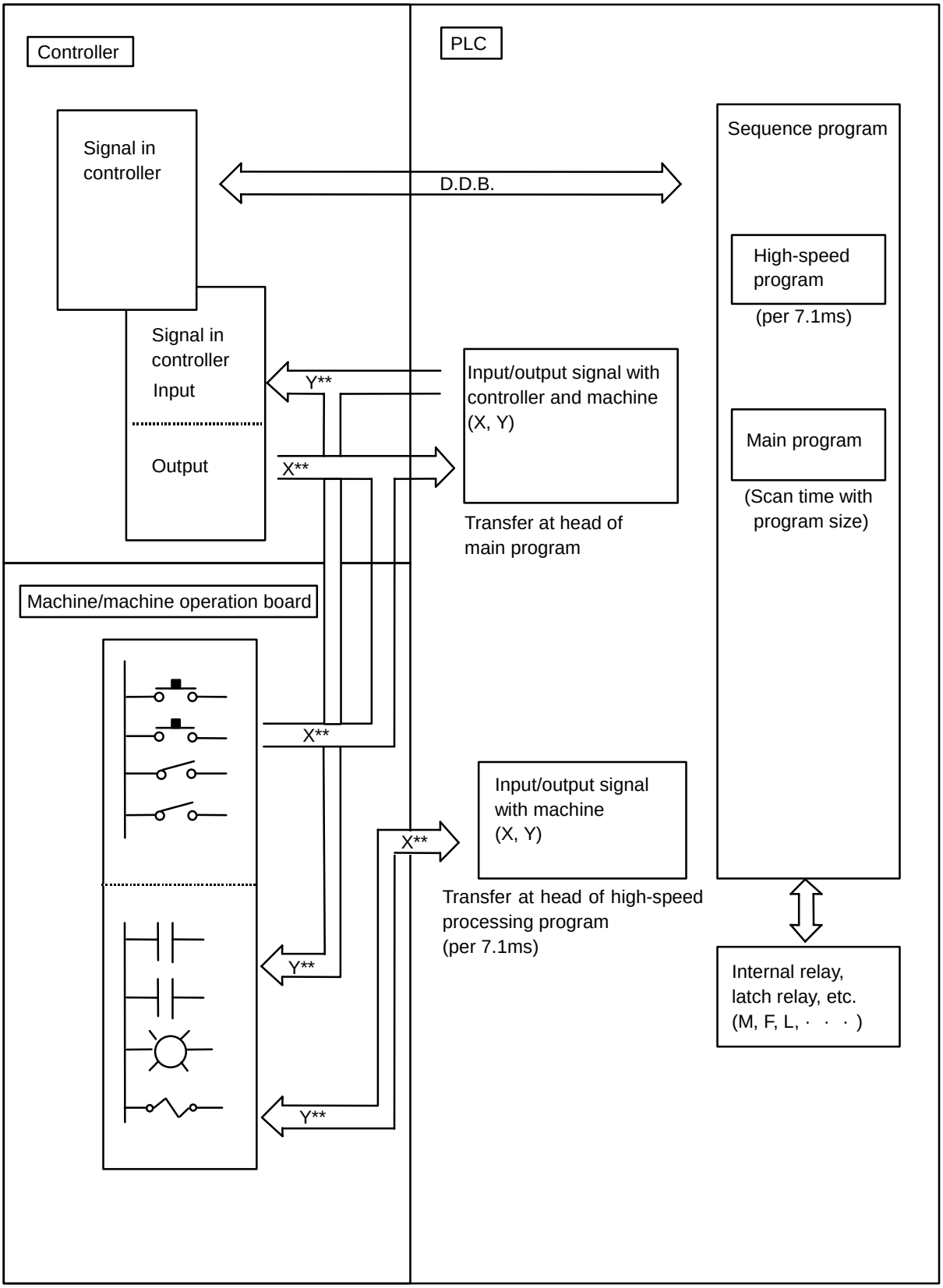
The fixed devices can be allocated arbitrarily with the following parameters.

The parameters #2073 to #2075 are valid when 1 is set in #1226 aux10 bit 5.
When the parameters #2073 to #2075 are valid, do not set the same device number. If the same device number exists, an emergency stop occurs. However, no device number check is performed for an axis to which a signal (R156, R157) that ignores the fixed signal is input.

When the arbitrary allocation is valid, the fixed signals (X400 to X40F) can be used as other signals.

#	Items		Details	Setting range (unit)
1226	aux10 (bit5)	Arbitrary allocation of dog signal	Specify whether to enable the arbitrary allocation parameter for the origin dog and H/W OT. 0: Disable arbitrary allocation. (Fixed device) 1: Enable arbitrary allocation. (Device specified by the parameter)	0/1
2073	zrn_dog	Origin dog	Under the standard specifications, the origin dog signal is assigned to a fixed device. When it is desired to assign the origin dog signal to a position other than the fixed device, specify the input device in this parameter. • This parameter is valid when 1 is set in #1226 aux10 bit 5. • When this parameter is valid, do not set the same device number. If the same device number exists, an emergency stop occurs. However, no device number check is performed for an axis to which a signal that ignores the near-point dog signal (R157) is input.	00 to FF (HEX)
2074	H/W_OT+	H/W OT+	Under the standard specifications, the OT (+) signal is assigned to a fixed device. When it is desired to assign the OT (+) signal to a position other than the fixed device, specify the input device in this parameter. • This parameter is valid when 1 is set in #1226 aux10 bit 5. • When this parameter is valid, do not set the same device number. If the same device number exists, an emergency stop occurs. However, no device number check is performed for an axis to which a signal that ignores the OT signal (R156) is input.	00 to FF (HEX)
2075	H/W_OT-	H/W OT-	Under the standard specifications, the OT (-) signal is assigned to a fixed device. When it is desired to assign the OT (-) signal to a position other than the fixed device, specify the input device in this parameter. • This parameter is valid when 1 is set in #1226 aux10 bit 5. • When this parameter is valid, do not set the same device number. If the same device number exists, an emergency stop occurs. However, no device number check is performed for an axis to which a signal that ignores the OT signal (R156) is input.	00 to FF (HEX)

2.8 Flow of Signals



2.9 List of Devices Used

The devices used by the PLC are shown below. (PLC4B)

Device	Device No.		Unit	Details	Format
X*	X0 to X4BF	(1216 points)	1 bit	Input signal to PLC: Machine input, etc.	
Y*	X0 to Y53F	(1344 points)	1 bit	Output signal from PLC: Machine output, etc.	
U*	U0 to U17F	(384 points)	1 bit	Input signal to PLC: For 2nd part system.	——
W*	W0 to W1FF	(512 points)	1 bit	Output signal from PLC: For 2nd part system	——
I*	I0 to I3FF	(1024 points)	1 bit	Input signal to PLC	——
J*	J0 to J63F	(1600 points)	1 bit	Output signal from PLC	——
S*	S0 to S1F	(32 points)	1 bit	Input signal to PLC	——
	S40 to S5F	(32 points)	1 bit		
	S80 to S9F	(32 points)	1 bit		
	SC0 to SDF	(32 points)	1 bit		
	S100 to S13F	(64 points)	1 bit		
S*	S20 to S3F	(32 points)	1 bit	Output signal from PLC	——
	S60 to S7F	(32 points)	1 bit		
	SA0 to SBF	(32 points)	1 bit		
	SE0 to SFF	(32 points)	1 bit		
M	M0 to M5119	(5120 points)	1 bit	Temporary memory	1
G	G0 to G3071	(3072 points)	1 bit	Temporary memory	2
F	F0 to F127	(128 points)	1 bit	Temporary memory. Alarm message interface	3
L	L0 to L255	(256 points)	1 bit	Latch relay (back up memory)	4
E*	E0 to E127	(128 points)	1 bit	Special relay	——
T	T0 to T15	(16 points)	1 bit/16 bits	10ms unit timer	5, 6
	T16 to T95	(80 points)	1 bit/16 bits	100ms unit timer	
	T96 to T103	(8 points)	1 bit/16 bits	100ms integrated timer	
Q	Q0 to Q39	(40 points)	1 bit/16 bits	10ms unit timer (fixed timer)	7, 8
	Q40 to Q135	(96 points)	1 bit/16 bits	100ms unit timer (fixed timer)	
	Q136 to Q151	(16 points)	1 bit/16 bits	100ms integrated timer (fixed timer)	
C	C0 to C23	(24 points)	1 bit/16 bits	Counter	9, 10
B	B0 to B103	(104 points)	1 bit/16 bits	Counter (fixed counter)	11, 12
D	D0 to D1023	(1024 points)	16 bits/32 bits	Data register. Register for calculation	13
R*	R0 to R8191	(8192 points)	16 bits/32 bits	File register. Interface between PLC and controller 10ms timer expansion (400 points)	14
A	A0, A1	(2 points)	16 bits/32 bits	Accumulator	——
Z	——	(1 point)	16 bits	For D or R address index (for ±n)	
V	——	(1 point)	16 bits	For D or R address index (for ±n)	
N	N0 to N7	(8 points)	——	Master controller nesting level	
P*	P0 to P255	(256 points)	——	Label for conditional jump, subroutine call command	
K	K-32768 to K32767		——	Decimal constant for 16-bit command	
	K-2147483648 to K2147483647		——	Decimal constant for 32-bit command	
H	H0~HFFFF		——	Hexadecimal constant for 16-bit command	
	H0~HFFFFFFFF		——	Hexadecimal constant for 32-bit command	

(Note 1) Devices marked with * in the device column have designated applications. Do not use even the devices not currently defined.

(Note 2) The format displayed in the table is attached. Copy and use as required.

(Note 3) Devices X100 to X13F, Y100 to Y13F, R80 to R83, and R180 to R183 cannot be used in the MELDASMAGIC 64.

The device Nos. when using the PLC4B and the device Nos. when using the GX Developer corresponds as shown below.

Device No. when using PLC4B	Device No. when using GX Developer
X0 to X4BF	X0 to X4BF
U0 to U17F	X4C0 to X63F
I0 to I3FF	X640 to XA3F
S0 to S1F S40 to S5F S80 to S9F SC0 to SDF S100 to S13F	XA40 to XAFF
Y0 to Y53F	Y0 to Y53F
W0 to W1FF	Y540 to Y73F
J0 to J63F	Y740 to YD7F
S20 to S3F S60 to S7F SA0 to SBF SE0 to SFF	YD80 to YDFF
M0 to M5119	M0 to M5119
G0 to G3071	M5120 to M8191
F0 to F127	F0 to F127
L0 to L255	L0 to L255
E0 to E127	SM0 to SM127
T0 to T15	T0 to T15
Q0 to Q39	T16 to T55
T16 to T95	T56 to T135
Q40 to Q135	T136 to T231
T96 to T103	T232 to T239
Q136 to Q151	T240 to T255
C0 to C23	C0 to C23
B0 to B103	C24 to C127
D0 to D1023	D0 to D1023
R0 to R8191	R0 to R8191
A0,A1	
Z	Z0
V	Z1
N0 to N7	N0 to N7
P0 to P255	P0 to P255
K-32768 to K32767	K-32768 to K32767
K-2147483648 to K2147483647	K-2147483648 to K2147483647
H0 to HFFFF	H0 to HFFFF
H0 to HFFFFFFFF	H0 to HFFFFFFFF

2.10 File Register General Map

R000	R00 to R99	••••	Controller → PLC signal I/F (M, S, T codes, etc.)
R100	R100 to R199	••••	PLC → controller signal I/F (feed override code, etc.)
R200	R200 to R499	••••	System reserve
R500	R500 to R549	••••	User release (non-backed up area)
R560	R560 to R567	••••	External machine coordinate system compensation I/F
R600	R600 to R699	••••	System reserve
R700	R700 to R999	••••	Computer link communication I/F
R1000	R1000 to R1199	••••	System reserve
R1200	R1200 to R1224	••••	10ms timer coil (for 400 points expansion)
R1225	R1225 to R1249	••••	System reserve
R1250	R1250 to R1274	••••	10ms timer contact (for 400 points expansion)
R1275	R1275 to R1879	••••	System reserve
R1880	R1880 to R1889	••••	MELSEC link II diagnosis I/F (This cannot be used with the MELDASMAGIC 64.)
R1900	R1900 to R2799	••••	User release (backed up area)
R2800	R2800 to R2895	••••	Corresponding to parameters: PLC constants 1 to 48
R2900	R2900 to R2947	••••	Corresponding to parameters: Bit selection 1 to 96 (Note that 49 to 96 are the system reserve area)
R2950	R2950 to R2999	••••	ATC tool registration common data (spindle tool, etc.)
R3000	R3000 to R3159 (80)	••••	ATC tool registration magazine 1 data (corresponding to ATC tool registration screen) Tool life management data (Lath system: R3000 to R3639)
R3240	R3240 to R3399 (80)	••••	ATC tool registration magazine 2 data
R3480	R3480 to R3639 (80)	••••	ATC tool registration magazine 3 data
R3720	R3720 to R3735	••••	Tool life management I/F (machining center system)
R3736	R3736 to R3999	••••	System reserve
R4000	R4000 to R4399	••••	Data buffer for MELSEC link II (This cannot be used with the MELDASMAGIC 64.)
R4400	R4400 to R4449	••••	Corresponding to parameters : Bit selection2 97 to 196
R4450	R4450 to R4499	••••	MELSEC link II data buffer (This cannot be used with the MELDASMAGIC 64.)
R4500	R4500 to R4899	••••	System reserve
R4900	R4900 to R4995	••••	Corresponding to parameters : PLC constants2 49 to 96
R4996	R4996 to R5479	••••	System reserve
R5480	R5480 to R6279	••••	Tool life management I/F (for lathe system with spare tool life management)
R6280 R8191		••••	System reserve

(Note) The system reserve is used for function expansion by Mitsubishi, and must not be used by the user.

3. INPUT/OUTPUT SIGNALS WITH MACHINE

3.1 How to Read Input/Output Signal Table

The method of reading the input/output signal table is shown below.
Each card mounted on the RIO unit uses 32 points. Thus, even the 16 point output card has 32 points, and the head of the next card number will be a serial No. on the assumption that there are 32 points.

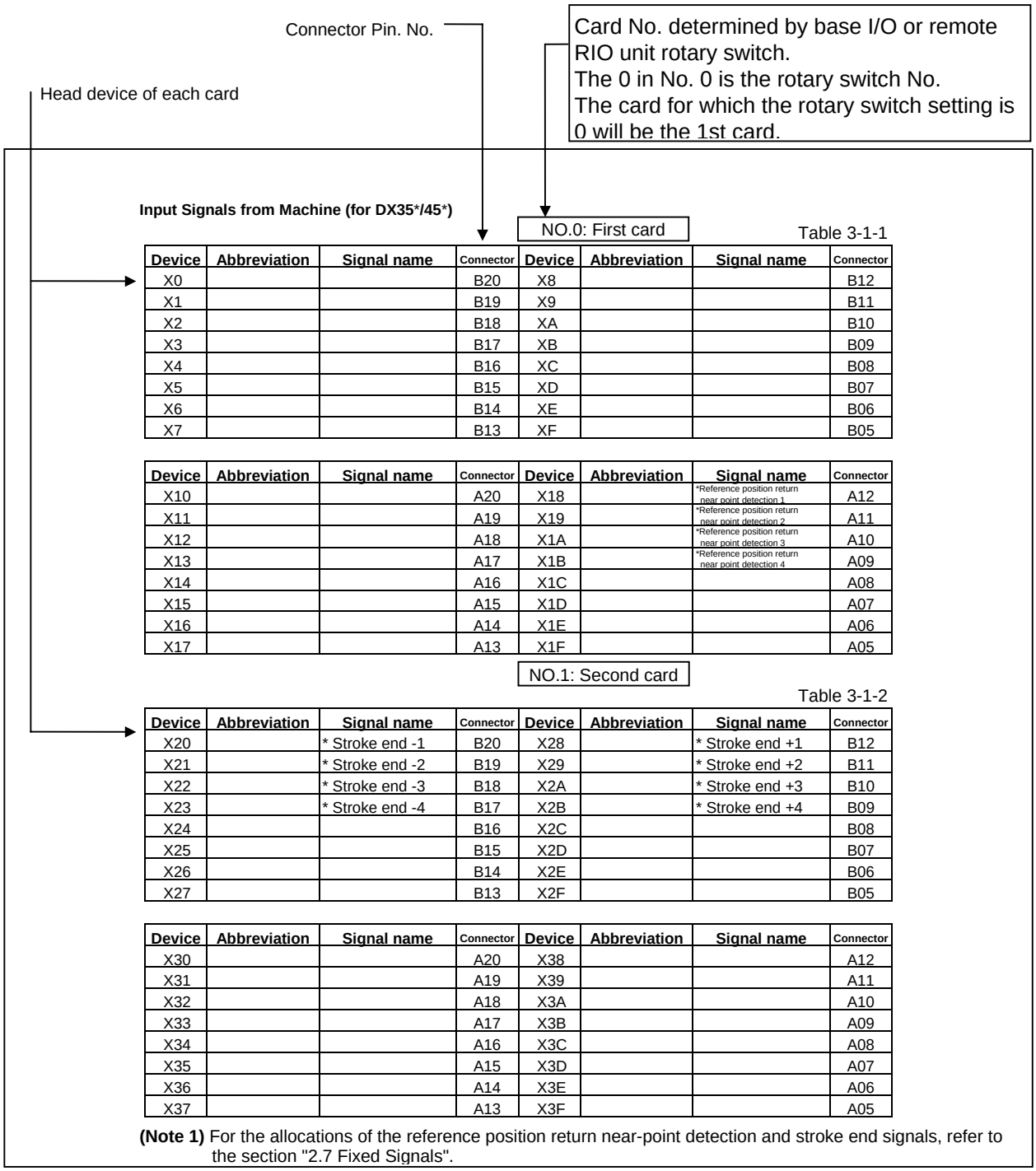


Table 3-1-1

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X0			B20	X8			B12
X1			B19	X9			B11
X2			B18	XA			B10
X3			B17	XB			B09
X4			B16	XC			B08
X5			B15	XD			B07
X6			B14	XE			B06
X7			B13	XF			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X10			A20	X18		*Reference position return near point detection 1	A12
X11			A19	X19		*Reference position return near point detection 2	A11
X12			A18	X1A		*Reference position return near point detection 3	A10
X13			A17	X1B		*Reference position return near point detection 4	A09
X14			A16	X1C			A08
X15			A15	X1D			A07
X16			A14	X1E			A06
X17			A13	X1F			A05

Table 3-1-2

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X20		* Stroke end -1	B20	X28		* Stroke end +1	B12
X21		* Stroke end -2	B19	X29		* Stroke end +2	B11
X22		* Stroke end -3	B18	X2A		* Stroke end +3	B10
X23		* Stroke end -4	B17	X2B		* Stroke end +4	B09
X24			B16	X2C			B08
X25			B15	X2D			B07
X26			B14	X2E			B06
X27			B13	X2F			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X30			A20	X38			A12
X31			A19	X39			A11
X32			A18	X3A			A10
X33			A17	X3B			A09
X34			A16	X3C			A08
X35			A15	X3D			A07
X36			A14	X3E			A06
X37			A13	X3F			A05

(Note 1) For the allocations of the reference position return near-point detection and stroke end signals, refer to the section "2.7 Fixed Signals".

(Note 1) [ ] are 1 word (16-bit) data.
(Note 2) Signals marked with [−] in the column for the 2nd part system indicate there is no signal corresponding to the 2nd part system, and the signal for the 1st part system side is used commonly.
(Note 3) Signals marked with * in the "Single name" column are handled as B contacts.

3.2 Classification of Machine Input/Output Signals

The signals handled by the PLC are classified as shown below.
Refer to the following table when making allocations during design.

	Signal type		Allocation table	Explanation
Input	DI	Machine	Table 3-1-1 to Table 3-1-9	(1) Allocated to device X. (2) Some connector pin allocations are determined. 1) Stroke end signal (+, -) 2) Reference point return near-point detection signal (3) The high-speed processing input is set with the parameters. (Read in at the head of the high-speed processing scan.) **(Note 1)** High-speed input of the machine operation board inputs is not possible. **(Note 2)** Machine operation board inputs are not possible for MELDASMAGIC 64.
		Machine operation board	Table 3-2-1 to Table 3-2-5	
	PLC switch input (Note)		Table 3-3-1	(1) The switches can be substituted for by the setting and display unit. (2) Allocated to device X. (3) The switch names displayed on the setting and display unit are user release switches, and can be created with the ladder message creation.
	Sensor input		Table 3-4-1	(1) Differs from other DI signals, and is connected to the controller. This is only used for monitoring on the ladder side.
	AI (Analog Input)		Table 4-2-1	(1) The connector pin allocation is determined. (2) Allocated to device R.
Output	DO	Machine	Table 3-5-1 to Table 3-5-9	(1) Allocated to device Y. (2) The high-speed processing output is set with the parameters. (Output at end of the high-speed processing scan.) **(Note 1)** High-speed output of the machine operation board outputs is not possible. **(Note 2)** Machine operation board outputs are not possible for MELDASMAGIC 64.
		Machine operation board	Table 3-6-1 to Table 3-6-5	
	PLC switch output (Note)		Table 3-7-1	(1) Output used to show that setting and display unit PLC switch input is valid. (2) Allocated to device Y.
	AO (Analog Output)		Table 4-4-1	(1) The connector pin allocation is determined. (2) Data to be D/A converted and output can be output by reading it into the file register (R).

(Note) The PLC switches are not signals for directly inputting/outputting with the machine, and are hypothetical switches used by the user on the setting and display unit. When classified by property, they are as shown above.

3.3 Machine Input Signals

3.3.1 Using DX35*/45* for Base I/O Unit

Input Signals from Machine (for DX35*/45*)

No.0: First card

Table 3-1-1

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X0			B20	X8			B12
X1			B19	X9			B11
X2			B18	XA			B10
X3			B17	XB			B09
X4			B16	XC			B08
X5			B15	XD			B07
X6			B14	XE			B06
X7			B13	XF			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X10			A20	X18		* Reference position return near point detection 1	A12
X11			A19	X19		* Reference position return near point detection 2	A11
X12			A18	X1A		* Reference position return near point detection 3	A10
X13			A17	X1B		* Reference position return near point detection 4	A09
X14			A16	X1C			A08
X15			A15	X1D			A07
X16			A14	X1E			A06
X17			A13	X1F			A05

No.1: Second card

Table 3-1-2

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X20		* Stroke end -1	B20	X28		* Stroke end +1	B12
X21		* Stroke end -2	B19	X29		* Stroke end +2	B11
X22		* Stroke end -3	B18	X2A		* Stroke end +3	B10
X23		* Stroke end -4	B17	X2B		* Stroke end +4	B09
X24			B16	X2C			B08
X25			B15	X2D			B07
X26			B14	X2E			B06
X27			B13	X2F			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X30			A20	X38			A12
X31			A19	X39			A11
X32			A18	X3A			A10
X33			A17	X3B			A09
X34			A16	X3C			A08
X35			A15	X3D			A07
X36			A14	X3E			A06
X37			A13	X3F			A05

(Note 1) For the allocations of the reference position return near-point detection and stroke end signals, refer to the section "2.7 Fixed Signals".

Input Signals from Machine (for DX35*/45*)

No.2: Third card

Table 3-1-3

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X40			B20	X48			B12
X41			B19	X49			B11
X42			B18	X4A			B10
X43			B17	X4B			B09
X44			B16	X4C			B08
X45			B15	X4D			B07
X46			B14	X4E			B06
X47			B13	X4F			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X50			A20	X58			A12
X51			A19	X59			A11
X52			A18	X5A			A10
X53			A17	X5B			A09
X54			A16	X5C		* Reference position return near point detection 5	A08
X55			A15	X5D		* Reference position return near point detection 6	A07
X56			A14	X5E		* Reference position return near point detection 7	A06
X57			A13	X5F		* Reference position return near point detection 8	A05

No.3: Fourth card

Table 3-1-4

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X60			B20	X68			B12
X61			B19	X69			B11
X62			B18	X6A			B10
X63			B17	X6B			B09
X64		* Stroke end -5	B16	X6C		* Stroke end +5	B08
X65		* Stroke end -6	B15	X6D		* Stroke end +6	B07
X66		* Stroke end -7	B14	X6E		* Stroke end +7	B06
X67		* Stroke end -8	B13	X6F		* Stroke end +8	B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X70			A20	X78			A12
X71			A19	X79			A11
X72			A18	X7A			A10
X73			A17	X7B			A09
X74			A16	X7C			A08
X75			A15	X7D			A07
X76			A14	X7E			A06
X77			A13	X7F			A05

(Note 1) For the allocations of the reference position return near-point detection and stroke end signals, refer to the section "2.7 Fixed Signals".

Input Signals from Machine (for DX35*/45*)

No.4: Fifth card

Table 3-1-5

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X80			B20	X88			B12
X81			B19	X89			B11
X82			B18	X8A			B10
X83			B17	X8B			B09
X84			B16	X8C			B08
X85			B15	X8D			B07
X86			B14	X8E			B06
X87			B13	X8F			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X90			A20	X98			A12
X91			A19	X99			A11
X92			A18	X9A			A10
X93			A17	X9B			A09
X94			A16	X9C			A08
X95			A15	X9D			A07
X96			A14	X9E			A06
X97			A13	X9F			A05

No.5: Sixth card

Table 3-1-6

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
XA0			B20	XA8			B12
XA1			B19	XA9			B11
XA2			B18	XAA			B10
XA3			B17	XAB			B09
XA4			B16	XAC			B08
XA5			B15	XAD			B07
XA6			B14	XAE			B06
XA7			B13	XAF			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
XB0			A20	XB8			A12
XB1			A19	XB9			A11
XB2			A18	XBA			A10
XB3			A17	XBB			A09
XB4			A16	XBC			A08
XB5			A15	XBD			A07
XB6			A14	XBE			A06
XB7			A13	XBF			A05

Input Signals from Machine (for DX35*/45*)

No.6: Seventh card

Table 3-1-7

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
XC0			B20	XC8			B12
XC1			B19	XC9			B11
XC2			B18	XCA			B10
XC3			B17	XCB			B09
XC4			B16	XCC			B08
XC5			B15	XCD			B07
XC6			B14	XCE			B06
XC7			B13	XCF			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
XD0			A20	XD8			A12
XD1			A19	XD9			A11
XD2			A18	XDA			A10
XD3			A17	XDB			A09
XD4			A16	XDC			A08
XD5			A15	XDD			A07
XD6			A14	XDE			A06
XD7			A13	XDF			A05

No.7: Eighth card

Table 3-1-8

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
XE0			B20	XE8			B12
XE1			B19	XE9			B11
XE2			B18	XEA			B10
XE3			B17	XEB			B09
XE4			B16	XEC			B08
XE5			B15	XED			B07
XE6			B14	XEE			B06
XE7			B13	XEF			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
XF0			A20	XF8			A12
XF1			A19	XF9			A11
XF2			A18	XFA			A10
XF3			A17	XFB			A09
XF4			A16	XFC			A08
XF5			A15	XFD			A07
XF6			A14	XFE			A06
XF7			A13	XFF			A05

3.3.2 Using HR378 for Base I/O Unit

Input Signals from Machine (for HR378)

No.0: First card

Table 3-1-9

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X00			MJ2-1	X08			MJ2-10
X01			MJ2-2	X09			MJ2-11
X02			MJ2-3	X0A			MJ2-12
X03			MJ2-4	X0B			MJ2-13
X04			MJ2-5	X0C			MJ2-14
X05			MJ2-6	X0D			MJ2-15
X06			MJ2-7	X0E			MJ2-16
X07			MJ2-8	X0F			MJ2-17

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X10			MJ2-19	X18		* Reference position return near point detection 1	MJ2-28
X11			MJ2-20	X19		* Reference position return near point detection 2	MJ2-29
X12			MJ2-21	X1A		* Reference position return near point detection 3	MJ2-30
X13			MJ2-22	X1B		* Reference position return near point detection 4	MJ2-31
X14			MJ2-23	X1C			MJ2-32
X15			MJ2-24	X1D			MJ2-33
X16			MJ2-25	X1E			MJ2-34
X17			MJ2-26	X1F			MJ2-35

No.1: First card

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X20		* Stroke end -1	MJ2-51	X28		* Stroke end +1	MJ2-60
X21		* Stroke end -2	MJ2-52	X29		* Stroke end +2	MJ2-61
X22		* Stroke end -3	MJ2-53	X2A		* Stroke end +3	MJ2-62
X23		* Stroke end -4	MJ2-54	X2B		* Stroke end +4	MJ2-63
X24			MJ2-55	X2C			MJ2-64
X25			MJ2-56	X2D			MJ2-65
X26			MJ2-57	X2E			MJ2-66
X27			MJ2-58	X2F			MJ2-67

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X30			MJ2-69	X38			MJ2-78
X31			MJ2-70	X39			MJ2-79
X32			MJ2-71	X3A			MJ2-80
X33			MJ2-72	X3B			MJ2-81
X34			MJ2-73	X3C			MJ2-82
X35			MJ2-74	X3D			MJ2-83
X36			MJ2-75	X3E			MJ2-84
X37			MJ2-76	X3F			MJ2-85

(Note 1) For the allocations of the reference position return near-point detection and stroke end signals, refer to the section "2.7 Fixed Signals".

(Note 2) With the base I/O unit HR378, each card has 64 points for input and 64 points for output.

3.3.3 Using DX1** for Machine Operation Board

Input Signals from Machine Operation Board (for DX1＊＊)

No.0: First card

Table 3-2-1

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X100			B20	X108	MRST	NC reset (Note1)	B12
X101			B19	X109			B11
X102			B18	X10A			B10
X103			B17	X10B			B09
X104			B16	X10C			B08
X105			B15	X10D			B07
X106			B14	X10E			B06
X107			B13	X10F			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X110			A20	X118			A12
X111			A19	X119			A11
X112			A18	X11A			A10
X113			A17	X11B			A09
X114			A16	X11C			A08
X115			A15	X11D			A07
X116			A14	X11E			A06
X117			A13	X11F			A05

No.1: Second card

Table 3-2-2

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X120			B20	X128			B12
X121			B19	X129			B11
X122			B18	X12A			B10
X123			B17	X12B			B09
X124			B16	X12C			B08
X125			B15	X12D			B07
X126			B14	X12E			B06
X127			B13	X12F			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X130			A20	X138			A12
X131			A19	X139			A11
X132			A18	X13A			A10
X133			A17	X13B			A09
X134			A16	X13C			A08
X135			A15	X13D			A07
X136			A14	X13E			A06
X137			A13	X13F			A05

(Note 1) X108 is a communication terminal reset button signal, and is always set to Y220 (NC reset 1), Y221 (NC reset 2) or Y222 (reset and rewind) by the sequence process.
This signal can be used without DX1**.

(Note 2) Input signals from the operation board cannot be used in the MELDASMAGIC 64.

Input Signals from Machine Operation Board (for DX1)**

No.2: Third card

Table 3-2-3

File register R80							
Bit	**Abbreviation**	**Signal name**	**Connector**	**Bit**	**Abbreviation**	**Signal name**	**Connector**
0			B20	8			B12
1			B19	9			B11
2			B18	A			B10
3			B17	B			B09
4			B16	C			B08
5			B15	D			B07
6			B14	E			B06
7			B13	F			B05

File register R81							
Bit	**Abbreviation**	**Signal name**	**Connector**	**Bit**	**Abbreviation**	**Signal name**	**Connector**
0			A20	8			A12
1			A19	9			A11
2			A18	A			A10
3			A17	B			A09
4			A16	C			A08
5			A15	D			A07
6			A14	E			A06
7			A13	F			A05

No.3: Fourth card

Table 3-2-4

File register R82							
Bit	**Abbreviation**	**Signal name**	**Connector**	**Bit**	**Abbreviation**	**Signal name**	**Connector**
0			B20	8			B12
1			B19	9			B11
2			B18	A			B10
3			B17	B			B09
4			B16	C			B08
5			B15	D			B07
6			B14	E			B06
7			B13	F			B05

File register R83							
Bit	**Abbreviation**	**Signal name**	**Connector**	**Bit**	**Abbreviation**	**Signal name**	**Connector**
0			A20	8			A12
1			A19	9			A11
2			A18	A			A10
3			A17	B			A09
4			A16	C			A08
5			A15	D			A07
6			A14	E			A06
7			A13	F			A05

(Note 1) Input signals from the operation board cannot be used in the MELDASMAGIC 64.

3.3.4 Using QY231 for Machine Operation Board

Input Signals from Machine Operation Board (for QY231)

No.0: First card

Table 3-2-5

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X100			CMD82-36	X108		NC reset (Note1)	CMD82-1
X101			CMD82-4	X109			CMD82-19
X102			CMD82-22	X10A			CMD82-34
X103			CMD82-37	X10B			CMD82-2
X104			CMD82-5	X10C			CMD82-20
X105			CMD82-23	X10D			CMD82-35
X106			CMD82-38	X10E			CMD82-3
X107			CMD82-6	X10F			CMD82-21

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X110			CMD82-26	X118			CMD82-24
X111			CMD82-42	X119			CMD82-39
X112			CMD82-10	X11A			CMD82-7
X113			CMD82-27	X11B			CMD82-25
X114			CMD82-43	X11C			CMD82-40
X115			CMD82-11	X11D			CMD82-8
X116			CMD82-28	X11E			CMD82-41
X117			CMD82-44	X11F			CMD82-9

No.1: First card

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X120			CMD82-47	X128			CMD82-12
X121			CMD82-15	X129			CMD82-29
X122			CMD82-32	X12A			CMD82-45
X123			CMD82-48	X12B			CMD82-13
X124			CMD82-16	X12C			CMD82-30
X125			CMD82-49	X12D			CMD82-46
X126			CMD82-17	X12E			CMD82-14
X127			CMD82-50	X12F			CMD82-31

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
X130			CMD81-10	X138			CMD81-14
X131			CMD81-17	X139			CMD81-1
X132			CMD81-4	X13A			CMD81-8
X133			CMD81-11	X13B			CMD81-15
X134			CMD81-18	X13C			CMD81-2
X135			CMD81-5	X13D			CMD81-9
X136			CMD81-12	X13E			CMD81-16
X137			CMD81-19	X13F			CMD81-3

(Note 1) X108 is a communication terminal reset button signal, and is always set to Y220 (NC reset 1), Y221 (NC reset 2) or Y222 (reset and rewind) by the sequence process. When using the QY231 for the operation board input/output, connecting with the CMD82-1 is not possible.

(Note 2) QY231 has 64 points for input and 48 points for output. Each channel No. setting switch is equivalent to continuous two channels. An even number must be set.

(Note 3) Input signals from the operation board cannot be used in the MELDASMAGIC 64.

3.3.5 PLC Switch/Sensor

PLC Switch Input

Table 3-3-1

Device No.				Device No.			
1st system	2nd system	Abbrev.	Signal name	1st system	2nd system	Abbrev.	Signal name
X140	—		PLC switch #1	X148	—		PLC switch #9
X141	—		PLC switch #2	X149	—		PLC switch #10
X142	—		PLC switch #3	X14A	—		PLC switch #11
X143	—		PLC switch #4	X14B	—		PLC switch #12
X144	—		PLC switch #5	X14C	—		PLC switch #13
X145	—		PLC switch #6	X14D	—		PLC switch #14
X146	—		PLC switch #7	X14E	—		PLC switch #15
X147	—		PLC switch #8	X14F	—		PLC switch #16

Device No.				Device No.			
1st system	2nd system	Abbrev.	Signal name	1st system	2nd system	Abbrev.	Signal name
X150	—		PLC switch #17	X158	—		PLC switch #25
X151	—		PLC switch #18	X159	—		PLC switch #26
X152	—		PLC switch #19	X15A	—		PLC switch #27
X153	—		PLC switch #20	X15B	—		PLC switch #28
X154	—		PLC switch #21	X15C	—		PLC switch #29
X155	—		PLC switch #22	X15D	—		PLC switch #30
X156	—		PLC switch #23	X15E	—		PLC switch #31
X157	—		PLC switch #24	X15F	—		PLC switch #32

Device No.				Device No.			
1st system	2nd system	Abbrev.	Signal name	1st system	2nd system	Abbrev.	Signal name
X160	—		Not used	X168	—		Not used
X161	—			X169	—		
X162	—			X16A	—		
X163	—			X16B	—		
X164	—			X16C	—		
X165	—			X16D	—		
X166	—			X16E	—		
X167	—			X16F	—		

Sensor Input

Table 3-4-1

Device No.				Device No.			
1st system	2nd system	Abbrev.	Signal name	1st system	2nd system	Abbrev.	Signal name
X170	—		— —	X178	—		Skip input 1
X171	—		— —	X179	—		Skip input 2
X172	—		— —	X17A	—		Skip input 3
X173	—		— —	X17B	—		Skip input 4
X174	—		— —	X17C	—		Skip input 5
X175	—		— —	X17D	—		Skip input 6
X176	—		— —	X17E	—		Skip input 7
X177	—		— —	X17F	—		Skip input 8

3.4 Machine Output Signals

3.4.1 Using DX35*/45* for Base I/O Unit

Output Signals to Machine (for DX35*/45*)

No.0: First card

Table 3-5-1

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y0			B20	Y8			B12
Y1			B19	Y9			B11
Y2			B18	YA			B10
Y3			B17	YB			B09
Y4			B16	YC			B08
Y5			B15	YD			B07
Y6			B14	YE			B06
Y7			B13	YF			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y10			A20	Y18			A12
Y11			A19	Y19			A11
Y12			A18	Y1A			A10
Y13			A17	Y1B			A09
Y14			A16	Y1C			A08
Y15			A15	Y1D			A07
Y16			A14	Y1E			A06
Y17			A13	Y1F			A05

No.1: Second card

Table 3-5-2

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y20			B20	Y28			B12
Y21			B19	Y29			B11
Y22			B18	Y2A			B10
Y23			B17	Y2B			B09
Y24			B16	Y2C			B08
Y25			B15	Y2D			B07
Y26			B14	Y2E			B06
Y27			B13	Y2F			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y30			A20	Y38			A12
Y31			A19	Y39			A11
Y32			A18	Y3A			A10
Y33			A17	Y3B			A09
Y34			A16	Y3C			A08
Y35			A15	Y3D			A07
Y36			A14	Y3E			A06
Y37			A13	Y3F			A05

Output Signals to Machine (for DX35*/45*)

No.2: Third card

Table 3-5-3

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y40			B20	Y48			B12
Y41			B19	Y49			B11
Y42			B18	Y4A			B10
Y43			B17	Y4B			B09
Y44			B16	Y4C			B08
Y45			B15	Y4D			B07
Y46			B14	Y4E			B06
Y47			B13	Y4F			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y50			A20	Y58			A12
Y51			A19	Y59			A11
Y52			A18	Y5A			A10
Y53			A17	Y5B			A09
Y54			A16	Y5C			A08
Y55			A15	Y5D			A07
Y56			A14	Y5E			A06
Y57			A13	Y5F			A05

No.3: Fourth card

Table 3-5-4

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y60			B20	Y68			B12
Y61			B19	Y69			B11
Y62			B18	Y6A			B10
Y63			B17	Y6B			B09
Y64			B16	Y6C			B08
Y65			B15	Y6D			B07
Y66			B14	Y6E			B06
Y67			B13	Y6F			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y70			A20	Y78			A12
Y71			A19	Y79			A11
Y72			A18	Y7A			A10
Y73			A17	Y7B			A09
Y74			A16	Y7C			A08
Y75			A15	Y7D			A07
Y76			A14	Y7E			A06
Y77			A13	Y7F			A05

Output Signals to Machine (for DX35*/45*)

No.4: Fifth card

Table 3-5-5

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y80			B20	Y88			B12
Y81			B19	Y89			B11
Y82			B18	Y8A			B10
Y83			B17	Y8B			B09
Y84			B16	Y8C			B08
Y85			B15	Y8D			B07
Y86			B14	Y8E			B06
Y87			B13	Y8F			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y90			A20	Y98			A12
Y91			A19	Y99			A11
Y92			A18	Y9A			A10
Y93			A17	Y9B			A09
Y94			A16	Y9C			A08
Y95			A15	Y9D			A07
Y96			A14	Y9E			A06
Y97			A13	Y9F			A05

No.5: Sixth card

Table 3-5-6

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
YA0			B20	YA8			B12
YA1			B19	YA9			B11
YA2			B18	YAA			B10
YA3			B17	YAB			B09
YA4			B16	YAC			B08
YA5			B15	YAD			B07
YA6			B14	YAE			B06
YA7			B13	YAF			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
YB0			A20	YB8			A12
YB1			A19	YB9			A11
YB2			A18	YBA			A10
YB3			A17	YBB			A09
YB4			A16	YBC			A08
YB5			A15	YBD			A07
YB6			A14	YBE			A06
YB7			A13	YBF			A05

Output Signals to Machine (for DX35*/45*)

No.6: Seventh card

Table 3-5-7

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
YC0			B20	YC8			B12
YC1			B19	YC9			B11
YC2			B18	YCA			B10
YC3			B17	YCB			B09
YC4			B16	YCC			B08
YC5			B15	YCD			B07
YC6			B14	YCE			B06
YC7			B13	YCF			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
YD0			A20	YD8			A12
YD1			A19	YD9			A11
YD2			A18	YDA			A10
YD3			A17	YDB			A09
YD4			A16	YDC			A08
YD5			A15	YDD			A07
YD6			A14	YDE			A06
YD7			A13	YDF			A05

No.7: Eighth card

Table 3-5-8

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
YE0			B20	YE8			B12
YE1			B19	YE9			B11
YE2			B18	YEA			B10
YE3			B17	YEB			B09
YE4			B16	YEC			B08
YE5			B15	YED			B07
YE6			B14	YEE			B06
YE7			B13	YEF			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
YF0			A20	YF8			A12
YF1			A19	YF9			A11
YF2			A18	YFA			A10
YF3			A17	YFB			A09
YF4			A16	YFC			A08
YF5			A15	YFD			A07
YF6			A14	YFE			A06
YF7			A13	YFF			A05

3.4.2 Using HR378 for Base I/O Unit

Output Signals to Machine (for HR378)

No.0: First card

Table 3-5-9

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y00			MJ3-2	Y08			MJ3-12
Y01			MJ3-3	Y09			MJ3-13
Y02			MJ3-4	Y0A			MJ3-14
Y03			MJ3-5	Y0B			MJ3-15
Y04			MJ3-7	Y0C			MJ3-17
Y05			MJ3-8	Y0D			MJ3-18
Y06			MJ3-9	Y0E			MJ3-19
Y07			MJ3-10	Y0F			MJ3-20

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y10			MJ3-22	Y18			MJ3-32
Y11			MJ3-23	Y19			MJ3-33
Y12			MJ3-24	Y1A			MJ3-34
Y13			MJ3-25	Y1B			MJ3-35
Y14			MJ3-27	Y1C			MJ3-37
Y15			MJ3-28	Y1D			MJ3-38
Y16			MJ3-29	Y1E			MJ3-39
Y17			MJ3-30	Y1F			MJ3-40

No.1: First card

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y20			MJ3-52	Y28			MJ3-62
Y21			MJ3-53	Y29			MJ3-63
Y22			MJ3-54	Y2A			MJ3-64
Y23			MJ3-55	Y2B			MJ3-65
Y24			MJ3-57	Y2C			MJ3-67
Y25			MJ3-58	Y2D			MJ3-68
Y26			MJ3-59	Y2E			MJ3-69
Y27			MJ3-60	Y2F			MJ3-70

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y30			MJ3-72	Y38			MJ3-88
Y31			MJ3-74	Y39			MJ3-90
Y32			MJ3-76	Y3A			MJ3-92
Y33			MJ3-78	Y3B			MJ3-94
Y34			MJ3-80	Y3C			MJ3-96
Y35			MJ3-82	Y3D			MJ3-97
Y36			MJ3-84	Y3E			MJ3-98
Y37			MJ3-86	Y3F			MJ3-99

(Note 1) With the base I/O unit HR378, each card has 64 points for input and 64 points for output.

3.4.3 Using DX1** for Machine Operation Board

Output Signals to Machine Operation Board (for DX1＊＊)

No.0: First card

Table 3-6-1

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y100			B20	Y108			B12
Y101			B19	Y109			B11
Y102			B18	Y10A			B10
Y103			B17	Y10B			B09
Y104			B16	Y10C			B08
Y105			B15	Y10D			B07
Y106			B14	Y10E			B06
Y107			B13	Y10F			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y110			A20	Y118			A12
Y111			A19	Y119			A11
Y112			A18	Y11A			A10
Y113			A17	Y11B			A09
Y114			A16	Y11C			A08
Y115			A15	Y11D			A07
Y116			A14	Y11E			A06
Y117			A13	Y11F			A05

No.1: Second card

Table 3-6-2

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y120			B20	Y128			B12
Y121			B19	Y129			B11
Y122			B18	Y12A			B10
Y123			B17	Y12B			B09
Y124			B16	Y12C			B08
Y125			B15	Y12D			B07
Y126			B14	Y12E			B06
Y127			B13	Y12F			B05

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y130			A20	Y138			A12
Y131			A19	Y139			A11
Y132			A18	Y13A			A10
Y133			A17	Y13B			A09
Y134			A16	Y13C			A08
Y135			A15	Y13D			A07
Y136			A14	Y13E			A06
Y137			A13	Y13F			A05

(Note 1) Output signals to the operation board cannot be used in the MELDASMAGIC 64.

Output Signals to Machine Operation Board (for DX1)**

No.2: Third card

Table 3-6-3

File register R180							
Bit	**Abbreviation**	**Signal name**	**Connector**	**Bit**	**Abbreviation**	**Signal name**	**Connector**
0			B20	8			B12
1			B19	9			B11
2			B18	A			B10
3			B17	B			B09
4			B16	C			B08
5			B15	D			B07
6			B14	E			B06
7			B13	F			B05

File register R181							
Bit	**Abbreviation**	**Signal name**	**Connector**	**Bit**	**Abbreviation**	**Signal name**	**Connector**
0			A20	8			A12
1			A19	9			A11
2			A18	A			A10
3			A17	B			A09
4			A16	C			A08
5			A15	D			A07
6			A14	E			A06
7			A13	F			A05

No.3: Fourth card

Table 3-6-4

File register R182							
Bit	**Abbreviation**	**Signal name**	**Connector**	**Bit**	**Abbreviation**	**Signal name**	**Connector**
0			B20	8			B12
1			B19	9			B11
2			B18	A			B10
3			B17	B			B09
4			B16	C			B08
5			B15	D			B07
6			B14	E			B06
7			B13	F			B05

(Note 1) Output signals to the operation board cannot be used in the MELDASMAGIC 64.

3.4.4 Using QY231 for Machine Operation Board

Output Signals to Machine Operation Board (for QY231)

No.0: First card

Table 3-6-5

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y100			CFD83-36	Y108			CFD83-1
Y101			CFD83-4	Y109			CFD83-19
Y102			CFD83-22	Y10A			CFD83-34
Y103			CFD83-37	Y10B			CFD83-2
Y104			CFD83-5	Y10C			CFD83-20
Y105			CFD83-23	Y10D			CFD83-35
Y106			CFD83-38	Y10E			CFD83-3
Y107			CFD83-6	Y10F			CFD83-21

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y110			CFD83-26	Y118			CFD83-24
Y111			CFD83-42	Y119			CFD83-39
Y112			CFD83-10	Y11A			CFD83-7
Y113			CFD83-27	Y11B			CFD83-25
Y114			CFD83-43	Y11C			CFD83-40
Y115			CFD83-11	Y11D			CFD83-8
Y116			CFD83-28	Y11E			CFD83-41
Y117			CFD83-44	Y11F			CFD83-9

No.0: First card

Device	Abbreviation	Signal name	Connector	Device	Abbreviation	Signal name	Connector
Y120			CFD83-47	Y128			CFD83-12
Y121			CFD83-15	Y129			CFD83-29
Y122			CFD83-32	Y12A			CFD83-45
Y123			CFD83-48	Y12B			CFD83-13
Y124			CFD83-16	Y12C			CFD83-30
Y125			CFD83-49	Y12D			CFD83-46
Y126			CFD83-17	Y12E			CFD83-14
Y127			CFD83-50	Y12F			CFD83-31

(Note 1) QY231 has 64 points for input and 48 points for output. Each channel No. setting switch is equivalent to continuous two channels. An even number must be set.

(Note 2) Output signals to the operation board cannot be used in the MELDASMAGIC 64.

3.4.5 PLC Switch

PLC Switch Output

Table 3-7-1

Device No.				Device No.			
1st system	2nd system	Abbrev.	Signal name	1st system	2nd system	Abbrev.	Signal name
Y160	—		PLC switch highlight #1	Y168	—		PLC switch highlight #9
Y161	—		PLC switch highlight #2	Y169	—		PLC switch highlight #10
Y162	—		PLC switch highlight #3	Y16A	—		PLC switch highlight #11
Y163	—		PLC switch highlight #4	Y16B	—		PLC switch highlight #12
Y164	—		PLC switch highlight #5	Y16C	—		PLC switch highlight #13
Y165	—		PLC switch highlight #6	Y16D	—		PLC switch highlight #14
Y166	—		PLC switch highlight #7	Y16E	—		PLC switch highlight #15
Y167	—		PLC switch highlight #8	Y16F	—		PLC switch highlight #16

Device No.				Device No.			
1st system	2nd system	Abbrev.	Signal name	1st system	2nd system	Abbrev.	Signal name
Y170	—		PLC switch highlight #17	Y178	—		PLC switch highlight #25
Y171	—		PLC switch highlight #18	Y179	—		PLC switch highlight #26
Y172	—		PLC switch highlight #19	Y17A	—		PLC switch highlight #27
Y173	—		PLC switch highlight #20	Y17B	—		PLC switch highlight #28
Y174	—		PLC switch highlight #21	Y17C	—		PLC switch highlight #29
Y175	—		PLC switch highlight #22	Y17D	—		PLC switch highlight #30
Y176	—		PLC switch highlight #23	Y17E	—		PLC switch highlight #31
Y177	—		PLC switch highlight #24	Y17F	—		PLC switch highlight #32

4. INPUT/OUTPUT SIGNALS TABLE WITH CONTROLLER

4.1 How to Read Input/Output Signal Table

Head device of each card

CNC → PLC

Table 4-2-2

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R64	—		Display information	R72	—		User macro output #1032 **Note 1)**
R65	—			R73	—		
R66	—			R74	—		User macro output #1033
R67	—			R75	—		
R68	—		PLC main scan time	R76	—		User macro output #1034
R69	—		Emergency stop cause	R77	—		
R70	—		DIO card data	R78	—		User macro output #1035
R71	R271		Program execution state (editing related) ▲	R79	—		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R80	—		Add-on (expansion) operation board input signal 1	R88	R288		Near reference position (per reference position)
R81	—		signal 2	R89	R289		
R82	—		signal 3	R90	R290		Presetter contact
R83	—		signal 4	R91	R291		Presetting interlock
R84	—		M-NET OT check	R92	R292		
R85	R285			R93	R293		
R86	—		PC high-speed process time	R94	R294		
R87	R287			R95	R295		

PLC → CNC (PLC4B)

Table 4-3-1 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y180	W0	DTCH1	Control axis detach 1st axis	Y188	W8	*SVF1	Servo OFF 1st axis
Y181	W1	DTCH2	2nd axis	Y189	W9	*SVF2	Servo OFF 2nd axis
Y182	W2	DTCH3	3rd axis	Y18A	WA	*SVF3	Servo OFF 3rd axis
Y183	W3	DTCH4	4th axis	Y18B	WB	*SVF4	Servo OFF 4th axis
Y184	W4	DTCH5	5th axis	Y18C	WC	*SVF5	Servo OFF 5th axis
Y185	W5	DTCH6	6th axis	Y18D	WD	*SVF6	Servo OFF 6th axis
Y186	W6	DTCH7	7th axis	Y18E	WE	*SVF7	Servo OFF 7th axis
Y187	W7	DTCH8	8th axis	Y18F	WF	*SVF8	Servo OFF 8th axis

(Note 1) [ ] are 1 word (16-bit) data.

(Note 2) Signals marked with [—] in the column for the 2nd part system indicate there is no signal corresponding to the 2nd part system, and the signal for the 1st part system side is used commonly.

(Note 3) Signals marked with * in the abbreviation are handled as B contacts.

4.2 Classification of Input/Output Signals with Controller

There are 1-bit unit, and 16-bit or 32-bit unit controller input/output signals, which are classified as shown below.
Refer to the following allocation tables for the signal allocations.
"1st sys" of "Device No." means the device for the first part system, that goes for "2nd sys" and the second part system.
"1st SP" of "Device No." means the device for the first spindle, that goes for "2nd SP" and the second spindle.

	Signal type	Allocation table	Explanation
Input	DI (1st part system or common for part systems)	Table 4-1-1 to Table 4-1-12	(1) Allocated to device X. (2) Data calculated in bit units are allocated as a principle.
	DI (2nd part system)		(1) Allocated to device U, I (device X for GX Developer). (2) Data calculated in bit units are allocated as a principle.
	Data	Table 4-2-1 to Table 4-2-8	(1) Allocated to device R. (2) Data handled in 16-bit or 32-bit units is allocated as a principle.
Output	DO (1st part system or common for part systems)	Table 4-3-1 to Table 4-3-14	(1) Allocated to device Y. (2) Data calculated in bit units are allocated as a principle.
	DO (2nd part system)		(1) Allocated to device W, J (device Y for GX Developer). (2) Data calculated in bit units are allocated as a principle.
	Data	Table 4-4-1 to Table 4-4-6	(1) Allocated to device R. (2) Data handled in 16-bit or 32-bit units is allocated as a principle.
Others	Special relay	Table 4-5-1 to Table 4-5-2	(1) Allocated to device E (device SM for GX Developer). (2) The sequence command calculation state, results and the signals with special operations are allocated.
	Classified under purpose	Table 4-6-1 to Table 4-6-11	(1) Devices are classified under the usage purpose.

CNC → PLC (GX Developer)

Table 4-1-1 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X180	X4C0	RDY1	Servo ready 1st axis	X188	X4C8	AX1	Axis selected 1st axis
X181	X4C1	RDY2	Servo ready 2nd axis	X189	X4C9	AX2	Axis selected 2nd axis
X182	X4C2	RDY3	Servo ready 3rd axis	X18A	X4CA	AX3	Axis selected 3rd axis
X183	X4C3	RDY4	Servo ready 4th axis	X18B	X4CB	AX4	Axis selected 4th axis
X184	X4C4	RDY5	Servo ready 5th axis	X18C	X4CC	AX5	Axis selected 5th axis
X185	X4C5	RDY6	Servo ready 6th axis	X18D	X4CD	AX6	Axis selected 6th axis
X186	X4C6	RDY7	Servo ready 7th axis	X18E	X4CE	AX7	Axis selected 7th axis
X187	X4C7	RDY8	Servo ready 8th axis	X18F	X4CF	AX8	Axis selected 8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X190	X4D0	MVP1	In plus motion +1st axis	X198	X4D8	MVM1	In minus motion -1st axis
X191	X4D1	MVP2	In plus motion +2nd axis	X199	X4D9	MVM2	In minus motion -2nd axis
X192	X4D2	MVP3	In plus motion +3rd axis	X19A	X4DA	MVM3	In minus motion -3rd axis
X193	X4D3	MVP4	In plus motion +4th axis	X19B	X4DB	MVM4	In minus motion -4th axis
X194	X4D4	MVP5	In plus motion +5th axis	X19C	X4DC	MVM5	In minus motion -5th axis
X195	X4D5	MVP6	In plus motion +6th axis	X19D	X4DD	MVM6	In minus motion -6th axis
X196	X4D6	MVP7	In plus motion +7th axis	X19E	X4DE	MVM7	In minus motion -7th axis
X197	X4D7	MVP8	In plus motion +8th axis	X19F	X4DF	MVM8	In minus motion -8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X1A0	X4E0	ZP11	1st reference position reached 1st axis	X1A8	X4E8	ZP21	2nd reference position reached 1st axis
X1A1	X4E1	ZP12	2nd axis	X1A9	X4E9	ZP22	2nd axis
X1A2	X4E2	ZP13	3rd axis	X1AA	X4EA	ZP23	3rd axis
X1A3	X4E3	ZP14	4th axis	X1AB	X4EB	ZP24	4th axis
X1A4	X4E4	ZP15	5th axis	X1AC	X4EC	ZP25	5th axis
X1A5	X4E5	ZP16	6th axis	X1AD	X4ED	ZP26	6th axis
X1A6	X4E6	ZP17	7th axis	X1AE	X4EE	ZP27	7th axis
X1A7	X4E7	ZP18	8th axis	X1AF	X4EF	ZP28	8th axis

CNC → PLC (GX Developer) Table 4-1-2 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X1B0	X4F0	ZP31	3rd reference position reached 1st axis	X1B8	X4F8	ZP41	4th reference position reached 1st axis
X1B1	X4F1	ZP32	2nd axis	X1B9	X4F9	ZP42	2nd axis
X1B2	X4F2	ZP33	3rd axis	X1BA	X4FA	ZP43	3rd axis
X1B3	X4F3	ZP34	4th axis	X1BB	X4FB	ZP44	4th axis
X1B4	X4F4	ZP35	5th axis	X1BC	X4FC	ZP45	5th axis
X1B5	X4F5	ZP36	6th axis	X1BD	X4FD	ZP46	6th axis
X1B6	X4F6	ZP37	7th axis	X1BE	X4FE	ZP47	7th axis
X1B7	X4F7	ZP38	8th axis	X1BF	X4FF	ZP48	8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X1C0	X500			X1C8	X508		— —
X1C1	X501			X1C9	X509		— —
X1C2	X502	SSE	Search & start (error)	X1CA	X50A		— —
X1C3	X503		Search & start (search)	X1CB	X50B		— —
X1C4	X504		Power OFF request (SP regeneration circuit err)	X1CC	X50C		— —
X1C5	X505			X1CD	X50D		— —
X1C6	X506			X1CE	X50E		— —
X1C7	X507			X1CF	X50F		— —

Device No.				Device No.			
1st SP	2nd SP	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X1D0	X510		— —	X1D8	X518	NR F1	Near reference position 1st axis
X1D1	X511		— —	X1D9	X519	NR F2	2nd axis
X1D2	X512			X1DA	X51A	NR F3	3rd axis
X1D3	X513			X1DB	X51B	NR F4	4th axis
X1D4	X514			X1DC	X51C	NR F5	5th axis
X1D5	X515	SD2	Speed detect 2	X1DD	X51D	NR F6	6th axis
X1D6	X516	MCSA	In M coil selected	X1DE	X51E	NR F7	7th axis
X1D7	X517		Index positioning complete	X1DF	X51F	NR F8	8th axis

— — : Reserved for the system.

CNC → PLC (GX Developer) Table 4-1-3 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X1E0	X520	JO	In jog mode	X1E8	X528	MEMO	In memory mode
X1E1	X521	HO	In handle mode	X1E9	X529	TO	In tape mode
X1E2	X522	SO	In incremental mode	X1EA	X52A		— —
X1E3	X523	PTPO	In manual random feed mode	X1EB	X52B	DO	In MDI mode
X1E4	X524	ZRNO	In reference position return mode	X1EC	X52C		— —
X1E5	X525	ASTO	In automatic initial set mode	X1ED	X52D		In direct operation ▲
X1E6	X526		In JOG-handle simultaneous mode	X1EE	X52E		
X1E7	X527			X1EF	X52F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X1F0	X530	MA	Controller ready complete	X1F8	X538	DEN	Motion command complete
X1F1	X531	SA	Servo ready complete	X1F9	X539	TIMP	All axes in-position
X1F2	X532	OP	In auto operation "run"	X1FA	X53A	TSMZ	All axes smoothing zero
X1F3	X533	STL	In auto operation "start"	X1FB	X53B		— —
X1F4	X534	SPL	In auto operation "pause"	X1FC	X53C	CXFIN	Manual random feed complete
X1F5	X535	RST	In "reset"	X1FD	X53D		
X1F6	X536	CXN	In manual random feed	X1FE	X53E		
X1F7	X537	RWD	In rewind	X1FF	X53F		In high-speed mode (G05)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X200	X540	RPN	In rapid traverse	X208	X548	INCH	In inch unit select
X201	X541	CUT	In cutting feed	X209	X549	DLKN	In display lock
X202	X542	TAP	In tapping	X20A	X54A	F1DN	F1-digit commanded
X203	X543	THRD	In thread cutting	X20B	X54B	TLFO	In tool life management
X204	X544	SYN	In synchronous feed	X20C	X54C	SUPP	Spindle speed upper limit over
X205	X545	CSS	In constant surface speed	X20D	X54D	SLOW	Spindle speed lower limit over
X206	X546	SKIP	In skip	X20E	X54E	TLOV	Tool life over
X207	X547	ZRNN	In reference position return	X20F	X54F	BATAL	Battery alarm

— — : Reserved for the system.

▲ : For specific manufacturers.

CNC → PLC (GX Developer) Table 4-1-4 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X210	X550	AL1	NC alarm 1	X218	X558	F11	F1-digit No.1
X211	X551	AL2	NC alarm 2 (Servo alarm)	X219	X559	F12	F1-digit No.2
X212	X552	AL3	NC alarm 3 (Program error)	X21A	X55A	F14	F1-digit No.4
X213	X553	AL4	NC alarm 4 (Operation error)	X21B	X55B	—	(Always "0")
X214	X554	SIGE	S-analog gear No. illegal	X21C	X55C		Waiting between part systems
X215	X555	SOVE	S-analog max./min. command value over	X21D	X55D		
X216	X556	SNGE	S-analog no gear selected	X21E	X55E		
X217	X557	ASLE	Illegal axis selected	X21F	X55F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X220	X560	DM00	M code independent output M00	X228	X568		(EF)
X221	X561	DM01	M01	X229	X569	MMS	Manual numerical command
X222	X562	DM02	M02	X22A	X56A		— —
X223	X563	DM30	M30	X22B	X56B	TCP	Tool change position return complete
X224	X564			X22C	X56C	TCRQ	New tool change
X225	X565	GR1	Spindle gear shift 1	X22D	X56D		— —
X226	X566	GR2	Spindle gear shift 2	X22E	X56E		
X227	X567	—	(Always "0")	X22F	X56F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X230	X570	MF1	M function strobe 1	X238	X578	TF1	T function strobe 1
X231	X571	MF2	M function strobe 2	X239	X579	—	— —
X232	X572	MF3	M function strobe 3	X23A	X57A	—	— —
X233	X573	MF4	M function strobe 4	X23B	X57B	—	— —
X234	X574	SF1	S function strobe 1	X23C	X57C	BF1	2nd M function strobe 1
X235	X575	SF2	S function strobe 2	X23D	X57D	—	— —
X236	X576	SF3	S function strobe 3	X23E	X57E	—	— —
X237	X577	SF4	S function strobe 4	X23F	X57F	—	— —

— — : Reserved for the system.

CNC → PLC (GX Developer) Table 4-1-5 (GX Developer)

Device No.				Device No.			
1st SP	2nd SP	Abbrev.	Signal name	1st SP	2nd SP	Abbrev.	Signal name
X240	X580		Spindle 2nd in-position	X248	X588	SMA	Spindle ready-ON
X241	X581	CDO	Current detect	X249	X589	SSA	Spindle servo-ON
X242	X582	VRO	Speed detect	X24A	X58A	SEMG	Spindle emergency stop
X243	X583	FLO	In spindle alarm	X24B	X58B	SSRN	Spindle forward run
X244	X584	ZSO	Zero speed	X24C	X58C	SSRI	Spindle reverse run
X245	X585	USO	Up-to-speed	X24D	X58D	SZPH	Z-phase passed
X246	X586	ORAO	Spindle in-position	X24E	X58E	SIMP	Position loop in-position
X247	X587	LCSA	In L coil selected	X24F	X58F	STLQ	Torque limit

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X250	X590		— —	X258	X598		— —
X251	X591		— —	X259	X599		— —
X252	X592		— —	X25A	X59A		— —
X253	X593		— —	X25B	X59B		— —
X254	X594		— —	X25C	X59C		— —
X255	X595		— —	X25D	X59D		— —
X256	X596		— —	X25E	X59E		— —
X257	X597		— —	X25F	X59F		— —

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X260	X5A0	CHOP	In chopping start	X268	X5A8		Load monitor In teaching/monitor execution ▲
X261	X5A1	CHP1	Basic position – upper dead center point	X269	X5A9		Teaching mode valid ▲
X262	X5A2	CHP2	Upper dead center point – bottom dead point	X26A	X5AA		Monitor mode valid ▲
X263	X5A3	CHP3	Bottom dead center point – upper dead point	X26B	X5AB		Adaptive control valid ▲
X264	X5A4	CHP4	Upper dead center point – basic position	X26C	X5AC		
X265	X5A5	CHPMD	In chopping mode	X26D	X5AD	TRVE	Tap retract possible
X266	X5A6			X26E	X5AE	PCNT	No. of work machining over
X267	X5A7			X26F	X5AF	ABSW	Absolute position warning

— — : Reserved for the system.

▲ : For specific manufacturers.

CNC → PLC (GX Developer) Table 4-1-6 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X270	X5B0	PSW1	Position switch 1	X278	X5B8		— —
X271	X5B1	PSW2	Position switch 2	X279	X5B9		— —
X272	X5B2	PSW3	Position switch 3	X27A	X5BA		— —
X273	X5B3	PSW4	Position switch 4	X27B	X5BB		— —
X274	X5B4	PSW5	Position switch 5	X27C	X5BC		— —
X275	X5B5	PSW6	Position switch 6	X27D	X5BD		— —
X276	X5B6	PSW7	Position switch 7	X27E	X5BE		— —
X277	X5B7	PSW8	Position switch 8	X27F	X5BF		— —

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X280	X5C0	ZSF1	Zero point initialization set completed 1st axis	X288	X5C8	ZSE1	Zero point initialization set error completed 1st axis
X281	X5C1	ZSF2	2nd axis	X289	X5C9	ZSE2	2nd axis
X282	X5C2	ZSF3	3rd axis	X28A	X5CA	ZSE3	3rd axis
X283	X5C3	ZSF4	4th axis	X28B	X5CB	ZSE4	4th axis
X284	X5C4	ZSF5	5th axis	X28C	X5CC	ZSE5	5th axis
X285	X5C5	ZSF6	6th axis	X28D	X5CD	ZSE6	6th axis
X286	X5C6	ZSF7	7th axis	X28E	X5CE	ZSE7	7th axis
X287	X5C7	ZSF8	8th axis	X28F	X5CF	ZSE8	8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X290	X5D0	ILI1	In current limit 1st axis	X298	X5D8	ILA1	Current limit reached 1st axis
X291	X5D1	ILI2	2nd axis	X299	X5D9	ILA2	2nd axis
X292	X5D2	ILI3	3rd axis	X29A	X5DA	ILA3	3rd axis
X293	X5D3	ILI4	4th axis	X29B	X5DB	ILA4	4th axis
X294	X5D4	ILI5	5th axis	X29C	X5DC	ILA5	5th axis
X295	X5D5	ILI6	6th axis	X29D	X5DD	ILA6	6th axis
X296	X5D6	ILI7	7th axis	X29E	X5DE	ILA7	7th axis
X297	X5D7	ILI8	8th axis	X29F	X5DF	ILA8	8th axis

— — : Reserved for the system.

CNC → PLC (GX Developer) Table 4-1-7 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X2A0	X5E0		In polygon mode (Spindle-NC axis)	X2A8	X5E8		
X2A1	X5E1	AL5	NC alarm 5	X2A9	X5E9		
X2A2	X5E2		In polygon mode (Spindle-Spindle)	X2AA	X5EA		
X2A3	X5E3		Spindle-spindle polygon synchronization complete	X2AB	X5EB		
X2A4	X5E4			X2AC	X5EC		
X2A5	X5E5			X2AD	X5ED		
X2A6	X5E6			X2AE	X5EE		
X2A7	X5E7			X2AF	X5EF		For HVS control (position err detect) ▲

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X2B0	X5F0		Up-to-speed 1st axis	X2B8	X5F8		Unclamp command 1st axis
X2B1	X5F1		2nd axis	X2B9	X5F9		2nd axis
X2B2	X5F2		3rd axis	X2BA	X5FA		3rd axis
X2B3	X5F3		4th axis	X2BB	X5FB		4th axis
X2B4	X5F4		5th axis	X2BC	X5FC		5th axis
X2B5	X5F5		6th axis	X2BD	X5FD		6th axis
X2B6	X5F6		7th axis	X2BE	X5FE		7th axis
X2B7	X5F7		8th axis	X2BF	X5FF		8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X2C0	X600	RTAP	In synchronized tapping selection (M command)	X2C8	X608	ENB	Spindle enable
X2C1	X601		In small diameter deep hole cycle	X2C9	X609		
X2C2	X602		INC high-speed retract function valid state ▲	X2CA	X60A		
X2C3	X603		In INC high-speed retract function operation ▲	X2CB	X60B		
X2C4	X604		Optimum pecking function valid state ▲	X2CC	X60C		
X2C5	X605		In optimum pecking function operation ▲	X2CD	X60D		
X2C6	X606		Load monitor function valid state ▲	X2CE	X60E		
X2C7	X607		In load monitor function operation ▲	X2CF	X60F		

▲ : For specific manufacturers.

CNC → PLC (GX Developer) Table 4-1-8 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X2D0	X610		In barrier valid (left)	X2D8	X618		
X2D1	X611		In barrier valid (right)	X2D9	X619		
X2D2	X612			X2DA	X61A		
X2D3	X613			X2DB	X61B		
X2D4	X614			X2DC	X61C		
X2D5	X615			X2DD	X61D		
X2D6	X616			X2DE	X61E		
X2D7	X617			X2DF	X61F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X2E0	X620		In cross machining control 1st axis	X2E8	X628		In synchronous/ superimposition control 1st axis
X2E1	X621		2nd axis	X2E9	X629		2nd axis
X2E2	X622		3rd axis	X2EA	X62A		3rd axis
X2E3	X623		4th axis	X2EB	X62B		4th axis
X2E4	X624		5th axis	X2EC	X62C		5th axis
X2E5	X625		6th axis	X2ED	X62D		6th axis
X2E6	X626		7th axis	X2EE	X62E		7th axis
X2E7	X627		8th axis	X2EF	X62F		8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X2F0	X630			X2F8	X638		
X2F1	X631			X2F9	X639		
X2F2	X632			X2FA	X63A		
X2F3	X633			X2FB	X63B		
X2F4	X634			X2FC	X63C		
X2F5	X635			X2FD	X63D		
X2F6	X636			X2FE	X63E		
X2F7	X637			X2FF	X63F		

CNC → PLC (GX Developer) Table 4-1-9 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X300	X9C0	DROPNS	Door open enable	X308	—	SPSYN1	In spindle synchronous control
X301	X9C1			X309	—	FSPRV	Spindle rotation speed synchronization complete
X302	—		MELDASNET diagnosis output complete	X30A	—	FSPPH	Spindle phase synchronization complete
X303	X9C3	NETSMP	MELDASNET in sampling	X30B	—	SPSYN2	In spindle synchronous control 2 (D)
X304	—	RPIN	In remote program input	X30C	—		— —
X305	—	RPFIN	Remote program input complete	X30D	—		— —
X306	—	RPERR	Remote program input error	X30E	—	SPCMP	Chuck close confirmation
X307	—		In tool ID communication ▲	X30F	—		Power OFF required after parameter change

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st SP	2nd SP	Abbrev.	Signal name
X310	—		— —	X318	X9D8		In magnetic bearing ready ON
X311	—		— —	X319	X9D9		In magnetic bearing servo ON
X312	—		— —	X31A	X9DA		— —
X313	—		— —	X31B	X9DB		— —
X314	—		— —	X31C	X9DC		In magnetic bearing warning
X315	—		— —	X31D	X9DD		— —
X316	—		— —	X31E	X9DE		— —
X317	—		— —	X31F	X9DF		In magnetic bearing alarm

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X320	—		Door open enable 1-2	X328	X9E8		
X321	—		— —	X329	X9E9		
X322	X9E2			X32A	X9EA		
X323	X9E3			X32B	X9EB		
X324	X9E4			X32C	X9EC		
X325	X9E5			X32D	X9ED		
X326	X9E6			X32E	X9EE		
X327	X9E7			X32F	X9EF		

— — : Reserved for the system.

▲ : For specific manufacturers.

CNC → PLC (GX Developer) Table 4-1-10 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X330	X9F0			X338	X9F8		
X331	X9F1			X339	X9F9		
X332	X9F2			X33A	X9FA		
X333	X9F3			X33B	X9FB		
X334	X9F4			X33C	X9FC		
X335	X9F5			X33D	X9FD		
X336	X9F6			X33E	X9FE		
X337	X9F7			X33F	X9FF		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X340	XA00			X348	XA08		
X341	XA01			X349	XA09		
X342	XA02			X34A	XA0A		
X343	XA03			X34B	XA0B		
X344	XA04			X34C	XA0C		
X345	XA05			X34D	XA0D		
X346	XA06			X34E	XA0E		
X347	XA07			X34F	XA0F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X350	XA10			X358	XA18		
X351	XA11			X359	XA19		
X352	XA12			X35A	XA1A		
X353	XA13			X35B	XA1B		
X354	XA14			X35C	XA1C		
X355	XA15			X35D	XA1D		
X356	XA16			X35E	XA1E		
X357	XA17			X35F	XA1F		

CNC → PLC (GX Developer)

Table 4-1-11 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X360	XA20			X368	XA28		
X361	XA21			X369	XA29		
X362	XA22			X36A	XA2A		
X363	XA23			X36B	XA2B		
X364	XA24			X36C	XA2C		
X365	XA25			X36D	XA2D		
X366	XA26			X36E	XA2E		
X367	XA27			X36F	XA2F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X370	XA30			X378	XA38		
X371	XA31			X379	XA39		
X372	XA32			X37A	XA3A		
X373	XA33			X37B	XA3B		
X374	XA34			X37C	XA3C		
X375	XA35			X37D	XA3D		
X376	XA36			X37E	XA3E		
X377	XA37			X37F	XA3F		

CNC → PLC (GX Developer) Table 4-1-12 (GX Developer)

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
X940	X950	ENB	Spindle enable	X948	X958		
X941	X951			X949	X959		
X942	X952			X94A	X95A		
X943	X953			X94B	X95B		
X944	X954			X94C	X95C		
X945	X955			X94D	X95D		
X946	X956			X94E	X95E		
X947	X957			X94F	X95F		

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
XA40	XA60	SUPP	Spindle speed upper limit over	XA48	XA68		— —
XA41	XA61	SLOW	Spindle speed lower limit over	XA49	XA69		— —
XA42	XA62	SIGE	S-analog gear No. illegal	XA4A	XA6A		
XA43	XA63	SOVE	S-analog max./min. command value over	XA4B	XA6B		
XA44	XA64	SNGE	S-analog no gear selected	XA4C	XA6C		
XA45	XA65	GR1	Spindle gear shift command 1	XA4D	XA6D	SD2	Speed detect 2
XA46	XA66	GR2	Spindle gear shift command 2	XA4E	XA6E	MCSA	In M coil selected
XA47	XA67	—	(Always "0")	XA4F	XA6F		Index positioning complete

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
XA50	XA70		2nd in-position (D)	XA58	XA78	SMA	Spindle ready-ON
XA51	XA71	CDO	Current detect	XA59	XA79	SSA	Spindle servo-ON
XA52	XA72	VRO	Speed detect	XA5A	XA7A	SEMG	Spindle emergency stop
XA53	XA73	FLO	In spindle alarm	XA5B	XA7B	SSRN	Spindle forward run
XA54	XA74	ZSO	Zero speed	XA5C	XA7C	SSRI	Spindle reverse run
XA55	XA75	USO	Up-to-speed	XA5D	XA7D		Z-phase passed
XA56	XA76	ORAO	Spindle in-position	XA5E	XA7E	SIMP	Position loop in-position
XA57	XA77	LCSA	In L coil selected	XA5F	XA7F	STLQ	Torque limit

— — : Reserved for the system.

CNC → PLC (PLC4B)

Table 4-1-1 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X180	U0	RDY1	Servo ready 1st axis	X188	U8	AX1	Axis selected 1st axis
X181	U1	RDY2	Servo ready 2nd axis	X189	U9	AX2	Axis selected 2nd axis
X182	U2	RDY3	Servo ready 3rd axis	X18A	UA	AX3	Axis selected 3rd axis
X183	U3	RDY4	Servo ready 4th axis	X18B	UB	AX4	Axis selected 4th axis
X184	U4	RDY5	Servo ready 5th axis	X18C	UC	AX5	Axis selected 5th axis
X185	U5	RDY6	Servo ready 6th axis	X18D	UD	AX6	Axis selected 6th axis
X186	U6	RDY7	Servo ready 7th axis	X18E	UE	AX7	Axis selected 7th axis
X187	U7	RDY8	Servo ready 8th axis	X18F	UF	AX8	Axis selected 8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X190	U10	MVP1	In plus motion +1st axis	X198	U18	MVM1	In minus motion -1st axis
X191	U11	MVP2	In plus motion +2nd axis	X199	U19	MVM2	In minus motion -2nd axis
X192	U12	MVP3	In plus motion +3rd axis	X19A	U1A	MVM3	In minus motion -3rd axis
X193	U13	MVP4	In plus motion +4th axis	X19B	U1B	MVM4	In minus motion -4th axis
X194	U14	MVP5	In plus motion +5th axis	X19C	U1C	MVM5	In minus motion -5th axis
X195	U15	MVP6	In plus motion +6th axis	X19D	U1D	MVM6	In minus motion -6th axis
X196	U16	MVP7	In plus motion +7th axis	X19E	U1E	MVM7	In minus motion -7th axis
X197	U17	MVP8	In plus motion +8th axis	X19F	U1F	MVM8	In minus motion -8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X1A0	U20	ZP11	1st reference position reached 1st axis	X1A8	U28	ZP21	2nd reference position reached 1st axis
X1A1	U21	ZP12	2nd axis	X1A9	U29	ZP22	2nd axis
X1A2	U22	ZP13	3rd axis	X1AA	U2A	ZP23	3rd axis
X1A3	U23	ZP14	4th axis	X1AB	U2B	ZP24	4th axis
X1A4	U24	ZP15	5th axis	X1AC	U2C	ZP25	5th axis
X1A5	U25	ZP16	6th axis	X1AD	U2D	ZP26	6th axis
X1A6	U26	ZP17	7th axis	X1AE	U2E	ZP27	7th axis
X1A7	U27	ZP18	8th axis	X1AF	U2F	ZP28	8th axis

CNC → PLC (PLC4B)

Table 4-1-2 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X1B0	U30	ZP31	3rd reference position reached 1st axis	X1B8	U38	ZP41	4th reference position reached 1st axis
X1B1	U31	ZP32	2nd axis	X1B9	U39	ZP42	2nd axis
X1B2	U32	ZP33	3rd axis	X1BA	U3A	ZP43	3rd axis
X1B3	U33	ZP34	4th axis	X1BB	U3B	ZP44	4th axis
X1B4	U34	ZP35	5th axis	X1BC	U3C	ZP45	5th axis
X1B5	U35	ZP36	6th axis	X1BD	U3D	ZP46	6th axis
X1B6	U36	ZP37	7th axis	X1BE	U3E	ZP47	7th axis
X1B7	U37	ZP38	8th axis	X1BF	U3F	ZP48	8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X1C0	U40			X1C8	U48		— —
X1C1	U41			X1C9	U49		— —
X1C2	U42	SSE	Search & start (error)	X1CA	U4A		— —
X1C3	U43		Search & start (search)	X1CB	U4B		— —
X1C4	U44		Power OFF request (SP regeneration circuit err)	X1CC	U4C		— —
X1C5	U45			X1CD	U4D		— —
X1C6	U46			X1CE	U4E		— —
X1C7	U47			X1CF	U4F		— —

Device No.				Device No.			
1st SP	2nd SP	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X1D0	U50		— —	X1D8	U58	NR F1	Near reference position 1st axis
X1D1	U51		— —	X1D9	U59	NR F2	2nd axis
X1D2	U52			X1DA	U5A	NR F3	3rd axis
X1D3	U53			X1DB	U5B	NR F4	4th axis
X1D4	U54			X1DC	U5C	NR F5	5th axis
X1D5	U55	SD2	Speed detect 2	X1DD	U5D	NR F6	6th axis
X1D6	U56	MCSA	In M coil selected	X1DE	U5E	NR F7	7th axis
X1D7	U57		Index positioning complete	X1DF	U5F	NR F8	8th axis

— — : Reserved for the system.

CNC → PLC (PLC4B) Table 4-1-3 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X1E0	U60	JO	In jog mode	X1E8	U68	MEMO	In memory mode
X1E1	U61	HO	In handle mode	X1E9	U69	TO	In tape mode
X1E2	U62	SO	In incremental mode	X1EA	U6A		— —
X1E3	U63	PTPO	In manual random feed mode	X1EB	U6B	DO	In MDI mode
X1E4	U64	ZRNO	In reference position return mode	X1EC	U6C		— —
X1E5	U65	ASTO	In automatic initial set mode	X1ED	U6D		In direct operation ▲
X1E6	U66		In JOG-handle simultaneous mode	X1EE	U6E		
X1E7	U67			X1EF	U6F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X1F0	U70	MA	Controller ready complete	X1F8	U78	DEN	Motion command complete
X1F1	U71	SA	Servo ready complete	X1F9	U79	TIMP	All axes in-position
X1F2	U72	OP	In auto operation "run"	X1FA	U7A	TSMZ	All axes smoothing zero
X1F3	U73	STL	In auto operation "start"	X1FB	U7B		— —
X1F4	U74	SPL	In auto operation "pause"	X1FC	U7C	CXFIN	Manual random feed complete
X1F5	U75	RST	In "reset"	X1FD	U7D		
X1F6	U76	CXN	In manual random feed	X1FE	U7E		
X1F7	U77	RWD	In rewind	X1FF	U7F		In high-speed mode (G05)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X200	U80	RPN	In rapid traverse	X208	U88	INCH	In inch unit select
X201	U81	CUT	In cutting feed	X209	U89	DLKN	In display lock
X202	U82	TAP	In tapping	X20A	U8A	F1DN	F1-digit commanded
X203	U83	THRD	In thread cutting	X20B	U8B	TLFO	In tool life management
X204	U84	SYN	In synchronous feed	X20C	U8C	SUPP	Spindle speed upper limit over
X205	U85	CSS	In constant surface speed	X20D	U8D	SLOW	Spindle speed lower limit over
X206	U86	SKIP	In skip	X20E	U8E	TLOV	Tool life over
X207	U87	ZRNN	In reference position return	X20F	U8F	BATAL	Battery alarm

— — : Reserved for the system.

▲ : For specific manufacturers.

CNC → PLC (PLC4B) Table 4-1-4 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X210	U90	AL1	NC alarm 1	X218	U98	F11	F1-digit No.1
X211	U91	AL2	NC alarm 2 (Servo alarm)	X219	U99	F12	F1-digit No.2
X212	U92	AL3	NC alarm 3 (Program error)	X21A	U9A	F14	F1-digit No.4
X213	U93	AL4	NC alarm 4 (Operation error)	X21B	U9B	—	(Always "0")
X214	U94	SIGE	S-analog gear No. illegal	X21C	U9C		Waiting between part systems
X215	U95	SOVE	S-analog max./min. command value over	X21D	U9D		
X216	U96	SNGE	S-analog no gear selected	X21E	U9E		
X217	U97	ASLE	Illegal axis selected	X21F	U9F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X220	UA0	DM00	M code independent output M00	X228	UA8		(EF)
X221	UA1	DM01	M01	X229	UA9	MMS	Manual numerical command
X222	UA2	DM02	M02	X22A	UAA		— —
X223	UA3	DM30	M30	X22B	UAB	TCP	Tool change position return complete
X224	UA4			X22C	UAC	TCRQ	New tool change
X225	UA5	GR1	Spindle gear shift 1	X22D	UAD		— —
X226	UA6	GR2	Spindle gear shift 2	X22E	UAE		
X227	UA7	—	(Always "0")	X22F	UAF		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X230	UB0	MF1	M function strobe 1	X238	UB8	TF1	T function strobe 1
X231	UB1	MF2	M function strobe 2	X239	UB9	—	— —
X232	UB2	MF3	M function strobe 3	X23A	UBA	—	— —
X233	UB3	MF4	M function strobe 4	X23B	UBB	—	— —
X234	UB4	SF1	S function strobe 1	X23C	UBC	BF1	2nd M function strobe 1
X235	UB5	SF2	S function strobe 2	X23D	UBD	—	— —
X236	UB6	SF3	S function strobe 3	X23E	UBE	—	— —
X237	UB7	SF4	S function strobe 4	X23F	UBF	—	— —

— — : Reserved for the system.

CNC → PLC (PLC4B) Table 4-1-5 (PLC4B)

Device No.				Device No.			
1st SP	2nd SP	Abbrev.	Signal name	1st SP	2nd SP	Abbrev.	Signal name
X240	UC0		Spindle 2nd in-position	X248	UC8	SMA	Spindle ready-ON
X241	UC1	CDO	Current detect	X249	UC9	SSA	Spindle servo-ON
X242	UC2	VRO	Speed detect	X24A	UCA	SEMG	Spindle emergency stop
X243	UC3	FLO	In spindle alarm	X24B	UCB	SSRN	Spindle forward run
X244	UC4	ZSO	Zero speed	X24C	UCC	SSRI	Spindle reverse run
X245	UC5	USO	Up-to-speed	X24D	UCD	SZPH	Z-phase passed
X246	UC6	ORAO	Spindle in-position	X24E	UCE	SIMP	Position loop in-position
X247	UC7	LCSA	In L coil selected	X24F	UCF	STLQ	Torque limit

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X250	UD0		— —	X258	UD8		— —
X251	UD1		— —	X259	UD9		— —
X252	UD2		— —	X25A	UDA		— —
X253	UD3		— —	X25B	UDB		— —
X254	UD4		— —	X25C	UDC		— —
X255	UD5		— —	X25D	UDD		— —
X256	UD6		— —	X25E	UDE		— —
X257	UD7		— —	X25F	UDF		— —

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X260	UE0	CHOP	In chopping start	X268	UE8		Load monitor In teaching/monitor execution output ▲
X261	UE1	CHP1	Basic position – upper dead center point	X269	UE9		Teaching mode valid ▲
X262	UE2	CHP2	Upper dead center point – bottom point	X26A	UEA		Monitor mode valid ▲
X263	UE3	CHP3	Bottom dead center point – upper point	X26B	UEB		Adaptive control valid ▲
X264	UE4	CHP4	Upper dead center point – basic position	X26C	UEC		
X265	UE5	CHPMD	In chopping mode	X26D	UED	TRVE	Tap retract possible
X266	UE6			X26E	UEE	PCNT	No. of work machining over
X267	UE7			X26F	UEF	ABSW	Absolute position warning

— — : Reserved for the system.

▲ : For specific manufacturers.

CNC → PLC (PLC4B) Table 4-1-6 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X270	UF0	PSW1	Position switch 1	X278	UF8		— —
X271	UF1	PSW2	Position switch 2	X279	UF9		— —
X272	UF2	PSW3	Position switch 3	X27A	UFA		— —
X273	UF3	PSW4	Position switch 4	X27B	UFB		— —
X274	UF4	PSW5	Position switch 5	X27C	UFC		— —
X275	UF5	PSW6	Position switch 6	X27D	UFD		— —
X276	UF6	PSW7	Position switch 7	X27E	UFE		— —
X277	UF7	PSW8	Position switch 8	X27F	UFF		— —

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X280	U100	ZSF1	Zero point initialization set completed 1st axis	X288	U108	ZSE1	Zero point initialization set error completed 1st axis
X281	U101	ZSF2	2nd axis	X289	U109	ZSE2	2nd axis
X282	U102	ZSF3	3rd axis	X28A	U10A	ZSE3	3rd axis
X283	U103	ZSF4	4th axis	X28B	U10B	ZSE4	4th axis
X284	U104	ZSF5	5th axis	X28C	U10C	ZSE5	5th axis
X285	U105	ZSF6	6th axis	X28D	U10D	ZSE6	6th axis
X286	U106	ZSF7	7th axis	X28E	U10E	ZSE7	7th axis
X287	U107	ZSF8	8th axis	X28F	U10F	ZSE8	8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X290	U110	ILI1	In current limit 1st axis	X298	U118	ILA1	Current limit reached 1st axis
X291	U111	ILI2	2nd axis	X299	U119	ILA2	2nd axis
X292	U112	ILI3	3rd axis	X29A	U11A	ILA3	3rd axis
X293	U113	ILI4	4th axis	X29B	U11B	ILA4	4th axis
X294	U114	ILI5	5th axis	X29C	U11C	ILA5	5th axis
X295	U115	ILI6	6th axis	X29D	U11D	ILA6	6th axis
X296	U116	ILI7	7th axis	X29E	U11E	ILA7	7th axis
X297	U117	ILI8	8th axis	X29F	U11F	ILA8	8th axis

— — : Reserved for the system.

CNC → PLC (PLC4B) Table 4-1-7 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X2A0	U120		In polygon mode (Spindle-NC axis)	X2A8	U128		
X2A1	U121	AL5	NC alarm 5	X2A9	U129		
X2A2	U122		In polygon mode (Spindle-Spindle)	X2AA	U12A		
X2A3	U123		Spindle-spindle polygon synchronization complete	X2AB	U12B		
X2A4	U124			X2AC	U12C		
X2A5	U125			X2AD	U12D		
X2A6	U126			X2AE	U12E		
X2A7	U127			X2AF	U12F		For HVS control (position err detect) ▲

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X2B0	U130		Up-to-speed 1st axis	X2B8	U138		Unclamp command 1st axis
X2B1	U131		2nd axis	X2B9	U139		2nd axis
X2B2	U132		3rd axis	X2BA	U13A		3rd axis
X2B3	U133		4th axis	X2BB	U13B		4th axis
X2B4	U134		5th axis	X2BC	U13C		5th axis
X2B5	U135		6th axis	X2BD	U13D		6th axis
X2B6	U136		7th axis	X2BE	U13E		7th axis
X2B7	U137		8th axis	X2BF	U13F		8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X2C0	U140	RTAP	In synchronized tapping selection (M command)	X2C8	U148	ENB	Spindle enable
X2C1	U141		In small diameter deep hole cycle	X2C9	U149		
X2C2	U142		INC high-speed retract function valid state ▲	X2CA	U14A		
X2C3	U143		In INC high-speed retract function operation ▲	X2CB	U14B		
X2C4	U144		Optimum pecking function valid state ▲	X2CC	U14C		
X2C5	U145		In optimum pecking function operation ▲	X2CD	U14D		
X2C6	U146		Load monitor function valid state ▲	X2CE	U14E		
X2C7	U147		In load monitor function operation ▲	X2CF	U14F		

▲ : For specific manufacturers.

CNC → PLC (PLC4B)

Table 4-1-8 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X2D0	U150		In barrier valid (left)	X2D8	U158		
X2D1	U151		In barrier valid (right)	X2D9	U159		
X2D2	U152			X2DA	U15A		
X2D3	U153			X2DB	U15B		
X2D4	U154			X2DC	U15C		
X2D5	U155			X2DD	U15D		
X2D6	U156			X2DE	U15E		
X2D7	U157			X2DF	U15F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X2E0	U160		In cross machining control 1st axis	X2E8	U168		In synchronous/ superimposition control 1st axis
X2E1	U161		2nd axis	X2E9	U169		2nd axis
X2E2	U162		3rd axis	X2EA	U16A		3rd axis
X2E3	U163		4th axis	X2EB	U16B		4th axis
X2E4	U164		5th axis	X2EC	U16C		5th axis
X2E5	U165		6th axis	X2ED	U16D		6th axis
X2E6	U166		7th axis	X2EE	U16E		7th axis
X2E7	U167		8th axis	X2EF	U16F		8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X2F0	U170			X2F8	U178		
X2F1	U171			X2F9	U179		
X2F2	U172			X2FA	U17A		
X2F3	U173			X2FB	U17B		
X2F4	U174			X2FC	U17C		
X2F5	U175			X2FD	U17D		
X2F6	U176			X2FE	U17E		
X2F7	U177			X2FF	U17F		

CNC → PLC (PLC4B) Table 4-1-9 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X300	I380	DROPNS	Door open enable	X308	—	SPSYN1	In spindle synchronous control
X301	I381			X309	—	FSPRV	Spindle rotation speed synchronization complete
X302	—		MELDASNET diagnosis output complete	X30A	—	FSPPH	Spindle phase synchronization complete
X303	I383	NETSMP	MELDASNET in sampling	X30B	—	SPSYN2	In spindle synchronous control 2 (D)
X304	—	RPIN	In remote program input	X30C	—		— —
X305	—	RPFIN	Remote program input complete	X30D	—		— —
X306	—	RPERR	Remote program input error	X30E	—	SPCMP	Chuck close confirmation
X307	—		In tool ID communication ▲	X30F	—		Power OFF required after parameter change

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st SP	2nd SP	Abbrev.	Signal name
X310	—		— —	X318	I398		In magnetic bearing ready ON
X311	—		— —	X319	I399		In magnetic bearing servo ON
X312	—		— —	X31A	I39A		— —
X313	—		— —	X31B	I39B		— —
X314	—		— —	X31C	I39C		In magnetic bearing warning
X315	—		— —	X31D	I39D		— —
X316	—		— —	X31E	I39E		— —
X317	—		— —	X31F	I39F		In magnetic bearing alarm

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X320	—		Door open enable 1-2	X328	I3A8		
X321	—		— —	X329	I3A9		
X322	I3A2			X32A	I3AA		
X323	I3A3			X32B	I3AB		
X324	I3A4			X32C	I3AC		
X325	I3A5			X32D	I3AD		
X326	I3A6			X32E	I3AE		
X327	I3A7			X32F	I3AF		

— — : Reserved for the system.

▲ : For specific manufacturers.

CNC → PLC (PLC4B)

Table 4-1-10 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X330	I3B0			X338	I3B8		
X331	I3B1			X339	I3B9		
X332	I3B2			X33A	I3BA		
X333	I3B3			X33B	I3BB		
X334	I3B4			X33C	I3BC		
X335	I3B5			X33D	I3BD		
X336	I3B6			X33E	I3BE		
X337	I3B7			X33F	I3BF		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X340	I3C0			X348	I3C8		
X341	I3C1			X349	I3C9		
X342	I3C2			X34A	I3CA		
X343	I3C3			X34B	I3CB		
X344	I3C4			X34C	I3CC		
X345	I3C5			X34D	I3CD		
X346	I3C6			X34E	I3CE		
X347	I3C7			X34F	I3CF		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X350	I3D0			X358	I3D8		
X351	I3D1			X359	I3D9		
X352	I3D2			X35A	I3DA		
X353	I3D3			X35B	I3DB		
X354	I3D4			X35C	I3DC		
X355	I3D5			X35D	I3DD		
X356	I3D6			X35E	I3DE		
X357	I3D7			X35F	I3DF		

CNC → PLC (PLC4B)

Table 4-1-11 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X360	I3E0			X368	I3E8		
X361	I3E1			X369	I3E9		
X362	I3E2			X36A	I3EA		
X363	I3E3			X36B	I3EB		
X364	I3E4			X36C	I3EC		
X365	I3E5			X36D	I3ED		
X366	I3E6			X36E	I3EE		
X367	I3E7			X36F	I3EF		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
X370	I3F0			X378	I3F8		
X371	I3F1			X379	I3F9		
X372	I3F2			X37A	I3FA		
X373	I3F3			X37B	I3FB		
X374	I3F4			X37C	I3FC		
X375	I3F5			X37D	I3FD		
X376	I3F6			X37E	I3FE		
X377	I3F7			X37F	I3FF		

CNC → PLC (PLC4B) Table 4-1-12 (PLC4B)

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
I300	I310	ENB	Spindle enable	I308	I318		
I301	I311			I309	I319		
I302	I312			I30A	I31A		
I303	I313			I30B	I31B		
I304	I314			I30C	I31C		
I305	I315			I30D	I31D		
I306	I316			I30E	I31E		
I307	I317			I30F	I31F		

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
S000	S040	SUPP	Spindle speed upper limit over	S008	S048		— —
S001	S041	SLOW	Spindle speed lower limit over	S009	S049		— —
S002	S042	SIGE	S-analog gear No. illegal	S00A	S04A		
S003	S043	SOVE	S-analog max./min. command value over	S00B	S04B		
S004	S044	SNGE	S-analog no gear selected	S00C	S04C		
S005	S045	GR1	Spindle gear shift command 1	S00D	S04D	SD2	Speed detect 2
S006	S046	GR2	Spindle gear shift command 2	S00E	S04E	MCSA	In M coil selected
S007	S047	—	(Always "0")	S00F	S04F		Index positioning complete

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
S010	S050		2nd in-position (D)	S018	S058	SMA	Spindle ready-ON
S011	S051	CDO	Current detect	S019	S059	SSA	Spindle servo-ON
S012	S052	VRO	Speed detect	S01A	S05A	SEMG	Spindle emergency stop
S013	S053	FLO	In spindle alarm	S01B	S05B	SSRN	Spindle forward run
S014	S054	ZSO	Zero speed	S01C	S05C	SSRI	Spindle reverse run
S015	S055	USO	Up-to-speed	S01D	S05D		Z-phase passed
S016	S056	ORAO	Spindle in-position	S01E	S05E	SIMP	Position loop in-position
S017	S057	LCSA	In L coil selected	S01F	S05F	STLQ	Torque limit

— — : Reserved for the system.

CNC → PLC Table 4-2-1

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st SP	2nd SP	Abbrev.	Signal name
R0	—	AI1	Analog input	R8	R208		Spindle command rotation speed input
R1	—	AI2	Analog input	R9	R209		
R2	—	AI3	Analog input	R10	R210		Spindle command final data (rotation speed)
R3	—	AI4	Analog input	R11	R211		
R4	—		— —	R12	R212		Spindle command final data (12-bit binary)
R5	—		— —	R13	R213		
R6	—		— —	R14	R214		
R7	—		— —	R15	R215		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R16	—		KEY IN 1	R24	R224		M code data 3
R17	—		FULL KEY IN	R25	R225		
R18	R218		Spindle actual speed	R26	R226		M code data 4
R19	R219			R27	R227		
R20	R220		M code data 1	R28	R228		S code data 1
R21	R221			R29	R229		
R22	R222		M code data 2	R30	R230		S code data 2
R23	R223			R31	R231		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R32	R232		S code data 3	R40	R240		— —
R33	R233			R41	R241		
R34	R234		S code data 4	R42	R242		— —
R35	R235			R43	R243		
R36	R236		T code data 1	R44	R244		2nd M function data 1
R37	R237			R45	R245		
R38	R238		— —	R46	R246		— —
R39	R239			R47	R247		

— — : Reserved for the system.

CNC → PLC Table 4-2-2

Device No.				Device No.			
1st sys	**2nd sys**	**Abbrev.**	**Signal name**	**1st sys**	**2nd sys**	**Abbrev.**	**Signal name**
R48	R248		— —	R56	—		Battery drop cause
R49	R249			R57	—		Temperature warning cause
R50	R250		— —	R58	—		5V/24V error cause
R51	R251			R59	R259		Adaptive control override output ▲
R52	R252		Load monitor warning axis ▲	R60	R260		CNC complete standby status output
R53	R253		Load monitor alarm axis ▲	R61	R261		
R54	R254		Load monitor data alarm information ▲	R62	R262		In initialization
R55	R255		Group in tool life management	R63	R263		Initialization incomplete

Device No.				Device No.			
1st sys	**2nd sys**	**Abbrev.**	**Signal name**	**1st sys**	**2nd sys**	**Abbrev.**	**Signal name**
R64	—		Display information	R72	—		User macro output #1032 **(Note 1)**
R65	—			R73	—		
R66	—			R74	—		User macro output #1033
R67	—			R75	—		
R68	—		PLC main scan time	R76	—		User macro output #1034
R69	—		Emergency stop cause	R77	—		
R70	—		DIO card information	R78	—		User macro output #1035
R71	R271		Program execution state (editing related) ▲	R79	—		

Device No.				Device No.			
1st sys	**2nd sys**	**Abbrev.**	**Signal name**	**1st sys**	**2nd sys**	**Abbrev.**	**Signal name**
R80	—		Add-on (expansion) operation board input signal 1	R88	R288		Near reference position (per reference position)
R81	—		signal 2	R89	R289		
R82	—		signal 3	R90	R290		Presetter contact
R83	—		signal 4	R91	R291		Presetter interlock
R84	—		M-NET OT check	R92	R292		
R85	R285			R93	R293		
R86	—		PC high-speed process time	R94	R294		
R87	R287			R95	R295		

— — : Reserved for the system.

▲ : For specific manufacturers.

(Note 1) #1032 to #1035 are output from the PLC, and the direction is the opposite of the other R registers.

CNC → PLC Table 4-2-3

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R96	—		CNC software version code				
R97	—						
R98	—						
R99	—						

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R372							
R373							
R374							
R375							
R376							
R377							
R378				R458	—		Control unit temperature
R379				R459	—		— —

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R460	—		Clock data Month/Year	R472	—		— —
R461	—		Hour/Date	R473	—		— —
R462	—		Second /Minute	R474	—		Spindle synchronous control Phase error output
R463	—		— —	R475	—		Phase error 1 (degree) (including shift calc.)
R464	R468		Area signal X axis ON/OFF ▲	R476	—		Phase error 2 (degree) (excluding shift calc.)
R465	R469		Area signal Z axis ON/OFF ▲	R477	—		Phase error monitor
R466	R470		Area signal X axis (-) ON/OFF ▲	R478	—		Phase error monitor (lower limit)
R467	R471		Area signal Z axis (-) ON/OFF ▲	R479	—		Phase error monitor (upper limit)

— — : Reserved for the system.

▲ : For specific manufacturers.

CNC → PLC Table 4-2-4

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R480	R484		Takt time (ms) (Low)	R488	—		Tool ID communication error information ▲
R481	R485		Takt time (ms) (High)	R489	—		MELDASNET diagnosis output cause
R482	R486		Takt time (min) (Low)	R490	—		Spindle synchronous control Phase offset data
R483	R487		Takt time (min) (High)	R498	R499		For HVS control (position err detect) ▲

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R614	R616		Tool life usage data				
R615	R617						

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
				R645	—		— —

— — : Reserved for the system.

▲ : For specific manufacturers.

CNC → PLC

Table 4-2-5

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R670	R680		Load monitor status ▲	R678	R688		Load monitor status ▲
R671	R681		Load monitor status ▲	R679	R689		Load monitor status ▲
R672	R682		Load monitor status ▲				
R673	R683		Load monitor status ▲				
R674	R684		Load monitor status ▲				
R675	R685		Load monitor status ▲				
R676	R686		Load monitor status ▲				
R677	R687		Load monitor status ▲				

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R690	—		— —				

— — : Reserved for the system.

▲ : For specific manufacturers.

CNC → PLC

Table 4-2-6

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R1100	R1116		Servo deflection amount	R1108	R1124		Servo deflection amount
R1101	R1117		1st axis	R1109	R1125		5th axis
R1102	R1118			R1110	R1126		
R1103	R1119		2nd axis	R1111	R1127		6th axis
R1104	R1120			R1112	R1128		
R1105	R1121		3rd axis	R1113	R1129		7th axis
R1106	R1122			R1114	R1130		
R1107	R1123		4th axis	R1115	R1131		8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R1350	—		Synchronous control error amount 1st axis (L)	R1358	—		Synchronous control error amount 5th axis (L)
R1351	—		1st axis (H)	R1359	—		5th axis (H)
R1352	—		2nd axis (L)	R1360	—		6th axis (L)
R1353	—		2nd axis (H)	R1361	—		6th axis (H)
R1354	—		3rd axis (L)	R1362	—		7th axis (L)
R1355	—		3rd axis (H)	R1363	—		7th axis (H)
R1356	—		4th axis (L)	R1364	—		8th axis (L)
R1357	—		4th axis (H)	R1365	—		8th axis (H)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R1366	—		Synchronous control error amount (spare) (L)	R1374	—		Synchronous control error amount (spare) (L)
R1367	—		(spare) (H)	R1375	—		(spare) (H)
R1368	—		(spare) (L)	R1376	—		(spare) (L)
R1369	—		(spare) (H)	R1377	—		(spare) (H)
R1370	—		(spare) (L)				
R1371	—		(spare) (H)				
R1372	—		(spare) (L)				
R1373	—		(spare) (H)				

CNC → PLC Table 4-2-7

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R1502	—		Remote program input error information				
R1503	—		MELDAS-NET output				

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R2896	R1892		No. of work machining (current) (Low-order)				
R2897	R1893		(High-order)				
R2898	R1894		No. of work machining (max.) (Low-order)				
R2899	R1895		(High-order)				

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
R4500	R4520		Spindle command rotation speed input	R4508	R4528		
R4501	R4521			R4509	R4529		
R4502	R4522		Spindle command final data (rotation speed)	R4510	R4530		
R4503	R4523			R4511	R4531		
R4504	R4524		Spindle command final data (12-bit binary)	R4512	R4532		
R4505	R4525			R4513	R4533		
R4506	R4526		Spindle actual speed	R4514	R4534		
R4507	R4527			R4515	R4535		

CNC → PLC

Table 4-2-8

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
R4516	R4536						
R4517	R4537						
R4518	R4538						
R4519	R4539						

PLC → CNC (GX Developer) Table 4-3-1 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y180	Y540	DTCH1	Control axis detach 1st axis	Y188	Y548	* SVF1	Servo OFF 1st axis
Y181	Y541	DTCH2	2nd axis	Y189	Y549	* SVF2	Servo OFF 2nd axis
Y182	Y542	DTCH3	3rd axis	Y18A	Y54A	* SVF3	Servo OFF 3rd axis
Y183	Y543	DTCH4	4th axis	Y18B	Y54B	* SVF4	Servo OFF 4th axis
Y184	Y544	DTCH5	5th axis	Y18C	Y54C	* SVF5	Servo OFF 5th axis
Y185	Y545	DTCH6	6th axis	Y18D	Y54D	* SVF6	Servo OFF 6th axis
Y186	Y546	DTCH7	7th axis	Y18E	Y54E	* SVF7	Servo OFF 7th axis
Y187	Y547	DTCH8	8th axis	Y18F	Y54F	* SVF8	Servo OFF 8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y190	Y550	MI1	Mirror image 1st axis	Y198	Y558	* +EDT1	External deceleration +1st axis
Y191	Y551	MI2	Mirror image 2nd axis	Y199	Y559	* +EDT2	+2nd axis
Y192	Y552	MI3	Mirror image 3rd axis	Y19A	Y55A	* +EDT3	+3rd axis
Y193	Y553	MI4	Mirror image 4th axis	Y19B	Y55B	* +EDT4	+4th axis
Y194	Y554	MI5	Mirror image 5th axis	Y19C	Y55C	* +EDT5	+5th axis
Y195	Y555	MI6	Mirror image 6th axis	Y19D	Y55D	* +EDT6	+6th axis
Y196	Y556	MI7	Mirror image 7th axis	Y19E	Y55E	* +EDT7	+7th axis
Y197	Y557	MI8	Mirror image 8th axis	Y19F	Y55F	* +EDT8	+8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y1A0	Y560	* -EDT1	External deceleration -1st axis	Y1A8	Y568	* +AIT1	Auto interlock +1st axis
Y1A1	Y561	* -EDT2	-2nd axis	Y1A9	Y569	* +AIT2	+2nd axis
Y1A2	Y562	* -EDT3	-3rd axis	Y1AA	Y56A	* +AIT3	+3rd axis
Y1A3	Y563	* -EDT4	-4th axis	Y1AB	Y56B	* +AIT4	+4th axis
Y1A4	Y564	* -EDT5	-5th axis	Y1AC	Y56C	* +AIT5	+5th axis
Y1A5	Y565	* -EDT6	-6th axis	Y1AD	Y56D	* +AIT6	+6th axis
Y1A6	Y566	* -EDT7	-7th axis	Y1AE	Y56E	* +AIT7	+7th axis
Y1A7	Y567	* -EDT8	-8th axis	Y1AF	Y56F	* +AIT8	+8th axis

PLC → CNC (GX Developer) Table 4-3-2 (GX Developer)

Device No.				Device No.			
1st sys	**2nd sys**	**Abbrev.**	**Signal name**	**1st sys**	**2nd sys**	**Abbrev.**	**Signal name**
Y1B0	Y570	* -AIT1	Auto interlock -1st axis	Y1B8	Y578	* +MIT1	Manual interlock +1st axis
Y1B1	Y571	* -AIT2	-2nd axis	Y1B9	Y579	* +MIT2	+2nd axis
Y1B2	Y572	* -AIT3	-3rd axis	Y1BA	Y57A	* +MIT3	+3rd axis
Y1B3	Y573	* -AIT4	-4th axis	Y1BB	Y57B	* +MIT4	+4th axis
Y1B4	Y574	* -AIT5	-5th axis	Y1BC	Y57C	* +MIT5	+5th axis
Y1B5	Y575	* -AIT6	-6th axis	Y1BD	Y57D	* +MIT6	+6th axis
Y1B6	Y576	* -AIT7	-7th axis	Y1BE	Y57E	* +MIT7	+7th axis
Y1B7	Y577	* -AIT8	-8th axis	Y1BF	Y57F	* +MIT8	+8th axis

Device No.				Device No.			
1st sys	**2nd sys**	**Abbrev.**	**Signal name**	**1st sys**	**2nd sys**	**Abbrev.**	**Signal name**
Y1C0	Y580	*-MIT1	Manual interlock -1st axis	Y1C8	Y588	AMLK1	Auto machine lock 1st axis
Y1C1	Y581	*-MIT2	-2nd axis	Y1C9	Y589	AMLK2	2nd axis
Y1C2	Y582	*-MIT3	-3rd axis	Y1CA	Y58A	AMLK3	3rd axis
Y1C3	Y583	*-MIT4	-4th axis	Y1CB	Y58B	AMLK4	4th axis
Y1C4	Y584	*-MIT5	-5th axis	Y1CC	Y58C	AMLK5	5th axis
Y1C5	Y585	*-MIT6	-6th axis	Y1CD	Y58D	AMLK6	6th axis
Y1C6	Y586	*-MIT7	-7th axis	Y1CE	Y58E	AMLK7	7th axis
Y1C7	Y587	*-MIT8	-8th axis	Y1CF	Y58F	AMLK8	8th axis

Device No.				Device No.			
1st sys	**2nd sys**	**Abbrev.**	**Signal name**	**1st sys**	**2nd sys**	**Abbrev.**	**Signal name**
Y1D0	Y590	MMLK1	Manual machine lock 1st axis	Y1D8	Y598	+J1	Feed axis select +1st axis
Y1D1	Y591	MMLK2	2nd axis	Y1D9	Y599	+J2	+2nd axis
Y1D2	Y592	MMLK3	3rd axis	Y1DA	Y59A	+J3	+3rd axis
Y1D3	Y593	MMLK4	4th axis	Y1DB	Y59B	+J4	+4th axis
Y1D4	Y594	MMLK5	5th axis	Y1DC	Y59C	+J5	+5th axis
Y1D5	Y595	MMLK6	6th axis	Y1DD	Y59D	+J6	+6th axis
Y1D6	Y596	MMLK7	7th axis	Y1DE	Y59E	+J7	+7th axis
Y1D7	Y597	MMLK8	8th axis	Y1DF	Y59F	+J8	+8th axis

PLC → CNC (GX Developer) Table 4-3-3 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y1E0	Y5A0	-J1	Feed axis select -1st axis	Y1E8	Y5A8	CHPS	Chopping
Y1E1	Y5A1	-J2	-2nd axis	Y1E9	Y5A9		
Y1E2	Y5A2	-J3	-3rd axis	Y1EA	Y5AA		
Y1E3	Y5A3	-J4	-4th axis	Y1EB	Y5AB		
Y1E4	Y5A4	-J5	-5th axis	Y1EC	Y5AC		
Y1E5	Y5A5	-J6	-6th axis	Y1ED	Y5AD		
Y1E6	Y5A6	-J7	-7th axis	Y1EE	Y5AE		
Y1E7	Y5A7	-J8	-8th axis	Y1EF	Y5AF		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y1F0	Y5B0	MAE1	Manual/Auto simultaneous valid 1st axis	Y1F8	Y5B8		— —
Y1F1	Y5B1	MAE2	2nd axis	Y1F9	Y5B9		
Y1F2	Y5B2	MAE3	3rd axis	Y1FA	Y5BA	RSST	Search & start
Y1F3	Y5B3	MAE4	4th axis	Y1FB	Y5BB		Magazine index check valid (ATC high-speed)
Y1F4	Y5B4	MAE5	5th axis	Y1FC	Y5BC		Spindle orientation complete standby valid (ATC high-speed)
Y1F5	Y5B5	MAE6	6th axis	Y1FD	Y5BD		
Y1F6	Y5B6	MAE7	7th axis	Y1FE	Y5BE		
Y1F7	Y5B7	MAE8	8th axis	Y1FF	Y5BF		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y200	Y5C0	ZSL1	Reference position select 1	Y208	Y5C8	J	Jog mode
Y201	Y5C1	ZSL2	Reference position select 2	Y209	Y5C9	H	Handle mode
Y202	Y5C2			Y20A	Y5CA	S	Incremental mode
Y203	Y5C3			Y20B	Y5CB	PTP	Manual random feed mode
Y204	Y5C4			Y20C	Y5CC	ZRN	Reference position return mode
Y205	Y5C5			Y20D	Y5CD	AST	Auto initialization mode
Y206	Y5C6			Y20E	Y5CE		
Y207	Y5C7		Reference position select method	Y20F	Y5CF		

— — : Reserved for the system.

PLC → CNC (GX Developer) Table 4-3-4 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y210	Y5D0	MEM	Memory mode	Y218	Y5D8	ST	Auto operation "start" command
Y211	Y5D1	T	Tape mode	Y219	Y5D9	* SP	Auto operation "pause" command
Y212	Y5D2		— —	Y21A	Y5DA	SBK	Single block
Y213	Y5D3	D	MDI mode	Y21B	Y5DB	* BSL	Block start interlock
Y214	Y5D4		— —	Y21C	Y5DC	* CSL	Cutting block start interlock
Y215	Y5D5		Direct operation mode ▲	Y21D	Y5DD	DRN	Dry run
Y216	Y5D6			Y21E	Y5DE		
Y217	Y5D7			Y21F	Y5DF	ERD	Error detect

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y220	Y5E0	NRST1	NC reset 1	Y228	Y5E8	TLM	Tool length measurement 1
Y221	Y5E1	NRST2	NC reset 2	Y229	Y5E9	TLMS	Tool length measurement 2 (L system)
Y222	Y5E2	RRW	Reset & rewind	Y22A	Y5EA		Synchronization correction mode
Y223	Y5E3	* CDZ	Chamfering	Y22B	Y5EB	PRST	Program restart
Y224	Y5E4	ARST	Auto restart	Y22C	Y5EC	PB	Playback
Y225	Y5E5	GFIN	Gear shift complete	Y22D	Y5ED	UIT	Macro interrupt
Y226	Y5E6	FIN1	M function finish 1	Y22E	Y5EE	RT	Rapid traverse
Y227	Y5E7	FIN2	M function finish 2	Y22F	Y5EF		— —

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y230	Y5F0	ABS	Manual absolute	Y238	—	* KEY1	Data protect key 1
Y231	Y5F1	DLK	Display lock	Y239	—	* KEY2	Data protect key 2
Y232	Y5F2		F1-digit speed change valid	Y23A	—	* KEY3	Data protect key 3
Y233	Y5F3	CRQ	Recalculation request	Y23B	—	—	— —
Y234	—	RHD1	Integration time input 1	Y23C	—	PDISP	Program display during operation
Y235	—	RHD2	Integration time input 2	Y23D	Y5FD		Inclined axis control valid
Y236	Y5F6	PIT	PLC interrupt signal	Y23E	Y5FE		Inclined axis control: No Z axis compensation
Y237	Y5F7			Y23F	Y5FF	BDT1	Optional block skip

— — : Reserved for the system.

▲ : For specific manufacturers.

PLC → CNC (GX Developer) Table 4-3-5 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y240	Y600	—	— —	Y248	Y608	HS11	1st handle axis No.
Y241	Y601	—	— —	Y249	Y609	HS12	
Y242	Y602	—	— —	Y24A	Y60A	HS14	
Y243	Y603	—	— —	Y24B	Y60B	HS18	
Y244	Y604	—	— —	Y24C	Y60C	HS116	
Y245	Y605	—	— —	Y24D	Y60D		
Y246	Y606	—	— —	Y24E	Y60E		
Y247	Y607	—	— —	Y24F	Y60F	HS1S	1st handle valid

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y250	Y610	HS21	2nd handle axis No.	Y258	Y618	HS31	3rd handle axis No.
Y251	Y611	HS22		Y259	Y619	HS32	
Y252	Y612	HS24		Y25A	Y61A	HS34	
Y253	Y613	HS28		Y25B	Y61B	HS38	
Y254	Y614	HS216		Y25C	Y61C	HS316	
Y255	Y615			Y25D	Y61D		
Y256	Y616			Y25E	Y61E		
Y257	Y617	HS2S	2nd handle valid	Y25F	Y61F	HS3S	3rd handle valid

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y260	Y620	FBE1	Manual feedrate B valid 1st axis	Y268	Y628	CX11	Manual random feed 1st axis No.
Y261	Y621	FBE2	2nd axis	Y269	Y629	CX12	
Y262	Y622	FBE3	3rd axis	Y26A	Y62A	CX14	
Y263	Y623	FBE4	4th axis	Y26B	Y62B	CX18	
Y264	Y624	FBE5	5th axis	Y26C	Y62C	CX116	
Y265	Y625	FBE6	6th axis	Y26D	Y62D		(Always "0")
Y266	Y626	FBE7	7th axis	Y26E	Y62E		(Always "0")
Y267	Y627	FBE8	8th axis	Y26F	Y62F	CX1S	Manual random feed 1st axis valid

— — : Reserved for the system.

PLC → CNC (GX Developer) Table 4-3-6 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y270	Y630	CX21	Manual random feed 2nd axis No.	Y278	Y638	CX31	Manual random feed 3rd axis No.
Y271	Y631	CX22		Y279	Y639	CX32	
Y272	Y632	CX24		Y27A	Y63A	CX34	
Y273	Y633	CX28		Y27B	Y63B	CX38	
Y274	Y634	CX216		Y27C	Y63C	CX316	
Y275	Y635		(Always "0")	Y27D	Y63D		(Always "0")
Y276	Y636		(Always "0")	Y27E	Y63E		(Always "0")
Y277	Y637	CX2S	Manual random feed 2nd axis valid	Y27F	Y63F	CX3S	Manual random feed 3rd axis valid

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st SP	2nd SP	Abbrev.	Signal name
Y280	Y640	CXS1	Smoothing off	Y288	Y648	SP1	Spindle override 1
Y281	Y641	CXS2	Axis independent	Y289	Y649	SP2	Spindle override 2
Y282	Y642	CXS3	EX.F/MODAL.F	Y28A	Y64A	SP4	Spindle override 4
Y283	Y643	CXS4	G0/G1	Y28B	Y64B		
Y284	Y644	CXS5	MC/WK	Y28C	Y64C		
Y285	Y645	CXS6	ABS/INC	Y28D	Y64D		
Y286	Y646	*CXS7	Stop	Y28E	Y64E		
Y287	Y647	CXS8	Strobe	Y28F	Y64F	SPS	Spindle override method select

Device No.				Device No.			
1st SP	2nd SP	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y290	Y650	GI1	Spindle gear select 1	Y298	Y658	OVC	Override cancel
Y291	Y651	GI2	Spindle gear select 2	Y299	Y659	OVSL	Manual override valid
Y292	Y652	—	(Always "0")	Y29A	Y65A	AFL	Miscellaneous function lock
Y293	Y653			Y29B	Y65B		
Y294	Y654	SSTP	Spindle stop	Y29C	Y65C	TRV	Tap retract
Y295	Y655	SSFT	Spindle gear shift	Y29D	Y65D	RTN	Reference position retract
Y296	Y656	SORC	Oriented spindle speed command	Y29E	Y65E		
Y297	Y657			Y29F	Y65F	QEMG	PLC emergency stop

PLC → CNC (GX Developer) Table 4-3-7 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y2A0	Y660	* FV1	Cutting feedrate override	Y2A8	Y668	ROV1	Rapid traverse speed override
Y2A1	Y661	* FV2		Y2A9	Y669	ROV2	
Y2A2	Y662	* FV4		Y2AA	Y66A		
Y2A3	Y663	* FV8		Y2AB	Y66B		
Y2A4	Y664	* FV16		Y2AC	Y66C		
Y2A5	Y665			Y2AD	Y66D		
Y2A6	Y666	FV2E	2nd cutting feedrate override valid	Y2AE	Y66E		
Y2A7	Y667	FVS	Cutting feedrade override method select	Y2AF	Y66F	ROVS	Rapid traverse speed override method select

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y2B0	Y670	* JV1	Manual feedrate	Y2B8	Y678	PCF1	Feedrate least increment
Y2B1	Y671	* JV2		Y2B9	Y679	PCF2	
Y2B2	Y672	* JV4		Y2BA	Y67A	JSYN	Jog synchronous feed valid
Y2B3	Y673	* JV8		Y2BB	Y67B	JHAN	Jog•handle synchronous
Y2B4	Y674	* JV16		Y2BC	Y67C		Each axis manual feedrate B valid
Y2B5	Y675			Y2BD	Y67D		— —
Y2B6	Y676			Y2BE	Y67E		— —
Y2B7	Y677	JVS	Manual feedrate method select	Y2BF	Y67F		— —

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y2C0	Y680	MP1	Handle/Incremental feed multiplication	Y2C8	Y688	TAL1	Tool alarm 1/Tool-skip tool
Y2C1	Y681	MP2		Y2C9	Y689	TAL2	Tool alarm 2 (M system)
Y2C2	Y682	MP4		Y2CA	Y68A	TCEF	Data count valid
Y2C3	Y683			Y2CB	Y68B	TLFI	Tool life management input (M system)
Y2C4	Y684			Y2CC	Y68C	TRST	Tool change reset (L system)
Y2C5	Y685			Y2CD	Y68D		
Y2C6	Y686		— —	Y2CE	Y68E		
Y2C7	Y687	MPS	Handle/Incremental feed multiplication method select	Y2CF	Y68F		

— — : Reserved for the system.

PLC → CNC (GX Developer) Table 4-3-8 (GX Developer)

Device No.				Device No.			
1st SP	2nd SP	Abbrev.	Signal name	1st SP	2nd SP	Abbrev.	Signal name
Y2D0	Y690	SRN	Spindle forward run start	Y2D8	Y698		
Y2D1	Y691	SRI	Spindle reverse run start	Y2D9	Y699		
Y2D2	Y692	TL1	Torque limit 1	Y2DA	Y69A		C axis gain L
Y2D3	Y693	TL2	Torque limit 2	Y2DB	Y69B		C axis gain H
Y2D4	Y694	WRN	Spindle forward run index	Y2DC	Y69C		C axis zero point return
Y2D5	Y695	WRI	Spindle reverse run index	Y2DD	Y69D		
Y2D6	Y696	ORC	Spindle orient command	Y2DE	Y69E	LRSM	M coil selection
Y2D7	Y697	LRSL	L coil selection	Y2DF	Y69F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y2E0	—	* PCD1	PLC axis near point detect 1st axis	Y2E8	—	SPSYC	Spindle synchronization cancel
Y2E1	—	* PCD2	PLC axis near point detect 2nd axis	Y2E9	—	SPCMPC	Chuck close
Y2E2	—		— —	Y2EA	—		
Y2E3	—		— —	Y2EB	—		
Y2E4	—	PCH1	PLC axis 1st handle valid	Y2EC	—		
Y2E5	—	PCH2	PLC axis 2nd handle valid	Y2ED	—		
Y2E6	—	PCH3	PLC axis 3rd handle valid	Y2EE	—		
Y2E7	Y6A7			Y2EF	—		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y2F0	Y6B0		— —	Y2F8	—	CRTFN	CRT changeover complete
Y2F1	Y6B1		— —	Y2F9	Y6B9	CSRON	Screen display request
Y2F2	Y6B2		— —	Y2FA	Y6BA		
Y2F3	Y6B3		— —	Y2FB	Y6BB	NETSTP	MELDASNET sampling stop
Y2F4	Y6B4		— —	Y2FC	—	SMPTRG	Data sampling trigger
Y2F5	Y6B5		— —	Y2FD	—	MTBT	PLC snapshot
Y2F6	Y6B6		— —	Y2FE	—	DISP1	Display changeover $1
Y2F7	Y6B7		— —	Y2FF	—	DISP2	Display changeover $2

— — : Reserved for the system.

PLC → CNC (GX Developer) Table 4-3-9 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y300	Y6C0	AZS1	Zero point initialization set mode 1st axis	Y308	Y6C8	ZST1	Zero point initialization set start 1st axis
Y301	Y6C1	AZS2	2nd axis	Y309	Y6C9	ZST2	2nd axis
Y302	Y6C2	AZS3	3rd axis	Y30A	Y6CA	ZST3	3rd axis
Y303	Y6C3	AZS4	4th axis	Y30B	Y6CB	ZST4	4th axis
Y304	Y6C4	AZS5	5th axis	Y30C	Y6CC	ZST5	5th axis
Y305	Y6C5	AZS6	6th axis	Y30D	Y6CD	ZST6	6th axis
Y306	Y6C6	AZS7	7th axis	Y30E	Y6CE	ZST7	7th axis
Y307	Y6C7	AZS8	8th axis	Y30F	Y6CF	ZST8	8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y310	Y6D0		Current limit mode 1	Y318	Y6D8		Current limit changeover 1st axis
Y311	Y6D1		Current limit mode 2	Y319	Y6D9		2nd axis
Y312	Y6D2		(Same as above, spare)	Y31A	Y6DA		3rd axis
Y313	Y6D3	LDWT	Load monitor Teaching/ monitor execution ▲	Y31B	Y6DB		4th axis
Y314	Y6D4		Load monitor Teaching mode select ▲	Y31C	Y6DC		5th axis
Y315	Y6D5		Load monitor Monitor mode select ▲	Y31D	Y6DD		6th axis
Y316	Y6D6		Load monitor Alarm reset ▲	Y31E	Y6DE		7th axis
Y317	Y6D7		Load monitor Warning reset ▲	Y31F	Y6DF		8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y320	Y6E0		Droop release request 1st axis	Y328	Y6E8		— —
Y321	Y6E1		2nd axis	Y329	Y6E9		Ext. workpiece coordinate measurement 2nd axis
Y322	Y6E2		3rd axis	Y32A	Y6EA		— —
Y323	Y6E3		4th axis	Y32B	Y6EB		— —
Y324	Y6E4		5th axis	Y32C	Y6EC		— —
Y325	Y6E5		6th axis	Y32D	Y6ED		— —
Y326	Y6E6		7th axis	Y32E	Y6EE		— —
Y327	Y6E7		8th axis	Y32F	Y6EF		— —

— — : Reserved for the system.

▲ : For specific manufacturers.

PLC → CNC (GX Developer) Table 4-3-10 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y330	Y6F0	DTCH21	Control axis detach 2 1st axis	Y338	Y6F8		Unclamp complete 1st axis
Y331	Y6F1	DTCH22	2nd axis	Y339	Y6F9		2nd axis
Y332	Y6F2	DTCH23	3rd axis	Y33A	Y6FA		3rd axis
Y333	Y6F3	DTCH24	4th axis	Y33B	Y6FB		4th axis
Y334	Y6F4	DTCH25	5th axis	Y33C	Y6FC		5th axis
Y335	Y6F5	DTCH26	6th axis	Y33D	Y6FD		6th axis
Y336	Y6F6	DTCH27	7th axis	Y33E	Y6FE		7th axis
Y337	Y6F7	DTCH28	8th axis	Y33F	Y6FF		8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y340	Y700		Each axis reference position return 1st axis	Y348	Y708	* ZRIT	2nd reference position return interlock
Y341	Y701		2nd axis	Y349	Y709		Adaptive control execution ▲
Y342	Y702		3rd axis	Y34A	Y70A		Small diameter deep hole drilling cycle
Y343	Y703		4th axis	Y34B	Y70B		— —
Y344	Y704		5th axis	Y34C	Y70C		INC high-speed retract function valid ▲
Y345	Y705		6th axis	Y34D	Y70D		Optimum pecking function valid ▲
Y346	Y706		7th axis	Y34E	Y70E		Load monitor function valid ▲
Y347	Y707		8th axis	Y34F	Y70F		

Device No.				Device No.			
1st SP	2nd SP	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y350	Y710	SWS	Spindle command selection	Y358	Y718		Waiting ignore
Y351	Y711			Y359	Y719		Spindle-spindle polygon cancel
Y352	Y712			Y35A	Y71A		Synchronous tapping command polarity reversal
Y353	Y713			Y35B	Y71B		Spindle OFF mode
Y354	Y714			Y35C	Y71C		
Y355	Y715			Y35D	Y71D		
Y356	Y716			Y35E	Y71E		
Y357	Y717	MPCSL	PLC coil changeover	Y35F	Y71F		

— — : Reserved for the system.

▲ : For specific manufacturers.

PLC → CNC (GX Developer) Table 4-3-11 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y360	Y720		Cross machining control request 1st axis	Y368	Y728		
Y361	Y721		2nd axis	Y369	Y729		
Y362	Y722		3rd axis	Y36A	Y72A		
Y363	Y723		4th axis	Y36B	Y72B		
Y364	Y724		5th axis	Y36C	Y72C		
Y365	Y725		6th axis	Y36D	Y72D		
Y366	Y726		7th axis	Y36E	Y72E		
Y367	Y727		8th axis	Y36F	Y72F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y370	Y730		Position switch 1 interlock	Y378	Y738		Barrier valid (left)
Y371	Y731		Position switch 2 interlock	Y379	Y739		Barrier valid (right)
Y372	Y732		Position switch 3 interlock	Y37A	Y73A		Tool presetter sub-side valid
Y373	Y733		Position switch 4 interlock	Y37B	Y73B		
Y374	Y734		Position switch 5 interlock	Y37C	Y73C		
Y375	Y735		Position switch 6 interlock	Y37D	Y73D		
Y376	Y736		Position switch 7 interlock	Y37E	Y73E		
Y377	Y737		Position switch 8 interlock	Y37F	Y73F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st SP	2nd SP	Abbrev.	Signal name
Y380	—		Door open	Y388	YCC8		Magnetic bearing servo ON command
Y381	YCC1		Door open II	Y389	YCC9		Magnetic bearing tool unclamp
Y382	YCC2		Door open signal input (spindle speed monitor)	Y38A	YCCA		— —
Y383	YCC3		Door interlock spindle speed clamp	Y38B	YCCB		— —
Y384	—	RPN	Remote program input start	Y38C	YCCC		— —
Y385	—		Tool ID data read ▲	Y38D	YCCD		— —
Y386	—		Tool ID data write ▲	Y38E	YCCE		— —
Y387	—		Tool ID data erase ▲	Y38F	YCCF		— —

— — : Reserved for the system.

▲ : For specific manufacturers.

PLC → CNC (GX Developer) Table 4-3-12 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y390	—		Tool IC new read ▲	Y398	—	SPSY	Spindle synchronous control
Y391	—		Tool IC exchange read ▲	Y399	—	SPPHS	Spindle phase synchronous control
Y392	—			Y39A	—		Spindle synchronous rotation direction
Y393	—			Y39B	—	SSPHM	Phase shift calculation request
Y394	—			Y39C	—	SSPHF	Phase offset request
Y395	—		— —	Y39D	—	SPDRPO	Error temporary cancel
Y396	—			Y39E	—		
Y397	—		— —	Y39F	—		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y3A0	YCE0		PLC skip 1	Y3A8	YCE8	SYNC1	Synchronous control request 1st axis
Y3A1	YCE1		PLC skip 2	Y3A9	YCE9	SYNC2	2nd axis
Y3A2	YCE2		PLC skip 3	Y3AA	YCEA	SYNC3	3rd axis
Y3A3	YCE3		PLC skip 4	Y3AB	YCEB	SYNC4	4th axis
Y3A4	YCE4		PLC skip 5	Y3AC	YCEC	SYNC5	5th axis
Y3A5	YCE5		PLC skip 6	Y3AD	YCED	SYNC6	6th axis
Y3A6	YCE6		PLC skip 7	Y3AE	YCEE	SYNC7	7th axis
Y3A7	YCE7		PLC skip 8	Y3AF	YCEF	SYNC8	8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y3B0	YCF0	PILE1	Superimposition control request 1st axis	Y3B8	—		Door open II 1-2
Y3B1	YCF1	PILE2	2nd axis	Y3B9	—		— —
Y3B2	YCF2	PILE3	3rd axis	Y3BA	—		Door open signal input 1-2
Y3B3	YCF3	PILE4	4th axis	Y3BB	—		— —
Y3B4	YCF4	PILE5	5th axis	Y3BC	YCFC		
Y3B5	YCF5	PILE6	6th axis	Y3BD	YCFD		
Y3B6	YCF6	PILE7	7th axis	Y3BE	YCFE		
Y3B7	YCF7	PILE8	8th axis	Y3BF	YCFF		

— — : Reserved for the system.

▲ : For specific manufacturers.

PLC → CNC (GX Developer) Table 4-3-13 (GX Developer)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y3C0	YD00			Y3C8	YD08		
Y3C1	YD01			Y3C9	YD09		
Y3C2	YD02			Y3CA	YD0A		
Y3C3	YD03			Y3CB	YD0B		
Y3C4	YD04			Y3CC	YD0C		
Y3C5	YD05			Y3CD	YD0D		
Y3C6	YD06			Y3CE	YD0E		
Y3C7	YD07			Y3CF	YD0F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y3D0	YD10			Y3D8	YD18		
Y3D1	YD11			Y3D9	YD19		
Y3D2	YD12			Y3DA	YD1A		
Y3D3	YD13			Y3DB	YD1B		
Y3D4	YD14			Y3DC	YD1C		
Y3D5	YD15			Y3DD	YD1D		
Y3D6	YD16			Y3DE	YD1E		
Y3D7	YD17			Y3DF	YD1F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y3E0	YD20			Y3E8	YD28		
Y3E1	YD21			Y3E9	YD29		
Y3E2	YD22			Y3EA	YD2A		
Y3E3	YD23			Y3EB	YD2B		
Y3E4	YD24			Y3EC	YD2C		
Y3E5	YD25			Y3ED	YD2D		
Y3E6	YD26			Y3EE	YD2E		
Y3E7	YD27			Y3EF	YD2F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y3F0	YD30			Y3F8	YD38		
Y3F1	YD31			Y3F9	YD39		
Y3F2	YD32			Y3FA	YD3A		
Y3F3	YD33			Y3FB	YD3B		
Y3F4	YD34			Y3FC	YD3C		
Y3F5	YD35			Y3FD	YD3D		
Y3F6	YD36			Y3FE	YD3E		
Y3F7	YD37			Y3FF	YD3F		

PLC → CNC (GX Developer) Table 4-3-14 (GX Developer)

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
YD40	YD50	SWS	Spindle selection	YD48	YD58	GFIN	Gear shift complete
YD41	YD51			YD49	YD59		
YD42	YD52			YD4A	YD5A		
YD43	YD53			YD4B	YD5B		
YD44	YD54			YD4C	YD5C		
YD45	YD55			YD4D	YD5D		
YD46	YD56			YD4E	YD5E		
YD47	YD57	MPCSL	PLC coil changeover	YD4F	YD5F		

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
YD80	YDA0	SP1	Spindle override 1	YD88	YDA8	GI1	Spindle gear selection input 1
YD81	YDA1	SP2	Spindle override 2	YD89	YDA9	GI2	Spindle gear selection input 2
YD82	YDA2	SP4	Spindle override 4	YD8A	YDAA	—	(Always "0")
YD83	YDA3			YD8B	YDAB		
YD84	YDA4			YD8C	YDAC	SSTP	Spindle stop
YD85	YDA5			YD8D	YDAD	SSFT	Spindle gear shift
YD86	YDA6			YD8E	YDAE	SORC	Oriented spindle speed command
YD87	YDA7	SPS	Spindle override method select	YD8F	YDAF		

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
YD90	YDB0	SRN	Spindle forward run start	YD98	YDB8		
YD91	YDB1	SRI	Spindle reverse run start	YD99	YDB9		
YD92	YDB2	TL1	Torque limit 1	YD9A	YDBA		C axis gain L
YD93	YDB3	TL2	Torque limit 2	YD9B	YDBB		C axis gain H
YD94	YDB4	WRN	Spindle forward run index	YD9C	YDBC		C axis reference position return
YD95	YDB5	WRI	Spindle reverse run index	YD9D	YDBD		
YD96	YDB6	ORC	Spindle orientation command	YD9E	YDBE	LRSM	M coil selection
YD97	YDB7	LRSL	L coil selection	YD9F	YDBF		

PLC → CNC (PLC4B)

Table 4-3-1 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y180	W0	DTCH1	Control axis detach 1st axis	Y188	W8	* SVF1	Servo OFF 1st axis
Y181	W1	DTCH2	2nd axis	Y189	W9	* SVF2	Servo OFF 2nd axis
Y182	W2	DTCH3	3rd axis	Y18A	WA	* SVF3	Servo OFF 3rd axis
Y183	W3	DTCH4	4th axis	Y18B	WB	* SVF4	Servo OFF 4th axis
Y184	W4	DTCH5	5th axis	Y18C	WC	* SVF5	Servo OFF 5th axis
Y185	W5	DTCH6	6th axis	Y18D	WD	* SVF6	Servo OFF 6th axis
Y186	W6	DTCH7	7th axis	Y18E	WE	* SVF7	Servo OFF 7th axis
Y187	W7	DTCH8	8th axis	Y18F	WF	* SVF8	Servo OFF 8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y190	W10	MI1	Mirror image 1st axis	Y198	W18	* +EDT1	External deceleration +1st axis
Y191	W11	MI2	Mirror image 2nd axis	Y199	W19	* +EDT2	+2nd axis
Y192	W12	MI3	Mirror image 3rd axis	Y19A	W1A	* +EDT3	+3rd axis
Y193	W13	MI4	Mirror image 4th axis	Y19B	W1B	* +EDT4	+4th axis
Y194	W14	MI5	Mirror image 5th axis	Y19C	W1C	* +EDT5	+5th axis
Y195	W15	MI6	Mirror image 6th axis	Y19D	W1D	* +EDT6	+6th axis
Y196	W16	MI7	Mirror image 7th axis	Y19E	W1E	* +EDT7	+7th axis
Y197	W17	MI8	Mirror image 8th axis	Y19F	W1F	* +EDT8	+8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y1A0	W20	* -EDT1	External deceleration -1st axis	Y1A8	W28	* +AIT1	Auto interlock +1st axis
Y1A1	W21	* -EDT2	-2nd axis	Y1A9	W29	* +AIT2	+2nd axis
Y1A2	W22	* -EDT3	-3rd axis	Y1AA	W2A	* +AIT3	+3rd axis
Y1A3	W23	* -EDT4	-4th axis	Y1AB	W2B	* +AIT4	+4th axis
Y1A4	W24	* -EDT5	-5th axis	Y1AC	W2C	* +AIT5	+5th axis
Y1A5	W25	* -EDT6	-6th axis	Y1AD	W2D	* +AIT6	+6th axis
Y1A6	W26	* -EDT7	-7th axis	Y1AE	W2E	* +AIT7	+7th axis
Y1A7	W27	* -EDT8	-8th axis	Y1AF	W2F	* +AIT8	+8th axis

PLC → CNC (PLC4B) Table 4-3-2 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y1B0	W30	* -AIT1	Auto interlock -1st axis	Y1B8	W38	* +MIT1	Manual interlock +1st axis
Y1B1	W31	* -AIT2	-2nd axis	Y1B9	W39	* +MIT2	+2nd axis
Y1B2	W32	* -AIT3	-3rd axis	Y1BA	W3A	* +MIT3	+3rd axis
Y1B3	W33	* -AIT4	-4th axis	Y1BB	W3B	* +MIT4	+4th axis
Y1B4	W34	* -AIT5	-5th axis	Y1BC	W3C	* +MIT5	+5th axis
Y1B5	W35	* -AIT6	-6th axis	Y1BD	W3D	* +MIT6	+6th axis
Y1B6	W36	* -AIT7	-7th axis	Y1BE	W3E	* +MIT7	+7th axis
Y1B7	W37	* -AIT8	-8th axis	Y1BF	W3F	* +MIT8	+8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y1C0	W40	*-MIT1	Manual interlock -1st axis	Y1C8	W48	AMLK1	Auto machine lock 1st axis
Y1C1	W41	*-MIT2	-2nd axis	Y1C9	W49	AMLK2	2nd axis
Y1C2	W42	*-MIT3	-3rd axis	Y1CA	W4A	AMLK3	3rd axis
Y1C3	W43	*-MIT4	-4th axis	Y1CB	W4B	AMLK4	4th axis
Y1C4	W44	*-MIT5	-5th axis	Y1CC	W4C	AMLK5	5th axis
Y1C5	W45	*-MIT6	-6th axis	Y1CD	W4D	AMLK6	6th axis
Y1C6	W46	*-MIT7	-7th axis	Y1CE	W4E	AMLK7	7th axis
Y1C7	W47	*-MIT8	-8th axis	Y1CF	W4F	AMLK8	8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y1D0	W50	MMLK1	Manual machine lock 1st axis	Y1D8	W58	+J1	Feed axis select +1st axis
Y1D1	W51	MMLK2	2nd axis	Y1D9	W59	+J2	+2nd axis
Y1D2	W52	MMLK3	3rd axis	Y1DA	W5A	+J3	+3rd axis
Y1D3	W53	MMLK4	4th axis	Y1DB	W5B	+J4	+4th axis
Y1D4	W54	MMLK5	5th axis	Y1DC	W5C	+J5	+5th axis
Y1D5	W55	MMLK6	6th axis	Y1DD	W5D	+J6	+6th axis
Y1D6	W56	MMLK7	7th axis	Y1DE	W5E	+J7	+7th axis
Y1D7	W57	MMLK8	8th axis	Y1DF	W5F	+J8	+8th axis

PLC → CNC (PLC4B) Table 4-3-3 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y1E0	W60	-J1	Feed axis select -1st axis	Y1E8	W68	CHPS	Chopping
Y1E1	W61	-J2	-2nd axis	Y1E9	W69		
Y1E2	W62	-J3	-3rd axis	Y1EA	W6A		
Y1E3	W63	-J4	-4th axis	Y1EB	W6B		
Y1E4	W64	-J5	-5th axis	Y1EC	W6C		
Y1E5	W65	-J6	-6th axis	Y1ED	W6D		
Y1E6	W66	-J7	-7th axis	Y1EE	W6E		
Y1E7	W67	-J8	-8th axis	Y1EF	W6F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y1F0	W70	MAE1	Manual/Auto simultaneous valid 1st axis	Y1F8	W78		— —
Y1F1	W71	MAE2	2nd axis	Y1F9	W79		
Y1F2	W72	MAE3	3rd axis	Y1FA	W7A	RSST	Search & start
Y1F3	W73	MAE4	4th axis	Y1FB	W7B		Magazine index check valid (ATC high-speed)
Y1F4	W74	MAE5	5th axis	Y1FC	W7C		Spindle orientation complete standby valid (ATC high-speed)
Y1F5	W75	MAE6	6th axis	Y1FD	W7D		
Y1F6	W76	MAE7	7th axis	Y1FE	W7E		
Y1F7	W77	MAE8	8th axis	Y1FF	W7F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y200	W80	ZSL1	Reference position select 1	Y208	W88	J	Jog mode
Y201	W81	ZSL2	Reference position select 2	Y209	W89	H	Handle mode
Y202	W82			Y20A	W8A	S	Incremental mode
Y203	W83			Y20B	W8B	PTP	Manual random feed mode
Y204	W84			Y20C	W8C	ZRN	Reference position return mode
Y205	W85			Y20D	W8D	AST	Auto initialization mode
Y206	W86			Y20E	W8E		
Y207	W87		Reference position select method	Y20F	W8F		

— — : Reserved for the system.

PLC → CNC (PLC4B) Table 4-3-4 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y210	W90	MEM	Memory mode	Y218	W98	ST	Auto operation "start" command
Y211	W91	T	Tape mode	Y219	W99	* SP	Auto operation "pause" command
Y212	W92		— —	Y21A	W9A	SBK	Single block
Y213	W93	D	MDI mode	Y21B	W9B	* BSL	Block start interlock
Y214	W94		— —	Y21C	W9C	* CSL	Cutting block start interlock
Y215	W95		Direct operation mode ▲	Y21D	W9D	DRN	Dry run
Y216	W96			Y21E	W9E		
Y217	W97			Y21F	W9F	ERD	Error detect

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y220	WA0	NRST1	NC reset 1	Y228	WA8	TLM	Tool length measurement 1
Y221	WA1	NRST2	NC reset 2	Y229	WA9	TLMS	Tool length measurement 2 (L system)
Y222	WA2	RRW	Reset & rewind	Y22A	WAA		Synchronization correction mode
Y223	WA3	* CDZ	Chamfering	Y22B	WAB	PRST	Program restart
Y224	WA4	ARST	Auto restart	Y22C	WAC	PB	Playback
Y225	WA5	GFIN	Gear shift complete	Y22D	WAD	UIT	Macro interrupt
Y226	WA6	FIN1	M function finish 1	Y22E	WAE	RT	Rapid traverse
Y227	WA7	FIN2	M function finish 2	Y22F	WAF		— —

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y230	WB0	ABS	Manual absolute	Y238	—	* KEY1	Data protect key 1
Y231	WB1	DLK	Display lock	Y239	—	* KEY2	Data protect key 2
Y232	WB2		F1-digit speed change valid	Y23A	—	* KEY3	Data protect key 3
Y233	WB3	CRQ	Recalculation request	Y23B	—	—	— —
Y234	—	RHD1	Integration time input 1	Y23C	—	PDISP	Program display during operation
Y235	—	RHD2	Integration time input 2	Y23D	WBD		Inclined axis control valid
Y236	WB6	PIT	PLC interrupt signal	Y23E	WBE		Inclined axis control: No Z axis compensation
Y237	WB7			Y23F	WBF	BDT1	Optional block skip

— — : Reserved for the system.

▲ : For specific manufacturers.

PLC → CNC (PLC4B)

Table 4-3-5 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y240	WC0	—	— —	Y248	WC8	HS11	1st handle axis No.
Y241	WC1	—	— —	Y249	WC9	HS12	
Y242	WC2	—	— —	Y24A	WCA	HS14	
Y243	WC3	—	— —	Y24B	WCB	HS18	
Y244	WC4	—	— —	Y24C	WCC	HS116	
Y245	WC5	—	— —	Y24D	WCD		
Y246	WC6	—	— —	Y24E	WCE		
Y247	WC7	—	— —	Y24F	WCF	HS1S	1st handle valid

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y250	WD0	HS21	2nd handle axis No.	Y258	WD8	HS31	3rd handle axis No.
Y251	WD1	HS22		Y259	WD9	HS32	
Y252	WD2	HS24		Y25A	WDA	HS34	
Y253	WD3	HS28		Y25B	WDB	HS38	
Y254	WD4	HS216		Y25C	WDC	HS316	
Y255	WD5			Y25D	WDD		
Y256	WD6			Y25E	WDE		
Y257	WD7	HS2S	2nd handle valid	Y25F	WDF	HS3S	3rd handle valid

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y260	WE0	FBE1	Manual feedrate B valid 1st axis	Y268	WE8	CX11	Manual random feed 1st axis No.
Y261	WE1	FBE2	2nd axis	Y269	WE9	CX12	
Y262	WE2	FBE3	3rd axis	Y26A	WEA	CX14	
Y263	WE3	FBE4	4th axis	Y26B	WEB	CX18	
Y264	WE4	FBE5	5th axis	Y26C	WEC	CX116	
Y265	WE5	FBE6	6th axis	Y26D	WED		(Always "0")
Y266	WE6	FBE7	7th axis	Y26E	WEE		(Always "0")
Y267	WE7	FBE8	8th axis	Y26F	WEF	CX1S	Manual random feed 1st axis valid

— — : Reserved for the system.

PLC → CNC (PLC4B)

Table 4-3-6 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y270	WF0	CX21	Manual random feed 2nd axis No.	Y278	WF8	CX31	Manual random feed 3rd axis No.
Y271	WF1	CX22		Y279	WF9	CX32	
Y272	WF2	CX24		Y27A	WFA	CX34	
Y273	WF3	CX28		Y27B	WFB	CX38	
Y274	WF4	CX216		Y27C	WFC	CX316	
Y275	WF5		(Always "0")	Y27D	WFD		(Always "0")
Y276	WF6		(Always "0")	Y27E	WFE		(Always "0")
Y277	WF7	CX2S	Manual random feed 2nd axis valid	Y27F	WFF	CX3S	Manual random feed 3rd axis valid

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st SP	2nd SP	Abbrev.	Signal name
Y280	W100	CXS1	Smoothing off	Y288	W108	SP1	Spindle override 1
Y281	W101	CXS2	Axis independent	Y289	W109	SP2	Spindle override 2
Y282	W102	CXS3	EX.F/MODAL.F	Y28A	W10A	SP4	Spindle override 4
Y283	W103	CXS4	G0/G1	Y28B	W10B		
Y284	W104	CXS5	MC/WK	Y28C	W10C		
Y285	W105	CXS6	ABS/INC	Y28D	W10D		
Y286	W106	*CXS7	Stop	Y28E	W10E		
Y287	W107	CXS8	Strobe	Y28F	W10F	SPS	Spindle override method select

Device No.				Device No.			
1st SP	2nd SP	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y290	W110	GI1	Spindle gear select 1	Y298	W118	OVC	Override cancel
Y291	W111	GI2	Spindle gear select 2	Y299	W119	OVSL	Manual override valid
Y292	W112	—	(Always "0")	Y29A	W11A	AFL	Miscellaneous function lock
Y293	W113			Y29B	W11B		
Y294	W114	SSTP	Spindle stop	Y29C	W11C	TRV	Tap retract
Y295	W115	SSFT	Spindle gear shift	Y29D	W11D	RTN	Reference position retract
Y296	W116	SORC	Oriented spindle speed command	Y29E	W11E		
Y297	W117			Y29F	W11F	QEMG	PLC emergency stop

PLC → CNC (PLC4B) Table 4-3-7 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y2A0	W120	* FV1	Cutting feedrate override	Y2A8	W128	ROV1	Rapid traverse speed override
Y2A1	W121	* FV2		Y2A9	W129	ROV2	
Y2A2	W122	* FV4		Y2AA	W12A		
Y2A3	W123	* FV8		Y2AB	W12B		
Y2A4	W124	* FV16		Y2AC	W12C		
Y2A5	W125			Y2AD	W12D		
Y2A6	W126	FV2E	2nd cutting feedrate override valid	Y2AE	W12E		
Y2A7	W127	FVS	Cutting feedrade override method select	Y2AF	W12F	ROVS	Rapid traverse speed override method select

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y2B0	W130	* JV1	Manual feedrate	Y2B8	W138	PCF1	Feedrate least increment
Y2B1	W131	* JV2		Y2B9	W139	PCF2	
Y2B2	W132	* JV4		Y2BA	W13A	JSYN	Jog synchronous feed valid
Y2B3	W133	* JV8		Y2BB	W13B	JHAN	Jog•handle synchronous
Y2B4	W134	* JV16		Y2BC	W13C		Each axis manual feedrate B valid
Y2B5	W135			Y2BD	W13D		— —
Y2B6	W136			Y2BE	W13E		— —
Y2B7	W137	JVS	Manual feedrate method select	Y2BF	W13F		— —

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y2C0	W140	MP1	Handle/Incremental feed multiplication	Y2C8	W148	TAL1	Tool alarm 1/Tool-skip tool
Y2C1	W141	MP2		Y2C9	W149	TAL2	Tool alarm 2 (M system)
Y2C2	W142	MP4		Y2CA	W14A	TCEF	Data count valid
Y2C3	W143			Y2CB	W14B	TLFI	Tool life management input (M system)
Y2C4	W144			Y2CC	W14C	TRST	Tool change reset (L system)
Y2C5	W145			Y2CD	W14D		
Y2C6	W146		— —	Y2CE	W14E		
Y2C7	W147	MPS	Handle/Incremental feed multiplication method select	Y2CF	W14F		

— — : Reserved for the system.

PLC → CNC (PLC4B) Table 4-3-8 (PLC4B)

Device No.				Device No.			
1st SP	2nd SP	Abbrev.	Signal name	1st SP	2nd SP	Abbrev.	Signal name
Y2D0	W150	SRN	Spindle forward run start	Y2D8	W158		
Y2D1	W151	SRI	Spindle reverse run start	Y2D9	W159		
Y2D2	W152	TL1	Torque limit 1	Y2DA	W15A		C axis gain L
Y2D3	W153	TL2	Torque limit 2	Y2DB	W15B		C axis gain H
Y2D4	W154	WRN	Spindle forward run index	Y2DC	W15C		C axis zero point return
Y2D5	W155	WRI	Spindle reverse run index	Y2DD	W15D		
Y2D6	W156	ORC	Spindle orient command	Y2DE	W15E	LRSM	M coil selection
Y2D7	W157	LRSL	L coil selection	Y2DF	W15F		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y2E0	—	* PCD1	PLC axis near point detect 1st axis	Y2E8	—	SPSYC	Spindle synchronization cancel
Y2E1	—	* PCD2	PLC axis near point detect 2nd axis	Y2E9	—	SPCMPC	Chuck close
Y2E2	—		— —	Y2EA	—		
Y2E3	—		— —	Y2EB	—		
Y2E4	—	PCH1	PLC axis 1st handle valid	Y2EC	—		
Y2E5	—	PCH2	PLC axis 2nd handle valid	Y2ED	—		
Y2E6	—	PCH3	PLC axis 3rd handle valid	Y2EE	—		
Y2E7	W167			Y2EF	—		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y2F0	W170		— —	Y2F8	—	CRTFN	CRT changeover complete
Y2F1	W171		— —	Y2F9	W179	CSRON	Screen display request
Y2F2	W172		— —	Y2FA	W17A		
Y2F3	W173		— —	Y2FB	W17B	NETSTP	MELDASNET sampling stop
Y2F4	W174		— —	Y2FC	—	SMPTRG	Data sampling trigger
Y2F5	W175		— —	Y2FD	—	MTBT	PLC snapshot
Y2F6	W176		— —	Y2FE	—	DISP1	Display changeover $1
Y2F7	W177		— —	Y2FF	—	DISP2	Display changeover $2

— — : Reserved for the system.

PLC → CNC (PLC4B)

Table 4-3-9 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y300	W180	AZS1	Zero point initialization set mode 1st axis	Y308	W188	ZST1	Zero point initialization set start 1st axis
Y301	W181	AZS2	2nd axis	Y309	W189	ZST2	2nd axis
Y302	W182	AZS3	3rd axis	Y30A	W18A	ZST3	3rd axis
Y303	W183	AZS4	4th axis	Y30B	W18B	ZST4	4th axis
Y304	W184	AZS5	5th axis	Y30C	W18C	ZST5	5th axis
Y305	W185	AZS6	6th axis	Y30D	W18D	ZST6	6th axis
Y306	W186	AZS7	7th axis	Y30E	W18E	ZST7	7th axis
Y307	W187	AZS8	8th axis	Y30F	W18F	ZST8	8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y310	W190		Current limit mode 1	Y318	W198		Current limit changeover 1st axis
Y311	W191		Current limit mode 2	Y319	W199		2nd axis
Y312	W192		(Same as above, spare)	Y31A	W19A		3rd axis
Y313	W193	LDWT	Load monitor Teaching/ monitor execution ▲	Y31B	W19B		4th axis
Y314	W194		Load monitor Teaching mode select ▲	Y31C	W19C		5th axis
Y315	W195		Load monitor Monitor mode select ▲	Y31D	W19D		6th axis
Y316	W196		Load monitor Alarm reset ▲	Y31E	W19E		7th axis
Y317	W197		Load monitor Warning reset ▲	Y31F	W19F		8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y320	W1A0		Droop release request 1st axis	Y328	W1A8		— —
Y321	W1A1		2nd axis	Y329	W1A9		Ext. workpiece coordinate measurement 2nd axis
Y322	W1A2		3rd axis	Y32A	W1AA		— —
Y323	W1A3		4th axis	Y32B	W1AB		— —
Y324	W1A4		5th axis	Y32C	W1AC		— —
Y325	W1A5		6th axis	Y32D	W1AD		— —
Y326	W1A6		7th axis	Y32E	W1AE		— —
Y327	W1A7		8th axis	Y32F	W1AF		— —

— — : Reserved for the system.

▲ : For specific manufacturers.

PLC → CNC (PLC4B) Table 4-3-10 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y330	W1B0	DTCH21	Control axis detach 2 1st axis	Y338	W1B8		Unclamp complete 1st axis
Y331	W1B1	DTCH22	2nd axis	Y339	W1B9		2nd axis
Y332	W1B2	DTCH23	3rd axis	Y33A	W1BA		3rd axis
Y333	W1B3	DTCH24	4th axis	Y33B	W1BB		4th axis
Y334	W1B4	DTCH25	5th axis	Y33C	W1BC		5th axis
Y335	W1B5	DTCH26	6th axis	Y33D	W1BD		6th axis
Y336	W1B6	DTCH27	7th axis	Y33E	W1BE		7th axis
Y337	W1B7	DTCH28	8th axis	Y33F	W1BF		8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y340	W1C0		Each axis reference position return 1st axis	Y348	W1C8	* ZRIT	2nd reference position return interlock
Y341	W1C1		2nd axis	Y349	W1C9		Adaptive control execution ▲
Y342	W1C2		3rd axis	Y34A	W1CA		Small diameter deep hole drilling cycle
Y343	W1C3		4th axis	Y34B	W1CB		— —
Y344	W1C4		5th axis	Y34C	W1CC		INC high-speed retract function valid ▲
Y345	W1C5		6th axis	Y34D	W1CD		Optimum pecking function valid ▲
Y346	W1C6		7th axis	Y34E	W1CE		Load monitor function valid ▲
Y347	W1C7		8th axis	Y34F	W1CF		

Device No.				Device No.			
1st SP	2nd SP	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y350	W1D0	SWS	Spindle selection	Y358	W1D8		Waiting ignore
Y351	W1D1			Y359	W1D9		Spindle-spindle polygon cancel
Y352	W1D2			Y35A	W1DA		Synchronous tapping command polarity reversal
Y353	W1D3			Y35B	W1DB		Spindle OFF mode
Y354	W1D4			Y35C	W1DC		
Y355	W1D5			Y35D	W1DD		
Y356	W1D6			Y35E	W1DE		
Y357	W1D7	MPCSL	PLC coil changeover	Y35F	W1DF		

— — : Reserved for the system.

▲ : For specific manufacturers.

PLC → CNC (PLC4B) Table 4-3-11 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y360	W1E0		Cross machining control request 1st axis	Y368	W1E8		
Y361	W1E1		2nd axis	Y369	W1E9		
Y362	W1E2		3rd axis	Y36A	W1EA		
Y363	W1E3		4th axis	Y36B	W1EB		
Y364	W1E4		5th axis	Y36C	W1EC		
Y365	W1E5		6th axis	Y36D	W1ED		
Y366	W1E6		7th axis	Y36E	W1EE		
Y367	W1E7		8th axis	Y36F	W1EF		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y370	W1F0		Position switch 1 interlock	Y378	W1F8		Barrier valid (left)
Y371	W1F1		Position switch 2 interlock	Y379	W1F9		Barrier valid (right)
Y372	W1F2		Position switch 3 interlock	Y37A	W1FA		Tool presetter sub-side valid
Y373	W1F3		Position switch 4 interlock	Y37B	W1FB		
Y374	W1F4		Position switch 5 interlock	Y37C	W1FC		
Y375	W1F5		Position switch 6 interlock	Y37D	W1FD		
Y376	W1F6		Position switch 7 interlock	Y37E	W1FE		
Y377	W1F7		Position switch 8 interlock	Y37F	W1FF		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st SP	2nd SP	Abbrev.	Signal name
Y380	—		Door open	Y388	J588		Magnetic bearing servo ON command
Y381	J581		Door open II	Y389	J589		Magnetic bearing tool unclamp
Y382	J582		Door open signal input (spindle speed monitor)	Y38A	J58A		— —
Y383	J583		Door interlock spindle speed clamp	Y38B	J58B		— —
Y384	—	RPN	Remote program input start	Y38C	J58C		— —
Y385	—		Tool ID data read ▲	Y38D	J58D		— —
Y386	—		Tool ID data write ▲	Y38E	J58E		— —
Y387	—		Tool ID data erase ▲	Y38F	J58F		— —

— — : Reserved for the system.

▲ : For specific manufacturers.

PLC → CNC (PLC4B) Table 4-3-12 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y390	—		Tool IC new read ▲	Y398	—	SPSY	Spindle synchronous control
Y391	—		Tool IC exchange read ▲	Y399	—	SPPHS	Spindle phase synchronous control
Y392	—			Y39A	—		Spindle synchronous rotation direction
Y393	—			Y39B	—	SSPHM	Phase shift calculation request
Y394	—			Y39C	—	SSPHF	Phase offset request
Y395	—		— —	Y39D	—	SPDRPO	Error temporary cancel
Y396	—			Y39E	—		
Y397	—		— —	Y39F	—		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y3A0	J5A0		PLC skip 1	Y3A8	J5A8	SYNC1	Synchronous control request 1st axis
Y3A1	J5A1		PLC skip 2	Y3A9	J5A9	SYNC2	2nd axis
Y3A2	J5A2		PLC skip 3	Y3AA	J5AA	SYNC3	3rd axis
Y3A3	J5A3		PLC skip 4	Y3AB	J5AB	SYNC4	4th axis
Y3A4	J5A4		PLC skip 5	Y3AC	J5AC	SYNC5	5th axis
Y3A5	J5A5		PLC skip 6	Y3AD	J5AD	SYNC6	6th axis
Y3A6	J5A6		PLC skip 7	Y3AE	J5AE	SYNC7	7th axis
Y3A7	J5A7		PLC skip 8	Y3AF	J5AF	SYNC8	8th axis

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y3B0	J5B0	PILE1	Superimposition control request 1st axis	Y3B8	—		Door open II 1-2
Y3B1	J5B1	PILE2	2nd axis	Y3B9	—		— —
Y3B2	J5B2	PILE3	3rd axis	Y3BA	—		Door open signal input 1-2
Y3B3	J5B3	PILE4	4th axis	Y3BB	—		— —
Y3B4	J5B4	PILE5	5th axis	Y3BC	J5BC		
Y3B5	J5B5	PILE6	6th axis	Y3BD	J5BD		
Y3B6	J5B6	PILE7	7th axis	Y3BE	J5BE		
Y3B7	J5B7	PILE8	8th axis	Y3BF	J5BF		

— — : Reserved for the system.

▲ : For specific manufacturers.

PLC → CNC (PLC4B) Table 4-3-13 (PLC4B)

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y3C0	J5C0			Y3C8	J5C8		
Y3C1	J5C1			Y3C9	J5C9		
Y3C2	J5C2			Y3CA	J5CA		
Y3C3	J5C3			Y3CB	J5CB		
Y3C4	J5C4			Y3CC	J5CC		
Y3C5	J5C5			Y3CD	J5CD		
Y3C6	J5C6			Y3CE	J5CE		
Y3C7	J5C7			Y3CF	J5CF		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y3D0	J5D0			Y3D8	J5D8		
Y3D1	J5D1			Y3D9	J5D9		
Y3D2	J5D2			Y3DA	J5DA		
Y3D3	J5D3			Y3DB	J5DB		
Y3D4	J5D4			Y3DC	J5DC		
Y3D5	J5D5			Y3DD	J5DD		
Y3D6	J5D6			Y3DE	J5DE		
Y3D7	J5D7			Y3DF	J5DF		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y3E0	J5E0			Y3E8	J5E8		
Y3E1	J5E1			Y3E9	J5E9		
Y3E2	J5E2			Y3EA	J5EA		
Y3E3	J5E3			Y3EB	J5EB		
Y3E4	J5E4			Y3EC	J5EC		
Y3E5	J5E5			Y3ED	J5ED		
Y3E6	J5E6			Y3EE	J5EE		
Y3E7	J5E7			Y3EF	J5EF		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
Y3F0	J5F0			Y3F8	J5F8		
Y3F1	J5F1			Y3F9	J5F9		
Y3F2	J5F2			Y3FA	J5FA		
Y3F3	J5F3			Y3FB	J5FB		
Y3F4	J5F4			Y3FC	J5FC		
Y3F5	J5F5			Y3FD	J5FD		
Y3F6	J5F6			Y3FE	J5FE		
Y3F7	J5F7			Y3FF	J5FF		

PLC → CNC (PLC4B) Table 4-3-14 (PLC4B)

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
J600	J610	SWS	Spindle selection	J608	J618	GFIN	Gear shift complete
J601	J611			J609	J619		
J602	J612			J60A	J61A		
J603	J613			J60B	J61B		
J604	J614			J60C	J61C		
J605	J615			J60D	J61D		
J606	J616			J60E	J61E		
J607	J617	MPCSL	PLC coil changeover	J60F	J61F		

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
S020	S060	SP1	Spindle override 1	S028	S068	GI1	Spindle gear selection input 1
S021	S061	SP2	Spindle override 2	S029	S069	GI2	Spindle gear selection input 2
S022	S062	SP4	Spindle override 4	S02A	S06A	—	(Always "0")
S023	S063			S02B	S06B		
S024	S064			S02C	S06C	SSTP	Spindle stop
S025	S065			S02D	S06D	SSFT	Spindle gear shift
S026	S066			S02E	S06E	SORC	Oriented spindle speed command
S027	S067	SPS	Spindle override method select	S02F	S06F		

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
S030	S070	SRN	Spindle forward run start	S038	S078		
S031	S071	SRI	Spindle reverse run start	S039	S079		
S032	S072	TL1	Torque limit 1	S03A	S07A		C axis gain L
S033	S073	TL2	Torque limit 2	S03B	S07B		C axis gain H
S034	S074	WRN	Spindle forward run index	S03C	S07C		C axis reference position return
S035	S075	WRI	Spindle reverse run index	S03D	S07D		
S036	S076	ORC	Spindle orientation command	S03E	S07E	LRSM	M coil selection
S037	S077	LRSL	L coil selection	S03F	S07F		

PLC → CNC Table 4-4-1

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R100	—	AO1	Analog output	R108	R308		Spindle command rotation speed output
R101	—	AO2	Analog output	R109	R309		
R102	—	AO3	Analog output	R110	R310	SLSP	Spindle command selection
R103	—	AO4	Analog output	R111	R311		
R104	—		— —	R112	—		KEY OUT 1
R105	—		— —	R113	R313		
R106	—		— —	R114	R314		
R107	—		— —	R115	R315		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R116	R316		Load monitor Axis selection ▲	R124	R324		Encoder selection
R117	R317		Load monitor Load change rate detection axis ▲	R125	R325		C axis selection
R118	R318		Load monitor Teaching data sub-No. ▲	R126	R326		
R119	R319		Adaptive control Basic axis selection ▲	R127	R327		
R120	R320		Each axis reference position select	R128	R328		
R121	R321		Each axis reference position return interlock (ATC time reduction)	R129	R329		
R122	R322		Editing state input ▲	R130	R330		PLC interrupt program number
R123	R323			R131	R331		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R132	R332		1st cutting feedrate override	R140	R340		Handle/Incremental feed multiplication
R133	R333		2nd cutting feedrate override	R141	R341		
R134	R334		Rapid traverse override	R142	R342		Manual random feed 1st axis movement data
R135	R335	CHPOV	Chopping override	R143	R343		
R136	R336		Manual feedrate	R144	R344		Manual random feed 2nd axis movement data
R137	R337			R145	R345		
R138	R338		Manual feedrate B	R146	R346		Manual random feed 3rd axis movement data
R139	R339			R147	R347		

— — : Reserved for the system.

▲ : For specific manufacturers.

PLC → CNC Table 4-4-2

Device No.				Device No.			
1st sys	**2nd sys**	**Abbrev.**	**Signal name**	**1st sys**	**2nd sys**	**Abbrev.**	**Signal name**
R148	R348		S analog override	R156	R356		OT ignored
R149	R349		Multi-point orientation position data	R157	R357		Near-point ignored
R150	R350		Tool group number designation	R158	—		Alarm message I/F 1
R151	R351			R159	—		Alarm message I/F 2
R152	—		Load meter 1	R160	—		Alarm message I/F 3
R153	—			R161	—		Alarm message I/F 4
R154	—		Load meter 2	R162	—		Operator message I/F
R155	—			—	R363		Board communication state ▲

Device No.				Device No.			
1st sys	**2nd sys**	**Abbrev.**	**Signal name**	**1st sys**	**2nd sys**	**Abbrev.**	**Signal name**
R164	R364		— —	R172	—		User macro output #1132 **(Note 1)**
R165	R365		— —	R173	—		
R166	R366		— —	R174	—		User macro output #1133
R167	R367			R175	—		
R168	R368			R176	—		User macro output #1134
R169	R369			R177	—		
R170	R370		Search & start program No.	R178	—		User macro output #1135
R171	R371			R179	—		

Device No.				Device No.			
1st sys	**2nd sys**	**Abbrev.**	**Signal name**	**1st sys**	**2nd sys**	**Abbrev.**	**Signal name**
R180	—		Add-on (expansion) operation board output 1	R188	R388		Special display unit interface
R181	—		Add-on (expansion) operation board output 2	R189	R389		— —
R182	—		Add-on (expansion) operation board output 3	R190	R390		
R183	—		— — (spare)	R191	R391		
R184	R384			R192	R392		Ext. workpiece coordinate offset measurement tool compensation No. **(Note 2)**
R185	R385		Current limit changeover	R193	R393		
R186	R386		Wear compensation No. (tool presetter)	R194	R394		Ext. workpiece coordinate offset measurement tool No. **(Note 2)**
R187	R387		— —	R195	R395		

— — : Reserved for the system.

▲ : For specific manufacturers.

(Note 1) #1132 to #1135 are input signals to the PLC, and the direction is opposite of the other registers.

(Note 2) When the chuck barrier is checked, these are the "Selected tool compensation No. (main):R192, 193" and the "Selected tool No.(main):R194, 195"

PLC → CNC

Table 4-4-3

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R196	—		User PLC version code				
R197	—						
R198	—						
R199	—						

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R400	R416		Each axis manual feedrate B 1st axis	R408	R424		Each axis manual feedrate B 5th axis
R401	R417			R409	R425		
R402	R418		Each axis manual feedrate B 2nd axis	R410	R426		Each axis manual feedrate B 6th axis
R403	R419			R411	R427		
R404	R420		Each axis manual feedrate B 3rd axis	R412	R428		Each axis manual feedrate B 7th axis
R405	R421			R413	R429		
R406	R422		Each axis manual feedrate B 4th axis	R414	R430		Each axis manual feedrate B 8th axis
R407	R423			R415	R431		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
				R435	R436		Synchronous control operation method selection

PLC → CNC Table 4-4-4

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R438	—		Tool I/D R/W pot No. designation ▲	R446	—		Spindle synchronous control Basic spindle select
R439	—		Large diameter tool information ▲	R447	—		Synchronous spindle select
R440	—		Tool weight (spindle tool) ▲	R448	—		Phase shift amount
R441	—		Tool weight (standby tool) ▲	R449	—		
R442	—		Unset tool information ▲	R450	—		
R443	—		Tool IC communication process results ▲	R451	—		
R444	—		— —	R452	—		
R445	—		— —	R453	—		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R560	R568		Ext. machine coordinate system compensation data 1st axis				
R561	R569		2nd axis				
R562	R570		3rd axis				
R563	R571		4th axis				
R564	R572		5th axis				
R565	R573		6th axis				
R566	R574		7th axis				
R567	R575		8th axis				

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R627	—		Skip retract valid				
R628	—		Skip retract amount				
R629	—						
R630	—		Skip retract speed				
R631	—						

— — : Reserved for the system.

▲ : For specific manufacturers.

PLC → CNC Table 4-4-5

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R650	—		Direct screen selection	R658	—		APLC version
R651	—		Direct screen selection	R659	—		
R652	—		Direct screen selection				
R653	—		Direct screen selection	R669	—		Cutting performance estimation I/F ▲
R656	—		APLC version				
R657	—						

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R1000	R1050	—	Selected tool	R1008	R1058	—	— —
R1001	R1051	—	compensation No.(sub)	R1009	R1059		
R1002	R1052	—	wear No. (sub)	R1010	R1060		
R1003	R1053	—		R1011	R1061		
R1004	R1054	—	Tool mounting information (1 to 16)	R1012	R1062		
R1005	R1055	—	Tool mounting information (17 to 32)	R1013	R1063		
R1006	R1056	—	— —	R1014	R1064		
R1007	R1057	—	— —	R1015	R1065		

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R1400	—		Remote program input No.	R1896	—		Setup parameter lock I/F
R1401	—						
R1402			(password No.)				
R1403	—						
R1404	—		MELDAS-NET input				

— — : Reserved for the system.

▲ : For specific manufacturers.

PLC → CNC Table 4-4-6

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
R4600	R4620		Spindle command rotation speed output	R4608	R4628		
R4601	R4621			R4609	R4629		
R4602	R4622			R4610	R4630		
R4603	R4623			R4611	R4631		
R4604	R4624		S-analog override	R4612	R4632		
R4605	R4625		Multi-point orientation position data	R4613	R4633		
R4606	R4626	SLSP	Spindle selection signal	R4614	R4634		
R4607	R4627			R4615	R4635		

Device No.				Device No.			
3rd SP	4th SP	Abbrev.	Signal name	3rd SP	4th SP	Abbrev.	Signal name
R4616	R4636						
R4617	R4637						
R4618	R4638						
R4619	R4639						

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R4732			User PLC version code 2				
R4733							
R4734							
R4735							
R4736							
R4737							
R4738							

Device No.				Device No.			
1st sys	2nd sys	Abbrev.	Signal name	1st sys	2nd sys	Abbrev.	Signal name
R5461	R5470		Tool life management data sort ▲				
R5461	R5471		No. of registered tool life management items ▲				

▲ : For specific manufacturers.

Special relay (1/2) < $1, $2 common > Table 4-5-1 (GX Developer)

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
SM00			SM08		
SM01			SM09		
SM02			SM10		— —
SM03			SM11		
SM04			SM12	CARRY	Carry flag
SM05			SM13		
SM06			SM14		
SM07			SM15		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
SM16		Temperature rise	SM24		
SM17		DIO error	SM25		
SM18		— —	SM26		
SM19		— —	SM27		
SM20			SM28		
SM21			SM29		
SM22			SM30		
SM23			SM31		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
SM32			SM40		
SM33			SM41		
SM34			SM42		
SM35			SM43		
SM36			SM44		
SM37			SM45		
SM38			SM46		
SM39			SM47		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
SM48			SM56		
SM49			SM57		
SM50			SM58		
SM51			SM59		
SM52			SM60		
SM53			SM61		
SM54			SM62		
SM55			SM63		— —

— — : Reserved for the system.

Special relay (1/2) < $1, $2 common > Table 4-5-2 (GX Developer)

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
SM64	DSPRQ	Tool Registration and Life screen display request	SM72		
SM65	LSTIN	Life management data setting prohibited	SM73		— —
SM66		— —	SM74		
SM67		— —	SM75		
SM68			SM76		
SM69		— —	SM77		
SM70		— —	SM78		
SM71	TSTIN	Tool Registration screen setting prohibited	SM79		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
SM80	PSW00	X140 Reverse signal	SM88	PSW08	X148 Reverse signal
SM81	PSW01	X141 Reverse signal	SM89	PSW09	X149 Reverse signal
SM82	PSW02	X142 Reverse signal	SM90	PSW10	X14A Reverse signal
SM83	PSW03	X143 Reverse signal	SM91	PSW11	X14B Reverse signal
SM84	PSW04	X144 Reverse signal	SM92	PSW12	X14C Reverse signal
SM85	PSW05	X145 Reverse signal	SM93	PSW13	X14D Reverse signal
SM86	PSW06	X146 Reverse signal	SM94	PSW14	X14E Reverse signal
SM87	PSW07	X147 Reverse signal	SM95	PSW15	X14F Reverse signal

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
SM96	PSW16	X150 Reverse signal	SM104	PSW24	X158 Reverse signal
SM97	PSW17	X151 Reverse signal	SM105	PSW25	X159 Reverse signal
SM98	PSW18	X152 Reverse signal	SM106	PSW26	X15A Reverse signal
SM99	PSW19	X153 Reverse signal	SM107	PSW27	X15B Reverse signal
SM100	PSW20	X154 Reverse signal	SM108	PSW28	X15C Reverse signal
SM101	PSW21	X155 Reverse signal	SM109	PSW29	X15D Reverse signal
SM102	PSW22	X156 Reverse signal	SM110	PSW30	X15E Reverse signal
SM103	PSW23	X157 Reverse signal	SM111	PSW31	X15F Reverse signal

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
SM112			SM120		
SM113			SM121		
SM114			SM122		
SM115			SM123		
SM116			SM124		
SM117			SM125		
SM118			SM126		
SM119			SM127		

— — : Reserved for the system.

(Note) SM80 to SM111 are signals to reverse the PLC switch inputs X140 to X15F.

Special relay (1/2) < $1, $2 common > Table 4-5-1 (PLC4B)

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
E00			E08		
E01			E09		
E02			E10		— —
E03			E11		
E04			E12	CARRY	Carry flag
E05			E13		
E06			E14		
E07			E15		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
E16		Temperature rise warning	E24		
E17		DIO error	E25		
E18		— —	E26		
E19		— —	E27		
E20			E28		
E21			E29		
E22			E30		
E23			E31		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
E32			E40		
E33			E41		
E34			E42		
E35			E43		
E36			E44		
E37			E45		
E38			E46		
E39			E47		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
E48			E56		
E49			E57		
E50			E58		
E51			E59		
E52			E60		
E53			E61		
E54			E62		
E55			E63		— —

— — : Reserved for the system.

Special relay (2/2) < $1, $2 common > Table 4-5-2 (PLC4B)

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
E64	DSPRQ	Tool Registration and Life screen display request	E72		
E65	LSTIN	Life management data setting prohibited	E73		— —
E66		— —	E74		
E67		— —	E75		
E68			E76		
E69		— —	E77		
E70		— —	E78		
E71	TSTIN	Tool Registration screen setting prohibited	E79		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
E80	PSW00	X140 Reverse signal	E88	PSW08	X148 Reverse signal
E81	PSW01	X141 Reverse signal	E89	PSW09	X149 Reverse signal
E82	PSW02	X142 Reverse signal	E90	PSW10	X14A Reverse signal
E83	PSW03	X143 Reverse signal	E91	PSW11	X14B Reverse signal
E84	PSW04	X144 Reverse signal	E92	PSW12	X14C Reverse signal
E85	PSW05	X145 Reverse signal	E93	PSW13	X14D Reverse signal
E86	PSW06	X146 Reverse signal	E94	PSW14	X14E Reverse signal
E87	PSW07	X147 Reverse signal	E95	PSW15	X14F Reverse signal

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
E96	PSW16	X150 Reverse signal	E104	PSW24	X158 Reverse signal
E97	PSW17	X151 Reverse signal	E105	PSW25	X159 Reverse signal
E98	PSW18	X152 Reverse signal	E106	PSW26	X15A Reverse signal
E99	PSW19	X153 Reverse signal	E107	PSW27	X15B Reverse signal
E100	PSW20	X154 Reverse signal	E108	PSW28	X15C Reverse signal
E101	PSW21	X155 Reverse signal	E109	PSW29	X15D Reverse signal
E102	PSW22	X156 Reverse signal	E110	PSW30	X15E Reverse signal
E103	PSW23	X157 Reverse signal	E111	PSW31	X15F Reverse signal

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
E112			E120		
E113			E121		
E114			E122		
E115			E123		
E116			E124		
E117			E125		
E118			E126		
E119			E127		

— — : Reserved for the system.

(Note) E80 to E111 are signals to reverse the PLC switch inputs X140 to X15F.

(1) IO link

Table 4-6-1

Device No.	Master side	Slave side
Output data		
R1460 to R1467	Output 0 (common for all slaves)	Output (each slave axis)
R1468 to R1475	Output 1 (slave station 1)	Not used
R1476 to R1483	Output 2 (slave station 2)	Not used
R1484 to R1491	Output 3 (slave station 3)	Not used
R1492 to R1499	Output 4 (slave station 4)	Not used
Input data		
R1560 to R1567	Not used	Input 0 (common for all slaves)
R1568 to R1575	Input 1 (slave station 1)	Input (each slave axis)
R1576 to R1583	Input 2 (slave station 2)	Not used
R1584 to R1591	Input 3 (slave station 3)	Not used
R1592 to R1599	Input 4 (slave station 4)	Not used
R1559	IO link communication state	

(2) M-NET

Table 4-6-2

Device No.	Signal name
X380 to X47F	Serial input
Y400 to Y4FF	Serial output
Serial connection operation state	
R1880	No. of framing error occurrences
R1881	No. of parity error occurrences
R1882	No. of overrun error occurrences
R1883	No. of illegal transmission data detections
R1884	Error No. register
R1885	No. of illegal transmission data detections
R1886	Reception preparation sequence
R1887	Reception preparation sequence
R1888	Reception preparation sequence
R1889	Reception preparation sequence

(3) MELSEC bus connection

Table 4-6-3

Device No.	Signal name
X380 to X47F	Input
R4000 to R4095	
Y400 to Y4FF	Output
R4200 to R4327	
R1880	Current timeout counter
R1881	Maximum timeout counter after power ON
R1882	Maximum timeout counter after system startup (backed up)

(4) CC-Link

Table 4-6-4

Device name	Device range
X	X0 to X1FF (Avoid overlapping with the range for real I/O)
Y	Y0 to Y1FF (Avoid overlapping with the range for real I/O)
M	M0 to M8191
L	L0 to L255
D	D0 to D1023
R	R4000 to R4499, R6400 to R7199

Input No.	Signal name	Output No.	Signal name
X480	Unit error	Y500	Refresh command
X481	Data link state at host station	Y501	(Prohibited to use)
X482	Parameter setting status	Y502	
X483	Data link status at other station	Y503	
X484	Unit reset acceptance completed	Y504	Unit reset request
X485	(Prohibited to use)	Y505	(Prohibited to use)
X486	Data link startup normal completion	Y506	Data link start request
X487	Data link startup error completion	Y507	(Prohibited to use)
X488	Data link startup by EEPROM parameter normal completion	Y508	Data link startup request from EEPROM parameter
X489	Data link startup by EEPROM parameter error completion	Y509	(Prohibited to use)
X48A	Parameter registration to EEPROM normal completion	Y50A	Parameter registration request to EEPROM
X48B	Parameter registration to EEPROM error completion	Y50B	(Prohibited to use)
X48C	(Prohibited to use)	Y50C	
X48D		Y50D	
X48E		Y50E	
X48F	Unit ready	Y50F	
X490	(Prohibited to use)	Y510	
X491		Y511	
X492		Y512	
X493		Y513	
X494		Y514	
X495		Y515	
X496		Y516	
X497		Y517	
X498		Y518	
X499		Y519	
X49A		Y51A	
X49B		Y51B	
X49C		Y51C	
X49D		Y51D	
X49E		Y51E	
X49F		Y51F	

(5) J2-CT link

Table 4-6-5

Device No.		Abbrev.	Signal name
	bit		
R1784	bit0		J2CT operation adjustment mode valid (common for all axes)

Signal name	J2CT control command 4	J2CT control command 3	J2CT control command 2	J2CT control command 1	J2CT control command L	J2CT control command H
Abbrev.	CTCM4	CTCM3	CTCM2	CTCM1	CTCML	CTCMH
J2CT 1st axis	R1700	R1701	R1702	R1703	R1704	R1705
J2CT 2nd axis	R1706	R1707	R1708	R1709	R1710	R1711
J2CT 3rd axis	R1712	R1713	R1714	R1715	R1716	R1717
J2CT 4th axis	R1718	R1719	R1720	R1721	R1722	R1723

Device No.		Abbrev.	Signal name
	bit		
R1656	bit0		J2CT 1st axis in operation adjustment mode
	bit1		J2CT 2nd axis in operation adjustment mode
	bit2		J2CT 3rd axis in operation adjustment mode
	bit3		J2CT 4th axis in operation adjustment mode

Signal name	J2CT status 4	J2CT status 3	J2CT status 2	J2CT status 1
Abbrev.	CTST4	CTST3	CTST2	CTST1
J2CT 1st axis	R1600	R1601	R1602	R1603
J2CT 2nd axis	R1604	R1605	R1606	R1607
J2CT 3rd axis	R1608	R1609	R1610	R1611
J2CT 4th axis	R1612	R1613	R1614	R1615

(6) Other file registers (R)

Table 4-6-6

Device No.	Signal name	
	M system	**L system**
R700 to R999	Computer link interfaces	
R2800 to R2895	PLC constant parameters (corresponds to parameters #6301 to #6348)	
R2900 to R2947	PLC bit selection parameters (corresponds to parameters #6401 to #6496)	
R2950 to R2999	ATC command control information	–
R2970, R2971	–	Tool compensation No. for tool length measurement 2
R3000 to R3719	ATC registration tools	–
R3000 to R3639	–	Life management data ($1, $2)
R3720 to R3735	Life management interfaces	–
R4400 to R4449	Expansion bit selection parameters (corresponds to parameters #6448 to #6596)	
R4900 to R4995	Expansion PLC constant parameters (corresponds to parameters #6349 to #6396)	
R5000 to R5099	Special table interfaces	
R5480 to R6279	–	Tool life management data with spare tool

(7) Other inputs/outputs (X, Y)

Table 4-6-7

Device No.	Signal name
X140 to X15F	PLC switch input 1 to 32
X178 to X17F	Skip input 1 to 8 for monitor
Y160 to Y17F	PLC switch for reversed display 1 to 32

(8) Fixed (semi-fixed) devices

Table 4-6-8

Device No.	Signal name
X108	NC reset Reset is input (Y222, etc.) to the NC based on this signal.
X18 to X1B	Reference position return near-point detection 1 to 4
X20 to X23	Stroke end (–) 1 to 4
X28 to X2B	Stroke end (+) 1 to 4
X5C to X5F	Reference position return near-point detection 5 to 8
X64 to X67	Stroke end (–) 5 to 8
X6C to X6F	Stroke end (+) 5 to 8

(9) Maintenance

Table 4-6-9

Device No.	Signal name
R1850	CRC count (servo #1)
R1851	CRC count (servo #2)
R1852	Address illegal (servo #1)
R1853	Address illegal (servo #2)
R1854	CRC count (display unit)
R1855	Address illegal (display unit)

(10) Software timer

Table 4-6-10

Device No.	Signal name
R1200 to R1224	Expansion timer coil (corresponds to #6600 to #6999)
R1250 to R1274	Expansion timer contact (corresponds to #6600 to #6999)

(11) Spindle related devices

CNC -> PLC (GX Developer) Table 4-6-11

Device No.					
1st sys	2nd sys			Abbrev.	Signal name
X1C4	X504				Power OFF request (spindle regeneration circuit error)
X234	X574			SF1	S function strobe 1
X235	X575			SF2	S function strobe 2
X236	X576			SF3	S function strobe 3
X237	X577			SF4	S function strobe 4
X2A0	X5E0				In polygon mode (Spindle-NC axis)
X2A2	X5E2				In polygon mode (Spindle-Spindle)
X2A3	X5E3				Spindle-spindle polygon synchronization complete
X308	—			SPSYN1	In spindle synchronous control
X309	—			FSPRV	Spindle rotation speed synchronization complete
X30A	—			FSPPH	Spindle phase synchronization complete
X30B	—			SPSYN2	In spindle synchronous control 2 (D)
X30E	—			SPCMP	Chuck close confirmation

Device No.					
1st SP	2nd SP	3rd SP	4th SP	Abbrev.	Signal name
X1D0	X510	XA48	XA68		— —
X1D1	X511	XA49	XA69		— —
X1D5	X515	XA4D	XA6D	SD2	Speed detect 2
X1D6	X516	XA4E	XA6E	MCSA	In M coil selected
X1D7	X517	XA4F	XA6F		Index positioning complete
X20C	X54C	XA40	XA60	SUPP	Spindle rotation speed upper limit over
X20D	X54D	XA41	XA61	SLOW	Spindle rotation speed lower limit over
X214	X554	XA42	XA62	SIGE	S-analog gear No. illegal
X215	X555	XA43	XA63	SOVE	S-analog max./min. command value over
X216	X556	XA44	XA64	SNGE	S-analog no gear selected
X225	X565	XA45	XA65	GR1	Spindle gear shift 1
X226	X566	XA46	XA66	GR2	Spindle gear shift 2
X227	X567	XA47	XA67	—	(Always "0")
X240	X580	XA50	XA70		Spindle 2nd in-position
X241	X581	XA51	XA71	CDO	Current detect
X242	X582	XA52	XA72	VRO	Speed detect
X243	X583	XA53	XA73	FLO	In spindle alarm
X244	X584	XA54	XA74	ZSO	Zero speed
X245	X585	XA55	XA75	USO	Up-to-speed
X246	X586	XA56	XA76	ORAO	Spindle in-position
X247	X587	XA57	XA77	LCSA	In L coil selected
X248	X588	XA58	XA78	SMA	Spindle ready-ON
X249	X589	XA59	XA79	SSA	Spindle servo-ON
X24A	X58A	XA5A	XA7A	SEMG	Spindle emergency stop

Device No.					
1st SP	2nd SP	3rd SP	4th SP	Abbrev.	Signal name
X24B	X58B	XA5B	XA7B	SSRN	Spindle forward run
X24C	X58C	XA5C	XA7C	SSRI	Spindle reverse run
X24D	X58D	XA5D	XA7D		Z-phase passed
X24E	X58E	XA5E	XA7E	SIMP	Position loop in-position
X24F	X58F	XA5F	XA7F	STLQ	Torque limit
X2C8	X608	X940	X950	ENB	Spindle enable
X318	X9D8				In magnetic bearing ready ON
X319	X9D9				In magnetic bearing servo ON
X31C	X9DC				In magnetic bearing warning
X31F	X9DF				In magnetic bearing alarm

— — : Reserved for the system.

CNC -> PLC (PLC4B) Table 4-6-11

Device No.					
1st sys	2nd sys			Abbrev.	Signal name
X1C4	U44				Power OFF request (spindle regeneration circuit error)
X234	UB4			SF1	S function strobe 1
X235	UB5			SF2	S function strobe 2
X236	UB6			SF3	S function strobe 3
X237	UB7			SF4	S function strobe 4
X2A0	U120				In polygon mode (Spindle-NC axis)
X2A2	U122				In polygon mode (Spindle-Spindle)
X2A3	U123				Spindle-spindle polygon synchronization complete
X308	—			SPSYN1	In spindle synchronous control
X309	—			FSPRV	Spindle rotation speed synchronization complete
X30A	—			FSPPH	Spindle phase synchronization complete
X30B	—			SPSYN2	In spindle synchronous control 2 (D)
X30E	—			SPCMP	Chuck close confirmation

Device No.					
1st SP	2nd SP	3rd SP	4th SP	Abbrev.	Signal name
X1D0	U50	S008	S048		— —
X1D1	U51	S009	S049		— —
X1D5	U55	S00D	S04D	SD2	Speed detect 2
X1D6	U56	S00E	S04E	MCSA	In M coil selected
X1D7	U57	S00F	S04F		Index positioning complete
X20C	U8C	S000	S040	SUPP	Spindle rotation speed upper limit over
X20D	U8D	S001	S041	SLOW	Spindle rotation speed lower limit over
X214	U94	S002	S042	SIGE	S-analog gear No. illegal
X215	U95	S003	S043	SOVE	S-analog max./min. command value over
X216	U96	S004	S044	SNGE	S-analog no gear selected

— — : Reserved for the system.

Device No.					
1st SP	2nd SP	3rd SP	4th SP	Abbrev.	Signal name
X225	UA5	S005	S045	GR1	Spindle gear shift 1
X226	UA6	S006	S046	GR2	Spindle gear shift 2
X227	UA7	S007	S047	—	(Always "0")
X240	UC0	S010	S050		Spindle 2nd in-position
X241	UC1	S011	S051	CDO	Current detect
X242	UC2	S012	S052	VRO	Speed detect
X243	UC3	S013	S053	FLO	In spindle alarm
X244	UC4	S014	S054	ZSO	Zero speed
X245	UC5	S015	S055	USO	Up-to-speed
X246	UC6	S016	S056	ORAO	Spindle in-position
X247	UC7	S017	S057	LCSA	In L coil selected
X248	UC8	S018	S058	SMA	Spindle ready-ON
X249	UC9	S019	S059	SSA	Spindle servo-ON
X24A	UCA	S01A	S05A	SEMG	Spindle emergency stop
X24B	UCB	S01B	S05B	SSRN	Spindle forward run
X24C	UCC	S01C	S05C	SSRI	Spindle reverse run
X24D	UCD	S01D	S05D		Z-phase passed
X24E	UCE	S01E	S05E	SIMP	Position loop in-position
X24F	UCF	S01F	S05F	STLQ	Torque limit
X2C8	U148	I300	I310	ENB	Spindle enable
X318	I398				In magnetic bearing ready ON
X319	I399				In magnetic bearing servo ON
X31C	I39C				In magnetic bearing warning
X31F	I39F				In magnetic bearing alarm

CNC → PLC

Device No.					
1st sys	2nd sys			Abbrev.	Signal name
R28	R228				S code data 1
R29	R229				
R30	R230				S code data 2
R31	R231				
R32	R232				S code data 3
R33	R233				
R34	R234				S code data 4
R35	R235				
R474	—				Spindle synchronous control Phase error output
R475	—				Spindle synchronous control Phase error 1 (degree) (including shift calc.)
R476	—				Spindle synchronous control Phase error 2 (degree) (excluding shift calc.)
R477	—				Spindle synchronous control Phase error monitor
R478	—				Spindle synchronous control (lower limit) Phase error monitor
R479	—				Spindle synchronous control (upper limit) Phase error monitor
R490	—				Spindle synchronous control Phase offset data

Device No.					
1st SP	2nd SP	3rd SP	4th SP	Abbrev.	Signal name
R8	R208	R4500	R4520		Spindle command rotation speed input
R9	R209	R4501	R4521		
R10	R210	R4502	R4522		Spindle command final data (rotation speed)
R11	R211	R4503	R4523		
R12	R212	R4504	R4524		Spindle command final data (12-bit binary)
R13	R213	R4505	R4525		
R18	R218	R4506	R4526		Spindle actual speed
R19	R219	R4507	R4527		

PLC → CNC (GX Developer)

Device No.					
1st sys	2nd sys			Abbrev.	Signal name
Y1FC	Y5BC				Spindle orientation complete standby valid (ATC high-speed)
Y2E8	—			SPSYC	Spindle synchronous control cancel
Y2E9	—			SPCMPC	Chuck close
Y359	Y719				Spindle-spindle polygon cancel
Y35A	Y71A				Synchronized tapping command polarity reversal
Y382	YCC2				Door open signal input (spindle speed monitor)
Y383	YCC3				Door interlock spindle speed clamp
Y398	—			SPSY	Spindle synchronous control
Y399	—			SPPHS	Spindle phase synchronous control
Y39A	—				Spindle synchronous rotation direction
Y39B	—			SSPHM	Phase shift calculation request
Y39C	—			SSPHF	Phase offset request
Y39D	—			SRDRPO	Error temporary cancel

Device No.					
1st SP	2nd SP	3rd SP	4th SP	Abbrev.	Signal name
Y225	Y5E5	YD48	YD58	GFIN	Gear shift complete
Y288	Y648	YD80	YDA0	SP1	Spindle override 1
Y289	Y649	YD81	YDA1	SP2	Spindle override 2
Y28A	Y64A	YD82	YDA2	SP4	Spindle override 4
Y28F	Y64F	YD87	YDA7	SPS	Spindle override method select
Y290	Y650	YD88	YDA8	GI1	Spindle gear select 1
Y291	Y651	YD89	YDA9	GI2	Spindle gear select 2
Y292	Y652	YD8A	YDAA	—	(Always "0")
Y294	Y654	YD8C	YDAC	SSTP	Spindle stop
Y295	Y655	YD8D	YDAD	SSFT	Spindle gear shift
Y296	Y656	YD8E	YDAE	SORC	Oriented spindle speed command
Y2D0	Y690	YD90	YDB0	SRN	Spindle forward run start
Y2D1	Y691	YD91	YDB1	SRI	Spindle reverse run start
Y2D2	Y692	YD92	YDB2	TL1	Torque limit 1
Y2D3	Y693	YD93	YDB3	TL2	Torque limit 2
Y2D4	Y694	YD94	YDB4	WRN	Spindle forward run index
Y2D5	Y695	YD95	YDB5	WRI	Spindle reverse run index
Y2D6	Y696	YD96	YDB6	ORC	Spindle orient command
Y2D7	Y697	YD97	YDB7	LRSL	L coil selection
Y2DA	Y69A	YD9A	YDBA		C axis gain L
Y2DB	Y69B	YD9B	YDBB		C axis gain H
Y2DC	Y69C	YD9C	YDBC		C axis zero point return
Y2DE	Y69E	YD9E	YDBE	LRSM	M coil selection
Y350	Y710	YD40	YD50	SWS	Spindle selection
Y357	Y717	YD47	YD57	MPCSL	PLC coil changeover

Device No.					
1st SP	2nd SP	3rd SP	4th SP	Abbrev.	Signal name
Y388	YCC8				Magnetic bearing servo ON command
Y389	YCC9				Magnetic bearing tool clamp
Y38A	YCCA				— —
Y38B	YCCB				— —
Y38C	YCCC				— —
Y38D	YCCD				— —
Y38E	YCCE				— —
Y38F	YCCF				— —

PLC → CNC (PLC4B)

Device No.					
1st sys	2nd sys			Abbrev.	Signal name
Y1FC	W7C				Spindle orientation complete standby valid (ATC high-speed)
Y2E8	—			SPSYC	Spindle synchronous control cancel
Y2E9	—			SPCMPC	Chuck close
Y359	W1D9				Spindle-spindle polygon cancel
Y35A	W1DA				Synchronized tapping command polarity reversal
Y382	J582				Door open signal input (spindle speed monitor)
Y383	J583				Door interlock spindle speed clamp
Y398	—			SPSY	Spindle synchronous control
Y399	—			SPPHS	Spindle phase synchronous control
Y39A	—				Spindle synchronous rotation direction
Y39B	—			SSPHM	Phase shift calculation request
Y39C	—			SSPHF	Phase offset request
Y39D	—			SRDRPO	Error temporary cancel

Device No.					
1st SP	2nd SP	3rd SP	4th SP	Abbrev.	Signal name
Y225	WA5	J608	J618	GFIN	Gear shift complete
Y288	W108	S020	S060	SP1	Spindle override 1
Y289	W109	S021	S061	SP2	Spindle override 2
Y28A	W10A	S022	S062	SP4	Spindle override 4
Y28F	W10F	S027	S067	SPS	Spindle override method select
Y290	W110	S028	S068	GI1	Spindle gear select 1
Y291	W111	S029	S069	GI2	Spindle gear select 2
Y292	W112	S02A	S06A	—	(Always "0")
Y294	W114	S02C	S06C	SSTP	Spindle stop
Y295	W115	S02D	S06D	SSFT	Spindle gear shift
Y296	W116	S02E	S06E	SORC	Oriented spindle speed command
Y2D0	W150	S030	S070	SRN	Spindle forward run start
Y2D1	W151	S031	S071	SRI	Spindle reverse run start
Y2D2	W152	S032	S072	TL1	Torque limit 1
Y2D3	W153	S033	S073	TL2	Torque limit 2

Device No.					
1st SP	2nd SP	3rd SP	4th SP	Abbrev.	Signal name
Y2D4	W154	S034	S074	WRN	Spindle forward run index
Y2D5	W155	S035	S075	WRI	Spindle reverse run index
Y2D6	W156	S036	S076	ORC	Spindle orient command
Y2D7	W157	S037	S077	LRSL	L coil selection
Y2DA	W15A	S03A	S07A		C axis gain L
Y2DB	W15B	S03B	S07B		C axis gain H
Y2DC	W15C	S03C	S07C		C axis zero point return
Y2DE	W15E	S03E	S07E	LRSM	M coil selection
Y350	W1D0	J600	J610	SWS	Spindle selection
Y357	W1D7	J607	J617	MPCSL	PLC coil changeover
Y388	J588				Magnetic bearing servo ON command
Y389	J589				Magnetic bearing tool clamp
Y38A	J58A				— —
Y38B	J58B				— —
Y38C	J58C				— —
Y38D	J58D				— —
Y38E	J58E				— —
Y38F	J58F				— —

PLC → CNC

Device No.					
1st Sys	2nd Sys			Abbrev.	Signal name
R124	R324				Encoder selection
R446	—				Spindle synchronous control Basic spindle select
R447	—				Synchronous spindle select
R448	—				Phase shift amount

Device No.					
1st SP	2nd SP	3rd SP	4th SP	Abbrev.	Signal name
R108	R308	R4600	R4620		Spindle command rotation speed output
R109	R309	R4601	R4621		
R110	R310	R4606	R4626	SLSP	Spindle command selection
R148	R348	R4604	R4624		S analog override
R149	R349	R4605	R4625		Multi-point orientation position data

5. OTHER DEVICES

5.1 Devices

In addition to U, Y, W, E, and R devices described above, the following devices exist:

Name	Symbol	Description
Internal relay Latch relay	M G F L	(1) Internal and latch relays are auxiliary relays in the sequence that cannot directly be output to the external. (2) The latch relay L will be backed up even if the power is turned OFF. (3) The internal relay F may be used as the interface for the alarm message display.
Timer	T Q	(1) Timers T and Q are count-up timers. (2) Timer T can set the timer value for either the sequence program or setting and display unit. Timer Q can set the timer value setting only from the sequence program. (3) The 100ms, 10ms and 100ms integral timer are available.
Counter	C B	(1) Addition system counter C and B. (2) Counter C can set the counter value for either the sequence program or setting and display unit. Counter B can set the counter value only from the sequence program.
Data register	D	(1) The data register stores sequence data. (2) One data register consists of 16 bits and can be read or written in 16-bit units. To handle 32-bit data, two data registers are used. The data register addressed by a 32-bit instruction is used as the low-order 16 bits; the data register addressed by the specified data register number +1 is used as the high-order 16 bits.
File register	R	(1) The file register release area can be used in the same manner as the data register. (2) The file register uses a 16-bit structure for 1 point, and reads and writes in 16-bit units. Two points are used to handle 32-bit data. The file register No. designated with the 32-bit command is the low-order 16-bit, and the designated file register plus one is the high-order 16-bit.

The assignment tables for the above tables are on the following pages. Copy and use them as necessary.

<Format 1>

<Internal relay>

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
M			M		
M			M		
M			M		
M			M		
M			M		
M			M		
M			M		
M			M		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
M			M		
M			M		
M			M		
M			M		
M			M		
M			M		
M			M		
M			M		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
M			M		
M			M		
M			M		
M			M		
M			M		
M			M		
M			M		
M			M		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
M			M		
M			M		
M			M		
M			M		
M			M		
M			M		
M			M		
M			M		

<Format 2>

<Internal relay>

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
G			G		
G			G		
G			G		
G			G		
G			G		
G			G		
G			G		
G			G		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
G			G		
G			G		
G			G		
G			G		
G			G		
G			G		
G			G		
G			G		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
G			G		
G			G		
G			G		
G			G		
G			G		
G			G		
G			G		
G			G		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
G			G		
G			G		
G			G		
G			G		
G			G		
G			G		
G			G		
G			G		

<Format 3>

<Internal relay>

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
F			F		
F			F		
F			F		
F			F		
F			F		
F			F		
F			F		
F			F		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
F			F		
F			F		
F			F		
F			F		
F			F		
F			F		
F			F		
F			F		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
F			F		
F			F		
F			F		
F			F		
F			F		
F			F		
F			F		
F			F		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
F			F		
F			F		
F			F		
F			F		
F			F		
F			F		
F			F		
F			F		

<Format 4>

<Latch relay>

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
L			L		
L			L		
L			L		
L			L		
L			L		
L			L		
L			L		
L			L		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
L			L		
L			L		
L			L		
L			L		
L			L		
L			L		
L			L		
L			L		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
L			L		
L			L		
L			L		
L			L		
L			L		
L			L		
L			L		
L			L		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
L			L		
L			L		
L			L		
L			L		
L			L		
L			L		
L			L		
L			L		

<Format 5>

<Timer>

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		

<Format 6>

<Timer numerical value setting data output> 16-bit unit

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		
T			T		

<Format 7>

<Timer>

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		

<Format 8>

<Timer numerical value setting data output> 16-bit unit

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
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Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		
Q			Q		

<Format 9>

<Counter>

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
C0			C8		
C1			C9		
C2			C10		
C3			C11		
C4			C12		
C5			C13		
C6			C14		
C7			C15		
Device	**Abbreviation**	**Signal name**	**Device**	**Abbreviation**	**Signal name**
C16					
C17					
C18					
C19					
C20					
C21					
C22					
C23					

<Format 10>

<Counter numerical value setting data> 16-bit unit

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
C0			C8		
C1			C9		
C2			C10		
C3			C11		
C4			C12		
C5			C13		
C6			C14		
C7			C15		
Device	**Abbreviation**	**Signal name**	**Device**	**Abbreviation**	**Signal name**
C16					
C17					
C18					
C19					
C20					
C21					
C22					
C23					

<Format 11>

<Counter>

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
B0			B8		
B1			B9		
B2			B10		
B3			B11		
B4			B12		
B5			B13		
B6			B14		
B7			B15		
Device	**Abbreviation**	**Signal name**	**Device**	**Abbreviation**	**Signal name**
B16					
B17					
B18					
B19					
B20					
B21					
B22					
B23					

<Format 12>

<Counter numerical value setting data> 16-bit unit

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
B0			B8		
B1			B9		
B2			B10		
B3			B11		
B4			B12		
B5			B13		
B6			B14		
B7			B15		
Device	**Abbreviation**	**Signal name**	**Device**	**Abbreviation**	**Signal name**
B16					
B17					
B18					
B19					
B20					
B21					
B22					
B23					

<Format 13>

<Data register>

16-bit unit

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
D			D		
D			D		
D			D		
D			D		
D			D		
D			D		
D			D		
D			D		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
D			D		
D			D		
D			D		
D			D		
D			D		
D			D		
D			D		
D			D		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
D			D		
D			D		
D			D		
D			D		
D			D		
D			D		
D			D		
D			D		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
D			D		
D			D		
D			D		
D			D		
D			D		
D			D		
D			D		
D			D		

<Format 14>

<File register>

16-bit unit

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
R			R		
R			R		
R			R		
R			R		
R			R		
R			R		
R			R		
R			R		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
R			R		
R			R		
R			R		
R			R		
R			R		
R			R		
R			R		
R			R		

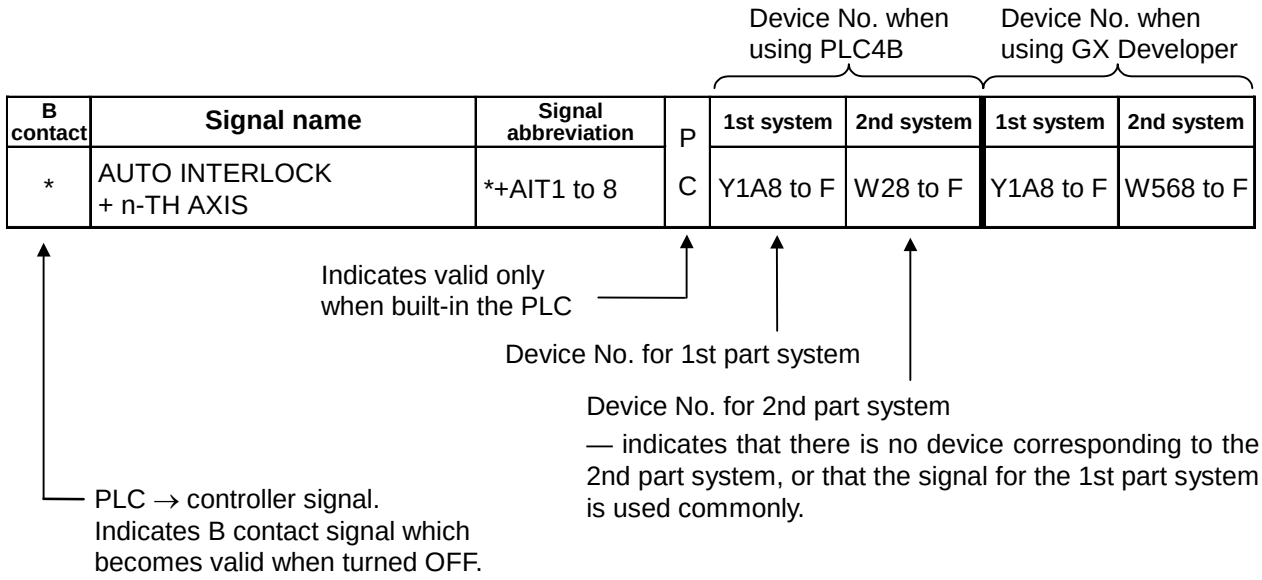
Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
R			R		
R			R		
R			R		
R			R		
R			R		
R			R		
R			R		
R			R		

Device	Abbreviation	Signal name	Device	Abbreviation	Signal name
R			R		
R			R		
R			R		
R			R		
R			R		
R			R		
R			R		
R			R		

6. EXPLANATION OF INTERFACE SIGNALS

The signals are explained in order of the tables of input/output signals with the controller as shown below.

How to read the signals



6.1 PLC Input Signals (Bit Type: X***)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SERVO READY nTH AXIS	RDY1 to 8	—	X180 to 7	U0 to 7	X180 to 7	X4C0 to 7

[Function]

This signal indicates that the drive section of the n-th axis is ready for operation.

[Operation]

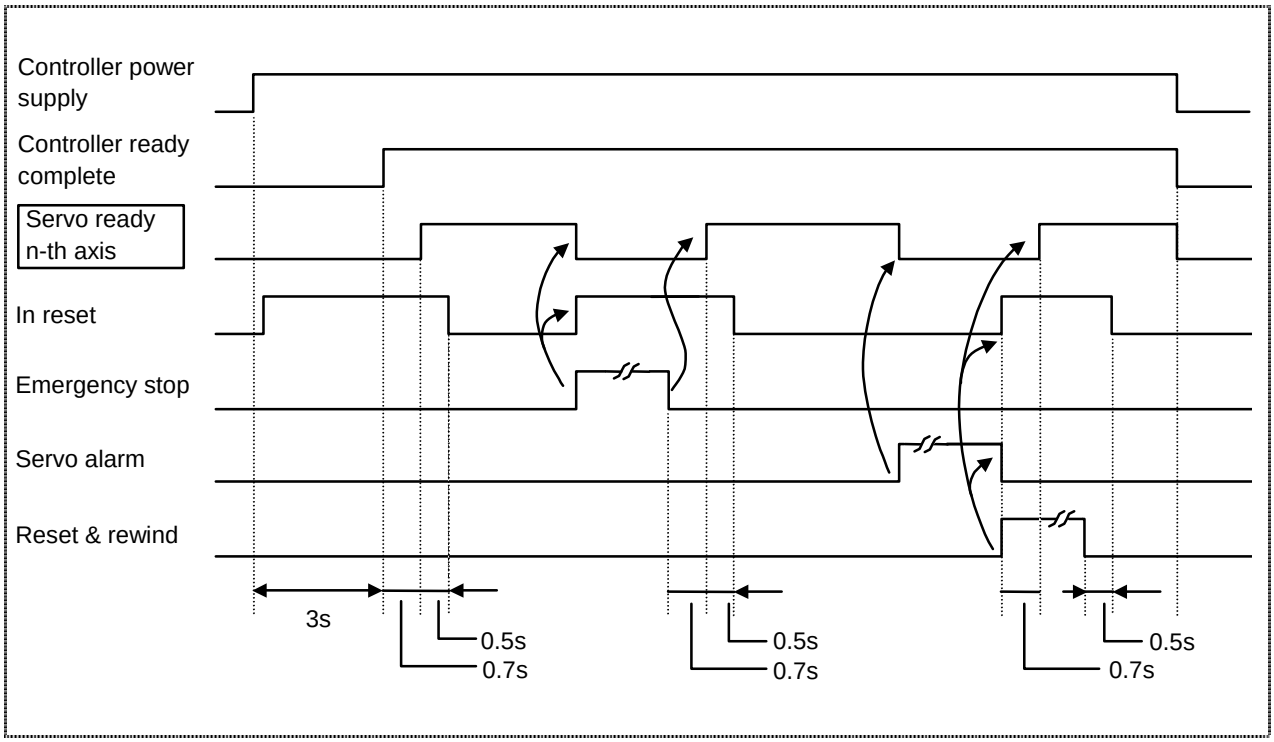
The signal turns ON when:

(1) The power supply of the controller is turned ON and the diagnosis on the servo system has been completed successfully.
(2) Servo alarm has been reset.
(3) Emergency stop has been reset.
(4) "Servo off" signal is reset.

The signal turns OFF when:

(1) Servo alarm occurs.
(2) Emergency stop is issued.
(3) "Servo off" signal is input.

[Operation sequence]



[Related signal]

(1) Servo ready complete (SA: X1F1)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	AXIS SELECTED nTH AXIS	AX1 to 8	—	X188 to F	U8 to F	X188 to F	X4C8 to F

[Function]

This signal indicates that motion command is issued to the control axis.

[Operation]

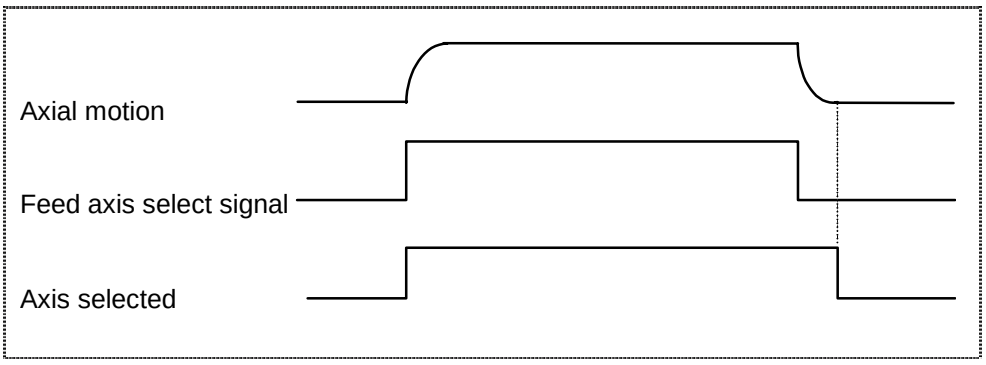
This signal turns ON and OFF as follows:

(1) Automatic operation
The signal is ON while the motion command is issued to the end of movement, or to when automatic operation pause turns ON.

(2) Manual operation
(a) For JOG mode
The signal is ON while "Feed axis select" signal (+Jn and -Jn) is ON.
(b) For HANDLE mode
When "Handle axis No." signal (HS11 to 116, HS21 to 216, HS31 to 316) and "Handle valid" signal (HS1S, HS2S, HS3S) have been selected, the "Axis selected" signal for the axis specified by the "Handle axis No." signal is ON.
(c) For INCREMENTAL mode
The signal turns ON when "Feed axis select" signal turns ON, and turns OFF when the specified motion is completed.
(d) For MANUAL RANDOM FEED mode
The signal turns ON when "Strobe" signal (CXS8) turns ON, and turns OFF when the specified motion is completed. Even when "Stop" signal (CXS7) is turned OFF (0) during motion, the axis select output signal remains ON.
(e) For REFERENCE POSITION RETURN mode
The signal is ON while "Feed axis select" signal (+Jn and -Jn) is ON. After "Reference position return near point detect" signal is detected, and the motion speed changes to approach (creeping) speed, the "Axis selected" signal remains ON until the motion stops at the reference position, even when "Feed axis select" signal turns OFF.

(3) Other conditions
(a) The signal can turn ON even during machine lock (Z-axis is in cancellation). However, it does not turn ON during machine lock in manual operation mode.
(b) The signal remains on even when motion stops due to feedrate override set at 0%, manual control feedrate set at 0 mm/min, or 0 inch/min.
(c) Interlock does not affect status of this signal (the signal remains ON, or turns ON).
(d) "Servo off" signal does not affect status of this signal.
(e) The signal cannot be turned ON by G04 and G92.
(f) The signal turns OFF with "controller Reset & Rewind", or "Emergency stop".

(Example)



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN PLUS MOTION +nTH AXIS	MVP1 to 8	PC	X190 to 7	U10 to 7	X190 to 7	X4D0 to 7

[Function]

This signal indicates that the specified axial motion is in plus (+) direction.
This signal is available per control axis, and the last number of the signal name indicates the control axis No.

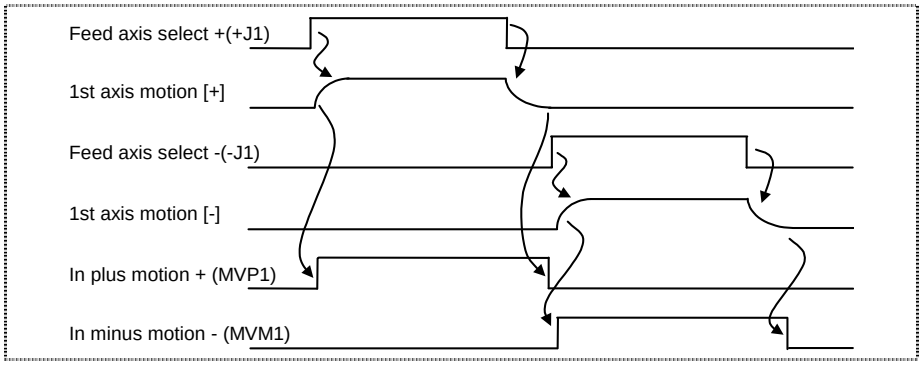
M V P n
- n: 1: 1st axis in motion
  :
  :
  8: 8th axis in motion
- P: In motion to plus direction
- M: In motion to minus direction

[Operation]

The signal turns ON when:
(1) The specified axial component starts moving in the plus direction or when moving.

The signal turns OFF when:
(2) The specified control axis stops moving or moves in the minus direction.

An example of the time chart for the jog mode is shown below.



(Note 1) This signal operates regardless of the operation mode.
(Note 2) The real movement direction is indicated.
(Note 3) The signal does not turn ON during machine lock.

[Related signals]

In minus motion –nth axis (MVM1 to 8: X198 to 19F)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN MINUS MOTION -nTH AXIS	MVM 1 to 8	PC	X198 to F	U18 to F	X198 to F	X4D8 to F

[Function]

This signal indicates that the control axis is moving in the minus direction.

[Operation]

This motion direction is the reverse of the plus motion, and the operation is the same as IN PLUS MOTION + (MVPn).

[Related signals]

In plus motion +nth axis (MVP1 to 8: X190 to 197)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	1ST REFERENCE POSITION REACHED, nTH AXIS	ZP11 to 18	—	X1A0 to 7	U20 to 7	X1A0 to 7	X4E0 to 7

[Function]

This signal indicates that the axial component of the n-th axis is ON the 1st reference position.
This signal is available per control axis, and the last number of the signal name indicates the control axis No.

ZP1n
- 1: 1st reference position reached, 1st axis
- :
- :
- 8: 1st reference position reached, 8th axis

[Operation]

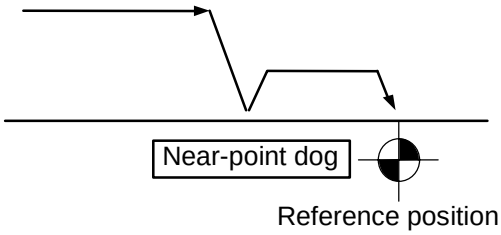
(1) The signal turns ON when:
- "1st reference position reached" is attained with reference position return mode in manual operation.
  Refer to the REFERENCE POSITION RETURN (ZRN) section for details on returning.
- "1st reference position reached" is attained with G28 command in automatic operation.

(Note) If "1st reference position reached" is achieved in other operation mode, or by other command, the signal does not turn ON.

(2) The signal turns OFF when:
- The axial component in position is relocated from the 1st reference position by motion command.
- "Emergency stop" signal is input or servo alarm occurs, causing stop to the machine.

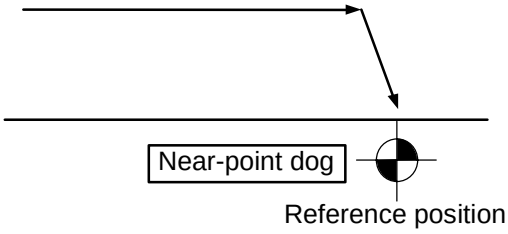
(3) Reference position return operation pattern

○ Dog-type reference position return



- When basic machine coordinate system is not established.
- When dog-type return is selected with setup parameters, basic specification parameter "#1063 mandog" in the manual mode.

○ High-speed reference position return



- When basic machine coordinate system is not established.
- When high-speed return is selected with setup parameters, basic specification parameter "#1063 mandog" in the manual mode.

Note)
Reference position return will be the high-speed return when the basic machine coordinate system is established (2nd time and following).

[Related signals]

2nd reference position reached nth axis (ZP21 to 28: X1A8 to 1AF)
3rd reference position reached nth axis (ZP31 to 38: X1B0 to 1B7)
4th reference position reached nth axis (ZP41 to 48: X1B8 to 1BF)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	2ND REFERENCE POSITION REACHED, nTH AXIS	ZP21 to 28	—	X1A8 to F	U28 to F	X1A8 to F	X4E8 to F

[Function]

This signal indicates that the axial component of the nth axis is on the 2nd reference position.
This signal is available per control axis, and the last number of the signal name indicates the control axis No.

ZP2n
- 1: 2nd reference position reached, 1st axis
- :
- :
- 8: 2nd reference position reached, 8th axis

[Operation]

(1) The signal turns ON when:
- "2nd reference position reached" is attained with G30 command in automatic operation.

(Note) If "2nd reference position reached" is achieved in other operation mode, or by other command, the signal does not turn ON.

(2) The signal turns OFF when:
- The axial component in position is relocated from the 1st reference position by motion command.
- "Emergency stop" signal is input or servo alarm occurs, causing stop to the machine.

[Related signals]

1st reference position reached nth axis (ZP11 to 18: X1A0 to 1A7)
3rd reference position reached nth axis (ZP31 to 38: X1B0 to 1B7)
4th reference position reached nth axis (ZP41 to 48: X1B8 to 1BF)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	3RD REFERENCE POSITION REACHED, n-TH AXIS	ZP31 to 38	PC	X1B0 to 7	U30 to 7	X1B0 to 7	X4F0 to 7

[Function] [Operation]

The function and operation of this signal are the same as those of "2nd reference position reached" signal, except for 2nd and 3rd reference positions and G command (G30P3 is used instead of G30P2 Xx Yy ...).
Refer to the section of "2nd reference position reached".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	4TH REFERENCE POSITION REACHED, n-TH AXIS	ZP41 to 48	PC	X1B8 to F	U38 to F	X1B8 to F	X4F8 to F

[Function] [Operation]

The function and operation of this signal are the same as those of "2nd reference position reached" signal, except for 2nd and 4th reference positions and G command (G30P4 is used instead of G30P2 Xx Yy ...).
Refer to the section of "2nd reference position reached".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SEARCH & START (error)	SSE	PC	X1C2	U42	X1C2	X502

[Function]

This signal is output when the program No. to be searched with search & start is illegally designated.

[Operation]

This signal is output when the No. of the program to be searched with search & start is illegal. Automatic operation start will not be carried out if this signal is output. This signal will turn OFF if the program No. is correctly input and search & start is executed again, or when the reset signal is issued.
Refer to the "Search & start" signal (RSST) for details.

[Related signals]

Search & start (RSST: Y1FA)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SEARCH & START (search)	SSG	PC	X1C3	U43	X1C3	X503

[Function]

This signal is output when searching for a program with search & start.

[Operation]

Informs the PLC that the NC is searching for the program with search & start.
Hold the search & start signal until the search & start (search) signal turns ON.
If the No. of the program to be searched is illegal, the search & start (error) signal (SSE) will be output.

[Related signals]

(1) Search & start program No. (R170/171)
(2) Search & start (error) (SSE: X1C2)
(3) Search & start (RSST: Y1FA)

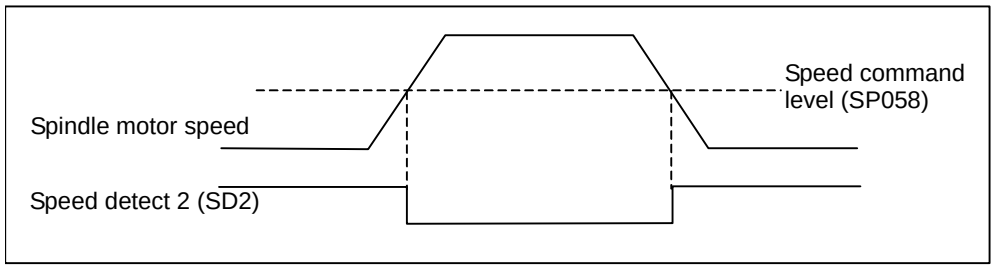
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPEED DETECT 2	SD2	P C	X1D5	U55	X1D5	X515

[Function]

This signal is output from the high-speed serial connection specification spindle controller (spindle drive) and informs that motor speed is dropped below the speed specified by the parameter.

[Operation]

This signal (SD2) turns ON if the motor speed (motor rotation speed) drops the detection level specified by the parameter "#3258 SP058 (2nd speed detection speed)".



(Note 1) This signal is valid only with the system that is high-speed serial connection with the spindle controller.

[Related signals]

Speed detect (VRO: X242)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	IN M COIL SELECTED	MCSA	P C	X1D6	U056	X1D6	X516

[Function]

This signal indicates that the middle-speed coil is being selected in the 3-step coil changeover specification of the spindle coil changeover function.

[Operation]

The state of the selected coil is combined with the "In L coil selected" (LCSA), and that is output.

Selected coil	L coil selection (LRSL)	M coil selection (LRSM)	In L coil selected (LCSA)	In M coil selected (MCSA)
High-speed (H)	OFF	OFF	OFF	OFF
Middle-speed (M)	OFF	ON	OFF	ON
Low-speed (L)	ON	OFF	ON	OFF
	ON	ON	ON	ON

[Related signals]

L coil selection (LRSL: Y2D7)
M coil selection (LRSM: Y2DE)
In L coil selected (LCSA: X247)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	INDEX POSITIONING COMPLETE		P C	X1D7	U57	X1D7	X517

[Function]

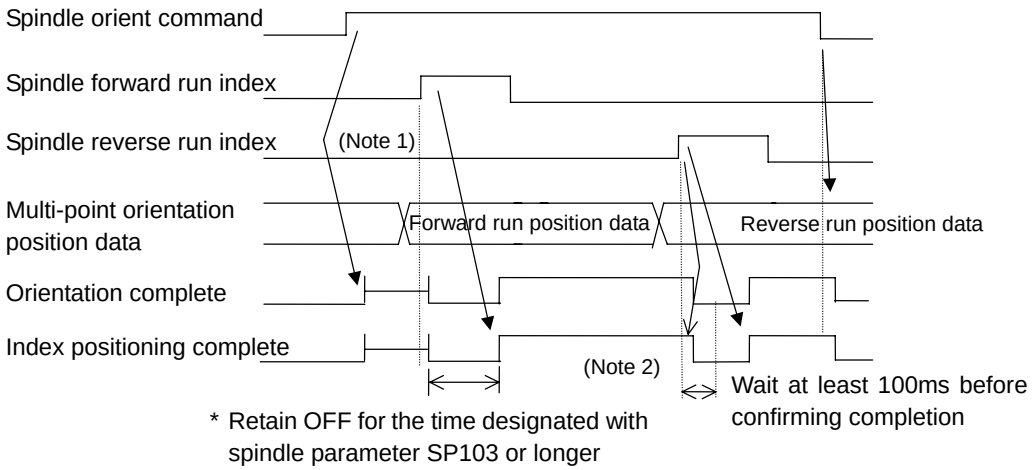
This signal informs that positioning for the spindle forward run and reverse run indexing functions has been completed.

[Operation]

(1) Orient the spindle.
If values are set in the parameters and multi-point orientation position data at this time, the spindle will be positioned to an angle shifted by the amount obtained by adding the two values.
If there is multi-point orientation position data during orientation, the spindle will be positioned to the angle shifted by that amount during forward run/reverse run indexing.
The basic orientation shift is carried out with parameters.

(2) Next, carry out positioning to an arbitrary angle using the forward run/reverse run indexing function.
At this time, set the angle data before turning the "Spindle forward run/reverse run index" signal ON. (Note 1)
The "Index positioning complete" signal will turn OFF when forward run/reverse run is started (turned ON), but it will take some time for the signal to turn OFF once, wait at least 100ms before confirming that the index positioning is completed after forward run/reverse run is completed. (Note 2)

(3) If the spindle orientation holding torque forces are overlapped, the torque limit function will be used.
An example of the turret control timing is shown below.



[Related signals]

Spindle orient command (ORC: Y2D6)
Spindle forward run index (WRN: Y2D4)
Spindle reverse run index (WRI: Y2D5)
Multi-point orientation position data (R149)

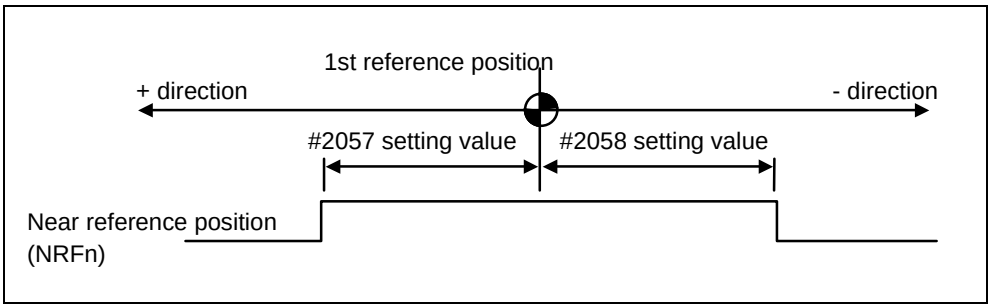
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	NEAR REFERENCE POSITION nTH AXIS	NRF1 to 8	P C	X1D8 to F	U58 to F	X1D8 to F	X518 to F

[Function]

This signal indicates that the control axis is near the 1st reference position in the absolute position detection system.

[Operation]

This signal turns ON when the control axis is in the range of the parameter set using the 1st reference position as a base point, and turns OFF when the range is exceeded. The parameter is set with #2057 (nrefp) and #2058 (nrefn) in the [ABS. POSI PARAM] screen.



(Note 1) The "Near reference position" signal is output even while the axis is moving, but there may be a slight deviation with the actual machine position.
Rapid traverse : Approx. 19mm at 20m/min.
Cutting feed : Approx. 9.5mm at 10m/min.

(Note 2) This signal is valid only with the absolute position detection system.

(Note 3) When 0 is set for #2057 (nrefp) and #2058 (nrefn) in the [ABS. POSI PARAM] screen, it will be same as when the grid width is set.

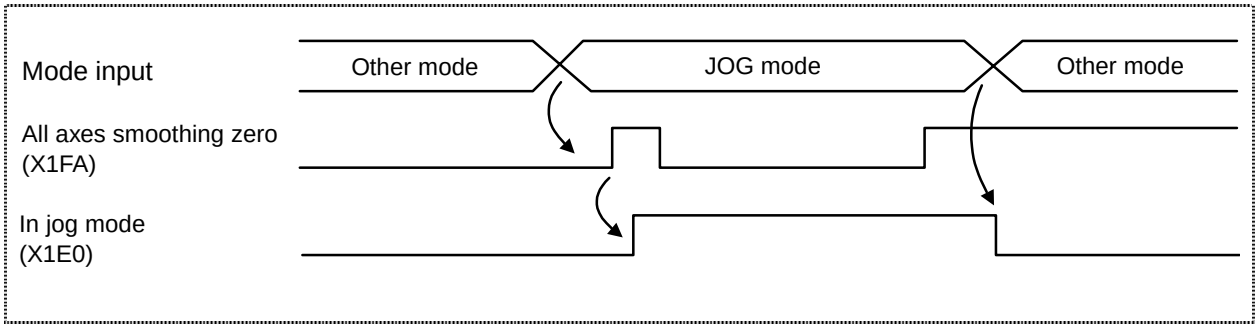
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN JOG MODE	JO	PC	X1E0	U60	X1E0	X520

[Function]

This signal indicates that JOG mode is selected.

[Operation]

Mode is changed to JOG mode from other mode after "All axes smoothing zero" (command acceleration/deceleration delay is zero) is verified.



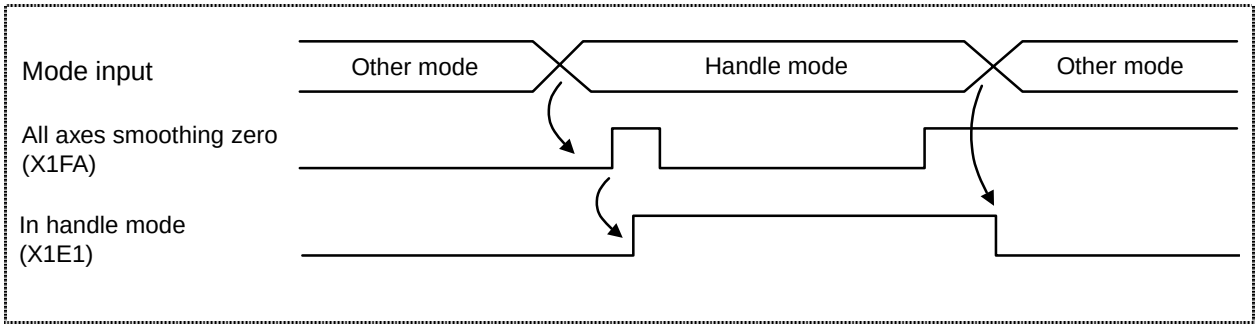
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN HANDLE MODE	HO	PC	X1E1	U61	X1E1	X521

[Function]

This signal indicates that HANDLE mode is selected.

[Operation]

Mode is changed to HANDLE mode from other mode after "All axes smoothing zero" (command acceleration/deceleration delay is zero) is verified.



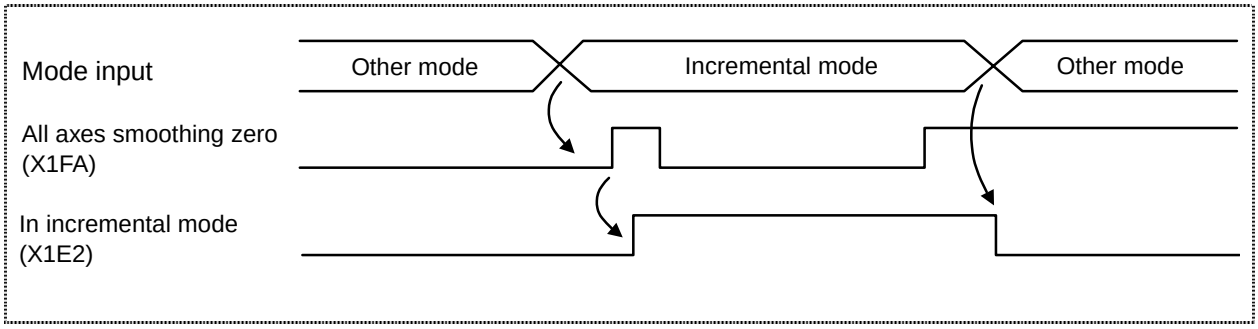
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN INCREMENTAL MODE	SO	PC	X1E2	U62	X1E2	X522

[Function]

This signal indicates that INCREMENTAL mode is selected.

[Operation]

Mode is changed to INCREMENTAL mode from other mode after "All axes smoothing zero" (command acceleration/deceleration delay is zero) is verified.



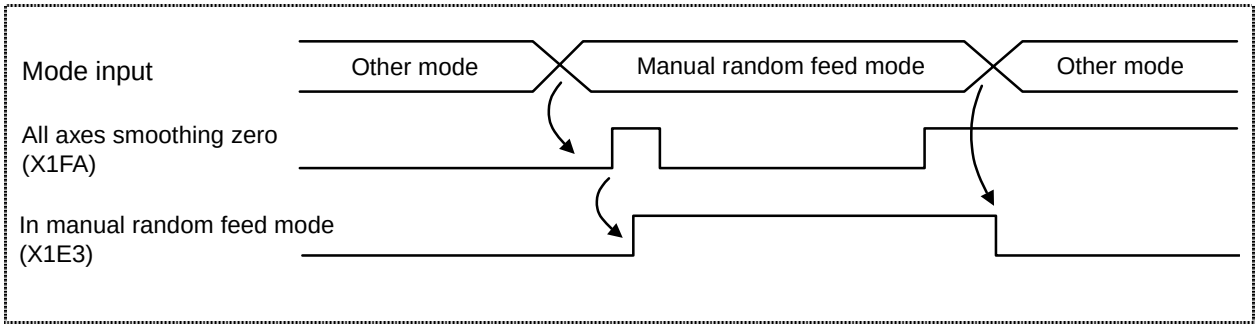
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN MANUAL RANDOM FEED MODE	PTPO	PC	X1E3	U63	X1E3	X523

[Function]

This signal indicates that MANUAL RANDOM FEED mode is selected.

[Operation]

Mode is changed to MANUAL RANDOM FEED mode from other mode after "All axes smoothing zero" (command acceleration/deceleration delay is zero) is verified.



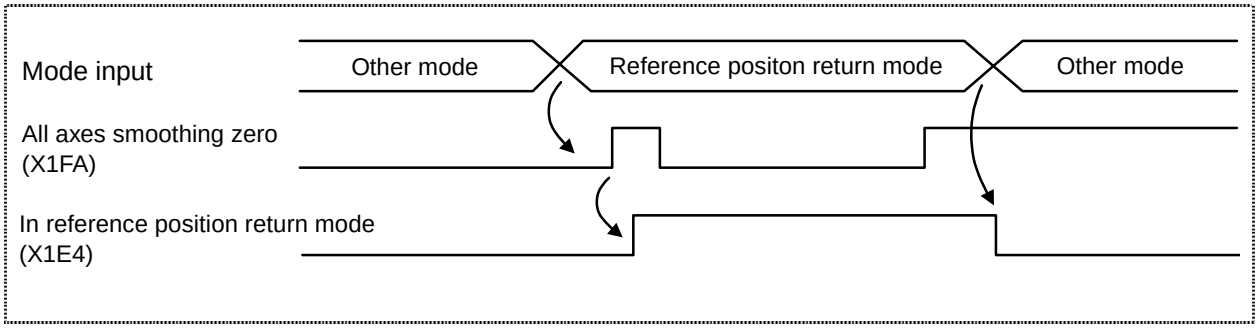
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN REFERENCE POSITION RETURN MODE	ZRNO	P C	X1E4	U64	X1E4	X524

[Function]

This signal indicates that REFERENCE POSITION RETURN mode is selected.

[Operation]

Mode is changed from other mode to REFERENCE POSITION RETURN mode after "All axes smoothing zero" (command acceleration/deceleration delay is zero) has been verified.



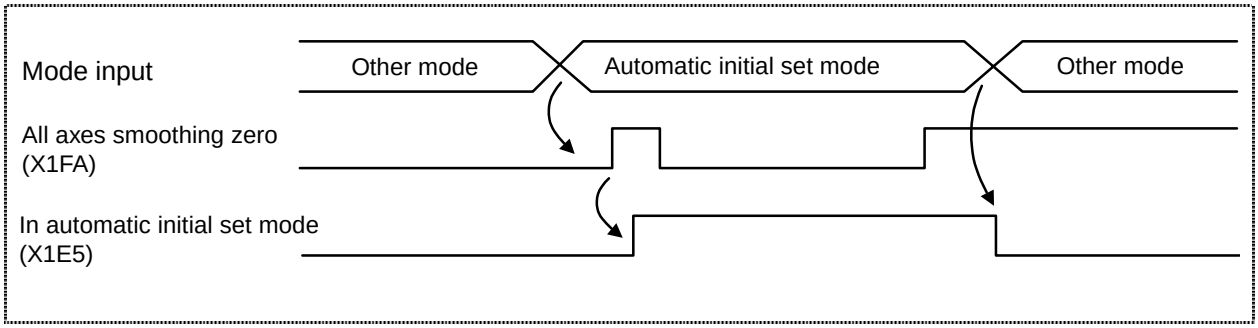
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN AUTOMATIC INITIAL SET MODE	ASTO	P C	X1E5	U65	X1E5	X525

[Function]

This signal indicates that AUTOMATIC INITIAL SET MODE is selected.

[Operation]

Mode is changed over from other mode to IN AUTOMATIC INITIAL SET MODE mode after "All axes smoothing zero" (command acceleration/deceleration delay is zero) has been verified.



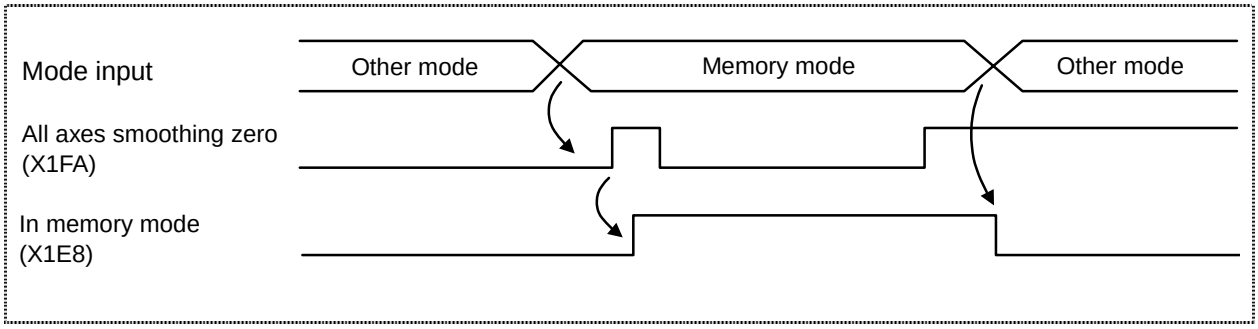
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN MEMORY MODE	MEMO	P C	X1E8	U68	X1E8	X528

[Function]

This signal indicates that MEMORY mode is selected.

[Operation]

Mode is changed from other mode to MEMORY mode after "All axes smoothing zero" (command acceleration/deceleration delay is zero) is verified.



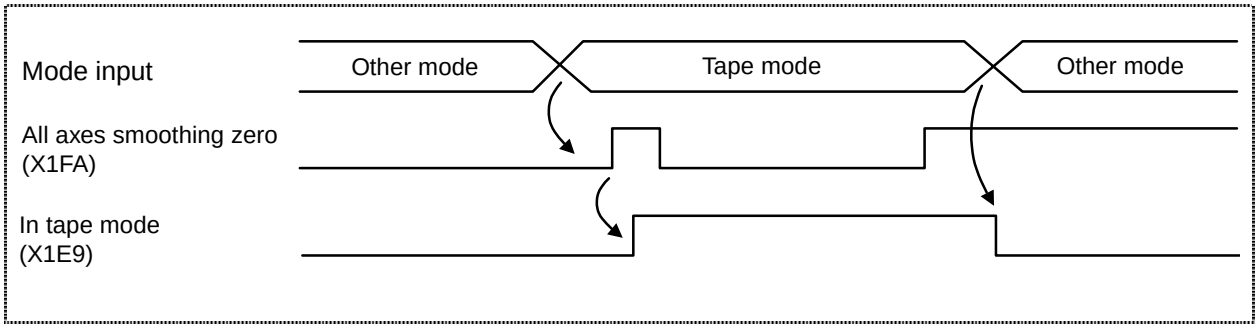
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN TAPE MODE	TO	P C	X1E9	U69	X1E9	X529

[Function]

This signal indicates TAPE mode is selected.

[Operation]

Mode is changed from other mode to TAPE mode when "All axes smoothing zero" (command acceleration/deceleration delay is zero) occurs.



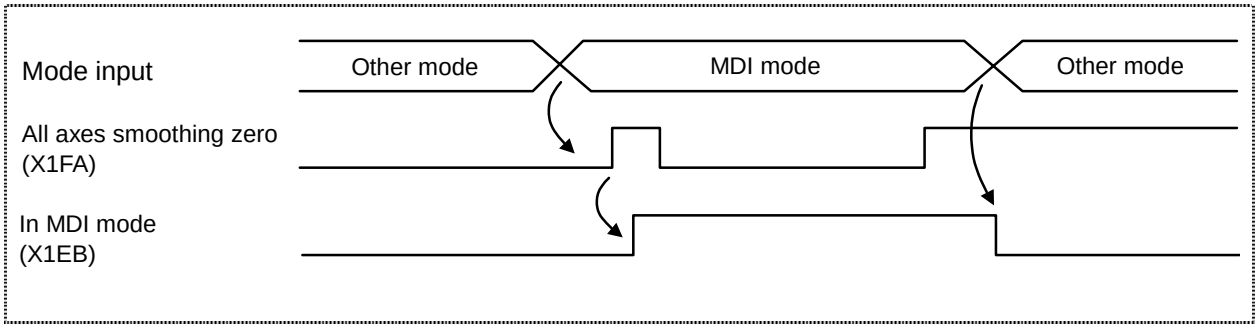
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN MDI MODE	DO	P C	X1EB	U6B	X1EB	X52B

[Function]

This signal indicates that MDI mode is selected.

[Operation]

Mode is changed from other mode to MDI mode when "All axes smoothing zero" (command acceleration/deceleration delay is zero) occurs.



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	CONTROLLER READY COMPLETE	MA	—	X1F0	U70	X1F0	X530

[Function]

This signal indicates that the controller is ready for normal operation.

[Operation]

The signal turns ON when:

(1) The controller starts working successfully after it is turned ON or when no off-condition exists.

The signal turns OFF when:

(1) The controller is turned OFF.
(2) Trouble occurs with the controller (such as failure in the CPU, memory, etc.).
(3) "Servo alarm" which cannot be reset without turning OFF the power supply of the controller occurs.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SERVO READY COMPLETE	SA	—	X1F1	U71	X1F1	X531

[Function]

This signal indicates that the servo system is ready for normal operation. In other words, the servo system (position control) is not working when the signal is OFF.

[Operation]

The signal turns ON when:

(1) The diagnosis on the servo system is completed successfully after the control unit is turned ON.
(2) "Servo alarm", if occurs, is reset. (Resetting may not be possible depending on the servo alarm contents.)
(3) "Emergency stop" input is removed.

The signal turns OFF when:

(1) "Servo alarm" occurs.
(2) "Emergency stop" is input.
(3) The power supply of controller is turned OFF.
(4) Trouble occurs with the controller (such as failure in the CPU or memory).

(Note 1) This signal (SA) cannot be turned OFF only with the "Servo OFF" (*SVFn) signal.

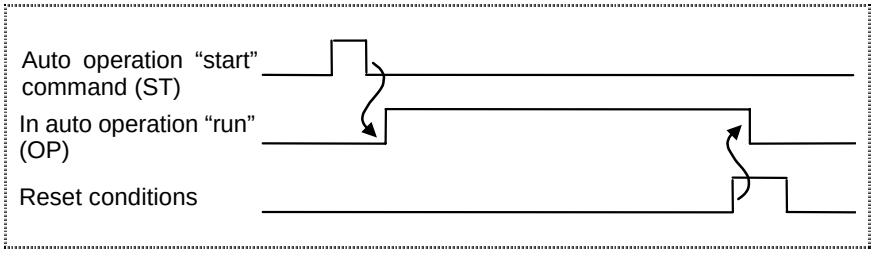
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN AUTO OPERATION "RUN"	OP	—	X1F2	U72	X1F2	X532

[Function]

This signal indicates that the controller is in automatic operation caused by "Auto operation "start" command" signal.

[Operation]

This signal stays ON from when automatic operation starts with the "Auto operation "start" command (ST)" signal in the memory, MDI or tape mode, until the operation is reset.



(1) Reset conditions include the followings:
- "Reset & rewind (RRW)" is input.
- "Emergency stop" signal or "Servo alarm" signal is input.

(2) Signals related to "In auto operation "run" (OP)" include "In auto operation "start" (STL)", "In auto operation pause (SPL)", etc.
The ON/OFF state of these signals in each state are shown below.

	In auto operation "RUN" (OP)	In auto operation "START" (STL)	In auto operation "PAUSE" (SPL)
Reset condition	0	0	0
Auto operation stop condition	1	0	0
Auto operation pause condition	1	0	1
Auto operation start condition	1	1	0

The outline of each condition is as follows:
- Reset condition ..... Automatic operation is stopped by one of reset conditions described above. (All states not in automatic operation are this state.)
- Auto operation stop condition ..... Automatic operation is stopped after completion of one block. (This state is entered during single block stop.)
- Auto operation pause condition ..... Automatic operation suspended in the course of execution of one block. (This state is entered when the "Auto operation "pause" command signal (*SP)" is OFF.)
- Auto operation start condition ..... Automatic operation is being executed.

[Related signals]

In auto operation "start" (STL: X1F3)
In auto operation "pause" (SPL: X1F4)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN AUTO OPERATION "START"	STL	—	X1F3	U73	X1F3	X533

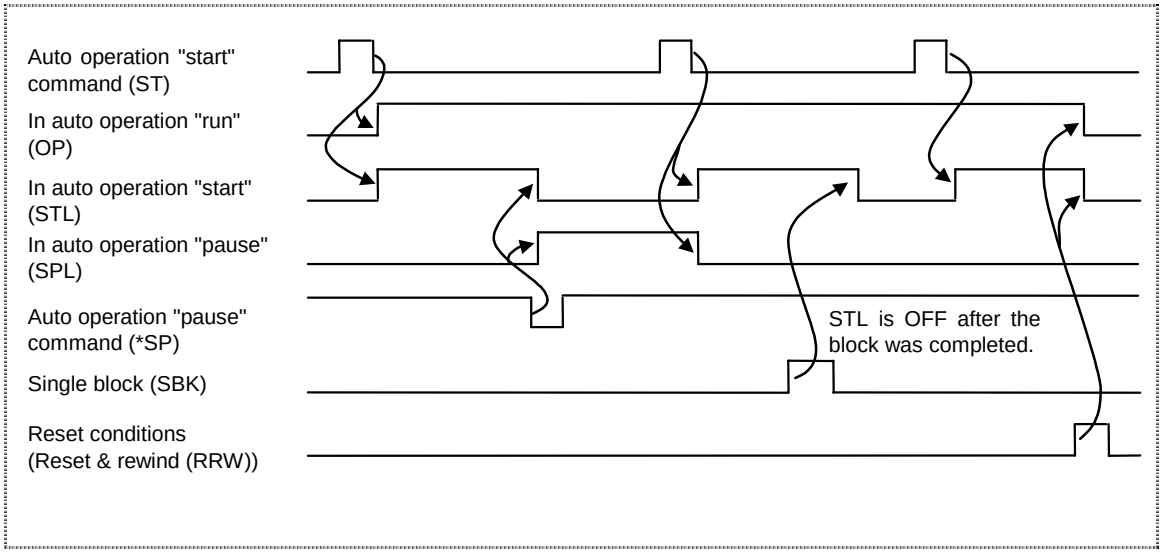
[Function]

This signal informs the PLC that automatic operation of the controller starts (started by automatic operation and motion command or M, S, T, B processing is in execution.

[Operation]

The signal turns ON by the "Auto operation "start" command" signal (ST) in memory, MDI or tape mode, and OFF when auto operation pause, block stop or reset condition occurs.

The "In auto operation "start"" signal (STL) time chart, including automatic operation "pause" and block stop, is shown below.



(Note 1) For reset conditions, refer to the section on "In auto operation "run"" (OP).

[Related signals]

In auto operation "run" (OP: X1F2)
In auto operation "pause" (SPL: X1F4)
Auto operation "start" command (ST: Y218)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN AUTO OPERATION "PAUSE"	SPL	—	X1F4	U74	X1F4	X534

[Function]

This signal informs that the controller operation has been stopped due to the "Auto operation "pause" command" signal, etc., during motion command or miscellaneous function command.

[Operation]

The "In auto operation "pause"" signal (SPL) turns ON with the following factors during automatic operation using the memory, MDI or tape mode.

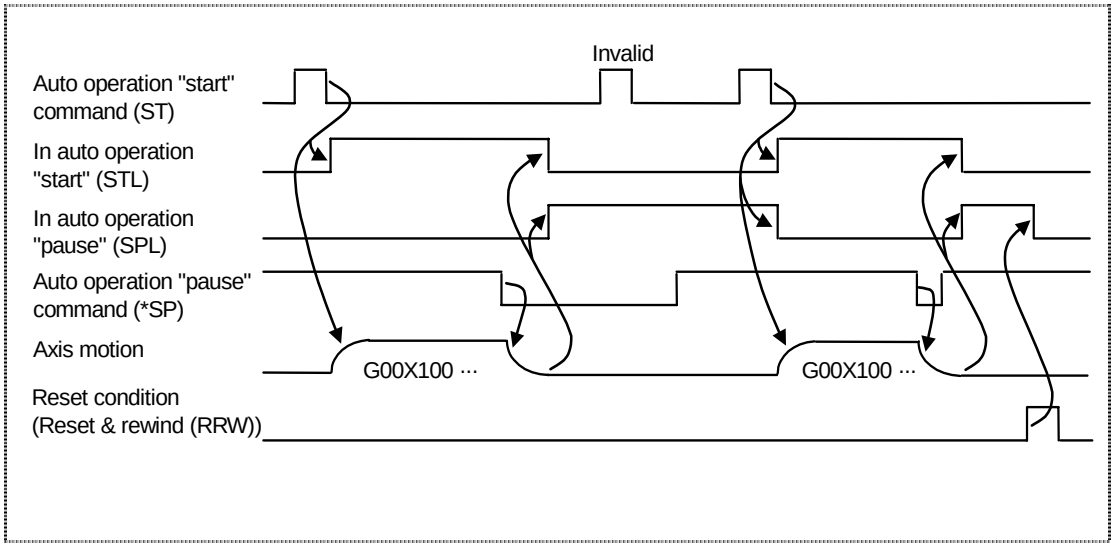
(1) When "Auto operation "pause" command" signal (*SP) turns OFF.
(2) When mode changes to manual operation mode (jog, handle, incremental, reference position return mode, etc.).

This signal will turn ON even during machine lock or a miscellaneous function (M, S, T, B) command.

This signal will turn OFF in the following cases.

(1) When "Auto operation "start" command" signal (ST) turns ON. However, this will be invalid if the "Auto operation "pause" command" signal (*SP) is not turned back ON or if the mode is not automatic operation (memory, MDI, tape).
(2) When reset conditions are input.

The timing chart for the "In automatic operation "pause"" signal (SPL) is shown below.



(Note 1) Refer to the section on "In auto operation "run"" (OP) for the rest conditions.

[Related signals]

In auto operation (OP: X1F2)
In auto operation "start" (STL: X1F3)
Auto operation "start" command (ST: Y218)
Auto operation "pause" command (*SP: Y219)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN "RESET"	RST	—	X1F5	U75	X1F5	X535

[Function]

This signal informs that the controller is in reset condition.

[Operation]

The signal turns ON:

(1) For about 4 to 5 seconds after the power is turned ON.
(2) While "Reset and rewind" signal (RRW) is ON, and for about 0.5 to 1 seconds after "Reset and rewind" signal (RRW) turns OFF.
(3) While "Emergency stop" signal is being input, and for 1 to 1.5 seconds after "Emergency stop" signal turns OFF.
(4) During "Servo alarm", and for 1 to 1.5 seconds after "Servo alarm" is removed.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN MANUAL RANDOM FEED	CXN	PC	X1F6	U76	X1F6	X536

[Function]

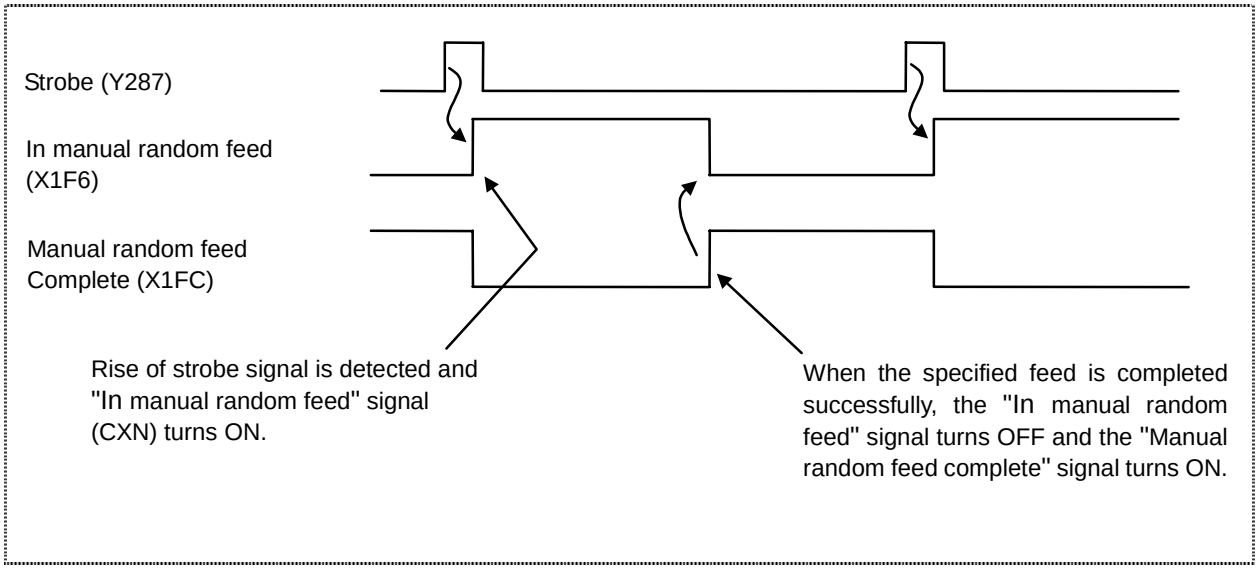
This signal is output during execution of manual random feed command.

[Operation]

The signal turns ON when "Strobe" signal (Y287) turns ON during MANUAL RANDOM FEED mode.

The signal turns OFF when commanded feed has been completed, and when "Reset & Rewind" signal is input during execution of manual random feed command.

[Timing chart]



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN REWIND	RWD	—	X1F7	U77	X1F7	X537

[Function]

This signal informs that the controller is indexing the memory mode.

[Operation]

The signal turns ON when "Reset & rewind" signal (RRW) is turned ON by the PLC in memory mode (with M02 or M30 command), and turns OFF when the controller completes indexing the program in execution.

(Note 1) Since indexing of program in memory mode ends immediately, it may not be verified by user PLC.

[Related signals]

Reset & rewind (RRW: Y222)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MOTION COMMAND COMPLETE	DEN	—	X1F8	U78	X1F8	X538

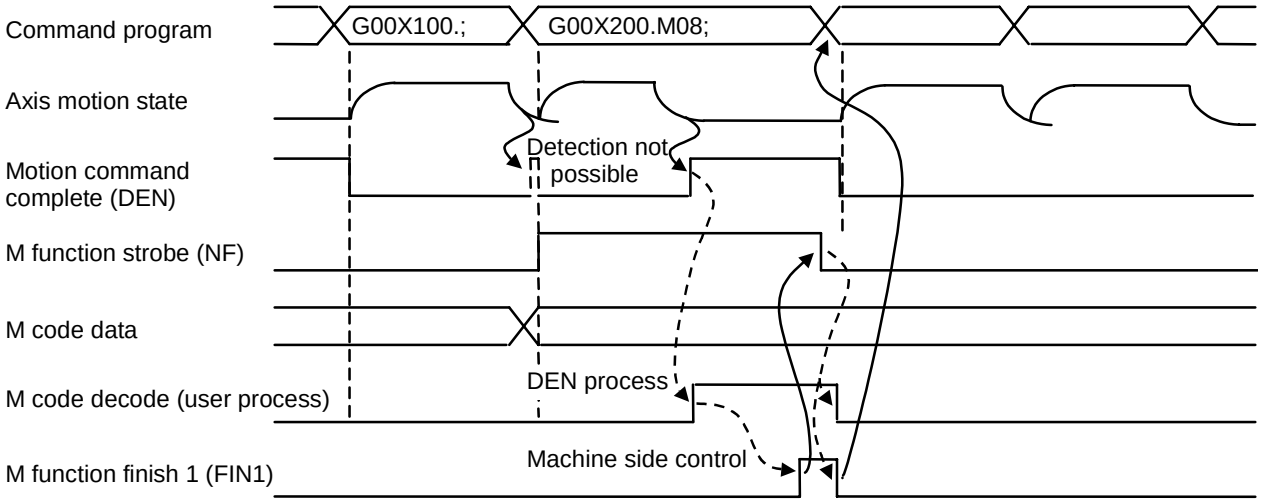
[Function]

This signal notifies that the commanded motion has been completed by the controller.
In the machining program when the motion command and miscellaneous function (M, S, T, B) command are specified in the same block, this signal can be used as a synchronization signal to determine whether miscellaneous function command is executed simultaneously with or after the motion command.

[Operation]

The signal turns ON when:
(1) The system is initialized after the power is turned ON.
(2) Execution of motion command is completed in automatic operation.
(3) Reset condition occurs.
(For reset conditions, refer to the section on "In auto operation "run"" signal (OP).)

The timing chart for the "Motion command complete" signal (DEN) is shown below.



(Note 1) The "Motion command complete" signal is output even during machine lock.
(Note 2) Unless commanded motion is completed, this signal does not turn ON even when motion is suspended by interlock function or "Auto operation "pause" command" signal.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ALL AXES IN-POSITION	TIMP	—	X1F9	U79	X1F9	X539

[Function]

This signal informs the PLC that the all axis components of the controller are in commanded positions.

[Operation]

The signal turns ON when there is no acceleration/deceleration delay in all control axes and servo errors (remaining pulses) in positioning are within the specified range.

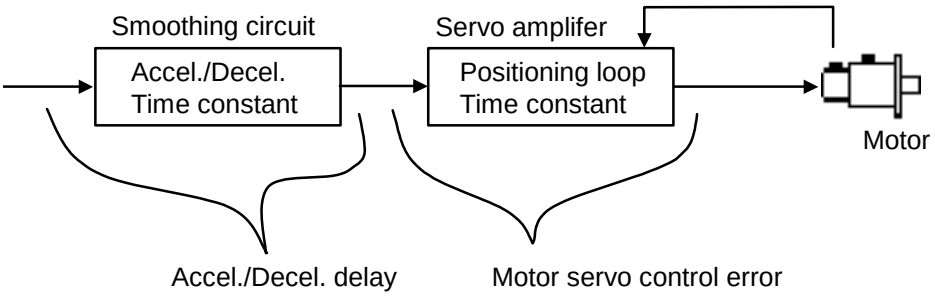
The signal turns OFF when:

(1) Acceleration/deceleration motion is delayed in a control axis.

(2) Servo positioning error (remaining pulses) for a control axis exceeds the specified range.

(Note 1) The signal may turn ON even during motion if the motion is an extremely low speed.

(Note 2) The condition where the servo errors must be in a specific range to turn ON the signal can be invalidated with parameters. In this case, the signal will turn ON/OFF regardless of whether there is any delay in the acceleration/deceleration.



[Related signal]

All axes smoothing zero (TSMZ: X1FA)

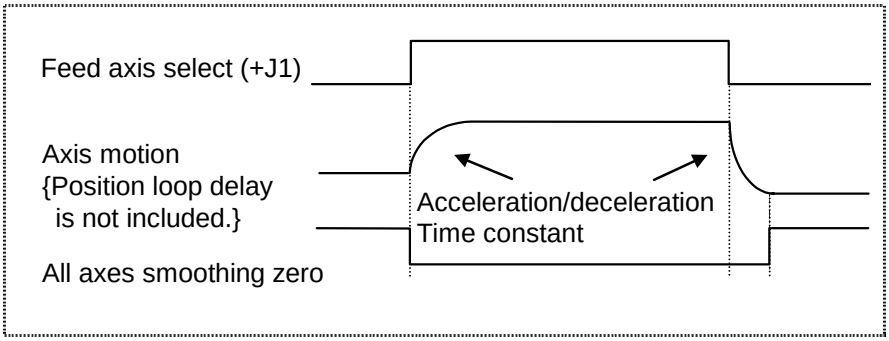
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ALL AXES SMOOTHING ZERO	TSMZ	—	X1FA	U7A	X1FA	X53A

[Function]

This signal informs the PLC that there is no delay (caused by the acceleration/deceleration time constants) in any of the controller control axis command system.
The PLC axis is not included in the control axis.

[Operation]

The signal turns ON when the motion commanded in automatic or manual operation is completed successfully without delay. The signal is OFF during execution of motion command, or if delay in execution of command occurs.



(Note 1) The signal can turn ON even during machine lock.
(Note 2) The signal may turn ON during motion if the motion is an extremely low speed.

[Related signals]

(1) All axes in-position (TIMP: X1F9)
(2) In plus motion +1st axis to +8th axis (MVP1 to MVP8: X190)
(3) In minus motion -1st axis to -8th axis (MVM1 to MVM8: X198)

"All axes smoothing zero" signal turns ON when these signals are OFF.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL RANDOM FEED COMPLETE	CXFIN	P C	X1FC	U7C	X1FC	X53C

[Function]

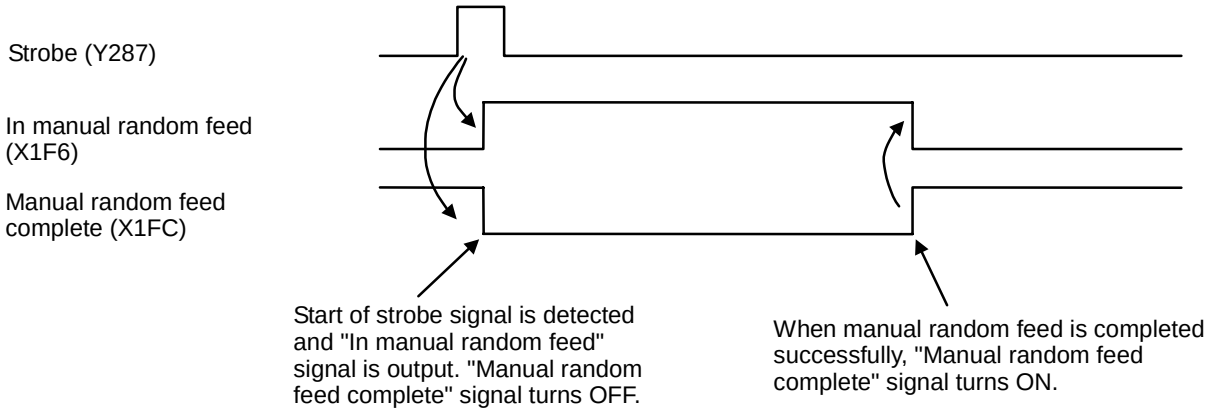
This signal is output when motion commanded in manual random feed mode is completed.

[Operation]

The signal turns ON when:
(1) The motion commanded in manual random feed mode is completed.

The signal turns OFF when:
(1) During motion in manual random feed mode.
(The signal stays OFF when motion is interrupted by a reset & rewind signal.)
(2) The power is turned ON.

[Timing chart]



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN RAPID TRAVERSE	RPN	—	X200	U80	X200	X540

[Function]

This signal is output during rapid traverse motion in automatic operation (memory, MDI, tape).

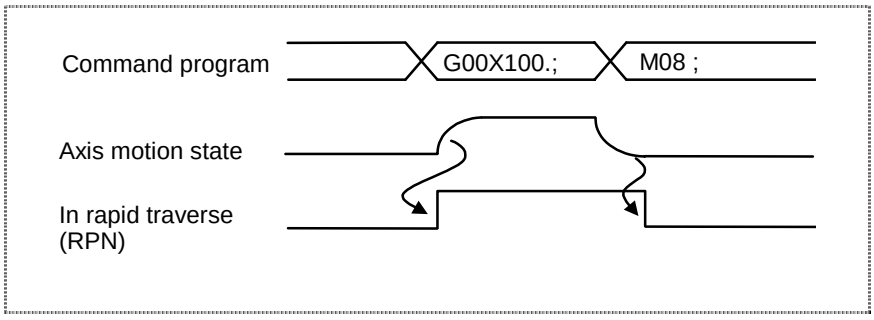
[Operation]

(1) The signal is ON when:
- Rapid traverse motion in automatic operation.
  Fixed cycle positioning and reference position return (G28), etc., are included in the automatic operation rapid traverse besides the motion command by the G00 command.

(2) The signal turns OFF when:
- The block in rapid traverse motion is completed during automatic operation.
- Rapid traverse motion is stopped by "Auto operation "pause" command" signal (*SP) during automatic operation.
- Rapid traverse motion axis is stopped by interlock during automatic operation.
- The ratio of the "Cutting feedrate override" (*FV1 to 16) becomes 0% during automatic rapid traverse operation.
- A stroke end (hardware or software) occurs during automatic rapid traverse operation.
- Reset condition occurs.

(Note 1) "In rapid traverse" signal (RPN) can turn ON and OFF even during machine lock.
(Note 2) The signal is not output in manual operation.
(Note 3) For reset condition, refer to the section on "In auto operation "run"" signal (OP).

The timing chart for "In rapid traverse" signal (RPN) is shown below.



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN CUTTING FEED	CUT	—	X201	U81	X201	X541

[Function]

This signal informs that given motion command is executed for cutting feed in automatic operation (memory, MDI, tape).

[Operation]

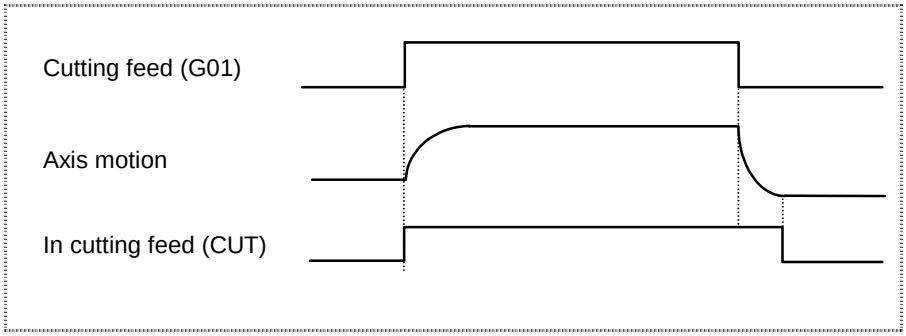
The signal turns ON when:

(1) Motion command is given for cutting feed in automatic operation.

The signal turns OFF when:

(1) The block in cutting feed in automatic operation is completed.
(2) Execution of cutting feed is suspended by "Auto operation "pause" command" signal (*SP).
(3) Execution of cutting feed is stopped by interlock during auto operation.
(4) The ratio of the cutting feedrate override becomes 0% during automatic cutting feed operation.
(5) A stroke end (hardware or software) occurs during automatic cutting feed operation.
(6) Reset condition occurs.

(Note 1) The signal (CUT) can be turned ON and OFF during cutting feed even if machine interlock is applied.
(Note 2) Cutting feed commands in automatic operation include G01, G02, G03 and G31.
(Note 3) The signal is not output in manual operation.
(Note 4) For reset condition, refer to the section on "In auto operation "run"" signal (OP).



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN TAPPING	TAP	—	X202	U82	X202	X542

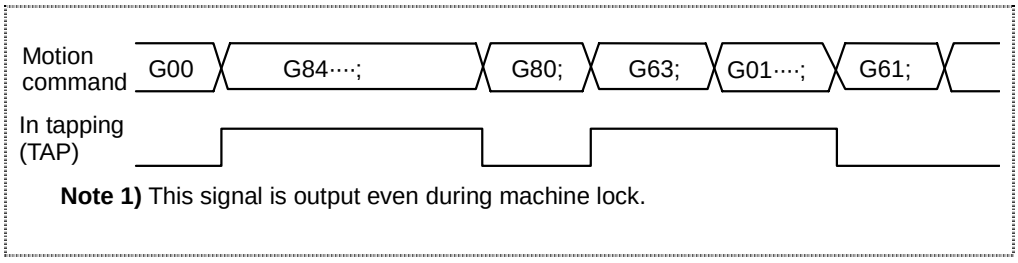
[Function]

This signal informs that commanded motion in automatic operation (memory, MDI, tape) is executed in canned tapping cycle, or tapping mode is selected for execution of commanded motion.

[Operation]

(1) The signal turns ON when:
- Commanded motion in automatic operation is being executed in canned tapping cycle.
- Commanded motion in automatic operation is being executed in tapping mode (G63).

(2) The signal turns OFF when:
- Commanded motion is not being executed in fixed tapping cycle, nor in tapping mode.
  The signal is reset by G80 or "01" group G command (G00, G01, G02, G03, G33) during canned tapping cycle, and by G61, G62 and G64 during tapping mode.



Note 1) This signal is output even during machine lock.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN THREAD CUTTING	THRD	—	X203	U83	X203	X543

[Function]

This signal is output during execution of thread cutting command.

[Operation]

The signal turns ON when:
(1) Thread cutting command is given.

The signal turns OFF when:
(1) Motion command other than thread cutting command is given.
(2) Reset condition occurs during thread cutting.

((Note) Spindle override is invalid (100%) during thread cutting.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN SYNCHRONOUS FEED	SYN	—	X204	U84	X204	X544

[Function]
This signal is output during execution of synchronous feed command.

[Operation]
The signal turns ON when:
(1) Synchronous feed command (G94) is given.

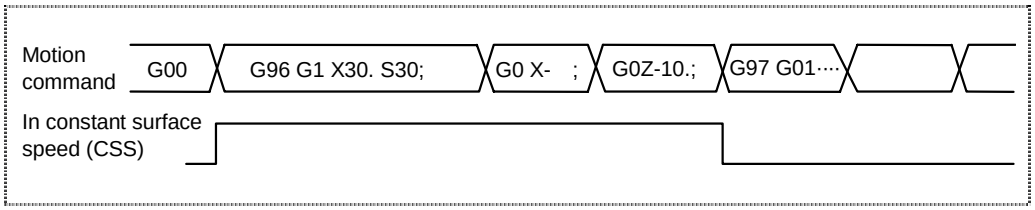
The signal turns OFF when:
(1) Asynchronous feed command (G95) is given.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN CONSTANT SURFACE SPEED	CSS	—	X205	U85	X205	X545

[Function]
This signal informs that automatic operation is under constant circumferential (surface) speed control.

[Operation]
The signal turns ON when:
(1) Constant surface speed control mode (G96) is selected during automatic operation.

The signal turns OFF when:
(1) Constant surface speed control off command (G97) is given.



(Note 1) This signal (CSS) is output even during machine lock.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN SKIP	SKIP	—	X206	U86	X206	X546

[Function]
This signal is output while skip command (G31) is being executed.

[Operation]
The signal turns ON when:
(1) Skip command (G31) is being executed with automatic operation.

The signal turns OFF when:
(1) Block having a skip command is completed.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN REFERENCE POSITION RETURN	ZRNN	—	X207	U87	X207	X547

[Function]
This signal is output while reference position return command is being executed.

[Operation]
The signal turns ON when:
(1) G28 command is executed.
(2) G30 command is executed.
(3) Manual reference position return mode is selected.

The signal turns OFF when:
(1) All cases other than above.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN INCH UNIT SELECT	INCH	—	X208	U88	X208	X548

[Function]
This signal informs that the controller uses inch unit for data input.

[Operation]
This signal turns ON when inch unit is selected.
The inch unit mode is established when setup parameter [#1041 I_inch] is set and the power is turned ON.

(Note 1) With G20 command (inch unit command) or G21 command (metric unit command), the signal (INCH) does not change.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN DISPLAY LOCK	DLNK	P C	X209	U89	X209	X549

[Function]

This signal informs that the results of the movement command executed by the control unit are not reflected onto POSITION screen (display locked).

[Operation]

This signal turns ON while the display lock signal (DLK) is input.
The display lock operation is validated immediately after the display lock signal (DLK) turns ON.

[Related signals]

Display lock (DLK: Y231)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	F1-DIGIT COMMANDED	F1DN	—	X20A	U8A	X20A	X54A

[Function]

This signal informs that the controller uses F1-digit commands (F1 to 5) to control operation.

[Operation]

The signal turns ON when:
(1) F1-digit command (F1 to 5) is selected for feedrate command currently being executed.

The signal turns OFF when:
(1) Block having a motion command specified with F1-digit code is completed.
(2) Operation is stopped by "Auto operation "pause" command" signal (*SP) during execution of F1-digit feedrate command.
(3) Operation is stopped by "Interlock" signal during execution of F1-digit feedrate command.
(4) Reset condition occurs.
(For details of reset conditions, refer to the description about "In auto operation "run"" signal (OP).)

(Note 1) The setup parameter, base specification parameter "#1079 F1digt" must be validated and "#1185 to 89 F1-digit feedrate" must be set to use the F1-digit command.

[Related signal]

(1) F1-digit No. (F11 to 14: X218)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN TOOL LIFE MANAGEMENT	TLFO	P C	X20B	U8B	X20B	X54B

[Function]

This signal is output while tool life is being managed.

[Operation]

The signal turns ON when the parameter "#1103 T_Life" is ON.

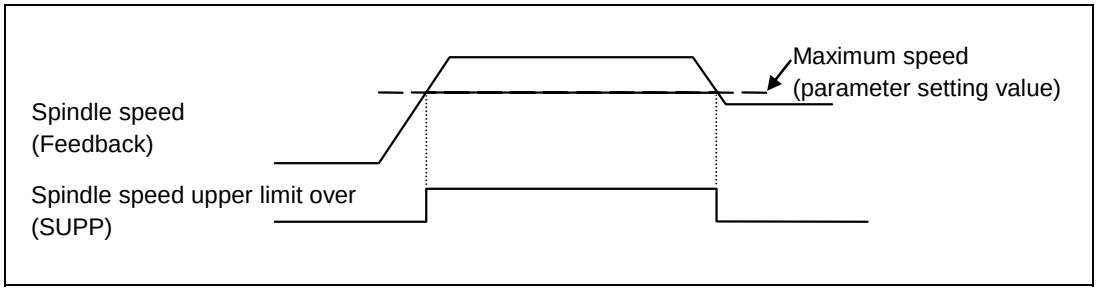
B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE SPEED UPPER LIMIT OVER	SUPP	P C	X20C	U8C	X20C	X54C

[Function]

This signal notifies that the feedback of the spindle motor has exceeded the maximum speed.

[Operation]

This signal turns ON when the spindle motor's feedback exceeds the maximum speed regardless of the commanded speed.



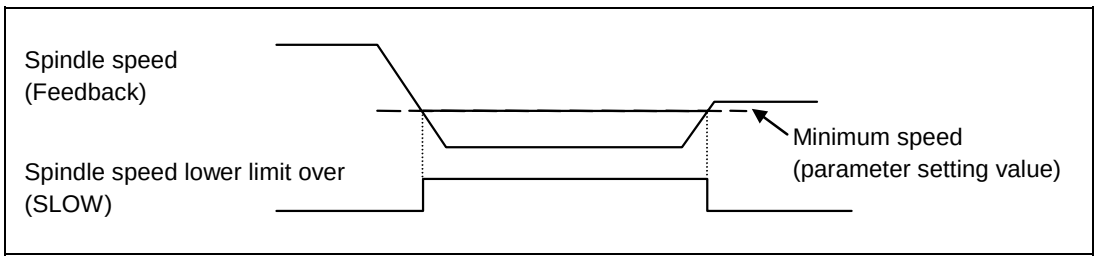
B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE SPEED LOWER LIMIT OVER	SLOW	P C	X20D	U8D	X20D	X54D

[Function]

This signal notifies that the feedback of the spindle motor has exceeded the minimum speed.

[Operation]

This signal turns ON when the spindle motor's feedback exceeds the minimum speed regardless of the commanded speed.



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL LIFE OVER	TLOV	PC	X20E	U8E	X20E	X54E

[Function]

This signal notifies the PLC that the lives of all tools in the same group have reached (usage data ≥ life data).
Note that for tool life management I, the data is controlled with tool units.

[Operation]

<For L system tool life management I>

This signal turns ON when the usage data of the tool matches or exceeds the life data. Note that this signal is only output, and the automatic operation of the controller, etc., will not stop.

<For L system tool life management II>

This signal turns ON when the usage data of the tool matches or exceeds the life data. Note that this signal is only output, and the automatic operation of the NC, etc., will not stop.
The signal turns ON when:
(1) The final tool of the group current selected has reached the life (usage data ≥ life data). (Same timing as the count up of usage data.)
(2) When a "Tool change reset" (TRST) signal has been input in respect to the last tool in the currently selected group.
(3) If a group is selected, when the lives of all tools in the group have reached the life. (Same timing as tool function strobe 1 (TF1) signal.)

The signal turns OFF when:
(1) When the group selection has been completed. (At T command. Note that if the selected group is a life group, the signal will remain ON.)
(2) When usage data of currently selected group is cleared. (When "Tool change reset" (TRST) signal is input, etc.)

<For M system tool life management II>

This signal turns ON when the life of all tools in the group mounted on the spindle is reached, or when erroneous tools are selected. Note that this signal is output only, and the automatic operation of the control unit, etc., will not stop.
This signal turns ON when:
(1) When the usage data ≥ life data of the final tool in the group mounted on the spindle.
(Same timing as the count up of usage data)
(2) When a tool error signal is input for the final tool in the group mounted on the spindle.
(3) When the lives have been reached of all the tools in the mounted group when the tools are mounted on the spindle.

This signal turns OFF when:
(1) When a tool from another group is mounted on the spindle.
(Note that if the life of all the tools in the mounted group is reached, the signal will remain ON.)
(2) When the usage data of the group mounted on the spindle is cleared.
(3) When the tool life management is invalidated.

[Caution]

When this signal is used in M system tool life management II, refer to the ladder cycle after the spindle tool is changed. (This signal will not change in the same cycle in which the spindle tool was changed.)

[Related signals]

(1) Tool change reset (TRST: Y2CC)
(2) Tool function strobe 1 (TF1: X238)
(3) In tool life management (TLFO: X20B)
(4) New tool change (TCRQ: X22C)
(5) Group in tool life management
(6) Tool life usage data

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	BATTERY ALARM	BATAL	PC	X20F	U8F	X20F	X54F

[Function]

This signal notifies that the voltage of the data storage battery in the controller or the battery supplying to the absolute position detector has dropped below the specified value.

[Operation]

The signal turns ON when:

(1) The voltage of the data storage battery is checked when the power is turned ON and is below the specified voltage (approx. 2.6V). At this time, the system alarm (Z52) will display.
(2) A fault is detected in the power voltage supplied to the absolute position detector.
At this time, the absolute position detection system alarm (Z73 0001) and servo alarm (S52 9F) will display.
(3) A fault is detected in the power voltage for the speed detector in the absolute position detector.
At this time, the absolute position detection system alarm (Z71 0001) and servo alarm (S01) will display.

In the case of (1) and (2), automatic starting is possible.

The signal turns OFF when:

(1) For alarms caused by ON condition (1), the signal can be turned OFF by resetting the setting and display unit. However, if the battery voltage is still below the specified value when the controller power is turned OFF and ON, the signal will turn ON again.
(2) For alarms caused by ON conditions (2) and (3), the signal can be turned OFF by removing the power voltage fault and then turning the power ON again.

[Related signal]

(1) Battery drop cause (R56)

[Caution]

If this battery alarm occurs (especially in the "ON" conditions (1)) assume that the data which should be registered, such as the machining programs, has been damaged, and take suitable measure.
Always make a back up of the data in the controller as a safeguard for when this alarm occurs.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	NC ALARM 1	AL1	—	X210	U90	X210	X550

[Function]

This signal informs that system error occurred in the controller.

[Operation]

If "watch dog error", "memory parity check error", etc. occurs on the controller side, the signal turns ON. The system error can be reset by turning OFF.

(Note 1) "NC alarm 1" (AL1) may not be detected as signal.
(Note 2) For details of system alarms, refer to the relevant Operation Manual or Alarm/Parameter Manual.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	NC ALARM 2 (Servo alarm)	AL2	—	X211	U91	X211	X551

[Function]

This signal informs that the controller is in servo alarm condition. If servo alarm occurs, "Servo ready complete" signal (SA) turns OFF.

[Operation]

The signal turns ON when:

(1) Servo alarm occurs. Servo alarms include the following:
- Servo failure 1 (no signal, overcurrent, overvoltage, etc.)
- Servo failure 2 (motor overheat, excessive error, amplifier external emergency stop, etc.)
- Initial parameter error (parameter transferred to amplifier when the power is turned ON is illegal)
- Amplifier not mounted (cable is not connected between controller and servo controller).
- Parameter error (a parameter that will disrupt movement of the control axis was found).

Alarm can be reset by turning OFF the power, or using controller reset, or by setting parameter again, etc., depending on type of alarm. For details of alarm resetting, and servo alarm, refer to the relevant Operation Manual or Alarm/Parameter Manual.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	NC ALARM 3 (Program error)	AL3	—	X212	U92	X212	X552

[Function]

This signal informs that the controller is in program error condition.

[Operation]

This type of alarm occurs during automatic operation in memory, MDI or tape mode, mainly due to use of faulty machining program, or program incompatible with the controller specifications.

Some typical examples of program error are shown below. For details, refer to the relevant Operation Manual or Alarm/Parameter Manual.

(1) Illegal address (address not covered by the specifications is used)
(2) Absence of F command
(3) Arc end point excessive deviation
(4) Return incomplete axis found (a motion command was issued to an axis that has not completed reference position return)
(5) Program end error (M02 or M30 command is not inserted or reset & rewind process has not been performed)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	NC ALARM 4 (Operation error)	AL4	—	X213	U93	X213	X553

[Function]

This signal informs that the controller is in operation error condition.

[Operation]

The signal turns ON in case of operation alarm, and OFF when the alarm condition is removed.
Some typical examples of operation errors are shown below:
For details, refer to the relevant Operation Manual or Alarm/Parameter Manual.

(1) Hardware axis motion stroke end
(2) Software axis motion stroke end
(3) No operation mode set
(4) Cutting feedrate override set to "zero"
(5) Manual feedrate zero
(6) External interlock axis found
(7) Warning regarding absolute position detection

(Note) When the "NC alarm 5" (X2A1) is valid, the following alarms are not output to the "NC alarm 4".

Error No.	Details
0004	External interlock
0102	Cutting override zero
0103	External feed speed zero
0109	Block start interlock
0110	Cutting block start interlock
1033	Spindle-Spindle polygon (G51.2) cutting interlock

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	S-ANALOG GEAR NO. ILLEGAL	SIGE	PC	X214	U94	X214	X554

[Function]
This signal is output if specified gear No. is illegal.

[Operation]
The signal turns ON if gear No. specified by user is beyond the maximum system gear No.

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	S-ANALOG MAX./MIN. COMMAND VALUE OVER	SOVE	PC	X215	U95	X215	X555

[Function]
This signal is output when S-analog command value is clamped to the maximum or minimum value.

[Operation]
The signal turns ON if S-analog command value is larger than spindle maximum speed parameter (Smaxn) value, or smaller than spindle minimum speed parameter (Smin) value.

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	S-ANALOG NO GEAR SELECTED	SNGE	PC	X216	U96	X216	X556

[Function]
This signal is output if gear is not present for S function (S code) issued by automatic operation.

[Operation]
This signal will turn ON when the S function (S code) is issued during automatic operation, and the S code does not match any gear set in the spindle maximum speed parameters.

This signal (SNGE) is output simultaneously with spindle function strobe signal (SF).

[Related signals]
Spindle function strobe (SFn: X234)
Spindle gear shift (GR1, GR2: X225)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ILLEGAL AXIS SELECTED	ASLE	PC	X217	U97	X217	X557

[Function]

This signal is output if axis (No.) selected in handle mode or manual random feed mode is illegal.

[Operation]

The signal turns ON when:

(1) For handle mode
If specified handle axis No. is beyond the maximum number of axes.

(2) For manual random feed mode
If specified manual random feed axis No. is beyond the maximum number of axes.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	F1-DIGIT NO. (1, 2, 4)	F11 to 14	PC	X218 to A	U98 to A	X218 to A	X558 to A

[Function]

F1-digit feed function No. is output.

[Operation]

When F1-digit feed command specified in memory, MDI or tape operation is executed, No. of that F1-digit feed function is set with a code.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	WAITING BETWEEN PART SYSTEMS		PC	X21C	U9C	X21C	X55C

[Function]

This signal informs that the waiting between part systems is being executed.

[Operation]

1: This signal is output while the waiting between part systems is commanded in one part system to when the corresponding waiting between system command is commanded in the other part system (during the waiting function between part systems).

0: When the waiting between part systems is not executed, this signal is not output.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	M CODE INDEPENDENT OUTPUT M00	DM00	—	X220	UA0	X220	X560

[Function]

This signal informs that a special miscellaneous function (M00) is selected and commanded. When a special M function is specified, "Normal miscellaneous function strobe" signal and "M code data" are output.

M code independent outputs include M01, M02 and M30.

[Operation]

When M00, M01, M02 or M30 is specified during auto operation (memory, MDI or tape), or by manually set numerical command, this signal turns ON. The signal turns OFF when M function finish signal, reset signal or reset & rewind signal is given.

Machining program	M code independent output	Abbr.	Answer back to controller
M00	M00	DM00	Fin 1 or Fin 2
M01	M01	DM01	Fin 1 or Fin 2
M02	M02	DM02	Reset & rewind signal ("Fin" is not sent back)
M30	M30	DM30	Reset & rewind signal ("Fin" is not sent back)

If motion command and/or dwell is present in the same block, the signal turns ON after completion of dwell.

However, the signal is not output if M function finish signal turns ON before completion of motion command or dwell.

Generally, each M code is used for the following purpose:

M00 ……..... Program stop
M01 ...……. Optional stop
M02, M30 ..... Program end

• Operation on user PLC side

(1) For M00
When M00 is input, single block signal (SBK) is turned ON and M function finish signal (Fin 1 or Fin 2) is sent back.

(2) For M01
When M01 is input, optional stop switch setting (ON or OFF) is checked. If the setting is "ON", single block signal is turned ON and M function finish signal is sent back, like the case with M00. If the setting is "OFF", M function finish signal is sent back immediately.

(3) For M02, M30
When motion where M02 or M30 was input (spindle stop, coolant stop, etc.) is completed, reset & rewind signal (RRW) is sent back instead of M function finish signal. If M function finish (Fin 1, Fin 2) signal is sent back, "program error" may occur.

[Related signals]

(1) M code independent output M01 (DM01: X221)
(2) M code independent output M02 (DM02: X222)
(3) M code independent output M30 (DM30: X223)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	M CODE INDEPENDENT OUTPUT M01	DM01	—	X221	UA1	X221	X561

[Function] [Operation]
Refer to "M CODE INDEPENDENT OUTPUT M00".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	M CODE INDEPENDENT OUTPUT M02	DM02	—	X222	UA2	X222	X562

[Function] [Operation]
Refer to "M CODE INDEPENDENT OUTPUT M00".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	M CODE INDEPENDENT OUTPUT M30	DM30	—	X223	UA3	X223	X563

[Function] [Operation]
Refer to "M CODE INDEPENDENT OUTPUT M00".

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE GEAR SHIFT 1, 2	GR1, 2	—	X225, 6	UA5, 6	X225, 6	X565, 6

[Function]

This signal informs which gear stage in the spindle applies to the S command (S code) issued in the automatic operation (memory, MDI or tape) machining program.
For machines that have gear stage shift, the gear will be shifted on the machine side when this signal is received.

[Operation]

When the S command (S code) is issued in automatic operation, the gear stage for the commanded S code is output with a 2-bit (GR1, GR2) code from the preset parameters (spindle max. speed).

The relation of the spindle max. speed parameter (Smax1 to Smax4) and the "Spindle gear shift" (GR1, GR2) signal output is shown below.

Gear stage	Max. spindle speed	Spindle gear shift		
		GR2	GR1	
1	Smax 1	0	0	← Range "S0 to S (Smax1)"
2	Smax 2	0	1	← Range "S (Smax1)+1 to S (Smax2)"
3	Smax 3	1	0	← Range "S (Smax2)+1 to S (Smax3)"
4	Smax 4	1	1	← When range over "S (Smax3)+1" is specified.

This signal (GR1, GR2) is output simultaneously with the "Spindle function strobe" (SFn).

(Note 1) If the commanded S code does not match any of the gear stages, the "S-analog no gear selected" (SNGE) signal will be output separately from this signal.

[Related signals]

Spindle function strobe (SFn: X234)
S-analog no gear selected (SNGE: X216)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL NUMERICAL COMMAND	MMS	—	X229	UA9	X229	X569

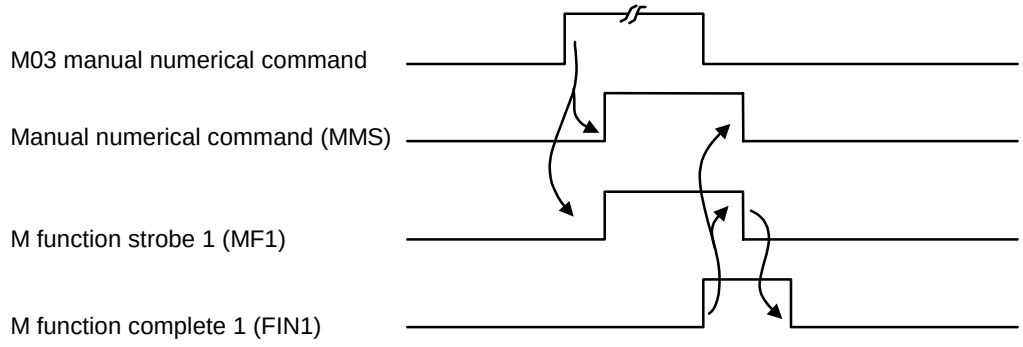
[Function]

This signal informs that M, S, T or B (2nd miscellaneous function) command is given with a specific display format selected on the setting and display unit.
With the signal, user PLC discriminates the command from that given in normal automatic operation.

[Operation]

The signal turns ON when M, S, T or B signal is specified with a specific display format in manual or automatic operation (other than auto start). Like M function strobe signal, the signal turns OFF when M function finish 1 or 2 signal turns ON, or in case of reset.

(Example)



[Related signals]

(1) M function strobe (MFn: X230)
(2) S function strobe (SFn: X234)
(3) T function strobe 1 (TF1: X238)
(4) 2nd M function strobe 1 (BF1: X23C)
(5) M function finish 1 (FIN 1: Y226)
(6) M function finish 2 (FIN 2: Y227)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL CHANGE POSITION RETURN COMPLETE	TCP	P C	X22B	UAB	X22B	X56B

[Function]

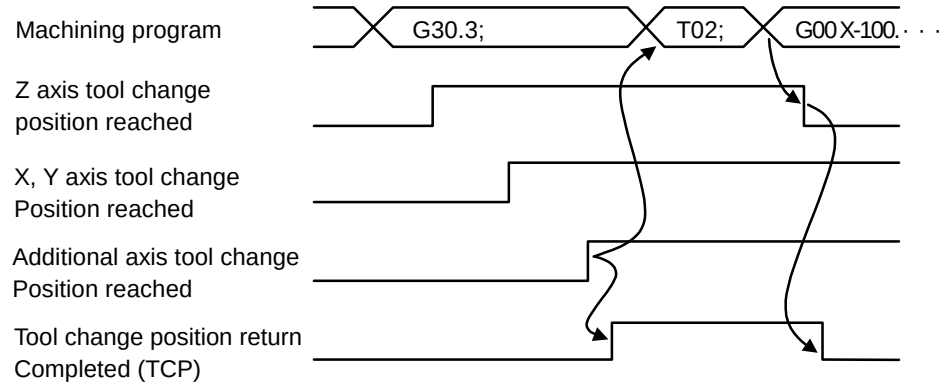
This signal notifies that the axis commanded with the tool change position return command has completed return to the tool change position.

[Operation]

This signal turns ON when all axes commanded with the tool change position return command (G30.*) have moved to the tool change position. This signal turns OFF when even one of the axes moved to the tool change position with the command has moved from the tool change position.
Refer to the Programming Manual for details on the tool change return command.

[Time chart]

Example: When G30.3 command, additional axis tool change position return is valid



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	NEW TOOL CHANGE	TCRQ	P C	X22C	UAC	X22C	X56C

[Function]

This signal notifies that a new tool (not used tool) in the group is to be selected for tool life management II.

[Operation]

<For L system tool life management II>

This signal turns ON when:

(1) When the tool selected by the T command tool selection is an unused tool (tool for which the status is 0).

This signal turns OFF when:

(1) When the T command is completed due to the input of the Miscellaneous function finish signal (FIN1, FIN2).

<For M system tool life management II>

This signal turns ON when:

(1) When the tool mounted as a standby tool is a not used tool (tool for which the status is 0).

This signal turns OFF when:

(1) When another tool is mounted as a standby tool.
Note that if the replacement tool is a not used tool, this signal will remain ON.

[Caution]

When this signal is used in M system tool life management II, refer to the ladder cycle after the standby tool is changed. (This signal will not change in the same cycle in which the standby tool was changed.)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	M FUNCTION STROBE 1	MF1	—	X230	UB0	X230	X570

[Function]

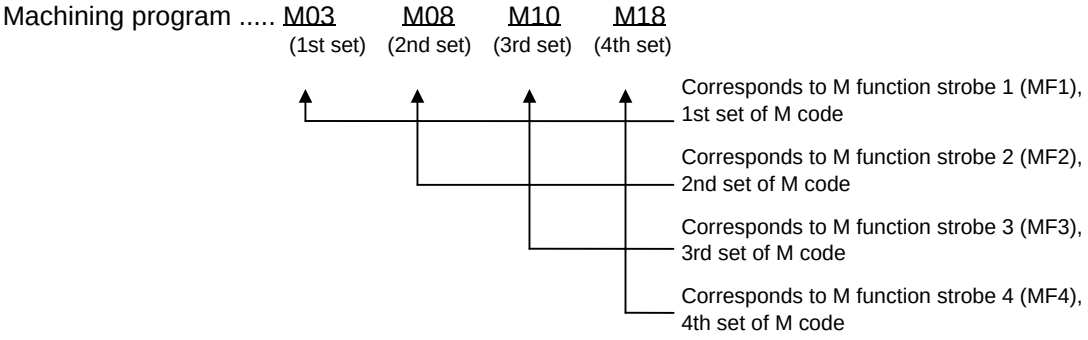
This signal informs that the 1st set of miscellaneous functions (M code) is commanded with the automatic operation (memory, MDI, tape) machining program or manual numerical command input.
The miscellaneous function is also called the M function, and is used to issue miscellaneous functions such as ON/OFF of the cutting oil, and normal/reverse/stop of the spindle, etc., for the target machine.

[Operation]

This signal turns ON when:
(1) The 1st set of M function (M code) is specified in automatic operation (memory, MDI or tape mode).
(2) M function (M code) is specified by manual numerical command input.

The signal turns OFF when:
(1) M function finish 1 signal (FIN1) or M function finish 2 signal (FIN2) turns ON.
(2) Reset condition occurs.
Refer to the "In auto operation "run"" signal (OP) section for details on the reset conditions.

(Note 1) When built-in PLC is used, four sets of M functions can be specified at the same time the relation of the machining program and M function strobe is shown below.

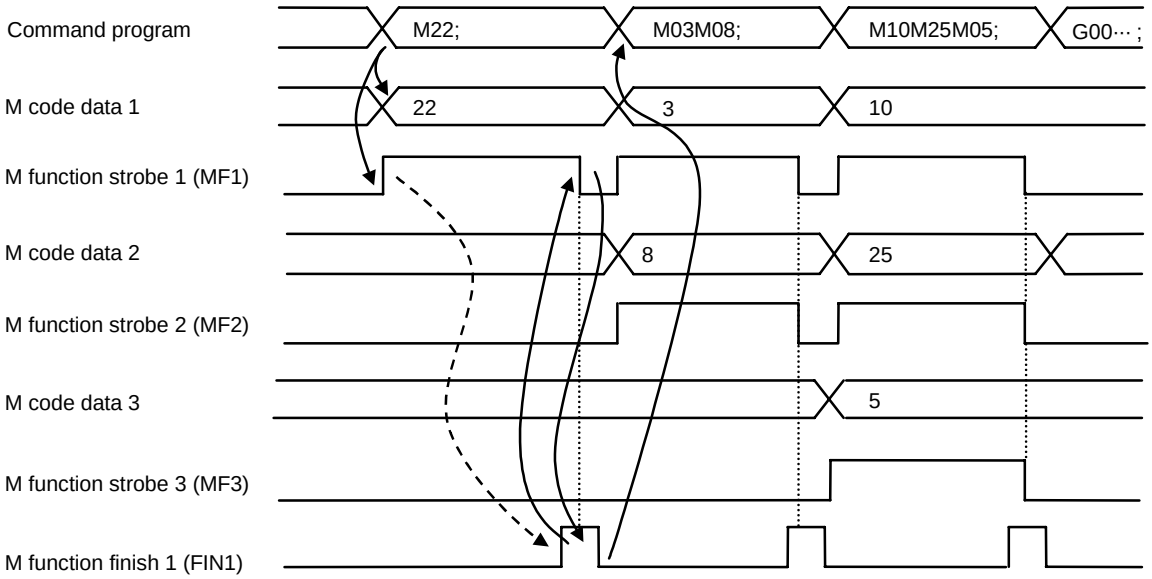


(Note 2) During operation with miscellaneous function lock (AFL signal ON), the "M function strobe" (MF1, MF2, MF3, MF4) will not be output. However, this signal will be output when the M code is commanded independently (M00, M01, M02, M30).

(Note 3) Since M98 (read of subprogram call), M99 (return from subprogram), etc. are handled within the controller, "M function strobe" is not output.

(Note 4) The "M function strobe" will not be output when the M function is output if the "M function finish 1" signal (FIN1) or "M function finish 2" signal (FIN 2) is ON.

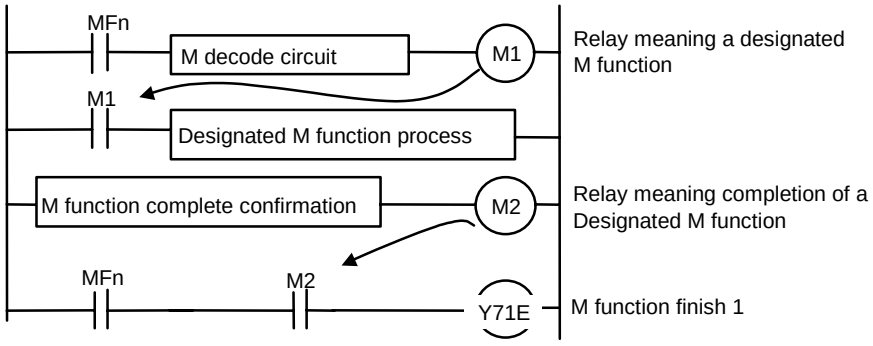
An example of the timing chart for the M function strobe signal (MF1, MF2 and MF3) is shown below.



Point The following points must be observed in the sequence process.

(a) When the M function is commanded, the MFn and M code data n is output.
(b) MFn is always the trigger in the sequence process to start the M function process.
(c) When the designated M function process is completed, the "M function finish" signal is returned to the controller.
(d) The controller waits for the rising of the M function finish signal and then turns MFn OFF.
(e) MFn OFF is confirmed in the sequence process and then the "M function finish" signal is turned OFF.
This completes the series of M function processes.

Handshaking with the controller and an accurate sequence process possible if the Mfn conditions are inserted at the M function start and completed signals.



[Related signals]

M function strobe 2 (MF2: X231)
M function strobe 3 (MF3: X232)
M function strobe 4 (MF4: X233)

M function finish 1 (FIN1: Y226)
M function finish 2 (FIN2: Y227)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	M FUNCTION STROBE 2	MF2	P C	X231	UB1	X231	X571

[Function]

This signal informs that the 2nd set of M function (M code) is specified in automatic operation.

[Operation]

The signal turns ON when:

(1) Two or more M function commands (M code) are specified for one block in automatic operation (memory, MDI or tape mode).

The signal turns OFF when:

(1) "M function finish 1" signal (FIN1) or "M function finish 2" signal (FIN2) turns ON.
(2) Reset condition occurs.

Other details are the same as those of "M function strobe 1" signal (MF1).
Refer to "M function strobe 1".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	M FUNCTION STROBE 3	MF3	P C	X232	UB2	X232	X572

[Function]

This signal informs that the 3rd set of M function (M code) is specified in automatic operation.

[Operation]

The signal turns ON when:

(1) Three or more M function commands (M code) are specified for one block in automatic operation (memory, MDI or tape mode).

The signal turns OFF when:

(1) "M function finish 1" signal (FIN1) or "M function finish 2" signal (FIN2) turns ON.
(2) Reset condition occurs.

Other details are the same as those of "M function strobe 1" signal (MF1).
Refer to "M function strobe 1".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	M FUNCTION STROBE 4	MF4	PC	X233	UB3	X233	X573

[Function]

This signal informs that the 4th set of M function (M code) is specified in automatic operation.

[Operation]

The signal turns ON when:

(1) Four or more M function commands (M code) are specified for one block in automatic operation (memory, MDI or tape mode).

The signal turns OFF when:

(1) "M function finish 1" signal (FIN1) or "M function finish 2" signal (FIN2) turns ON.
(2) Reset condition occurs.

Other details are the same as those of "M function strobe 1" signal (MF1).
Refer to "M function strobe 1".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	S FUNCTION STROBE 1 to 4	SF1 to 4	—	X234 to 7	UB4 to 7	X234 to 7	X574 to 7

[Function]

This signal informs that S (spindle) function (S code) is specified in automatic operation (memory, MDI or tape mode) machining program or by manual numerical command input.
The spindle function is also called the S function, and is used to command the spindle speed.
With the signal (SF1 to 4), user PLC reads S code data (1 to 4) respectively.

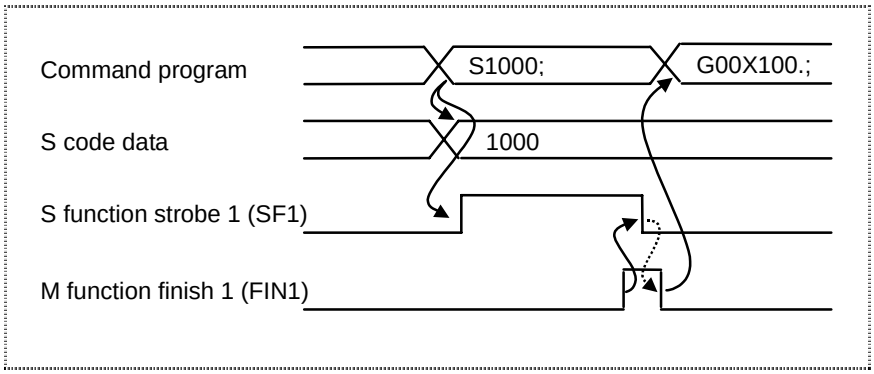
[Operation]

The signal turns ON when:
(1) S function (S code) is specified in automatic operation (memory, MDI or tape mode).
(2) S function is specified by manual numerical command input.

The signal turns OFF when:
(1) "M function finish 1" signal (FIN1) or "M function finish 2" signal (FIN2) turns ON.
(2) Reset condition occurs.
(Refer to the "In auto operation "run"" signal (OP) section for details on the reset conditions.)

(Note 1) The S function strobe is not output during operation with M function lock (AFL signal ON).
(Note 2) When the S function is commanded, the "Spindle gear shift" signal (GR1, GR2) and "S-analog no gear selected" signal (SNGE) are output in addition to this signal (SFn). Refer to the sections of each signal for details.
(Note 3) By combining this signal (SFn), "Spindle gear select input" signal (GI1, GI2) and "Spindle gear shift complete" signal (GFIN), the data can be converted into S-analog data.
(Data is transferred when the spindle controller is the high-speed serial connection specification type.)

An example of the timing chart for the "S function strobe" signal (SF1) is shown below.



[Related signals]

S code data (R28)
Spindle gear shift (GR1, GR2: X225)
S-analog no gear selected (SNGE: X216)

Spindle gear selection input (GI1, GI2: Y290)
Spindle gear shift complete (GFIN: Y225)
M function finish 1 (FIN1: Y226)
M function finish 2 (FIN2: Y227)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	T FUNCTION STROBE 1	TF1	—	X238	UB8	X238	X578

[Function]

This signal informs that the tool function (T code) is specified in automatic operation (memory, MDI or tape mode), machining program or by manual numerical command input.
With the signal (TF1), user PLC reads T code data 1.
The tool function is also called the T function, and is used to command the tool No. in the lathe specification controller, the tool compensation (tool length offset, tool nose wear compensation) Nos. are also indicated.
The user PLC receives the T code data 1 with this signal.

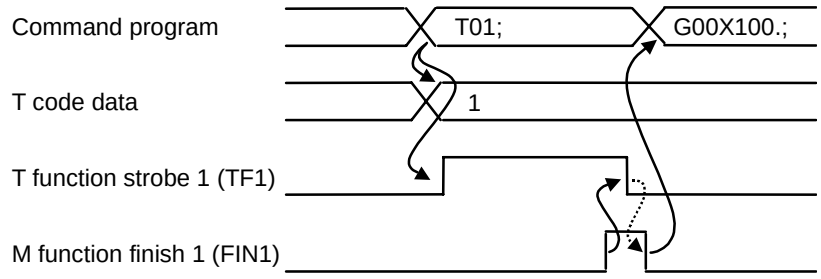
[Operation]

The signal turns ON when:
(1) The T function (T code) is specified in automatic operation (memory, MDI or tape mode).
(2) T function (T) is specified by manual numerical command input.

The signal turns OFF when:
(1) "M function finish 1" signal (FIN1) or "M function finish 2" signal (FIN2) turns ON.
(2) Reset condition occurs.
(Refer to the "In auto operation "run"" signal (OP) section for details on the reset conditions.)

(Note 1) The "T function strobe" (TF) is not output during operation with the M function lock (AFL signal ON).

An example of the timing chart for the "T function strobe 1" signal (TF1) is shown below.



[Related signals]

T code data (R36)
M function finish 1 (FIN1: Y226)
M function finish 2 (FIN2: Y227)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	2ND M FUNCTION STROBE 1	BF1	P C	X23C	UBC	X23C	X57C

[Function]

This signal informs that the 1st set of 2nd M function is selected in automatic operation (memory, MDI or tape) machining program or by manual numerical command input.
The 2nd M function is also called the B function.
With the signal (BF1), user PLC reads 2nd M function data 1.

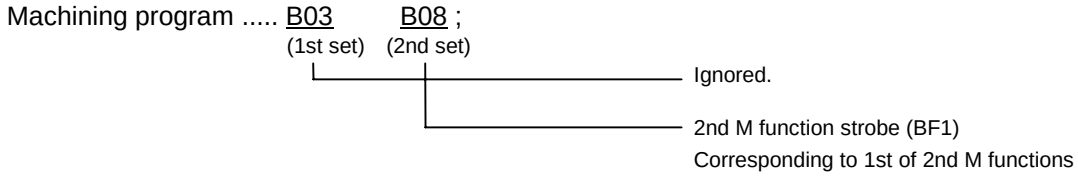
[Operation]

The signal turns ON when:
(1) The 1st set of 2nd M function (B code) is specified in automatic operation (memory, MDI or tape).
(2) 2nd M function (B code) is issued by manual numerical command input.

The signal turns OFF when:
(1) "M function finish 1" signal (FIN1) or "M function finish 2" signal (FIN2) is sent back.
(2) Reset condition occurs.
(Refer to the "In auto operation "run"" signal (OP) section for details on the reset conditions.)

(Note 1) Only one 2nd M function can be issued in one block at a time.

The relation of the machining program and 2nd M function strobe is shown below.



(Note 2) The "2nd M function strobe 1" (BF1) is not output during operation with M function lock (AFL signal ON).
(Note 3) In the case of manual numerical command input, outputs are in accordance with "2nd M function strobe 1" (BF1).
(Note 4) Address for 2nd M function can be selected from addresses A, B and C by using Setup parameter. Set so that the address is different from the axis address.

[Related signals]

M function finish 1 (FIN1: Y226)
M function finish 2 (FIN2: Y227)

B contact	Signal name	Signal abbreviation	PC	1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE 2ND IN-POSITION			X240	UC0	X240	X580

[Function]

When the parameters are set, this function turns ON the PLC interface in-position signal and spindle monitor orientation complete signal, etc., when the spindle rotation speed enters the orientation in-position width ("#3204 SP004" OINP) and orientation advance in-position width ("#3301 SP101" DINP) during orientation.

The takt time can be shortened with this function since entry into the in-position width can be confirmed, and completion of orientation can be predicted.

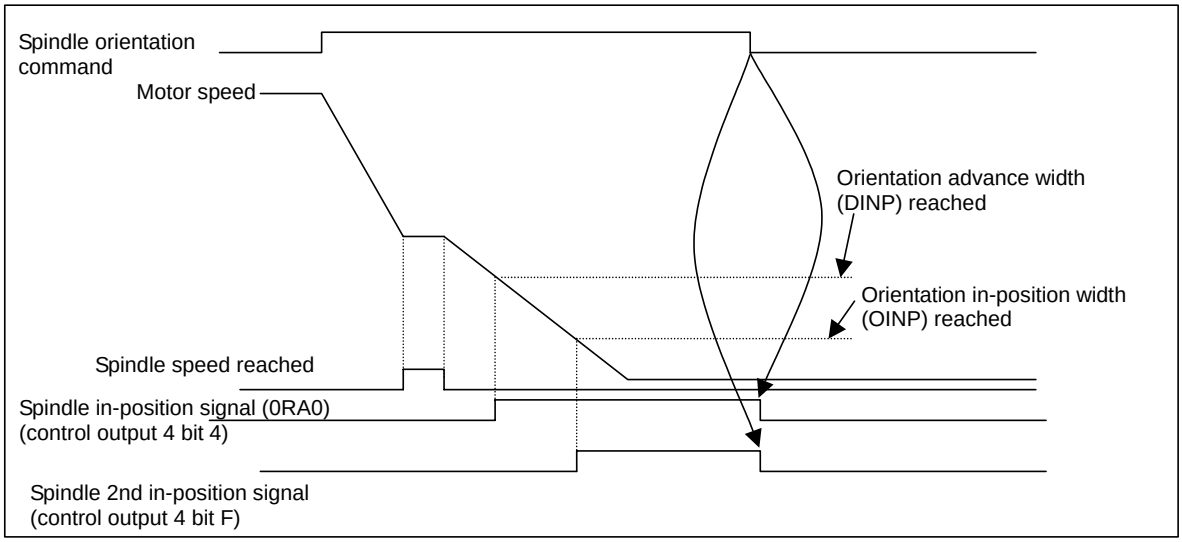
[Operation]

Within value set for orientation in-position advance width

→ Spindle in-position signal turns ON, and spindle monitor control output 4 bit 4 turns ON

Within value set for orientation in-position width

→ Spindle 2nd in-position signal turns ON, and spindle monitor control output 4 bit F turns ON



		Parameter in-position advance "#3297 SP097/bit2"	
		0: Invalid	1: Valid
Spindle 2nd in-position	0: Invalid	Spindle 2nd in-position signal = 0 Control output 4 bit F= 0 At OINP width, spindle in-position signal = 1 Control output 4 bit 4 = 1	Spindle 2nd in-position signal = 0 Control output 4 bit F= 0 At DINP width, spindle in-position signal = 1 Control output 4 bit 4 = 1
	1: Valid		At DINP width, spindle in-position signal = 1 Control output 4 bit 4 = 1 At OINP width, spindle 2nd in-position signal = 1 Control output 4 bit F = 1

[Related signals]

Spindle in-position (ORAO: X246)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	CURRENT DETECT	CDO	PC	X241	UC1	X241	X581

[Function]

This signal is output from the high-speed serial connection specification spindle controller (spindle drive) and informs that drive motor current is about to reach the permissible maximum current. The signal can be used to prevent stabbing of cutter into workpiece, for example.

[Operation]

The signal (CDO) turns ON if motor current goes up to a level (110% output) close to the permissible maximum current (120%).

(Note 1) This signal is valid only for the system that is high-speed serial connection with the controller.

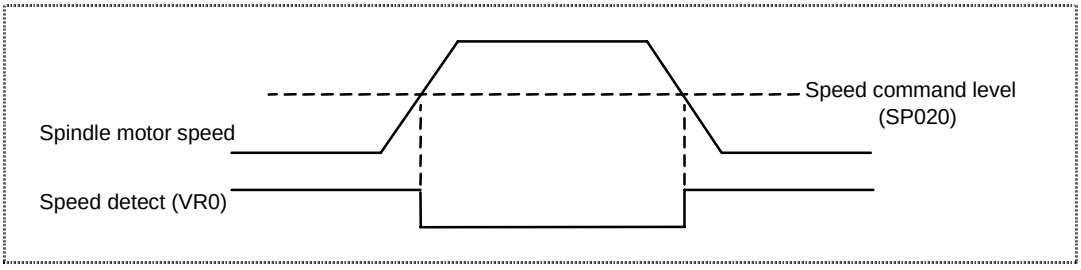
B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPEED DETECT	VRO	PC	X242	UC2	X242	X582

[Function]

This signal is output from the high-speed serial connection specification spindle controller (spindle drive) and informs that motor speed is dropped below the speed specified by parameter.

[Operation]

The signal (VRO) turns ON when motor speed (motor rotation speed) drops below the speed specified by parameter "#3220 SP020 (Speed detection set value)".



(Note 1) This signal is valid only for the system that is high-speed serial connection with the controller.

[Related signals]

Speed detect 2 (SD2: X1D5)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	IN SPINDLE ALARM	FLO	—	X243	UC3	X243	X583

[Function]

This signal is output from the high-speed serial connection specification spindle controller (spindle drive) and informs that failure occurs in spindle controller.

[Operation]

The signal turns ON if alarm which occurs in the spindle controller is detected.

To cancel alarm, reset the controller (by reset & rewind), turn the controller power OFF or turn the spindle controller power supply OFF. Note that reset method depends on type of alarm.
Typical examples of alarm are listed below. For details of alarm contents and cancel procedure, refer to the Spindle Controller specifications and maintenance manual.

(1) Overcurrent
(2) Breaker trip
(3) Motor overheat

(Note 1) This signal is valid only for the system that is high-speed serial connected with the controller.

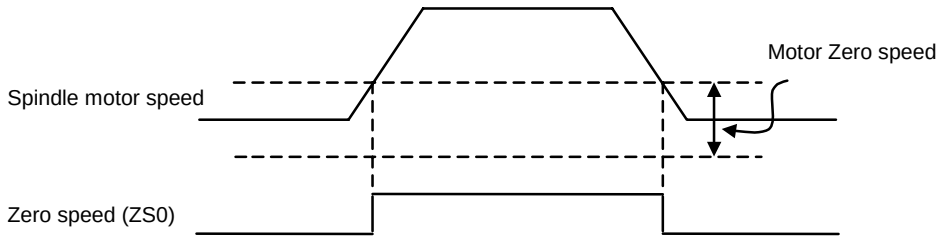
B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	ZERO SPEED	ZSO	—	X244	UC4	X244	X584

[Function]

This signal is output from the high-speed serial connection specification spindle controller (spindle drive) and informs that motor speed has dropped below the set speed level.

[Operation]

This signal turns ON when the actual spindle motor speed drops below the speed set in the spindle parameter "#3218 (motor zero speed)".



(Note 1) The signal is output, no matter whether direction of rotation is "Spindle forward run start" (SRN) or "Spindle reverse run start" (SRI).
(Note 2) Minimum output pulse width of the signal is about 200ms.
(Note 3) Speed at which the signal is output can be set within range from 1r/min to 1000r/min with the spindle parameters.
(Note 4) This signal is valid only for the system that is high-speed serial connected with the controller

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	UP-TO-SPEED	USO	—	X245	UC5	X245	X585

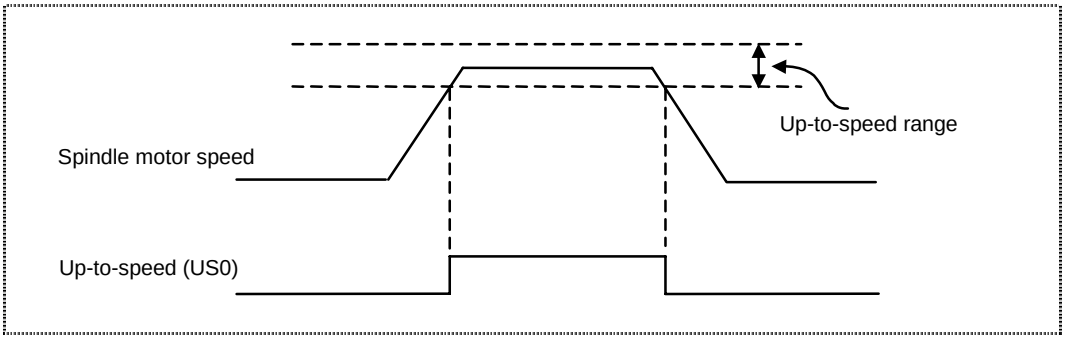
[Function]

This signal is output from the high-speed serial connection specification spindle controller (spindle drive) and informs that actual spindle motor speed reaches the range set with the parameter SP048 (standard setting ±15%).

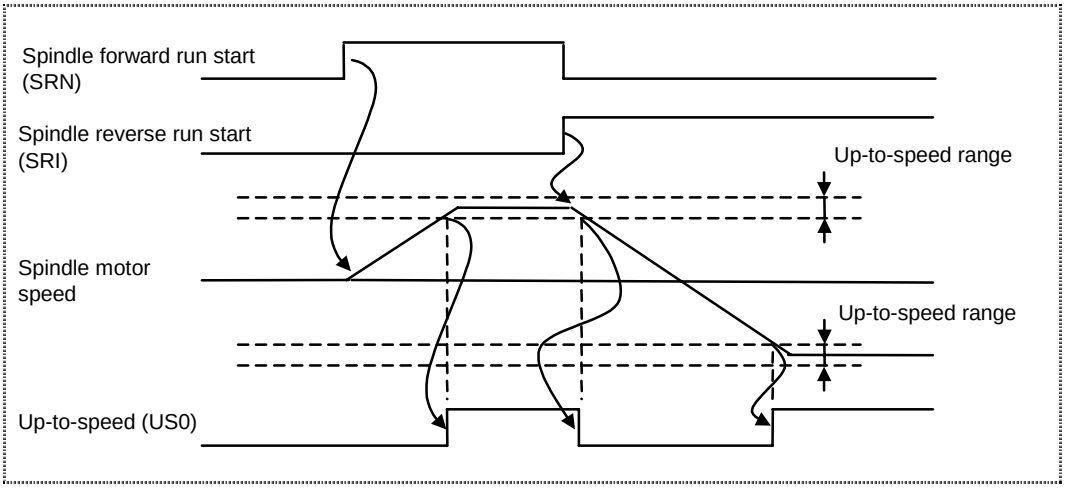
This signal is used for the S command complete conditions or control axis interlock during automatic operation.

[Operation]

The up-to-speed signal (USO) turns ON when an alarm is detected on the spindle controller side.



When a command is given to change motor rotation from "forward" to "reverse", spindle motor speed starts going down and the signal (USO) is turned OFF. When motor speed enters the specified detection range, the signal turns ON.



(Note 1) The signal cannot be output if neither "Spindle forward run start" (SRN) signal nor "Spindle reverse run start" (SRI) signal is ON.

(Note 2) This signal is not output when operating with a command that is not a speed command such as synchronous tap.

(Note 3) This signal is valid only for the system that is high-speed serial connected with the controller.

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE IN-POSITION	ORAO	—	X246	UC6	X246	X586

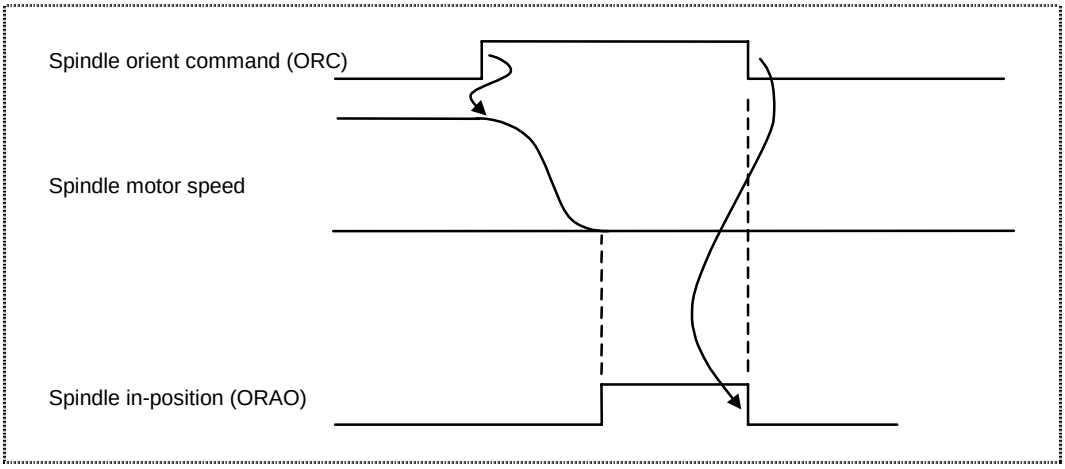
[Function]

This signal is output from the high-speed serial connection specification spindle controller (spindle drive) and informs that the spindle is positioned in the set range in accordance with spindle orient command.

[Operation]

When the spindle positioning in the set range completes, this signal will turn ON. The spindle orientation is stored by "Spindle orient command" signal (ORC).

(1) The in-position range is set with the spindle parameters.
(2) While the spindle is in position, it is under servo lock condition. However, if the spindle is rotated by external force, the signal (ORAO) may be turned OFF.
(3) The signal is turned OFF when the "Spindle orient command" (ORC) is turned OFF.



(Note 1) When spindle orient command is given, orientation starts regardless of the "Spindle forward run start (SRN)" or "Spindle reverse run start (SRI)".
(Note 2) Range of in-position can be set within range from 0.001 to 99.999 degrees.
(Note 3) This signal is valid only for the system that is high-speed serial connected with the controller.

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	IN L COIL SELECTED	LCSA	P C	X247	UC7	X247	X587

[Function]

This signal indicates that the low-speed coil is being selected in the spindle coil changeover function.

[Operation]

The high-speed coil and low-speed coil are changed over only with the "L coil selection" (LRSL) in the 2-step coil changeover specification. The high-speed coil, middle-speed coil and low-speed coil are changed over with the combination of the "L coil selection" (LRSL) and "M coil selection" (LRSM) in the 3-step coil changeover specification.

(1) 2-step coil changeover

Selected coil	**L coil selection** (LRSL)	**In L coil selected** (LCSA)
High-speed (H)	OFF	OFF
Low-speed (L)	ON	ON

(2) 3-step coil changeover

Selected coil	**L coil selection** (LRSL)	**M coil selection** (LRSM)	**In L coil selected** (LCSA)	**In M coil selected** (MCSA)
High-speed (H)	OFF	OFF	OFF	OFF
Middle-speed(M)	OFF	ON	OFF	ON
Low-speed(L)	ON	OFF	ON	OFF
	ON	ON	ON	ON

[Related signals]

L coil selection (LRSL: Y2D7)
M coil selection (LRSM: Y2DE)
In M coil selected (MCSA: X1D6)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE READY-ON	SMA	P C	X248	UC8	X248	X588

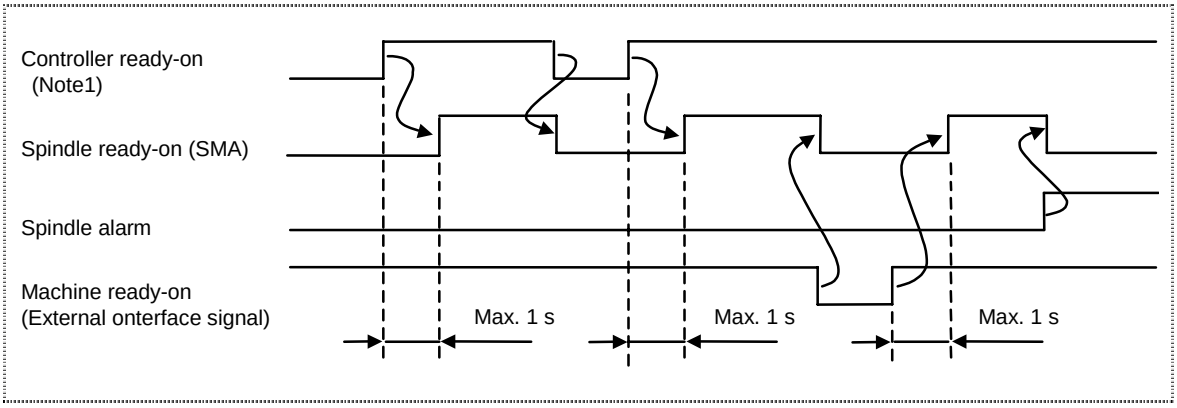
[Function]

This signal is output from the high-speed serial connection specification spindle controller (spindle drive) and informs that the spindle can operate.

[Operation]

This signal (SMA) turns ON when the spindle controller is ready for operation. The signal turns OFF (ready off) in the following conditions.

(1) A spindle alarm is generated.
(2)"Ready-on" signal (internal signal) from controller is OFF.
(3) The "Machine ready-on" signal that is an external interface (DIO input) signal of the spindle controller is OFF.
(The machine ready signal can be invalidated with the spindle controller parameters.)



(Note 1) The ready on signal is output from the controller to the spindle controller.
(Note 2) This signal is valid only for the system that is high-speed serial connected with the controller.

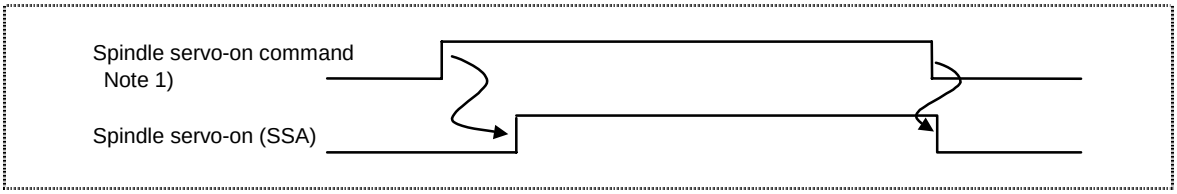
B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE SERVO-ON	SSA	P C	X249	UC9	X249	X589

[Function]

This signal is output from the high-speed serial connection specification spindle controller (spindle drive) and informs that the spindle is under the position control state (synchronous tap control, C-axis control).

[Operation]

The "Spindle servo-on" signal (SSA) turns ON when the spindle is ready (SMA signal is ON), the servo-on command has been transferred from the controller to the spindle controller, and the spindle controller is in the servo-on state.
This signal (SSA) turns OFF when the servo-on command is canceled.



(Note 1) The spindle servo-on command is output from the controller to the spindle controller, and is mainly output during synchronous tap control.
(Note 2) While the "Spindle servo-on" signal is ON, all input signals for "Spindle forward run start" (SRN), "Spindle reverse run start" (SRI), and "Spindle orient command" (ORC) are ignored.
(Note 3) This signal is valid only for the system that is high-speed serial connected with the controller.

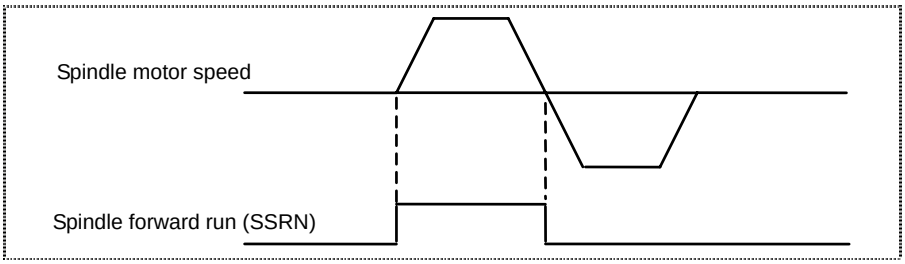
B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE FORWARD RUN	SSRN	PC	X24B	UCB	X24B	X58B

[Function]

This signal is output from the high-speed serial connection specification spindle controller (spindle drive) and informs that the spindle is rotating in the forward direction.

[Operation]

The "Spindle forward run" signal (SSRN) turns ON when the spindle motor is rotating in the forward direction. This will also turn OFF if the spindle motor is rotating in the forward direction during orientation or synchronous tap.



(Note 1) The "Spindle forward run" signal (SSRN) turns ON and OFF while the spindle motor is in the stop state with servo features during oriented motion or synchronous tap.

(Note 2) This signal is valid only for the system that is high-speed serial connected with the controller.

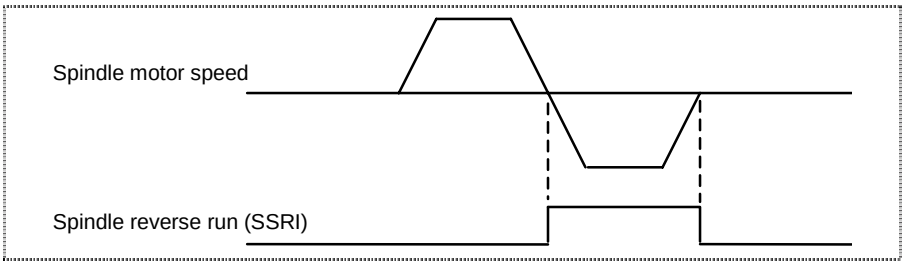
B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE REVERSE RUN	SSRI	PC	X24C	UCC	X24C	X58C

[Function]

This signal is output from the high-speed serial connection specification spindle controller (spindle drive) and informs that the spindle motor is rotating in the reverse direction.

[Operation]

The "Spindle reverse run" (SSRI) signal turns ON when the spindle motor rotates in the reverse direction. It also turns ON even during oriented motion or synchronous tap if the spindle rotates in the reverse.



(Note 1) The "Spindle reverse run" (SSRI) signal turns ON and OFF while the spindle motor is in the stop state with servo features during oriented motion or synchronous tap.

(Note 2) This signal is valid only for the system that is high-speed serial connected with the controller.

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	Z-PHASE PASSED	SZPH	P C	X24D	UCD	X24D	X58D

[Function]

This signal is output from the spindle controller (spindle drive) for the MELDAS AC spindle drive high-speed serial connection specification, and informs that the encoder's Z phase has been passed when changing the spindle to the positioning control from the speed control during the C axis control.

[Operation]

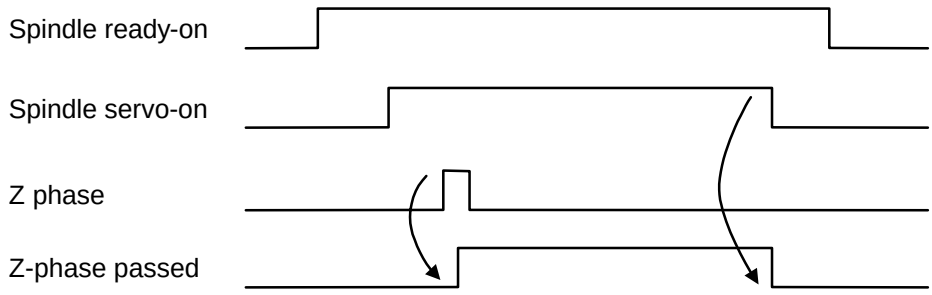
The signal will turn ON when:

(1) The Z phase is passed during the C axis control.

The signal will turn OFF when:

(1) The "Spindle servo-on" signal turns OFF.

(2) The "Spindle ready-on" signal turns OFF.



(Note 1) This signal is valid only for the system in which the control unit and spindle controller are high-speed serial connected.

B contact	Signal name	Signal abbreviation	P C	1st spindle	2nd spindle	1st spindle	2nd spindle
—	POSITION LOOP IN-POSITION	SIMP		X24E	UCE	X24E	X58E

[Function]

If the spindle controller is connected with high-speed serial connection, this signal will inform that the spindle is in the in-position state during synchronous tap.

[Operation]

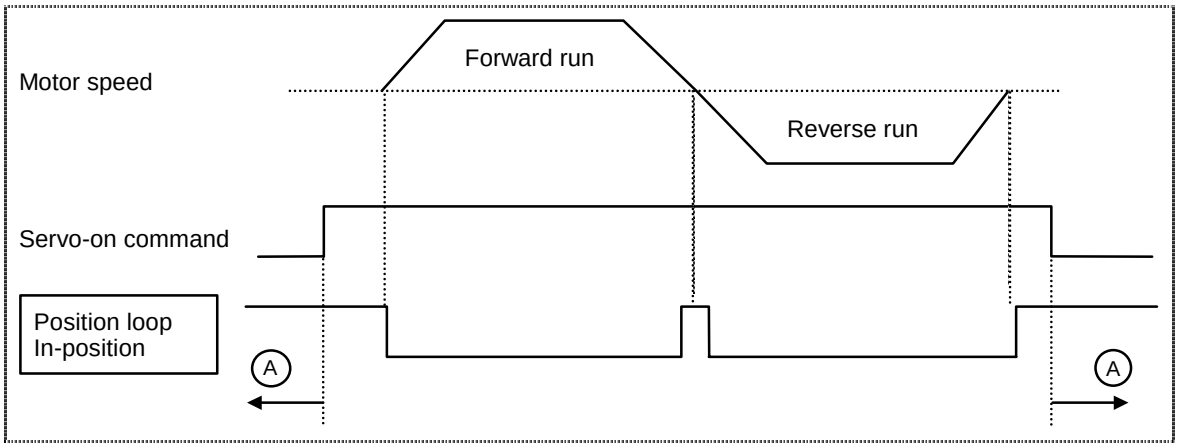
The signal will turn ON when:

(1) The droop amount (servo tracking delay error) is within the in-position range during synchronous tap control (servo on).

(2) Synchronous tap control is not commanded. (Ⓐ in following drawing)

The signal will turn OFF when:

(1) The droop amount (servo tracking delay error) has exceeded the in-position range during synchronous tap control (servo on).



B contact	Signal name	Signal abbreviation	P C	1st spindle	2nd spindle	1st spindle	2nd spindle
—	TORQUE LIMIT	STLQ		X24F	UCF	X24F	X58F

[Function]

This signal is output from the high-speed serial connection specification spindle controller (spindle drive) and informs that the spindle is in position under C-axis control or synchronous tap control.

[Operation]

The "STLQ" signal turns ON when:

(1) Torque limit 1 (TL1) or torque limit 2 (TL2) signal is ON.

The "STLQ" signal turns OFF when:

(1) Torque limit 1 (TL1) or torque limit 2 (TL2) signal is OFF.

(Note 1) This signal is valid only for the system that is high-speed serial connected with the controller.

[Related signals]

Torque limit 1 (TL1: Y2D2)
Torque limit 2 (TL2: Y2D3)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN CHOPPING START	CHOP	PC	X260	UE0	X260	X5A0

[Function] [Operation]
For both the function and operation, refer to the section "Chopping" signal (Y1E8).

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	BASIC POSITION – UPPER DEAD CENTER POINT	CHP1	PC	X261	UE1	X261	X5A1

[Function] [Operation]
For both the function and operation, refer to the section "Chopping" signal (Y1E8).

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	UPPER DEAD CENTER POINT – BOTTOM DEAD CENTER POINT	CHP2	PC	X262	UE2	X262	X5A2

[Function] [Operation]
For both the function and operation, refer to the section "Chopping" signal (Y1E8).

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	BOTTOM DEAD CENTER POINT – UPPER DEAD CENTER POINT	CHP3	PC	X263	UE3	X263	X5A3

[Function] [Operation]
For both the function and operation, refer to the section "Chopping" signal (Y1E8).

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	UPPER DEAD CENTER POINT – BASIC POSITION	CHP4	PC	X264	UE4	X264	X5A4

[Function] [Operation]
For both the function and operation, refer to the section "Chopping" signal (Y1E8).

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN CHOPPING MODE	CHPMD	PC	X265	UE5	X265	X5A5

[Function] [Operation]
For both the function and operation, refer to the section "Chopping" signal (Y1E8).

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	LOAD MONITOR IN TEACHING/MONITOR EXECUTION		P C	X268	UE8	X268	X5A8

[Function]

This signal indicates that teaching or monitor is being executed.

[Operation]

This signal turns ON when the teaching/monitor execution signal is input.

[Related signals]

Load monitor Teaching mode valid, Monitor mode valid (X269, X26A)
Load monitor Warning axis, Alarm axis, Data alarm information (R52 to R54)
Load monitor Teaching/monitor execution, Teaching mode select, Monitor mode select, Alarm reset, Warning reset (Y313 to Y317)
Load monitor Axis selection, Load change rate detection axis, Teaching data sub-No. (R116 to R118)
Load monitor status (R670 to R679)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	LOAD MONITOR TEACHING MODE VALID		P C	X269	UE9	X269	X5A9

[Function]

This signal indicates that the teaching mode is selected.

[Operation]

This signal turns ON when the teaching mode signal is input.

[Related signals]

Load monitor In teaching/monitor execution, Monitor mode valid (X268, X26A)
Load monitor Warning axis, Alarm axis, Data alarm information (R52 to R54)
Load monitor Teaching/monitor execution, Teaching mode select, Monitor mode select, Alarm reset, Warning reset (Y313 to Y317)
Load monitor Axis selection, Load change rate detection axis, Teaching data sub-No. (R116 to R118)
Load monitor status (R670 to R679)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	LOAD MONITOR MONITOR MODE VALID		P C	X26A	UEA	X26A	X5AA

[Function]
This signal indicates that the monitor mode is selected.

[Operation]
This signal turns ON when the monitor mode signal is input.

[Related signals]
Load monitor In teaching/monitor execution, Teaching mode valid (X268, X269)
Load monitor Warning axis, Alarm axis, Data alarm information (R52 to R54)
Load monitor Teaching/monitor execution, Teaching mode select, Monitor mode select, Alarm reset, Warning reset (Y313 to Y317)
Load monitor Axis selection, Load change rate detection axis, Teaching data sub-No. (R116 to R118)
Load monitor status (R670 to R679)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ADAPTIVE CONTROL VALID		P C	X26B	UEB	X26B	X5AB

[Function]
This signal indicates that adaptive control is selected.

[Operation]
This signal turns ON when the adaptive control execution signal is turned ON during monitor execution.

[Caution]
This signal is valid only for MELDAS65 System.

[Related signals]
Adaptive control execution (Y349)
Adaptive control override output (R59)
Adaptive control basic axis selection (R119)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TAP RETRACT POSSIBLE	TRVE	P C	X26D	UED	X26D	X5AD

[Function]

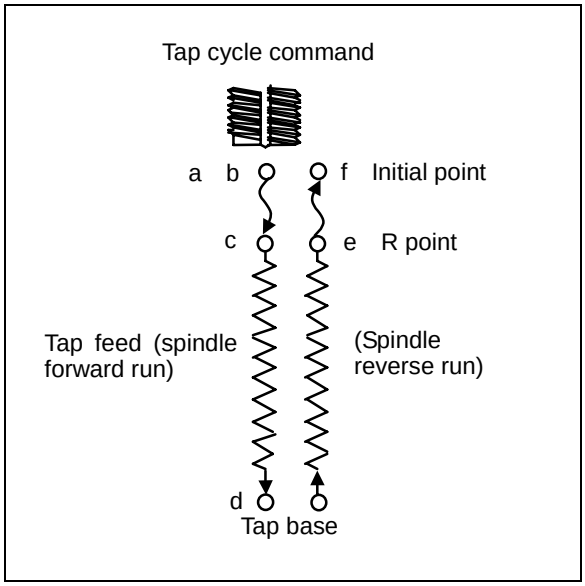
This signal informs that tap retract is possible, and is output if operation is stopped during tap cycle execution.

The "Tap retract" signal (TRV) will be valid when this signal (TRVE) is ON.

[Operation]

(1) This signal turns ON when tap cycle is stopped in the cutting feed area (between c-d-e in the drawing) due to the following causes:
- Emergency stop.
- Reset stop.
- Power OFF (only in absolute position detection system).

(2) This signal turns OFF in the following cases:
- Tap retract is executed and completed.
- Tap axis is moved manually or with manual mode.



[Related signal]

Tap retract (TRV: Y29C)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	NO. OF WORK MACHINING OVER	PCNT	PC	X26E	UEE	X26E	X5AE

[Function]

This signal is output when the No. of work machining matches or exceeds the maximum No. of work machining.

[Operation]

This signal turns ON when the No. of work machining matches or exceeds the maximum work value (WRK LIMIT) set in the [Process parameter] screen.

(Note 1) This signal turns ON when the No. of work machining matches or exceeds the maximum work value regardless of the count up by the controller or user PLC.

(Note 2) This signal is not output when "0" is set for the maximum work value.

[Related signals]

(1) No. of work machining (current value) (R2896, 7)
(2) No. of work machining (max. value) (R2898, 9)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ABSOLUTE POSITION WARNING	ABSW	PC	X26F	UEF	X26F	X5AF

[Function]

This signal notifies that the amount moved while the power is OFF has exceeded to the tolerable amount when using the absolute position detection system.

[Operation]

This signal turns ON when the difference of the machine position at power OFF and at power ON exceeds the tolerable value ([ABS. POSI PARAM] #2051 (check) setting value) when using the absolute position detection system.

(Note) The movement amount during power OFF depends on the "PON POS (power ON position)" and "POF POS (power OFF position)" on the [ABS SERVO MONITOR (absolute position monitor)] screen.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	POSITION SWITCH 1 to 8	PSW1 to 8	P C	X270 to 7	UF0 to 7	X270 to 7	X5B0 to 7

[Function]

This signal notifies that the machine position is within the area set by the parameters.

[Operation]

This signal turns ON when the control axis machine position reaches the range set by the parameters, and turns OFF when the range is left. The axis name and range are set in parameters #7501 to #7573.
The validity of this signal differs in the following manner depending on the absolute position detection or incremental detection.

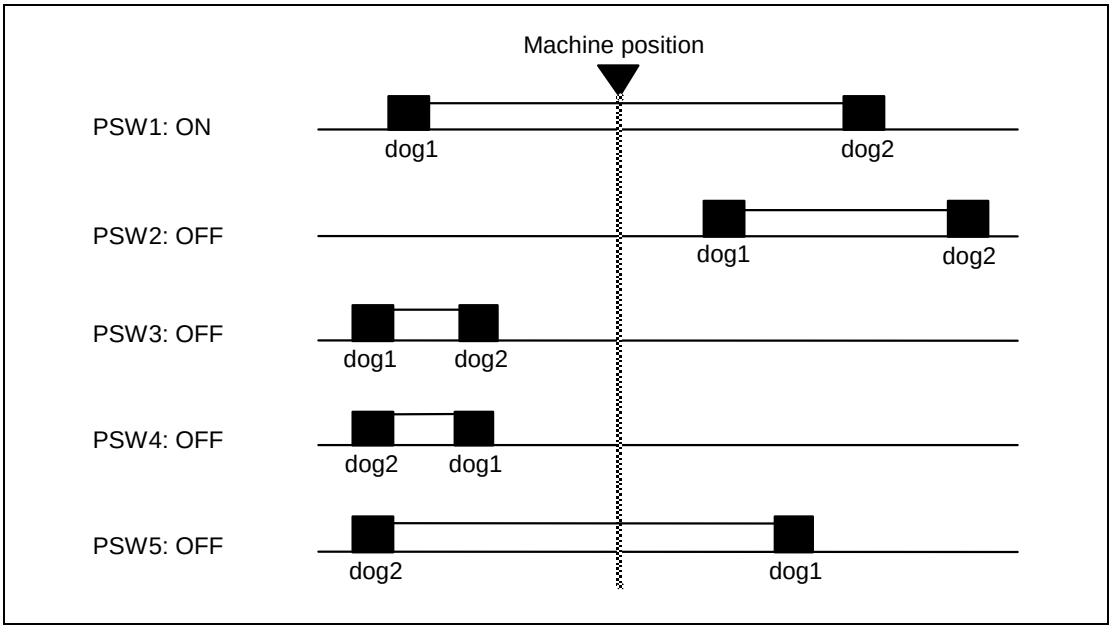
<For absolute position detection system>

This signal is valid when the power is turned ON after zero point initialization is completed.

<For incremental position detection system>

This signal is not validated until the first reference position return is completed after the power is turned ON. (PSW1 to PSW8 will all remain OFF until this signal is validated.)

[Example of signal output]



The setting range of the position switch uses the basic machine coordinate system as a reference.
The dog1 and dog2 setting values can be set to any size, and the area between the smaller setting and the larger setting will be used as the signal output range.
A slight delay will occur in the output signal fluctuation due to the actual machine position. The maximum delay time is as follows.

$$tmax = 0.06 \quad -TP \ [s]$$

TP: Position loop time constant ($\frac{1}{PGN}$ [s])

PNG: Position loop gain

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ZERO POINT INITIALIZATION SET COMPLETED nth AXIS	ZSF1 to 8	P C	X280 to 7	U100 to 7	X280 to 7	X5C0 to 7

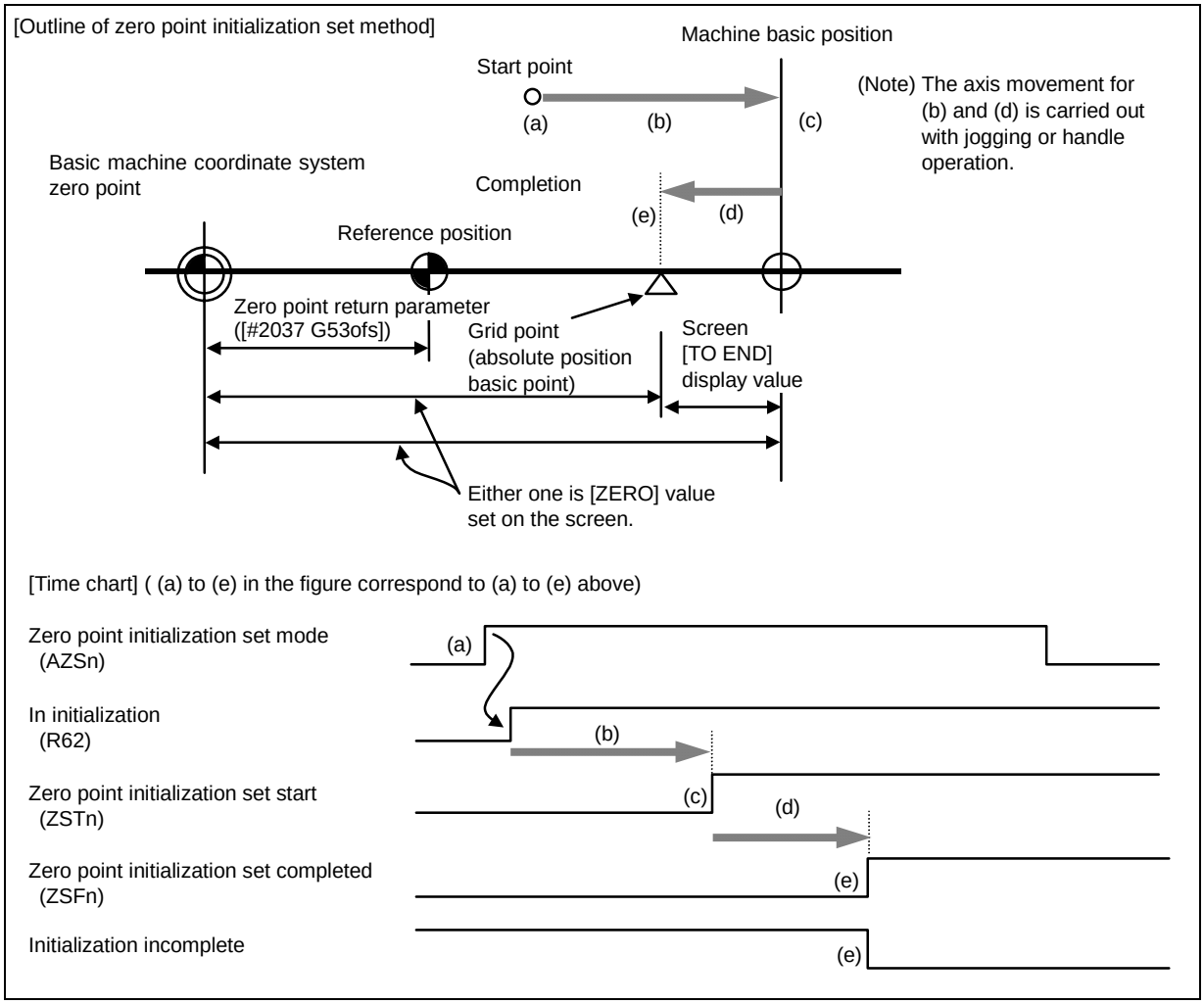
[Function]

This signal notifies that the basic machine coordinate system has been set (established) during zero point initialization set using the marked point alignment method in the absolute position detection system.

[Operation]

This signal is valid when "#2049 TYPE" on the [ABS. POSI PARAM] screen is set to "2", and turns ON when the basic machine coordinate system is set (established).
This signal will turn OFF if initializing is carried out again or if the power is turned ON again.

<Zero point initialization set method using marked point alignment method, and time chart>



[Related signals]

(1) Zero point initialization set error completed (ZSE1 to 8: X288)
(2) In initialization (R62)
(3) Initialization incomplete (R63)
(4) Zero point initialization set mode (AZS1 to 8: Y300)
(5) Zero point initialization set start (ZST1 to 8: Y308)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ZERO POINT INITIALIZATION SET ERROR COMPLETED nth AXIS	ZSE1 to 8	PC	X288 to F	U108 to F	X288 to F	X5C8 to F

[Function]

This signal is output when initializing is not possible during the marked point alignment method of the absolute position detection system.

[Operation]

This signal turns ON when the initializing is not possible at the rising edge of the "Zero point initialization set start" (ZSTn) signal.

This signal is invalidated in the following cases:

- During emergency stop
- During reset
- When "Zero point initialization set start" (ZSTn) signal is turned ON before the "Zero point initialization set mode" (AZSn) signal
- When grid has not been passed even once after the power has been turned ON. (Depends on the detector type)

[Related signals]

(1) Zero point initialization set completed (ZSF1 to 8: X280)
(2) In initialization (R62)
(3) Initialization incomplete (R63)
(4) Zero point initialization set mode (AZS1 to 8: Y300)
(5) Zero point initialization set start (ZST1 to 8: Y308)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN POLYGON MODE (SPINDLE-NC AXIS)		PC	X2A0	U120	X2A0	X5E0

[Function]

This signal informs the PLC that polygon machining (spindle-NC axis) mode is entered.

(Note) Refer to the "in polygon mode (spindle-spindle) " signal for details on the spindle-spindle polygon.

#1501 polyax $\neq$ 0: Polygon machining (spindle-NC axis)
= 0: Spindle-spindle polygon (spindle-spindle)

[Operation]

This signal is turned ON by the polygon machining start command (G51.2), and is held during the polygon machining mode.

This signal is turned OFF when the polygon machining mode is canceled (G50.2, reset, etc.), and remains OFF in modes other than the polygon machining mode.

[Related signals]

In polygon mode (spindle-spindle) (X2A2)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	NC ALARM 5	AL5	—	X2A1	U121	X2A1	X5E1

[Function]

This signal informs that the controller is in operation alarm (error) condition.

[Operation]

The signal turns ON when:

• The parameter "#1238 set10/bit7" is ON and the operation alarms below occur.

The signal turns OFF when:

• The parameter "#1238 set10/bit7" is OFF.

• The parameter "#1238 set10/bit7" is ON and the operation alarm conditions below do not exist.

For details on the operation alarms, refer to “Alarm/Parameter Manual”.

<Operation alarms output to NC alarm 5 >

• External interlock (M01 0004)
• Override zero (M01 0102)
• External feed speed zero (M01 0103)
• Block start interlock (M01 0109)
• Cutting block start interlock (M01 0110)
• Spindle-spindle polygon (G51.2) cutting interlock (M01 1033)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN POLYGON MODE (SPINDLE-SPINDLE)		PC	X2A2	U122	X2A2	X5E2

[Function]

This signal informs that the spindle-spindle polygon machining mode is being executed.

(Note) Refer to the explanation of "in polygon mode (spindle-NC axis)" signal for details on the spindle-NC axis polygon.

#1501 polyax $\neq$ 0: Polygon machining (spindle-NC axis)

= 0: Spindle-spindle polygon (spindle-spindle)

[Operation]

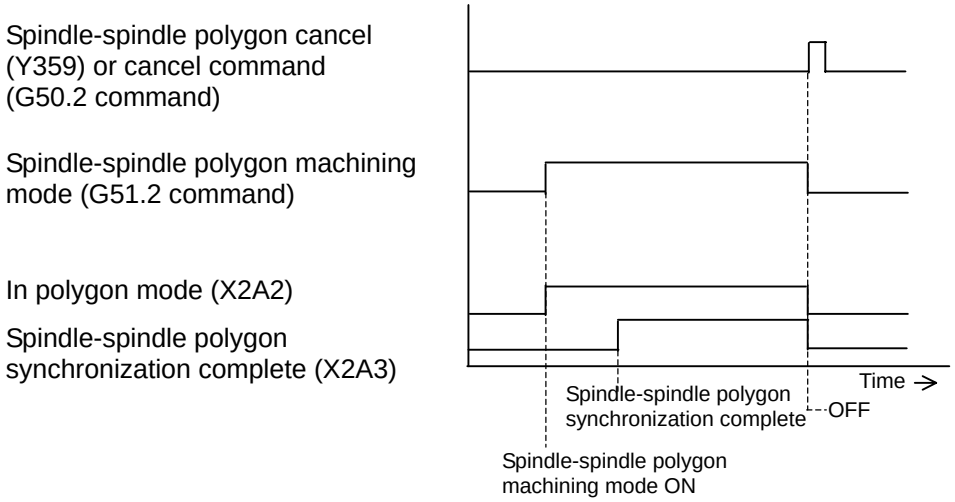
The signal turns ON when:

• The G51.2 is commanded, and the spindle-spindle polygon machining is executed.

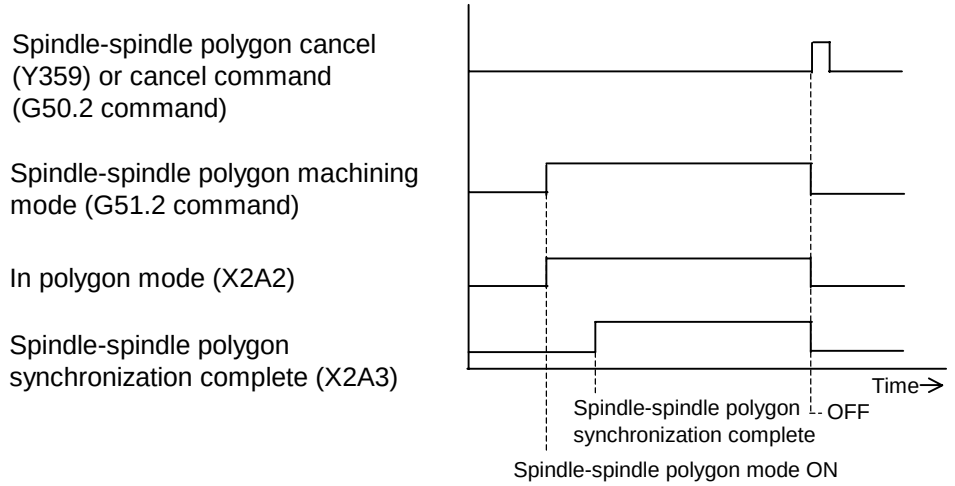
The signal turns OFF when:

• The G50.2 is commanded, and the spindle-spindle polygon machining is canceled.
• The "Spindle synchronization cancel" signal is input, and the spindle-spindle polygon machining is canceled.
• "Emergency stop" occurs.
• "Reset" is input.

(1) Spindle-spindle polygon machining (with phase error)



(2) Spindle-spindle polygon machining (no phase error)



[Related signals]

Spindle-spindle polygon cancel (Y359)
In polygon mode (Spindle-NC axis) (X2A0)
Spindle-spindle polygon synchronization complete (X2A3)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE-SPINDLE POLYGON SYNCHRONIZATION COMPLETE		P C	X2A3	U123	X2A3	X5E3

[Function]

This signal informs that the workpiece spindle and rotary tool spindle are in the synchronized rotation state.

[Operation]

The signal turns ON when:

- The rotary tool spindle rotation speed, in respect to the rotation speed following the rotary tool spindle and workpiece spindle rotation ratio command, reaches the value set for the spindle-spindle polygon synchronization rotation speed attainment level during the spindle-spindle polygon machining mode.

The signal turns OFF when:

- The rotary tool spindle rotation speed, in respect to the rotation speed following the rotary tool spindle and workpiece spindle rotation ratio command, deviates from the value set for the spindle-spindle polygon synchronization rotation speed attainment level during the spindle-spindle polygon machining mode.
- The spindle-spindle polygon synchronization mode is canceled.

[Related signals]

Spindle-spindle polygon cancel (Y359)
In polygon mode (spindle-spindle) (X2A2)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	UP-TO-SPEED n-TH AXIS	ARRFn	P C	X2B0 to 7	U130 to 7	X2B0 to 7	X5F0 to 7

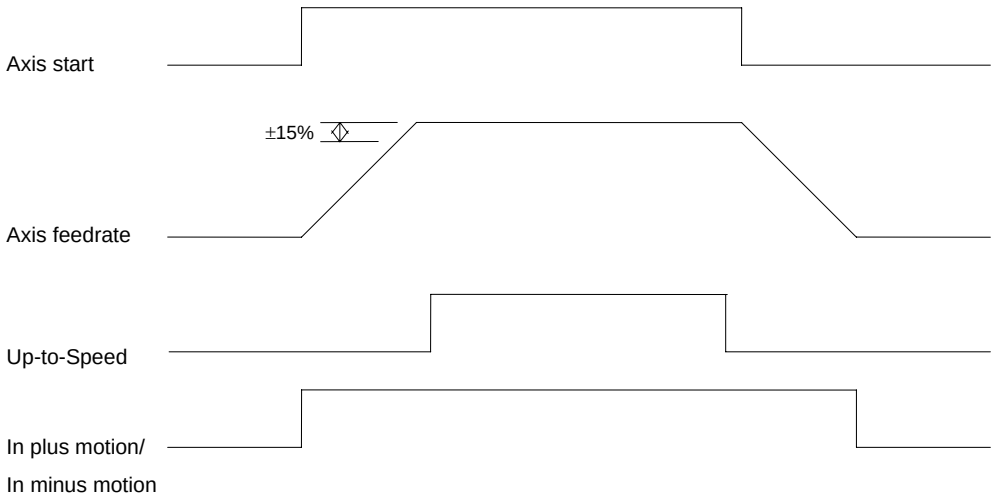
[Function]

This signal indicates that the actual axis feedrate has reached the feedrate commanded for each axis.

ARRFn
- 0: 1st axis speed reached
- 1: 2nd axis speed reached
- 2: 3rd axis speed reached
- :
- 7: 8th axis speed reached

[Operation]

This signal turns ON when the difference of the speed commanded for each axis and the motor feedback feedrate is within a set range (approx. ±15%).
This signal turns OFF when the speed difference exceeds the set range.



[Related signals]

In plus motion +nth axis (MVP1 to 8: X190 to 7)
In minus motion -nth axis (MVM1 to 8: X198 to F)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	UNCLAMP COMMAND		P C	X2B8 to F	U138 to F	X2B8 to F	X5F8 to F

[Function]

This signal is output when movement of the axis selected as the index table indexing axis is commanded.

[Operation]

When this signal turns ON, the index table indexing axis clamp is released by the ladder, and the unclamp complete signal is set.
This signal turns OFF when movement of the index table indexing axis is completed.

The signal turns ON when:

- Movement of the indexing axis is commanded during automatic operation.

This signal turns OFF when:

- Movement of the indexing axis is completed during automatic operation.
- The axis movement is forcibly ended with reset or emergency stop, etc.

(Note 1) The index command will not turn OFF if the axis movement is interrupted with an interlock or automatic operation pause, etc.

(Note 2) This signal is turned ON and OFF when the index table indexing axis acceleration/deceleration has completed.
Thus, if the in-position has to be confirmed during the clamp/unclamp operation, confirm with the PLC.

[Related signals]

Unclamp complete (Y338 to Y33F)

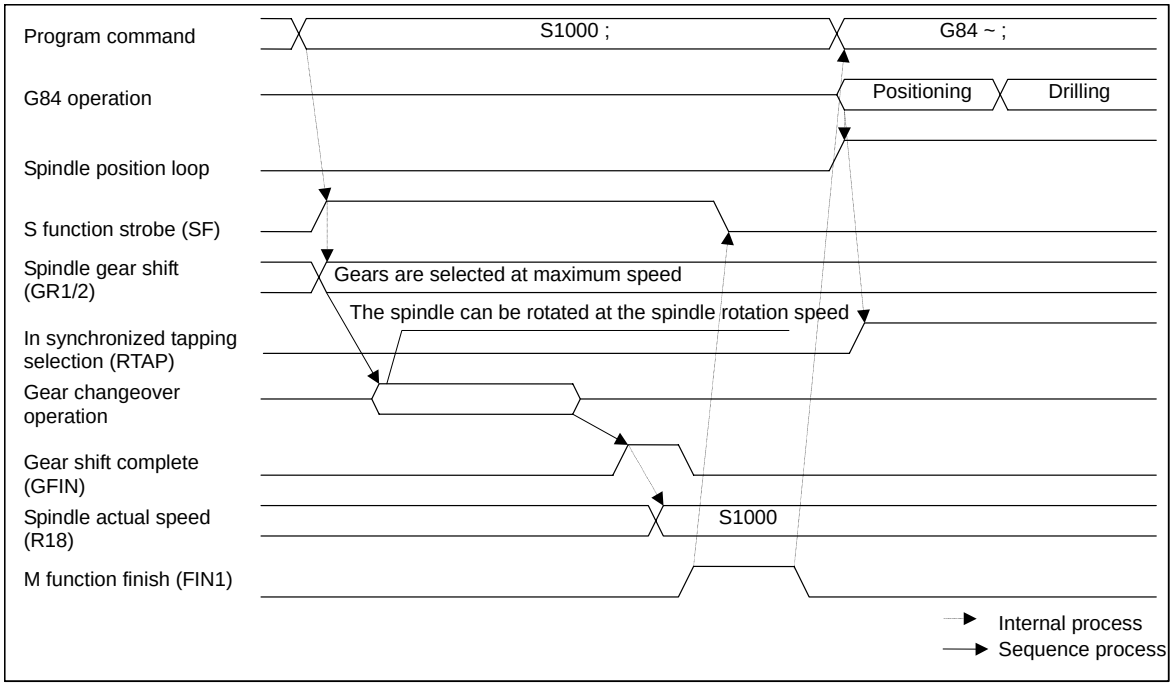
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN SYNCHRONIZED TAPPING SELECTION (M COMMAND)	RTAP	P C	X2C0	U140	X2C0	X600

[Function]

This signal informs that the synchronized tapping mode is active.
(This signal is output only when the M function synchronized tapping cycle valid parameter (#1272 ext08 bit1) is ON.)

[Operation]

(1) ON timing

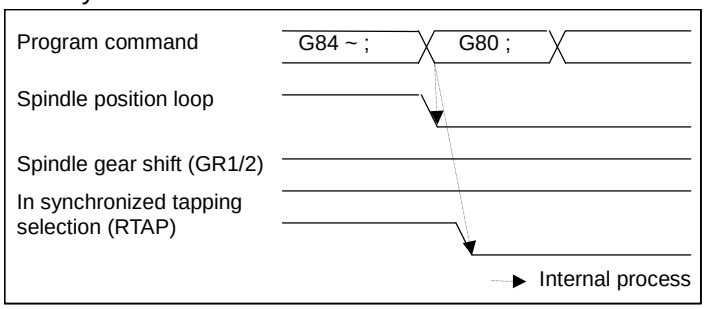


(Note 1) Spindle position loop and in synchronized tapping selection turn ON only during synchronized tapping.

(Note 2) If synchronized tapping is applied even during tap retract, "in synchronized tapping selection" signal will turn ON.

(2) OFF timing

This signal turns OFF when reset, G80 (hole drilling fixed cycle cancel), 01 group G codes or other fixed cycle G codes are commanded.



(Note 1) The gears are not selected until the S command is issued again.

(Note 2) This signal turns OFF when tap retract is canceled or completed.

[Related signals]

Gear shift complete (Y225: GFIN)
Spindle actual speed (R18)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	INC HIGH-SPEED RETRACT FUNCTION VALID STATE		P C	X2C2	U142	X2C2	X602

[Function]

This signal informs that the INC high-speed retract function is valid.

[Operation]

This signal turns ON when the INC high-speed retract function valid signal is ON.
This signal turns OFF when the INC high-speed retract function valid signal turns OFF, or when the INC high-speed retract function option is not provided.

[Related signals]

In INC High-speed retract function operation (X2C3)
INC High-speed retract function valid (Y34C)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN INC HIGH-SPEED RETRACT FUNCTION OPERATION		P C	X2C3	U143	X2C3	X603

[Function]

This signal informs that the INC high-speed return function is in operation.

[Operation]

This signal turns ON when the INC high-speed retract function is valid, and a fixed cycle program (G81, G82, G83, G73), which carries out high-speed retract, is being executed. If this signal is ON while executing a fixed cycle program, high-speed retract operation will be executed.

[Related signals]

INC High-speed retract function valid state (X2C2)
INC High-speed retract function valid (Y34C)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE ENABLE	ENB	P C	X2C8	U148	X2C8	X608

[Function]

This signal informs whether there are command outputs to the spindle or not.
0: No command output to spindle
1: With command output to spindle

[Related signals]

(1) Spindle selection (SWS: Y350)
(2) Spindle command selection (SLSP: R110)
(3) Spindle stop (SSTP: Y294)
(4) Encoder selection (R124)
(5) Spindle forward run start (SRN: Y2D0)
(6) Spindle reverse run start (SRI: Y2D1)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN BARRIER VALID (left)		P C	X2D0	U150	X2D0	X610

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN BARRIER VALID (right)		P C	X2D1	U151	X2D1	X611

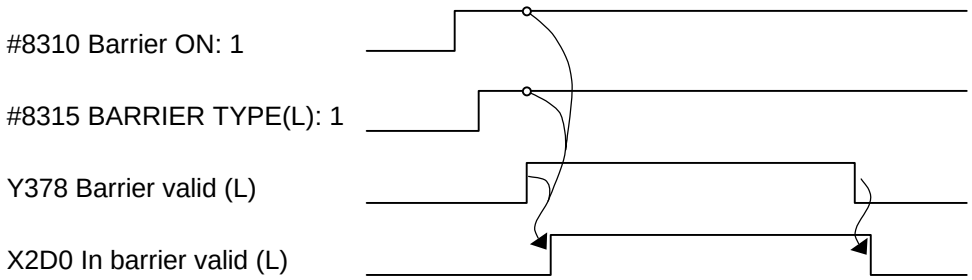
[Function]

This signal informs that the barrier area of left side (right side) is valid in the chuck•tailstock barrier function.

[Operation]

When all conditions below are satisfied and the barrier area is valid, this signal is turned ON. (When this signal is OFF, the barrier check is not executed.)

- The option of chuck barrier check function is valid.
- The setting of parameter "#8310 Barrier ON" on the barrier data screen is "1". (Excluding when using the special display unit)
- The setting of parameter "#8315 BARRIER TYPE (L)" ("#8316 BARRIER TYPE (R)") on the barrier data screen is other than "0".
- The "Barrier valid" signal input above is ON, or the G22 modal is valid.



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN CROSS MACHINING CONTROL nth AXIS		P C	X2E0 to 7	U160 to 7	X2E0 to 7	X620 to 7

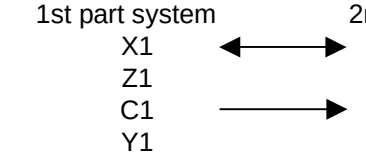
[Function]

This signal is a status signal that indicates a state commanded by the "Cross machining control request" signal.

[Operation]

The axis in the cross machining control is "1".

(Example)



(1) Cross machining between X1 and X2:
X2E0 and U160 are "1".

(2) When C1 is controlled in 2nd part system:
X2E2 and U162 are "1".

[Related signals]

Cross machining control request nth axis (Y360 to 7)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN SYNCHRONOUS/ SUPERIMPOSITION CONTROL nth AXIS		P C	X2E8 to F	U168 to F	X2E8 to F	X628 to F

[Function]

This signal informs the axis in the synchronous control/superimposition control.
0: Axis not in synchronous control/superimposition control
1: Axis in synchronous control/superimposition control

[Operation]

The synchronous axis/superimposing axis and synchronization basic axis/superimposition basic axis are indicated during the synchronous control/superimposition control.

[Related signals]

(1) Synchronous control request nth axis (Y3A8 to F)
(2) Superimposition control request nth axis (Y3B0 to 7)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	DOOR OPEN ENABLE		P C	X300	I380	X300	X9C0

[Function]

This signal informs the PLC that the drive power to all axes is turned OFF due to the "Door open" signal, or that the same status is canceled.

[Operation]

This signal turns ON when the drive power to all axes is turned OFF due to the "Door open" signal turning ON.
This signal turns OFF at all axes ready ON and at all servo axes servo ON, due to the "Door open" signal turning OFF.
Release of the door lock is enabled at the rising edge of the "Door open enable" signal.
The operation is in a READY status at the falling edge of the "Door open enable" signal.

[Caution]

(1) Handling of the PLC axis
Set so a "Door open" signal is output to the NC after the PLC axis is stopped by the PLC.
If a "Door open" signal is input without stopping the PLC axis, the axis will stop with a dynamic brake method due to the ready OFF state.
The remaining distance will be held in the R register being used in the DDB.

(2) Handling of the analog spindle
When an analog spindle is connected, it is not possible to confirm that the spindle has completely stopped with the NC. Thus, confirm that the spindle has completely stopped using the PLC, before opening the door.
Because the spindle may start rotating again immediately after the door is closed, for safety turn the forward run and reverse run signals OFF when the door is open.

(3) Opening the door during ATC operation
When opening the door during ATC operation, apply an interlock with the user PLC.

[Related signals]

Door open (Y380, 1)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MELDASNET IN SAMPLING	NETSMP	P C	X303	I383	X303	X9C3

[Function]

This signal informs that sampling is being executed by the MELDASNET function.

[Operation]

This signal turns ON when sampling with the MELDASNET function is being executed.

[Related signals]

MELDASNET sampling stop (NETSTP: Y2FB)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN TOOL ID COMMUNICATION		P C	X307	—	X307	—

[Function]

This signal indicates that data transmission and reception with the tool ID controller are executed.

[Operation]

This signal turns ON during commanding to write and read the tool ID data, and turns OFF after the transmission and reception with the tool ID controller is completed.
For whether transmission and reception have normally completed or not, refer to the "Tool ID communication information error" (R488).

[Caution]

Even if the "Reset" signal is turned ON during the tool ID communication, the communication is not stopped.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN SPINDLE SYNCHRONOUS CONTROL	SPSYN1	P C	X308	—	X308	—

[Function]

This signal informs that the spindle synchronous control mode has been entered.

[Operation]

The signal turns ON when:

- The G114.1 is commanded, and spindle synchronous control is entered. (Spindle synchronization control I)
- The spindle synchronous control signal (Y398) turns ON. (Spindle synchronization control II)

The signal turns OFF when:

- Spindle synchronous control is canceled with the G113 command. Or, when the spindle synchronization cancel signal (Y2E8) turns ON. (Spindle synchronization control I)
- When the spindle synchronous control signal (Y398) turns OFF. (Spindle synchronization control II)

[Related signals]

Spindle rotation speed synchronization complete (FSPRV: X309)
Spindle phase synchronization complete (FSPPH: X30A)
Spindle synchronous control (SPSY: Y398)
Spindle phase synchronous control (SPPHS: Y399)
Spindle synchronization cancel (SPSYC: Y2E8)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE ROTATION SPEED SYNCHRONIZATION COMPLETE	FSPRV	PC	X309	—	X309	—

[Function]

This signal informs that the spindle synchronization state mode is entered.

[Operation]

The signal turns ON when:

- The difference of the rotation speeds of the basic spindle and synchronous spindle reaches the value set for the spindle rotation speed attainment level during the spindle synchronous control mode.

The signal turns OFF when:

- The actual rotation speed of the synchronization basic spindle or synchronous spindle, in respect to the spindle synchronous rotation speed command value, widely exceeds or deviates value set for the spindle synchronization rotation speed attainment level during the rotation synchronization mode.
- The spindle synchronous control mode is canceled.

[Related signals]

In spindle synchronous control (SPSYN1: X308)
Spindle phase synchronization complete (FSPPH: X30A)
Spindle synchronous control (SPSY: Y398)
Spindle phase synchronous control (SPPHS: Y399)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE PHASE SYNCHRONIZATION COMPLETE	FSPPH	P C	X30A	—	X30A	—

[Function]

This signal informs that the spindle synchronization state is entered.

[Operation]

The signal turns ON when:

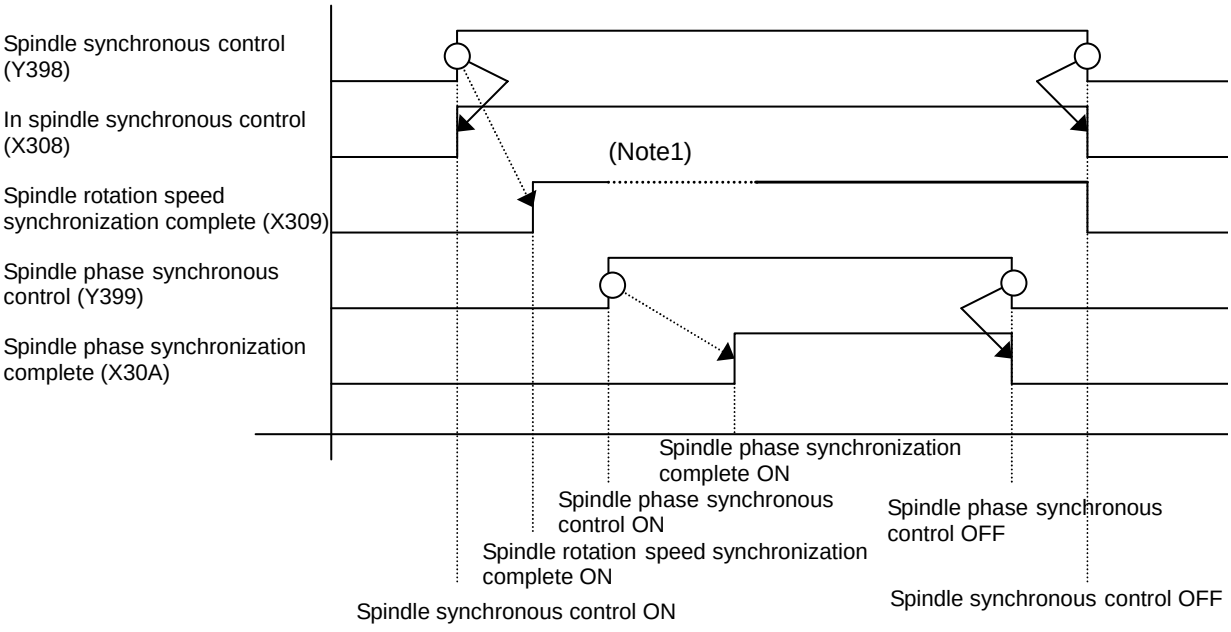
- The phase alignment of the synchronization basic spindle and synchronous spindle is completed during the phase synchronization mode.

The signal turns OFF when:

- The phase difference of the synchronization basic spindle and synchronous spindle exceeds the value set for the spindle synchronization phase attainment level during the phase synchronization mode.
- The spindle synchronous control mode is canceled.

⚠ CAUTION

⚠ Always turn the spindle phase synchronization complete signal ON before chucking both ends of the workpiece to the basic spindle and synchronous spindle. If the spindle phase synchronization signal is turned ON when both ends of the workpiece are chucked to the basic spindle and synchronous spindle, the chuck or workpiece could be damaged by the torsion that occurs during phase alignment.



(Note1) Temporary turn OFF to change the rotation speed during the phase synchronization.

[Related signals]

In spindle synchronous control (SPSYN1: X308)
Spindle rotation speed synchronization complete (FSPRV: X309)
Spindle synchronous control (SPSY: Y398)
Spindle phase synchronous control (SPPHS: Y399)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN SPINDLE SYNCHRONOUS CONTROL 2 (D)	SPSYN2	P C	X30B	—	X30B	—

[Function]
This signal informs that the spindle-spindle polygon machining is started.

[Operation]
This signal turns ON when:
- G114.2 is commanded, and the spindle-spindle polygon machining is started.

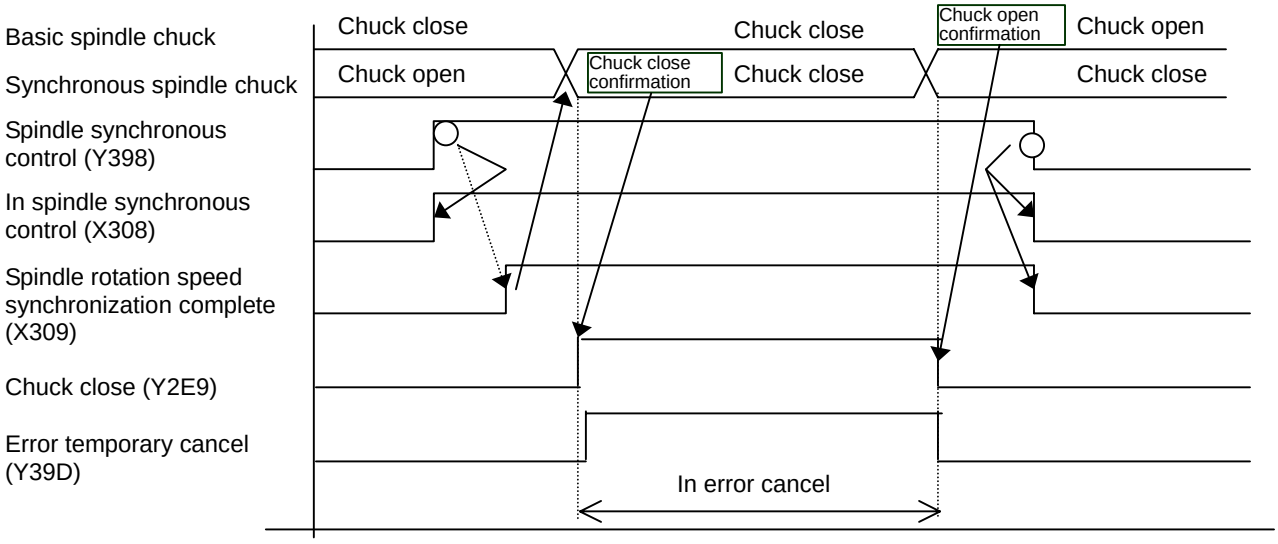
This signal turns OFF when:
- G113 is commanded, and the spindle-spindle polygon machining is canceled.
- When the spindle synchronization cancel signal (SPSYC) is input, and spindle-spindle polygon machining is canceled.

[Related signals]
Spindle synchronization cancel (SPSYC: Y2E8)
Spindle rotation speed synchronization complete (FSPRV: X309)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	CHUCK CLOSE CONFIRMATION	SPCMP	P C	X30E	—	X30E	—

[Function]
This signal informs that chuck close (SPCMPC: Y2E9) is input during spindle synchronous control.

[Operation]
This signal turns ON when the "Chuck close" (Y2E9) is ON.
This signal turns OFF when the "Chuck close" (Y2E9) is OFF.
This signal turns OFF when the spindle synchronous control is canceled.



(Note) Use "error temporary cancel" signal only when the position error between two spindles still occurs even after the "Chuck close" signal is turned ON.

[Related signals]
Chuck close (SPCMPC: Y2E9)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	POWER OFF REQUIRED AFTER PARAMETER CHANGE		PC	X30F	—	X30F	—

[Function]

This signal informs that the set parameter is not valid without rebooting the power.

[Operation]

When the following operation is executed, the "Power OFF required after parameter change" signal is output, and the display symbol "PR" is displayed in the operation status section.

(1) The parameters to be valid after rebooting the power are set. / Such parameter data is input.
(2) The auxiliary axis parameters to be valid after rebooting the power are set. / Such data is input. / Such data backed up before is input.
(3) The maintenance data for the ALL1 is input.
(4) The backup data is input with the SRAM backup function.

If the power is rebooted, the "Power OFF required after parameter change" signal will turn OFF, and the "PR" display will disappear.

(Note 1) Even if the same value is set to the parameter which needs to reboot the power, the "Power OFF required parameter change" signal is output, and the "PR" is displayed.
(Note 2) Even if the value is returned to the original value after setting the parameter which needs to reboot the power, the "Power OFF required after parameter change" signal remains ON, and the "PR" also remains displayed.
(Note 3) The parameters which do not need to reboot the power are targeted for rewriting the parameters with DDB or G10, so the "Power OFF required after parameter change" signal is not output, and the "PR" is not displayed.

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	IN MAGNETIC BEARING READY ON		PC	X318	I398	X318	X9D8

[Function] [Operation]

This signal indicates that the magnetic bearing is in the READY ON state.

[Related signals]

In magnetic bearing servo ON (X319)
In magnetic bearing warning (X31C)
In magnetic bearing alarm (X31F)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	IN MAGNETIC BEARING SERVO ON		P C	X319	I399	X319	X9D9

[Function]
This signal indicates that the magnetic bearing is in the servo ON (bearing suspended) state.

[Operation]
Always confirm that this signal is ON before issuing a forward run or reverse run command to the spindle.

[Related signals]
In magnetic bearing ready ON (X318)
In magnetic bearing warning (X31C)
In magnetic bearing alarm (X31F)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	IN MAGNETIC BEARING WARNING		P C	X31C	I39C	X31C	X9DC

[Function] [Operation]
This signal indicates that a magnetic bearing servo warning is occurring.

[Related signals]
In magnetic bearing ready ON (X318)
In magnetic bearing servo ON (X319)
In magnetic bearing alarm (X31F)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	IN MAGNETIC BEARING ALARM		P C	X31F	I39F	X31F	X9DF

[Function] [Operation]
This signal indicates that a magnetic bearing servo alarm is occurring.

[Related signals]
In magnetic bearing ready ON (X318)
In magnetic bearing servo ON (X319)
In magnetic bearing warning (X31C)

6.2 PLC Input Signals (Data Type: R***)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE COMMAND ROTATION SPEED INPUT		P C	R8, 9	R208, 9	R8, 9	R208, 9

[Function]

This signal informs that spindle speed reference signal (S) specified in automatic operation (memory, MDI or tape) or by manual numerical data input. "Spindle command rotation input" speed output from the controller is binary data. Under the S analog mode, the data can be monitored in the "S display" on the command value screen.

[Operation]

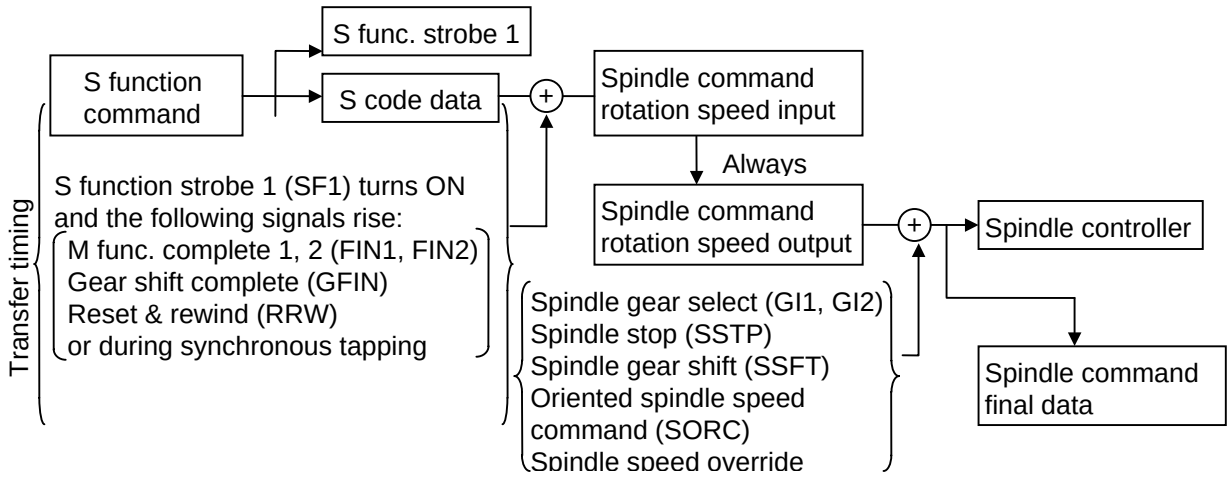
Set "Spindle command rotation speed input" is renewed when:

(1) "S**" is specified in automatic operation (memory, MDI or tape) and "M function finish 1 or 2" signal (FIN1 or FIN2) or "Gear shift complete" signal (GFIN) is sent back to the controller.

(2) "S**" is specified by manual numerical command input and "M function finish 1 or 2" signal (FIN1 or FIN2) or "Gear shift complete" signal (GFIN) is sent back to the controller.

(Note 1) Data cannot be cleared by "Reset" or "Emergency stop".

<Data flow>



When the system is under constant surface speed control, constant surface speed data is set for "Spindle command rotation speed input".

(Note 2) "Spindle command rotation speed input" directly denotes spindle speed (r/min) specified as S function command.

[Related signals]

(1) Spindle speed command rotation output (R108, 9)

(2) Spindle command final data (R10 to 13)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE COMMAND FINAL DATA (rotation speed)		P C	R10, 1	R210, 1	R10, 1	R210, 1

[Function]

The command value is indicated to the spindle controller.

[Operation]

The "Spindle command rotation speed input" indicates the value for the spindle function (S) data commanded with the automatic operation or manual numeric value command, whereas this data indicates a value to which the "Spindle override", "Spindle gear select input" (GI1, GI2), "Spindle stop" (SSTP), "Spindle gear shift" (SSFT) and "Oriented spindle speed command" (SORC) conditions have been considered.

[Related signals]

(1) Spindle command rotation speed input (R8, 9)
(2) Spindle command rotation speed output (R108, 9)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	KEY IN 1		P C	R16	—	R16	—

[Function]

Operator's key operation can be monitored on the user PLC side.

[Operation]

While operator is using the keyboard, the corresponding data is set to KEY-IN 1.
Refer to the "PLC Programming Manual" ("User PLC key operation") for details on the set key data.

[Related signals]

(1) KEY OUT 1 (R112)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE ACTUAL SPEED		P C	R18, 9	R218, 9	R18, 9	R218, 9

[Function]

When the system has spindle equipped with encoder, actual spindle speed can be monitored.

[Operation]

True spindle speed is always set by feedback signal from spindle encoder.
Data are multiplied by 1000, and stored.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	M CODE DATA 1		P C	R20, 1	R220, 1	R20, 1	R220, 1

[Function]

When M function is specified, value following address "M" can be identified. The M code data output from the controller is a max. 8-digit BCD code.

[Operation]

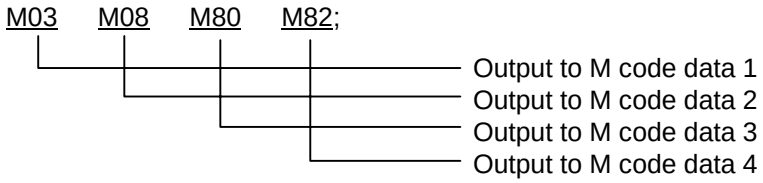
M code data are updated when:

(1) "M**" is issued in automatic operation (tape, memory or MDI).
(2) "M**" in fixed cycle causes motion during execution of the fixed cycle.
(3) "M**" is executed by manual numerical command input.

M code data is also updated when an "M code independent output" command is issued even during M function lock. The data is kept unchanged after "M function finish" signal (FIN1, FIN2) is sent back. "Reset" or "Emergency stop" does not clear the data.

[Cautions]

(1) Commands can be defined up to four in a block with parameters. (One command for the system when the standard PLC is available.) When plural M functions are placed in one block, the signals are output in the order at programming.



(2) M98 (read of subprogram), M99 (return to main program), etc. are processed within the CNC, and not output as M code data.

[Related signals]

(1) M function strobe (MFn: X230)
(2) M code data 2, 3, 4 (R22 to 27)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	M CODE DATA 2		P C	R22, 3	R222, 3	R22, 3	R222, 3

[Function]

When M function is specified, value following address "M" can be identified. The M code data output from the controller is a max. 8-digit BCD code.

[Operation]

M code data 2 are updated when:

(1) Two or more M functions are placed in one block in automatic operation (tape, memory or MDI).

For other details, refer to the section on "M CODE DATA 1".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	M CODE DATA 3		P C	R24, 5	R224, 5	R24, 5	R224, 5

[Function]

When M function is specified, value following address "M" can be identified. The M code data output from the controller is BCD code.

[Operation]

M code data 3 are updated when:

(1) Three or more M functions are placed in one block in automatic operation (tape, memory or MDI).

For other details, refer to the section on "M CODE DATA 1".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	M CODE DATA 4		P C	R26, 7	R226, 7	R26, 7	R226, 7

[Function]

When M function is specified, value following address "M" can be identified. The M code data output from the controller is a max. 8-digit BCD code.

[Operation]

M code data 4 are updated when:

(1) Four or more M functions are placed in one block in automatic operation (tape, memory or MDI).

For other details, refer to the section on "M CODE DATA 1".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	S CODE DATA 1		P C	R28, 9	R228, 9	R28, 9	R228, 9

[Function]

When S function is specified, value following address "S" can be identified. The S code data output from the controller is binary code.

[Operation]

S code data 1 are updated when:

(1) "S**" is specified in automatic operation (tape, memory or MDI).

(2) "S**" is executed by manual numerical command input.

Data remain unchanged even when "M function finish" signal (FIN1 or FIN2) is sent back. "Reset" and "Emergency stop" does not clear this data.

The S-code data is issued in the following manner

Signal name	Register	
	1st part system	2nd-part system
S code data 1	R28, 29	R228, 229
S code data 2	R30, 31	R230, 231
S code data 3	R32, 33	R232, 233
S code data 4	R34, 35	R234, 235

[Caution]

(1) If two or more S codes for one spindle are issued in a block, the S code defined last will be valid.

[Related signal]

(1) S function strobe (SFn: X234)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	T CODE DATA 1		P C	R36, 7	R236, 7	R36, 7	R236, 7

[Function]

When T function is specified, value following address "T" can be identified. The T code data output from the controller is a max. 8-digit BCD code.

[Operation]

T code data are updated when:

(1) "T**" is specified in automatic operation (tape, memory or MDI).

(2) "T**" is executed by manual numerical command input.

Data remain unchanged even when "M function finish" signal (FIN1 or FIN2) is sent back. "Reset" and "Emergency stop" does not clear this data.

[Cautions]

(1) Only one T code can be commanded in one block. The latter code will be valid if more than one code is commanded in one block.

[M system]

T05 T15;

Output to T code data 1

This T code data is invalid.

[L system]

T0505 T1515;

Output to T code data 1

This T code data is invalid.

[Related signals]

(1) Tool function strobe 1 (TF1: X238)

B contact	Signal name	Signal abbreviation	PC	1st system	2nd system	1st system	2nd system
—	2ND M FUNCTION DATA 1			R44, 5	R244, 5	R44, 5	R244, 5

[Function]

When 2nd M function is specified, value following address "B" can be identified. The 2nd M function data output from the controller is a max. 8-digit BCD code.

Note 1) Select an address for the 2nd M function address from the setup parameters basic specification parameter "#1170 M2name" A, B or C address that is not being used for "#1013 axname" or "#1014 incax".

[Operation]

2ND M FUNCTION DATA 1 are updated when:

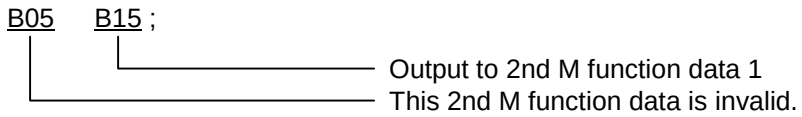
(1) "B (A, C)**" is specified in automatic operation (tape, memory or MDI).

(2) "B (A, C)**" is executed by manual numerical command input.

Data remain unchanged even when "M function finish" signal (FIN1 or FIN2) is sent back. "Reset" and "Emergency stop" does not clear this data.

[Cautions]

(1) Only one 2nd M function can be placed in one block. The latter code will be valid if more than one code is commanded in one block.



[Related signals]

(1) 2nd M function strobe 1 (BF1: X23C)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	LOAD MONITOR WARNING AXIS		P C	R52	R252	R52	R252

[Function]

This signal indicates the axis for which a warning occurred during monitor operation.

[Operation]

The bit corresponding to the axis for which the effective load exceeded the warning value during monitor operation is set to "1".
This signal is reset when the alarm reset or warning reset signal is input.
This signal is also reset when the teaching/monitor execution signal is turned OFF.

S	T												X	Y

* S indicates the 1st spindle and T indicates the 2nd spindle.

[Related signals]

Load monitor In teaching/monitor execution, Teaching mode valid, Monitor mode valid (X268 to X26A)
Load monitor Alarm axis, Data alarm information (R53, R54)
Load monitor Teaching/monitor execution, Teaching mode select, Monitor mode select, Alarm reset, warning reset (Y313 to Y317)
Load monitor Axis selection, Load change rate detection axis, Teaching data sub-No. (R116 to R118)
Load monitor status (R670 to R679)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	LOAD MONITOR ALARM AXIS		P C	R53	R253	R53	R253

[Function]

This signal indicates the axis for which an alarm occurred during monitor operation.

[Operation]

The bit corresponding to the axis for which the effective load exceeded the alarm value during monitor operation is set to "1".
This signal is reset when the alarm reset signal is input.

S	T												X	Y

* S indicates the 1st spindle and T indicates the 2nd spindle.

[Related signals]

Load monitor In teaching/monitor execution, Teaching mode valid, Monitor mode valid (X268 to X26A)
Load monitor Warning axis, Data alarm information (R52, R54)
Load monitor Teaching/monitor execution, Teaching mode select, Monitor mode select, Alarm reset, warning reset (Y313 to Y317)
Load monitor Axis selection, Load change rate detection axis, Teaching data sub-No. (R116 to R118)
Load monitor status (R670 to R679)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	LOAD MONITOR DATA ALARM INFORMATION		PC	R54	R254	R54	R254

[Function]

This signal indicates the error that occurred during teaching and monitor operation.

[Operation]

The corresponding bit shown below is set when an error occurs during teaching and monitor operation. This signal is reset when the alarm reset signal is input.

- Bit0: The teaching data designated during monitoring is not registered.
- Bit1: The teaching data alarm value designated during monitoring is smaller than the warning value.
- Bit2: The number of teaching data items has exceeded the registration capacity.
- Bit3: The teaching data cannot be registered during teaching because there is no teaching time.
- Bit8: The upper tolerable value is smaller than the lower tolerable value when executing adaptive control.
- Bit9: The override maximum value is smaller than the override minimum value when executing adaptive control.
- BitA: The adaptive control basic axis selection command is illegal.

[Related signals]

Load monitor In teaching/monitor execution, Teaching mode valid, Monitor mode valid (X268 to X26A)
Load monitor Warning axis, Alarm axis (R52, R53)
Load monitor Teaching/monitor execution, Teaching mode select, Monitor mode select, Alarm reset, warning reset (Y313 to Y317)
Load monitor Axis selection, Load change rate detection axis, Teaching data sub-No. (R116 to R118)
Load monitor status (R670 to R679)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	GROUP OUTPUT IN LIFE MANAGEMENT		PC	R55	R255	R55	R255

[Function]

The No. of the group currently in life management with the lathe system's tool life management II is output.

[Operation]

The No. of the group currently in life management is output.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	BATTERY DROP CAUSE		PC	R56	—	R56	—

[Function]

This notifies a drop in the battery voltage.

[Operation]

A drop in voltage of the data storage battery located on the front door of the controller is checked when the power is turned ON. If the voltage is below the specified voltage (approx. 2.6V), the battery alarm (BATAL) signal turns ON, and bit 0 of this data is set to "1".

(Note) This data will not change until the battery voltage is recovered to a normal value.

[Related signal]

(1) Battery alarm (BATAL: X20F)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TEMPERATURE WARNING CAUSE		P C	R57	—	R57	—

[Function]

If the internal temperature of the control unit rises above 80◦C or the ambient temperature of the communication terminal (setting and display unit) rises above 70◦C, the overheat will be detected, and the following states will occur.
(1) The "Temperature rise" (E16) is turned ON.
(2) The "Temperature warning cause" (R57) is turned ON.
(3) The alarm message (Z53) is displayed on the screen.
If the machine is in automatic operation, the operation will be continued, but restarting will not be possible after resetting or stopping with M02/M30. (Starting will be possible after block stop or feed hold.)

[Operation]

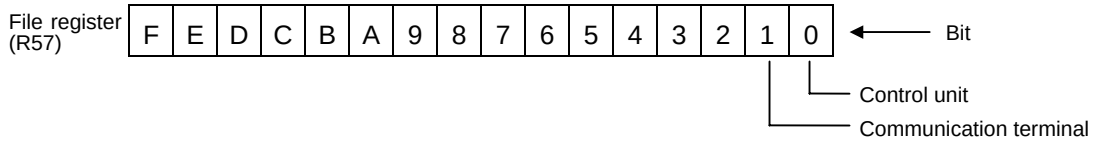
The "Temperature warning cause" is turned ON when:

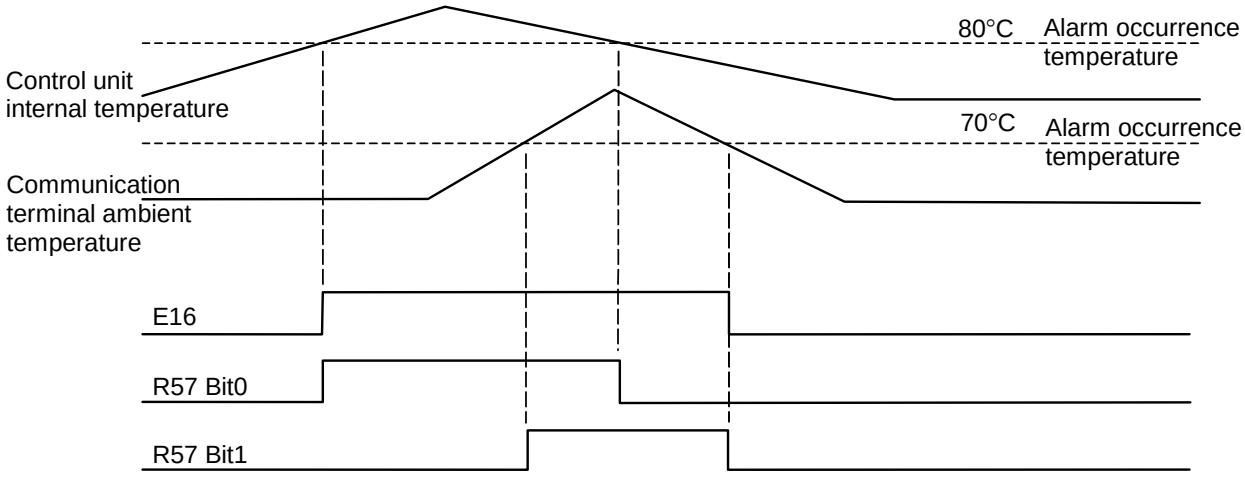
- The internal temperature of the control unit rises above 80◦C or the ambient temperature of the communication terminal rises above 70◦C.

The "Temperature warning cause" is turned OFF when:

- The internal temperature of control unit drops below 80◦C and the ambient temperature of the communication terminal drops below 70◦C.

The "Temperature warning cause" is a bit unit signal. Independent bits are assigned to the control unit and communication terminal respectively.





[Related signals]

(1) Temperature rise (E16)
(2) Control unit temperature (R458)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ADAPTIVE CONTROL OVERRIDE OUTPUT		P C	R59	R259	R59	R259

[Function]

The override controlled with adaptive control is output.

[Operation]

The override based on the results controlled with adaptive control is output.
100% is always output except during adaptive control.
Output unit: 1/100

(Example) "10000" is output for a 100% override.

[Related signals]

Adaptive control valid (X26B)
Adaptive control execution (Y349)
Adaptive control basic axis selection (R119)

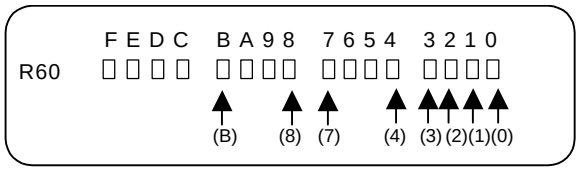
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	CNC COMPLETE STANDBY STATUS OUTPUT		P C	R60	R260	R60	R260

[Function]

The NC's operation state when the machine seems to be not operated in automatic operation without alarms occurring is output by the bit unit. The alarm messages can be displayed using this signal in the user PLC.

[Operation]

The corresponding bit below turns ON.
Bit0 : Complete standby status of M,S,T,B
Bit1 : In rapid traverse deceleration check
Bit2 : In cutting feed deceleration check
Bit3 : Waiting for spindle orientation complete
Bit4 : Waiting for spindle position loop
Bit7 : Door opened
Bit8 : In executing dwell
BitB : Waiting for unclamp signal



The right figure shows the bit correspondence.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	IN INITIALIZATION		P C	R62	R262	R62	R262

[Function]

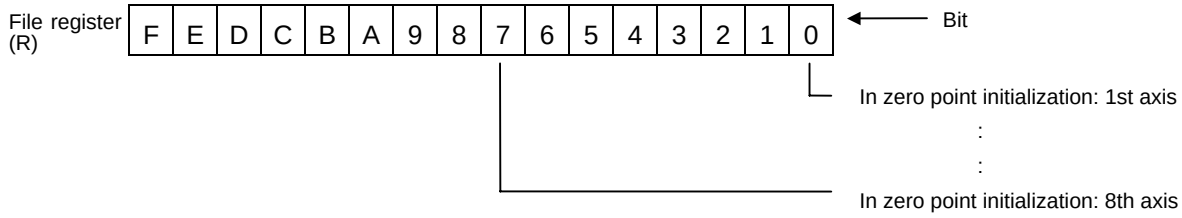
This signal is output when zero point initialization is being carried out in the absolute position detection system.

[Operation]

The axis for which "1" is set in #0 INIT. SET on the [ABS. POSITION SET] screen is set to "1", and is held until the power is turned OFF.

The stored stroke limit and stroke end signals are invalid while this signal is set to "1", and the current limit during initialization is valid.

This signal is also set to "1" when the "Zero point initialization mode" (AZS1 to 8) signal is ON.



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	INITIALIZATION INCOMPLETE		P C	R63	R263	R63	R263

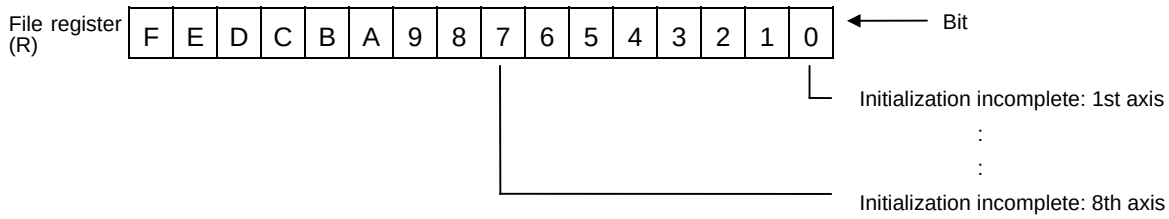
[Function]

This signal is output when the absolute position is not established in the absolute position detection system.

[Operation]

This signal indicates that the zero point initialization has not been established once or that the absolute position has been lost.

The stored stroke limit of the axis for which this signal is set to "1" in the absolute position detection system is invalid.



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SCREEN CONTROL INFORMATION		P C	R64 to 7	—	R64 to 7	—

[Function]

This signal notifies which screen is currently being displayed by the controller.

[Operation]

The screen information changes in the following cases. Note that the information will not change when a screen that has already been displayed is re-displayed.

(1) When a function select key is pressed.
(2) When a menu key is pressed.
(3) When a page key is pressed.

The relation of each key operated and the screen information is as follows.

File register	Operated key	Screen information		
R65 bit F to 8	Function No.	MONITOR		00
		TOOL•PARAM	cmdtyp is 1, 2	0C
			cmdtyp is 3, 4	12
		EDIT•MDI		0D
		DIAGN•IN/OUT		10
		SFG		08
		F0		09
R65 bit 7 to 0	Menu No.	00 to 13 (0 to 19: decimal) Menu changeover: 00 01 02 03 04 / 05 06 07 08 09 / 0A 0B 0C 0D 0E / 0F 10 11 12 13		
R64 bit F to 8	Page No.	01 to n Change by next page key or previous page key		
R64 bit 7 to 0	_____	Not set. The data is not set.		

(Note) File registers R66 and 67 are invalid.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	PLC MAIN SCAN TIME		P C	R68	—	R68	—

[Function]

Time taken for scanning in user PLC can be monitored.

[Operation]

Scanning time for user PLC main processing is continuously updated and set.

<File register contents and time calculation>

File register

F	E	D	C	B	A	9	8	7	6	5	4	3	2	1	0

Upper-order data — Lower-order data

Time calculation

$$\boxed{\text{Upper-order data}} \times 7.1 + \frac{\boxed{\text{Lower-order data}}}{256} \times 7.1 \quad \text{(ms)}$$

(Example)

F	E	D	C	B	A	9	8	7	6	5	4	3	2	1	0
0	0	0	0	0	1	1	0	1	1	0	1	0	0	0	0

$$\boxed{\text{Upper-order data=6}} \times 7.1 + \frac{\boxed{\text{Lower-order data=208}}}{256} \times 7.1 \quad \text{(ms)}$$

(Note 1) For this data, mean scanning time is about 1.8sec.

(Note 2) I/O processing time for PLC control software (PLC BASIC) is included in this data processing time.

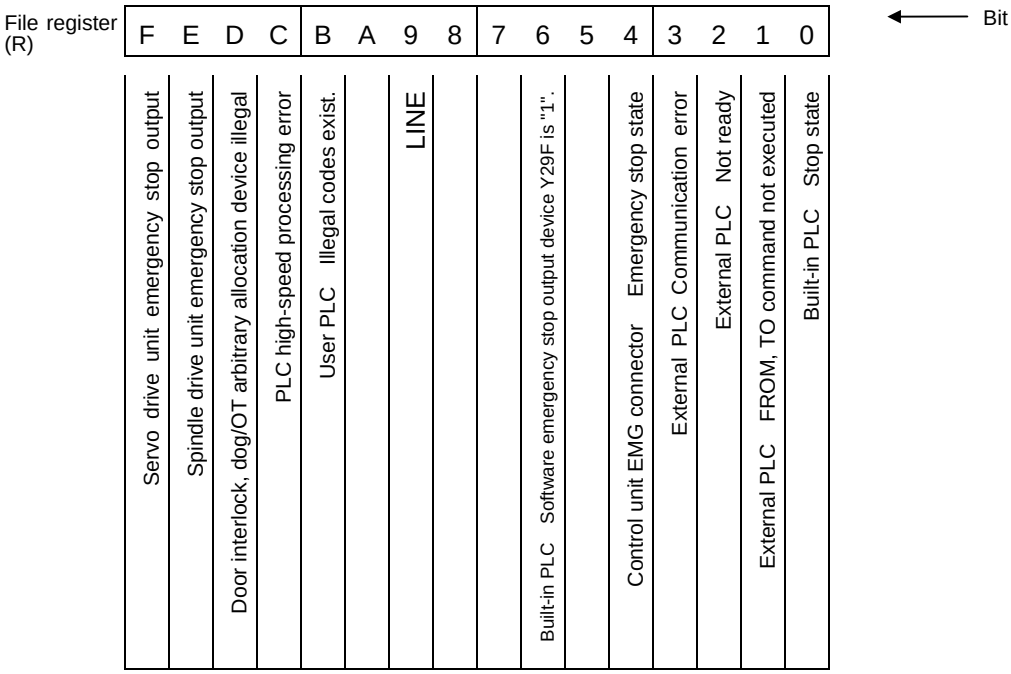
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	EMERGENCY STOP CAUSE		P C	R69	—	R69	—

[Function]

The causes of emergency stop are shown with bit correspondence.

[Operation]

The cause of the emergency stop state is shown as follows with bit correspondence.
If there are multiple causes, the multiple bits corresponding to each cause are output.
The bit of this signal that is set to "0" is the emergency stop cause.



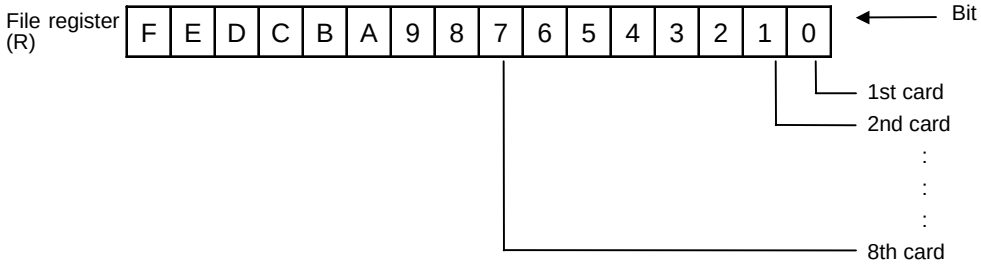
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	DIO CARD INFORMATION		P C	R70	—	R70	—

[Function]

The remote I/O unit connected to the controller can be found with the user PLC.
The user PLC finds the connection state of the remote I/O unit with this data.

[Operation]

(1) When a remote I/O card is connected "1" is set, and when not connected "0" is set. Note that for DC100/101, DX110/111, DX120/121 and DX140/141, two cards are used per unit, so the two bits corresponding to the connected unit will be set to "1".



(2) No. of cards mounted in remote I/O unit (DX***)

Unit	No. of cards
DX100/101	1 card
DX110/111, DX120/121, DX140/141	2 cards

(3) The position of the bit that turns ON depends on the rotary switch on the remote I/O unit.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	USER MACRO OUTPUT #1032 PLC → Controller		P C	R72, 73	—	R72, 73	—

[Function]

This is interface function used to coordinate user PLC to user macro.

(Note) The other signals from R0 to R99 are PLC inputs, but this signal is output to the controller from PLC.

[Operation]

The data set in file registers Rn and Rn+1 with the user PLCs, can be referred to on the user macro side with the user macro system variables #1000 to #1031 or #1032.

The relationship between system variable and file register is as follows:

System variable	Points	Interface output signal	System variable	Points	Interface output signal
#1000	1	Register R72 bit 0	#1016	1	Register R73 bit 0
#1001	1	Register R72 bit 1	#1017	1	Register R73 bit 1
#1002	1	Register R72 bit 2	#1018	1	Register R73 bit 2
#1003	1	Register R72 bit 3	#1019	1	Register R73 bit 3
#1004	1	Register R72 bit 4	#1020	1	Register R73 bit 4
#1005	1	Register R72 bit 5	#1021	1	Register R73 bit 5
#1006	1	Register R72 bit 6	#1022	1	Register R73 bit 6
#1007	1	Register R72 bit 7	#1023	1	Register R73 bit 7
#1008	1	Register R72 bit 8	#1024	1	Register R73 bit 8
#1009	1	Register R72 bit 9	#1025	1	Register R73 bit 9
#1010	1	Register R72 bit 10	#1026	1	Register R73 bit 10
#1011	1	Register R77 bit 11	#1027	1	Register R73 bit 11
#1012	1	Register R72 bit 12	#1028	1	Register R73 bit 12
#1013	1	Register R72 bit 13	#1029	1	Register R73 bit 13
#1014	1	Register R72 bit 14	#1030	1	Register R73 bit 14
#1015	1	Register R72 bit 15	#1031	1	Register R73 bit 15

System variable	Points	Interface output signal
#1032	32	Register R72, R73
#1033	32	Register R74, R75
#1034	32	Register R76, R77
#1035	32	Register R78, R79

This correspondence table shows the example for file registers R72 and R73.

File registers R72 and R73 correspond to system variables #1000 to #1031, and #1032 (32-bit data).

[Related signals]

(1) User macro output #1033, #1034, #1035 (R74 to R79)
(2) User macro input #1132, #1133, #1134, #1135 (R172 to R179)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	USER MACRO OUTPUT #1033 PLC → Controller		P C	R74, 75	—	R74, 75	—

[Function]

This provides interface function used to coordinate user PLC to user macro.

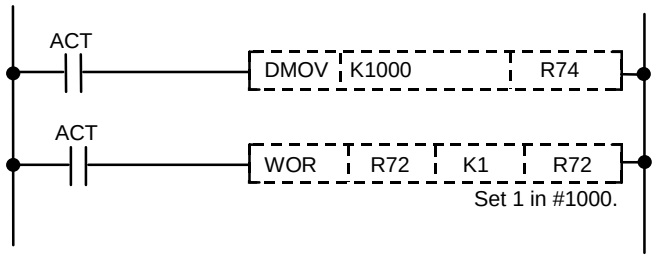
(Note) The other signals from R0 to R99 are PLC inputs, but this signal is output to the controller from PLC.

[Operation]

The data set in file registers Rn and Rn+1 with the user PLCs, can be referred to on the user macro side with the user macro system variables #1033.

(Example)

Sequence program



User macro program

```
IF [#1000  EQ  0]  GOTO  100

#100 = #1033

N100
```

The #1033(R74, R75) data is read into #100
Other than when #1000 is set to 0.

[Related signals]

(1) User macro output #1032, #1034, #1035, #1000 to #1031

(2) User macro input #1132, #1133, #1134, #1135, #1100 to #1131

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
	USER MACRO OUTPUT #1034 PLC → Controller		P C	R76, 77	—	R76, 77	—

[Function] [Operation]

The function, operation, etc. are the same as those of "USER MACRO OUTPUT #1033".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
	USER MACRO OUTPUT #1035 PLC → Controller		P C	R78, 79	—	R78, 79	—

[Function] [Operation]

The function, operation, etc. are the same as those of "USER MACRO OUTPUT #1033".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ADD-ON (EXPANSION) OPERATION BOARD INPUT SIGNALS 1 to 4		P C	R80 to 3	—	R80 to 3	—

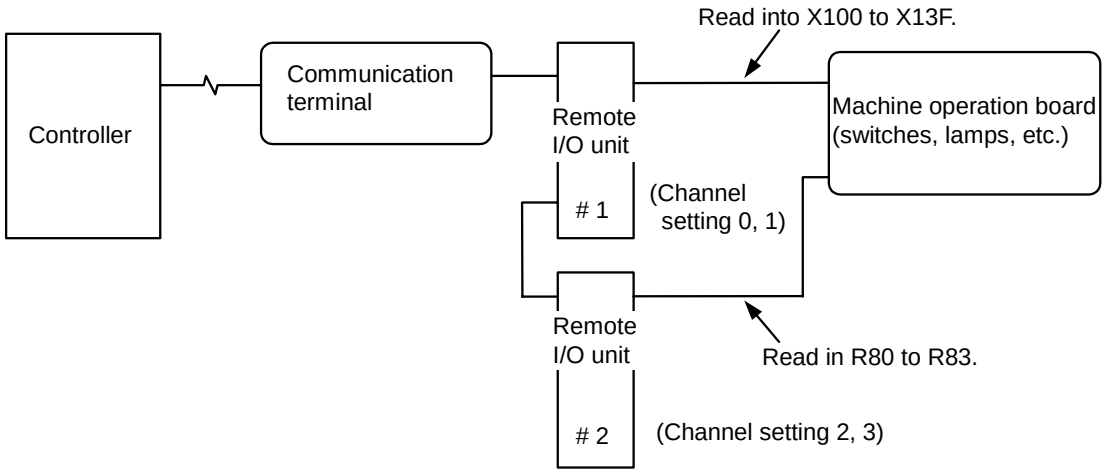
[Function]

By adding the remote I/O unit or QY231 to the communication terminal, the machine operation board input/output signals can be input and output with the communication terminal control signals.
If the added remote I/O unit has less than 64 input points and 48 output points the input signals will be input to (X100 to X13F) and the output signals output to (Y100 to Y12F). If the number of input/output points is larger, the input signals will be R80 to R83 explained here, and the output signals R180 to R182 explained later. Generally, these signals are to be assigned to "bit-based arithmetic operation area (X**)". They, however, are input to file registers (R).

[Operation]

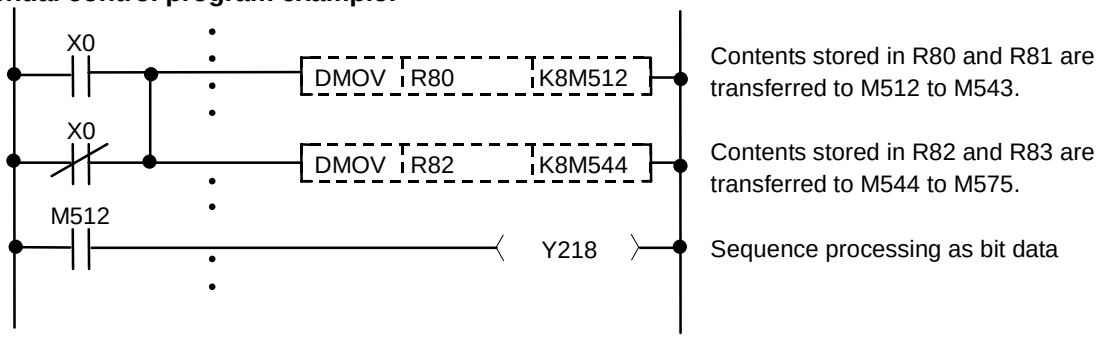
The signals are read together with other input signals at start of PLC main processing (medium speed).

<Hardware block diagram>



(Note 1) This is conventionally a bit unit signal, so create it in the temporary memory (M) and then transfer it to the corresponding file register (R) before using.

Sequential control program example:



(Note 2) Refer to the section "2.2 Operation board remote I/O unit" for the relation of the remote I/O channel setting switch and device.

(Note 3) Refer to the section “3.3 Machine Input Signals" Tables 3-2-3 to 3-2-4 for the add-on (expansion) operation board input signals 1 to 4.

[Related signals]

(1) Add-on (expansion) operation board output signals 1 to 3 (R180 to R182)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	NEAR REFERENCE POSITION (PER REFERENCE POSITION)		PC	R88, 9	R288, 9	R88, 9	R288, 9

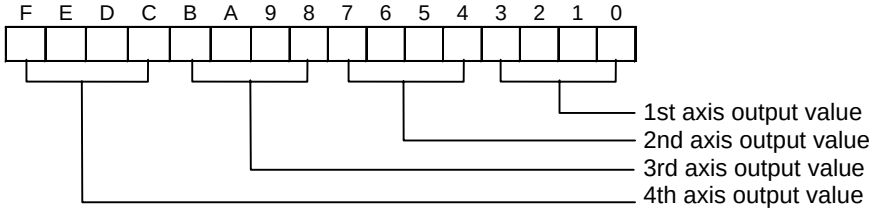
[Function]

This signal indicates that the control axis is near the reference position when using the absolute position detection system.
This signal is output for the 1st reference position to the 4th reference position.
Near the 1st reference position, the time for outputting the signal is shorter than the "near reference position nth axis (NRFn)" signal (the ON/OFF timing accuracy during axis movement is improved).

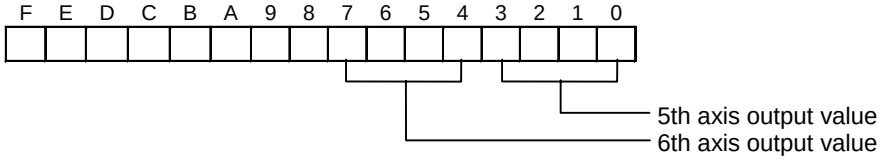
[Operation]

(1) Using the nth reference position as a reference, when the control axis is in the range set with the parameters, this signal turns ON, and turns OFF when the axis is not within the range.
(2) The near reference position signal is output with four bits for each axis.
(a) R register and corresponding axes

R88 (R288)



R89 (R289)



(b) Output value and near nth reference position

High-order bit ⟷ Low-order bit				Near nth reference position
0	0	0	1	Near 1st reference position
0	0	1	0	Near 2nd reference position
0	1	0	0	Near 3rd reference position
1	0	0	0	Near 4th reference position

(Note 1) The near reference position signal devices include X devices (X1D8 and following) which output signal only for the 1st reference position, and the R registers (R88/R89) which outputs a signal for each reference position (1st reference position to 4th reference position).
(Note 2) The near reference position signal output width is set with the absolute position parameters "#2057 nrefp" and "#2058 nrefn". The near reference position signal output width is the same width for the 1st reference position to the 4th reference position.
(Note 3) Near the 1st reference position, the signals are output to the conventional X device (X1D8 and following) and the R registers (R88/R89) which output signals to each reference position.

[Related signals]

Near reference position nth axis (NRF1 to 8: X1D8 to F)

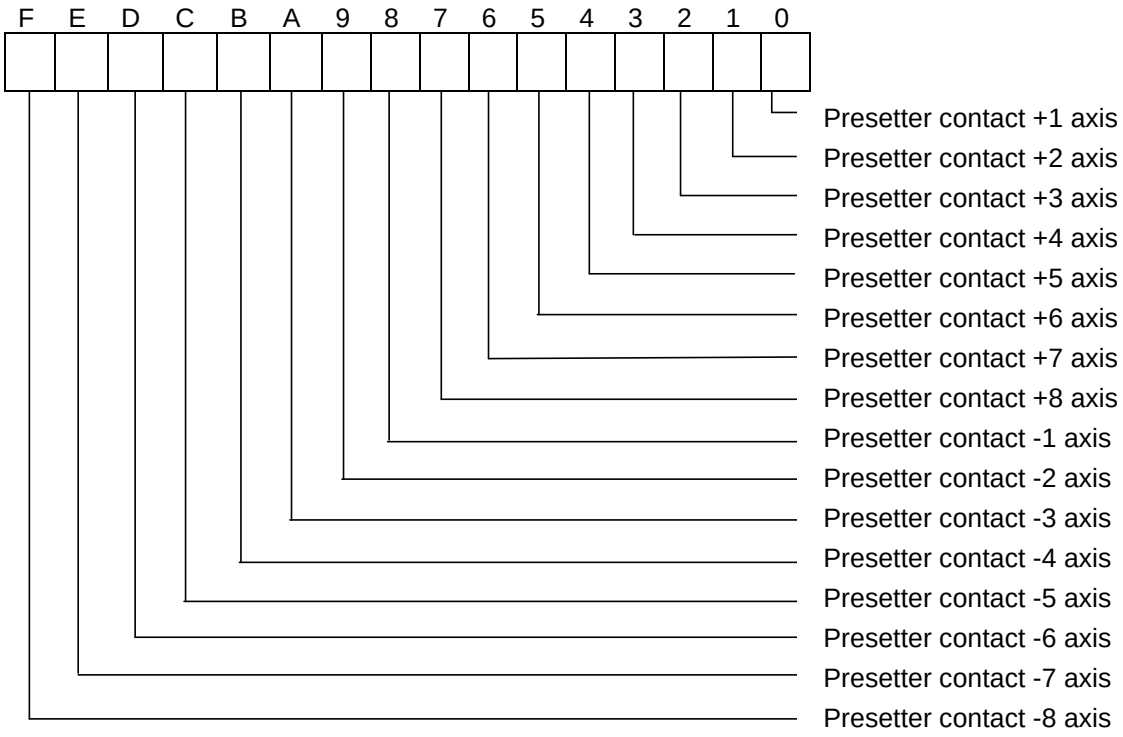
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	PRESETTER CONTACT		P C	R90	R290	R90	R290

[Function]

The axis movement direction at the moment when the "Skip" signal is entered is output in the tool presetter.

[Operation]

The axis movement direction at the moment when the tool contacts the sensor ("Skip" signal ON) during the tool measurement mode (TLMS ON) is set to the corresponding bit.
This signal is turned OFF by the sensor OFF.
This signal turns OFF when the "Tool measurement mode" signal is turned OFF.
This signal is not output when the tool measurement mode is not entered.
This signal is "0xFFFF" when an axis with no movement contacts the sensor.



1: Sensor ON
0: Sensor OFF or tool measurement mode OFF

[Related signals]

Tool length measurement 2 (TLMS: Y229)

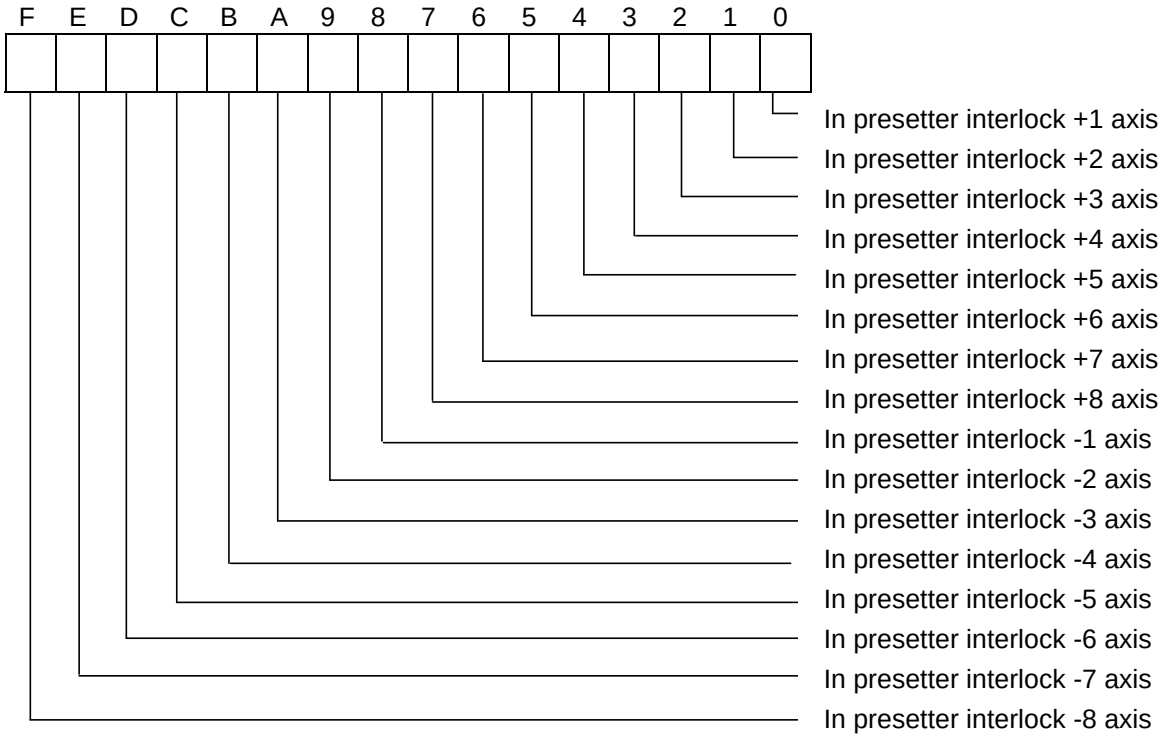
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	PRESETTER INTERLOCK		P C	R91	R291	R91	R291

[Function]

The interlock direction in the CNC is output after the sensor is entered in the tool presetter.

[Operation]

The interlock direction to the entrance direction in the CNC is output after the sensor is entered during the tool measurement mode (TLMS ON).
This signal is turned OFF when the escape operation complete conditions are satisfied.
This signal turns OFF when the "Tool measurement mode" signal is turned OFF.
This signal is not output when the tool measurement mode is not entered.



1: In interlock
0: Interlock cancel or tool measurement mode OFF

[Related signals]

Tool length measurement 2 (TLMS: Y229)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	CNC SOFTWARE VERSION CODE		P C	R96 to 9	—	R96 to 9	—

[Function]

This indicates the version of the software for controller control.

[Operation]

The version displayed at "MP" on the [Software Directory] screen is indicated.

[S/W MODULE TREE] ALARM/DIAGN 8.1/2
MP BND - 810W400 – A01 SV1 BND-
OFFM

The file registers R96 to 99 are set to the following data.

(Example) BND-810W400-A 0 1
(1) (2) (3)

Item		File register	Type	Example
(1)	Mode function No.	R99	Binary	810=032AH
(2)	Serial No.	R98	Binary	400=0190H
(3)	Version	Bits F to 8 of R97	ASCII code	A=41H
		Bits 7 to 0 of R97	ASCII code	0=30H
		Bits F to 8 of R96	ASCII code (Note1)	1=31H
—	———	Bits 7 to 0 of R96	Always FFH (Note2)	

(Note 1) If the version is a 2-digit No., bits F to 8 of R96 are set to "00H".
(Note 2) Bits 7 to 0 on the R96 are always "FFH".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	CONTROL UNIT TEMPERATURE		P C	R458	—	R458	—

[Function]

This signal indicates the temperature in the control unit.

[Operation]

This signal indicates the temperature in the control unit. The unit is "C°".

[Related signals]

(1) Temperature rise (E16)
(2) Temperature warning cause (R57)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	CLOCK DATA		P C	R460 to 2	—	R460 to 2	—

[Function]

The year, month, date, hour, minute and second data is informed by the controller to the PLC as the current clock information.

[Operation]

The date and time data is output as shown below. The data is output as binary data.

	F 87 0	
R460	Month	Year
R461	Hour	Date
R462	Second	Minute

(Example) For October 26, 2002, 14:56:36.

R460 ... 0 0 0 0 1 0 1 0 | 0 0 0 0 0 0 1 0 = 0A02H
October 2002

R461 ... 0 0 0 0 1 1 1 0 | 0 0 0 1 1 0 1 0 = 0E1AH
14 hundred hours 26th day

R462 ... 0 0 1 0 0 1 0 0 | 0 0 1 1 1 0 0 0 = 2438H
36 seconds 56 minutes

(Note 1) The time is displayed with the 24-hour system.
(Note 2) The data and time are set with the [TIME] screen on the setting and display unit.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE SYNCHRONOUS CONTROL PHASE ERROR OUTPUT		P C	R474	—	R474	—

[Function]

The synchronous spindle delay to the basic spindle is output in the spindle synchronous function.

[Operation]

The synchronous spindle delay to the basic spindle is output.
Unit: 360°/4096
(Note 1) If the phase can not be calculated because, for instance, the basic spindle or synchronous spindle has not passed the Z-phase, "-1" will be output.
(Note 2) This data is output only during the phase shift calculation or the spindle phase synchronization.

[Related signals]

Phase shift calculation request (SSPHM: Y39B)
Phase offset request (SSPHF: Y39C)
Spindle synchronous control phase offset data (R490)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE SYNCHRONOUS CONTROL PHASE ERROR 1 (degree) (including phase shift calc.)		P C	R475	—	R475	—

[Function]

1. During spindle synchronous function (G114.1)
   This signal informs the phase error (value including the phase error memorized with the spindle synchronization phase shift calculation function) when the phase synchronization (with R command) or the "Phase shift calculation request" signal (Y39B) is ON. The phase error is output by 1◦ increment.

2. During phase synchronization of polygon machining between spindles (G114.2)
   This signal informs the phase error corresponding to the commanded phase shift amounts by 1◦ increment.

The data has no meaning in cases other than above.

[Operation]

1. During spindle synchronous function (G114.1)
   When the phase synchronization (with R command) or the "Phase shift calculation request" signal (Y39B) is ON, and when the speeds of the basic spindle and the synchronous spindle are constant, the phase error between the basic spindle and the synchronous spindle is output.

2. During phase synchronization of polygon machining between spindles (G114.2)
   This signal informs the phase error corresponding to the commanded phase shift amounts by 1◦ increment.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE SYNCHRONOUS CONTROL PHASE ERROR 2 (degree) (excluding phase shift calc.)		P C	R476	—	R476	—

[Function]

1. During spindle synchronous function (G114.1)
   This signal informs the phase error (value excluding the phase error memorized with the spindle synchronization phase shift calculation function) when the phase synchronization (with R command) or the "Phase shift calculation request" signal (Y39B) is ON. The phase error is output by 1◦ increment.

2. During phase synchronization of polygon machining between spindles (G114.2)
   This signal informs the phase error corresponding to the commanded phase shift amounts by 1◦ increment. (Same as R475.)

The data has no meaning in cases other than above.

[Operation]

1. During spindle synchronous function (G114.1)
   When the phase synchronization (with R command) or the "Phase shift calculation request" signal (Y39B) is ON, and when the speeds of the basic spindle and the synchronous spindle are constant, the phase error between the basic spindle and the synchronous spindle is output.

2. During phase synchronization of polygon machining between spindles (G114.2)
   This signal informs the phase error corresponding to the commanded phase shift amounts by 1◦ increment. (Same as R475.)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE SYNCHRONOUS CONTROL PHASE ERROR MONITOR		P C	R477	—	R477	—

[Function]
The phase error during the spindle phase synchronous state can be monitored.

[Operation]
The phase error during the spindle phase synchronous control is output by the pulse unit.

[Related signals]
Spindle synchronous control phase error monitor (lower limit value) (R478)
Spindle synchronous control phase error monitor (upper limit value) (R479)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE SYNCHRONOUS CONTROL PHASE ERROR MONITOR (lower limit value)		P C	R478	—	R478	—

[Function]
The phase error during the spindle phase synchronous state can be monitored.

[Operation]
The lower limit value of the phase error during the spindle phase synchronous control is output by the pulse unit.

[Related signals]
Spindle synchronous control phase error monitor (R477)
Spindle synchronous control phase error monitor (upper limit value) (R479)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE SYNCHRONOUS CONTROL PHASE ERROR MONITOR (upper limit value)		P C	R479	—	R479	—

[Function]
The phase error during the spindle phase synchronous state can be monitored.

[Operation]
The upper limit value of the phase error during the spindle phase synchronous control is output by the pulse unit.

[Related signals]
Spindle synchronous control phase error monitor (R477)
Spindle synchronous control phase error monitor (lower limit value) (R478)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL ID COMMUNICATION ERROR INFORMATION		P C	R488	—	R488	—

[Function]

The error information at the transmission and reception with the tool ID controller is set.

[Operation]

Whether an error has occurred in finishing the transmission and reception with the tool ID controller (falling edge of X307) or not is set. "0" is set in normally ending, a code other than "0" is set when an error occurs.

The error information is cleared (set to "0") in starting the transmission and reception with the tool ID controller.

[Cautions]

For details on error, refer to the table below.

Error code	Error details	Remedies
0	Normal	—
1	Host -> controller Flaming	Confirm whether the connection and setting are correct.
2	Host -> controller Parity error in one character	Confirm whether the connection and setting are correct.
3	Host -> controller Communication format error	Confirm whether the connection and setting are correct.
4	Host -> controller Check sum error	Confirm whether the connection and setting are correct.
5	Host designated writing to the protect area.	Confirm whether the connection and setting are correct.
6	ID label incompatible error	The tool No. of data to be written is different from the tool No. in the ID label. Confirm the data to be written and the tool. When the tool data is written newly, designate an unset tool.
7	Controller's hardware error	The body of the tool ID may be damaged.
8	Reading error between controller and ID label	Confirm the distance between the ID antenna and the ID chip.
9	Writing error between controller and ID label	Confirm the distance between the ID antenna and the ID chip. If the distance has no problem, the verify error is occurring. Execute writing repeatedly until writing is executed normally.
10	Unformatted error	Execute the "#1060" (SETUP).
11	Tool position acquirement error	Confirm that the value designated in R438 is correct. Confirm that the designated tool No. exists.

Error code	Error details	Remedies
12	No reply error	Confirm whether the connection and setting are correct. *1
13	No. of received characters over error	Confirm whether the connection and setting are correct. *1
14	Received character check sum error	Confirm whether the connection and setting are correct. *1
15	Sort executing error	Execute the writing operation at some intervals.
16	No. of tools over error	The No. of registered tools reaches the maximum value.
17	T4-digit designation error	Change the program T command to the T8-digit.
18	Tool No. duplication error	The same tool No. as the tool No. of the data to be read already exists in the NC. Confirm the data to be read and the tool.
19	Tool ID option invalid error	Validate the tool ID option.
20	Tool ID incompatible format error	After validating the tool ID option, execute the #1060 (SETUP).
-2	Channel duplication open error	Confirm whether the connection and setting are correct. *1
-4	Time out error	Confirm whether the connection and setting are correct. *1
-5	Physical error	Confirm whether the connection and setting are correct. *1
-7	Reset end error	Confirm whether the connection and setting are correct. *1
-10	Input/output device connection error	Confirm whether the connection is correct. *1
-15	Parity H error	Confirm whether the connection and setting are correct. *1
-16	Parity V error	Confirm whether the connection and setting are correct. *1
-17	Over run error	Confirm whether the connection and setting are correct. *1
-18	Code translation error 1	Confirm whether the connection and setting are correct. *1
-20	Code translation error 2	Confirm whether the connection and setting are correct. *1

*1: Retry first. If the same error occurs after retrying, confirm that the connection and setting are correct.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE SYNCHRONOUS CONTROL PHASE OFFSET DATA		P C	R490	—	R490	—

[Function]

With the spindle phase shift amount calculation function, the phase error of the basic spindle and synchronous spindle is obtained and memorized by turning the PLC signal ON at executing the spindle synchronization. The synchronous spindle can be rotated with the handle during the spindle phase shift calculation, so the phase relation between two spindles can be adjusted by seeing.
If the "Spindle phase synchronous control" (SPPHS) signal is input while the "Phase offset request" signal (SSPHF) is ON, the phase error will be aligned based on the position shifted by the memorized phase shift amount.
Such operation makes the phase alignment easy when clamping an irregular material over.

[Operation]

The phase error memorized by the phase shift calculation is output.
Unit: 360◦/4096
(Note 1) This data is output only during the spindle synchronous control.

[Related signals]

Spindle phase synchronous control (SPPHS: Y399)
Phase shift calculation request (SSPHM: Y39B)
Phase offset request (SSPHF: Y39C)
Spindle synchronous control phase error output (R474)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL LIFE USAGE DATA		P C	R614, 5	R616, 7	R614, 5	R616, 7

[Function]

The usage data of the tool currently being used with the lathe-system tool life management II is output. (When multiple compensation Nos. are used, the total of usage data per compensation No. is output.)

[Operation]

The relation of the usage data of the tool currently being used and the output file register is as follows.

Details	File register
Tool life usage data (1st part system)	R614
	R615
Tool life usage data (2nd part system)	R616
	R617

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	LOAD MONITOR STATUS		P C	R670 to 9	R680 to 9	R670 to 9	R680 to 9

[Function]

The status of teaching and monitor execution for the load monitor, and the previous status is output.

R670 (R680)		R671 (R681)		R672 (R682)		R673 (R683)		R674 (R684)	
Low-order	High-order	Low-order	High-order	Low-order	High-order	Low-order	High-order	Low-order	High-order
Current	Previous	Two times prior	Three times prior	Four times prior	Five times prior	Six times prior	Seven times prior	Eight times prior	Nine times prior

R675 (R685)		R676 (R686)		R677 (R687)		R678 (R688)		R679 (R689)	
Low-order	High-order	Low-order	High-order	Low-order	High-order	Low-order	High-order	Low-order	High-order
Ten times prior	Eleven times prior	Twelve times prior	Thirteen times prior	Fourteen times prior	Fifteen times prior	Sixteen times prior	Seventeen times prior	Eighteen times prior	Nineteen times prior

[Operation]

The following values are output according to each status.

Output value	Status	Details
0 (00)	Teaching/monitor not executed	
13 (0D)	Teaching	In sampling prohibit time
14 (0E)		In no-load monitor time
15 (0F)		Waiting for cutting start point detection
16 (10)		Waiting for cutting start point detection after interruption
17 (11)		In monitoring prohibit time
18 (12)		Monitoring prohibit time end
19 (13)		Monitoring prohibit time end after interruption
23 (17)	Monitoring (adaptive control invalid)	In sampling prohibit time
24 (18)		Waiting for cutting start point detection
25 (19)		In monitoring prohibit time
26 (1A)		In monitoring prohibit time after interruption
27 (1B)		Monitoring prohibit time end
28 (1C)		Monitoring prohibit time end after interruption
33 (21)	Monitoring (adaptive control valid)	In sampling prohibit time
34 (22)		Waiting for cutting start point detection
35 (23)		In monitoring prohibit time
36 (24)		In monitoring prohibit time after interruption
37 (25)		Monitoring prohibit time end
38 (26)		Monitoring prohibit time end after interruption

(Note 1) The values shown in parentheses in the Output value field are hexadecimal notations.
(Note 2) "Interruption" refers to when teaching/monitoring is interrupted for rapid traverse during teaching/monitoring.

[Related signals]

Load monitor In teaching/monitor execution, Teaching mode valid, Monitor mode valid (X268 to X26A)
Load monitor Warning axis, Alarm axis, Data alarm information (R52 to R54)
Load monitor Teaching/monitor execution, Teaching mode select, Monitor mode select, Alarm reset, Warning reset (Y313 to Y317)
Load monitor Axis selection, Load change rate detection axis, Teaching data sub-No. (R116 to R118)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SERVO DEFLECTION AMOUNT nTH AXIS		P C	R1100 to 15	R1116 to 31	R1100 to 15	R1116 to 31

[Function]

The deflection amount of the servo nth axis is output always in the command unit.

[Operation]

Servo 1st part system 1st axis : R1100 (LOW) R1101 (HIGH)
:
Servo 1st part system 8th axis : R1114 (LOW) R1115 (HIGH)
Servo 2nd part system 1st axis : R1116 (LOW) R1117 (HIGH)
:
Servo 2nd part system 8th axis : R1130 (LOW) R1131 (HIGH)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SYNCHRONOUS ERROR AMOUNT n-TH AXIS		P C	R1350, 1 to R1376, 7	—	R1350, 1 to R1376, 7	—

[Function]

The synchronization error amount during the synchronous control is output. (Unit: command unit)

[Operation]

The synchronization error amount between the basic axis and synchronous axis during the synchronous control is output to the synchronous axis.

(The axis Nos. are not for the part system, but for the whole system.)

Synchronization error amount	R register	Synchronization error amount	R register
1st axis	R1350 (L)/R1351 (H)	8th axis	R1364 (L)/R1365 (H)
2nd axis	R1352 (L)/R1353 (H)	9th axis	R1366 (L)/R1367 (H)
3rd axis	R1354 (L)/R1355 (H)	10th axis	R1368 (L)/R1369 (H)
4th axis	R1356 (L)/R1357 (H)	11th axis	R1370 (L)/R1371 (H)
5th axis	R1358 (L)/R1359 (H)	12th axis	R1372 (L)/R1373 (H)
6th axis	R1360 (L)/R1361 (H)	13th axis	R1374 (L)/R1375 (H)
7th axis	R1362 (L)/R1363 (H)	14th axis	R1376 (L)/R1377 (H)

[Cautions]

This signal is common to the simple C-axis synchronous control.

[Related signals]

(1) Synchronous control request (SYNC1 to 8: Y3A8 to F)
(2) Superimposition control request (PILE1 to 8: Y3B0 to 7)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	NO. OF WORK MACHINING (current value, max. value)		P C	R2896 to 9	R1892 to 5	R2896 to 9	R1892 to 5

[Function]

The No. of work machining current value and maximum value are notified by the controller to the PLC.

[Operation]

If data is set in the No. of work machining (WRK COUNT M) and work machining maximum value (WRK LIMIT) of the [Process parameters], the current value or maximum value of the No. of work machining is output.

R2896 (R1892)	No. of work machining	Low-order side
R2897 (R1893)	Current value	High-order side

R2898 (R1894)	No. of work machining	Low-order side
R2899 (R1895)	Maximum value	High-order side

The register shown in parentheses is for the 2nd part system.

(Note 1) If data is not set in "WRK COUNT M" and "WRK LIMIT" on the [Process Parameter] screen, data will not be output to the file register.

(Note 2) If the No. of work machining matches or exceeds maximum value, the No. of work machining over signal (X26E) turns ON.

<Counting of No. of work machining using user PLC>

(1) Set "0" in "WRK COUNT M" on the [Process Parameter] screen. With this setting, the controller side will not count up.
(2) Add "1" to R2896, 7 (R1892,3 for 2nd part system) with the user PLC.
(3) The controller will display R2896, 7 (R1892,3 for 2nd part system) as the No. of work machining on the [COORDINATE] screen. Even in this case, if the No. of work machining matches or exceeds the work maximum value, the No. of work machining over signal (X26E) will turn ON.

6.3 PLC Output Signals (Bit Type: Y***)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	CONTROL AXIS DETACH n-TH AXIS	DTCH1 to 8	—	Y180 to 7	W0 to 7	Y180 to 7	Y540 to 7

[Function]

Desired control axis can be specified to be exempted from control function.
Each control axis is provided with this signal. The last numeric of signal name indicates axis No. to be detached.

DTCHn

- 1 ..... 1st axis is detached
- :
- :
- 8 ..... 8th axis is detached

[Operation]

When "Control axis detach" signal (DTCHn) turns ON, the corresponding axis is exempted from control.

(1) Specified axis is not under any positioning control (oriented spindle stop, index, etc.)
(2) "Servo alarm", "Stroke end alarm" and other alarms are not applied to specified axis.
(3) Interlock signal applied to specified axis is deemed to be ON.
(4) Specified axis is displayed by the setting and display unit.

(Note 1) The same function can be used by setting parameter on the setting and display unit. (See below)

The control axis detach is valid when the following are valid:

Control axis detach nth axis (DTCHn)	or	Basic specification parameter "#1070 axoff" (axis detach), and axis parameter of machining parameter "#8201 AX. RELEASE"

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	SERVO OFF n-TH AXIS	*SVF1 to 8	—	Y188 to F	W8 to F	Y188 to F	Y548 to F

[Function]

Control axis (axis motion under control) can be set to "Servo OFF" (i.e., servo motor remains still).
In servo OFF condition, positioning control is impossible but the position detect function is alive.
Each control axis is provided with this signal. The last numeric of signal name indicates No. of control axis.

*SVFn
- 1 ..... 1st axis in "Servo OFF"
- :
- :
- 8 ..... 8th axis in "Servo OFF"

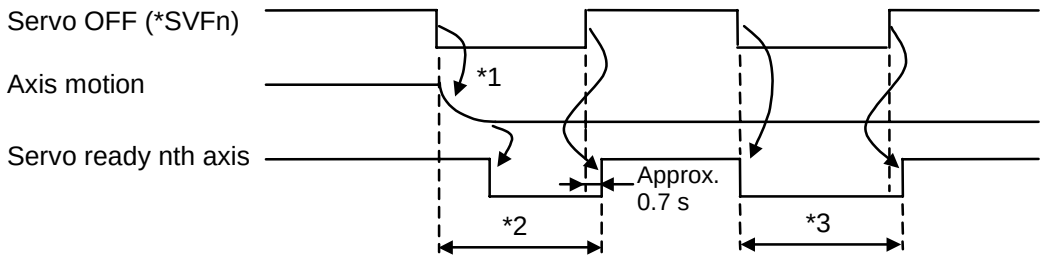
[Operation]

When "Servo OFF" signal (*SVFn) turns OFF, the corresponding control axis is set to servo OFF condition.
Whether displacement which was caused during servo OFF by external force is corrected when "Servo ON" signal is given, or not, can be determined by setting parameter.

(1) When displacement is corrected (follow-up):
- An amount of motion equal to the displacement is commanded so that positioning error becomes zero.
- In this case, machine position remains deviated from in-position when "Servo OFF" signal is restored.
  The current position read by position counter is corrected and the machine position is corrected when the next absolute motion command is given ("Manual absolute" signal (ABS) is turned ON when manual operation is selected).

(2) When displacement is not corrected:
- In this case, machine position should be corrected when "Servo OFF" signal is restored.

(Example) Servo-OFF during motion



*1: Servo turns OFF after deceleration and stopping during axis motion.
*2, 3: Controller internal interlock by servo OFF (axis motion not possible)

[Caution]

These signals are all handled as B contacts.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MIRROR IMAGE nTH AXIS	MI1 to 8	P C	Y190 to 7	W10 to 17	Y190 to 7	Y550 to 7

[Function]

This signal is used to machine a symmetrical shape by reversing the sign for the movement amount per block.

Each control axis is provided with this signal. The last number of signal name indicates No. of control axis.

M I n

1: Mirror image is applied ON 1st axis.
:
:
8: Mirror image is applied ON 8th axis.

[Operation]

Symmetrical cutting is enabled by reversing the sign of the value commanded for memory or MDI operation.

(1) Regardless of whether the coordinate command value is an incremental value or absolute value, the mirror image is applied ON the incremental amount to be executed for all axes that can be controlled.

(Note) The mirror image is changed after block stop.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	EXTERNAL DECELERATION + nTH AXIS	*+EDT1 to 8	P C	Y198 to F	W18 to F	Y198 to F	Y558 to F

[Function]

The feedrate when the control axis is moving in the + direction can be controlled while this signal (*+EDTn) is OFF, at a constant speed set with the parameters.

This signal is present for each control axis. The end numbers in the signal name indicate the control axis No.

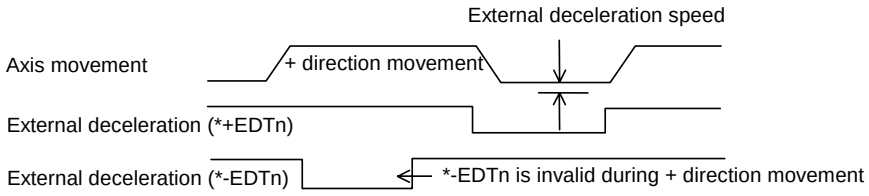
* + E D T n

1 ... The 1st axis is decelerated.
:
:
8 ... The 8th axis is decelerated.

[Operation]

During manual mode when the "External deceleration" signal (*+EDTn) turns OFF, each axis decelerates independently. However, during automatic mode, all axes will decelerate at the same deceleration speed when even one axis matches the external deceleration conditions. The deceleration occurs when the movement axis direction matches the "External deceleration" signal direction of the corresponding axis.

(1) The external deceleration speed can be randomly set with the parameters. (#1216 extdcc)
(2) When the speed is less than the external deceleration speed, it will not be affected even if this signal is OFF.
(3) The deceleration speed during automatic operation will be the combined deceleration speed, if the deceleration conditions match and the external deceleration speed is exceeded.
(4) When returning in the reverse direction, the speed will immediately return to the correct command speed.
(5) For G28, G29 and G30 commands, the speed will become the external deceleration speed for that axis only, even in automatic operation.
(6) The speed will become the external deceleration speed even in rapid traverse during synchronous tapping.



[Caution]

(1) The external deceleration signal is handled as a B contact (*) signal, but changes to 1 (ON) when the power is turned ON. When not being used, it is not necessary be concerned with external deceleration when programming.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	EXTERNAL DECELERATION -nTH AXIS	*-EDT1 to 8	P C	Y1A0 to 7	W20 to 7	Y1A0 to 7	Y560 to 7

[Function] [Operation]

The functions and operations of this signal are the same as those of "External deceleration + nth axis" signal (*+EDTn). The deceleration occurs when the movement is in the minus direction and the "External deceleration - nth axis" signal (*-EDTn) is OFF.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	AUTO INTERLOCK + nTH AXIS	*+AIT1 to 8	P C	Y1A8 to F	W28 to F	Y1A8 to F	Y568 to F

[Function]

All axis motions of machine can be decelerated and stopped immediately during automatic operation when motion of a specific axis (nth axis) in plus direction activates the interlock function.
These signals are for each control axis, and the number at the end of the signal name indicates the control axis No.

*+AITn
- 1 ..... Automatic interlock (+) 1st axis
- :
- :
- 8 ..... Automatic interlock (+) 8th axis

[Operation]

When this signal turns OFF for a specific axis in motion in the plus direction under automatic operation mode (memory, MDI, tape), motion of all axis decelerates and stops with "M01 operation error code 004" displayed. With this signal set OFF from the beginning, the system completes calculation for axis motion but makes it remain stopped with the same operation error code displayed. In either case, setting the signal ON resumes or starts axis motion.

[Related signals]

Auto interlock, - nth axis (*-AITn: Y1B0)
Manual interlock, +/- nth axis (*+/-MITn: Y1B8/Y1C0)

[Cautions]

(1) All automatic interlock signals are for B contact.
(2) The "Automatic interlock" signal is set to 1 when the power is turned ON, so an interlock cancel state in the sequence program does not need to be created for the axis not being used.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	AUTO INTERLOCK - nTH AXIS	*-AIT1 to 8	P C	Y1B0 to 7	W30 to 7	Y1B0 to 7	Y570 to 7

[Function] [Operation]

The details are the same as the "Automatic interlock +nth axis" signal, except that the direction is opposite.
The "Automatic interlock +nth axis" signal is valid for the axis moving in the plus direction, and this signal is valid for the axis moving in the minus direction.
These signals are for each control axis, and the number at the end of the signal name indicates the control axis No.

*-AITn
- 1 ..... Automatic interlock (-) 1st axis
- :
- :
- 8 ..... Automatic interlock (-) 8th axis

[Related signals]

Auto interlock, + nth axis (*+AITn: Y1A8)
Manual interlock, +/- nth axis (*+/-MITn: Y1B8/Y1C0)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	MANUAL INTERLOCK + n-TH AXIS	*+MIT1 to 8	P C	Y1B8 to F	W38 to F	Y1B8 to F	Y578 to F

[Function]

When the corresponding axis is moving in the plus direction with manual operation (jog, manual, incremental, reference position return), only the corresponding axis can be decelerated and stopped by turning OFF this signal that corresponds to that axis.
These signals are for each control axis, and the number at the end of the signal name indicates the control axis No.

*+MITn
- 1 ..... Manual interlock (+) 1st axis
- :
- :
- 8 ..... Manual interlock (+) 8th axis

[Operation]

When this signal turns OFF (0) for a specific axis in motion in the plus direction under manual operation mode (jog, handle, incremental, reference position return), motion of the axis decelerates and stops with NC alarm "M01 OPERATION ERROR 0004" displayed. With this signal set OFF from the beginning, the system completes calculation for axis motion but makes it remain stopped with the same operation error code displayed. In either case, setting the signal ON (1) resumes or starts axis motion.

[Related signals]

Manual interlock, - nth axis (*-MITn: Y1C0)
Auto interlock, +/- nth axis (*+/-AITn: Y1A8/Y1B0)

[Cautions]

(1) All interlock signals are for B contact.
(2) The "Manual interlock" signal is set to 1 when the power is turned ON, so an interlock cancel state in the sequence program does not need to be created for the axis not being used.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	MANUAL INTERLOCK - n-TH AXIS	*-MIT1 to 8	P C	Y1C0 to 7	W40 to 7	Y1C0 to 7	Y580 to 7

[Function] [Operation]

The details are the same as the "Manual interlock +nth axis" signal, except that the direction is opposite.
The "Manual interlock +nth axis" signal is valid for the axis moving in the plus direction, and this signal is valid for the axis moving in the minus direction.
These signals are for each control axis, and the number at the end of the signal name indicates the control axis No.

*-MITn
- 1 ..... Manual interlock (-) 1st axis
- :
- :
- 8 ..... Manual interlock (-) 8th axis

[Related signals]

Manual interlock, + nth axis (*+MITn: Y1B8)
Auto interlock, +/- nth axis (*+/-AITn: Y1A8/Y1B0)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	AUTO MACHINE LOCK n-TH AXIS	AMLK1 to 8	P C	Y1C8 to F	W48 to F	Y1C8 to F	Y588 to F

[Function]

During automatic operation, current position (counter) can be changed without actual machine motion to check program.
These signals are for each control axis, and the number at the end of the signal name indicates the control axis No.

AMLKn
- 1 ..... Automatic machine lock 1st axis
- :
- 8 ..... Automatic machine lock 8th axis

[Operation]

In the automatic operation (memory, MDI or tape), when this signal is ON, the current position (counter) can be changed on a specific axis (for which the signal is ON) without actual machine motion. If the signal turns ON in the middle of a block (during motion), block termination occurs after the completion of that block, and then the machine lock will be valid for the following blocks.

[Related signal]

Manual machine lock, nth axis (MMLKn: Y1D0)

[Cautions]

(1) If "Auto machine lock" signal changes during automatic operation, block stop occurs after completion of the block in execution.
(2) To move only the table without drilling to confirm the drilling position, turn ON the signal for the 3rd axis (AMLK3) if the drilling axis is the 3rd axis. (Equivalent to Z axis cancel)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL MACHINE LOCK n-TH AXIS	MMLK1 to 8	P C	Y1D0 to 7	W50 to 7	Y1D0 to 7	Y590 to 7

[Function]

During manual operation, current position (counter) can be changed without actual machine motion to check program.

[Operation]

When this signal is ON, current position can be changed on a specific axis (nth axis) without actual machine motion. If the signal turns ON or OFF during execution of a block, the operation continues until it is completed. It is required to stop motion of all axes to validate the machine lock.
These signals are for each control axis, and the number at the end of the signal name indicates the control axis No.

MMLKn
- 1 ..... Manual machine lock 1st axis
- :
- 8 ..... Manual machine lock 8th axis

[Related signal]

Auto machine lock, nth axis (AMLKn: Y1C8)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	FEED AXIS SELECT + n-TH AXIS	+J1 to 8	—	Y1D8 to F	W58 to F	Y1D8 to F	Y598 to F

[Function]

This signal is used to start motion (jog feed, incremental feed or reference position return mode) in plus direction during manual operation.

These signals are for each control axis, and the number at the end of the signal name indicates the control axis No.

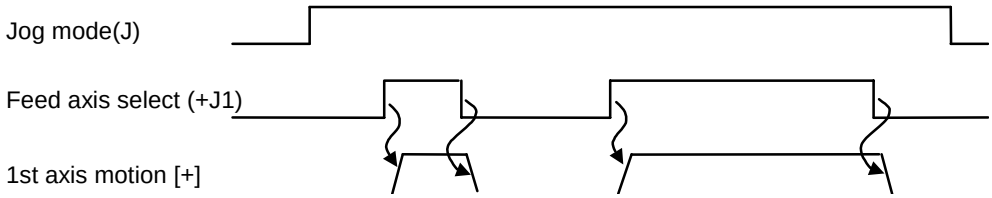
+Jn
- 1 ... 1st axis is selected for feed motion
- :
- :
- 8 ... 8th axis is selected for feed motion
- +... Feed motion in + direction
- - ... Feed motion in - direction

[Operation]

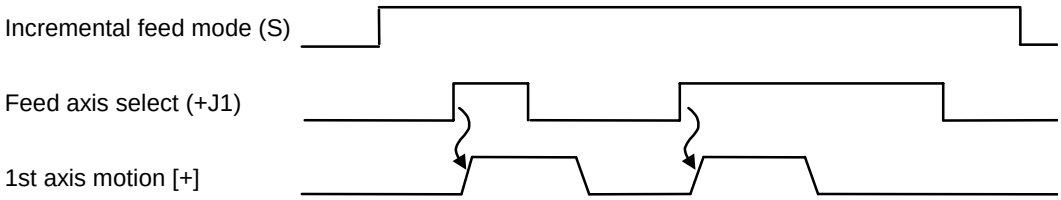
When "Feed axis select" signal (+Jn) turns ON, the following motion occurs.

(1) When jog feed, incremental feed or reference position return is possible, motion in plus direction occurs on the selected axis.

(2) In jog feed, motion continues while the signal is ON.



(3) In incremental feed, amount (length) of motion depends on setting of "Handle/Incremental feed multiplication". The motion is in plus direction. Even when signal (+Jn) turns OFF during motion, the motion (feed) does not stop. To start the motion again, turn ON the signal after the preceding motion has been completed.



(4) After reference position return mode is decelerated to approach speed by the near point detect dog, the motion continues, even after the feed axis select signal is turned OFF, until motion reaches the reference position.

(Note 1) If feed axis select plus [+] and minus [-] signals turn ON at the same time, neither plus signal nor minus signal is selected (same as the case where feed axis select signal is OFF.)

(Note 2) If "Feed axis select" signal turns ON before jog, incremental or reference position return mode is selected, the "Feed axis select" signal is ignored. In this case, the signal should be turned OFF and then ON.

(Note 3) If reset is exerted while "Feed axis select" signal is ON, or "Feed axis select" signal turns ON during reset, the "Feed axis select" signal is ignored even when the reset condition is canceled. In this case, the this signal should be turned OFF and then ON.

(Note 4) The "Feed axis select" signal will be invalid even if turned ON while the corresponding axis is decelerating (when command output is not completed). The signal must be turned OFF and ON again after the deceleration has completed completely (command output is completed). Special care is required when the feed axis direction changes.

(Note 5) In the 2nd part system specifications, even if the 1st part system and 2nd part system feed axis select turn ON in the same cycle (scan) of the sequence, the start up may not be completely simultaneous.

[Related signal]

(1) Feed axis select - nth axis (-Jn: Y1E0)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	FEED AXIS SELECT - n-TH AXIS	-J1 to 8	—	Y1E0 to 7	W60 to 7	Y1E0 to 7	Y5A0 to 7

[Function]

This signal is used to feed the axis in the minus (-) direction during jog feed, incremental feed or reference position return mode in manual operation.

These signals are for each control axis, and the number at the end of the signal name indicates the control axis No.

(Refer to the "Feed axis selection + nth axis" for details.)

[Operation]

The operation is the same as the feed axis select (+).

Use this signal to move in the minus (-) direction.

[Related signals]

Feed axis select + nth axis (+Jn: Y1D8)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	CHOPPING	CHPS	P C	Y1E8	W68	Y1E8	Y5A8

[Function]

With this function, the chopping axis is always returned independently of the program operation during executing the program.

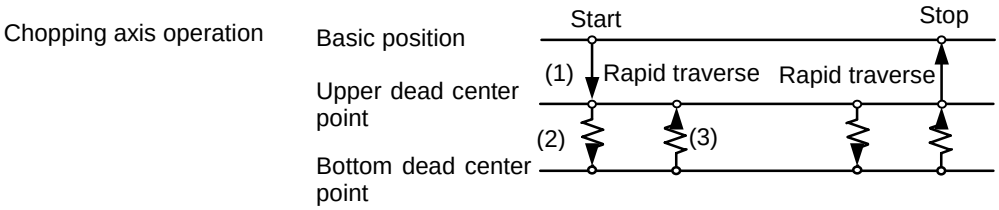
[Operation]

■ Chopping operation start

The chopping mode is entered when the "Chopping" (Y1E8) turns ON, and the chopping operation is started based on the position positioned with the program, etc.

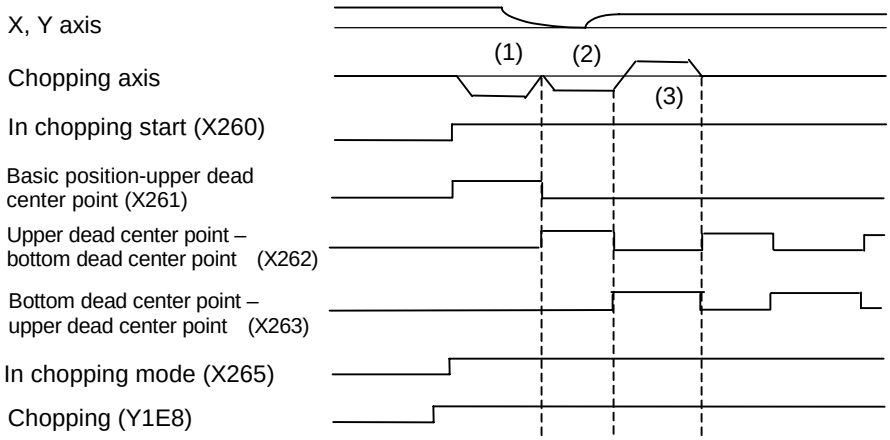
The chopping control sequence is the following.

1) When the chopping axis is not moving, chopping is started immediately.
2) When the chopping axis is moving, chopping is valid from the next block in the automatic mode, and an operation alarm will occur in the manual mode.

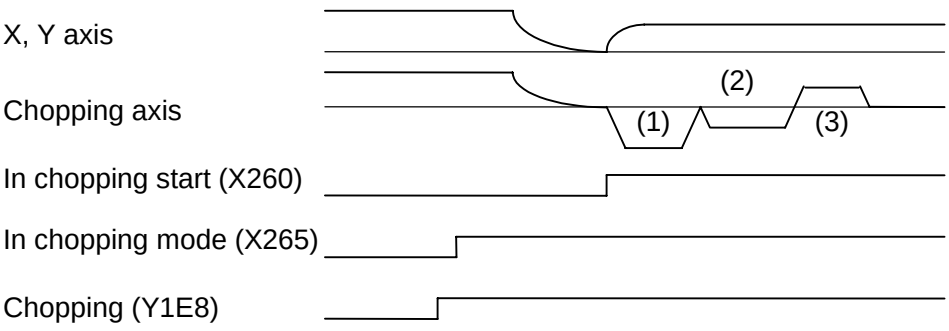


(1) In automatic mode

(a) When the chopping axis is not moving:



(b) When the chopping axis is moving:



The "In chopping start" is entered after the chopping axis movement has been finished.

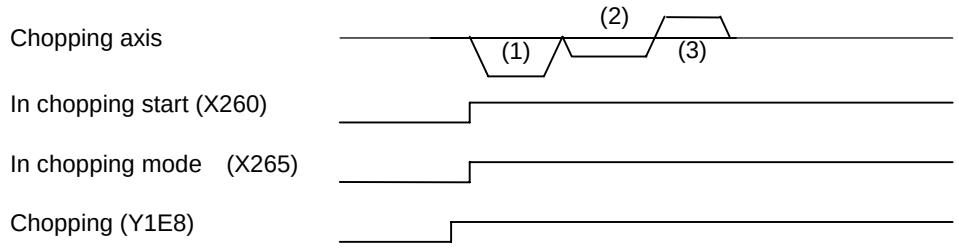
(2) In manual mode

In the jog and step mode, when the chopping axis is not moving, the chopping operation is started when the "Chopping" signal turns ON.

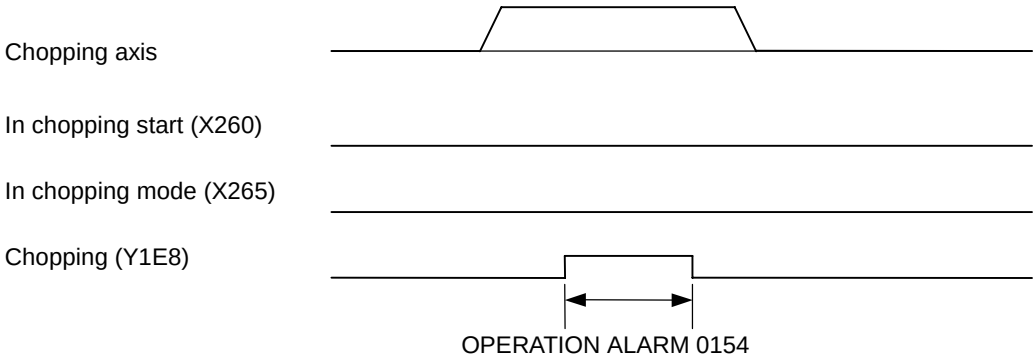
If the "Chopping" signal is turned ON when the chopping axis is moving, the OPERATION ALARM 0154 will occur, and the chopping will not be started.

(The "Chopping" signal's turning ON is ignored.)

(a) When the chopping axis is not moving:



(b) When the chopping axis is moving:



In the handle mode, when the chopping axis is not selected to the handle axis, the chopping operation is started when the "Chopping" signal turns ON

If the "Chopping" signal is turned ON when the chopping axis is selected to the handle axis, the OPERATION ALARM 0154 will occur, and the chopping is not started.

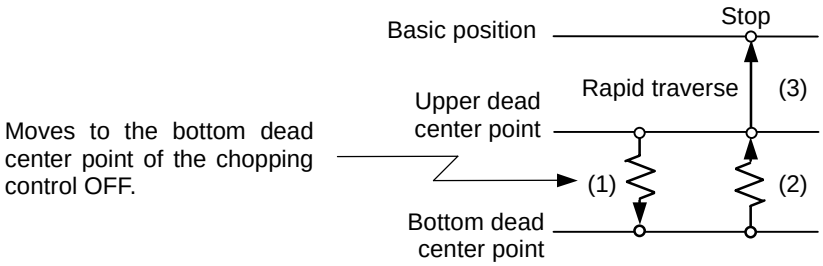
■ Chopping operation stop

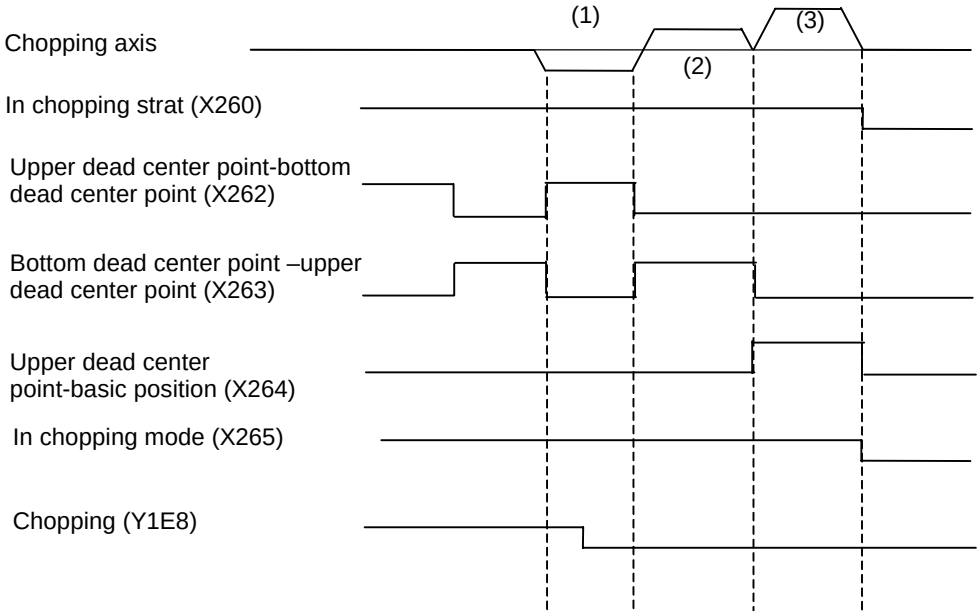
The chopping operation is stopped when the "Chopping" signal from the PLC turns OFF.

The chopping axis moves to the basic position with the rapid traverse after executing the chopping operation to the upper dead center point.

The chopping axis once moves to the bottom dead center point even when moving from the upper dead center point to the bottom dead center point.

Stop operation of chopping axis





The "In chopping start" and the "In chopping mode" signals are turned OFF after return to the basic position completes.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL/AUTO SIMULTANEOUS VALID n-TH AXIS	MAE1 to 8	PC	Y1F0 to 7	W70 to 7	Y1F0 to 7	Y5B0 to 7

[Function]

The automatic mode (tape, MDI, memory) and manual mode (handle, step, jog, manual reference position return) can be simultaneously selected allowing manual operation during automatic operation. (Random feed with the PLC is also possible.)

[Operation]

The manual/auto simultaneous mode is entered when the automatic mode and manual mode are selected simultaneously. The manual operation axis is selected with this signal during the manual/auto mode. The manual operation axes (MAEn) are selected individually for the 1st to 8th axes.
The axis selected with this signal can be operated in the manual mode during automatic operation.

(Note 1) If an axis command is issued to a manual operation axis from the automatic mode, the "M01 OPERATION ERROR 0005" will occur. The automatic operation will be interlocked until the operation error is canceled.

(Note 2) During the automatic mode (when manual is not selected and manual/auto simultaneous mode is not entered), this signal will be invalid and the interlock will not be applied.

(Note 3) If this signal turns ON in respect to an axis commanded with automatic during the manual/auto simultaneous mode, an interlock will be applied on the axis, and the axis will immediately decelerate and stop. (The "M01 OPERATION ERROR 0005" will occur.)
After decelerating and stopping, operation with the manual mode will be possible. Note that the interlock will also be applied during the tap modal.

(Note 4) During the manual/auto simultaneous mode and the automatic mode, the manual axis command for which this signal is OFF will be invalid. Note that interruption with the manual handle will be possible.

(Note 5) The feedrates for the automatic command axis and the manual command axis are different. The acceleration/deceleration mode (rapid traverse, cutting feed) are also independent.

(Note 6) The rapid traverse override, cutting feed override and 2nd cutting feedrate override are valid for both the automatic command axis and manual command axis. (Note that the cutting and 2nd cutting overrides to the manual command axis are valid when the manual cutting override is valid.) Override cancel is valid for the automatic command axis.

(Note 7) The manual interlock is valid for the manual command axis, and the automatic interlock is valid for the automatic command axis.

(Note 8) The in-cutting feed and in-rapid traverse signals will follow the automatic command axis movement mode.

(Note 9) The axis moving with manual movement will not stop with single block stop or feed hold.

(Note 10) If the G92 and G53 commands are issued in the manual mode to an axis for which this signal is ON, the G92 and G53 commands will be executed after the manual axis movement stops. (An axis command with G53 will cause an operation error after the manual axis movement stops.)

(Note 11) If a soft limit or OT is applied on the manual command axis during the manual/auto simultaneous mode, the automatic command axis will also decelerate to a stop, and will enter the feed hold state.

<Relation with manual handle interrupt>

The operation of the automatic handle interruption during the manual/auto mode is as follows.

		Axis for which manual/ auto valid signal is ON	Axis for which manual/ auto valid signal is OFF
Handle mode selection	Automatic handle interrupt	The specifications of the manual/auto simultaneous mode will be followed. The automatic axis command will cause an operation error, and only the manual axis command will be valid.	The specifications of the automatic handle interruption will be followed. Interruption with the handle can be applied in respect to the automatic axis movement.
Manual mode other than handle		Same as above	Same as above

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SEARCH & START	RSST	PC	Y1FA	W7A	Y1FA	Y5BA

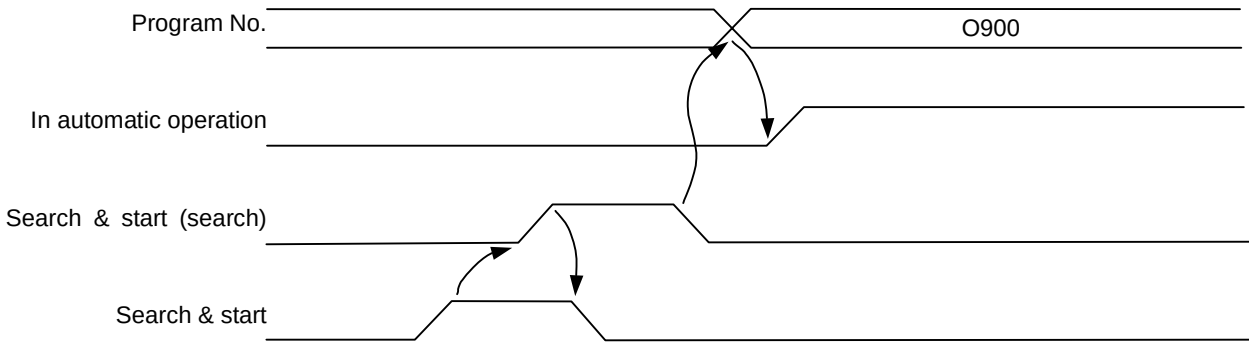
[Function]

This signal is input into the controller when executing operation search in the memory mode and carrying out automatic start up.

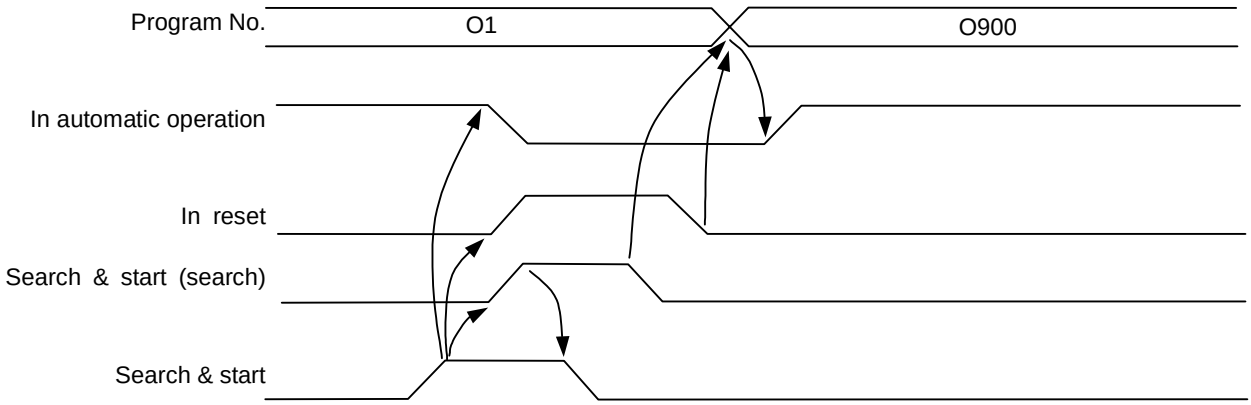
[Operation]

If this signal is input when the memory operation mode is selected, an operation search of the machining program with the designated No. (R170, 171) will be carried out. After the search, the program will be automatically started.
If this signal is input during automatic operation, the program will be reset before the search. After the resetting is completed, the search and automatic start operations will be executed.
Hold the search & start signal until the search & start (search) signal turns ON.

(Example) The O900 machining program is designated and search & start is executed in a state other than automatic operation.



(Example) When O900 machining program is designated during operation of the O1 machining program, and search & start is executed.



(**Note 1)** This signal is valid only when the memory mode is selected.
(Note 2) An error signal will be output if the machining program No. is not designated or if the designated program No. is illegal (0 or exceeding 99999999).
(Note 3) This signal is valid at the rising edge.
(Note 4) If this signal is input during resetting, the search & start will not be executed.

[Related signals]
(1) Search & start program No. (R170, 171)
(2) Search & start (error) (SSE: X1C2)
(3) Search & start (search) (SSG: X1C3)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	REFERENCE POSITION SELECT 1, 2	ZSL1, 2	P C	Y200, 1	W80, 1	Y200, 1	Y5C0, 1

[Function]

It is also possible to return to the nth reference position in the manual reference position return mode. This signal is used to select the number of the reference position (n) to return to. Normally both the reference position select signals 1 and 2 are turned OFF, and 1st point reference position return is performed.

[Operation]

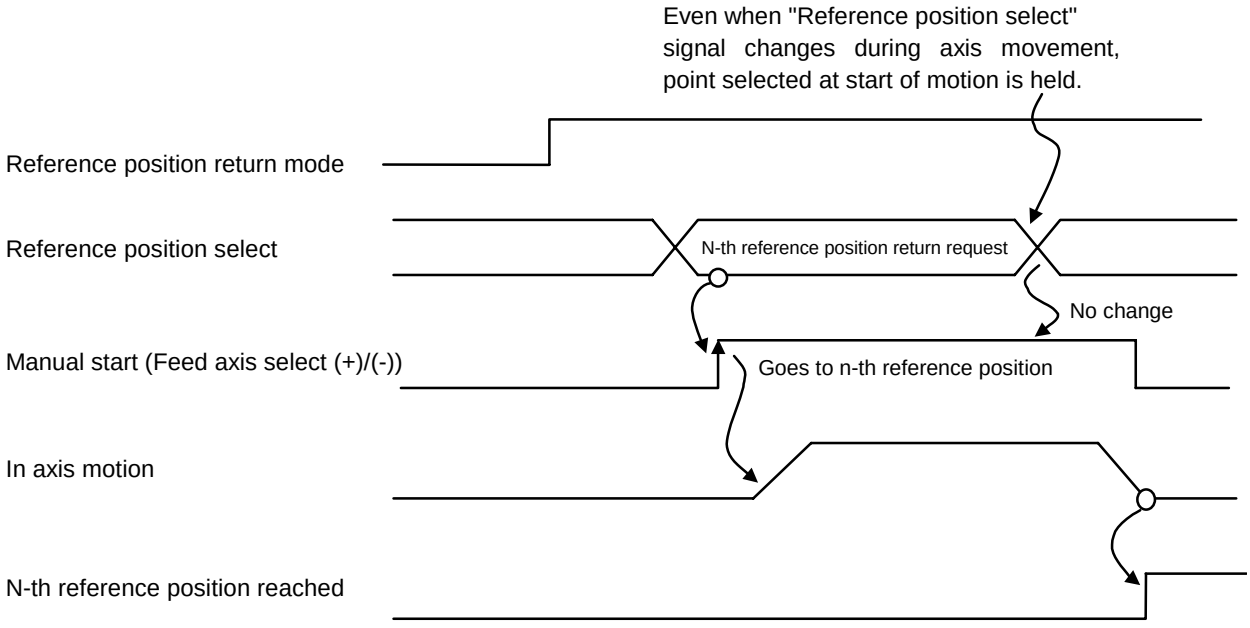
"Reference position select" signal 1, 2 is valid when:

(1) Reference position return mode is ON ("1").
(2) Manual start condition is held.

Reference position select 2	Reference position select 1	Return position
0	0	1st reference position
0	1	2nd reference position
1	0	3rd reference position
1	1	4th reference position

(Note 1) Returning to the first reference position must be performed before returning to the second, third or forth reference position.

[Operation sequence]



[Related signals]

(1) Reference position return mode (ZRN: Y20C)
(2) Feed axis select (+Jn: Y1D8, -Jn: Y1E0)
(3) N-th reference position reached (ZP11 to 48: X1A0 to X1BF)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	REFERENCE POSITION SELECT METHOD		P C	Y207	W87	Y207	Y5C7

[Function]

This signal selects whether the reference position selection is common for all axes (Y200, Y201) or independent for each axis (R120).

[Operation]

When this signal is OFF, the reference position selection is common for all axes, and Y200 and Y201 are valid.
When this signal is ON, the reference position selection is independent for each axis, and R120 is valid.

[Related signals]

Reference position select 1, 2 (ZSL1, 2: Y200, Y201)
Each axis reference position select (R120)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	JOG MODE	J	—	Y208	W88	Y208	Y5C8

[Function]

JOG operation mode (manual operation) is selected.

[Operation]

When JOG mode signal (J) turns ON, JOG operation mode is selected.
Axis motion is started by turning ON the "Feed axis select plus (+J1 to 8) or minus (-J1 to 8)" signal after turning ON the jog mode and setting the manual feedrate (*JV1 to 16).
For rapid traverse, "Rapid traverse" signal (RT) is turned ON together with this signal (J).
If the operation mode duplicates the other mode or if it is removed, the NC alarm "M01 OPERATION ERROR 0101" will occur.

[Related signals]

(1) Feed axis select (+J1 to 8: Y1D8, -J1to 8: Y1E0)
(2) Manual feedrate (*JV1 to 16: Y2B0 to Y2B4)
(3) Rapid traverse (RT: Y22E)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	HANDLE MODE	H	—	Y209	W89	Y209	Y5C9

[Function]

"Handle feed operation" mode (manual operation) is selected.

[Operation]

When HANDLE mode signal (H) is turned ON, HANDLE FEED mode is selected.
Axis motion starts when the manual pulse generator handwheel is rotated after axis is selected by handle axis select code (HS11 to 116, HS1S, HS21 to 216, HS2S, HS31 to 316, HS3S) and this signal is turned ON. Speed of the axis motion depends on setting of feedrate multiplication (MP1 to 4).
If the operation mode duplicates the other mode or if it is removed, the NC alarm "M01 OPERATION ERROR 0101" will occur.

[Related signals]

(1) 1st handle axis No. (HS11 to 116: Y248), 1st handle valid (HS1S: Y24F)
(2) 2nd handle axis No. (HS21 to 216: Y250), 2nd handle valid (HS2S: Y257) ..... Valid only for handle 2-axis spec.
(3) 3rd handle axis No. (HS31 to 316: Y258), 3rd handle valid (HS3S: Y25F) ..... Valid only for handle 3-axis spec.
(4) Handle/Incremental feed multiplication (MP1 to 4: Y2C0 to Y2C2)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	INCREMENTAL MODE	S	—	Y20A	W8A	Y20A	Y5CA

[Function]

INCREMENTAL FEED mode (manual operation) is selected.

[Operation]

When incremental mode command signal (S) is turned ON, INCREMENTAL FEED mode is selected.
Each time "Feed axis select" signal (+J1 to 8, -J1 to 8) for desired axis is turned ON, axis motion starts. Speed of the axis motion (incremental feed) depends on setting of "Handle/Incremental feed multiplication" (MP1 to 4).
When "Rapid traverse" signal (RT) is ON, speed is the rapid traverse speed. When signal (RT) is OFF, speed is equal to "Manual federate" (*JV1 to 16).
If the signal is the same as another operation mode or if it is removed, the NC alarm "M01 OPERATION ERROR 0101" will occur.

(Note 1) The incremental mode is also called the step mode.

[Related signals]

(1) Handle/Incremental feed multiplication (MP1 to 4: Y2C0 to Y2C2)
(2) Feed axis select (+J1 to 8: Y1D8, -J1 to 8: Y1E0)
(3) Manual feedrate (*JV1 to 16: Y2B0)
(4) Rapid traverse (RT: Y22E)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL RANDOM FEED MODE	PTP	PC	Y20B	W8B	Y20B	Y5CB

[Function]

MANUAL RANDOM FEED mode in manual operation is selected.

[Operation]

MANUAL RANDOM FEED mode is selected when this signal is turned ON ("1").

[Caution]

To turn the MANUAL RANDOM FEED mode ON, the rest of the manual modes and the automatic mode must be OFF (0). Otherwise, this mode cannot be selected. (Note that this mode can be selected simultaneously when manual/automatic simultaneous is valid.)

[Related signals]

(1) Signals from PLC to controller

Device No. 1st system	Device No. 2nd system	Abbreviation	Signal name	Device No. 1st system	Device No. 2nd system	Abbreviation	Signal name
Y268	WE8	CX11	Manual random feed, 1st axis No.	Y270	WF0	CX21	Manual random feed, 2nd axis No.
Y269	WE9	CX12		Y271	WF1	CX22	
Y26A	WEA	CX14		Y272	WF2	CX24	
Y26B	WEB	CX18		Y273	WF3	CX28	
Y26C	WEC	CX116		Y274	WF4	CX216	
Y26D	WED		(Always "0")	Y275	WF5		(Always "0")
Y26E	WEE		(Always "0")	Y276	WF6		(Always "0")
Y26F	WEF	CX1S	Manual random feed 1st axis valid	Y277	WF6	CX2S	Manual random feed 2nd axis valid

Device No. 1st system	Device No. 2nd system	Abbreviation	Signal name	Device No. 1st system	Device No. 2nd system	Abbreviation	Signal name
Y278	WF8	CX31	Manual random feed, 3rd axis No.	Y280	W100	CXS1	Smoothing off
Y279	WF9	CX32		Y281	W101	CXS2	Axis independent
Y27A	WFA	CX34		Y282	W102	CXS3	EX. F/MODAL.F
Y27B	WFB	CX38		Y283	W103	CXS4	G0/G1
Y27C	WFC	CX316		Y284	W104	CXS5	MC/WK
Y27D	WFD		(Always "0")	Y285	W105	CXS6	ABS/INC
Y27E	WFE		(Always "0")	Y286	W106	*CXS7	Stop
Y27F	WFF	CX3S	Manual random feed 3rd axis valid	Y287	W107	CXS8	Strobe

Device No. 1st system	Device No. 2nd system	Abbreviation	Signal name
R140	R340		Handle/Incremental feed multiplication
R141	R341		
R142	R342		Manual random feed 1st axis movement data
R143	R343		
R144	R344		Manual random feed 2nd axis movement data
R145	R345		
R146	R346		Manual random feed 3rd axis movement data
R147	R347		

(2) Signals from controller to PLC
- (a) In manual random feed mode (PTPO: X1E3)
- (b) In manual random feed (CXN: X1F6)
- (c) Manual random feed complete (CXFIN: X1FC)

(3) Other:
- (a) Feedrate least increment (PCF1: Y2B8, PCF2: Y2B9)
- (b) Manual/automatic simultaneous valid nth axis (MAE1~8)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	REFERENCE POSITION RETURN MODE	ZRN	—	Y20C	W8C	Y20C	Y5CC

[Function]

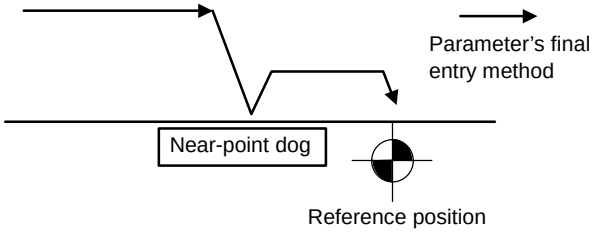
REFERENCE POSITION RETURN mode is selected.
"Reference position return" is that axis motion component (tool, table, etc.) is returned to the position previously determined for individual machine.

[Operation]

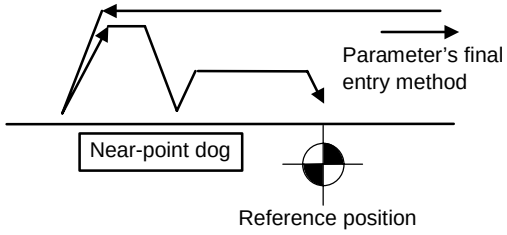
The reference position return mode is selected when the "Reference position return mode" signal (ZRN) is turned ON.
Select the reference position return mode, and turn ON the "Feed axis select" signal (+J1 to 8, -J1 to 8) of designated axis to return to the reference position.
If the signal is the same as another operation mode or if it is removed, the NC alarm "M01 OPERATION ERROR 0101" will occur.
The first reference position return after the controller power is turned ON is the dog-type return (excluding when the basic machine coordinate system is established for the absolute position detection specifications). After the second manual reference position return (when basic machine coordinate system is established), the dog-type or high-speed return is selected with the setup parameters, basic specification parameter "#1063 mandog".

(1) Dog-type reference position return pattern
The return pattern is determined by the final entry method of the setup parameter reference position return.

(a) Operation when axis is moved in same direction as the final entry method, and dog is tripped.



(b) When axis is moved in opposite direction from final entry method, and dog is tripped.



- After the near-point dog is detected and the approach speed is applied, the axis will move to the reference position even if the "Feed axis select" signal is turned OFF. Thus, after the approach speed is applied, another axis can be switched to and reference position return executed.
- The entry direction (final entry direction) after the near-point dog is tripped is set with parameters.
- The feedrate before the approach speed is the reference position return feedrate if the "Rapid traverse" signal (RT) is ON, and the "Manual feedrate" (*JV1 to 16) is OFF.
- The approach speed is set with the parameters.
- When the reference position is reached, the movement will stop even if the feed axis select signal is ON, and the "1st reference position reached" signal (ZP1n) will turn ON.

(2) High-speed reference position return
- The axis will move toward the reference position. The motion speed will be rapid traverse if the rapid traverse signal is ON, and manual feedrate if OFF.
- When the reference position is reached, the movement will stop even if the feed axis select signal is ON, and the "1st reference position reached" signal (ZP1n) will turn ON.
- The feed axis select signal for high-speed return is valid only in the reference position direction. If the opposite direction signal is designated, the NC alarm "M01 Operation error 0003" will occur.

[Related signals]

(1) Feed axis select (+J1 to 8: Y1D8, -J1 to 8: Y1E0)
(2) Manual feedrate (*JV1 to 16: Y2B0)
(3) Rapid traverse (RT: Y22E)
(4) 1st reference position reached (ZP11 to 18: X1A0 to 1A7)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	AUTOMATIC INITIALIZATION MODE	AST	P C	Y20D	W8D	Y20D	Y5CD

[Function]

The automatic initialization mode is selected.

[Operation]

This mode is selected when automatic initialization is to be carried out with the machine end stopper method of absolute position detection.
The initialization is started when the automatic initialization mode is selected, and the "Feed axis select" (+Jn, -Jn) signal in the direction of the machine end of the axis to be initialized is turned ON.

(Note 1) The automatic initialization mode is invalid when the absolute position detector is not provided and when the machine end stopper method is not selected for the absolute position detection.
(During feed axis selection, "M01 OPERATION ERROR 0024" will occur.)

(Note 2) This mode will not start in the following cases of the machine end stopper method absolute position detection.
(The message "Start not possible" will display.
• When #0 "INIT. SET" on the [ABS. POSITION SET] screen is not set to "1".
• When #2 "ZERO" on the [ABS. POSITION SET] screen has not been set.
• When #2055 [pushf] on the [ABS. POSI PARAM] screen has not been set.
• When "Z71 DETECTOR ERROR 0005" has occurred.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MEMORY MODE	MEM	—	Y210	W90	Y210	Y5D0

[Function]

MEMORY mode of automatic operation is selected.
In this mode of operation, automatic operation is based on programs stored in the memory.

[Operation]

- MEMORY mode is selected when "Memory mode" signal (MEM) turns ON.
- The program is started with the "Auto operation "start" command" signal (ST).
- If the automatic operation mode is duplicated or canceled during automatic operation, the NC alarm "M01 OPERATION ERROR 0101" will occur, and the block will stop.
- If the manual operation mode is entered or the program is duplicated with the manual operation mode during automatic operation, the NC alarm will occur, and automatic operation will stop. However, the manual and automatic programs can be duplicated if manual/automatic simultaneous operation is valid.

(Note 1) Even when operation mode is other than automatic operation, illegal mode, if selected, causes operation error.

[Related signals]

Auto operation "start" command (ST: Y218)
Auto operation "pause" command (*SP: Y219)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TAPE MODE	T	—	Y211	W91	Y211	Y5D1

[Function]

TAPE mode of automatic operation is selected.
In this mode of operation, automatic operation is based on tape command (RS232-C input) programs stored in NC tape.

[Operation]

- Tape mode is selected when "Tape moe" (T) signal turns ON.
- The program is started with the "Auto operation "start" command" signal (ST).
- If the automatic operation mode is duplicated or canceled during automatic operation, the NC alarm "M01 OPERATION ERROR 0101" will occur, and the block will stop.
- If the manual operation mode is entered or the program is duplicated with the manual operation mode during automatic operation, the NC alarm will occur, and automatic operation will stop. However, the manual and automatic programs can be duplicated if manual/automatic simultaneous operation is valid.

(Note 1) Even when operation mode is other than automatic operation, illegal mode, if selected, causes operation error.

[Related signals]

Auto operation "start" command (ST: Y218)
Auto operation "pause" command (*SP: Y219)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MDI MODE	D	—	Y213	W93	Y213	Y5D3

[Function]

MDI (Manual Data Input) mode of automatic operation is selected.
Automatic operation is performed with the program set in the MDI screen.

[Operation]

- MDI mode is selected when "MDI mode" (D) signal turns ON.
- The program is started with the "Auto operation "start" command" signal (ST).
- If the automatic operation mode is duplicated or canceled during automatic operation, the NC alarm "M01 OPERATION ERROR 0101" will occur, and the block will stop.
- If the manual operation mode is entered or the program is duplicated with the manual operation mode during automatic operation, the NC alarm will occur, and automatic operation will stop. However, the manual and automatic programs can be duplicated if manual/automatic simultaneous operation is valid.

(Note 1) Even when operation mode is other than automatic operation, illegal mode, if selected, causes operation error.

[Related signals]

Auto operation “start” command (ST: Y218)
Auto operation "pause" command (*SP: Y219)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	AUTO OPERATION "START" COMMAND (Cycle start)	ST	—	Y218	W98	Y218	Y5D8

[Function]

This signal is used to start automatic operation in MEMORY mode, MDI mode or TAPE mode, or to restart after automatic operation pause (halt) or block stop.

[Operation]

(1) "Auto operation "start" command" (ST) signal arises when the pressed "auto operation start" pushbutton is released (i.e. at the time the signal turns OFF). The signal must be ON for a min. of 100msec.
(2) "In auto operation "start"" signal (status signal "STL") turns ON when the pressed "auto operation start" pushbutton is released, and turns OFF when "auto operation pause (or halt)" pushbutton is pressed or block stop occurs in single-block operation.
(3) Signal (ST) is invalid when:
    - Automatic operation starts.
    - "Auto operation "pause" command" (*SP) signal is OFF.
    - During reset ("Reset & rewind" signal is ON).
    - During alarm.
    - Sequence No. is being searched for.

(4) Automatic operation stops or is suspended or block stops when:
- "Auto operation "pause" command" (*SP) signal turns OFF.
- Reset occurs ("Reset & rewind" signal turns ON).
- Alarm which causes stop to automatic operation occurs.
- Automatic operation mode is changed to manual operation mode.
- Mode is changed to other automatic operation mode and then the block in execution is completed.
- Block in execution is completed after "Single-block" (SBK) signal turns ON.
- Block in execution is completed after "Auto machine lock" signal (AMKL) turns ON.
- Program specified in MDI mode has been executed completely.

[Related signals]

Memory mode (MEM: Y210)
Tape mode (T: Y211)
MDI mode (D: Y213)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	AUTO OPERATION "PAUSE" COMMAND (Feed hold)	*SP	—	Y219	W99	Y219	Y5D9

[Function]

During automatic operation, axis motion can be decelerated and stopped with this command signal. To restart, press "Auto operation "start" command" (ST) signal pushbutton.

[Operation]

(1) When "Auto operation "pause" command" (*SP) signal turns OFF, automatic operation stops.
- During automatic operation, the operation stops. "In auto operation "pause"" (SPL) occurs.
- Restart with the automatic start (ST) button. (Press after turning *SP signal.)

(2) In the following cases, automatic operation does not immediately stop.
- During tapping in fixed cycle.
  Automatic operation stops when tapping is completed and the tool returns to "R" point.
- During thread cutting.
  Automatic operation stops when a block for axis motion (other than thread cutting), which comes first after the "Auto operation "pause" command" (*SP) signal turns OFF, is completed. If the "Auto operation "pause" command" (*SP) signal remains OFF, however, automatic operation stops immediately after a block (other than thread cutting) is given.
- When control variable "feed hold invalid" has been set by user macro.
  Automatic operation stops immediately after a block where the control variable "feed hold invalid" is cleared starts.

(3) "Auto operation "pause" command" (*SP) signal is valid even during machine lock.

[Related signals]

Memory mode (MEM: Y210)
Tape mode (T: Y211)
MDI mode (D: Y213)
Auto operation "start" command (ST: Y218)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SINGLE BLOCK	SBK	—	Y21A	W9A	Y21A	Y5DA

[Function]

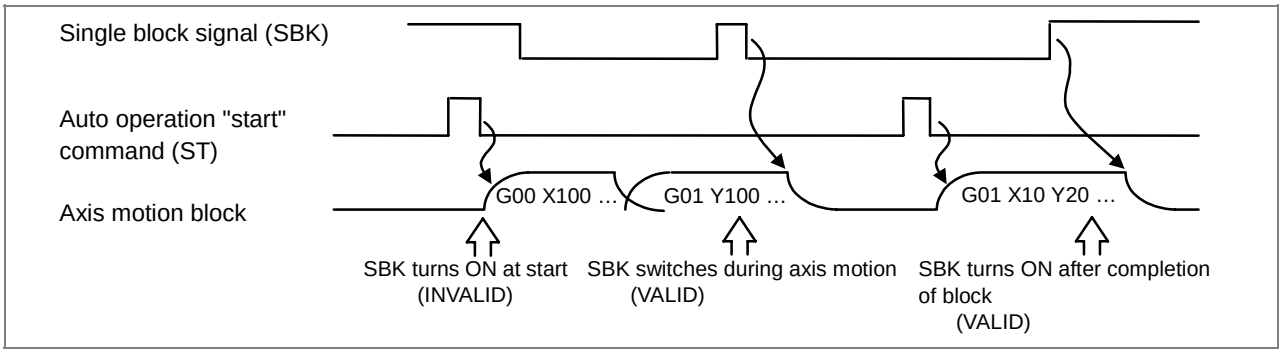
Machining program can be executed block by block in automatic operation.

[Operation]

(1) When "Single block" signal (SBK) turns ON, operation of controller is as follows:
- During automatic operation
  After the block in execution has been completed, automatic operation stops. To start execution of the next block, "Auto operation "start" command" (ST) must be turned ON to OFF.
- There will be no operation when automatic operation is not being executed but if automatic operation is started with the "Single block" signal (SBK) ON, one block will be executed and then will stop. This allows the commanded program to be executed one block at a time.

(2) If the "Single block" signal (SBK) is ON at the end of a block, operation will normally stop immediately. However, in the following case, operation will continue to where stopping is possible, and then will stop.
- During cycle operation such as a fixed cycle. The block where single block is being received will differ according to each cycle. Refer to the cycle sections in the Programming Manual.

<Example of operation pattern>



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	BLOCK START INTERLOCK	*BSL	—	Y21B	W9B	Y21B	Y5DB

[Function]

This signal prohibits start of the next block in automatic operation (memory, MDI or tape).

[Operation]

While the "Block start interlock" (*BSL) signal is OFF, execution of the next block may not be started in automatic operation. When the signal is given during execution of a block, the execution of the block continues until it is completed. Since the signal does not cause stop or suspension of automatic operation, execution of program starts when the "Block start interlock" (*BSL) signal turns ON.

(Note 1) This signal is valid to all blocks including blocks internally generated in controller by fixed cycle, etc.

(Note 2) The signal (*BSL) is ON when the power is turned ON. When the signal is not used, programming on the PLC is not required for this signal.

[Related signal]

(1) Cutting block start interlock (*CSL: Y21C)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	CUTTING BLOCK START INTERLOCK	*CSL	—	Y21C	W9C	Y21C	Y5DC

[Function]

This signal prohibits start of an axis motion command block other than that for positioning in automatic operation (memory, MDI, tape).

[Operation]

While the "Cutting block start interlock" (*CSL) signal is OFF, execution of an axis motion command block other than that for positioning may not be started in automatic operation. When the signal is given during execution of a block, the execution of the block continues until it is completed. Since the signal does not cause stop or suspension of automatic operation, execution of program starts when the "Cutting block start interlock" (*CSL) signal is turned ON.

(Note 1) This signal is valid to all blocks including blocks internally generated by fixed cycle, etc.
(Note 2) The signal (*CSL) is ON when the power is turned ON. When the signal is not used, programming on the PLC is not required for this signal.

[Related signal]

(1) Block start interlock (*BSL: Y21B)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	DRY RUN	DRN	—	Y21D	W9D	Y21D	Y5DD

[Function]

Feedrate in automatic operation is specified by manually set value instead of program command value (F value).

[Operation]

(1) DRY RUN signal given during cutting feed
- When "Rapid traverse" (RT) signal is ON, the cutting feedrate is equal to the maximum cutting feedrate.
  In this case, "cutting feedrate override" and "rapid traverse override" are ignored.
- When "Rapid traverse" (RT) signal is OFF, the set manual feedrate (*JV1 to 16) will apply. Cutting feed override will also be valid if the "Manual override valid" (OVSL) signal is ON.

(2) Dry run signal given during rapid traverse
The parameter must be turned ON to validate dry run for rapid traverse (G0, G27, G28, G29, G30).
- When "Rapid traverse" (RT) signal is ON, the "Dry run" signal is ignored.
- When "Rapid traverse" (RT) signal is OFF, the speed is equal to manually set speed.

(Note 1) Dry run is not applicable to manual operation.
(Note 2) Dry run is valid even during G84 or G74 operation.

[Related signals]

(1) Manual feedrate (*JV1 to 16: Y2B0)
(2) Rapid traverse (RT: Y22E)
(3) Manual feedrate override valid (OVSL: Y299)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ERROR DETECT	ERD	—	Y21F	W9F	Y21F	Y5DF

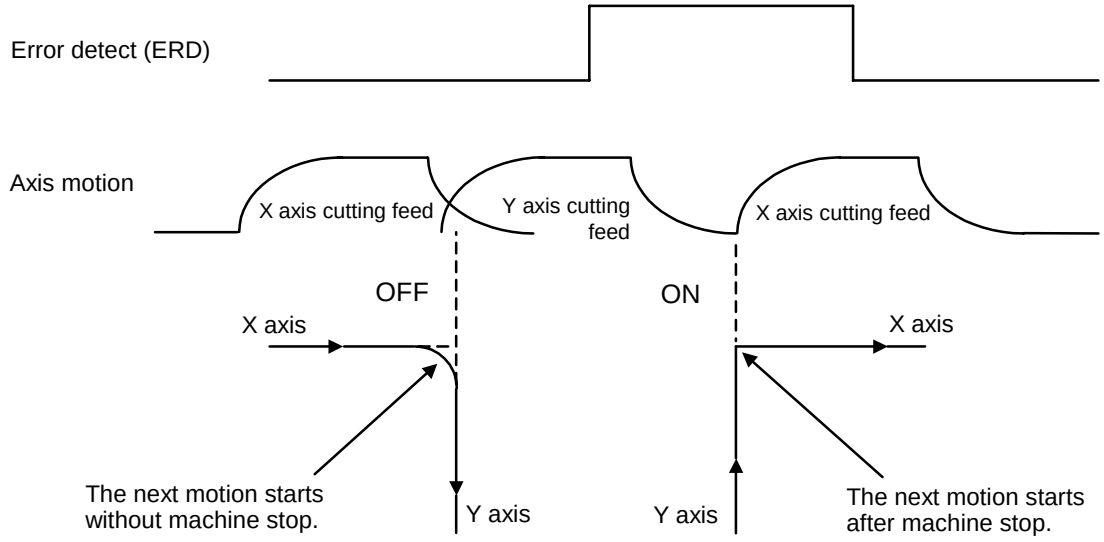
[Function]

Machine motion is stopped momentarily in transition from a cutting feed block to other block during automatic operation to provide time for determination whether in-position check is made or not before start of the next block.

Block-to-block transition may cause rounding in cutting because of delay caused by acceleration or deceleration, and servo response delay. Rounding can be eliminated by stopping the machine motion between the blocks by turning the "Error detect" signal (ERD) ON.

[Operation]

When this "Error detect" signal (ERD) is ON in block-to-block transition during cutting in automatic operation, in-position check is accomplished. If the signal is OFF, the next block starts after completion of the preceding block without stop.



(Note 1) In general practice, the signal (ERD) is turned ON and OFF using an appropriate miscellaneous function (M code, etc.) so that command program can determine whether machine motion should be stopped or not. When the signal is ON, the status is same as the case where G09 is specified by the command program. Consequently, it is recommended to use G function unless otherwise required especially.

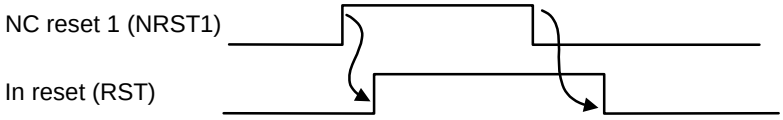
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	NC RESET 1	NRST1	P C	Y220	WA0	Y220	Y5E0

[Function]

This signal is used to reset the control unit.

[Operation]

When this signal (NRST1) is turned ON, the control unit can be reset.
Generally, the signal for the reset button of the NC operation board is set to "NC reset 1" (NRST1). At this time, the control unit will take the following actions.
(1) The G command modal will be held.
(2) The tool compensation data will be held.
(3) The memory will be indexed.
(4) The error/alarm will be reset.
(5) The MST code output will be held.
(6) The M code independent output (M00, M01, M02, M30) will turn OFF.
(7) The axis movement will stop.
(8) The "In reset" signal (RST) will be output.



[Related signals]

NC reset 2 (NRST2:Y221)
Reset & rewind (RRW:Y222)
In “reset” (RST:X1F5)

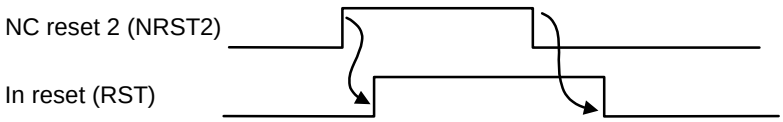
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	NC RESET 2	NRST2	P C	Y221	WA1	Y221	Y5E1

[Function]

This signal is used to reset the control unit.

[Operation]

When this signal (NRST2) is turned ON, the control unit can be reset.
Generally, this is turned ON when the miscellaneous function M02 or M30 is executed. In some cases, the "Reset & Rewind" (RRW) explained later is used.
At this time, the control unit will take the following actions.
(1) The G command modal will be initialized.
(2) The tool compensation data will be canceled. (Will not be applied.)
(3) The memory will not be indexed.
(4) The error/alarm will be reset.
(5) The MST code output will be held.
(6) The M code independent output (M00, M01, M02, M30) will turn OFF.
(7) The axis movement will stop.
(8) The "In reset" signal (RST) will be output.



[Related signals]

NC reset 1 (NRST1:Y220)
Reset & rewind (RRW:Y222)
In “reset” (RST:X1F5)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	RESET & REWIND	RRW	—	Y222	WA2	Y222	Y5E2

[Function]

This signal resets the controller.
During memory operation, the head of the machining program currently being run can be called out.
The reset key (X108) in the communication terminal is also set to Y222 by the sequence program.

[Operation]

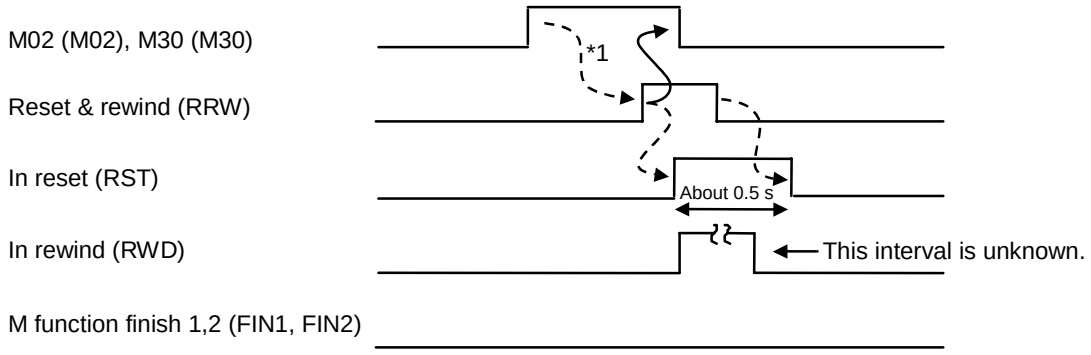
When this signal (RRW) turns ON:

(1) Ongoing axis motion is decelerated and stopped.
(2) CNC is reset after axis motion stops. In about 0.5 second after CNC is reset, "In reset" signal (status signal RST) turns ON.
(3) At the same time as CNC is reset, "In rewind" (RWD) signal turns ON.
  • In memory operation mode, the head of program in execution is read (memory index).
(4) While the signal (RRW) is ON, automatic operation and manual operation are impossible.
(5) G command modal is initialized.
(6) Tool compensation (offset) data are canceled (no motion).
(7) Error/alarm is reset.
(8) M, S, T code outputs are held. (Strobe signal turns OFF.)
(9) M code independent output (M00, M01, M02 and M30) is turned OFF.

<Operation example>

The process when M02 or M30 are commanded in the program is shown below.

Generally, when M02 (or M30) is executed by the program, this signal (RRW) will be returned when the designated operation is completed. M function finish 1 (FIN1) and M function finish 2 (FIN2) will not be returned.
(Refer to *1 in the following drawing.)



[Related signals]

In reset (RST: X1F5)
In rewind (RWD: X1F7)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	CHAMFERING	*CDZ	P C	Y223	WA3	Y223	Y5E3

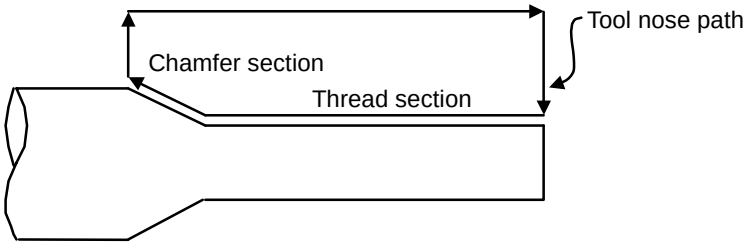
[Function]

In thread cutting cycle, chamfering can be ignored.

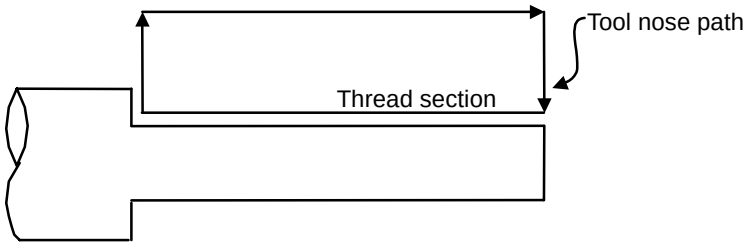
[Operation]

Status of this signal is determined at start of thread cutting cycle.

• CHAMFERING (*CDZ) is OFF.
Chamfering (at end of thread cutting) is accomplished.



• CHAMFERING (*CDZ) is ON.
Chamfering is not accomplished (signal is ignored).



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	AUTO RESTART	ARST	P C	Y224	WA4	Y224	Y5E4

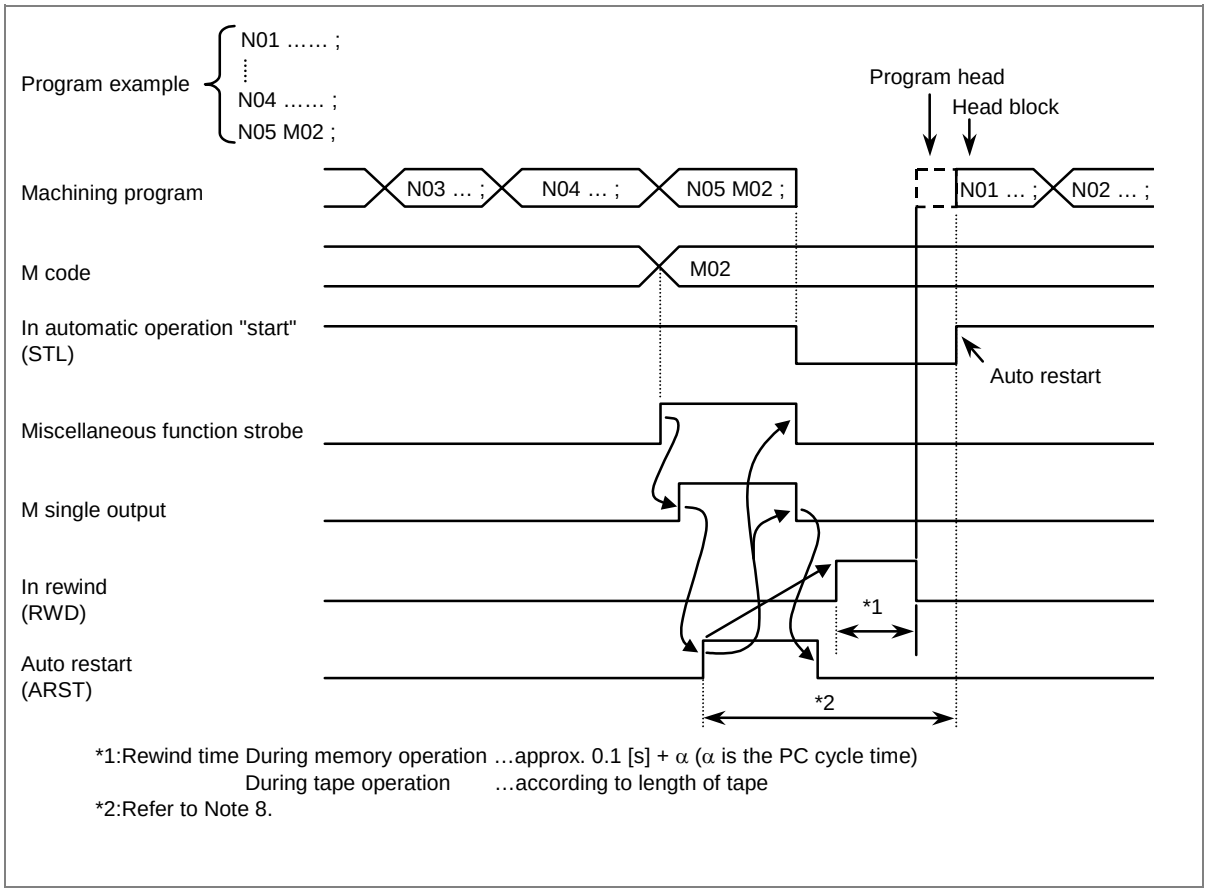
[Function]

If this signal is turned ON after the end of the machining program execution, the same machining program will be restarted.

[Operation]

The same machining program will restart if this signal is turned ON during automatic start.

[Time chart]



*1:Rewind time During memory operation …approx. 0.1 [s] + α (α is the PC cycle time)
During tape operation …according to length of tape
*2:Refer to Note 8.

(Note 1) The modal is initialized with this signal.
(Note 2) This signal is valid only during automatic start.
(Note 3) This signal is valid during the memory and MDI automatic operation modes.
(Note 4) Normally, "M code independent output" signal for M02 or M30 is input into this signal, but in this case, do not input the M02 or M30 completion signal (FIN1, FIN2).
(Note 5) If the "Auto operation "pause" command" (*SP) signal is valid, the "Auto restart" signal will be invalid.
(Note 6) This signal is invalid during single block stop.
(Note 7) Note that if an M command other than M02 or M30 is input into this signal, the program will return to the start point without completing the program, and the program will be restarted.
(Note 8) If "Reset & rewind" (RRW) are applied during the auto restart process (*2 section in time chart above), the modal will be initialized and the tape will be rewound, but the "Auto restart" signal will be invalid.

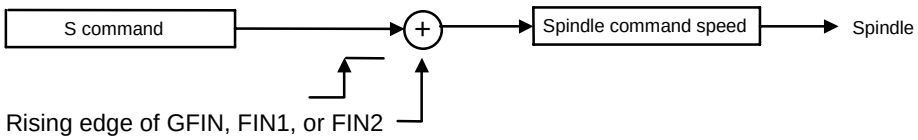
B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	GEAR SHIFT COMPLETE	GFIN	—	Y225	WA5	Y225	Y5E5

[Function]

This signal changes the spindle speed to the speed (S command) specified in the machining program. This signal is used to smoothly perform the spindle speed (S analog, etc.) control.

[Operation]

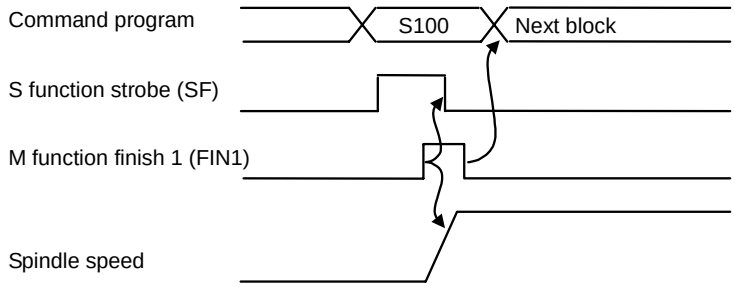
To change the spindle speed to the speed specified by the S command during automatic operation (memory, MDI, or tape), it is needed to turn ON the "Gear shift complete" (GFIN), or "M function finish 1 (FIN1, FIN2)" signal.



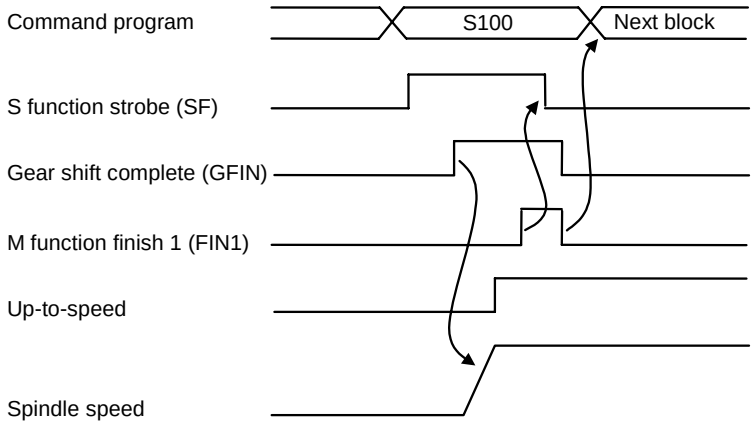
When using the "Gear shift complete" signal, the following two conditions should be considered:

- Whether gear shift (gear change) is applicable (whether there are two or more states of gear shift).
- Whether "Up-to-speed" signal output from the spindle controller is used for verification of spindle speed.

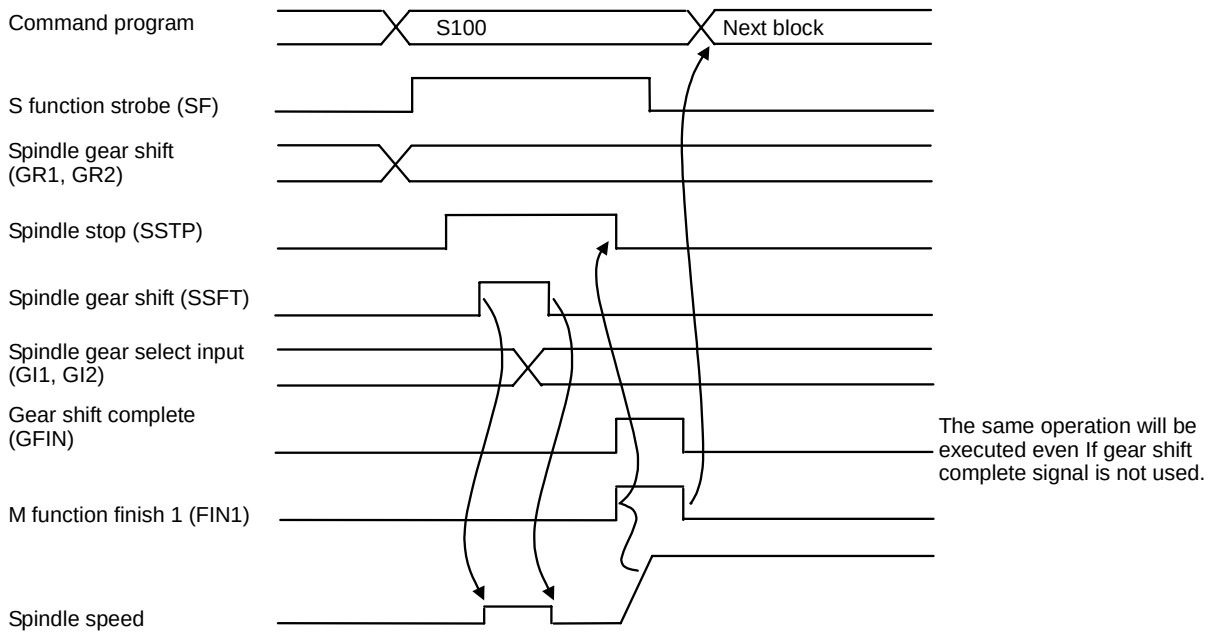
Operation example (1) There is no gear shift and the "Up-to-speed" signal is not used.



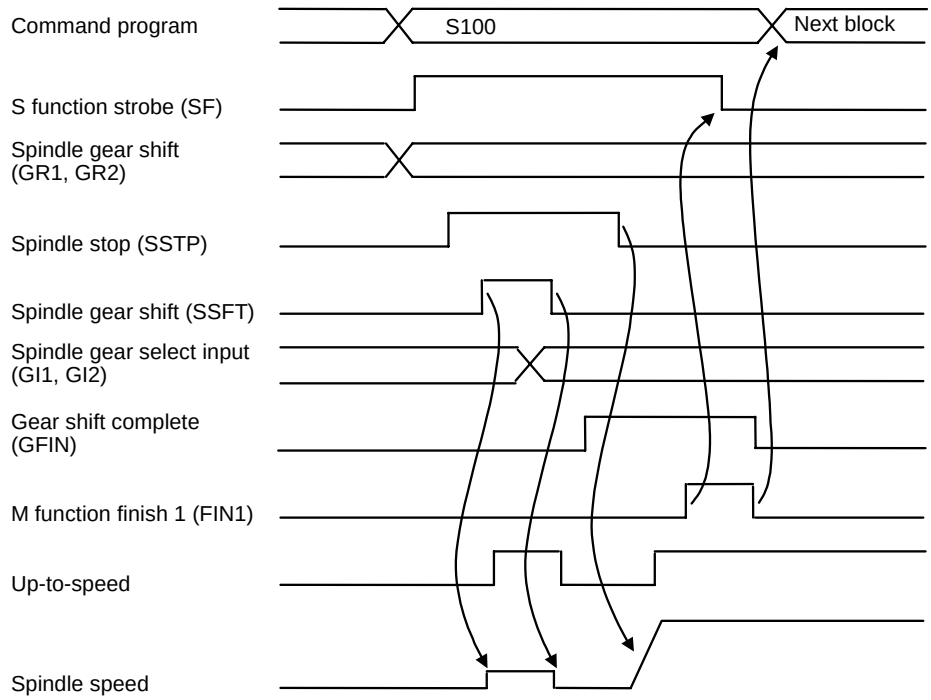
Operation example (2) There is no gear shift, but the "Up-to-speed" signal is used.



Operation example (3) There is gear shift, but the "Up-to-speed" signal is not used.



Operation example (4) There is gear shift and "Up-to-speed" signal are used.



[Related signals]

(1) S function strobe (SFn: X234)
(2) Spindle gear shift (GR1, GR2: X225, X226)
(3) M function finish (FIN1, FIN2: Y226, Y227)
(4) Spindle gear select (GI1, GI2: Y290, Y291)
(5) Spindle stop (SSTP: Y294), Spindle gear shift (SSFT: Y295)

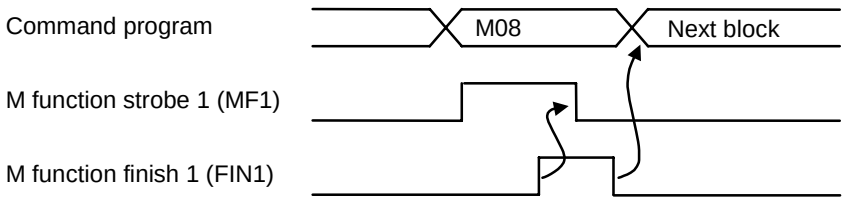
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	M FUNCTION FINISH 1	FIN1	—	Y226	WA6	Y226	Y5E6

[Function]

This status signal informs the controller that specified miscellaneous (M) function, spindle (S) function, tool (T) function or 2nd miscellaneous function (A, B or C) is accomplished on the PLC side.

[Operation]

If the M, S, T or 2nd M function command is executed during automatic operation, the code and each function strobe (MF1 to 4, SF1 to 4, TF1, BF1) will turn ON.
When the PLC verifies that one or more M, S, T and/or B function has been specified, it performs that function(s) and, after completion of the function(s), "M function finish 1" (FIN1) signal turns OFF.
When the controller verifies that signal FIN1 turns ON, it turns OFF strobe signal of corresponding function.
The PLC checks that each strobe signal turns OFF, then turns OFF FIN1. With the signal FIN1 turned OFF, the controller proceeds to the next block.
An example of timing chart, where M function is specified, is as follows:



There are two "M function finish" signals, namely, "M function finish 1" and "M function finish 2" (Refer to the next page). The only difference is if the next block is proceeded to at the falling edge or at the rising edge. These can be used separately per operation in one PLC.

(Note 1) "M function finish" (FIN1) signal is common to M, S, T and B functions.
(Note 2) The "M function finish 1" signal is also the signal for upgrading the spindle speed output (S analog data, etc.) during S function execution.
(Note 3) If signal FIN1 has been ON before M, S, T or B function is specified, data pertinent to M, S, T or B function are not output. To output, the signal FIN1 should be turned OFF once.
(Note 4) When "Reset & rewind" (RRW) signal is sent to the controller by M02 or M30, "M function finish 1 or 2" signal should not be sent back. If the "M function finish 1 (2)" signal is return with the M02 command at the end of the machining program, the NC alarm program error (P36) will occur.

[Related signals]

(1) M function finish 2 (FIN2: Y227)
(2) M function strobe 1 to 4 (MF1 to 4: X230)
(3) S function strobe 1 to 4 (SF1 to 4: X234)
(4) T function strobe 1 (TF1: X238)
(5) 2nd M function strobe 1 (BF1: X23C)
(6) M, S, T, B function data (output to file register R: R20 and later)
(7) Reset & rewind (RRW: Y222)

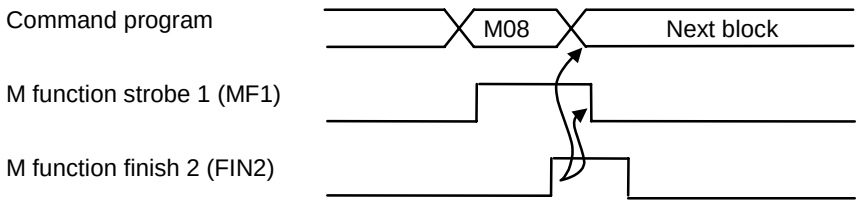
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	M FUNCTION FINISH 2	FIN2	—	Y227	WA7	Y227	Y5E7

[Function]

This status signal informs the controller that specified miscellaneous (M) function, spindle (S) function, tool (T) function or 2nd miscellaneous function (A, B or C) is accomplished on the PLC side. When too much signals FIN1 must be used, this signal can be used instead of signal FIN1 to save time.

[Operation]

If the M, S, T or 2nd M function command is executed during automatic operation, the code and each function strobe (MF1 to 4, SF1 to 4, TF1, BF1) will turn ON.
When the PLC verifies that one or more M, S, T and/or 2nd M function has been specified, it performs that function(s) and, after completion of the function(s), "M function finish 2" (FIN2) signal turns ON.
When the controller verifies that signal FIN2 turns ON, it turns OFF strobe signal of corresponding function.
When each strobe signal turns OFF, the PLC turns OFF signal FIN2. With the signal FIN2 turned OFF, the controller proceeds to the next block.
An example of timing chart, where M function is specified, is as follows:



There are two "M function finish" signals, namely, "M function finish 1" (refer to the previous page) and "M function finish 2". The only difference is if the next block is proceeded to at the falling edge or at the rising edge. These can be used separately per operation in one PLC.

(Note 1) "M function finish 2" (FIN2) signal is common to M, S, T and B functions.
(Note 2) The "M function finish 2" signal is also the signal for upgrading the spindle speed output (S analog data, etc.) during S function execution.
(Note 3) If signal FIN2 has been ON before M, S, T or B function is specified, data pertinent to M, S, T or B function are not output.
(Note 4) When "Reset & rewind" signal (RRW) is sent to the controller by M02 or M30, "M function finish 2 or 1" signal should not be sent back. If the "M function finish 2 (1)" signal is return with the M02 command at the end of the machining program, the NC alarm program error (P36) will occur.

[Related signals]

(1) M function finish 1 (FIN1: Y226)
(2) M function strobe 1 to 4 (MF1 to 4: X230)
(3) S function strobe 1 to 4 (SF1 to 4: X234)
(4) T function strobe 1 (TF1: X238)
(5) 2nd M function strobe 1 (BF1: X23C)
(6) M, S, T, B function data (output to file register R: R20 and later)
(7) Reset & rewind (RRW: Y222)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL LENGTH MEASUREMENT	TLM	P C	Y228	WA8	Y228	Y5E8

[Function]

"Tool length manual measurement 1" is selected by this signal.
For M system, "Tool length manual measurement 1 and 2" functions are used by this signal.

[Operation]

When the signal (TLM) is turned ON (1), amount of tool length to be corrected is calculated automatically in the controller.

[Caution]

(1) This signal is invalid if the tool length screen is not selected.
(2) The calculation result is read when INPUT key is pressed.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL LENGTH MEASUREMENT 2 (L system)	TLMS	P C	Y229	WA9	Y229	Y5E9

[Function]

"Tool length measurement 2" is selected by this signal.

[Operation]

When the signal (TLMS) is turned ON, tool length measurement mode is established. When skip signal is input during tool length measurement, amount of tool length to be corrected is calculated.

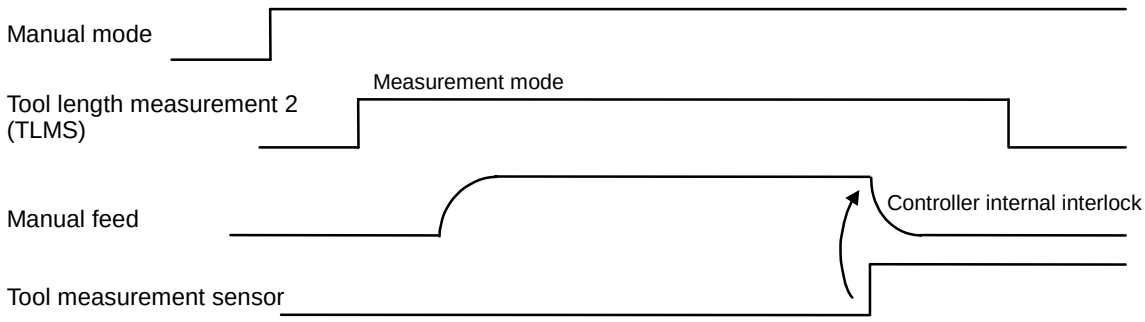
[Cautions]

(1) To use the tool length measurement 2 function, select manual operation mode.
Otherwise, tool length measurement mode cannot be established.
(2) "Tool length measurement 2" can be used with a machine equipped with tool measurement sensor.
The sensor for tool length measurement is connected to the connector "SENSOR" No. 2 pin ON the controller unit.
(3) The calculation result is read automatically inside the controller.

[Related signals]

R2970 ...Tool No. of tool to be measured is specified (T 4-digit BCD).

[Timing chart]



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SYNCHRONIZATION CORRECTION MODE		P C	Y22A	WAA	Y22A	Y5EA

[Function]

When the "M01 OPERATION ERROR 0051" (Synchronization error too large) occurs, the occurring error is corrected without changing the operation method with this mode.

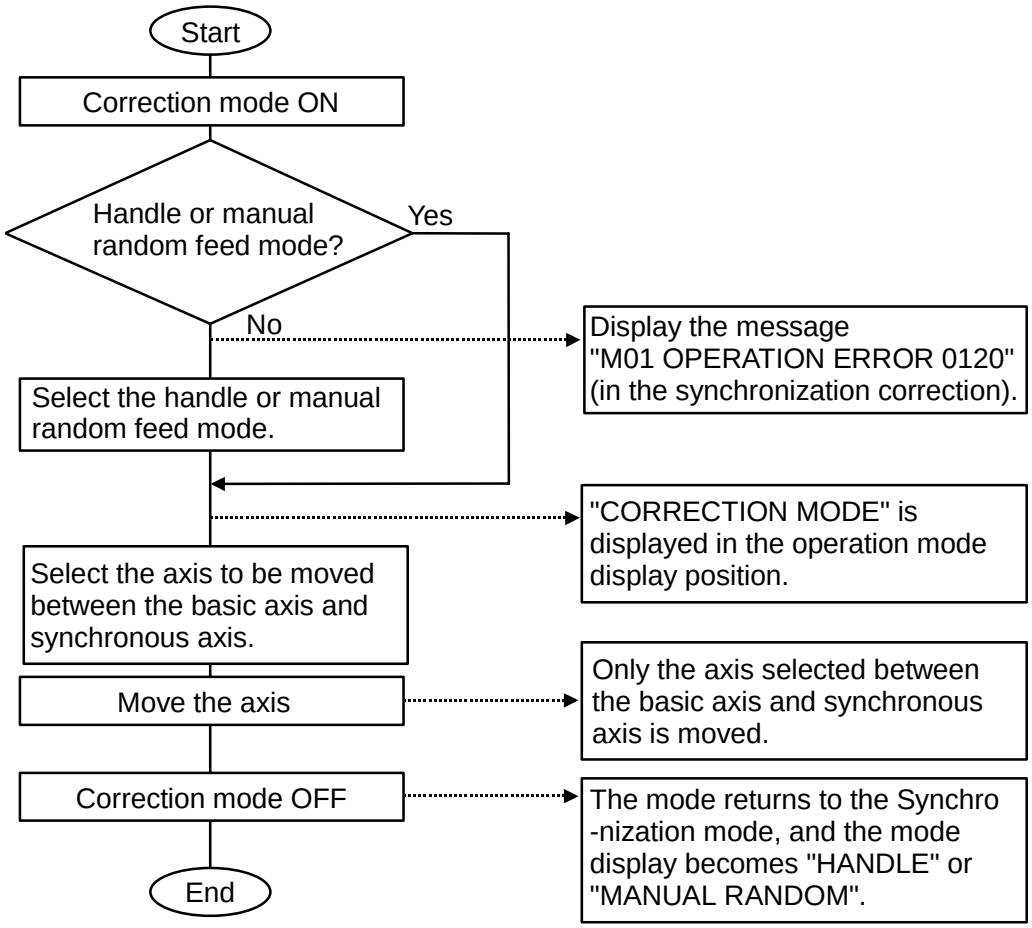
[Operation]

In the correction mode, the operation is as follows.

(1) The synchronous control is not carried out even in the synchronous axis, and the basic axis and synchronous axis are handled as independent two axes in the each control part. Thus, the basic axis and synchronous axis can be moved individually.
(2) If the zero point has established, the synchronization error check is carried out.
(3) If the correction mode switch is turned ON during selecting the mode except the handle or manual random feed mode, the "M01 OPERATION ERROR 0120" (Synchronization correction mode ON) will occur.

In the handle or manual random feed mode, if the correction mode switch (1st part system: Y22A, 2nd part system: WAA) is turned ON, the correction mode can be set and "CORRECTION MODE" will be displayed in the operation mode display position.

The operation procedure is shown below.



[Related signal]

Synchronous control operation method selection (R435)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	PROGRAM RESTART	PRST	P C	Y22B	WAB	Y22B	Y5EB

[Function]

With the program restart function, when the axis is returned to the restart position with the manual mode after the restart search is performed, the direction can be checked, or the axis can be stopped at the restart position.

[Operation]

If the "Program restart" signal (PRST) is turned ON after the restart search is performed and the axis is moved to the restart position direction with the manual mode, the axis is stopped at the restart position automatically. The [RESTART-R] values on the program restart screen are set to zero and "RP" appears by the side of the [RESTART-P] values. If the axis is moved in the opposite direction to the restart position, an OPERATION ERROR will occur.

[RESTART- (G54)]		[RESTART-R]	
X	-130.000 RP	X	0.000
Y	-10.000 RP	Y	0.000
Z	0.000 RP	Z	0.000

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	PLAYBACK	PB	—	Y22C	WAC	Y22C	Y5EC

[Function]

This signal is used to convert amount of axis motion into controller command data for generation of operation program.

[Operation]

When the "Playback" (PB) signal turns ON, the playback display mode appears on the communication terminal. By moving and stopping axis motion components (tool or table) with JOG feed, rapid traverse or handle feed, the displayed coordinate value is read and converted into NC data in accordance with the operation program format. By repeating data read, an operation program can be created.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MACRO INTERRUPT	UIT	—	Y22D	WAD	Y22D	Y5ED

[Function]

When the controller is ready for user macro interrupt, the program being in execution can be interrupted, or other program can be executed after the former program has been executed, by turning ON "Macro interrupt" (UIT) signal.

[Operation]

When "Macro interrupt" (UIT) signal turns ON within time interval starting with M96 command(Note 1) and ending with M97 command or reset, the program being in execution can be interrupted for execution of other program.

"Macro interrupt" (UIT) signal becomes valid when:

(1) Memory, tape or MDI is selected.
(2) Automatic operation is selected (signal STL is ON).
(3) Other user macro is not being executed.

"Macro interrupt" (UIT) signal is accepted in "status trigger" method or "edge trigger" method, either one of which can be selected by parameter #1112.

(1) Status trigger method
While "Macro interrupt" (UIT) signal is ON, the signal can be accepted.
When M96 is used to make acceptable user macro interrupt, the inserted program is executed when the signal (UIT) turns ON.
With the signal (UIT) kept turned ON, inserted program can be executed repeatedly.

(2) Edge trigger method
The signal (UIT) is accepted when its status changes from "OFF" to "ON" (i.e., with rise edge of signal).
This method is advantageous when inserted program is executed only once.

<Command format>

M96 P_ H_ ; . . . . . User macro interrupt valid
H_ : Interrupt sequence No.
P_ : Interrupt program No.

M97 : . . . . . User macro interrupt invalid

Refer to the relevant "Programming Manual" for details on the user macro interrupt function such as interrupt method and call method for when the "Macro interrupt" (UIT) signal is ON.

(Note 1) M96 and M97 can be changed to other M code by using a parameter.
(Note 2) User macro interrupt control M code is processed internally and not output to an external source (PLC).

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	RAPID TRAVERSE	RT	—	Y22E	WAE	Y22E	Y5EE

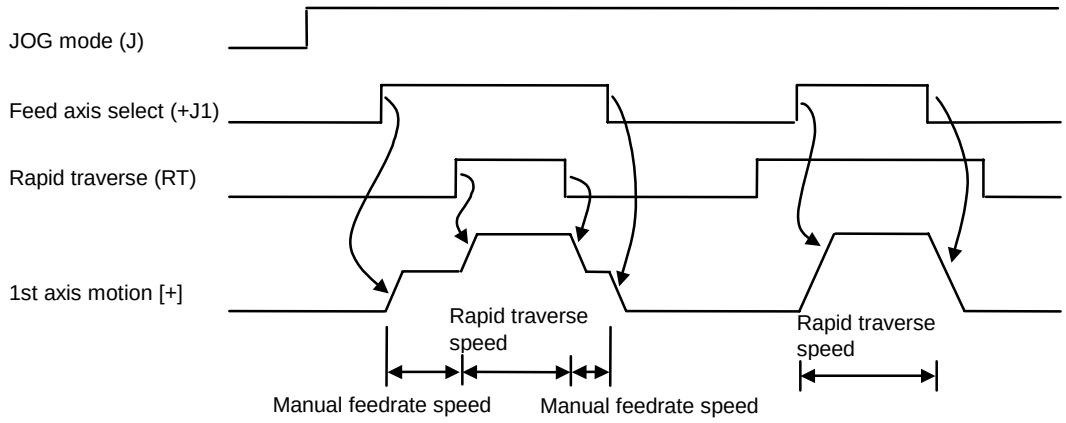
[Function]

Speed or feedrate of axis motion in "JOG" mode, "incremental feed" mode or "reference position return" mode can be changed to rapid traverse speed.

[Operation]

When the signal (RT) is turned ON.

(1) The jog and incremental feedrate will be the rapid traverse feedrate set with parameters.
(2) The speed until the near-point detection dog signal is detected during dog-type reference position return will be the reference position return rapid traverse feedrate set with parameters.
(3) Speed or feedrate is changed at the same time as the signal is turned ON.
When the signal (RT) is turned OFF, rapid traverse speed changes to the previous speed or feedrate. "Feed axis select" signal (±J1 to 8) may be kept turned ON.
(4) The speed will be the rapid traverse feedrate until the near point dog signal is detected during jog, incremental feed or reference position return. The rapid traverse override will also be valid.
(5) The "Rapid traverse override" (ROV1, ROV2) will be validated when the "Rapid traverse" signal is ON.



(Note 1) "Rapid traverse" (RT) signal does not act as mode signal, but serves as interrupt signal for "JOG" mode, "INCREMENTAL FEED" mode, etc.
(Note 2) This signal can be used likewise during machine lock.
(Note 3) For handling of "Rapid traverse" (RT) signal during dry run, refer to the description about dry run signal (DRN).

[Related signals]

(1) Rapid traverse override (ROV1, ROV2: Y2A8, Y2A9)

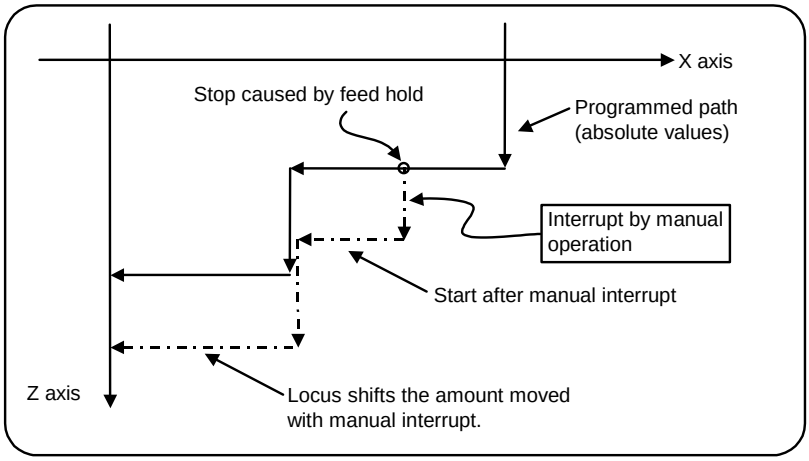
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL ABSOLUTE	ABS	—	Y230	WB0	Y230	Y5F0

[Function]

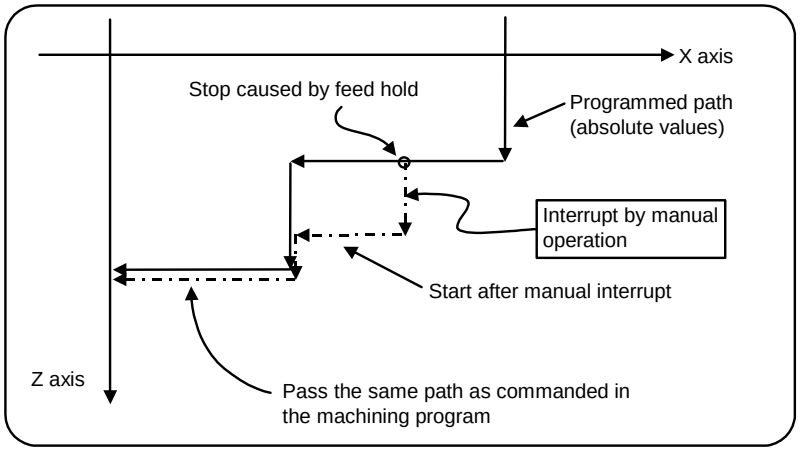
This signal selects whether to update the program coordinate system the amount moved with manual operation (jog, handle, etc.).

[Operation]

(1) When "Manual absolute" signal (ABS) is OFF:
The amount moved with manual operation is not added to the absolute position register in the controller. Thus, if manual is used during automatic operation, the axis will move in parallel the amount moved manually at the end point of the block and the end point of the following blocks. (The axis will move in parallel regardless of the absolute value/incremental value command in the machining program.)



(2) When "Manual absolute" signal (ABS) is ON:
The amount moved by manual operation is added to the absolute position register in the controller, and the coordinate system is not changed. Thus, if manual operation is used during automatic operation by absolute value command, the axis will return to the position commanded at the end of the inserted block and following blocks. However, if the manual interrupt is an incremental value command, the axis will move in parallel the amount moved manually. (The axis will move in parallel regardless of the absolute value/incremental value command at the end of the inserted block.)



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	DISPLAY LOCK	DLK	P C	Y231	WB1	Y231	Y5F1

[Function]

By using this signal, the current position displayed on the display unit is not updated even if the machine is moved with automatic operation or manual operation.

[Operation]

When the display lock signal (DLK) is ON, the machine movement and program coordinate system are updated in the normal state, but the current position displayed on the display unit is locked.

(Note 1) This signal (DLK) is valid at all times, and can be turned ON and OFF immediately.

(Note 2) This signal is valid during machine lock operation.

[Related signals]

In display lock (DLKN: X209)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	F1-DIGIT SPEED CHANGE VALID	F1D	P C	Y232	WB2	Y232	Y5F2

[Function]

When this signal is ON and F1-digit feed is commanded, the feedrate registered in the parameters can be increased or decreased by turning the manual handle.

[Operation]

When the program feedrate is commanded with an F1-digit, the feedrate can be increased or decreased by turning the manual handle.

(Note 1) The feedrate cannot be increased/decreased with the manual handle with the M64 and M64A models.

(1) Speed fluctuation amount using manual handle

The speed fluctuation amount ΔF is expressed with the following expression.

$$\Delta F = \Delta P \times \frac{FM}{K}$$

ΔP : Handle pulse ($\pm$)
FM : Upper limit value for F1-F5 (parameter setting value #1506)
K : Speed fluctuation constant (parameter setting value #1507)

(Example) To increase/decrease by 10mm/min per handle feed scale

When Fmax 3600mm/min is set,

$$\Delta F = 10 = 1 \times \frac{3600}{K}$$ K =360 based on the following expression

(2) Validity conditions

(a) Automatic operation must be active.
(b) Automatic operation must be started.
(c) The operation must be in cutting feed, and the F1-digit feedrate must be designated.
(d) The F1-digit valid parameter must be ON.
(e) The F1-digit speed change valid signal must be ON.
(f) Dry run must not be active.

[Related signals]

F1-digit commanded (F1DN: X20A)
F1-digit No. (F11 to F14: X218 to X21A)

B contact	Signal name	Signal abbreviation	PC	1st system	2nd system	1st system	2nd system
—	RECALCULATION REQUEST	CRQ		Y233	WB3	Y233	Y5F3

[Function]

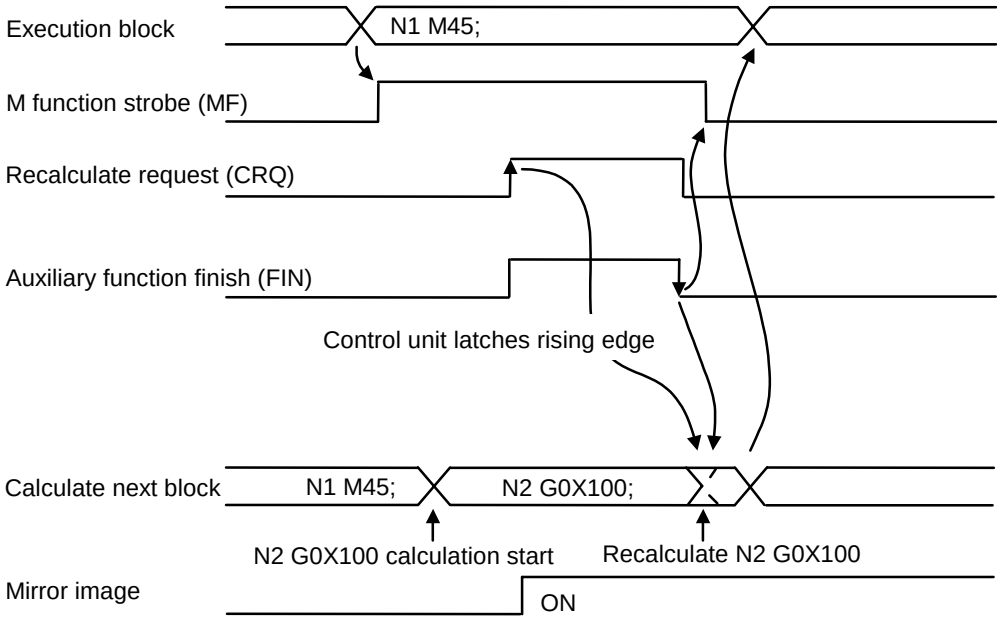
This signal is turned ON if a calculated block (next block) is recalculated during operation of the machining program.

[Operation]

For example, to operate mirror image, etc., with the miscellaneous (M) command in the program.

```
      ≀
N1  M45;          To apply mirror image with this M command
N2  G0X100;
      ≀
```

When the N1 block is reached in the above program example, the "Recalculate request" signal will turn ON before FIN is output or simultaneously with FIN.
This will validate the mirror image from the N2 block.



[Caution]

The "Recalculation request" (CRQ) signal latches the rising edge in the controller. Thus, even if the "Recalculation request" (CRQ) signal is ON (1), the "recalculation" will not take place unless at the rising edge.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	INTEGRATION TIME INPUT 1	RHD1	P C	Y234	—	Y234	—

[Function]

The total duration of a signal specified by a user PLC can be counted and displayed. For this, integration time input 1 and 2 are available.

[Operation]

The INTEGRAL TIME during this signal (RHD1) has been ON is displayed in hours, minutes, and seconds.

The counted (integrated) time is held even when the power is turned OFF. The integration time can be preset or reset.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	INTEGRATION TIME INPUT 2	RHD2	P C	Y235	—	Y235	—

[Function] [Operation]

Both functions and operations are the same as those of "Integration time input 1 (RHD1)". See the descriptions on "Integration time input 1 (RHD1)".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	PLC INTERRUPT	PIT	P C	Y236	W6B	Y236	Y5F6

[Function]

Interruption is executed with the interrupt program set with the R register when a signal is issued from the PLC during single block stop in program operation, or during the manual mode.

[Operation]

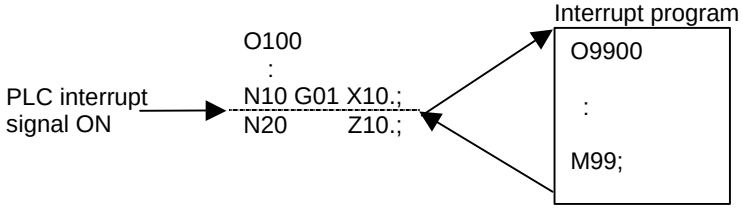
At the rising edge of this signal, the interrupt program (determined by the interrupt program No. input simultaneously with this signal) is executed during single block stop in program operation, or during the manual mode.

The interrupt program is ended with M99.

When the interrupt program ends, the operation mode returns to the same mode as before interruption was executed. For the memory or MDI mode, when the operation automatically starts, the block following the one ended just before interruption is executed. Note that if MDI operation is interrupted, the MDI program following the interrupted block will be canceled.

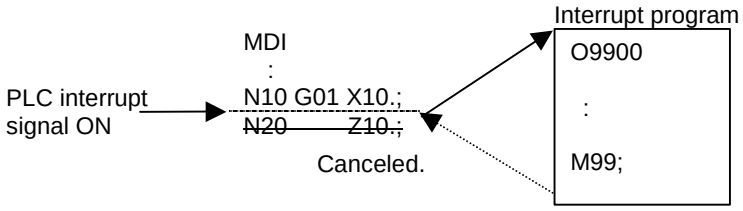
[Operation example]

Example 1: When program is interrupted during memory operation single block stop



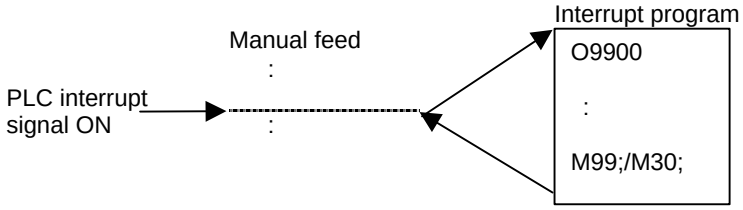
After the O100 N10 block ends, the designated interrupt program (O9900) is called when this signal turns ON. The PLC interrupt ends at the M99 block, and the block will stop. O100 N20 is executed from the next automatic start.

Example 2: When program is interrupted during MDI operation single block stop



After the MDI N10 block ends, the designated interrupt program (O9900) is called when this signal is turned ON. The PLC interrupt ends at the M99 block, and the block will stop. The next and subsequent blocks of the MDI program are canceled so operation cannot be continued.

Example 3: When program is interrupted during manual mode



During manual feed, the designated interrupt program (O9900) is called when this signal turns ON. The PLC interrupt ends at the M99 block, and the block will stop. The operation mode is returned to the manual mode by commanding reset.
If the PLC interrupt program is used in only in modes other than automatic operation, M30 can be commanded at the end of the program instead of M99 to command reset.

[Caution]

(1) Single block operation and automatic operation pause are valid even when the interrupt program is executed. To invalidate single block during the interrupt program execution, set system variable #3003. To invalidate automatic operation pause, set system variable #3004.
(2) Other PLC interrupt and MDI interrupt cannot be commanded during execution of the interrupt program.
(3) To disable the display of the interrupt program being executed on the Monitor screen, set the basic specification parameter "#1122 pglk-c" to 1 or 2.
(4) The PLC interrupt signal is ignored even if it is turned ON during automatic operation start or automatic operation pause.
(5) "In auto start" signal (OP) is output while the interrupt program is executed regardless of the operation mode which is active before the interruption.
(6) PLC interrupt is valid for each part system.
(7) If PLC interrupt is executed when there is no interrupt program or when program search has not been executed, a program error (P232) will occur when M99 is commanded.
(8) If the interrupt program No. set in the R register is not within the setting range, a program error (P232) will occur.
(9) This function is an option. If the option is not provided, the PLC interrupt signal will be ignored even if it is commanded.

[Related signals]

PLC interrupt program No. (R130)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	DATA PROTECT KEY 1	*KEY1	—	Y238	—	Y238	—

[Function]

Data pertinent to tool functions, and coordinate data (origin reset) can be protected with this signal.

[Operation]

When this signal is turned OFF (set to "0"), the tool data setting operation is prohibited.

[Caution]

(1) If a setting is changed while the signal (KEY1) is OFF, DATA PROTECT appears in the message section of screen.
Manual numerical command input is not applicable in "TOOL/OFFSET" display mode.
(2) The signal (KEY1) is ON (set to "1") when the power is turned ON (data are not protected). Therefore, if the signal is not turned OFF in sequential control program, it remains turned ON ("1").

[Related signals]

Data protect key 2 (*KEY2: Y239)
Data protect key 3 (*KEY3: Y23A)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	DATA PROTECT KEY 2	*KEY2	—	Y239	—	Y239	—

[Function]

Data pertinent to user parameters and common variables can be protected.

[Operation]

When this signal (KEY2) is turned OFF (0), the parameter and common variable setting operation is prohibited.

[Cautions]

(1) If a setting is changed while the signal (KEY2) is OFF (0), DATA PROTECT appears in the message section of CRT screen.
(2) The signal (KEY2) is ON (set to "1") when the power is turned ON (data are not protected). Therefore, if the signal is not turned OFF in sequential control program, it remains turned ON ("1").

[Related signals]

Data protect key 1 (*KEY1: Y238)
Data protect key 3 (*KEY3: Y23A)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	DATA PROTECT KEY 3	*KEY3	—	Y23A	—	Y23A	—

[Function]
Data pertinent to machining program can be protected.

[Operation]
When this signal (KEY3) is turned OFF (0), the editing of the machining program is prohibited.

[Cautions]
(1) If data is edited when the data protect key 3 is OFF (0), DATA PROTECT will appear in the message section.
(2) The signal (KEY3) is ON (set to "1") when the power is turned ON (data are not protected). Therefore, if the signal is not turned ON in sequential control program, it remains turned ON ("1").

[Related signals]
Data protect key 1 (*KEY1: Y238)
Data protect key 2 (*KEY2: Y239)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	PROGRAM DISPLAY DURING OPERATION	PDISP	PC	Y23C	—	Y23C	—

[Function]
This signal is used to display a program ON the Word Edit screen during operation.

[Operation]
When the program display during operation signal (PDISP) turns ON, the program being operated will appear in the program display of the EDIT screen.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	INCLINED AXIS CONTROL VALID		PC	Y23D	WBD	Y23D	Y5FD

[Function]
This signal validates the inclined axis control.

[Operation]
When this signal is turned ON, the inclined axis control is executed following the set parameter.
If this signal is turned OFF from ON, the inclined axis control will be invalid.

[Caution]
Even if this signal is changed over during the axis movement or the automatic operation, this signal will not be valid.
If this signal is changed over during the axis movement, this signal will be valid after the axis movement is stopped.
If this signal is changed over during the automatic operation, the block stop will occur.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	INCLINED AXIS CONTROL: NO Z AXIS COMPENSATION		P C	Y23E	WBE	Y23E	Y5FE

[Function]

Select whether the movement for the inclined axis in the manual operation is affected to the corresponding basic axis or not.

[Operation]

When this signal is turned ON and the manual operation for the inclined axis is executed, the corresponding basic axis is not moved.
When this signal is turned OFF and the manual operation for the inclined axis is executed, the compensation operation attending the movement of the inclined axis is executed to the corresponding basic axis.

[Caution]

Even if this signal is changed over during the axis movement, this signal will not be valid.
If this signal is changed over during the axis movement, this signal will be valid after the axis movement is stopped.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	OPTIONAL BLOCK SKIP	BDT1	—	Y23F	WBF	Y23F	Y5FF

[Function]

Block accompanying "/" (slash) can be skipped.
By creating a machining program with a "/" code inserted, a different part can be machined with one program.

[Operation]

(1) When a program having a block with "/" (slash code) placed at the head of block is executed with "Optional block skip" (BDT1) signal turned ON, the block is skipped. The block with the "/" code in the middle instead of at the head will be executed.
When the signal (BDT1) is OFF, block with "/" is executed.

```
N1G90G00Z3. M03S1000 ;
N2G00X50. ;
   G01Z-20. F100 ;
   G00Z3. ;
/N3G00X30. ;
/  G01Z-20. F100 ;
/  G00Z3. ;
N4G00X10. ;
   G01Z-20. F100 ;
   G00Z3. ;
N5G28X0Z0M05 ;
N6M02 ;
```

When the "Optional block skip" signal (BDT1) is ON, the block with "/" will not be executed.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	1ST HANDLE AXIS NO.	HS11 to 116	—	Y248 to C	WC8 to C	Y248 to C	Y608 to C

[Function]

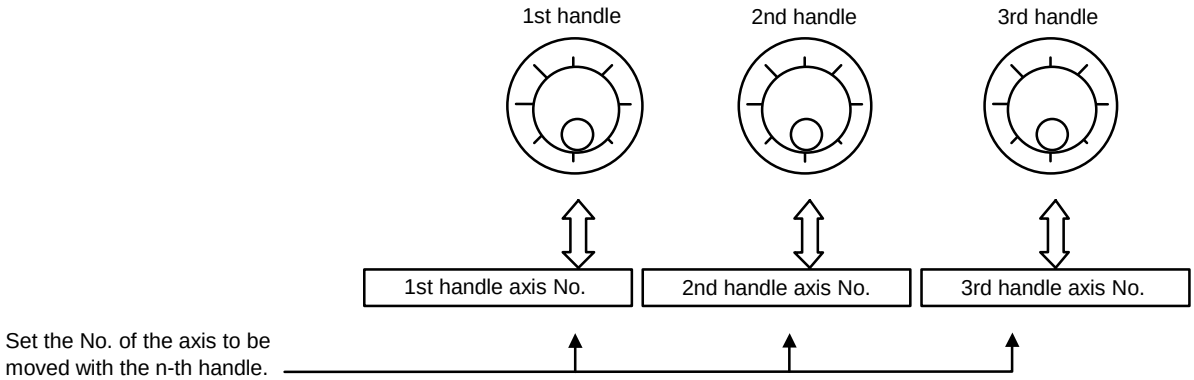
In HANDLE mode (handwheel is operated), axis component to be moved is selected.
In the case of 2-axis or 3-axis handle specification (two or three handles are required), axis is selected for the 1st handle.

[Operation]

For axis motion in HANDLE mode:
(1) Select HANDLE mode.
(2) Specify axis No. for 1st handle axis No.
(3) Turn ON "1st handle valid" (HS1S) signal (later described).
(4) Turn the handle (handwheel) ... motion will start.
The relationship between "handle axis No." and "motion axis" is as follows:

Handle axis No. / Motion axis	HS 1S	—	—	HS 116	HS 18	HS 14	HS 12	HS 11
X axis (1st axis) selected	1	—	—	0	0	0	0	1
Y axis (2nd axis) selected	1	—	—	0	0	0	1	0
Z axis (3rd axis) selected	1	—	—	0	0	0	1	1
#4 axis (4th axis) selected	1	—	—	0	0	1	0	0

"1st handle valid" signal



[Related signals]

(1) 2nd handle axis No. (HS21 to 216: Y250 to Y254), 2nd handle valid (HS2S: Y257)
(2) 3rd handle axis No. (HS31 to 316: Y258 to Y25C), 3rd handle valid (HS3S: Y25F)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	1ST HANDLE VALID	HS1S	P C	Y24F	WCF	Y24F	Y60F

[Function]

In HANDLE mode, axis No. of axis motion component to be moved is set for 1st handle axis No. (HS11~HS116). To make valid the specified handle axis No., this signal is used.

[Operation]

Axis motion does not start when the 1st handle (handwheel) is rotated after HANDLE mode is selected and the desired axis No. is set for the 1st handle axis No. if this signal (HS1S) is not given. Although either the "1st handle axis No." signal or the "1st handle valid" signal can be given first, these two signals are to be given when manual axis motion is started.

[Related signal]

(1) 1st handle axis No. (HS11 to 116: Y248 to Y24C)

B contact	Signal name	Signal abbreviation	PC	1st system	2nd system	1st system	2nd system
—	2ND HANDLE AXIS NO.	HS21 to 216		Y250 to 4	WD0 to 4	Y250 to 4	Y610 to 4

[Function]

This signal selects which handle to move with the 2nd handle when using the 2-axis or 3-axis handle specifications (two or three handles are required).

[Operation]

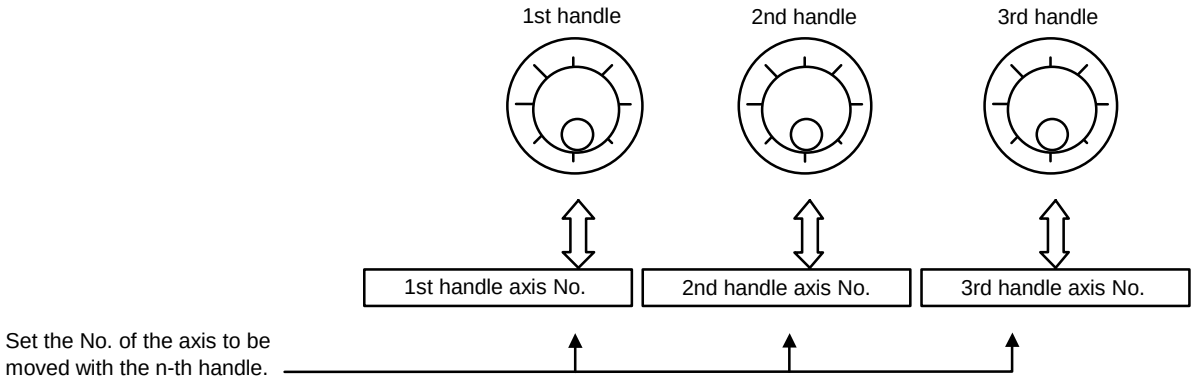
For axis motion controlled by the 2nd handle:

(1) Select HANDLE mode.
(2) Specify axis No. for 2nd handle axis No.
(3) Turn ON "2nd handle valid" signal (HS2S).
(4) Turn the handle (handwheel) ... motion will start.

The relationship between "handle axis No." and "motion axis" is as follows:

Handle axis No. / Motion axis	HS 2S	—	—	HS 216	HS 28	HS 24	HS 22	HS 21
X axis (1st axis) selected	1	—	—	0	0	0	0	1
Y axis (2nd axis) selected	1	—	—	0	0	0	1	0
Z axis (3rd axis) selected	1	—	—	0	0	0	1	1
#4 axis (4th axis) selected	1	—	—	0	0	1	0	0

"2nd handle valid" signal



[Related signals]

(1) 1st handle axis No. (HS11 to 116: Y248 to Y24C), 1st handle valid (HS1S: Y24F)
(2) 3rd handle axis No. (HS31 to 316: Y258 to Y25C), 3rd handle valid (HS3S: Y25F)

B contact	Signal name	Signal abbreviation	PC	1st system	2nd system	1st system	2nd system
—	2ND HANDLE VALID	HS2S		Y257	WD7	Y257	Y617

[Function] [Operation]

This signal is the same as "1st handle valid" signal in function and operation, except that it is applicable only to 2-axis handle specification (two handles are required).
Refer to the above table for the relation with the "2nd handle axis No." (HS21 to 216).

[Related signal]

(1) 2nd handle axis No. (HS21 to 216: Y250 to Y254)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	3RD HANDLE AXIS NO.	HS31 to 316	—	Y258 to C	WD8 to C	Y258 to C	Y618 to C

[Function]

This signal selects which handle to move with the 3rd handle when using the 3-axis handle specifications (three handle is required).

[Operation]

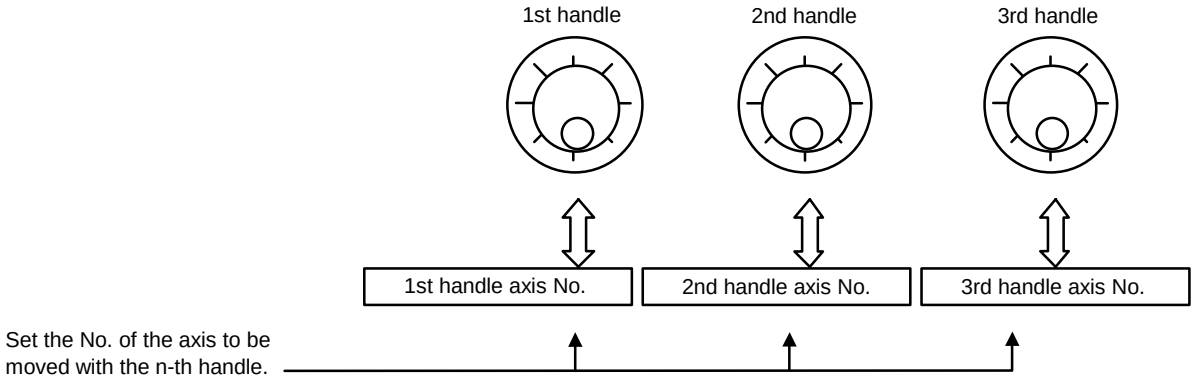
For axis motion in HANDLE mode:

(1) Select HANDLE mode.
(2) Specify axis No. for 3rd handle axis No.
(3) Turn ON "3rd handle valid" (HS3S) signal (later described).
(4) Turn the handle (handwheel) ... motion will start.

The relationship between "handle axis No." and "motion axis" is as follows:

Handle axis No. / Motion axis	HS 3S	—	—	HS 316	HS 38	HS 34	HS 32	HS 31
X axis (1st axis) selected	1	—	—	0	0	0	0	1
Y axis (2nd axis) selected	1	—	—	0	0	0	1	0
Z axis (3rd axis) selected	1	—	—	0	0	0	1	1
#4 axis (4th axis) selected	1	—	—	0	0	1	0	0

"3rd handle valid" signal



[Related signals]

(1) 1st handle axis No. (HS11 to 116: Y248 to Y24C), 1st handle valid (HS1S: Y24F)
(2) 2nd handle axis No. (HS21 to 216: Y250 to Y254), 2nd handle valid (HS2S: Y257)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	3RD HANDLE VALID	HS3S	PC	Y25F	WDF	Y25F	Y61F

[Function] [Operation]

This signal is the same as "1st handle valid" signal in function and operation, except that it is applicable only to 3-axis handle specification (three handles are required).
Refer to the above table for the relation with the "3rd handle axis No." (HS31 to 316).

[Related signal]

(1) 3rd handle axis No. (HS31 to 316: Y258 to Y25C)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL FEEDRATE B VALID nTH AXIS		P C	Y260 to Y267	WE0 to WE7	Y260 to Y267	Y620 to Y627

[Function]

This signal validates manual feed using the manual feedrate B.

[Operation]

If this signal is validated when carrying out manual feed in the jog mode, the axis will move at the speed commanded by manual feedrate B which is commanded separately from the manual feedrate.
This signal is independent for the axes.

<Using the manual feedrate B> (Example for 1st part system)

(1) To set the feedrate common for all axes as the manual feedrate B
  (a) Select the JOG mode signal (Y208).
  (b) Turn ON the "manual feedrate B valid nth axis" signal (Y260 to 7) for the axis to be moved at the manual feedrate B.
  (c) Command the feedrate set with the manual feedrate B in the "Manual feedrate B" registers (R138, R139).
  (d) Turn ON the "Feed axis select +" signal or "Feed axis select -" signal for the axis to be moved at the manual feedrate B.

(2) To set the feedrate independent for each axis as the manual feedrate B
  (a) Select the JOG mode signal (Y208).
  (b) Turn ON the "manual feedrate B valid nth axis" signal (Y260 to 7) for the axis to be moved at the manual feedrate B. Also turn ON the "Each axis manual feedrate B valid" signal (Y2BC).
  (c) Command the feedrate set for each axis manual feedrate B in the "each axis manual feedrate B speed nth axis" registers (R400 to R415).
  (d) Turn ON the "Feed axis select +" signal or "Feed axis select -" signal for the axis to be moved at the each axis manual feedrate B.

(Note 1) Manual feedrate B is valid only for JOG feed, and is invalid in all other manual modes.

(Note 2) The rapid traverse mode is invalid for the manual feedrate B valid axis.

(Note 3) Manual override is invalid for the manual feedrate B valid axis.

(Note 4) The axis moving at the manual feedrate B will decelerate and stop when NC reset is input. To move the axis at the manual feedrate B again, cancel the NC reset, and then turn the axis selection signal OFF and ON.

(Note 5) Even if the feed axis selection signal is turned ON when the command speed is "0", an error will occur and the manual feedrate B valid axis will not move.

(Note 6) The manual/automatic simultaneous signal must be valid to move a random axis at the manual feedrate B during automatic operation.

(Note 7) The JOG mode signal must be validated simultaneously to move a random axis at the manual feedrate B during a manual operation mode other than the JOG mode.

(Note 8) During synchronous control, the "manual feedrate B valid nth axis" signal is invalid for the syncronous axis. The manual feedrate B signal issued for the basic axis is also valid for the syncronous axis.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL RANDOM FEED 1ST AXIS NO.	CX11 to 116	P C	Y268 to C	WE8 to C	Y268 to C	Y628 to C

[Function]

This signal specifies a number of the axis component to move in manual random feed mode.
Components of up to three axes can be moved simultaneously in manual random feed mode.
This signal is used to specify one of them.

[Operation]

(1) The "Manual random feed 1st axis number" (CX11 to CX116) must be set before strobe signal CXS8 is turned ON. An attempt to set it during motion shall fail.
(2) Besides this signal (CX11 to CX116), there are two signals to specify a "Manual random feed 2nd axis number" (CX21 to CX216) and a "Manual random feed 3rd axis number" (CX31 to CX316). The axis numbers need not be specified in ascending order.
(3) The "Manual random feed 1st axis number" is validated by turning ON the "Manual random feed 1st axis valid" (CX1S) signal explained later. Similarly, the "specific validity" signals (CX2S and CX3S) are also provided for the 2nd and 3rd axis number signals.
(4) Axis numbers can be specified as follows:

n: 1 to 3

Signal / Axis specification	CXnS	—	—	CXn16	CXn8	CXn4	CXn2	CXn1
1st axis	1	—	—	0	0	0	0	1
2nd axis	1	—	—	0	0	0	1	0
3rd axis	1	—	—	0	0	0	1	1
4th axis	1	—	—	0	0	1	0	0

Validity signal — Axis number

(5) Motion of the specified axis component is as follows:
  (a) The motion of the axis component specified by the "Manual random feed 1st axis number" signal corresponds to the contents of "Manual random feed 1st axis movement data" (R142 and R143).
  (b) The motion of the axis component specified by the "Manual random feed 2nd axis number" signal corresponds to the contents of "Manual random feed 1st axis movement data" (R144 and R145).
  (c) The motion of the axis component specified by the "Manual random feed 3rd axis number" signal corresponds to the contents of "Manual random feed 1st axis movement data" (R146 and R147).

[Related signal]

For related signals, see the section "Manual random feed mode (PTP: Y20B)."

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL RANDOM FEED 1ST AXIS VALID	CX1S	PC	Y26F	WEF	Y26F	Y62F

[Function]

This signal is used to validate the axis specified by the "Manual random feed 1st axis number" signal so that the axis component can move in manual random feed mode.

[Operation]

(1) The specification of the axis by the "Manual random feed 1st axis number" signal explained earlier is validated only when the "CX1S" signal is turned ON.

[Related signal]

For related signal, see the section "Manual random feed mode (PTP: Y20B)."

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL RANDOM FEED 2ND AXIS NUMBER	CX21 to 216	PC	Y270 to 4	WF0 to 4	Y270 to 4	Y630 to 4

[Function] [Operation]

See the descriptions on the "Manual random feed 1st axis number" signal (CX11 to CX116: Y268 to Y26C) explained above.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL RANDOM FEED 2ND AXIS VALID	CX2S	PC	Y277	WF7	Y277	Y637

[Function] [Operation]

See the descriptions on the "Manual random feed 1st axis valid" signal (CX1S: Y26F).

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL RANDOM FEED 3RD AXIS NUMBER	CX31 to 316	PC	Y278 to C	WF8 to C	Y278 to C	Y638 to C

[Function] [Operation]

See the descriptions on the "Manual random feed 1st axis number" signal (CX11 to CX116: Y268 to Y26C) explained above.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL RANDOM FEED 3RD AXIS VALID	CX3S	PC	Y27F	WFF	Y27F	Y63F

[Function] [Operation]

See the descriptions on the "Manual random feed 1st axis valid" signal (CX1S: Y26F).

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SMOOTHING OFF	CXS1	P C	Y280	W100	Y280	Y640

[Function]

This signal is used to move an axis component under the condition where the acceleration/ deceleration time constant is 0 is manual random feed mode.

[Operation]

With the "Smoothing OFF" (CXS1) signal set ON, axis motion in manual random feed mode is performed under the same conditions as when the acceleration/deceleration time constant is set to 0.

(Note 1) When using this signal to move an axis component under the condition where the acceleration/deceleration time constant is 0, move it at a slow speed. Otherwise, a servo alarm (excess error) may occur.

[Related signal]

For related signal, see the section "Manual random feed mode" (PTP: Y20B) mode.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	AXIS INDEPENDENT	CXS2	P C	Y281	W101	Y281	Y641

[Function]

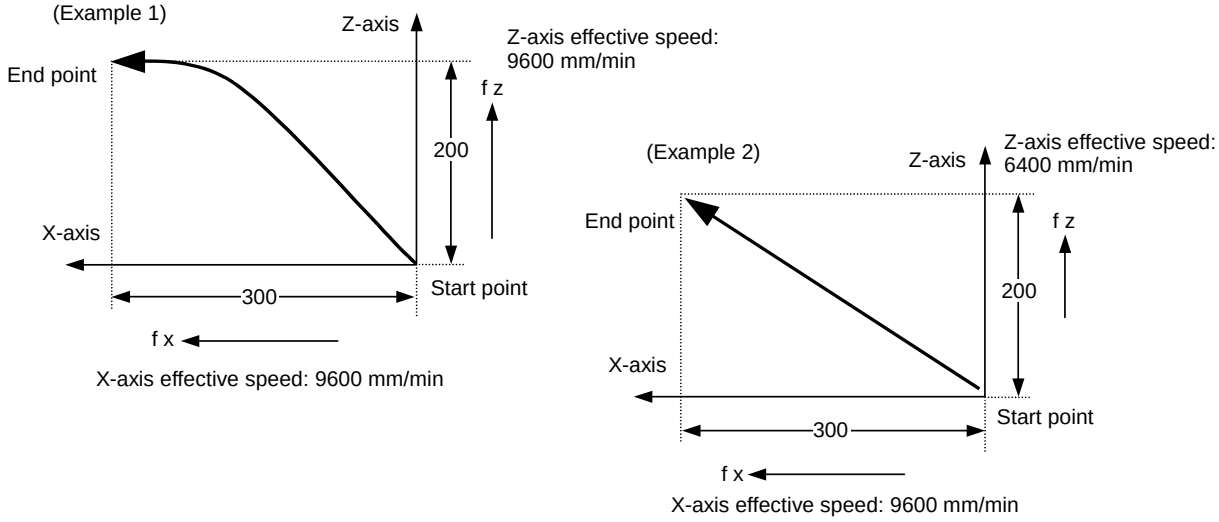
When moving two or more axis components simultaneously in "manual random feed" mode, this signal can be used to position each axis independently without performing interpolation.

[Operation]

When a manual random feed is executed for two or more axes at the same time with CXS2 ON, each axis is positioned independently without being subjected to interpolation.

The "CXS2" signal is generally used when the "G0/G1 select" signal (CXS4) explained later is OFF (G0 selected).

The following is an example where the rapid traverse speeds of X-axis and Z-axis are both set to 9,600 mm/min, and the amounts of movement of X-axis and Z-axis are set to 300mm and 200mm respectively.



[Related signal]

For related signal, see the section "Manual random feed mode (PTP: Y20B)."

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	EX. F/MODAL. F	CXS3	P C	Y282	W102	Y282	Y642

[Function]

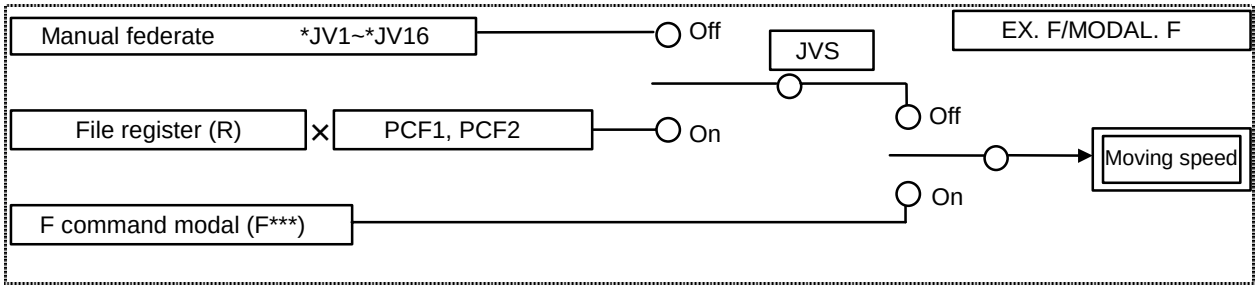
This signal selects whether a manual random feed in G1 mode is done at manual feed rate or at modal speed in automatic operation.

[Operation]

When the "G0/G1 select" (CXS4) signal explained later is ON n, the "CXS3" signal works as follows:

(1) When EX.F/MODAL.F (CXS3) is OFF:
   1) When the "Manual feedrate (JVS)" signal is OFF, the speed selected by the manual feed rate (*JV1 to 16) applies.
   2) When the "Manual feedrate (JVS)" signal is ON, the applicable speed is determined by the relation between the contents of the corresponding file register (R) and the "Feedrate least increment" signal (PCF1 or PCF2).

(2) When EX.F/MODAL.F (CXS3) is ON:
   Manual random feed is done at a modal speed (F***) set in automatic operation. However, manual random feed will not be done, if no F command has been executed before.



[Related signal]

For related signal, see the section "Manual random feed mode (PTP: Y20B)."

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	G0/G1	CXS4	P C	Y283	W103	Y283	Y643

[Function]

This signal selects a manual feed speed or rapid traverse speed in manual random feed mode.

[Operation]

This signal operates as shown below depending on the status of the "G0/G1 select" (CXS4) signal.

(1) When the "G0/G1 select" signal is OFF:
   The rapid traverse speed originally set to the corresponding axis applies. Rapid traverse override is also valid. The rapid traverse speed applicable when moving two or more axis components at the same time varies with the status of the "Axis independent (CXS2)" signal. See the descriptions on the "Axis independent (CXS2)" signal.

(2) When the "G0/G1 select" signal is ON:
   The manual feed speed or the speed specified by the F command in automatic operation apply. For details, see the description on the EX.F/MODAL.F (CXS3).

[Related signal]

For related signal, see the section "Manual random feed mode (PTP: Y20B)."

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MC/WK	CXS5	P C	Y284	W104	Y284	Y644

[Function]

This signal selects a machine coordinate system or a modal workpiece coordinate system on which positioning is done in manual random feed mode.

[Operation]

The "MC/WK (CXS5)" signal becomes valid when the "ABS/INC (CXS6)" signal explained later is OFF in manual random feed mode.

(1) When the "MC/WK" signal is OFF:
"Manual random feed nth axis movement data" set in a file register (R) is used for positioning on the machine coordinate system.

Amount of motion = Manual random feed nth movement data - Coordinate value on machine coordinate system

(2) When the "MC/WK" signal is ON:
"Manual random feed nth axis movement data" set in a file register (R) is used for positioning on the modal workpiece coordinate system.

Amount of motion = Manual random feed nth movement data - Coordinate value on modal workpiece coordinate system

[Related signal]

For related signal, see the section "Manual random feed mode (PTP: Y20B)."

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ABS/INC	CXS6	P C	Y285	W105	Y285	Y645

[Function]

This signal selects whether movement data is given in an absolute value or incremental value for manual random feed.

[Operation]

(1) When the "ABS/INC" (CXS6) signal is OFF:
"Manual random feed nth axis movement data" set in a file register (R) is handled as an absolute value. For details, see the descriptions on the "MC/WK (CXS5)" signal explained before.

(2) When the "ABS/INC" signal is ON:
"Manual random feed nth axis movement data" set in a file register (R) is handled as a real movement value.

[Related signal]

For related signal, see the section "Manual random feed mode (PTP: Y20B)."

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	STOP	*CXS7	PC	Y286	W106	Y286	Y646

[Function]

This signal stops an ongoing axis component halfway in manual random feed mode.
The function of this signal is equivalent to those of the "Manual interlock +nth axis (*+MITn) and -nth axis (*-MITn)" signals.

[Operation]

Turning the "Stop" signal (*CXS7) OFF (0) causes the following:

(1) Motion of axis in manual random feed mode is decelerated and stopped.
(2) The axis component which is going to move in manual random feed mode remains stopped.
When the "Stop" (*CXS7) signal is turned ON (1) while an axis component is in the stop state, it immediately restarts the operation.

(Note 1) When the power is turned ON, the "Stop" (*CXS7) signal is automatically set to "1". If the "Stop" signal is not to be used, there is no need to make a sequence program for it.

[Related signal]

For related signal, see the "Manual random feed mode (PTP: Y20B)."

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	STROBE	CXS8	P C	Y287	W107	Y287	Y647

[Function]

This signal is a trigger signal for moving an axis component in manual random feed mode. The axis component starts moving at the rising edge of this signal.

[Operation]

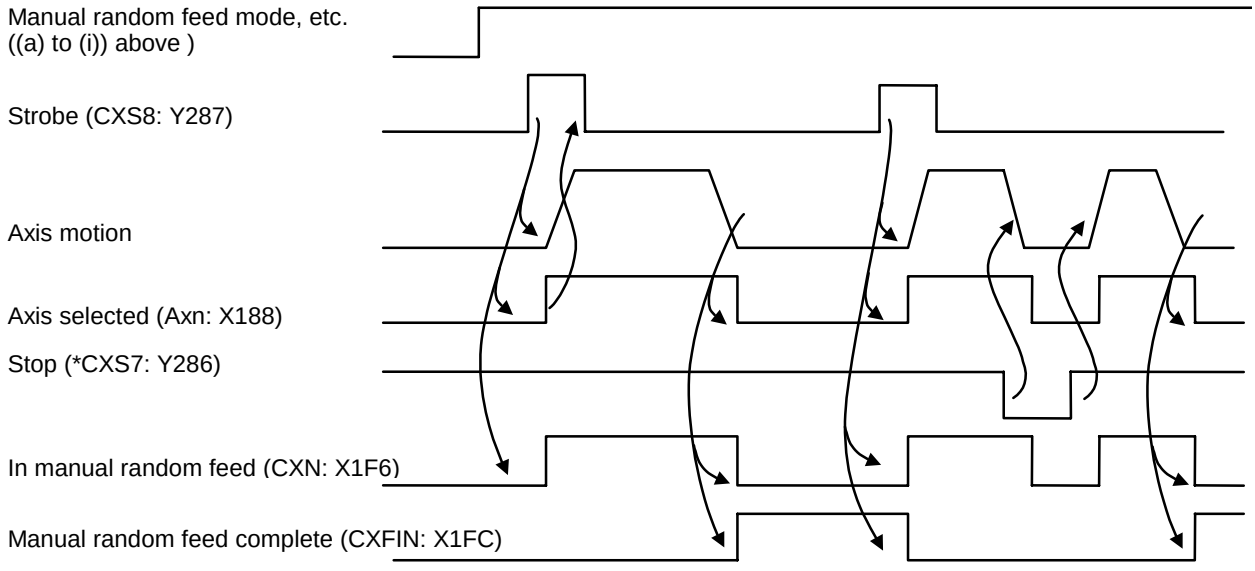
The "Strobe" signal (CXS8) should be turned ON after all signal values necessary for manual random feed are set appropriately.

(1) The following signals must be appropriately set before turning ON the "Strobe" signal:
- (a) Manual random feed mode (PTP)
- (b) Manual random feed nth axis number (CXn1 to CXn16) and manual random feed nth axis valid (CXnS)
- (c) Manual random feed nth axis movement data (file registers R142 to R147)
- (d) Smoothing OFF (CXS1)
- (e) Axis independent (CXS2)
- (f) EX.F/MODAL.F (CXS3)
- (g) G0/G1 (CXS4)
- (h) MC/WK (CXS5)
- (i) ABS/INC (CXS6)

(2) The following signals can be changed even after the "Strobe" signal is turned ON:
- (j) Manual feed speed
- (k) Rapid traverse override for a rapid traverse speed when the G0/G1 signal (CXS4) is OFF.
- (l) Stop (*CXS7)

(Note 1) The "Strobe" signal can be accepted even when the "Stop" signal (*CXS7) is OFF (0).

The following shows a timing chart of an example of operation.



(Note 2) The "Strobe" signal (CXS8) must be ON for at least 100ms.

[Related signals]

Signals listed in (a) to (l) above

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE SPEED OVERRIDE	SP1 to 4	—	Y288 to A	W108 to A	Y288 to A	Y648 to A

[Function]

This signal applies override (multiplication) on the S command issued in the automatic operation (memory, MDI, tape).

[Operation]

When "Override mode select" (SPS) signal is OFF, this signal is valid.
By selecting "Spindle speed override" (SP1 to 4) signal, override ratio can be selected within range from 50% to 120% (increment: 10%).
Override cannot be set when:

(1) "Spindle stop" signal is ON.
(2) TAP mode is selected.
(3) Thread cutting mode is selected.

This signal (SP1 to 4) is set with the code method. The relation is shown below.

SP4	SP2	SP1	Spindle override
1	1	1	50%
0	1	1	60%
0	1	0	70%
1	1	0	80%
1	0	0	90%
0	0	0	100%
0	0	1	110%
1	0	1	120%

[Related signal]

(1) Spindle override method select (SPS:Y28F)

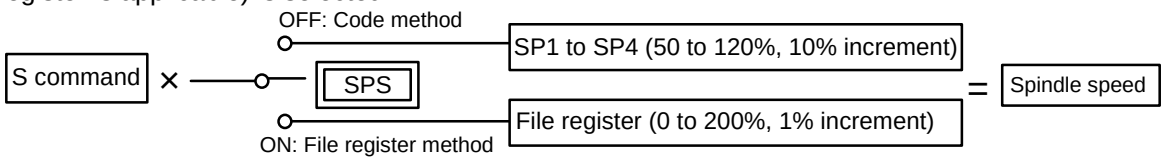
B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE OVERRIDE METHOD SELECT	SPS	PC	Y28F	W10F	Y28F	Y64F

[Function]

When override is applied on the S command issued in automatic operation (memory, MDI or tape), "code method" or "file register method" is selected for override method.

[Operation]

When the "Spindle override method select" (SPS) is OFF, code method override (signal SP1 to 4 is applicable) is selected.
When the "Spindle override method select" (SPS) is ON, register method override (value set in file register is applicable) is selected.



(Note 1) For details of "code method override" and "file register method override", refer to the respective description.

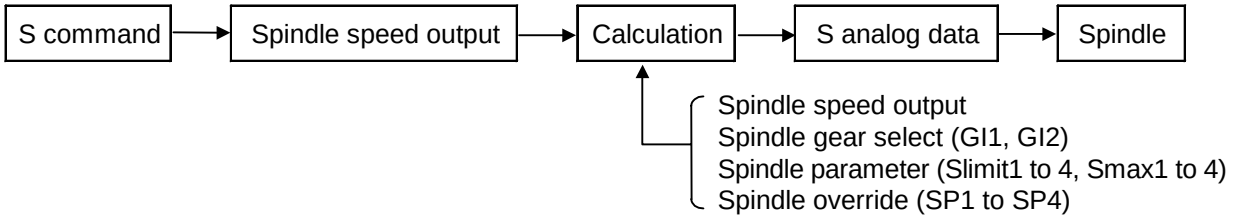
B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE GEAR SELECT 1, 2	GI1, 2	—	Y290, 1	W110, 1	Y290, 1	Y650, 1

[Function]

This signal informs the controller which spindle gear has been selected on the machine side.

[Operation]

This "Spindle gear select" signal (GI1, GI2) is set according to the machine's spindle gear stage. The controller calculates the S analog data (data is transferred when the spindle controller is the high-speed serial connection specification) based on this "Spindle gear selection" (GI1, GI2).
The flow after the S command is executed and output to the spindle is shown below.



The relation of the gear stage, spindle gear select input signal and spindle limit speed is as shown below.

Gear stage	Spindle gear select signal		Spindle speed limit
	GI2	GI1	
1	0	0	Slimt1
2	0	1	Slimt2
3	1	0	Slimt3
4	1	1	Slimt4

(1) Slimt1 to 4 are set with parameters. The spindle speed for when the S analog data is the max. (the motor is run at the max. speed) is set.
This setting is used for each gear unit, and is determined by the deceleration ratio (gear ratio) of the motor and spindle.
For example, if the max. motor speed is 6000 r/min, and the 1st gear stage is decelerated to half, "3000" will be set in parameter Slimit1.

(2) The controller calculates the spindle speed output data as shown below.
For example, if S command is issued, gear selection input is the 2nd stage (GI1=ON, GI2=OFF), spindle override value (%) is SOVR, and S analog data's max. value is "10":

$$\text{S analog data} = \frac{\text{S command}}{\text{Slimt2}} \times \frac{\text{SOVR}}{100} \times 10$$

(3) If S1300 is executed when using S analog output (max. 10V), Slimt2 = "2000", and spindle override "100%":

$$\text{S analog output} = \frac{1300}{2000} \times \frac{100}{100} \times 10\ (\text{V}) = 6.5\ (\text{V})$$

(4) The S command is clamped with the Smaxn (n=1 to 4).
If Smax2="1000" in the above state, the S analog output will be:

$$\text{S analog output} = \frac{1000}{2000} \times \frac{100}{100} \times 10\ (\text{V}) = 5.0\ (\text{V})$$

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE STOP	SSTP	—	Y294	W114	Y294	Y654

[Function]

In spindle control, S analog data (spindle speed) can be set to "0" by using this signal (SSTP). Usually, the signal is not used alone, but combined with "Spindle gear shift" signal (SSFT) explained later.

[Operation]

When the signal (SSTP) is turned ON, S analog data is set to "0". Analog data is restored when the signal is turned OFF.

When "Spindle gear shift" (SSFT) signal turns ON while the signal is ON, S analog data which corresponds to speed set by the spindle speed parameter is output.

"Spindle speed override" (SP1 to 4) is ignored while the signal is ON.

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE GEAR SHIFT	SSFT	—	Y295	W115	Y295	Y655

[Function]

This signal is used to run the spindle motor at low speed, when spindle gear is shifted, so that spindle gear can be engaged smoothly.

[Operation]

When the signal (SSFT) turns ON, the S analog data equivalent to the low speed previously set by parameter is output.

If gears are not engaged properly, the signal is turned ON. It should be noted that "Spindle stop" (SSTP) signal should be ON beforehand to use the signal (SSFT).

Spindle gear shift speed is selected by "Spindle gear select" input (GI1, GI2).

The relation is as follows:

Gear stage	Spindle gear select signal		Spindle speed at gear shift	Spindle speed limit
	GI2	GI1		
1	0	0	Ssift1	Slimt1
2	0	1	Ssift2	Slimt2
3	1	0	Ssift3	Slimt3
4	1	1	Ssift4	Slimt4

S analog data (spindle speed data) while "Spindle gear shift" (SSFT) signal is ON can be determined from the formula shown below.

For example, if the gear selection is the 1st stage (GI1= OFF, GI2= OFF), and the S analog data max. value is "10":

$$\text{S analog data for gear shift} = \frac{\text{Ssift1}}{\text{Slimt1}} \times 10$$

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	ORIENTED SPINDLE SPEED COMMAND	SORC	—	Y296	W116	Y296	Y656

[Function]

This signal is used to run the spindle motor at low speed when executing mechanical orientation during spindle control.

<Supplement>

Since most spindle drive/control units recently marketed are equipped with oriented spindle stop function, and therefore this signal is rarely used for mechanical orientation. The signal (SORC) can be used for other application such as constant rotation.

[Operation]

When the signal (SORC) turns ON, spindle speed is changed to the low speed previously set by parameter.
It should be noted that "Spindle stop" signal (SSTP) must be ON to use the signal (SORC).
Spindle gear shift data is selected by spindle gear select signal.

Gear stage	Gear select signal		Spindle speed limit	Oriented spindle stop speed
	GI2	GI1		
1	0	0	Slimt1	SORI
2	0	1	Slimt2	
3	1	0	Slimt3	
4	1	1	Slimt4	

Spindle speed data while "Oriented spindle speed command" (SORC) signal is ON can be determined from the formula shown below.
When "Spindle gear select" signal combination is GI2=0 and GI1=1 and maximum spindle speed is 10, for example.

$$\text{Oriented spindle stop speed data} = \frac{\text{SORI}}{\text{Slimt2}} \times 10$$

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	OVERRIDE CANCEL	OVC	—	Y298	W118	Y298	Y658

[Function]

With this signal, override to cutting feedrate input to the controller during automatic operation is ignored.

[Operation]

When the signal (OVC) turns ON ...

(1) Cutting feedrate override (*FV1 to 16) is ignored and feedrate specified by F command is selected.
(2) When cutting feedrate override is set at "0%", the signal (OVC) is not valid (feedrate is zero and no motion occurs).
(3) The signal does not affect to "Manual feedrate override" and "Rapid traverse override".

[Related signals]

Cutting feedrate override (*FV1 to 16: Y2A0)

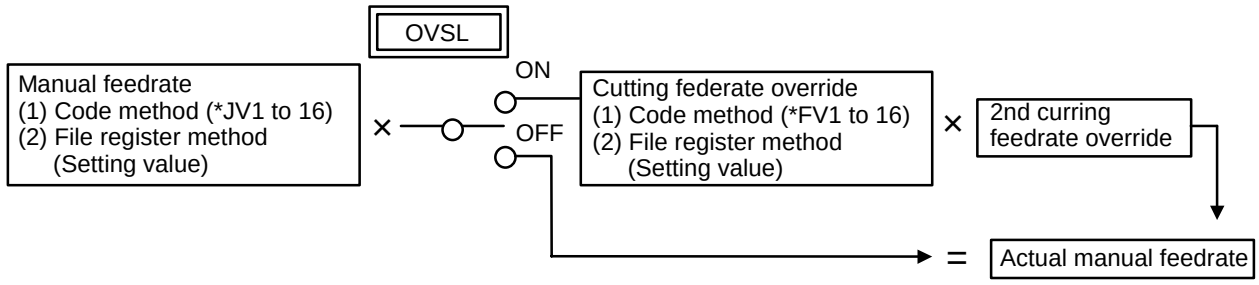
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL OVERRIDE VALID	OVSL	—	Y299	W119	Y299	Y659

[Function]

Override can be exerted on "manual feedrate" (feedrate in JOG feed, incremental feed, etc. during manual operation).

[Operation]

When this signal (OVSL) is turned ON when manual feedrate has been set, the previously set cutting feedrate override (%) is applied to that feedrate.



(Note) For details of "manual feedrate", "cutting feedrate override" and "2nd cutting feedrate override", refer to the relevant descriptions.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MISCELLANEOUS FUNCTION LOCK	AFL	—	Y29A	W11A	Y29A	Y65A

[Function]

Strobe signal for miscellaneous function (M, S, T and B) specified during automatic operation cannot be output when this signal is used. The signal (AFL) can be used to check machining program, for example.

[Operation]

When the signal (AFL) turns ON ...

(1) Miscellaneous function (M, S, T and B) specified in automatic operation cannot be executed, i.e. output of code data and function strobe signal (MF1 to 4, SF1 to 4, TF1, BF1) are withheld.
(2) If the signal turns ON after code data is output, that output is accepted and the corresponding function can be completed (FIN1 or FIN2 is received and strobe signal is set to "0").
(3) Miscellaneous function M00, M01, M02 or M30 is, however, accepted and realized even when the signal (AFL) is ON ... code data and "M function strobe" signal are output.
(4) Miscellaneous function which is executed within the controller and not output, such as M98 and M99, is executed even when the signal is ON.

[Related signals]

- M function strobe (MFn: X230)
- M code data (R20)
- S function strobe (SFn: X234)
- S code data (R28)
- T function strobe 1 (TF1: X238)
- T code data (R36)
- 2nd M function strobe 1 (BF1: X23C)
- 2nd M function data (R44)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TAP RETRACT	TRV	P C	Y29C	W11C	Y29C	Y65C

[Function]

This function is used to remove the tap from the workpiece when tap cycle has been stopped due to emergency stop, etc.

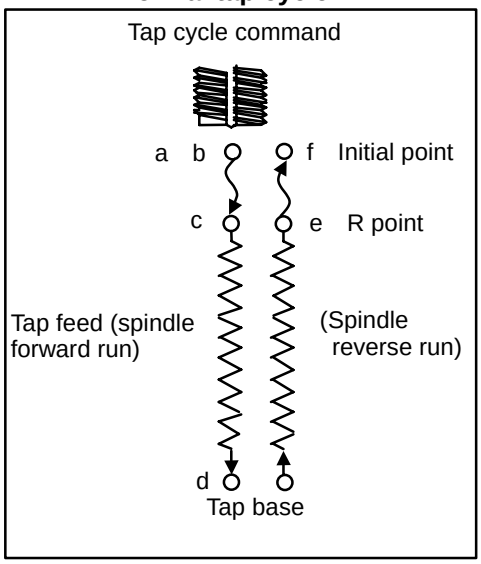
[Operation]

If the "Tap retract" signal (TRV) is turned ON while the "Tap retract possible" signal (TRVE) is ON due to an interruption in the tap cycle, the tap retract operation can be started.

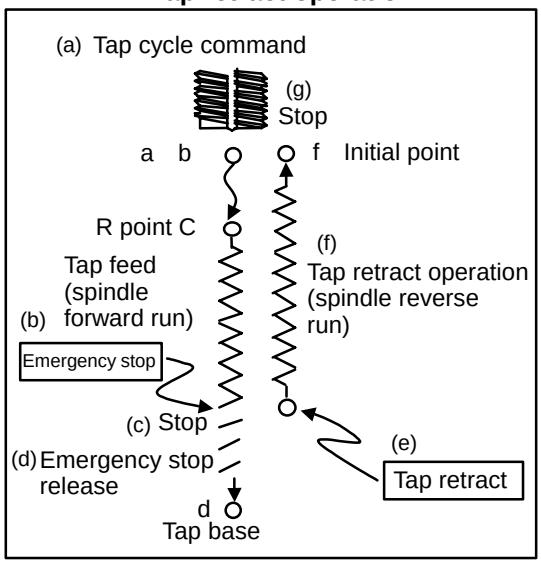
(1) The following items are conditions for tap retract. (The "Tap retract possible" signal will turn ON at this time.)
- Emergency stop during tap cycle
- Reset during tap cycle
- Power OFF during tap cycle (Only for absolute position detection system)

(2) Tap retract is executed as follows:
- Execute the synchronous tap cycle command. → (a)
- Stop the tap cycle with emergency stop. → (b)
- The "Tap retract possible" signal (TRVE) turns ON. → (c)
- Release the emergency stop. (The "Servo ready complete" signal (SA) turns ON.) → (d)
- Turn ON the "Tap retract" signal (TRV). → (e)
- The spindle will rotate in reverse, and the tap axis will move toward the tap cycle's initial point. The feedrate is the tap cycle feedrate. → (f)
- When the tap axis reaches the tap cycle initial point, the spindle and tap axis will stop, and tap retract will be completed. → (g)
- The "Tap retract possible" signal (TRVE) will turn OFF.

Normal tap cycle



Tap retract operation



(Note 1) The area between "c" and "e" above is the tap cycle. The "Tap retract possible" signal will not be output if the operation is not stopped in this area.

(Note 2) This signal is valid only during rising in the tap cycle.

(Note 3) When this signal turns ON, emergency stop and reset will not function.

[Related signals]

- Tap retract possible (TRVE: X26D)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	REFERENCE POSITION RETRACT	RTN	P C	Y29D	W11D	Y29D	Y65D

[Function]

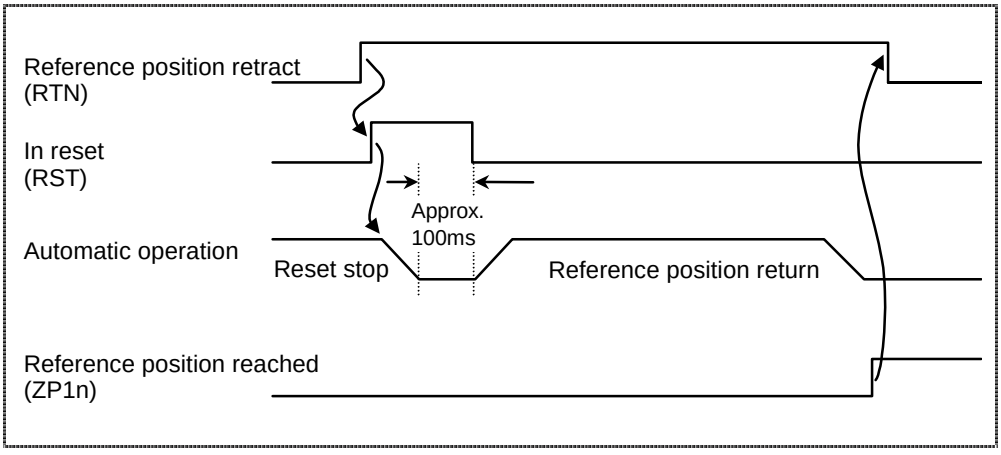
This function returns immediately to a set reference position when the return signal is input. This function is used to return to a set position for changing the tool.

[Operation]

Reference position return is executed when this signal is turned ON. At the rising edge of the signal, the program is automatically reset (reset & rewind) and then reference position return is executed.
During the automatic or MDI operation, the operation is interrupted and stopped by the reset, and reference position return is executed.
If this signal is input during execution of a tap cycle in the automatic or MDI operation modes, the "Tap retract possible" signal will be output by the reset interruption, and the return operation will be the tap retract operation. The tap retract is completed at the initial point, and after that the reference position return will be carried out.

(1) If there are two or more axes, set the return order with parameter "#2019 revnum".
(2) When the reference position is reached, the corresponding "Reference position reached" signal will be output.
(3) This signal must be held until the "Reference position reached" signal is output. If it is turned OFF midway, the return operation will be interrupted and stop. If the signal is input again, the operation will restart from execution of resetting.
(4) The reference position return speed is handled in the same manner as the normal reference position return speed.
(5) The reference position returned to during reference position retract depends on the Y200 and Y201 reference position selection.
(6) Even if the return signal is input during the thread cutting cycle, it will be invalid. However, if the return signal is executed in a block other than the thread cutting block, the return operation will be executed.
(7) The return signal is invalid if the coordinate system is not established. An operation error will occur when the return signal is input. "M01 OPERATION ERROR 0020"

[Time chart]



[Related signals]

Tap retract possible (TRVE: X26D)
Tap retract (TRV: Y29C)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	PLC EMERGENCY STOP	QEMG	P C	Y29F	W11F	Y29F	Y65F

[Function]

The controller can be set to emergency stop condition, like the case where emergency stop signal is given by user PLC.

[Operation]

Emergency stop occurs in the controller when the signal (QEMG) is turned ON. In this case, "Servo ready complete (SA)" is turned OFF.

(Note) Since this signal is processed in software, response is somewhat slower, as compared with external emergency stop signal. Approximate response is equal to 1 scan by user PLC plus 100ms.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	CUTTING FEEDRATE OVERRIDE	*FV1 to 16	—	Y2A0 to 4	W120 to 4	Y2A0 to 4	Y660 to 4

[Function]

Override (multiplication) can be exerted to cutting feedrate (F feedrate) during automatic operation with this signal.

[Operation]

When the signal is valid, true feedrate is the product obtained by multiplying referenced speed by override ratio (%) specified by the signal.
Override is 100%, even when the signal is given, in the following cases:

(1) When "Override cancel" (OVC) signal is ON.
(2) During tapping mode.
(3) During thread cutting.

These signals (*FV1 to 16) are set with the code method. The relation is shown below.

*FV16	*FV8	*FV4	*FV2	*FV1	Cutting feedrate override
1	1	1	1	1	0%
1	1	1	1	0	10%
1	1	1	0	1	20%
1	1	1	0	0	30%
1	1	0	1	1	40%
1	1	0	1	0	50%
1	1	0	0	1	60%
1	1	0	0	0	70%
1	0	1	1	1	80%
1	0	1	1	0	90%
1	0	1	0	1	100%
1	0	1	0	0	110%
1	0	0	1	1	120%
1	0	0	1	0	130%
1	0	0	0	1	140%
1	0	0	0	0	150%
0	1	1	1	1	160%
0	1	1	1	0	170%
0	1	1	0	1	180%
0	1	1	0	0	190%
0	1	0	1	1	200%
0	1	0	1	0	210%
0	1	0	0	1	220%
0	1	0	0	0	230%
0	0	1	1	1	240%
0	0	1	1	0	250%
0	0	1	0	1	260%
0	0	1	0	0	270%
0	0	0	1	1	280%
0	0	0	1	0	290%
0	0	0	0	1	300%

Generally, the rotary switch (5-step, 21-notch, compliment binary code output) is connected to the operation board, and used between 0 and 200%.

If *FV1 to *FV16 are all OFF, the previous value will be maintained. The value will change to 0% when the power is turned OFF.

[Related signals]

(1) Override cancel (OVC: Y298)
(2) 2nd cutting feedrate override valid (FV2E: Y2A6)
(3) Cutting feedrate override method select (FVS: Y2A7)

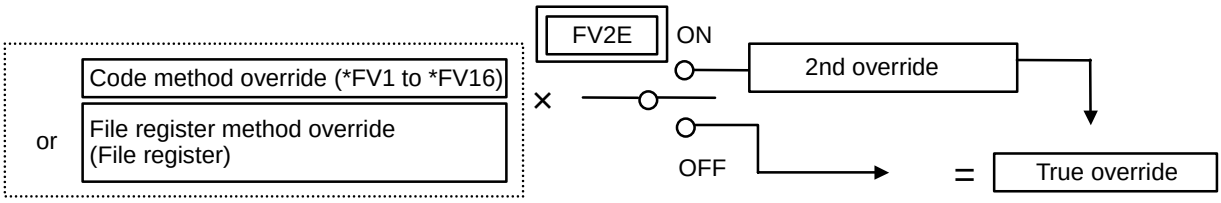
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	2ND CUTTING FEEDRATE OVERRIDE VALID	FV2E	P C	Y2A6	W126	Y2A6	Y666

[Function]

Override normally exerted on cutting feedrate in automatic operation is within a range from 0% to 300%. When this signal is used, another override (ranging from 0% to 327.67%) can be exerted on overridden feedrate.

[Operation]

When the signal (FV2E) is ON, override can be exerted on feedrate previously overridden in code method (*FV1 to 16), or file register method (by setting numerals manually). Applicable range of the 2nd override is 0% to 327.6% (0.01% increment). Value (override ratio) is set to file register in binary code.



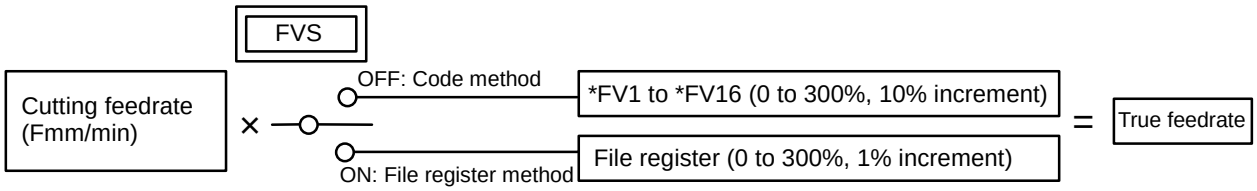
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	CUTTING FEEDRATE OVERRIDE METHOD SELECT	FVS	P C	Y2A7	W127	Y2A7	Y667

[Function]

When override is exerted on cutting feedrate in automatic operation, override method can be selected between "code method" and "file register method".

[Operation]

When the signal (FVS) is OFF, code method (*FV1 to 16) is selected.
When the signal (FVS) is ON, file register method (value is specified by manual setting) is selected.



(Note) For details of code method and file register method, refer to the relevant descriptions.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	RAPID TRAVERSE SPEED OVERRIDE	ROV1, 2	—	Y2A8, 9	W128, 9	Y2A8, 9	Y668, 9

[Function]

This signal is used to exert override on rapid traverse speed set by parameter (for rapid traverse) in automatic operation (memory, MDI or tape) or manual operation.

[Operation]

The true rapid traverse speed is that obtained by multiplying rapid traverse speed (set by parameter) by override ratio specified by this signal.
This signal is invalid if the "Rapid traverse" signal (RT) is OFF during cutting feed during automatic operation or during manual operation.

These signals (ROV1, 2) are set with the code method. The relation is shown below.

ROV2	ROV1	Rapid traverse speed override
0	0	100%
0	1	50%
1	0	25%
1	1	1%

[Related signal]

(1) Rapid traverse speed override method select (ROVS:Y2AF)

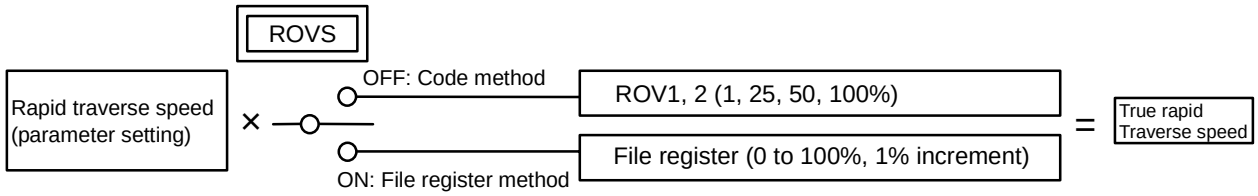
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	RAPID TRAVERSE SPEED OVERRIDE METHOD SELECT	ROVS	PC	Y2AF	W12F	Y2AF	Y66F

[Function]

When speed override is exerted on rapid traverse speed specified in automatic operation or manual operation, override method is selected between code method and file register method (manually set).

[Operation]

When the signal (ROVS) is OFF, code method (ROV1, 2) is used.
When the signal (ROVS) is ON, file register method is used.



(Note) For details of "code method override" and "file register method", refer to the respective description.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	MANUAL FEEDRATE	*JV1 to 16	—	Y2B0 to 4	W130 to 4	Y2B0 to 4	Y670 to 4

[Function]

Feedrate in manual operation (JOG mode, incremental feed mode, etc.) or in dry run of automatic operation (memory, MDI, tape) is selected.

[Operation]

This signal is valid in the following cases, but will be invalid when the "Rapid traverse" signal (RT) is ON.

(1) Jog mode, incremental mode or reference position return mode is ON.
(2) During cutting feed in automatic operation and "Dry run" signal (DRN) is ON.
(3) Dry run signal is ON during rapid traverse in the automatic operation. Note that parameter #1085 "G00 dry run" must be ON.

These signals (*JV1 to 16) are set with the code method. The relation is shown below.

*JV16	*JV8	*JV4	*JV2	*JV1	Manual feedrate			
					Machine parameter set in meters		Machine parameter set in inches	
					Metric mode (mm/min)	Inch mode (inch/min)	Metric mode (mm/min)	Inch mode (inch/min)
1	1	1	1	1	0.00	0.000	0.00	0.000
1	1	1	1	0	1.00	0.040	0.51	0.020
1	1	1	0	1	1.40	0.054	0.71	0.028
1	1	1	0	0	2.00	0.079	1.02	0.040
1	1	0	1	1	2.70	0.106	1.37	0.054
1	1	0	1	0	3.70	0.146	1.88	0.074
1	1	0	0	1	5.20	0.205	2.64	0.104
1	1	0	0	0	7.20	0.283	3.66	0.144
1	0	1	1	1	10.00	0.394	5.08	0.200
1	0	1	1	0	14.00	0.551	7.11	0.280
1	0	1	0	1	20.00	0.787	10.16	0.400
1	0	1	0	0	27.00	1.060	13.72	0.540
1	0	0	1	1	37.00	1.460	18.80	0.740
1	0	0	1	0	52.00	2.050	26.42	1.040
1	0	0	0	1	72.00	2.830	36.58	1.440
1	0	0	0	0	100.00	3.940	50.80	2.000
0	1	1	1	1	140.00	5.510	71.12	2.800
0	1	1	1	0	200.00	7.870	101.60	4.000
0	1	1	0	1	270.00	10.600	137.16	5.400
0	1	1	0	0	370.00	14.600	187.96	7.400
0	1	0	1	1	520.00	20.500	264.16	10.400
0	1	0	1	0	720.00	28.300	365.76	14.400
0	1	0	0	1	1000.00	39.400	508.00	20.000
0	1	0	0	0	1400.00	55.100	711.20	28.000
0	0	1	1	1	2000.00	78.700	990.60	39.000
0	0	1	1	0	2700.00	106.000	1371.60	54.000
0	0	1	0	1	3700.00	146.000	1879.60	74.000
0	0	1	0	0	5200.00	205.000	2641.60	104.000
0	0	0	1	1	7200.00	283.000	3657.60	144.000
0	0	0	1	0	10000.00	394.000	5080.00	200.000
0	0	0	0	1	14000.00	551.000	7112.00	280.000

If *JV 1 to *JV16 are all OFF, the previous value will be maintained. The value will be set to 0 when the power is turned OFF.

(Note 1) In JOG mode, true feedrate changes if this signal changes during feed motion.
(Note 2) In incremental feed mode, true feedrate does not change if this signal changes during feed motion.

[Related signal]

(1) Manual feedrate method select (JVS:Y2B7)
(2) Manual override valid (OVSL:Y299)

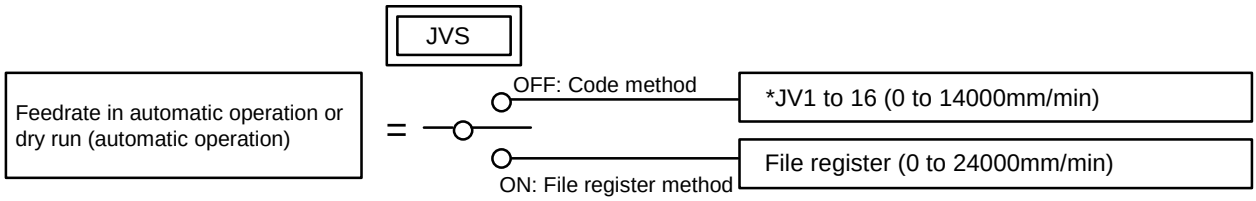
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL FEEDRATE METHOD SELECT	JVS	P C	Y2B7	W137	Y2B7	Y677

[Function]

When feedrate is specified in manual operation (JOG mode, incremental feed mode, etc.) or dry run (automatic operation), feedrate command method is selected between code method and file register method.

[Operation]

When the signal (JVS) is OFF, code method (*JV1 to *JV16) is selected.
When the signal (JVS) is ON, file register method is selected.



(Note) For details of "code method feedrate" and "file register method feedrate", refer to the relevant description.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	FEEDRATE LEAST INCREMENT	PCF1, 2	P C	Y2B8, 9	W138, 9	Y2B8, 9	Y678, 9

[Function]

When manual feedrate is specified in file register method (JVS: "ON") or in random manual feed mode, file registers R (R136 and R137) are used. In this case, least increment OFFeedrate entered into file registers R136 and R137 is specified by this signal.

[Operation]

The relationship between PCF1/PCF2 and least feed increment is as follows:

PCF2	PCF1	Least increment (mm/min or inch/min)	Operation
0	0	10	10mm/min (inch/min) when "1" is set in file registers.
0	1	1	1mm/min (inch/min) when "1" is set in file registers.
1	0	0.1	0.1mm/min (inch/min) when "1" is set in file registers.
1	1	0.01	0.01mm/min (inch/min) when "1" is set in file registers.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	JOG SYNCHRONOUS FEED VALID	JSYN	P C	Y2BA	W13A	Y2BA	Y67A

[Function]

This is used when the manual feedrate designation is to be per rotation feed (feed rate per spindle rotation).

[Operation]

(1) The following operation mode feedrates will immediately become per rotation feed when the "Jog synchronous feed valid" signal is turned ON.
- Jog mode
- Incremental feed mode
- Reference position return mode
- When EX.F/MODAL.F is OFF and G0/G1 is ON in the manual random feed mode.

(2) Even if the jog synchronous feed valid signal is ON, the per minute feed will be used in the following states.
- When the "Dry run" signal is ON.
- When the "Rapid traverse" signal is ON in the jog, incremental or reference position return modes.

[Designation OFFeedrates]

The designation of the per rotation feedrate is the same as the per minute feed input.
The cutting feedrate override will be valid when the manual override valid signal is ON.

(1) Code designation method (*JV1 to 16)

*JV16 (Y2B4)	*JV8 (Y2B3)	*JV4 (Y2B2)	*JV2 (Y2B1)	*JV1 (Y2B0)	Feed per minute		Feed per rotation	
					mm/min	inch/min	mm/rev	inch/rev
1	1	1	1	1	0.00	0.000	0.0000	0.00000
1	1	1	1	0	1.00	0.040	0.0100	0.00040
1	1	1	0	1	1.40	0.054	0.0140	0.00054
1	1	1	0	0	2.00	0.079	0.0200	0.00079
1	1	0	1	1	2.70	0.106	0.0270	0.00106
1	1	0	1	0	3.70	0.146	0.0370	0.00146
1	1	0	0	1	5.20	0.205	0.0520	0.00205
1	1	0	0	0	7.20	0.283	0.0720	0.00283
1	0	1	1	1	10.00	0.394	0.1000	0.00394
1	0	1	1	0	14.00	0.551	0.1400	0.00551
1	0	1	0	1	20.00	0.787	0.2000	0.00787
1	0	1	0	0	27.00	1.060	0.2700	0.01060
1	0	0	1	1	37.00	1.460	0.3700	0.01460
1	0	0	1	0	52.00	2.050	0.5200	0.02050
1	0	0	0	1	72.00	2.830	0.7200	0.02830
1	0	0	0	0	100.00	3.940	1.0000	0.03940
0	1	1	1	1	140.00	5.510	1.4000	0.05510
0	1	1	1	0	200.00	7.870	2.0000	0.07870
0	1	1	0	1	270.00	10.600	2.7000	0.10600
0	1	1	0	0	370.00	14.600	3.7000	0.14600
0	1	0	1	1	520.00	20.500	5.2000	0.20500
0	1	0	1	0	720.00	28.300	7.2000	0.28300
0	1	0	0	1	1000.00	39.400	10.0000	0.39400
0	1	0	0	0	1400.00	55.100	14.0000	0.55100
0	0	1	1	1	2000.00	78.700	20.0000	0.78700
0	0	1	1	0	2700.00	106.000	27.0000	1.06000
0	0	1	0	1	3700.00	146.000	37.0000	1.46000
0	0	1	0	0	5200.00	205.000	52.0000	2.05000
0	0	0	1	1	7200.00	283.000	72.0000	2.83000
0	0	0	1	0	10000.00	394.000	100.0000	3.94000
0	0	0	0	1	14000.00	551.000	140.0000	5.51000

(2) Numeric value setting method (R136, 7)

The feedrate when the "Manual feedrate method select" signal (JVS) is selected will be set in R136 and R137 with the binary value. The designation unit will be as follows according to the "Feedrate least increment" signals (PCF1, PCF2).

PCF2 (Y2B9)	PCF1 (Y2B8)	Feed per minute	Feed per rotation
		Speed unit mm/min. or inch min.	Speed unit mm/rev. or inch rev.
0	0	10	0.1
0	1	1	0.01
1	0	0.1	0.001
1	1	0.01	0.0001

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	JOG•HANDLE SYNCHRONOUS	JHAN	P C	Y2BB	W13B	Y2BB	Y67B

[Function]

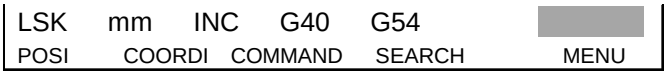
Jog feed and handle feed can be carried out without changing the operation mode.

[Operation]

If the "Jog mode" (J) signal and this signal are input simultaneously, the "jog/handle synchronous mode" will be entered.
If the "Rapid traverse" (RT) signal is turned ON during the "jog/handle synchronous mode", the jog feed will be carried out at the rapid traverse feedrate. When the "Rapid traverse" turns OFF, the jog feed will be carried out at the manual feedrate.

Operation mode	Jog•handle synchronous signal (Y2BB)	Rapid traverse signal (Y22E)	Operation during jog feed	Handle feed
Jog feed	On	On	Rapid traverse feedrate	Possible
		Off	Manual feedrate	Possible
	Off	On	Rapid traverse feedrate	Impossible
		Off	Manual feedrate	Impossible

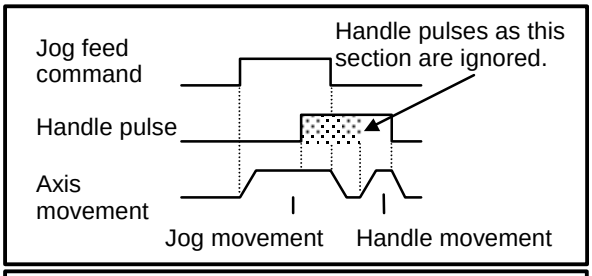
(1) During the "jog/handle synchronous mode", the operation status mode display at the lower part of the setting and display unit screen will be as shown below.



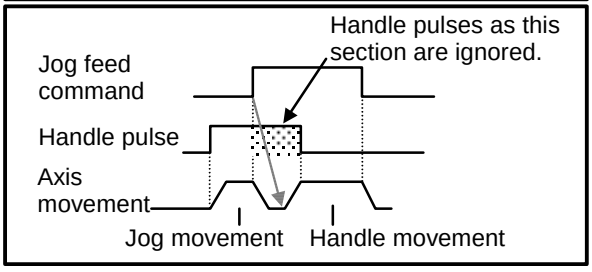
Rapid traverse hand
When jog feed is carried out at rapid traverse feedrate
Manual hand
When jog feed is carried out at manual feedrate

(2) During "jog/handle synchronous mode", jog feed and handle feed can be carried out randomly. However, jog feed and handle feed cannot be carried out simultaneously on the same axis. If carried out simultaneously, the jog feed will have a priority. The changeover between jog feed and handle feed on the same axis is carried out when the relevant axis has stopped.

- If handle feed is carried out on an axis that is being jog fed, the jog feed will have a priority, so after movement with jog feed has completed (the axis has stopped), handle feed movement will start.



- If jog feed is carried out on an axis that is being handle fed, the handle feed movement will stop at the rising edge of the jog feed command. After the axis stops, the jog feed movement will start.



(Note) If only the "Jog•handle synchronous" signal is output, "M01 OPERATION ERROR 0101" will occur. If the "Jog•handle synchronous" signal is input simultaneously with an operation mode signal other than the jog mode, the "Jog•handle synchronous" signal will be ignored.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	EACH AXIS MANUAL FEEDRATE B VALID		P C	Y2BC	W13C	Y2BC	Y67C

[Function]

This signal validates manual feed using each axis manual feedrate B.

[Operation]

(1) If this signal and the manual feedrate B valid signal for the corresponding axis are validated when carrying out manual feed in the jog mode, the axis will move at the speed commanded by each axis manual feedrate B which is commanded separately from the manual feedrate or manual feedrate B.
(2) This signal is common for all axes.

[Related signal]

- Manual feedrate B valid (Y260 to 267)
- Each axis manual feedrate B (R400 to 415)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	HANDLE/INCREMENTAL FEED MULTIPLICATION	MP1 to 4	P C	Y2C0 to 2	W140 to 2	Y2C0 to 2	Y680 to 2

[Function]

Amount OFFeed motion per pulse from the manual pulse generator in HANDLE feed mode, or amount OFFeed motion per shot in incremental feed mode (±J1 to 8: "ON") is multiplied by this signal.

[Operation]

This signal (MP1 to 4) is set with the code method.
When this code mode is selected, the true amount of feed motion (per pulse feed in handle feed mode, and per ON/OFF of ±Jn value in incremental feed mode) is the product obtained by multiplying originally set amount of feed by multiplier MP1, MP2, MP4.

The relationship between multiplier code (MP1 to 4) and multiplication in each feed mode is as follows.

MP4	MP2	MP1	Multiplication in HANDLE feed	Multiplication in INCREMENTAL feed
0	0	0	1	1
0	0	1	10	10
0	1	0	100	100
0	1	1	1000	1000
1	0	0	1	5000
1	0	1	10	10000
1	1	0	100	50000
1	1	1	1000	100000

[Related signal]

- Handle mode (H: Y209)
- Incremental mode (S: Y208)

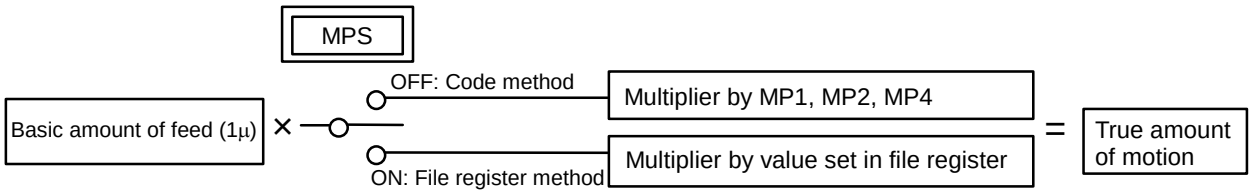
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	HANDLE/INCREMENTAL FEED MULTIPLICATION METHOD SELECT	MPS	PC	Y2C7	W147	Y2C7	Y687

[Function]

Feed multiplication method in handle feed or incremental feed is selected between "code method" and "file register method" by this signal.

[Operation]

When the signal (MPS) is OFF, "code feed multiplication method" is selected.
When the signal (MPS) is ON, "file register multiplication method" is selected.



(Note) For details OFFeed multiplication code method and feed multiplication file register method, refer to the relevant descriptions.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL ALARM 1/TOOL-SKIP TOOL	TAL1	PC	Y2C8	W148	Y2C8	Y688

[Function]

Set the tool data status during tool life management to status "3" (M system: Tool alarm 1, L system: Tool-skip tool).

[Operation]

When the signal (TAL1) is turned ON (for tool life management specification), status of tool data is changed to status "3".
For M system, this signal becomes valid when "Tool life management input" signal (Y2CB) is ON.

[Related signals]

Tool life management input (TLF1: Y2CB)
Tool alarm 2 (TAL2: Y2C9)
Data count valid (TCEF: Y2CA)

B contact	Signal name	Signal abbreviation	PC	1st system	2nd system	1st system	2nd system
—	TOOL ALARM 2 (M system)	TAL2		Y2C9	W149	Y2C9	Y689

[Function]
Set the tool data status during tool life management to status "4" (Tool alarm 2).

[Operation]
When the signal (TAL2) is turned ON (for tool life management specification), status of tooling data is changed to status "4". This signal becomes valid when "Tool life management input" signal (Y2CB) is ON.

[Related signals]
Tool life management input (TLF1: Y2CB)
Tool alarm 1/Tool-skip tool (TAL1: Y2C8)
Data count valid (TCEF: Y2CA)

B contact	Signal name	Signal abbreviation	PC	1st system	2nd system	1st system	2nd system
—	DATA COUNT VALID	TCEF		Y2CA	W14A	Y2CA	Y68A

[Function]
Tool life counter becomes applicable when this signal is used during tool life control.

[Operation]
When tool life control function is available, counter (count of tool service time or cycles) becomes valid. For M system, this signal becomes valid when "Tool life management input" signal (Y2CB) is ON.

[Related signals]
Tool life management input (TLF1: Y2CB)
Tool alarm 1/Tool-skip tool (TAL1: Y2C8)
Tool alarm 2 (TAL2: Y2C9)

B contact	Signal name	Signal abbreviation	PC	1st system	2nd system	1st system	2nd system
—	TOOL LIFE MANAGEMENT INPUT (M system)	TLF1		Y2CB	W14B	Y2CB	Y68B

[Function]
Tool life management function becomes valid when this signal is given.

[Operation]
When tool life management function is available, tool life can be controlled with this signal turned ON.

[Related signals]
Tool alarm 1/Tool-skip tool (TAL1: Y2C8)
Tool alarm 2 (TAL2: Y2C9)
Data count valid (TCEF: Y2CA)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL CHANGE RESET (L system)	TRST	P C	Y2CC	W14C	Y2CC	Y68C

[Function]

This signal is used to clear all tool usage data in the group of the lathe system tool life management II function.

[Operation]

Select whether the group to be cleared is all groups which have exceeded the life or specific group with the "Tool group No. designation" (file register R150, 151).
When the next group is selected after this signal is input, the head tool of that group will be selected.

(Note) The usage data will be counted in respect to the tool used when the signal is input until the tool change is reset or until the next tool is selected when tool skip is carried out on the currently selected group. Thus, when changing the selected tool along with the signal input, select the group beforehand. However, if there is no movement command up to the next group selection after this signal is input, a tool may not be selected because of the preceding process. In this case, turn the "Recalculation request" (CRQ) signal ON before selecting the group to invalidate the details of the preceding process.

[Related signals]

(1) Recalculation request (CRQ: Y233)
(2) Tool group No. designation (R150, 151)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE FORWARD RUN START	SRN	—	Y2D0	W150	Y2D0	Y690

[Function]

This signal is issued to the high speed serial connection specification spindle controller (spindle drive). When the signal turns ON, the spindle motor starts rotating in normal direction (CCW as viewed from the shaft side).

[Operation]

Spindle motor starts running at speed specified by S command (S analog data) when the signal (SRN) is turned ON.

When the signal is turned OFF, spindle motion decelerates and stops (transistor base current is shut OFF).

(1) Spindle motor stops if "Spindle forward run start" signal (SRN) and "Spindle reverse run start" signal (SRI) are turned ON at the same time. To resume forward run, both signals OFF once and then turn the "Spindle forward run start" signal ON.
(2) The operation may stop during forward run due to emergency stop, spindle alarm or resetting. Turn the forward run signal OFF and ON once after the "Servo ready complete" signal (SA) turns ON.
(3) The motor will not run if the S analog data is 0. The motor will run at the corresponding rotation speed when the S analog data changes.
(4) When "Spindle orient command" signal (ORC) is turned ON at the same as "Spindle forward run start" signal (SRN) is turned ON, priority is given to the former signal.

[Related signals]

(1) Spindle reverse run start (SRI: Y2D1)
(2) Spindle orient command (ORC: Y2D6)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE REVERSE RUN START	SRI	—	Y2D1	W151	Y2D1	Y691

[Function]

This signal is issued to the high speed serial connection specification spindle controller (spindle drive). When the signal turns ON, the spindle motor starts rotating in inverse direction (CW as viewed from the shaft side).

[Operation]

Spindle motor starts running at speed specified by S command (S analog data) when the signal (SRI) is turned ON.

When the signal is turned OFF, spindle motion decelerates and stops (transistor base current is shut OFF).

(1) Spindle motor stops if "Spindle reverse run start" signal (SRI) and "Spindle forward run start" signal (SRN) turn ON at the same time. To resume reverse run, both signals OFF once and then turn the "Spindle reverse run start" signal ON.
(2) The operation may stop during reverse run due to emergency stop, spindle alarm or resetting. Turn the reverse run signal OFF and ON once after the "Servo ready complete" signal (SA) turns ON.
(3) The motor will not run if the S analog data is 0. The motor will run at the corresponding rotation speed when the S analog data changes.
(4) When "Spindle orient command" signal (ORC) is turned ON at the same time "Spindle reverse run start" signal (SRI) is turned ON, priority is given to the former signal.

[Related signals]

(1) Spindle forward run start (SRN: Y2D0)
(2) Spindle orient command (ORC: Y2D6)

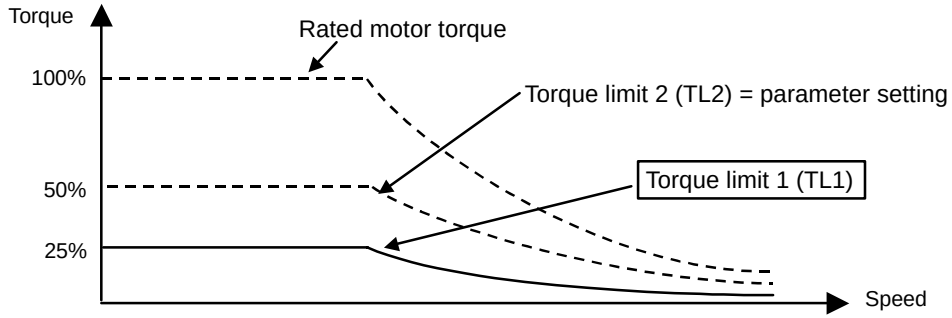
B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	TORQUE LIMIT 1	TL1	PC	Y2D2	W152	Y2D2	Y692

[Function]

This signal is issued to the high-speed serial connection specification spindle controller (spindle drive). When the signal turns ON, spindle motor torque is reduced temporarily.
The signal is used in mechanical oriented spindle stop, or gear shift.

[Operation]

There are torque limit 1 (TL1) and torque limit 2 (TL2) signals.
When the torque limit 1 signal (TL1) turns ON, the output torque will drop with the set torque limit ratio (half of the torque limit ratio when torque limit 2 set with parameters is ON).



(Note 1) This signal is valid only for systems that are high-speed serial connected with the spindle controller.

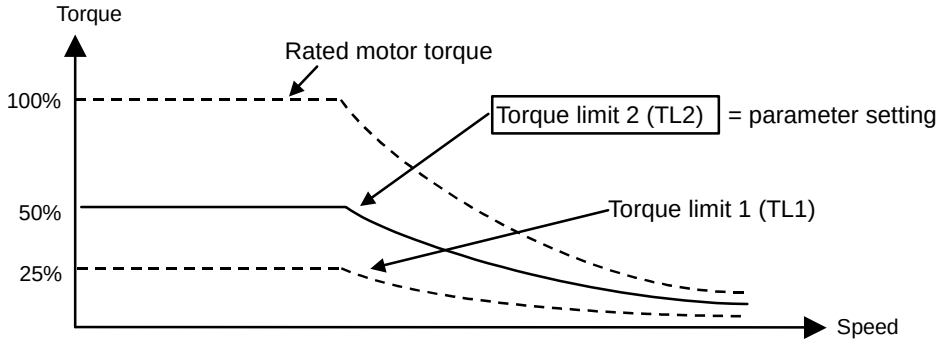
B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	TORQUE LIMIT 2	TL2	PC	Y2D3	W153	Y2D3	Y693

[FUNCTION]

This signal is used for the same purpose as torque limit 1 (TL1).

[Operation]

When torque limit 2 (TL2) turns ON, the output torque will drop by the torque limit ratio set with parameters.



(Note 1) The torque limit ratio can be set within the range of 0% to 120% with parameters only for torque limit 2.

(Note 2) This signal is valid only for systems that are high-speed serial connected with the spindle controller.

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE FORWARD RUN INDEX	WRN	P C	Y2D4	W154	Y2D4	Y694

[Function]

This signal is issued to the high-speed serial connection specification spindle controller (spindle drive), and used for the following two purposes.

(1) Spindle forward run index in multi-point indexing

(2) Forward run indexing in turret control (turret indexing)

[Operation]

(1) Multi-point indexing

(a) This signal turns ON after the "Spindle in-position (ORAO)" signal is output.

(b) Continuous indexing can be carried out by turning this signal ON and OFF while the "Spindle orient command" (ORC) signal is ON.

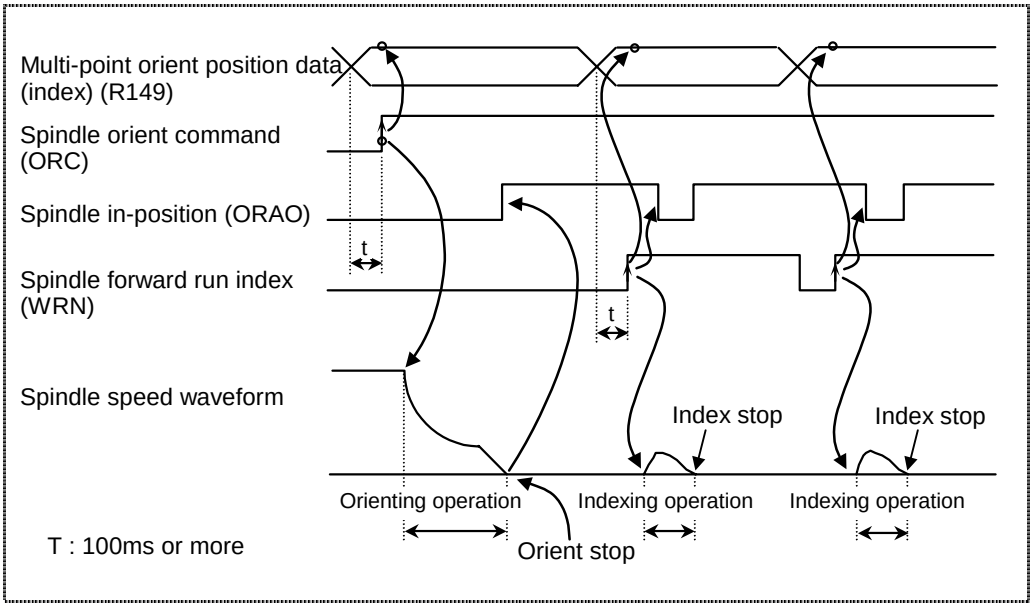
(c) If this signal is turned ON before the "Spindle orient command" (ORC) signal is turned ON and the "Spindle in-position" (ORAO) signal is output, first the "Spindle orient command" (ORC) signal will turn ON, and the orientation will be completed at the multi-point orientation position data (R149) read in. Then, the spindle will be indexed to the position command value read in when this signal is turned ON. If the position command value is the same when the "Spindle orient command" (ORC) turns ON and this signal turns ON, the indexing operation will not be carried out.

(d) The index position command value (12-bit) is read in at the rising edge of this signal. Thus, even if the index position command value is changed after this signal is input, the stop position will not change.

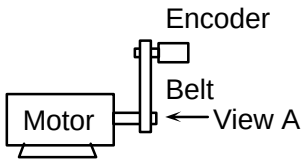
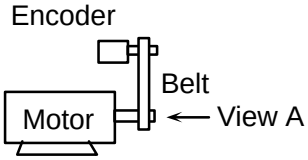
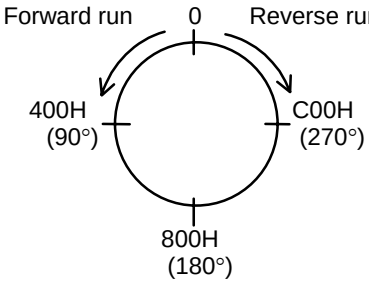
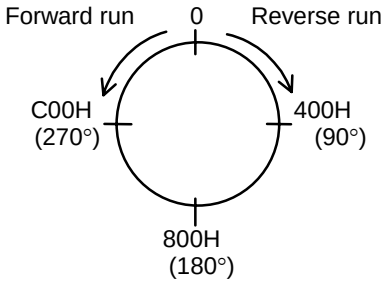
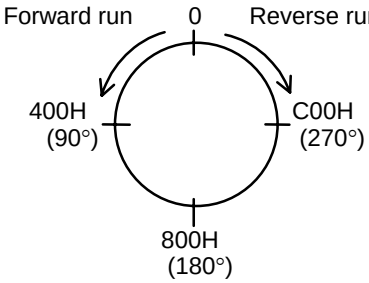
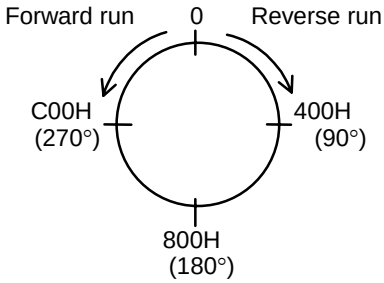
(e) Even if this signal is turned OFF while the "Spindle orient command" (ORC) is ON, the spindle will continue to stop at the position before this signal was turned OFF. Even if this signal is turned OFF during the indexing operation, the spindle will stop at the position command value read at the rising edge of this signal.

(f) If the stop point and index position command value are close (within the in-position range), the "Spindle in-position" (ORAO) signal may not turn OFF and the indexing may be carried out.

(g) If the "Spindle orient command" (ORC) signal is turned OFF during indexing or when stopped, the servo lock will turn OFF and the motor will coast. Orientation must be carried out again when executing indexing again.



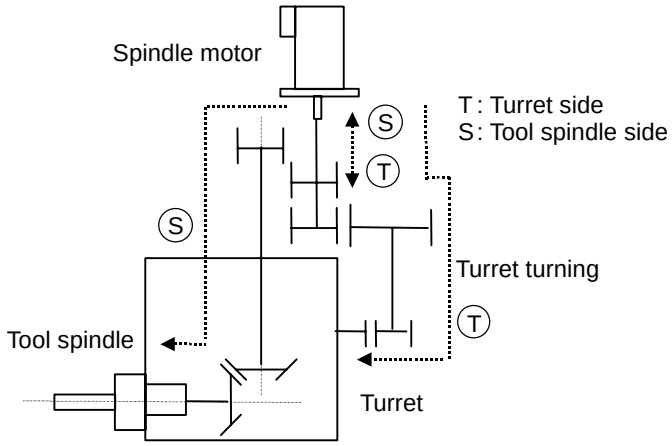
[Indexing operation according to encoder installation direction]

	Case 1	Case 2
Installation method		
Indexing		
Orienting		

(Note) Case 1 above applies when using the motor built-in encoder with Z-phase.

(2) Turret control (turret indexing)

[Configuration example]



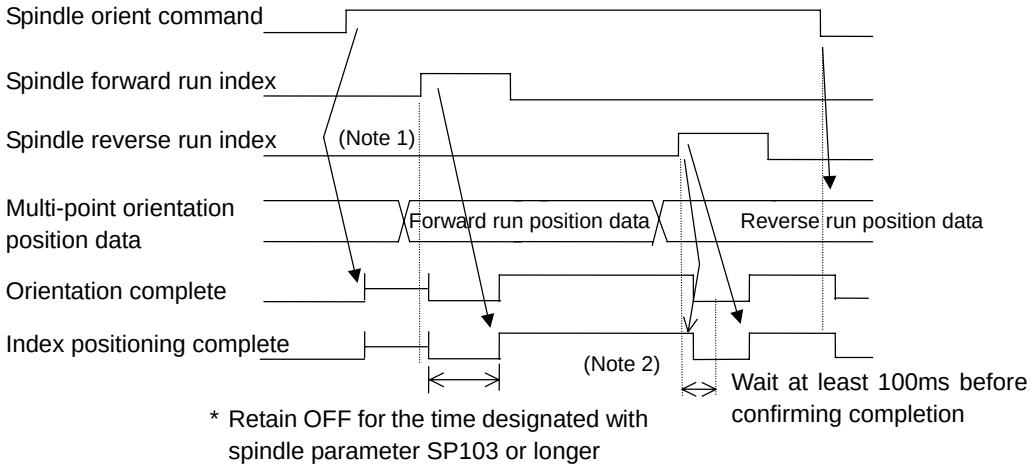
Turret control is used to turn the turret using the spindle system (drive amplifier, motor) originally used as the tool spindle. This control eliminates the need for the hydraulic drive system or general-purpose servo conventionally required just for the turret.

[Operation]

(a) Orient the spindle.
If values are set in the parameters and multi-point orientation position data at this time, the spindle will be positioned to an angle shifted by the amount obtained by adding the two values.
If there is multi-point orientation position data during orientation, the spindle will be positioned to the angle shifted by that amount during forward run/reverse run indexing.
The basic orientation shift is carried out with parameters.

(b) Next, carry out positioning to an arbitrary angle using the forward run/reverse run indexing function.
At this time, set the angle data before turning the "Spindle forward run/reverse run index" signal ON. (Note 1)
The "Index positioning complete" signal will turn OFF when forward run/reverse run is started (turned ON), but it will take some time for the signal to turn OFF once, wait at least 100ms before confirming that the index positioning is completed after forward run/reverse run is completed. (Note 2)

(c) If the spindle orientation holding torque forces are overlapped, the torque limit function will be used.
An example of the turret control timing is shown below.



[Cautions]

(1) Make sure that the operation is not overlapped with the tool spindle orientation.
(2) The indexing function can be used when orientation is completed.
(3) Only the indexing function is valid during turret control. The tool spindle speed control cannot be used.
(4) Set the multi-point orientation position data to "0" during the first orientation.
(5) If angle data is commanded during the first orientation, that point will be zero (0) degrees from the next indexing.
(6) Some spindle controllers do not have the turret control function.

[Related signals]

(1) Multi-point orientation position data (R149)
(2) Spindle in-position (ORAO: X246)
(3) Spindle orient command (ORC: X2D6)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE REVERSE RUN INDEX	WRI	PC	Y2D5	W155	Y2D5	Y695

[Function]

This signal is issued to the high-speed serial connection specification spindle controller (spindle drive), and used for the following two purposes.
(1) Spindle reverse run index in multi-point indexing
(2) Reverse run indexing in turret control (turret indexing)

[Operation]

The operation is the same as forward run indexing, except that the direction is different. Refer to the section on "Spindle forward run index".

[Related signal]

(1) Spindle forward run index (WRN: Y2D4)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE ORIENT COMMAND	ORC	P C	Y2D6	W156	Y2D6	Y696

[Function]

This signal is issued to the high-speed serial connection specification spindle controller (spindle drive). When the signal is turned ON, the spindle is indexed in position.

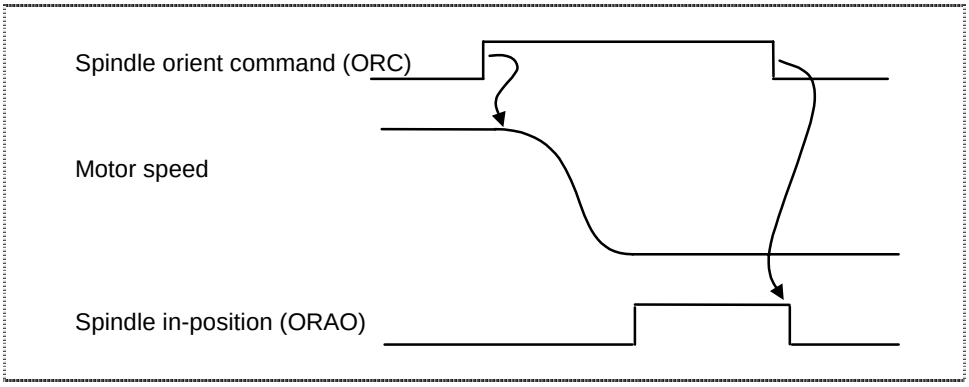
[Operation]

If the "Spindle orient command" signal (ORC) turns ON during spindle rotation or when stopped, the spindle will start orientation (stopping at set position). When positioning at the set position is completed, the "Spindle in-position" signal (ORAO) will be output, and orientation will stop.
During oriented spindle stop, the control system is under "servo lock" condition. Servo lock is released when the signal (ORC) is turned OFF. When servo lock must be maintained, the signal, therefore, should be kept turned ON.
The encoder or magnetic sensor method can be used for orientation.

The orientation rotation direction is determined with the parameters.
The orientation stop position is determined by the Z-phase for the encoder method, and by the sensor installation position for the magnetic sensor method. The stopping position can be changed with the following items when using the encoder method.

(1) By parameters (position shift amount)
(2) By multi-point orientation position data (data specification by R149) value
The multi-point orient position data by the parameter and R149 is added.

The timing chart for basic orientation is shown below.



(Note 1) The "Spindle orient command" (ORC) takes precedence over the forward run (SRN) and reverse run (SRI) commands.
(Note 2) This signal is valid only for systems that are high-speed serial connected with the spindle controller.

[Related signals]

(1) Multi-point orientation position data (R149)
(2) Spindle in-position (ORAO: X246)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	L COIL SELECTION	LRSL	P C	Y2D7	W157	Y2D7	Y697

[Function]

This signal is used to select the low-speed coil in the spindle coil changeover function.

[Operation]

The high-speed coil and low-speed coil are changed over only with the "L coil selection" (LRSL) in the 2-step coil changeover specification. The high-speed coil, middle- speed coil and low-speed coil are changed over with the combination of the "L coil selection" (LRSL) and "M coil selection" (LRSM) in the 3-step coil changeover specification.

(Note) The coil is not changed over during the position loop control mode even if this signal is changed. The coil selected immediately before the position loop control mode is entered is retained.

(1) 2-step coil changeover

Selected coil	L coil selection (LRSL)	In L coil selected (LCSA)
High-speed (H)	OFF	OFF
Low-speed (L)	ON	ON

(2) 3-step coil changeover

Selected coil	L coil selection (LRSL)	M coil selection (LRSM)	In L coil selected (LCSA)	In M coil selected (MCSA)
High-speed (H)	OFF	OFF	OFF	OFF
Middle-speed (M)	OFF	ON	OFF	ON
Low-speed (L)	ON	OFF	ON	OFF
	ON	ON	ON	ON

[Related signals]

M coil selection (LRSM: Y2DE)
In L coil selected (LCSA: X247)
In M coil selected (MCSA: X1D6)

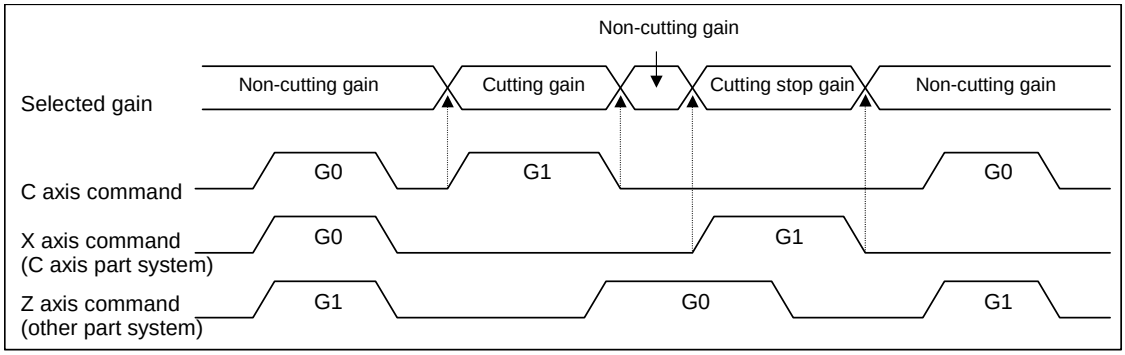
B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	C AXIS GAIN L, H		P C	Y2DA, B	W15A, B	Y2DA, B	Y69A, B

[Function]

This signal selects whether to change the C axis gain (select optimum gain) according the C axis cutting state.

During C axis cutting feed, cutting gain is applied. During other axis' cutting feed (C axis face turning), non-cutting stop gain is applied. Non-cutting gain is applied in all other cases.

[Operation]



(Note 1) The cutting feed of other part systems dose not affect the C axis gain selection.
(Note 2) There are 1st to 3rd cutting gains, which are selected with the ladder.

Signal / Selected details	C axis gain L	C axis gain H	Remarks	
Non-cutting gain	–	–	Spindle parameter SP003 selection	Selected during rapid traverse
1st cutting gain	0	0	Spindle parameter SP130 selection	Selected during cutting feed
	1	1		
2nd cutting gain	1	0	Spindle parameter SP131 selection	
3rd cutting gain	0	1	Spindle parameter SP132 selection	
Cutting stop gain	–	–	Spindle parameter SP133 selection	

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	M COIL SELECTION	LRSM	P C	Y2DE	W15E	Y2DE	Y69E

[Function]

This signal is used to select the middle-speed coil in the 3-step coil changeover specification of the spindle coil changeover function.

[Operation]

The coil is selected depending on the combination of this signal and the "L coil selection" (LRSL).

(Note) The coil is not changed over during the position loop control mode even if this signal is changed. The coil selected immediately before the position loop control mode is entered is retained.

Selected coil	L coil selection (LRSL)	M coil selection (LRSM)	In L coil selected (LCSA)	In M coil selected (MCSA)
High-speed (H)	OFF	OFF	OFF	OFF
Middle-speed (M)	OFF	ON	OFF	ON
Low-speed (L)	ON	OFF	ON	OFF
	ON	ON	ON	ON

[Related signals]

L coil selection (LRSL: Y2D7)
In L coil selected (LCSA: X247)
In M coil selected (MCSA: X1D6)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	PLC CONTROL AXIS NEAR-POINT DOG n-TH AXIS	*PCD1, 2	P C	Y2E0, 1	—	Y2E0, 1	—

[Function]
The PLC axis reference position near-point dog signal is input.

[Operation]
The PLC axis reference position near-point dog signal is set in the following devices by the PLC.

Device No.		Signal name
Y2E0	PCD1	PLC control axis near-point dog 1st axis
Y2E1	PCD2	PLC control axis near-point dog 2nd axis

(Note) If the dog signal is set during the PLC middle-speed process, the response will be poorer than when the dog signal is set with the PLC high-speed process.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	PLC CONTROL AXIS n-TH HANDLE VALID	PCH1 to 3	P C	Y2E4 to 6	—	Y2E4 to 6	—

[Function]
This is designated when handle feed is to be carried out with the PLC axis.

[Operation]
Designate with the following devices when carrying out handle feed with the PLC axis.

Device No.		Signal name
Y2E4	PCH1	PLC control axis 1st handle valid
Y2E5	PCH2	PLC control axis 2nd handle valid
Y2E6	PCH3	PLC control axis 3rd handle valid

(Note 1) When this signal is ON, each handle will be exclusive for the PLC axis. The handle will not be valid for the NC control axis.
The "1st handle axis No." (HS11 to 116, HS11S), the "2nd handle axis No." (HS21 to 216, HS21S) and "3rd handle axis No." (HS31 to 316, HS31S) are used to select each handle axis.
(Note 2) The handle feed magnification is common with that for the NC control axis.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE SYNCHRONIZATION CANCEL	SPSYC	PC	Y2E8	—	Y2E8	—

[Function]

This signal is used to cancel the spindle synchronous control with the G114.n command.
The spindle synchronous control with the "Spindle synchronous control" (Y398) is not canceled.

[Operation]

The spindle synchronous control mode can be canceled by turning this signal ON.

[Related signals]

In spindle synchronous control (SPSYN1: X308)
Spindle rotation speed synchronization complete (FSPRV: X309)
Spindle phase synchronization complete (FSPPH: X30A)
Spindle phase synchronous control (SPPHS: Y399)
Spindle synchronous control phase error 1 (degree) (R475)
Spindle synchronous control phase error 2 (degree) (R476)

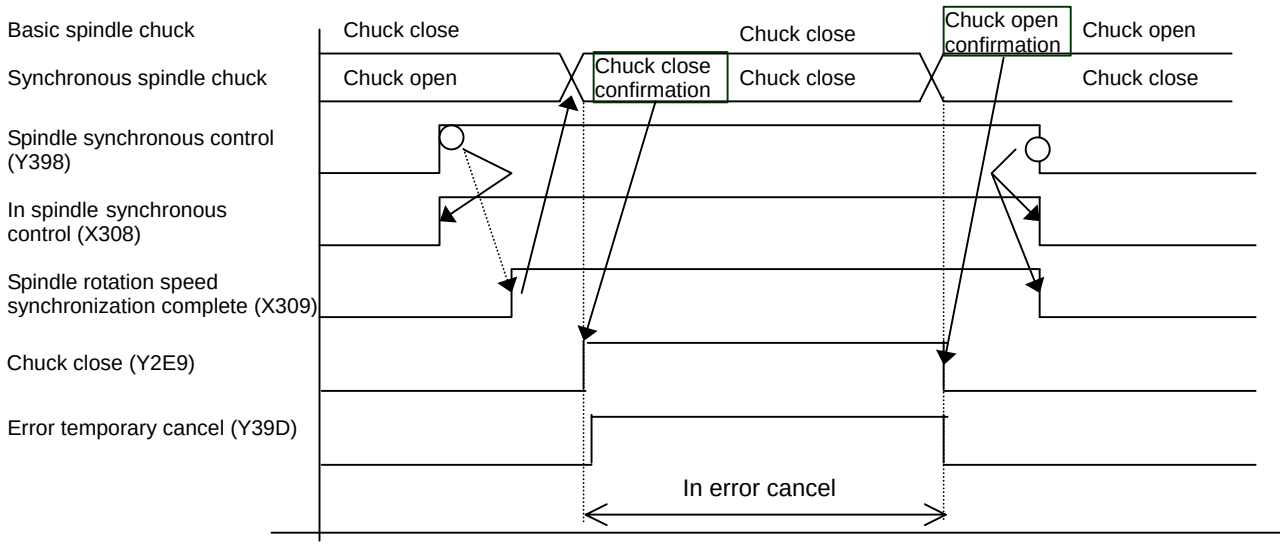
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	CHUCK CLOSE	SPCMPC	PC	Y2E9	—	Y2E9	—

[Function]

This signal is turned ON while the basic spindle and synchronous spindle clamp the same work.

[Operation]

The "Spindle chuck close confirmation" signal is turned ON when the "Chuck close" signal is ON.
The "Spindle chuck close confirmation" signal is turned OFF when the "Chuck close" signal is OFF.



(Note) Use the "Error temporary cancel" only when the rotation error between the basic spindle and synchronous spindle occurs because of the "Chuck close" signal.

[Related signals]

"Chuck close confirmation" signal (SPCMP: X30E)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	CRT CHANGEOVER COMPLETE	CRTFN	P C	Y2F8	—	Y2F8	—

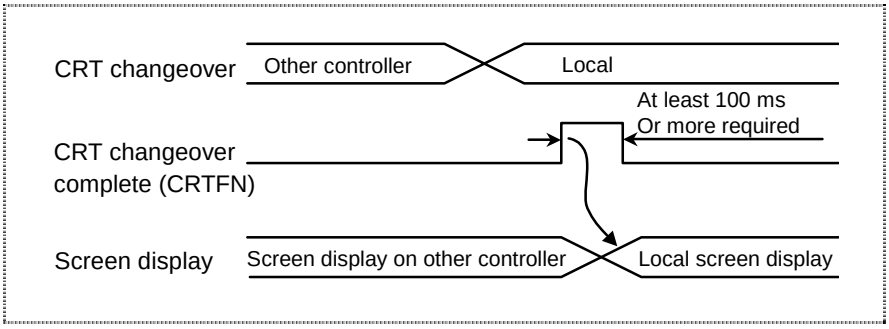
[Function]

When using one setting and display unit for multiple controller display units, this signal is used to inform the controller that it has been changed as a display unit.

[Operation]

When this signal turns ON, the currently selected screen will display at the rising edge. For the setting and display unit screen, the screen on the controller before the changeover will remain, so when this signal is input, the local screen display will be changed to.

[Time chart]



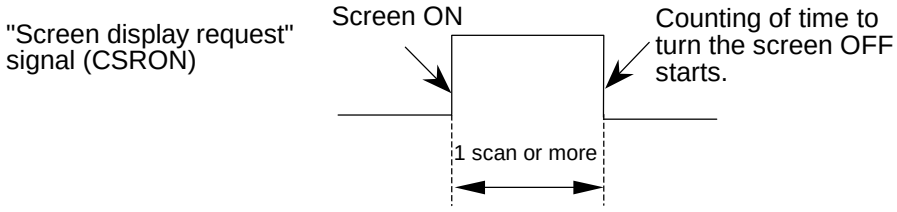
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SCREEN DISPLAY REQUEST	CSRON	P C	Y2F9	W179	Y2F9	Y6B9

[Function]

The screen turned OFF with the screen saver function can be turned ON again.

[Operation]

(1) The screen is turned ON again when this signal turns ON. Counting of the time to turn the screen OFF will start when this signal turns OFF.
(2) If this signal is output to the CNC while the screen is ON, counting of the time to turn the screen OFF will restart.



(Note 1) The screen is not turned OFF with the screen saver time while the "Screen display request" signal is ON, but the screen can be turned OFF using the SHIFT and C.B CAN keys.

(Note 2) If the "Screen display request" signal (Y2F9) is changed again after that has changed once, intervals of 1scan or more must be taken.

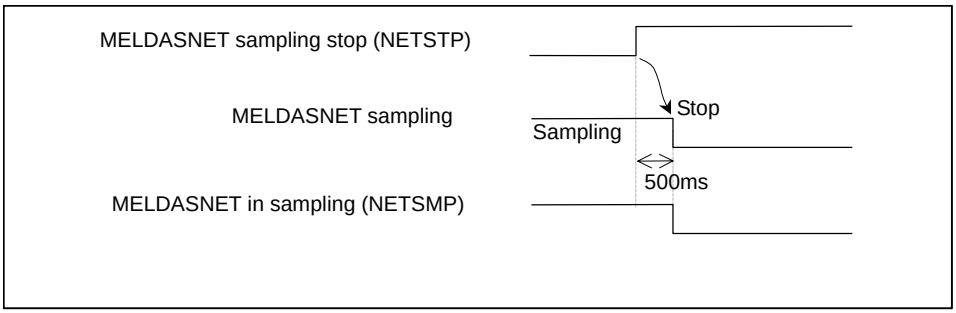
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MELDASNET SAMPLING STOP	NETSTP	P C	Y2FB	W17B	Y2FB	Y6BB

[Function]

When sampling with the MELDASNET function, the sampling will stop when this signal turns ON.

[Operation]

The MELDASNET sampling stop signal (NETSTP) is valid when this signal changes from OFF to ON. When sampling with the MELDASNET function (when the MELDASNET in sampling signal (NETSMP) is ON), the sampling will stop when this signal is turned ON. The sampling will stop approx. 500ms after this signal is turned ON. The sampling will stop, and the MELDASNET in sampling signal(NETSMP) will turn OFF.



(Note 1) If this signal is turned ON at the first scan after the power is turned ON, the sampling will not stop.
Turn this signal OFF and then ON again.

[Related signals]

MELDASNET in sampling (NETSMP: X303)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	DATA SAMPLING TRIGGER	SMPTRG	P C	Y2FC	—	Y2FC	—

[Function]

The start and end of data sampling are controlled.

[Operation]

If PLC device is selected as the conditions (#5, #22) for starting and ending data sampling, the start and end of data sampling will be controlled with this signal (Y2FC). Note that if a random device is designated (#24), the data sampling will start and end by turning the designated device ON and OFF.

The following parameter are set on the NC data sampling screen.

# No.	name	Detail
5	S-CONDITION	When this parameter is set to "2", the condition for starting data sampling is the PLC device ON (OFF when using B contact).
22	E-CONDITION	When this parameter is set to "2", the condition for ending data sampling is the PLC device OFF (ON when using B contact).
24	PLC-DEVICE	When #5 or #22 is set to "2", the device for controlling the start and end of data sampling is set. When this parameter is set to "0", the device for controlling the start and end of data sampling is the data sampling trigger (Y2FC).

(Note) When "#0 SMT START" is set to "0", this signal is invalid.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	PLC SNAPSHOT	MTBT	—	Y2FD	—	Y2FD	—

[Function]

The PLC snapshot data is saved in the CNC memory.
The saved data can be transmitted using the data transmission function of machine builder network system.
For example, if a ladder is created to turn MTBT ON when a PLC alarm occurs, the PLC snapshot data can be retrieved when a PLC alarm occurs.
The machine builder network system specifications are required to use this signal.

[Operation]

The following data is saved as the PLC snapshot data at the rising edge of this signal.

- Bit devices (X device, Y device)
- Registers (R register, D register)
- PLC timer

[Related signals]

This signal is used for the machine builder network system.
Contact the machine manufacturer for details on the machine builder network system.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	DISPLAY CHANGEOVER $1, $2	DISP1, 2	PC	Y2FE, F	—	Y2FE, F	—

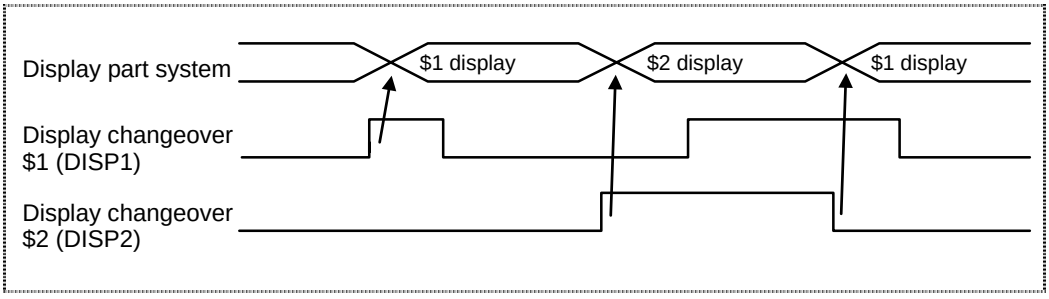
[Function]

The displayed part system of a dual part system can be changed.

[Operation]

The displayed part system is changed at the rising edge of each display changeover signal.
The screen display for a dual part system is a screen for displaying one of the part systems. Thus, which part system to be displayed is determined by these signals.
If both of these signals are started up simultaneously, they will be invalid.

[Time chart]



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ZERO POINT INITIALIZATION SET MODE nTH AXIS	AZS1 to 8	PC	Y300 to 7	W180 to 7	Y300 to 7	Y6C0 to 7

[Function]

This selects the zero point initialization set with the marked point alignment method in the absolute position detection system.

[Operation]

The zero point initialization set is selected with this signal.
Refer to the section on "Zero point initialization set completed" (ZSFn) signal for details on the operations.

(Note 1) This signal is a function signal for zero point initialization set, and is not a signal that selects the operation mode. Select the jog mode or handle mode to move the axis to a required position.

(Note 2) This signal is valid for the following specifications.

- When servo detection specification (motor detector, servo system) is the absolute position detection system.
- When "TYPE" on the [ABS. POSI PARAM] screen is set to "2".

[Related signals]

(1) Zero point initialization set completed (ZSFn : X280 to 7)
(2) Zero point initialization set error completed (ZSEn : X288 to F)
(3) In initialization (R62)
(4) Initialization incomplete (R63)
(5) Zero point initialization set start (ZSTn : Y308 to F)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ZERO POINT INITIALIZATION SET START nTH AXIS	ZST1 to 8	PC	Y308 to F	W188 to F	Y308 to F	Y6C8 to F

[Function]

This is used to set a random position as the origin during zero point initialization set using the marked point alignment method in the absolute position detection system.

[Operation]

This signal turns ON when a corresponding axis is moved in the zero point initialization set mode, and the position to be set as the zero point is reached.
Refer to the section on "Zero point initialization set completed" (ZSFn) signal for details on the operations.

(Note 1) This signal is a function signal for zero point initialization set, and is not a signal that selects the operation mode. Select the jog mode or handle mode to move the axis to a required position.

(Note 2) This signal is valid for the following specifications.
- When servo detection specification (motor detector, servo system) is the absolute position detection system.
- When "TYPE" on the [ABS. POSI PARAM] screen is set to "2".

(Note 3) This signal will be invalid in the following states.
- During emergency stop
- During reset
- When the "Zero point initialization set start" (ZSTn) signal is turned ON before the "Zero point initialization set mode" (AZSn) signal. In this case, turn this signal OFF once, and then turn it ON again.
- When the grid (Z-phase signal provided per motor rotation) has not been passed once after the power is turned ON.

[Related signals]

(1) Zero point initialization set completed (ZSFn : X280 to 7)
(2) Zero point initialization set error completed (ZSEn : X288 to F)
(3) In initialization (R62)
(4) Initialization incomplete (R63)
(5) Zero point initialization set mode (AZSn : Y300 to 7)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	LOAD MONITOR TEACHING/ MONITOR EXECUTION	LDWT	P C	Y313	W193	Y313	Y6D3

[Function]
Teaching and monitoring is executed.

[Operation]
The teaching or monitor mode is valid from the point that this signal turns ON during automatic operation.
Whether to carry out teaching or monitoring follows the teaching mode and monitor mode input signal.
The teaching and monitor mode is invalidated at the point this signal turns OFF.

[Caution]
Select the teaching mode or monitor mode before turning this signal ON.
This signal will not be validated if the teaching mode or monitor mode is not selected.

[Related signals]
Load monitor In teaching/monitor execution, Teaching mode valid, Monitor mode valid (X268 to X26A)
Load monitor Warning axis, Alarm axis, Data alarm information (R52 to R54)
Load monitor Teaching mode select, Monitor mode select, Alarm reset, Warning reset (Y314 to Y317)
Load monitor Axis selection, Load change rate detection axis, Teaching data sub-No. (R116 to R118)
Load monitor status (R670 to R679)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	LOAD MONITOR TEACHING MODE SELECT		P C	Y314	W194	Y314	Y6D4

[Function]
The teaching mode is selected.

[Operation]
Turn this signal ON to select the teaching mode.
The teaching mode is actually validated when this signal turns ON and then the teaching/monitor valid signal turns ON.

[Caution]
Do not turn the monitor mode input signal ON when turning this signal ON.

[Related signals]
Load monitor In teaching/monitor execution, Teaching mode valid, Monitor mode valid (X268 to X26A)
Load monitor Warning axis, Alarm axis, Data alarm information (R52 to R54)
Load monitor Teaching/monitor execution, Monitor mode select, Alarm reset, Warning reset (Y313, Y315 toY317)
Load monitor Axis selection, Load change rate detection axis, Teaching data sub-No. (R116 to R118)
Load monitor status (R670 to R679)

B contact	Signal name	Signal abbreviation	PC	1st system	2nd system	1st system	2nd system
—	LOAD MONITOR MONITOR MODE SELECT			Y315	W195	Y315	Y6D5

[Function]

The monitor mode is selected.

[Operation]

Turn this signal ON to select the monitor mode.
The monitor mode is actually validated when this signal turns ON and then the teaching/monitor valid signal turns ON.

[Caution]

Do not turn the teaching mode input signal ON when turning this signal ON.

[Related signals]

Load monitor In teaching/monitor execution, Teaching mode valid, Monitor mode valid (X268 to X26A)
Load monitor Warning axis, Alarm axis, Data alarm information (R52 to R54)
Load monitor Teaching/monitor execution, Teaching mode select, Alarm reset, Warning reset (Y313, Y314, Y316, Y317)
Load monitor Axis selection, Load change rate detection axis, Teaching data sub-No. (R116 to R118)
Load monitor status (R670 to R679)

B contact	Signal name	Signal abbreviation	PC	1st system	2nd system	1st system	2nd system
—	LOAD MONITOR ALARM RESET			Y316	W196	Y316	Y6D6

[Function]

This signal resets the alarm signal.

[Operation]

If this signal is turned ON when the alarm axis and data alarm information bit are ON, each alarm bit will turn OFF.
The warning information is reset simultaneously.

[Caution]

This signal is used to clear the alarm information and does not affect the other operations.

[Related signals]

Load monitor In teaching/monitor execution, Teaching mode valid, Monitor mode valid (X268 to X26A)
Load monitor Warning axis, Alarm axis, Data alarm information (R52 to R54)
Load monitor Teaching/monitor execution, Teaching mode select, Monitor mode select, Warning reset (Y313 to Y315, Y317)
Load monitor Axis selection, Load change rate detection axis, Teaching data sub-No. (R116 to R118)
Load monitor status (R670 to R679)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	LOAD MONITOR WARNING RESET		P C	Y317	W197	Y317	Y6D7

[Function]
The warning signal is reset.

[Operation]
If this signal is turned On when the warning axis information bit is ON, each warning bit will turn OFF.

[Caution]
This signal does not clear the alarm information.

[Related signals]
Load monitor In teaching/monitor execution, Teaching mode valid, Monitor mode valid (X268 to X26A)
Load monitor Warning axis, Alarm axis, Data alarm information (R52 to R54)
Load monitor Teaching/monitor execution, Teaching mode select, Monitor mode select, Alarm reset (Y313 to Y316)
Load monitor Axis selection, Load change rate detection axis, Teaching data sub-No. (R116 to R118)
Load monitor status (R670 to R679)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	EXT. WORKPIECE COORDINATE MEASUREMENT 2ND AXIS		P C	Y329	W1A9	Y329	Y6E9

[Function] (L system)
The Z axis external workpiece coordinate OFFset data can be set by cutting the workpiece face with manual operations and inputting external workpiece coordinate measurement 2nd axis.

[Operation]
(1) Mode selection
Set the mode selection switch to the manual mode ([Handle], [Jog] or [Rapid Traverse]).
(2) Tool measurement mode signal input
Set the tool measurement mode signal to "1".
(3) Main/sub selection
Using the tool presetter sub-side valid signal, select whether to measure the workpiece coordinates on the main spindle side or sub-spindle side.
<Tool presetter sub-side valid signal>
OFF : The compensation No. is retrieved from the main spindle side R registers.
ON : The compensation No. is retrieved from the sub-spindle side R registers.
(Note 1) Hold the state of this signal until the measurement with the selected tool is completed.
(4) Tool selection
Issue the T command with MDI operation, etc., and select the tool.
(Note 1) Set the selected tool compensation No. in the R register.
The set R register differs according to the parameter setting and the state of the tool presetter sub-side valid signal.
(Note 2) Set the "tool length/wear data" for the tool being used beforehand.

Compensation No. R registers

#1098 Tlno.	#1130 set_t	#1218 aux02 bit4	Tool length compensation No.		Tool nose wear compensation No.	
			Main side	Sub-side	Main side	Sub-side
0	0	0/1	R192, R193	R1000, R1001	R192, R193	R1000, R1001
	1	0/1				
1	0	0	R36, R37		R192, R193	R1000, R1001
		1	R194, R195	R1002, R1003	R192, R193	R1000, R1001
	1	0/1	R194, R195	R1002, R1003	R192, R193	R1000, R1001

- When the compensation No. is 0, the compensation amount will be calculated as "0".
- If the compensation No. exceeds the number of specified offset sets, the "Compensation No. illegal" error will occur.
- Whether to use the main side or sub-side is selected with the tool presetter sub-side valid signal. (OFF: Main side, ON: Sub-side)

(5) Cutting the workpiece face
If the workpiece face has not been cut, cut the workpiece face slightly to even it.

(Note 1) Do not move the tool in the detection of Z axis after cutting the workpiece face.

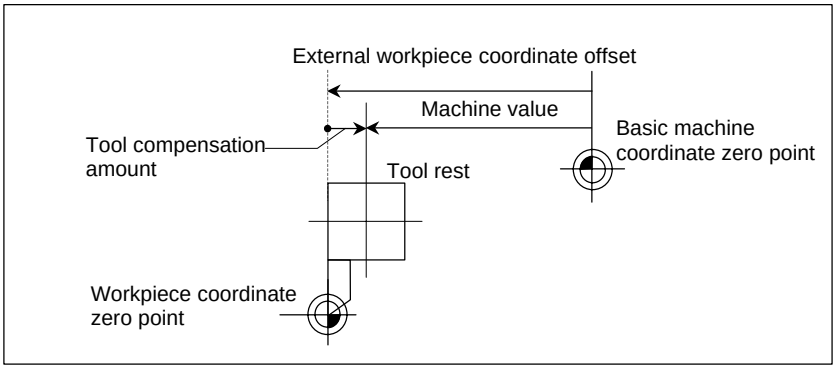
(Note 2) If the workpiece does not need to be cut, carry out positioning to the measurement position.

(6) Setting the Z axis external workpiece coordinate offset data with the external workpiece coordinate measurement 2nd axis signal input
Input the external workpiece coordinate measurement 2nd axis signal (this signal). The Z axis external workpiece coordinate offset data is automatically calculated from the tool compensation data of the used tool and the machine value at the point this signal is input. The results are set as the data.
(a) Details of automatic calculation expression
The external workpiece coordinate offset data is automatically calculated with the following expression.

External workpiece coordinate offset = Machine coordinate value - tool compensation data

The tool compensation data used for the measurement is selected with the base specification parameter "#1226 aux10 bit0".

aux10 bit0	Tool compensation data
0	Tool length data + nose wear data
1	Tool length data



(7) Turning the tool measurement mode signal OFF
Measurement of the external workpiece coordinate offset is completed.

[Related signals]
Tool presetter sub-side valid (Y37A)
Tool compensation No. (Main side: R192-R195, Sub side: R1000-R1003)
Tool measurement mode (TLMS: Y229)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	CONTROL AXIS DETACH 2 n-TH AXIS	DTCH21 to 28	P C	Y330 to 7	W1B0 to 7	Y330 to 7	Y6F0 to 7

[Function]

A control axis can be excluded from the control targets with this function.
This signal is present for each control axis. The end numbers in the signal name indicate the control axis No.

DTCH2n
- 1: The 1st axis is set as axis detach 2.
- :
- :
- 8: The 8th axis is set as axis detach 2.

[Operation]

When the "Control axis detach 2" signal (DTCH2n) turns ON, the corresponding axis is excluded from the control targets.
(1) Position control cannot be carried out, but the position is not lost because the position detection is valid.
(2) The "Interlock" signal of the corresponding axis is considered turned ON.
(3) The corresponding axis also appears in the CRT position display.

[Related signals]

Control axis detach nth axis (DTCHn: Y180)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	UNCLAMP COMPLETE n-TH AXIS		P C	Y338 to F	W1B8 to F	Y338 to F	Y6F8 to F

[Function]

This signal indicates that unclamping has been completed in respect to the unclamp command from the CNC.

[Operation]

When the unclamp command signal turns ON, the clamp on the corresponding axis is released by the PLC, and then this signal turns ON.
When the unclamp command turns OFF, the corresponding axis is clamped by the PLC, and then this signal turns OFF.

[Related signals]

Unclamp command (X2B8 to X2BF)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
*	2ND REFERENCE POSITION RETURN INTERLOCK	ZRIT	PC	Y348	W1C8	Y348	Y708

[Function]

The axis is interlocked at a designated position during manual 2nd reference position return.

[Operation]

During 2nd reference point return while this signal is valid (base specification parameter "#1505 ckref2" is "1"), if this signal turns OFF, movement of axes that have reached the designated position will stop, and an interlock will be applied. Axes that have not reached the designated position will be interlocked after reaching the designated position.

When this signal is ON, the axis movement will not stop, and the 2nd reference position return will continue.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ADAPTIVE CONTROL EXECUTION		PC	Y349	W1C9	Y349	Y709

[Function]

This signal is input to execute adaptive control.

[Operation]

Adaptive control will start if this signal is turned ON during load monitor execution.

[Related signals]

Adaptive control valid (X26B)
Adaptive control override output (R59)
Adaptive control basic axis selection (R119)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	INC HIGH-SPEED RETRACT FUNCTION VALID		PC	Y34C	W1CC	Y34C	Y70C

[Function]

When executing a fixed cycle, the axis will be retracted at a high-speed from the bottom of the hole.

[Operation]

If the fixed cycle program (G81/G82/G83/G73) is executed while this signal is ON, the axis will be retracted at a high-speed from the bottom of the hole.

[Caution]

High-speed retract will not be executed even if this signal is turned ON during the fixed cycle. Always turn the signal ON before the fixed cycle command, and hold the state until the fixed cycle command is completed.

[Related signals]

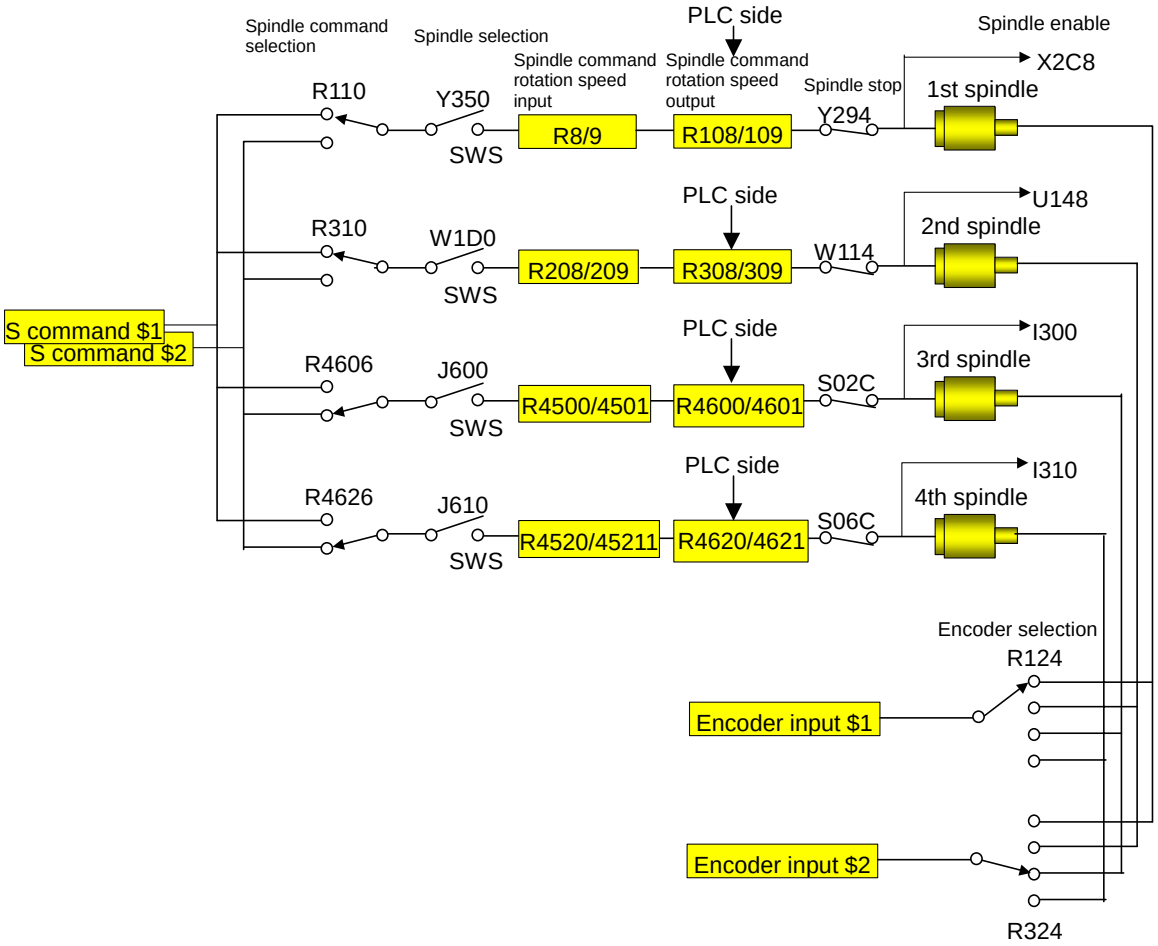
INC High-speed retract function valid state (X2C2)
In INC High-speed retract function operation (X2C3)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE SELECTION	SWS	P C	Y350	W1D0	Y350	Y710

[Function]

The spindle to which the S command for the spindle is output is selected when the multi-spindle control II is valid.
0: Not select
1: Select

[Operation]



The S command for a spindle is output as the rotation speed command to the spindle which has been selected by the "Spindle selection" signal (SWS) ON from the PLC. The selected spindle rotates at the rotation speed which was output. The spindles which were de-selected by the "Spindle selection" signal (SWS) OFF continue to rotate at the same rotation speed as the speed immediately before their de-selection. This allows each spindle to be rotated simultaneously at a different rotation speed. The "Spindle command selection" signal is used to select which of the spindles is to receive the S command from which part system.

[Related signals]

(1) Spindle command selection (SLSP: R110)
(2) Spindle stop (SSTP: Y294)
(3) Spindle enable (ENB: X2C8)
(4) Encoder selection (R124)
(5) Spindle forward run start (SRN: Y2D0)
(6) Spindle reverse run start (SRI: Y2D1)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	PLC COIL CHANGEOVER	MPCSL	P C	Y357	W1D7	Y357	Y717

[Function]

When the coil changeover is the NC internal process, the coil changeover with the PLC signal can be performed with this signal.

[Operation]

If the coil changeover is the NC internal process, the NC internal process selection is interrupted and changed to the selection with the PLC signal when this signal is turned ON.
The coil changeover in the NC internal process and the coil changeover via the PLC are changed over with the parameter #1239 set11/bit0.

0: Via PLC
1: NC internal process

(1) H/L coil changeover

- The L -> H coil changeover is changed over at the same time when the H coil selection is entered.
- The H -> L coil changeover is not changed over during the "Speed detect" signal (VRO) OFF even if the L coil selection is entered.
  The coil changeover is changed over after the "Speed detect" signal (SD) is turned ON.

(2) H/M/L coil changeover

- The L -> M coil changeover is changed over at the same time when the M coil selection is entered.
- The L -> H coil changeover is changed over at the same time when the H coil selection is entered.
- The M -> H coil changeover is changed over at the same time when the M coil selection is entered.
- The H -> M coil changeover is not changed over during the "Speed detect 2" signal (SD2) OFF even if the M coil selection is entered.
  The coil changeover is changed over after the "Speed detect 2" signal (SD2) is turned ON.
- The H -> L coil changeover is not changed over during the "Speed detect" signal (VRO) OFF even if the L coil selection is entered.
  The coil changeover is changed over after the "Speed detect" signal (VRO) is turned ON.
- The M -> L coil changeover is not changed over during the "Speed detect" signal (VRO) OFF even if the L coil selection is entered.
  The coil changeover is changed over after the "Speed detect" signal (VRO) is turned ON.

(Note) This signal must be turned ON after the "L coil selection" (LRSL)/ "M coil selection" (LRSM) signal has been decided. The NC internal changeover process is entered when this signal is turned OFF, so note the spindle rotation speed.

[Related signals]

L coil selection (LRSL: Y2D7)
M coil selection (LRSM: Y2DE)
In L coil selected (LCSA: X247)
In M coil selected (MCSA: X1D6)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	WAITING IGNORE		P C	Y358	W1D8	Y358	Y718

[Function]

This signal is used to designate whether to execute the waiting between part systems by M code or not.

[Operation]

1: The waiting by M code is not executed. The M code to execute waiting commanded during the machining program is ignored.

0: The waiting by M code is executed. If the M code to execute waiting is commanded in one part system, the execution of the next block starts after the same M code is commanded in the other part system.

(Note 1) With the M code for waiting, the code signal and strobe signal are not output differently from the other M code.

(Note 2) The M code during the machining program can be ignored with the "Waiting ignore" signal. The operation is possible only in the single part system without deleting the M code during the machining program.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE-SPINDLE POLYGON CANCEL		—	Y359	W1D9	Y359	Y719

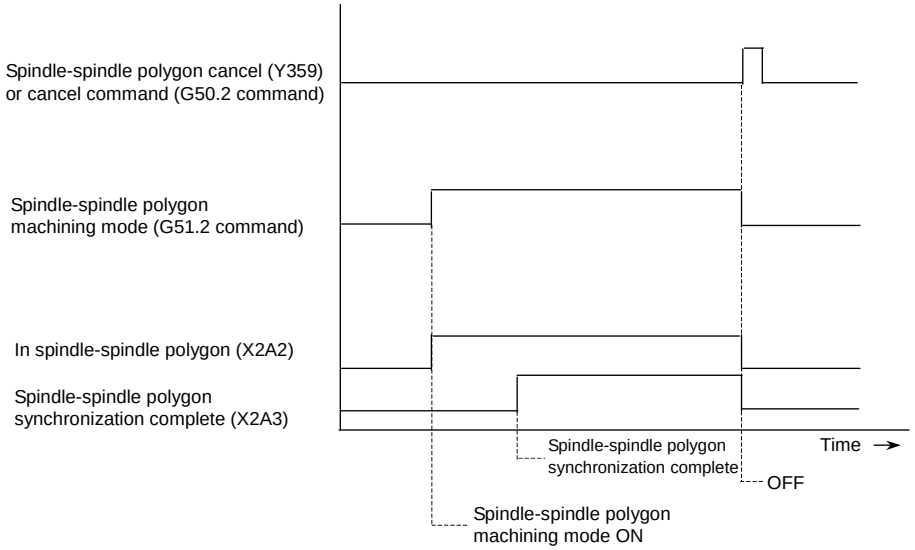
[Function]

Spindle-spindle polygon machining is canceled.

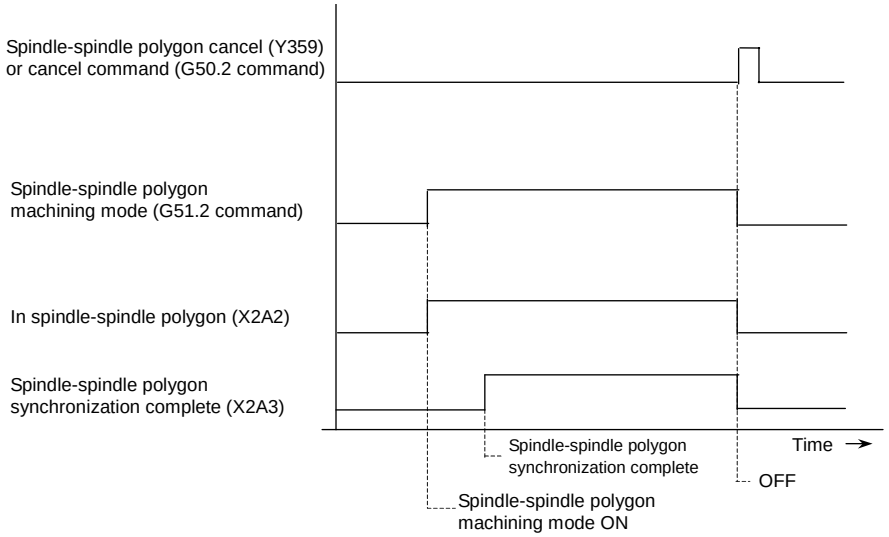
[Operation]

If this signal is input during spindle-spindle polygon, the spindle-spindle polygon machining mode will be canceled.

(1) Spindle-spindle polygon machining (with phase error)



(2) Spindle-spindle polygon machining (with no phase error)



[Related signals]

In polygon mode (spindle-spindle) (X2A2)
Spindle-spindle polygon synchronization complete (X2A3)

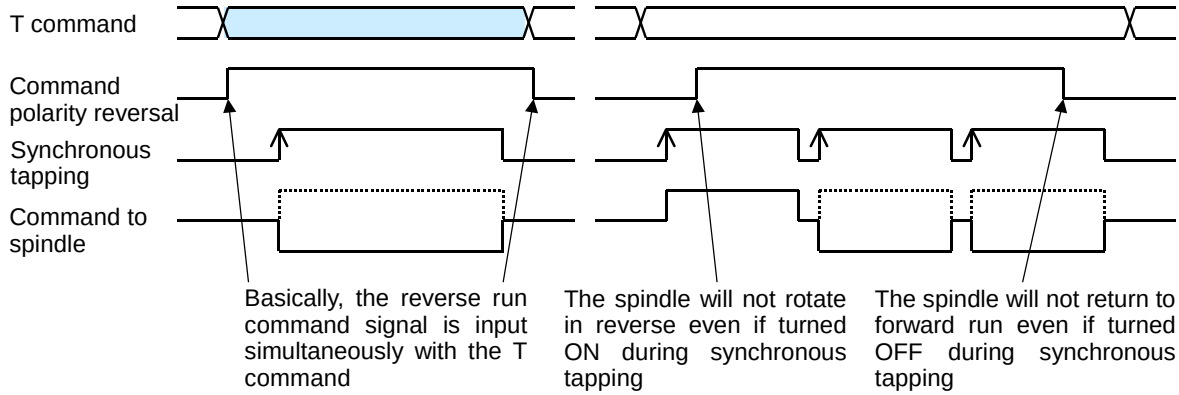
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SYNCHRONOUS TAPPING COMMAND POLARITY REVERSAL		P C	Y35A	W1DA	Y35A	Y71A

[Function]

Designate whether to rotate the spindle in reverse during synchronous tapping.

[Operation]

When the "Synchronous tapping command polarity reversal" signal is ON, the spindle will rotate in reverse during synchronous tapping.



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE OFF MODE		P C	Y35B	W1DB	Y35B	Y71B

[Function]

This function is used to check the program by moving the machine without rotating the spindle.

[Operation]

(1) Synchronized tapping mode
When the spindle OFF mode is turned ON, the spindle will not rotate even if the servo is turned ON.
During the synchronized tapping mode, the operation up to when the synchronized tapping mode turns OFF will not change even if the spindle OFF mode is changed.
This signal should be ON from the start of operation.

(2) Asynchronous tapping mode

(a) During synchronous (per revolution) feed
In addition to M03, M04 processing and dry run signal, turn the spindle OFF mode ON.
The program will advance when the signal is turned ON.

(b) During asynchronous feed (per minute) feed
The program will advance even if the spindle OFF mode is not turned ON.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	CROSS MACHINING CONTROL REQUEST n-TH AXIS		P C	Y360 to 7	W1E0 to 7	Y360 to 7	Y720 to 7

[Function]

The cross machining control is turned ON and OFF with the PLC signal. The axis set in the cross machining control state with each PLC signal is set with the parameter.

[Operations]

(1) Cross machining control command using PLC signals

There are "Cross machining control request" signals (CRS1 to CRS8) for eight axes in each part system. (There are signals for eight axes regardless of the actual number of axes.)

Cross machining is carried out with the axis for which the PLC signal is input and the axis that cross machines with that axis at the rising edge (0 to 1) of this signal. If an axis is not mounted at the section where the PLC signal is input, the axis set in the parameter will be moved from another part system.

The axis cross machining state is canceled at the falling edge (1 to 0) of this signal, and normal control is applied.

(2) Commanding in the machining program

The cross machining control command is issued as the cross machining control command signal with M command or T command, etc.

Command synchronization before the M command and T command, etc., for cross machining control so that the timing for cross machining control matches.

[Related signal]

In cross machining control (X2E0 to 7)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	POSITION SWITCH n INTERLOCK		P C	Y370 to 7	W1F0 to 7	Y370 to 7	Y730 to 7

[Function]

An interlock is applied on the axis when outside the position switch range, and movement of the axis targeted by the position switch is prohibited.

[Operation]

When this signal turns ON and the axis targeted for the corresponding position switch is outside the range, an interlock will be applied on the axis, and movement will be prohibited. Movement is possible within the set range.

- Movement in interlock range

  [For linear axis]

  The axis can move only in the direction toward the position switch range.

  If a command is issued in the direction that moves away from the position switch range, "M01 OPERATION ERROR 0004 *" (* is axis name) will occur.

  [For rotary axis]

  If axis movement is commanded in the interlock state, "M01 OPERATION ERROR 0004 *" (* is axis name) will occur. To move the axis, turn the "Position switch interlock" signal input OFF and cancel the interlock state. Note that even if the axis is moved away from the position switch range in this state, the interlock will not be applied.

- Coasting distance

  The coasting distance when outside the position switch range by axis movement depends on the commanded speed and parameter setting.

[Coasting distance for position switch interlock]

Pcheck	<check>	Coasting distance
0	0	The acceleration/deceleration delay is added to the movement distance within the commanded speed × 0.060 [s] or less.
0	1	Same as the above distance. (When Pcheck is 0, the <check> setting is invalid.)
1	0	Within commanded speed × 0.015 [s] or less (During manual mode, commanded speed × 0.030 [s] or less)
1	1	Acceleration/deceleration delay or position loop gain delay is added to above distance.

[Cautions]

(1) When moving from the set range to outside the range, the coasting distance up to when the axis stops will differ according to the position switch method.

(2) The position switch interlock is invalid for a reference position return incomplete axis (incremental specifications) absolute position initialization incomplete axis and an axis for which absolute position initialization is being carried out.

(3) The position switch range is judged with the machine coordinate system. Thus, the inclined axis is judged with the oblique (actual axis).

If the basic axis moves with a command issued for the inclined axis, the axis interlock will not be applied even if the basic axis moves out of the position switch range. (The interlock is valid only for the commanded axis.)

[Related signal]

Position switch (PSW1 to 7: X270 to 7)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	BARRIER VALID (LEFT)		P C	Y378	W1F8	Y378	Y738

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	BARRIER VALID (RIGHT)		P C	Y379	W1F9	Y379	Y739

[Function]

This signal is used to validate the left (right) barrier range for the chuck•tailstock barrier function.

[Operation]

The chuck/tailstock barrier function's barrier range is validated when this signal turns ON. If the tool nose attempts to enter the range, an error will occur.

Note that to validate the barrier function, this signal must be ON, and the parameter "#8310 Barrier ON" must be set to "1", and "#8315 BARRIER TYPE (L)" ("#8316 BARRIER TYPE (R)") must not be set to "0" on the BARRIER screen. (Excluding when using a special display unit.)

The barrier range validity can also be changed with the G22/G23 command instead of this signal input. In this case, the left and right settings will change simultaneously. (There are some systems with which G22/G23 cannot be commanded because of the selected G code system.)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	DOOR OPEN		P C	Y380	—	Y380	—

[Function]

This signal stops all axes, and cuts OFF contactor power.

[Operation]

The NC carries out the following operations when the "Door open" signal turns ON.

(1) A deceleration stop is carried out for all axes (servo axes and spindles).
(2) A ready OFF state occurs after all axes stop, and the contactor power of each amplifier is cut OFF.
(3) The "Door open enable" signal turns ON.

The NC carries out the following operations when the "Door open" signal turns OFF.

(1) A ready ON and servo ON state occurs for all axes.
(2) The "Door open enable" signal turns OFF.

[Caution]

(1) Handling of the PLC axis
Set so a "Door open" signal is output to the NC after the PLC axis is stopped by the PLC.
If a "Door open" signal is input without stopping the PLC axis, the axis will stop with a dynamic brake method due to the ready OFF state.
The remaining distance will be held in the R register being used in the DDB.

(2) Handling of the analog spindle
When an analog spindle is connected, it is not possible to confirm that the spindle has completely stopped with the NC. Thus, confirm that the spindle has completely stopped using the PLC, before opening the door.
Because the spindle may start rotating again immediately after the door is closed, for safety turn the forward run and reverse run signals OFF when the door is open.

(3) Opening the door during ATC operation
When opening the door during ATC operation, apply an interlock with the user PLC.

[Related signals]

Door open enable (X300)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	DOOR OPEN II		P C	Y381	J581	Y381	YCC1

[Function]

This signal stops all axes, and cuts OFF contactor power.

[Operation]

The NC carries out the following operations when the "Door open II" signal turns ON.

(1) A deceleration stop is carried out for all axes (servo axes and spindles). (Axis interlock)
(2) After all axes stop, the contactor power of each amplifier is cut OFF. The "Servo ready complete" signal (SA) does not turn OFF.
(3) The "Door open enable" signal turns ON.

The NC carries out the following operations when the "Door open II" signal turns OFF.

(1) A ready ON and servo ON state occurs for all axes.
(2) The "Door open enable" signal turns OFF.

[Caution]

(1) Handling of the PLC axis
Set so a "Door open" signal is output to the NC after the PLC axis is stopped by the PLC.
If a "Door open" signal is input without stopping the PLC axis, the axis will stop with a dynamic brake method due to the ready OFF state.
The remaining distance will be held in the R register being used in the DDB.

(2) Handling of the analog spindle
When an analog spindle is connected, it is not possible to confirm that the spindle has completely stopped with the NC. Thus, confirm that the spindle has completely stopped using the PLC, before opening the door.
Because the spindle may start rotating again immediately after the door is closed, for safety turn the forward run and reverse run signals OFF when the door is open.

(3) Opening the door during ATC operation
When opening the door during ATC operation, apply an interlock with the user PLC.

[Related signals]

Door open enable (X300)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	DOOR OPEN SIGNAL INPUT (spindle speed monitor)		P C	Y382	J582	Y382	YCC2

[Function]

This signal informs the door open or close state to the spindle amplifier with the spindle speed monitor function.

[Operation]

"1" is entered in the door open state.
The compatibility check of this signal and the door close signal connected with the spindle amplifier is performed in the spindle amplifier.
If those signals are not compatible for continuous 3 seconds, the servo alarm (5D) will occur.

[Related signals]

Door open enable (X300)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	DOOR INTERLOCK SPINDLE SPEED CLAMP		P C	Y383	J583	Y383	YCC3

[Function]

This signal is used to change the spindle's clamp speed.

[Operation]

When the "Door interlock spindle speed clamp" signal is turned ON, the spindle rotation speed will be limited by the set clamp speed value.

The relation of the "Door interlock spindle speed clamp" signal and the clamp speed parameter in each operation is shown below.

Spindle operation	Clamp speed parameter (spindle parameter)	
	Door interlock spindle speed clamp OFF	Door interlock spindle speed clamp ON
Orientation (multi-point orientation)	#3205 SP005	#3315 SP115
Turret indexing	#3312 SP112	#3211 SP011
Synchronized tapping (zero point return)	#3414 SP214	#3315 SP115
Spindle C axis (C axis zero point return)	#3349 SP149	#3315 SP115

[Cautions]

(1) This signal is valid only when the door interlock spindle clamp speed valid parameter "#1239 set11 BIT5" is set to "1".

(2) The clamp speed parameter setting value validated when the "Door interlock spindle speed clamp" signal is ON must always be set smaller than the original clamp speed setting value (clamp speed valid when signal is OFF). The clamp speed will change when the signal turns ON regardless of the size of the parameter setting values.

(3) Do not change the state of the "Door interlock spindle speed clamp" signal during multi-point indexing. The clamp speed will change if the signal state is changed during operation.

(4) Even if the "Door interlock spindle speed clamp" signal is changed during orientation, during zero point return at synchronized tapping, or during zero point return after changing from the spindle mode to the C axis mode under the spindle/C-axis control function, the clamp speed will not change. The rotation speed is clamped by the clamp speed set with the signal state before each operation is executed.

(5) The target for changing the clamp speed with the "Door interlock spindle speed clamp" signal differs according to the "#1154 pdoor" setting, system configuration and to which channel (SV1/SV2) of the base I/O unit the spindle drive unit is connected. The combinations are shown below.

#1154 pdoor setting value	No. of part systems	Door interlock spindle speed clamp	
		Spindle connected to SV1	Spindle connected to SV2
0	1	Y383	
0	2	Y383	
1	1	Y383	
1	2	Y383	J583

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL ID DATA READ		P C	Y385	—	Y385	—

[Function]
This signal starts reading of the tool information from the tool ID label.

[Operation]
When the rising edge (OFF to ON) of this signal is detected, transmission of data is requested to the tool ID controller. The received data is stored in the area corresponding to the tool No. in the reception data.
The "In tool ID communication" signal (X307) is output when communicating with the tool ID controller.
After the data is received, the received tool No. is stored in the pot No. designated by R438.

[Caution]
This signal will be ignored even if it is turned ON during tool ID communication.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL ID DATA WRITE		P C	Y386	—	Y386	—

[Function]
This signal starts writing of the tool information to the tool ID label.

[Operation]
When the rising edge (OFF to ON) of this signal is detected, the tool information corresponding to the tool No. stored in the pot No. designated by R438 is sent to the tool ID controller.
The "In tool ID communication" signal (X307) is output when communicating with the tool ID controller.

[Caution]
This signal will be ignored even if it is turned ON during tool ID communication.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL ID DATA ERASE		P C	Y387	—	Y387	—

[Function]
This signal erases the tool information stored in the CNC.

[Operation]
When the rising edge (OFF to ON) of this signal is detected, the tool information corresponding to the tool No. stored in the pot No. designated by R438 is erased, and the pot No. tool No. is set to "0".

[Caution]
This signal will be ignored even if it is turned ON during tool ID communication.

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	MAGNETIC BEARING SERVO ON COMMAND		P C	Y388	J588	Y388	YCCA

[Function]
The magnetic bearing is set in the servo ON state.

[Operation]
The bearings are suspended after this signal is input.
To rotate the spindle, turn this signal ON, confirm that the "in magnetic bearing servo ON" signal is ON, and then input the forward run or reverse run signal.

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	MAGNETIC BEARING TOOL UNCLAMP		P C	Y389	J589	Y389	YCCB

[Function]
This signal informs the magnetic bearing drive unit that tool mounted on the spindle is being exchanged.

[Operation]
When exchanging the tool, set the magnetic bearing in the servo OFF state, confirm that the servo is OFF, and then set this signal. Always turn this signal ON before changing the tool information parameters (mb012 to mb016).

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL IC NEW READ		P C	Y390	—	Y390	—

[Function]
The tool information is read from the IC code chip, and registration of the tool starts.

[Operation]
When the rising edge (OFF to ON) of this signal is detected, a data send request is sent to the IC code reader. The received data is stored in the area corresponding to the tool No. in the received data.
The "in tool ID communication" signal (X307) is output while communicating with the IC code reader.
After the data is received, the received tool No. is stored in the pot No. designated in R438.

(Note) This signal will be ignored even if it is turned ON during communication with the IC code reader.

[Related signals]
Tool IC exchange read (Y391)
Tool ID data erase (Y387)
Tool ID R/W pot No. (R483)
In tool ID communication (X307)
Tool ID communication error information (R488)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL IC EXCHANGE READ		P C	Y391	—	Y391	—

[Function]

The tool information is read from the IC code chip, and updating of the tool information starts.

[Operation]

When the rising edge (OFF to ON) of this signal is detected, the tool information is read, and is compared with the tool No. stored in the pot No. If the numbers match, the tool information is updated.
If the numbers do not match, an error is output to R488.
The in tool ID communication (X307) signal is output while communicating with the IC code reader.

(Note) This signal will be ignored even if it is turned ON during communication with the IC code reader.

[Related signals]

Tool IC new read (Y390)
Tool ID data erase (Y387)
Tool ID R/W pot No. (R483)
In tool ID communication (X307)
Tool ID communication error information (R488)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE SYNCHRONOUS CONTROL	SPSY	P C	Y398	—	Y398	—

[Function]

The spindle synchronous control mode is entered by turning this signal ON.

[Operation]

The spindle synchronous control mode is entered by inputting the "Spindle synchronous control" signal (SPSY). During the spindle synchronous control mode, the synchronous spindle is controlled in synchronization with the rotation speed commanded for the basic spindle.
Set the basic spindle, synchronous spindle and rotation direction beforehand.

Device No.	Signal name	Abbrev.	Explanation
R446	Spindle synchronous control Basic spindle select	–	Select a serially connected spindle to be controlled as the basic spindle. (0: 1st spindle), 1: 1st spindle, 2: 2nd spindle, 3: 3rd spindle, 4: 4th spindle **(Note 1)** Spindle synchronization control will not take place if a spindle not connected in serial is selected. **(Note 2)** If "0" is designated, the 1st spindle will be controlled as the basic spindle.
R447	Spindle synchronous control Synchronous spindle select	–	Select a serially connected spindle to be controlled as the synchronous spindle. (0: 2nd spindle), 1: 1st spindle, 2: 2nd spindle, 3: 3rd spindle, 4: 4th spindle **(Note 3)** Spindle synchronization control will not take place if a spindle not connected in serial is selected or if the same spindle as the basic spindle is selected. **(Note 4)** If "0" is designated, the 2nd spindle will be controlled as the synchronous spindle.
Y39A	Spindle synchronous rotation direction	–	Designate the basic spindle and synchronous spindle rotation directions for spindle synchronization control. 0: The synchronous spindle rotates in the same direction as the basic spindle. 1: The synchronous spindle rotates in the reverse direction of the basic spindle.

[Related signals]

In spindle synchronous control (SPSYN1: X308)
Spindle rotation speed synchronization complete (FSPRV: X309)
Spindle synchronous rotation direction (Y39A)
Spindle phase synchronous control (SPPHS: Y399)
Spindle phase synchronization complete (FSPPH: X30A)
Spindle synchronous control Basic spindle select (R446)
Spindle synchronous control Synchronous spindle select (R447)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE PHASE SYNCHRONOUS CONTROL	SPPHS	P C	Y399	—	Y399	—

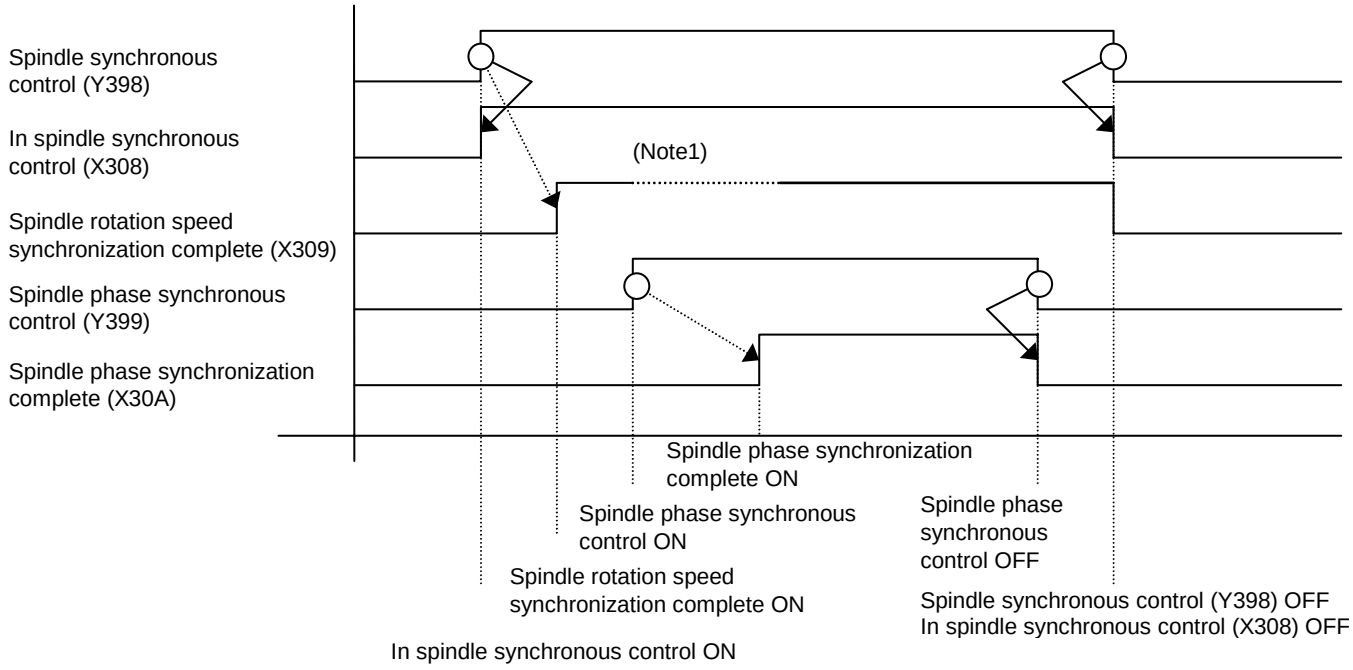
[Function]

Spindle phase synchronization starts this signal is turned ON during the spindle synchronous control mode.

[Operation]

Spindle phase synchronization starts when the "Spindle phase synchronous control" signal (SPPHS) is input during the spindle synchronous control mode. The "Spindle phase synchronization complete" signal is output when the spindle phase synchronization attainment level setting value (#3051 spplv) is reached.

(Note 1) This signal will be ignored even if it is turned ON during a mode other than the spindle synchronous control mode.



(Note 1) This is turned OFF once to change the rotation speed during phase synchronization.

[Related signals]

In spindle synchronous control (SPSYN1: X308)
Spindle rotation speed synchronization complete (FSPRV: X309)
Spindle synchronous control (SPSY: Y398)
Spindle synchronous rotation direction (Y39A)
Spindle phase synchronization complete (FSPPH: X30A)
Spindle synchronization phase shift amount (R448)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE SYNCHRONOUS ROTATION DIRECTION		P C	Y39A	—	Y39A	—

[Function]

The synchronous spindle's rotation direction is designated with this signal. Select whether the direction is the same as or the reverse of the basic spindle.

[Operation]

Designate the rotation direction for the basic spindle and synchronous spindle during spindle synchronous control.
0: Synchronous spindle rotates in same direction as basic spindle.
1: Synchronous spindle rotates in reverse direction of basic spindle.

[Related signals]

In spindle synchronous control (SPSYN1: X308)
Spindle rotation speed synchronization complete (FSPRV: X309)
Spindle synchronous control (SPSY: Y398)
Spindle phase synchronous control (SPPHS: Y399)
Spindle phase synchronization complete (FSPPH: X30A)
Spindle synchronization phase shift amount (R448)

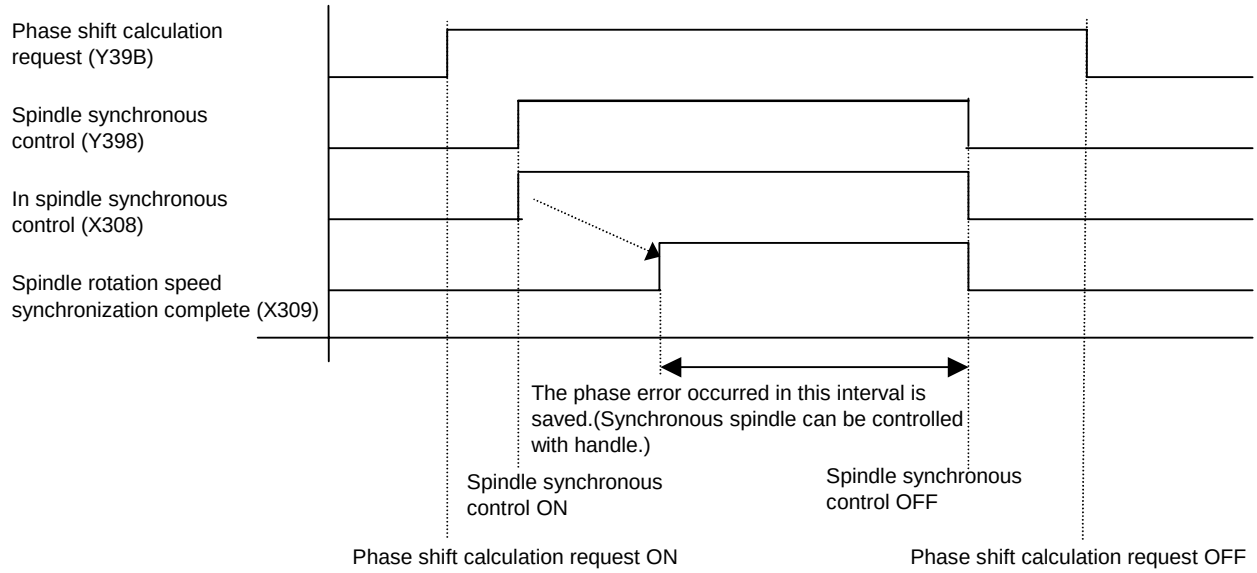
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	PHASE SHIFT CALCULATION REQUEST	SSPHM	P C	Y39B	—	Y39B	—

[Function]

This signal calculates the phase error of the basic spindle during rotation synchronization, and requests that it be saved in the NC memory.

[Operation]

The phase error of the basic spindle and synchronous spindle is saved in the NC memory when this signal is ON and the rotation synchronization command's (with no R address command) spindle synchronization is completed (when "Spindle rotation speed synchronization complete" signal is ON).
This signal turns ON when the spindle rotation is stopped before the rotation synchronization command.



(Note 1) The phase cannot be aligned when calculating the phase shift.
(Note 2) If the handle mode is selected as the manual operation mode, the synchronous spindle cannot be rotated with the handle.

[Related signals]

Phase OFFset request (SSPHF: Y39C)
Spindle synchronous control phase error output (R474)
Spindle synchronous control phase OFFset data (R490)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	PHASE OFFSET REQUEST	SSPHF	P C	Y39C	—	Y39C	—

[Function]

This signal requests that the phase be aligned to the value obtained by adding the value commanded with the phase synchronization command's R address to the phase error of the basic spindle and synchronous spindle saved with the "Phase shift calculation request" signal (Y39B).

[Operation]

If phase synchronization is commanded (with R address command) while this signal is ON, the basic spindle and synchronous spindle phases will be aligned to attain the phase error obtained by adding the value commanded with the R address command to the phase error of the basic spindle and synchronous spindle saved in the NC memory.

[Related signals]

Phase shift calculation request (SSPHM: Y39B)
Spindle synchronous control phase error output (R474)
Spindle synchronous control phase OFFset data (R490)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ERROR TEMPORARY CANCEL	SPDRPO	PC	Y39D	—	Y39D	—

[Function]

This signal cancels the error caused by the speed fluctuation when the chuck is closed.
When the chuck is closed, the speed will fluctuate due to external causes. An error will occur between the basic spindle's position and the synchronous spindle's position due to this speed fluctuation. This signal is used to cancel this error. (If spindle synchronization is attempted when closing the chuck without canceling this error, torsion could occur.)

[Operation]

The error between the basic spindle's position and synchronous spindle's position is saved when this signal changes from OFF to ON. The saved error is canceled and the spindle is synchronized while this signal is ON. (Even if the chuck close signal is OFF, the error will be canceled while the "Error temporary cancel" signal is ON.)

(Note 1) Turn this signal ON after the chucks on both the basic spindle side and synchronous spindle side have closed and grasped the chuck.

(Note 2) Turn this signal OFF when the either the basic spindle side or synchronous spindle side chuck is open.

(Example)

(1) Close the basic spindle side chuck.
(2) Start spindle synchronization (G114.1).
(3) Close the synchronous spindle side chuck.
(The speed will fluctuate due to external causes at this time, and an error will occur.)
(4) Using the "Chuck close confirmation" signal (SPCMP), check that the chucks are closed.
(5) Turn the "Error temporary cancel" signal (SPDRPO) ON, and cancel the error.
(6) Execute machining with spindle synchronous control.
(7) Open the chuck on the synchronous spindle side.
(8) Using the "Chuck close confirmation" signal (SPCMP), check that the chuck is opened.
(9) Turn the "Error temporary cancel" signal (SPDRPO) OFF, and stop the error cancellation.

[Related signals]

In spindle synchronous control (SPSYN1: X308)
Spindle rotation speed synchronization complete (FSPRV: X309)
Spindle phase synchronization complete (FSPPH: X30A)
Chuck close confirmation (SPCMP: X30E)
Chuck close (SPCMPC: Y2E9)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	PLC SKIP 1 to 8		PC	Y3A0 to 7	J5A0 to 7	Y3A0 to 7	YCE0 to 7

[Function]

This is the skip input signal from the PLC.

[Operation]

This can be used for the skip related functions. (G31 skip, tool length measurement, etc.)

[Cautions]

(1) The "PLC skip" signal is output to the skip input (X178 to X17F).
(2) When PLC skip is used, the coasting amount from the skip signal input will be slightly longer than the high speed skip.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SYNCHRONOUS CONTROL REQUEST n-TH AXIS	SYNC1 to 8	P C	Y3A8 to F	J5A8 to F	Y3A8 to F	YCE8 to F

[Function]

Whether to start or cancel synchronous control is selected with a signal corresponding to the synchronous axis.

1 → 0 (falling edge) Synchronous control cancel

0 → 1 (rising edge) Synchronous control start

[Operation]

Synchronous control is started and canceled with the rising edge (OFF to ON) or falling edge (ON to OFF) of the PLC signal (SYNC1 to 8) corresponding to the synchronous axis.

Thus, if synchronous control is canceled by a cause other than the PLC signal turning OFF, such as by emergency stop, and synchronous control is to be started again, turn the PLC signal OFF and then ON again.

The synchronization basic axis corresponding to each synchronous axis is set with the parameter "#2088 bsax_sy".

The movement direction of the synchronous axis in respect to the movement of the synchronous basic axis is determined by the value set for parameter "#2087 syncnt".

When syncnt is 0, moves in the same direction as the basic axis

When syncnt is 1, moves in the opposite direction of the basic axis

[Related signals]

(1) In synchronous/superimposition control (X2E8 to X2EF)

(2) Synchronous control error amount (R1350 to R1377)

[Cautions]

(1) The two axes related to control (synchronous/superimposition control) are both controlled in the smoothing 0 state. Control is started after the axis movement has ended and smoothing zero is established.

(2) Control (synchronous/superimposition control) are affected by the state of the two target part systems. Thus, attention must be paid to the timing between the part systems. Always command synchronization before commanding the control PLC signal.

(3) Control (synchronous/superimposition control) cannot be commanded to an axis in inclined axis control. An operation error will occur if this type of command is issued.

(4) Before control (synchronous/superimposition control) is started, the target axis must have completed reference position return after the power was turned ON, or the absolute position must be established. An operation error will occur if the above state is not established.

(5) A movement command cannot be issued to a synchronous axis during synchronous control. An operation error will occur if movement is commanded.

(6) An axis in synchronous control cannot be commanded as the superimposition control axis. An operation error will occur if this type of command is issued.

(7) A synchronous axis in synchronous control cannot be commanded as the synchronous axis for other synchronous control. An operation error will occur if this type of command is issued. Note that a single axis can be designated as the synchronous basic axis for several synchronous controls.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SUPERIMPOSITION CONTROL REQUEST n-TH AXIS	PILE1 to 8	PC	Y3B0 to 7	J5B0 to 7	Y3B0 to 7	YCF0 to 7

[Function]

Whether to start or cancel superimposition control is selected with a signal corresponding to the superimposing axis.

1 → 0 (falling edge) Superimposition control cancel

0 → 1 (rising edge) Superimposition control start

[Operation]

Superimposition control is started and canceled with the rising edge (OFF to ON) or falling edge (ON to OFF) of the PLC signal (PILE1 to 8) corresponding to the superimposing axis.

Thus, if superimposition control is canceled by a cause other than the PLC signal turning OFF, such as by emergency stop, and superimposition control is to be started again, turn the PLC signal OFF and then ON again.

The superimposing basic axis corresponding to each superimposing axis set with the parameter "#2089 bsax_sy".

The movement direction of the superimposing axis in respect to the movement of the superimposing basic axis is determined by the value set for parameter "#2087 syncnt".

When syncnt is 0, moves in the same direction as the basic axis

When syncnt is 1, moves in the opposite direction of the basic axis

[Related signals]

(1) In synchronous/superimposition control signal (X2E8 to X2EF)

(2) Synchronous control error amount (R1350 to R1377)

[Cautions]

(1) The two axes related to control (synchronous/superimposition control) are both controlled in the smoothing 0 state. Control is started after the axis movement has ended and smoothing zero is established.

(2) Control (synchronous/superimposition control) are affected by the state of the two target part systems. Thus, attention must be paid to the timing between the part systems. Always command synchronization before commanding the control PLC signal.

(3) Control (synchronous/superimposition control) cannot be commanded to an axis in inclined axis control. An operation error will occur if this type of command is issued.

(4) Before control (synchronous/superimposition control) is started, the target axis must have completed reference position return after the power was turned ON, or the absolute position must be established. An operation error will occur if the above state is not established.

(5) An axis in superimposition control cannot be commanded as the synchronous control axis. An operation error will occur if this type of command is issued.

(6) A superimposing axis in superimposition control cannot be commanded as the superimposing axis for other superimposition control. An operation error will occur if this type of command is issued. Note that a single axis can be designated as the superimposing basic axis for several superimposition controls.

6.4 PLC Output Signals (Data Type: R***)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ANALOG OUTPUT	AOn	P C	R100 to 3	—	R100 to 3	—

[Function]

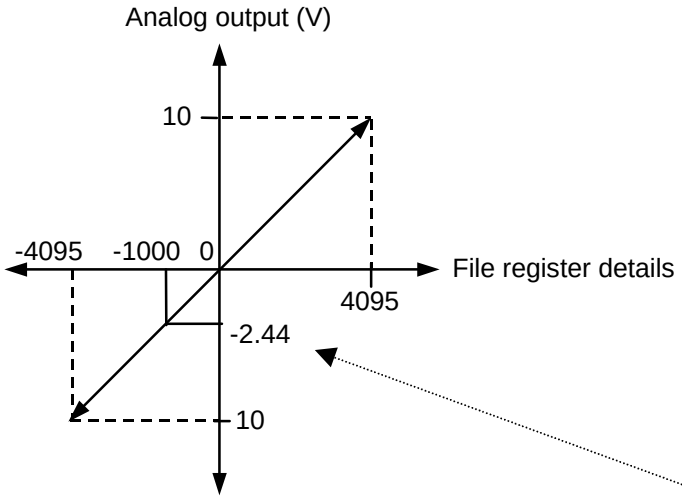
An analog voltage can be output from the designated connector pins (see below) on the remote I/O unit DX120 by setting designated data in the file registers.

[Operation]

"Analog voltage" signal (for speed control) can be output by setting signed binary data to the corresponding file register.
The analog output interface is explained below.

Channel	File register (R)	Remote I/O unit DX120 output destination
A01	R100	Channel setting switch is set to 1st card B04, A04 (Common)
A02	R101	Channel setting switch is set to 3rd card B04, A04 (Common)
A03	R102	Channel setting switch is set to 5th card B04, A04 (Common)
A04	R103	Channel setting switch is set to 7th card B04, A04 (Common)

<Relation of file register details and analog output voltage>



Output voltage : -10V to +10V (±5%)
Resolution : 2^{12} (1/4095) x Fullscal
Load conditions : 10kohm resistance load (standard)
Output impedance: 220ohm

Output voltage = $\frac{-1000}{4095}$ x 10V = -2.44V

The output voltage is

<Relation of file register details and output voltage>

Rn n = 100 to 103															
2^{15}	2^{14}	2^{13}	2^{12}	2^{11}	2^{10}	2^{9}	2^{8}	2^{7}	2^{6}	2^{5}	2^{4}	2^{3}	2^{2}	2^{1}	2^{0}
1	1	1	1	1	1	0	0	0	0	0	1	1	0	0	0

When -1000
(FC18 with hexadecimal)

The data is input as binary coded data.

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE COMMAND ROTATION SPEED OUTPUT		P C	R108, 9	R308, 9	R108, 9	R308, 9

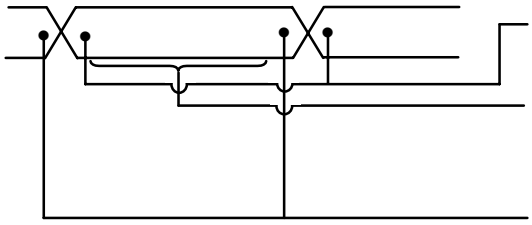
[Function]

By setting data of desired spindle speed to this signal, the spindle can be run at that speed.

[Operation]

When this signal is used, operation is same as the case where usual spindle command rotation speed input signal (R8, 9) is given. Difference is that when data is set by user PLC, priority is given to that data over spindle (S) command data specified in automatic operation, or by manual command setting.

User PLC main (medium-speed) operation pattern



(1) "Spindle command rotation speed input data" is set to the "output data" at the head of user PLC main program (controller process).
(2) "Spindle command rotation speed output data" can be rewritten by user PLC within this interval if necessary (PLC process).
(3) "Spindle command rotation speed output data" is processed at the end of user PLC and signal is given to spindle controller (controller process).

(Note 1) "Spindle command rotation speed output data" is rewritten by user PLC for each scan (constant).
(Note 2) "Spindle speed override", "Spindle gear select input (GI1, GI2)", "Spindle stop (SSTP)", "Spindle gear shift (SSFT)" and "Oriented spindle speed command (SORC)" conditions are added to "Spindle command rotation speed output data" and sent to the spindle controller.
(Note 3) For flow of spindle (S) function command data, data update timing, etc., refer to the section for normal "Spindle command rotation speed input" signal (R8, 9).

[Related signals]

(1) Spindle command rotation speed input (R8, 9)
(2) Spindle command final data (R10 to 13)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	SPINDLE COMMAND SELECTION	SLSP	P C	R110	R310	R110	R310

[Function]

Set which the part system the S command is output from when the multiple-spindle control II is valid.

0: 1st part system

1: 2nd part system

(Note) If a setting value exceeds the maximum number of part systems determined by specifications, it will be interpreted that a selection has not been made.

[Operation]

The S command for a spindle is output as the rotation speed command to the spindle which has been selected by the "Spindle selection" signal (SWS) ON from the PLC. The selected spindle rotates at the rotation speed which was output. The spindles which were de-selected by the "Spindle selection" signal (SWS) OFF continue to rotate at the same rotation speed as the speed immediately before their de-selection. This allows each spindle to be rotated simultaneously at a different rotation speed. The "Spindle command selection" signal is used to select which of the spindles is to receive the S command from which part system.

[Related signals]

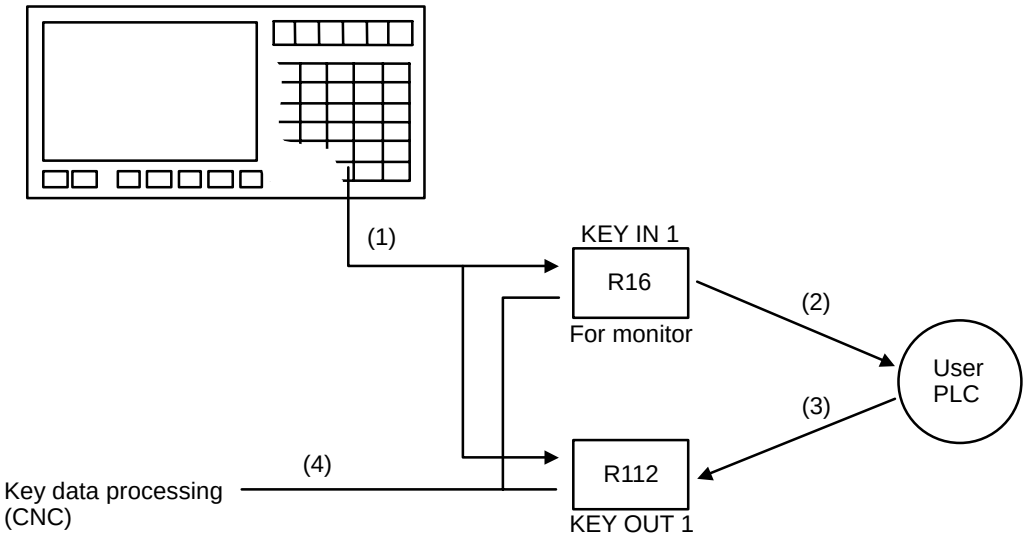
(1) Spindle selection (SWS: Y350)
(2) Spindle stop (SSTP: Y294)
(3) Spindle enable (ENB: X2C8)
(4) Encoder selection (R124)
(5) Spindle forward run start (SRN: Y2D0)
(6) Spindle reverse run start (SRI: Y2D1)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	KEY OUT 1		P C	R112	—	R112	—

[Function]

When this signal is used, key data can be entered on the user PLC side instead of the CNC keyboard.

[Operation]



(1) Key data is set to file registers R16 and R112 at the head of user PLC main program.
(2) The user PLC refers to the key data, and performs required processing.
(3) The user PLC sets the key data which meets the keyboard currently in use to register R112.
(4) The controller processes the effective key data after the main program of user PLC has been processed, referring to the settings of R16 and R112.

(Note 1) For details of key data and processing timing, refer to the Instruction Manual for "PLC programming" ("key operation using user PLC").

[Related signals]

(1) KEY IN 1 (R16)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	LOAD MONITOR AXIS SELECTION		P C	R116	R316	R116	R316

[Function]

The axis for teaching and monitor operations is designated.

[Operation]

The axis for teaching and monitor operations is designated with bit correspondence.
Teaching and monitor operations are carried out to all axes designated with this signal.

S	T												X	Y

* S indicates the 1st spindle and T indicates the 2nd spindle.

[Related signals]

Load monitor In teaching/monitor execution, Teaching mode valid, Monitor mode valid (X268 to X26A)
Load monitor Warning axis, Alarm axis, Data alarm information (R52 to R54)
Load monitor Teaching/monitor execution, Teaching mode select, Monitor mode select, Alarm reset, Warning reset (Y313 to Y317)
Load monitor Load change rate detection axis, Teaching data sub-No. (R117, R118)
Load monitor status (R670 to R679)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	LOAD MONITOR LOAD CHANGE RATE DETECTION AXIS		P C	R117	R317	R117	R317

[Function]

The axis targeted for the change rate detection is designated.

[Operation]

With bit correspondence, designate the axis for detecting the change rate when judging the start of actual cutting during teaching and monitor operation.
If a change rate is detected for even one of the axes designated with this signal, it will be judged that actual cutting has started.

S	T												X	Y

* S indicates the 1st spindle and T indicates the 2nd spindle.

[Related signals]

Load monitor In teaching/monitor execution, Teaching mode valid, Monitor mode valid (X268 to X26A)
Load monitor Warning axis, Alarm axis, Data alarm information (R52 to R54)
Load monitor Teaching/monitor execution, Teaching mode select, Monitor mode select, Alarm reset, Warning reset (Y313 to Y317)
Load monitor Axis selection, Teaching data sub-No. (R116, R118)
Load monitor status (R670 to R679)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	LOAD MONITOR TEACHING DATA SUB-NO.		P C	R118	R318	R118	R318

[Function]

The sub-No. for teaching and monitor operation is designated.

[Operation]

Designate the sub-No. of the data registered with teaching operation, and the sub-No. of data used for the monitor operation.

[Related signals]

Load monitor In teaching/monitor execution, Teaching mode valid, Monitor mode valid (X268 to X26A)
Load monitor Warning axis, Alarm axis, Data alarm information (R52 to R54)
Load monitor Teaching/monitor execution, Teaching mode select, Monitor mode select, Alarm reset, Warning reset (Y313 to Y317)
Load monitor Axis selection, Load change rate detection axis (R116, R117)
Load monitor status (R670 to R679)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ADAPTIVE CONTROL BASIC AXIS SELECTION		P C	R119	R319	R119	R319

[Function]

The basic axis for adaptive control is designated.

[Operation]

Designate which of the actual load's detection axes is targeted for adaptive control.
Only one of the monitor target axes is designated.

S	T												X	Y

* S indicates the 1st spindle and T indicates the 2nd spindle.

[Related signals]

Adaptive control valid (X28B)
Adaptive control execution (Y349)
Adaptive control override (R59)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	EACH AXIS REFERENCE POSITION SELECT		P C	R120	R320	R120	R320

[Function]

Select the each axis reference position return position for manual reference position return.

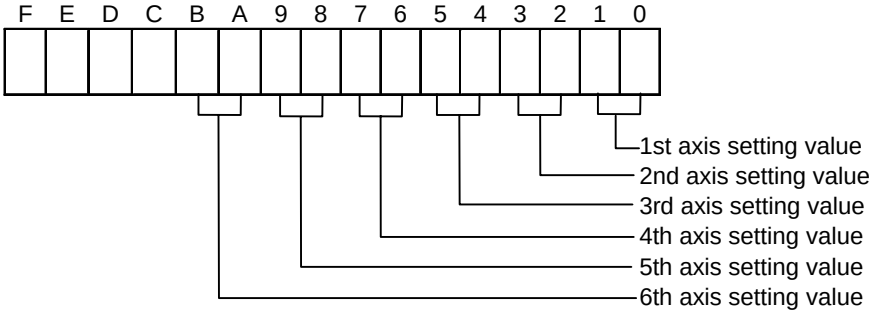
[Operation]

(1) This signal is valid when the reference position select method (Y207/W87) is ON.

(2) Two bits are used for each axis to select the reference position.

(a) R register and corresponding axis

R120 (R320)



(b) Setting value and reference position No.

High-order bit	Low-order bit	Return position
0	0	1st reference position
0	1	2nd reference position
1	0	3rd reference position
1	1	4th reference position

[Related signals]

Reference position select method (Y207)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ENCODER SELECTION		P C	R124	R324	R124	R324

[Function]

Using a binary setting, select which spindle's encoder feedback to use.

0: 1st spindle
1: 2nd spindle
2: 3rd spindle
3: 4th spindle

(Note) If a setting exceeds the number of connected spindles, it will be interpreted that a selection has not been made.

[Related signals]

(1) Spindle selection (SWS: X350)
(2) Spindle command selection (SLSP: R110)
(3) Spindle stop (SSTP: Y294)
(4) Spindle enable (ENB: X2C8)
(5) Spindle forward run start (SRN: Y2D0)
(6) Spindle reverse run start (SRI: Y2D1)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	C AXIS SELECTION		P C	R125	R325	R125	R325

[Function]

The "C axis selection" signal is used to issue the commands with the axis name command address to the axis selected from the Spindle/C-axis having the same axis name in the part system.

[Operation]

Using the axis number, set which spindle or C axis to output the commands to.
0: First C axis, 1: 1st axis, 2: 2nd axis, 3: 3rd axis, 4: 4th axis, ... 8: 8th axis
The setting is made with the axis number used in the part system.

(Note 1) This signal must always be input simultaneously with the "Recalculation request" signal (CRQ).
(Note 2) This signal is valid even when the multi-spindle function is invalid.
(Note 3) If an axis name (#1013 axname) is different from the initial C axis name, "M01 OPERATION ERROR 1031" will occur.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	PLC INTERRUPT PROGRAM NO.		P C	R130	R330	R130	R330

[Function]

Designate the program No. for PLC interrupt.
The interrupt program No. is 9000 to 9999.

[Operation]

Input the number of the program to be ecuted at PLC interrupt.

(Example) When program No. 9705 is to be executed at PLC interrupt

(1) Set the PLC interrupt program No. to 9705.
(2) Turn PLC interrupt signal ON.

The PLC interrupt program 9705 will be executed with the above settings.

[Related signals]

PLC interrupt (PIT: Y236)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	1ST CUTTING FEEDRATE OVERRIDE (File register method)		P C	R132	R332	R132	R332

[Function]

When "Cutting feedrate override method select" (FVS) is set to "file register method", override (0 to 300%, 1% increment) can be exerted on the cutting feedrate. Desired value is set to file register (R) in binary code.

[Operation]

When override is exerted to the preset feedrate, the true feedrate is the product obtained by multiplying the preset feedrate by the specified override ratio (provided that "2nd cutting feedrate override" is not valid).

The override ratio is fixed to 100%, irrespective of "1st feedrate override" setting, under the following condition:

(1) "Override cancel" (OVC) signal is ON.
(2) During tapping in fixede.
(3) During TAPPING mode.
(4) During thread cutting.

(Note) Only when override setting is 0%, override is exerted even on rapid traverse speed in automatic operation. That is, cutting feed as well as rapid traverse stop if the 1st feedrate override is set to 0% during automatic operation. When override setting is 0%, "M01 OPERATION ERROR" appears in the alarm display section of setting and display unit, and "M01 OPERATION ERROR 0102" in the ALARM DIAGNOSIS display.

[Related signals]

(1) Cutting feedrate override (*FV1 to 16: Y2A0)
(2) Cutting feedrate override method select (FVS: Y2A7)
(3) 2nd cutting feedrate override valid (FV2E: Y2A6)
(4) 2nd cutting feedrate override (R133) (File register method)

} For relationship among these signals, refer to the description the cutting feedrate override.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	2ND CUTTING FEEDRATE OVERRIDE (File register method)		P C	R133	R333	R133	R333

[Function]

When the "2nd cutting feedrate override valid" function (FV2E) is used, another override can be exerted on cutting feedrate overrided by "Feedrate override" (*FV1 to 16) in code method, or by "1st cutting feedrate override" when the "Cutting feedrate override method select" (FVS) is set to file register method. The 2nd feedrate override can be set within range from 0% to 327.67% with 0.01% increment. Value of override ratio is set in binary code system to file register.

[Operation]

When this override function is used, the true feedrate is the product obtained by multiplying commanded feedrate (F) by "1st cutting feedrate override" ratio and "2nd cutting feedrate override" ratio.
Since the least increment of 2nd feedrate override is 0.01%, override setting "10000" corresponds to 100%.
The override ratio is fixed to 100%, irrespective of "1st cutting feedrate override" or "2nd cutting feedrate override" setting, under the following condition:

(1) "Override cancel" (OVC) signal is ON.
(2) During tapping in fixed cycle.
(3) During TAPPING mode.
(4) During thread cutting.

(Note) Only when the 1st cutting feedrate override or 2nd cutting feedrate override is 0% or both of them are 0%, override is exerted even on rapid traverse speed in automatic operation. That is, cutting feed as well as rapid traverse stop if the 1st override feedrate is set to 0% during automatic operation. When override setting is 0%, "M01 OPERATION ERROR" appears in the alarm display section of setting and display unit, and "M01 OPERATION ERROR 0102" in the ALARM DIAGNOSIS display.

[Related signals]

(1) Cutting feedrate override (*FV1 to 16: Y2A0)
(2) Cutting feedrate override method select (FVS: Y2A7)
(3) 2nd cutting feedrate override valid (FV2E: Y2A6)
(4) 1st cutting feedrate override (R132) (File register method)

} For relationship among these signals, refer to the description about the cutting feedrate override.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	RAPID TRAVERSE OVERRIDE (File register method)		PC	R134	R334	R134	R334

[Function]

When "Rapid traverse speed override method select" signal (ROVS) is set to "file register method", override can be exerted, besides the code method override (ROV1, ROV2), by setting within the range of 0% to 100% by 1% increments. The value is set in the file register (R) in binary.

[Operation]

During rapid traverse in the automatic or manual operation, the actual feedrate will be the result of multiplying the rapid traverse speed set in a parameter by this override ratio.

(Note 1) The override will be clamped at 100%.
(Note 2) The "M01 operation error 0102" will occur if the override value is 0%.

[Related signals]

(1) Rapid traverse speed override (code method) (ROV1, ROV2: Y2A8, Y2A9)
(2) Rapid traverse speed override method select (ROVS: Y2AF)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	CHOPPING OVERRIDE	CHPOV	PC	R135	R335	R135	R335

[Function]

The chopping override can be set as a value between 0 and 100% (1% unit).
The value is set directly in the R register for chopping override. (This cannot be set with a code method.)
The data is set in R135.

[Operation]

(1) Only the chopping override is valid for the chopping operation.
When rapid traverse override valid is commanded with the DDB function command, the rapid traverse override can be validated for rapid traverse between the basic position and upper dead center point.
The rapid traverse override can be set with either the code method (1, 25, 50, 100%) or the file register (value setting) method (0 to 100%, 1% increment).
(2) The chopping override is set between 0 and 100% with a 1% increment.
If a value exceeding 0 to 100% is set, the override will be clamped at 100%.
(3) The chopping override is set as binary word data in the R register.
Set the data with one command.
(4) If the "Chopping override" signal is set to "0", "M01 OPERATION ERROR 0150" will occur.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL FEEDRATE (File register method)		P C	R136, 7	R336, 7	R136, 7	R336, 7

[Function]

When "Manual feedrate method select" signal (JVS) is set to "file register method", feedrate can be specified, besides code method (*JV1 to 16) setting, by setting desired feedrate ratio manually. The value is set in file register (R).

[Operation]

This mode of feedrate setting can be used in JOG feed, incremental feed, reference position return feed and manual random feed mode. For JOG, incremental and reference position return mode, "Rapid traverse speed" (RT) signal should be OFF. For manual random feed mode, "EX.F/MODAL.F" signal (CXS3) should be OFF. Feedrate specified in this mode can be applied to feed motion in dry run (automatic operation).

The use of this signal is conditioned as follows:

(1) When "Manual feedrate override valid" signal (OVSL) is OFF, the originally set feedrate is applied.
(2) When "Manual feedrate override valid" signal (OVSL) is ON, the feedrate override ratios of "1st cutting feedrate override" and "2nd cutting feedrate override" are applied to the originally set feedrate.
(3) Manual feedrate is set to file registers Rn and Rn+1. The feedrate depends on "Feedrate least increment" (PCF1, PCF2) as listed below.

PCF2	PCF1	Least increment (mm/min or inch/min)	Operation
0	0	10	10mm/min (inch/min) when "1" is set in file registers.
0	1	1	1mm/min (inch/min) when "1" is set in file registers.
1	0	0.1	0.1mm/min (inch/min) when "1" is set in file registers.
1	1	0.01	0.01mm/min (inch/min) when "1" is set in file registers.

(4) Feedrate clamp (max. feedrate) depends on setting of axis parameter (cutting feedrate clamp) when "Rapid traverse" signal (RT) is OFF.

(Note 1) During incremental feed mode, the true feedrate does not change even when the manual feedrate setting is changed while feed motion is going on.

(Note 2) As for file registers (Rn and Rn+1), Rn is of lower order.
Of the file registers Rn and Rn+1 to designate the feedrate, if the value is 2-bytes (one word), the high-order side does not need to do anything.

[Related signals]

(1) Manual feedrate (code method) (*JV1 to 16: Y2B0 to Y2B4)
(2) Manual feedrate method select (JVS: Y2B7)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL FEEDRATE B		P C	R138, 9	R338, 9	R138, 9	R338, 9

[Function] [Operation]

Designate the manual feedrate for the axis selected with the manual feedrate B valid signal.

[Caution]

(1) The speed designated with this register is valid for the manual feedrate of an axis for which the manual feedrate B valid signal is valid.
(2) Cutting override and manual override are invalid for this register's speed.
(3) This register is not related to the dry run speed.
(4) A binary value is directly set for this register. The setting unit is 0.01mm/min (°/min).
(5) This signal is a register common for all axes.

[Related signals]

Manual feedrate B valid (Y260 to 267)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	HANDLE/INCREMENTAL FEED MULTIPLICATION (File register method)		P C	R140, 1	R340, 1	R140, 1	R340, 1

[Function]

When "Handle/Incremental feed multiplication method select" (MPS) signal is set to "file register method", amount of feed per pulse or per command signal can be multiplied by value set to file register. Multiplication value (multiplier), binary code, is set in file register (R).

[Operation]

Multiplication is applied to amount of feed per pulse in handle feed mode (output from manual pulse generator), or to amount of feed per signal in incremental feed mode (+J1, –J1, etc.).
When multiplier is "500" and one pulse is given in handle feed mode, for example, 500µm of feed motion occurs. When multiplier is "30000" and one feed command signal is given in incremental feed mode, 30mm of feed motion occurs (time constant for feed motion is equal to time constant for rapid traverse or step).

(Note 1) Change of multiplication setting during feed motion is ignored.
(Note 2) Since considerably large multiplication can be used, the signal should be used carefully.

[Related signals]

(1) Handle/Incremental feed multiplication (code method) (MP1, MP2, MP4: Y2C0, Y2C1, Y2C2)
(2) Handle/Incremental feed multiplication method select (MPS: Y2C7)

B contact	Signal name	Signal abbreviation	PC	1st system	2nd system	1st system	2nd system
—	MANUAL RANDOM FEED 1ST AXIS MOVEMENT DATA			R142, 3	R342, 3	R142, 3	R342, 3

[Function]

This data specifies the amount of movement or positioning point in manual random feed mode.

[Operation]

"Manual random feed 1st axis movement data" is for the axis whose number is specified by "Manual random feed 1st axis No." (CX11 to 116: Y268 to Y26C).

"Manual random feed 1st axis movement data" means differently depending on the statuses of the "MC/WK (CXS5)" and "ABS/INC (CXS6)" signals.

(1) When the ABS/INC (CXS6) signal is ON:
"Manual random feed 1st axis movement data" specifies the amount of movement (increment).

(2) When the "ABS/INC (CXS6)" signal is OFF, it depends on the status of the "MC/WK (CXS5)" signal as follows:

(a) When the "MC/WK (CXS5)" signal is OFF:
"Manual random feed 1st axis movement data" specifies a coordinate value (positioning point) of the machine coordinate system.

(b) When the "MC/WK (CXS5)" signal is ON:
"Manual random feed 1st axis movement data" specifies a coordinate value (positioning point) of the modal workpiece coordinate system.

"Manual random feed 1st axis movement data" is written in binary notation with a sign. The unit of the specified value matches that of data entered.

Ex.: When (R143, R142)=1 is specified in micrometer system, axis motion is 1µm (at incremental specification).

[Caution]

"Manual random feed 1st axis movement data" forms a data item by R142 and R143 or R342 and R343. Handle negative data carefully.

[Related signals]

For related signals, see the descriptions on "Manual random feed mode (PTP: Y20B)".

B contact	Signal name	Signal abbreviation	PC	1st system	2nd system	1st system	2nd system
—	MANUAL RANDOM FEED 2ND AXIS MOVEMENT DATA			R144, 5	R344, 5	R144, 5	R344, 5

[Function] [Operation]

"Manual random feed 2nd axis movement data" is for the axis whose number is specified by "Manual random feed 2nd axis No. (CX21 to CX216)".

The other conditions are the same as for "Manual random feed 1st axis movement data" explained in the previous section.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	MANUAL RANDOM FEED 3RD AXIS MOVEMENT DATA		P C	R146, 7	R346, 7	R146, 7	R346, 7

[Function] [Operation]

"Manual random feed 3rd axis movement data" is for the axis whose number is specified by "Manual random feed 3rd axis No. (CX31 to CX316)."
The other conditions are the same as for "Manual random feed 1st axis movement data" explained in the previous section.

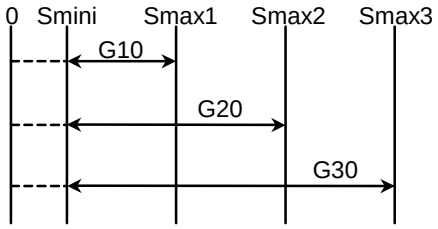
B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	S ANALOG OVERRIDE (File register method)		P C	R148	R348	R148	R348

[Function]

When "Spindle override method select" signal (SPS) is set to "file register method", override can be exerted on the spindle rotation speed besides the code method override (SP1 to SP4). Override can be exerted within range of 0% to 200% (1% increment). Value is set in binary code to file register (R).

[Operation]

When this function is used, the true spindle speed is obtained by multiplying the originally set spindle speed by override ratio set with this signal.
Clamp spindle speed is the maximum or minimum speed set with parameters, which depends on "Spindle gear select" signal (GI1, GI2).
Even when spindle speed exceeds the maximum or minimum speed at the currently selected gear stage, due to change of override setting, "Spindle gear shift" signal (GR1, GR2) does not automatically change.



Applicable override range at gear stage 3

GR10 : Applicable override range at gear stage
GR20 : Applicable override range at gear stage
GR30 : Applicable override range at gear stage
Smini : Minimum spindle speed (parameter)
Smax1 : Maximum spindle speed at gear stage 1 (parameter)
Smax2 : Maximum spindle speed at gear stage 2 (parameter)
Smax3 : Maximum spindle speed at gear stage 3 (parameter)

(Note) Override is not valid (100%) under the following condition:
(1) "Spindle stop" signal (SSTP) is ON.
(2) During tapping mode.
(3) During thread cutting.

[Related signals]

(1) S analog override (SPn: Y288)
(2) Spindle override method select (SPS: Y28F)
(3) Spindle gear select (GI1, GI2: Y290, Y291)
(4) Spindle stop (SSTP: Y294)
(5) Spindle gear shift (SSFT: Y295)
(6) Oriented spindle speed command (SORC: Y296)

B contact	Signal name	Signal abbreviation		1st spindle	2nd spindle	1st spindle	2nd spindle
—	MULTI-POINT ORIENTATION POSITION DATA		P C	R149	R349	R149	R349

[Function]

This signal, having the following three functions, is issued in respect to the high-speed serial connection specification spindle controller (spindle drive).

(1) Notification of orientation position to control unit (spindle controller) at orientation command.
Position data where the "Spindle orient command" (ORC: Y2D6) is turned ON.

(2) During multi-point indexing, notification of indexing position during forward run indexing or reverse run indexing to control unit (spindle controller).
Position data where the "Spindle forward run index" (WRN: Y2D4), the "Spindle reverse run index" (WR1: Y2D5) is turned ON.

(3) During turret control (turret indexing), notification of indexing position during forward run indexing or reverse run indexing to control unit (spindle controller).
Position data where the "Spindle forward run index" (WRN: Y2D4), the "Spindle reverse run index" (WR1: Y2D5) is turned ON.
The multi-point indexing or turret indexing mode is changed with the spindle parameter (SP097).

[Operation]

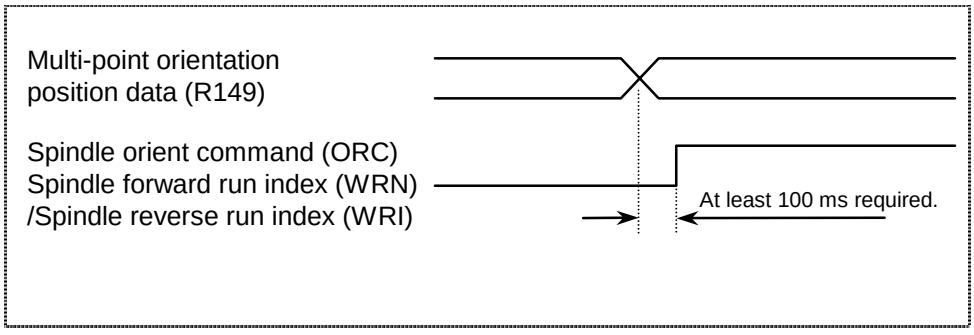
(1) Orientation command
The orient position at when the "Spindle orient command" (ORC) turns ON is input.
The values designated with the spindle parameter (SP007 OPST: in-position shift amount for orientation) and with "Multi-point orientation position data" signal are totaled to determine the orientation position.

(2) Multi-point indexing
Each time the "Spindle forward run index" (WRN) and "Spindle reverse run index" (WRI) turn ON, the axis rotates by the amount designated with the multi-point orientation position data.

The command is a 12-bit binary, and the command unit is as follows.

Command increment = 360/4096 [◦]

This signal must be validated before the "Spindle orient command" signal turns ON (at least 100 ms before).



(3) Turret control
The indexing position data for forward run/reverse run indexing is set.
[Setting range] For forward run/reverse run indexing: 0 to 359 (for 1 degree increment)
0 to 3599 (for 0.1 degree increment when parameter #3297 bit B is ON)
(Example) When using a 12-angle turret, the angle between stations will be 30 degrees. "30" is set in R149/R349, and when forward run/reverse run index is turned ON, the unit will move one station worth in the forward run direction.

[Operation]
Refer to the section on "Spindle forward run index" (WRN) turret control for the time chart.

(Note) Turret indexing command error warning: When the turret indexing function is valid, if a value exceeding "0 to 359" (for 1 degree increment) is issued for the indexing position command, "A8" will appear as a warning. Input the correct value, or turn the "Spindle orient command" (ORC) OFF to reset the warning.

[Related signals]
(1) Spindle orient command (ORC: Y2D6)
(2) Spindle forward run index (WRN: Y2D4)
(3) Spindle reverse run index (WRI: Y2D5)

(Note 1) R149 is the interface for the 1st spindle, and R349 is the interface for the 2nd spindle.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL GROUP NUMBER DESIGNATION		P C	R150, 1	R350, 1	R150, 1	R350, 1

[Function]

The group number is designated when the usage data of the group of which the tool life has been exceeded with tool life management II is to be cleared, or when the tool being used is to be forcibly changed.

[Operation]

The group designation range is as follows.

For group designation: 1 to 9999 of group number
For all groups : 65535 (all 1)

[Related signal]

(1) Tool change reset (TRST: Y2CC)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	LOAD METER 1, 2		P C	R152 to 5	—	R152 to 5	—

[Function] [Operation]

The load meter can be displayed on the coordinate value screen by just setting a value in the corresponding file register.
Refer to the section on "Load meter display" in the "PLC Programming Manual" for details.

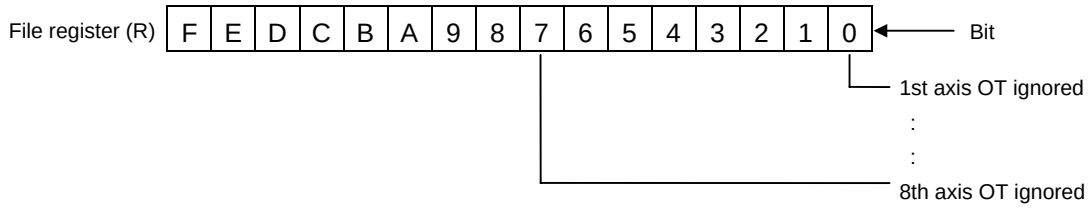
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	OT IGNORED		P C	R156	R356	R156	R356

[Function]

When this signal is used, "stroke end error" can be avoided without eternal wiring for stroke end signal (remote I/O connector pin No. fixed signal) provided for each axis. "Stroke end" signal on axis for which the "OT ignored" signal is set can be used for other purpose.

[Operation]

"Stroke end error" signal associated with a specific axis motion can be ignored.
The interface for this signal is as follows:



(Note 1) The signal is applicable to (+) and (-) motion at the same time (ignored when "ON").
(Note 2) "OT" is abbreviation of "Over Travel".

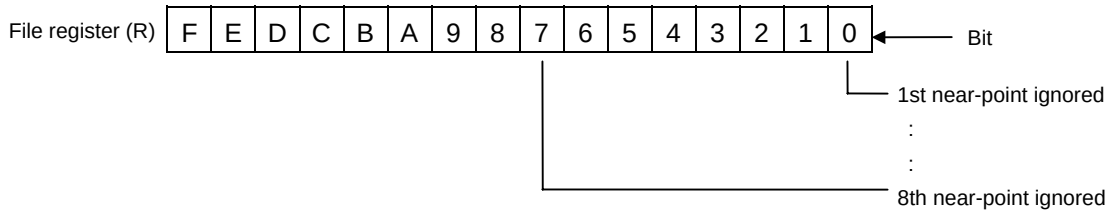
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	NEAR-POINT IGNORED		P C	R157	R357	R157	R357

[Function]

When this signal is used, "Near point detect" signal (remote I/O connector pin No. fixed signal) which is used for dog type reference position return can be ignored (dog not-passed state).
Furthermore, the "Near point detect" signal for an axis to which the "Near-point ignored" signal is set can be used for other applications.

[Operation]

When the signal is turned ON, "Near point detect" signal for the corresponding control axis can be ignored.
The interface is shown below:



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ALARM MESSAGE I/F 1 to 4		P C	R158 to 161	—	R158 to 161	—

[Function]

Desired alarm messages prepared using PLC development tool (personal computer) can be displayed in ALARM DIAGNOSIS screen of the setting and display unit by setting values (binary code) to alarm interface file registers (Rn, Rn+1, Rn+2, Rn+3).

[Operation]

If table No. of previously prepared alarm message table has been set to alarm interface file registers, alarm message, if alarm occurs, can be displayed in ALARM DIAGNOSIS screen.
Maximum 4 alarm messages can be displayed at the same time.
Alarm message can be cleared by setting "0" to alarm interface file registers.
For details of alarm message display, refer to the "PLC Programming Manual".

[Caution]

(1) Set setup parameter PLC "#6450 bit 0" to 1 to display the alarm messages.
(2) For alarm message interface, file register (R method) or temporary storage (F method) can be used. The selection is made with Setup parameter PLC "#6450 bit 1".
(3) In both R method (file register) and F method (temporary storage), alarm does extend to the controller.
When it is desirous to stop controller operation according to alarm type, signals such as "Auto operation "pause" command" (*SP) signal, "Single block" (SBK) signal and "Interlock" signal should be processed on the PLC side.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	OPERATOR MESSAGE I/F		P C	R162	—	R162	—

[Function]

Desired operator message prepared using PLC development tool (personal computer) can be displayed by setting value (binary code) to operator message interface file register (Rn). Operator message appears in ALARM DIAGNOSIS screen of the setting and display unit.

[Operation]

If table No. of previously prepared operator message table has been set to operator message interface file register, operator message can be displayed in ALARM DIAGNOSIS screen.
Operator message can be cleared by setting "0" to operator message interface file register.
For details of operator messages, refer to the "PLC Programming Manual".

[Caution]

(1) Set setup parameter PLC "#6450 bit 2" to 1 to display the operator messages.
(2) Display of operator message does not cause alarm on the controller side. When it is desirous to stop controller operation according to operator message, signals such as "Auto operation "pause" command" (*SP) signal, "Single block" (SBK) signal and "Interlock" signal should be processed on the PLC side.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	BOARD COMMUNICATION STATE		P C	—	R363	—	R363

[Function]

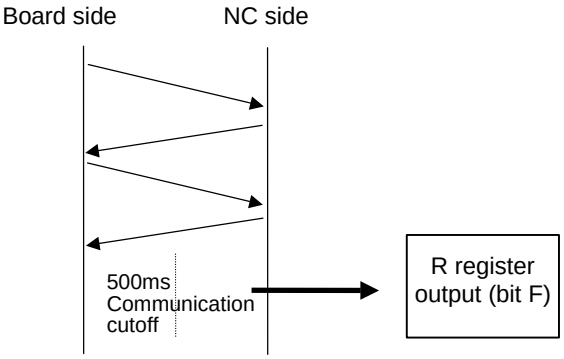
The communication state with the NC unit and setting and display unit is indicated.

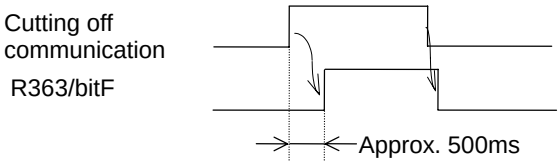
[Operation]

The communication state between the NC and board is indicated with a bit correspondence as shown below.

R363 F E D C B A 9 8 7 6 5 4 3 2 1 0

Communication cutoff
... (Communication between NC and board cut off for 500ms)





B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SEARCH & START PROGRAM NO.		P C	R170, 1	R370, 1	R170, 1	R370, 1

[Function]

The No. of the program to be searched with search & start is designated.

[Operation]

Set the No. of the program to be searched with search & start with a binary value.

(Note 1) The program No. must be set before the "Search & start" signal is input.

(Note 2) If a machining program No. is not designated or if an illegal No. is designated, and error signal will be output when the search operation is executed.

[Related signals]

(1) Search & start (RSST: Y1FA)
(2) Search & start (error) (SEE: X1C2)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	USER MACRO INPUT #1132 Controller → PLC		P C	R172, 3	—	R172, 3	—

[Function]

This is interface function used to coordinate user PLC to user macro.

(Note) The other signals from R100 to R199 are output from PLC, but this signal is input to PLC.

[Operation]

When a value is set in the system variables #1100 to #1131 or #1132 with the user macro system, the user PLC output to the file register Rn and Rn+1 corresponding to the user PLC can be referred to with that value.

The relationship between system variable and file register is as follows:

System variable	Points	Interface input signal	System variable	Points	Interface input signal
#1100	1	Register R172 bit 0	#1116	1	Register R173 bit 0
#1101	1	Register R172 bit 1	#1117	1	Register R173 bit 1
#1102	1	Register R172 bit 2	#1118	1	Register R173 bit 2
#1103	1	Register R172 bit 3	#1119	1	Register R173 bit 3
#1104	1	Register R172 bit 4	#1120	1	Register R173 bit 4
#1105	1	Register R172 bit 5	#1121	1	Register R173 bit 5
#1106	1	Register R172 bit 6	#1122	1	Register R173 bit 6
#1107	1	Register R172 bit 7	#1123	1	Register R173 bit 7
#1108	1	Register R172 bit 8	#1124	1	Register R173 bit 8
#1109	1	Register R172 bit 9	#1125	1	Register R173 bit 9
#1110	1	Register R172 bit 10	#1126	1	Register R173 bit 10
#1111	1	Register R172 bit 11	#1127	1	Register R173 bit 11
#1112	1	Register R172 bit 12	#1128	1	Register R173 bit 12
#1113	1	Register R172 bit 13	#1129	1	Register R173 bit 13
#1114	1	Register R172 bit 14	#1130	1	Register R173 bit 14
#1115	1	Register R172 bit 15	#1131	1	Register R173 bit 15

System variable	Points	Interface input signal
#1132	32	Register R172, R173
#1133	32	Register R174, R175
#1134	32	Register R176, R177
#1135	32	Register R178, R179

This correspondence table shows the example for file registers R172 and R173.

File registers R172 and R173 correspond to system variables #1100 to #1131, and #1132 (32-bit data).

[Related signals]

(1) User macro input #1133, #1134, #1135
(2) User macro output #1032, #1033, #1034, #1035, #1000 to #1031

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	USER MACRO INPUT #1133 Controller → PLC		P C	R174, 5	—	R174, 5	—

[Function]

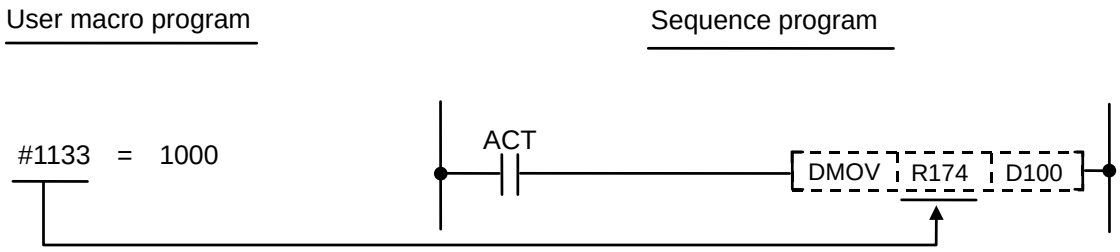
This provides interface function used to coordinate user PLC to user macro.

(Note) The other signals from R100 to R199 are output from PLC, but this signal is input to PLC.

[Operation]

When a value is set in the system variable #1133 with the user macro system, the user PLC output to the file register Rn and Rn+1 corresponding to the user PLC can be referred to with that value.

(Example)



1000 is input in D100 and 101 when the ACT signal turns ON.

[Related signals]

(1) User macro input #1132, #1134, #1135, #1100 to #1131
(2) User macro output #1032, #1033, #1034, #1035, #1000 to #1031

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	USER MACRO INPUT #1134 Controller → PLC		P C	R176, 7	—	R176, 7	—

[Function] [Operation]

The function operation, etc. are the same as those of "USER MACRO INPUT #1133".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	USER MACRO INPUT #1135 Controller → PLC		P C	R178, 9	—	R178, 9	—

[Function] [Operation]

The function operation, etc. are the same as those of "USER MACRO INPUT #1133".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	ADD-ON (EXPANSION) OPERATION BOARD OUTPUT 1 to 3		P C	R180 to 2	—	R180 to 2	—

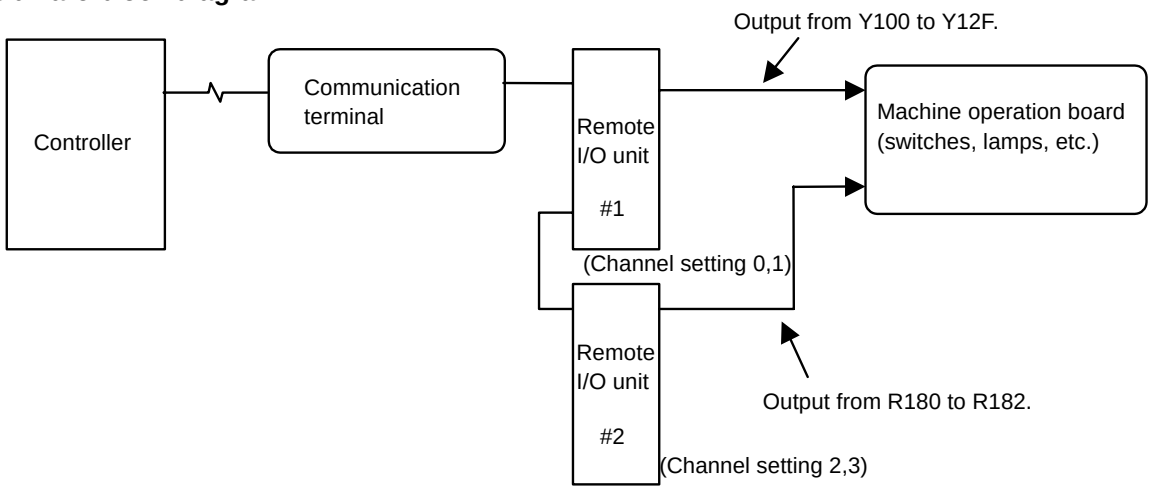
[Function]

By adding the remote I/O unit or the QY231 to the communication terminal, the machine operation board input/output signals can be input and output with the communication terminal control signals.
If the added remote I/O unit has less than 64 input points and 48 output points the input signals will be input to (X100 to X13F) and the output signals output to (Y100 to Y12F). If the number of input/output points is larger, the input signals will be R80 to R83 explained before, and the output signals R180 to R183 explained here. Generally, these signals are to be assigned to "bit-based arithmetic operation area (Y**)". They, however, are input to file registers (R).

[Operation]

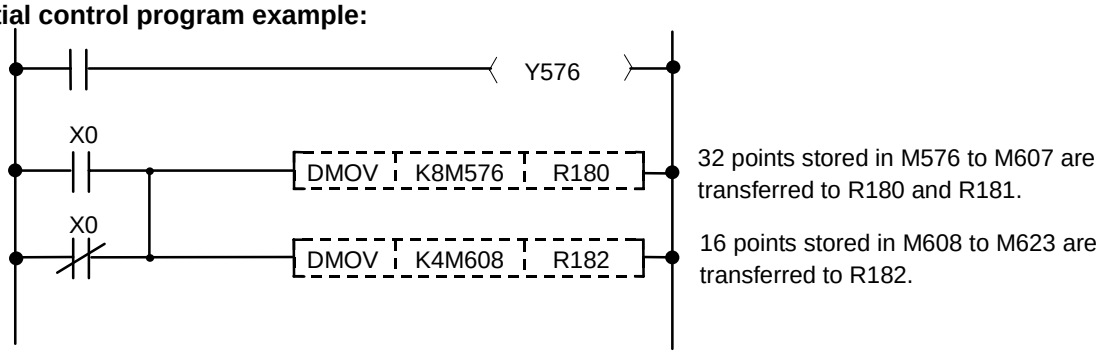
The signals are output together with other output signals at start of PLC main processing (medium speed).

<Hardware block diagram>



(Note 1) This is conventionally a bit unit signal, so create it in the temporary memory (M) and then transfer it to the corresponding file register (R) before using.

Sequential control program example:



(Note 2) Refer to the section "2.2 Operation board remote I/O unit" for the relation of the remote I/O channel setting switch and device.

(Note 3) Refer to the section "3.4 Machine output signals" Tables 3-6-3 to 3-6-4 for the add-on (expansion) operation board output 1 to 3.

[Related signals]

(1) Add-on (expansion) operation board input 1 to 4 (R80 to R83)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	WEAR COMPENSATION NO. (Tool presetter)		P C	R186	R386	R186	R386

[Function]

To clear the wear compensation amount after measuring the tool compensation amount with manual tool length measurement, set the wear compensation No. in a BCD code.

[Operation]

To clear the wear compensation amount after measuring the tool compensation amount with manual tool length measurement, set the wear compensation No. in a BCD code.
If 0 or an non-existing compensation No. is set, the wear data will not be cleared.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	EXTERNAL WORKPIECE COORDINATE OFFSET MEASUREMENT TOOL COMPENSATION NO. /SELECTION TOOL COMPENSATION NO. (Main)		P C	R192, 3	R392, 3	R192, 3	R392, 3

[Function]

1. External workpiece coordinate offset measurement function
   Set the tool No. (R194, 195) and the tool compensation No. (R192, R193) used for external workpiece coordinate offset measurement in a BCD code.
2. Chuck barrier check
   Set the tool No. (R194, 195) and the compensation No. (R192, R193) selected for the chuck barrier check.

[Operation]

1. External workpiece coordinate offset measurement function
   Set the tool No. and the tool compensation No. used for external workpiece coordinate offset measurement in a BCD code.
   This is set with the user PLC.
   This tool No. (R194, 195) is interpreted as the tool offset No. by the CNC.
2. Chuck barrier check
   The file register used differs according to the parameter (#1097 Tlno.)

#1097 Tlno.	R192,193/R392,393	R194,195/R394,395
0	Tool length, tool nose wear offset No.	Tool No.
1	Tool nose wear offset No.	Tool No., tool length offset No.

   If the tool length offset No. is not designated (if the contents are 0), the tool length and tool nose wear offset will both follow the T command modal.
   The T command modal will also be followed if the designated offset No. is not within the specified range.
   If the T command modal value is 0, the compensation amount will be interpreted as 0.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	EXTERNAL WORKPIECE COORDINATE OFFSET MEASUREMENT TOOL NO. /SELECTION TOOL NO. (Main)		P C	R194, 5	R394, 5	R194, 5	R394, 5

[Function] [Operation]

Refer to the explanation for R192 and R193 for details.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	USER PLC VERSION CODE		P C	R196 to 9	—	R196 to 9	—

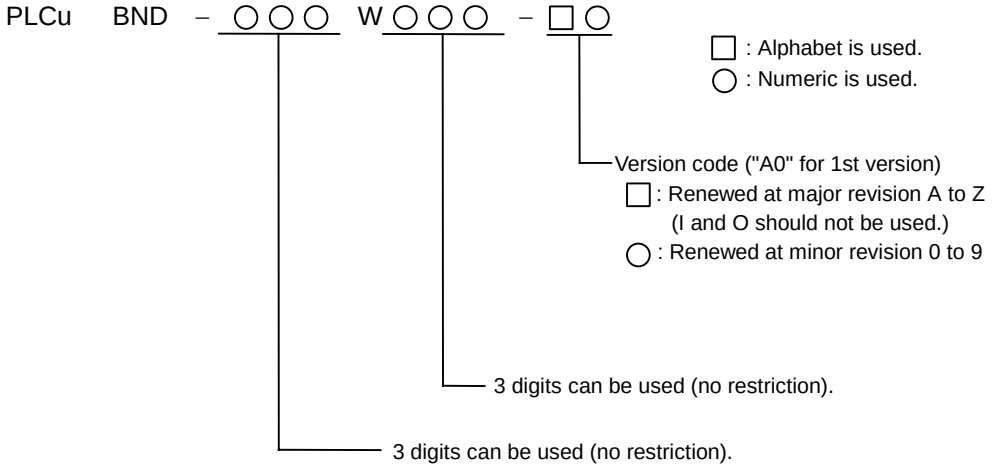
[Function]

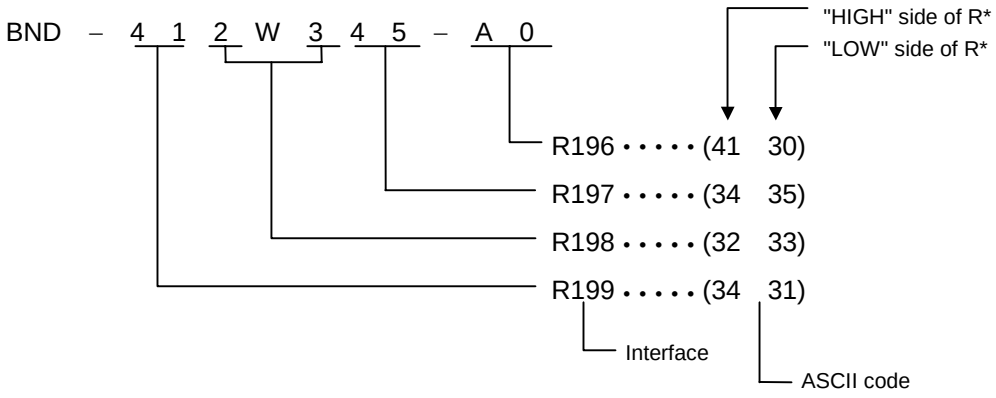
The user PLC version can be displayed with the software version that controls the other controller on the setting and display unit (communication terminal) DIAGN/IN/OUT screen.

[Operation]

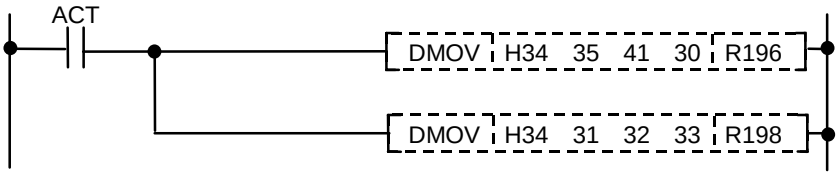
Characters to be displayed are placed in ASCII code.

<Display format>





(Program example)



B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	EACH AXIS MANUAL FEEDRATE B nth		P C	R400 to 415	R416 to 431	R400 to 415	R416 to 431

[Function] [Operation]

When the each axis manual feedrate B valid signal is valid, designate the manual feedrate for the axis selected with the manual feedrate B valid signal.

[Caution]

(1) When the each axis manual feedrate B valid signal is valid, the each axis speed designated with this register is valid for the manual feedrate of an axis for which the manual feedrate B valid signal is valid.
(2) Cutting override and manual override are invalid for this register's speed.
(3) This register is not related to the dry run speed.
(4) A binary value is directly set for this register. The setting unit is 0.01mm/min (°/min).
(5) This signal is a register independent for each axis.

[Related signals]

Manual feedrate B valid (Y260)
Each axis manual feedrate B valid (Y2BC)

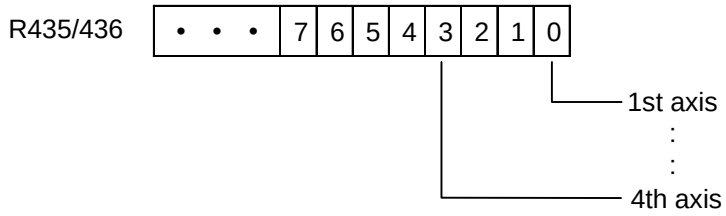
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SYNCHRONOUS CONTROL OPERATION METHOD SELECTION		P C	R435	R436	R435	R436

[Function] [Operation]

(1) Synchronous control

Synchronous control for the 1st part system is designated with the R435 register, and for the 2nd part system with the R436 register.

Synchronous control can be turned ON and OFF by setting the bits corresponding to each axis in the R435/436 registers. The CNC changes the operation when all axes reach the in-position state.



(a) Designating the synchronous operation method

Turn ON both bits corresponding to the axis related to the basic axis and synchronous axis with the base specification parameter "#1068 slavno".

(Example) To operate the 2nd axis (basic axis) and 3rd axis (synchronous axis) in synchronization

	7 6 5 4 3 2 1 0 HEX
R435	o o o o o o o o 0 0
	o o o o o 1 1 o 0 6

(b) Designating the independent operation method

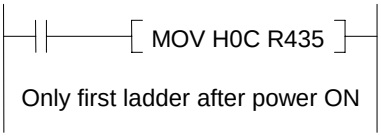
Turn ON only the bit corresponding to only one of the axes to be moved with the basic axis command.

(Example) To move only the 3rd axis (synchronous axis)

	7 6 5 4 3 2 1 0 HEX
R435	o o o o o o o o 0 0
	o o o o o 1 o o 0 4

If, due to the machine structure, the synchronous state must always be entered immediately after the power is turned ON, set the R435 register with the first ladder after the power is turned ON.

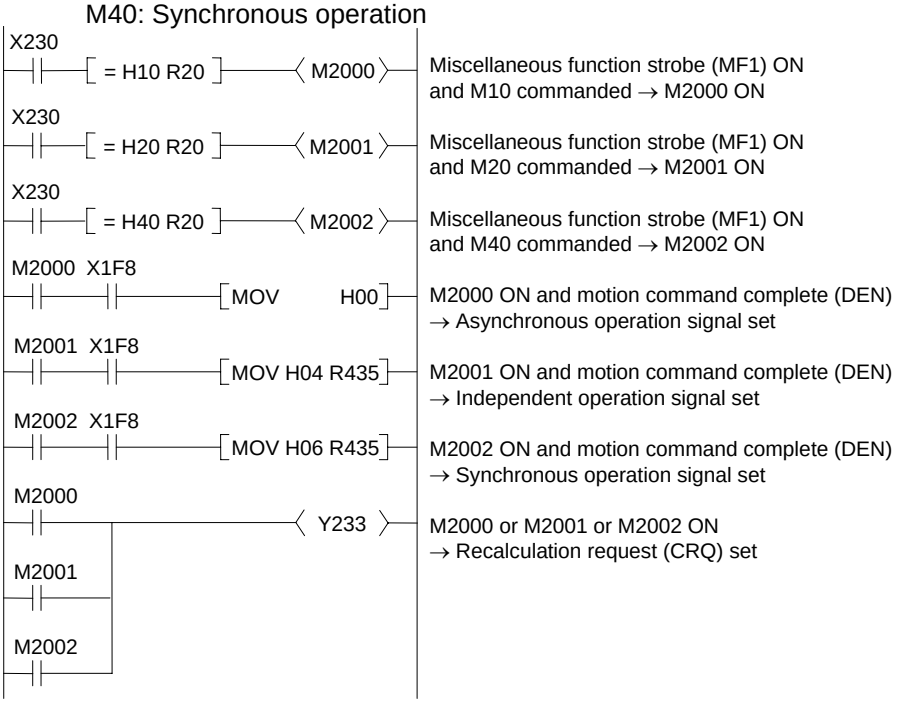
Example of ladder creation

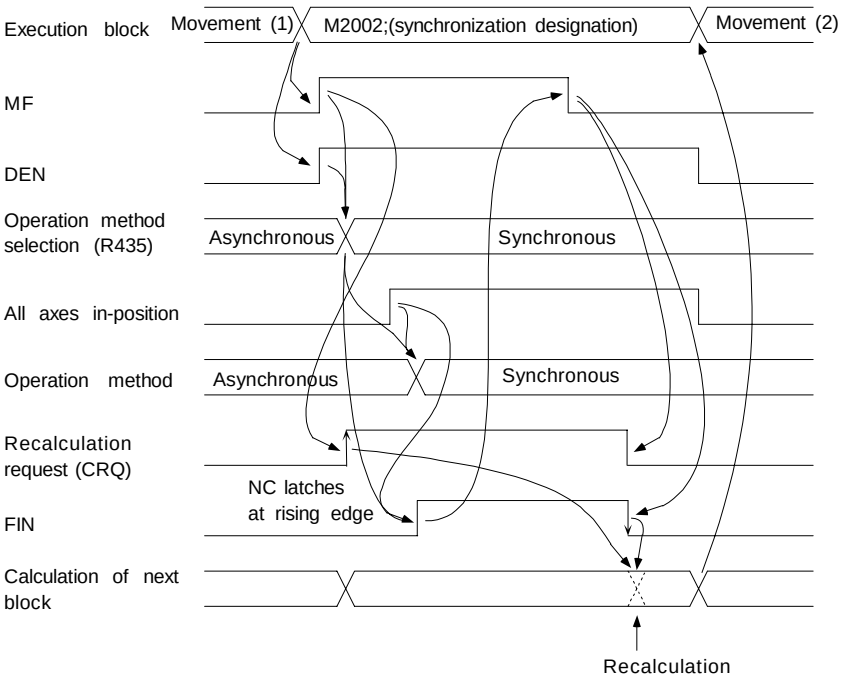


* The R436 register is used for the 2nd part system.

When changing the operation with the R435/436 register during automatic operation, calculate the coordinates again.
After synchronous axis independent operation is carried out, the end point coordinates of the synchronous axis are substituted in the program end point coordinates for the basic axis. Thus, if the coordinates are not recalculated, the basic axis' movement command will not be created properly.
Request recalculation immediately after the R435/436 register is changed.

<Example of ladder creation>
Basic axis: 2nd axis Synchronous axis: 3rd axis
When M code is assigned to each:
M10: Asynchronous operation
M20: Independent operation
M40: Synchronous operation



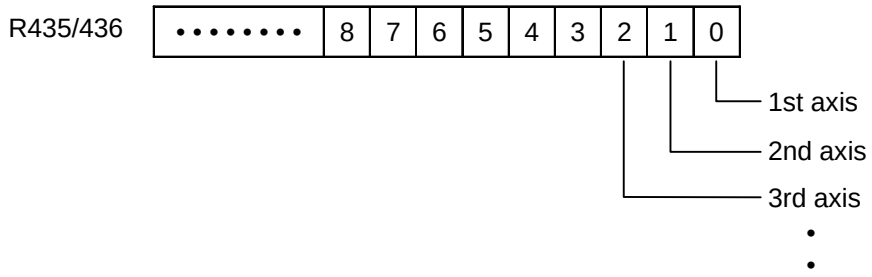


(2) Simple C-axis synchronous control

Synchronous control for the 1st part system is designated with the R435 register, and for the 2nd part system with the R436 register.

If this register is set in a mode other than the C axis mode, the operation alarm (1036) will occur.

Synchronous control can be turned ON and OFF by setting the bits corresponding to each axis in the R435/436 registers. The CNC changes the operation when all axes reach the in-position state.



Turn ON both bits corresponding to the axis related to the basic axis and synchronous axis with the base specification parameter "#1068 slavno".

(Example) To operate the 3rd axis (basic axis) and 5th axis (synchronous axis) in synchronization

	7 6 5 4 3 2 1 0 HEX
R435	o o o o o o o o 0 0
	o o o 1 o 1 o o 1 4

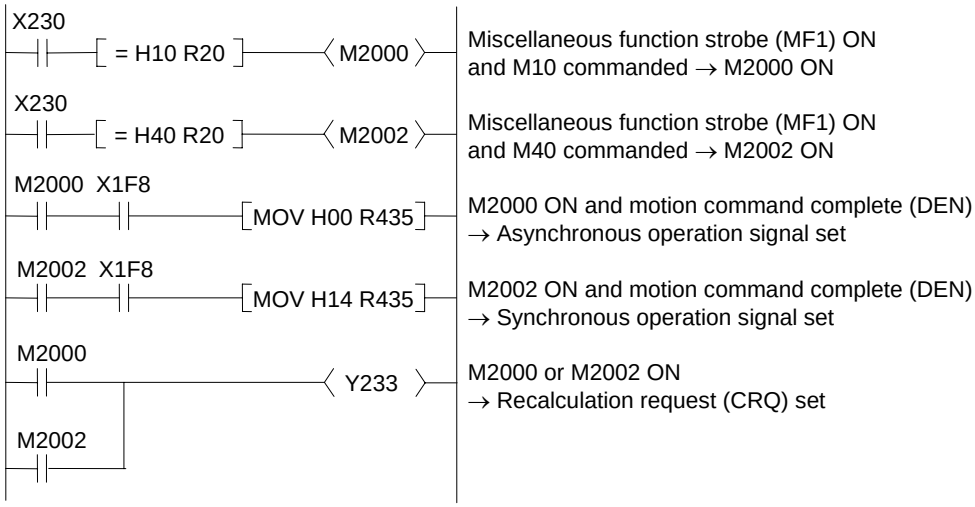
When changing the operation with the R435/436 register during automatic operation, calculate the coordinates again. The synchronous axis movement command may not be created correctly if coordinates are not recalculated. Request recalculation immediately after the R435/436 register is changed.

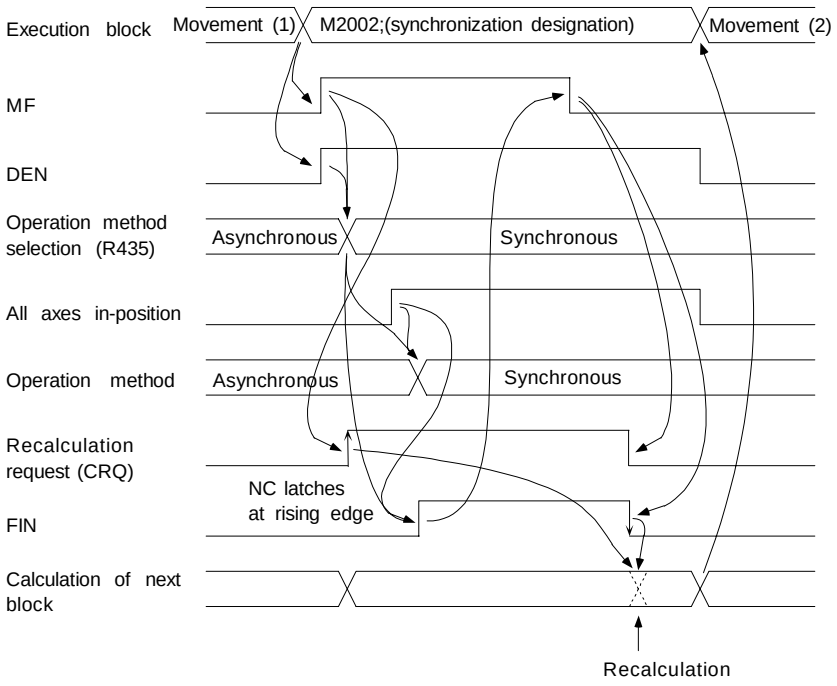
<Example of ladder creation>

Basic axis: 3rd axisSynchronous axis: 5th axis

When M code is assigned to each:

M10: Asynchronous operation M40: Synchronous operation





[Cautions]

(1) During synchronous operation or independent operation, the basic axis signals are valid for the "Interlock" and "Machine lock" signals, etc.

(2) The synchronous axis will return to the reference position in synchronization with the basic axis if G27, G28 or G30 is commanded during synchronous operation. If the synchronous axis is at the reference position when the basic axis completes reference position return, the reference position return will be completed. If the synchronous axis is not at the reference position when the basic axis completes reference position return, the "Reference position reached" signal for the basic axis will not be output.

(3) The position switches are processed independently for the basic axis and synchronous axis.

(4) Input the same OT signal for the basic axis and synchronous axis.
Set the same soft limit value for the basic axis and synchronous axis.
If the above settings cannot be made because of the machine specifications, observe the following points.
- If OT or soft limit occurs during the manual operation mode, an alarm will occur only for the synchronous axis, and the basic axis will not stop.
  Thus, make sure that the basic axis alarm turns ON before the synchronous axis.
- OT during the manual operation mode will cause the synchronous axis to stop when the OT signal for only the basic axis turns ON. The basic axis is stopped by the position controller, and the synchronous axis is stopped by the NC control unit.
  Thus, there may be a difference in the stop positions. If an excessive error alarm occurs because of OT, enter the correction mode, and cancel the alarm.

(5) The basic axis independent operation is handled as asynchronous, so the PLC input/output signal is not reflected on the synchronous axis.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL I/D R/W POT NO. DESIGNATION		P C	R438	—	R438	—

[Function]

Designate the number of the pot containing the tool No. of the information communicated with the tool ID controller.

[Operation]

1. Designate the pot No. to store the tool information tool No. read in from the tool ID controller.
2. Designate the pot No. containing the tool No. to write the tool information to the tool ID controller.
3. Designate the pot No. containing the tool No. of which tool information is to be erased.

[Caution]

Do not change the pot No. while communicating with the tool ID.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	LARGE DIAMETER TOOL INFORMATION		P C	R439	—	R439	—

[Function]

Information indicating whether the tool mounted on the spindle and standby tool are large diameter tools or not is set. (H: Spindle, L: Standby tool)

[Operation]

When the tool mounted on the spindle or standby tool is changed, "1" is set if the tool is a large diameter tool, and "0" is set if it is a normal tool, respectively.
If there is no tool mounted on the spindle or standby tool, H: spindle and L: standby tool will be cleared to "0".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL WEIGHT (Spindle tool)		P C	R440	—	R440	—

[Function]

Weight of the tool mounted on the spindle is set.

[Operation]

When the tool mounted on the spindle is changed, the weight of the newly-mounted tool will be set.
If no tool is mounted on the spindle, this setting will be cleared to "0".

[Caution]

Unit: 0.1kg

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL WEIGHT (Standby tool)		P C	R441	—	R441	—

[Function]
Weight of the standby tool is set.

[Operation]
When the standby tool is changed, the weight of newly-set standby tool will be set.
If there is no standby tool, this setting will be cleared to "0".

[Caution]
Unit: 0.1kg

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	UNSET TOOL INFORMATION		P C	R442	—	R442	—

[Function]
Information indicating whether the tool mounted on the spindle and standby tool are unset tools (*1) or not is set. (H: Spindle, L: Standby tool)

[Operation]
When the tool mounted on the spindle or standby tool is changed, "1" is set if the tool is an unset tool, and "0" is set if the tool is set, respectively.
If there is no tool or standby tool mounted on the spindle, H: spindle and L: standby tool will be cleared to "0".

*1: When changing the tool numbers in the ID label (when writing new tool information in the ID label), the tool must be set as an unset tool.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE SYNCHRONOUS FUNCTION BASIC SPINDLE SELECT		P C	R446	—	R446	—

[Function]
Select the basic spindle to be used for synchronous control from the PLC.

[Operation]
Select the spindle to be controlled as the basic spindle from the serially connected spindles.
(0: 1st spindle), 1: 1st spindle, 2: 2nd spindle, 3: 3rd spindle, 4: 4th spindle

(Note 1) If a spindle that is not serially connected is selected, spindle synchronous control will not be executed.
(Note 2) If "0" is designated, the 1st spindle will be controlled as the basic spindle.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE SYNCHRONOUS FUNCTION SYNCHRONOUS SPINDLE SELECT		P C	R447	—	R447	—

[Function]

Select the synchronous spindle to be used for synchronous control from the PLC.

[Operation]

Select the spindle to be controlled as the synchronous spindle from the serially connected spindles.
(0: 2nd spindle), 1: 1st spindle, 2: 2nd spindle, 3: 3rd spindle, 4: 4th spindle

(Note 1) If a spindle that is not serially connected is selected or if the same spindle as the basic spindle is selected, spindle synchronous control will not be executed.

(Note 2) If "0" is designated, the 2nd spindle will be controlled as the synchronous spindle.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SPINDLE SYNCHRONOUS FUNCTION PHASE SHIFT AMOUNT		P C	R448	—	R448	—

[Function]

The synchronous spindle's phase shift amount can be designated from the PLC.

[Operation]

Designate the phase shift amount for the synchronous spindle.
Unit: 360°/4096

[Related signals]

In spindle synchronous control (SPSYN1: X308)
Spindle rotation speed synchronization complete (FSPRV: X309)
Spindle phase synchronization complete (FSPPH: X30A)
Spindle synchronous control (SPSY: Y398)
Spindle phase synchronous control (SPPHS: Y399)
Spindle synchronous rotation direction (Y39A)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	EXTERNAL MACHINE COORDINATE SYSTEM COMPENSATION DATA		—	R560 to 7	R568 to 75	R560 to 7	R568 to 75

[Function]

This data compensates the basic machine coordinate system. The axis moves the amount equivalent to the set data (interpolation unit). The entire coordinate system value, including the basic machine coordinate system, will not change.

[Operation]

When the "External machine coordinate system compensation data" (R560 to 7) is set, the axis will move the amount equivalent to that set value.
The entire coordinate system value, including the basic machine coordinate system, will not change.
<Data range>
8000 (HEX) to 7FFF (HEX) (Absolute compensation amount –32768 to 32767)
Unit: Interpolation unit (0.5µm (0.05µm when using sub-micrometer specifications.)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SELECTION TOOL COMPENSATION NO. (Sub)		PC	R1000, 1	R1050, 1	R1000, 1	R1050, 1

[Function]

Designate the tool No. and compensation No. selected on the sub-spindle side for chuck barrier check.

[Operation]

The file register used differs according to the parameter (#1097 Tlno.)

#1097 Tlno.	R1000,1001/R1050,1051	R1002,1003/R1052,1053
0	Tool length, tool nose wear offset No.	Tool No.
1	Tool nose wear offset No.	Tool No., tool length offset No.

If the tool length offset No. is not designated (if the contents are 0), both the tool length and tool nose wear offset follow the details designated for the main spindle. The details for the main spindle will also be set if the designated offset No. is not within the specified range.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SELECTION TOOL WEAR NO. (Sub)		PC	R1002, 3	R1052, 3	R1002, 3	R1052, 3

[Function] [Operation]

Refer to the section for the "Selection tool compensation No. (sub) (R1000, 1)".

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL MOUNTING INFORMATION		P C	R1004, 5	R1054, 5	R1004, 5	R1054, 5

[Function]

Designate the presence of a tool mounted on the tool post (tool compensation amount validity).

[Operation]

When the tool designated for tool mounting is selected, the tool compensation amount will be added to the chuck barrier check.

<Bit allocation>

Tool mounting information (high order) R1005/R1055	bitF	bitE	bitD	bitC	bitB	bitA	bit9	bit8
	Tool 32	Tool 31	Tool 30	Tool 29	Tool 28	Tool 27	Tool 26	Tool 25
	bit7	bit6	bit5	bit4	bit3	bit2	bit1	bit0
	Tool 24	Tool 23	Tool 22	Tool 21	Tool 20	Tool 19	Tool 18	Tool 17

Tool mounting information (low order) R1005/R1055	bitF	bitE	bitD	bitC	bitB	bitA	bit9	bit8
	Tool 16	Tool 15	Tool 14	Tool 13	Tool 12	Tool 11	Tool 10	Tool 9
	bit7	bit6	bit5	bit4	bit3	bit2	bit1	bit0
	Tool 8	Tool 7	Tool 6	Tool 5	Tool 4	Tool 3	Tool 2	Tool 1

Bit OFF: Tool not mounted (tool compensation amount not added)
Bit ON: Tool mounted (tool compensation amount added)

In a machine that uses tools 1 to 12 on the main spindle's tool post and tools 17 to 28 on the sub-spindle's tool post, if the tools are mounted in either tool post, H0FFF is set for both R1004 and R1005.
When tool 28 is detached from the sub-spindle side next, R1005 will be set to H07FF.

[Remark]

This signal is initialized to HFFFF when the power is turned ON.
Thus, if this signal is not used, the tool compensation amount will always be added to the chuck barrier check.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	(PASSWORD NO.)		P C	R1402, 3	—	R1402, 3	—

[Function]

This function uses a password No. to prohibit editing and input/output of the user PLCs to prevent these user PLCs prepared by the machine manufacturer from being incorrect overwritten by the end user.
This function is an option.

[Operation]

The machine manufacturer's original password No. is registered in R1402[L]/R1403[H] with the user PLCs.
Set the password No. in the range of "2" to "99999999". "0" and "1" cannot be set. Note that if the R1402/R1403 value is "0" or "1", the default value "5963" will be used as the password No.

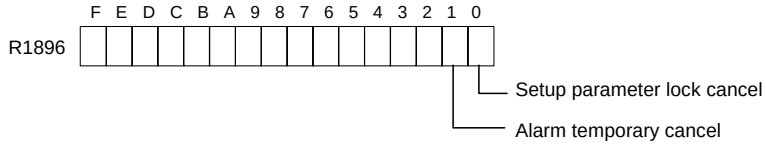
B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	SETUP PARAMETER LOCK I/F		P C	R1896	—	R1896	—

[Function]

This is the input signal used with the setup parameter lock function.

[Operation]

This signal is validated when the base specification parameter #1222 aux06 bit3 (setup parameter setting lock valid) is set to 1.



(1) Setup parameter lock cancel (bit 0)

The setup parameter lock is canceled when this bit is turned ON, and the following operations take place.

(a) Setting of the setup parameters is enabled.
(b) Alarm "M90 PARAM SET MODE" is displayed.
(c) "T01 STOP CODE (0190)" occurs when automatic start is activated.
(d) Parameters can be input via RS-232C.
(e) Parameters can be input from the GOP memory card.

The setup parameters are locked when this bit is turned OFF, and the following operations take place.

(a) Setting of the setup parameters is disabled.
(b) An operation error (E84 CAN'T IN/OUT) occurs when inputting parameters via RS-232C.
(c) An error occurs if parameters are input from the GOP memory card.
(d) Automatic start is enabled allowing automatic operation to be started.
(e) When this bit is changed from ON to OFF, the settings are validated after resetting.

(2) Alarm temporary cancel (bit1)

(a) When R1896 bit 0 is ON and setup parameter lock is canceled, alarms can be temporarily canceled by turning this bit ON.
(b) This bit will turn OFF when the power is turned ON again.

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TOOL COMPENSATION NO. FOR TOOL LENGTH MEASUREMENT 2		P C	R2970	R2971	R2970	R2971

[Function]

Set the number of the tool for measuring the tool compensation amount in a BCD code.

[Operation]

Set the number of the tool for measuring the tool compensation amount in a BCD code. This tool No. is interpreted as the tool compensation No. by the CNC.

[Related signals]

Wear compensation No. (R186)
Tool length measurement 2 (TLMS: Y229)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	USER PLC VERSION CODE 2		P C	R4732 to 8	—	R4732 to 8	—

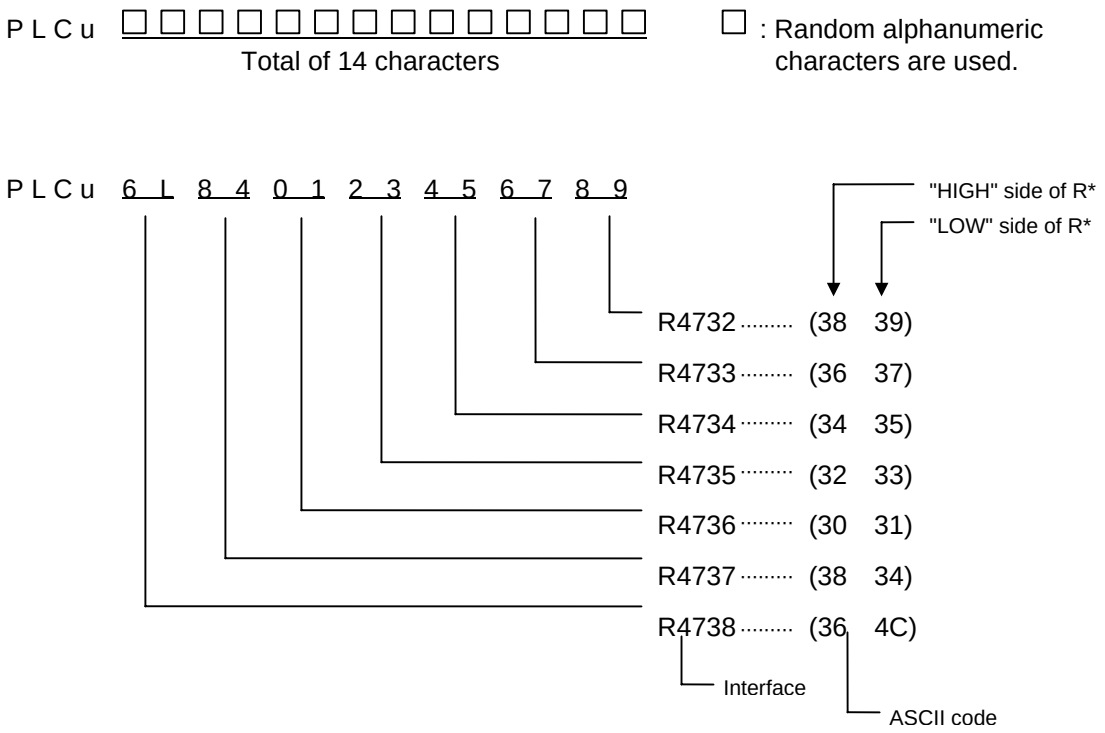
[Function]

This signal enables the user PLC version to be displayed, together with the software version controlling another control unit, in the DIAGN/IN/OUT screen of the setting display unit (communication terminal).

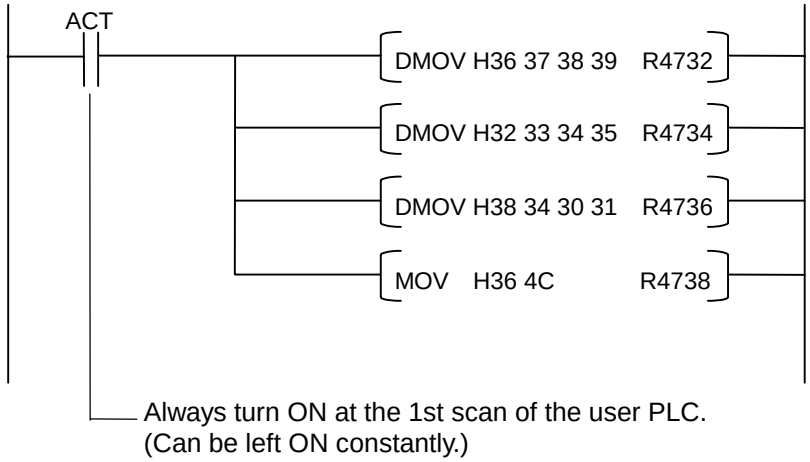
[Operation]

The ASCII code that corresponds to the character to be displayed in the version display interface is set.

<Display format and usage example>



(Program example)



6.5 Explanation of Special Relays (E**, SM**)

B contact	Signal name	Signal abbreviation		1st system	2nd system	1st system	2nd system
—	TEMPERATURE RISE WARNING		P C	E16	—	SM16	—

[Function]

If the alarm is displayed when an overheat alarm is detected in the control unit or communication terminal, the overheat signal will be output simultaneously. If the machine is in automatic operation, the operation will be continued, but restarting will not be possible after resetting or stopping with M02/M30. (Starting will be possible after block stop or feed hold.)
For details on the operation, etc., refer to "Temperature warning cause (R57)".

⚠ CAUTION

If the temperature rise detection function is invalidated with the parameters, the control could be disabled when the temperature is excessive. This could result in machine damage or personal injuries due to runaway axis, and could damage the device. Enable the detection function for normal use.

[Related signals]

Temperature warning cause (R57)
Control unit temperature (R458)

6.6 Explanations for Each Application

6.6.1 IO Link

(1) Outline

This function makes it possible to send and receive various data between multiple NCs with packet communication using the HDLC function.
This function uses a communication channel separate from that for the conventional communication between the NC and operation board.
Data can be exchanged between one master NC and up to four slave NC stations.
The master and slaves are set with the rotary switch (NCN0) on the expansion card (HR531/HR532/HR534/HR535).

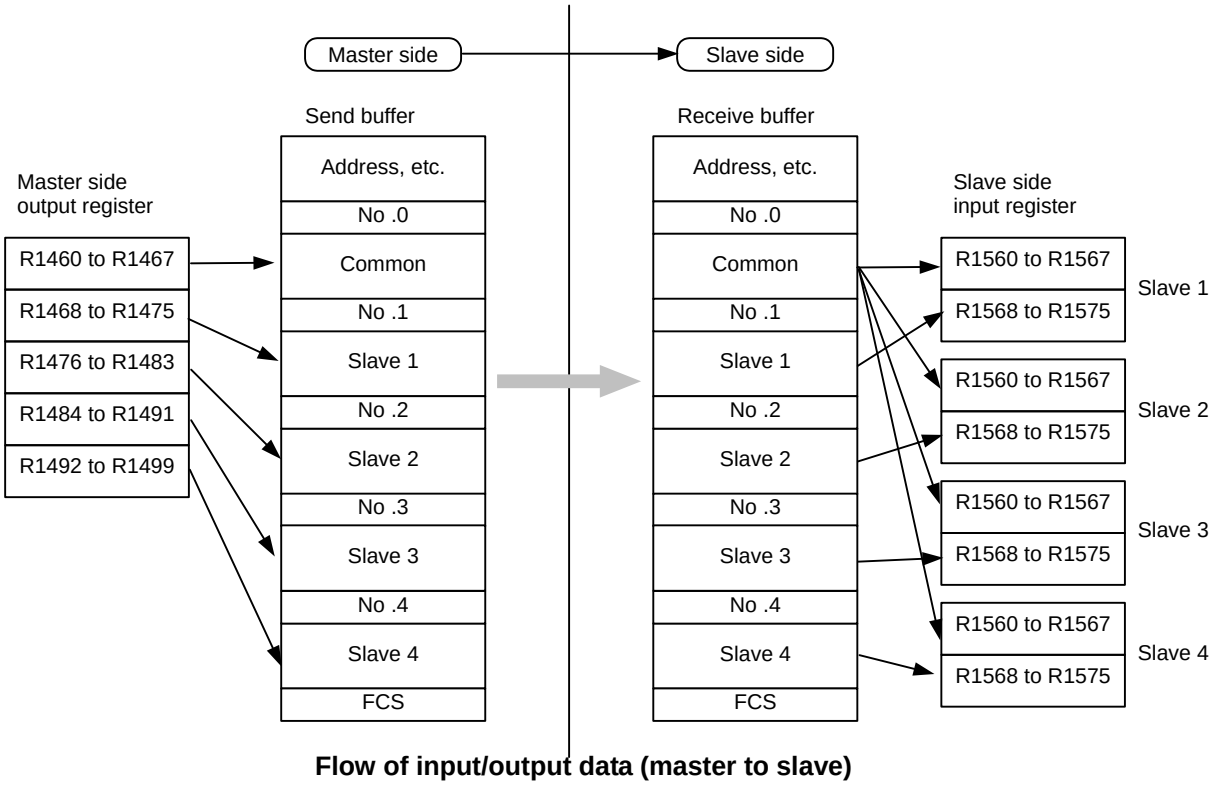
Rotary switch settings

Setting position	Function explanation
0	Master station for normal use or IO link
1	Slave station 1 for IO link
2	Slave station 2 for IO link
3	Slave station 3 for IO link
4	Slave station 4 for IO link

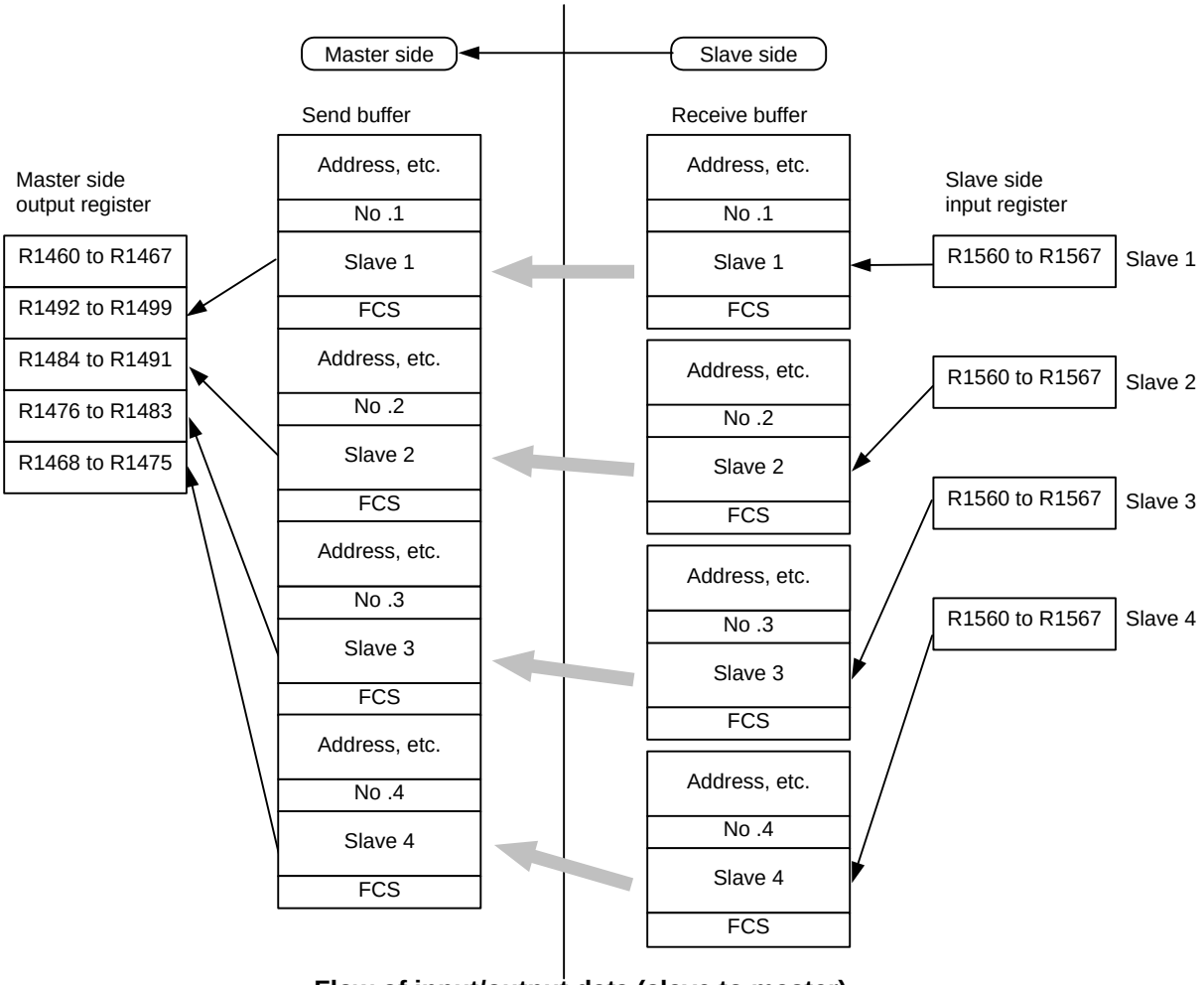
(2) Operation

The R registers are used for the input/output data.
The same R registers are used as shown below of the master and slaves.

	Input data			Output data	
	Master side	Slave side		Master side	Slave side
R1560 to R1567	Not used	Input 0 (common for all slaves)	R1460 to R1467	Output 0 (common for all slaves)	Output (each slave station)
R1568 to R1575	Input 1 (slave 1 station)	Input (each slave station)	R1468 to R1475	Output 1 (slave 1 station)	Not used
R1576 to R1583	Input 2 (slave 2 station)	Not used	R1476 to R1483	Output 2 (slave 2 station)	Not used
R1584 to R1591	Input 3 (slave 3 station)	Not used	R1484 to R1491	Output 3 (slave 3 station)	Not used
R1592 to R1599	Input 4 (slave 4 station)	Not used	R1492 to R1499	Output 4 (slave 4 station)	Not used



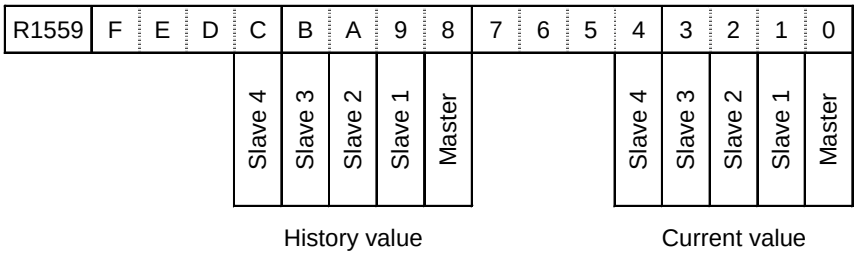
Flow of input/output data (master to slave)



Flow of input/output data (slave to master)

(3) Communication status

The communication status can be confirmed with either the master or slave by using the file register (R1559).
The input/output data is not updated when communication is cutoff.
Current value: The bit for the current communication client is set.
History value: The bit for the client with which communication was established in the past is turned ON.
(Only the master or slave is set at the ladder cycle.)



(4) Precautions

(a) Communication starts when the power for the master and slave is turned ON.
(b) For this communication, there must always be one master station. Data cannot be exchanged between slave stations.
(c) An alarm will not occur even if the communication is cut off.

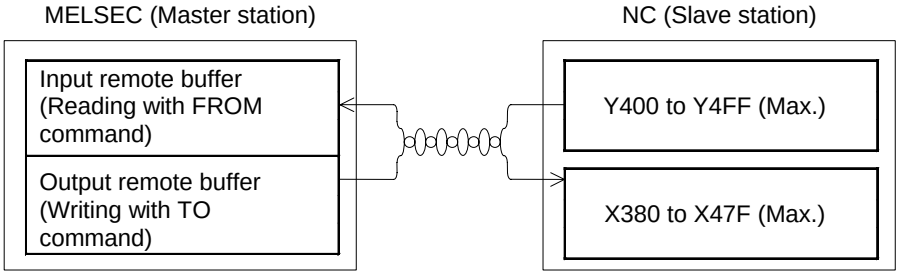
6.6.2 M-NET

(1) Outline

When this function is used, a serial link for RS422 can be used as the machine interface in addition to the conventional remote I/O.

(2) Assigning the input/output I/F

The input/output I/F for the serial link are assigned to a different range than RIO. Thus, even when using the serial link, the RIO can be used.
The serial input uses devices X380 and following, and the serial output uses devices Y400 and following.
The total number of input/output points for the serial link is max. 256 points for the input and max. 256 points for the output. The number of input/output points per station is independent for the input and output. A random number of points can be set for each in 8-point units within a range up to 256 points. However, when the MELSEC AJ71C22 unit is connected, both the input and output will be limited to max. 128 points per station.



The remote buffer assignment differs according to the number of input/output bytes and number of slave stations. Refer to the User's Manual for each unit for details.

The normal RIO assignment (X000 and following, and Y000 and following) is not affected.

Input/output device usage range

Data size	Machine signal input (X380 to)	Machine signal output (Y400 to)
1	to X387	to Y407
2	to X38F	to Y40F
3	to X397	to Y417
4	to X39F	to Y41F
5	to X3A7	to Y427
6	to X3AF	to Y42F
7	to X3B7	to Y437
8	to X3BF	to Y43F
9	to X3C7	to Y447
10	to X3CF	to Y44F
11	to X3D7	to Y457
12	to X3DF	to Y45F
13	to X3E7	to Y467
14	to X3EF	to Y46F
15	to X3F7	to Y477
16	to X3FF	to Y47F

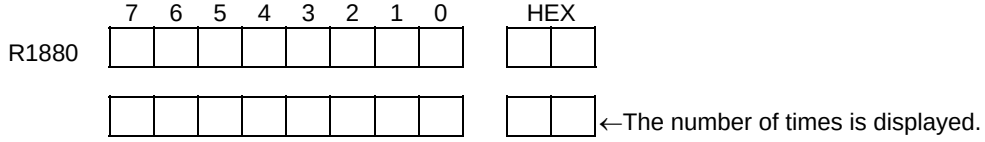
Data size	Machine signal input (X380 to)	Machine signal output (Y400 to)
17	to X407	to Y487
18	to X40F	to Y48F
19	to X417	to Y497
20	to X41F	to Y49F
21	to X427	to Y4A7
22	to X42F	to Y4AF
23	to X437	to Y4B7
24	to X43F	to Y4BF
25	to X447	to Y4C7
26	to X44F	to Y4CF
27	to X457	to Y4D7
28	to X45F	to Y4DF
29	to X467	to Y4E7
30	to X46F	to Y4EF
31	to X477	to Y4F7
32	to X47F	to Y4FF

(Note 1) When using the AJ71C22 or AJ71C22S1, the maximum number of points per slave station is limited to 128 points (data size 16). Thus, the data size setting is 16 or less.

(Note 2) Refer to the User's Manual for the link unit in use for details on assigning the master station's input/output remote buffer.

(3) Diagnosing the operation status

Set the serial connection operation status in the R1880 to R1889. The serial connection operation state can be diagnosed by monitoring R1880 to R1889 on the "I/F Diagnosis" screen.



To set the diagnosis register data to 0, set the register No. in Device ( ), "0" in Data ( ) and "1" in Mode ( ). Then, press the INPUT key.

Diagnosis register	(Note 1) Error No.	Details
R1880	10h (bit4)	Number of framing error occurrences The framing error is caused by a stop bit detection error. A mismatch of the number of stop bits, baud rate or data length, etc. is the cause.
R1881	20h (bit5)	Number of parity error occurrences The parity error is caused by a parity error detection in the horizontal direction. A mismatch of the parity addition specifications (validity, even/odd) or a transmission mistake, etc., is the cause.
R1882	40h (bit6)	Number of overrun error occurrences The overrun error can be caused by a response fault during reception on the NC side.
R1883	01h to 03h	Number of transmission data illegal detections The transmission data illegal detection includes the BCC error and transmission data errors 1 and 2. At an illegal detection, NAK (Not Acknowledge) is returned to the master station.

(Note 1) The error No. is displayed in R1884.

Diagnosis register	Details	
R1884	Error No. register Of each error, the number of the error that occurred last is displayed.	
	Error No.	**Error details**
	01h	BCC error A BCC code is added to the transmission data, and a transmission data error was detected from the transmission data and BCC code.
	02h	Transmission data error 1 The transmission data before the BCC code is an ETX (03h) code, but if the data before BCC is not an ETX code, the transmission data error 1 will occur.
	03h	Transmission data error 2 Transmission data error 2 will occur if the section that should be a "0" to "F" ASCII code (30H to 39H, 41H to 46H) in the transmission data is not within the range.
	04h	Timeout error The timeout error occurs if there is not transmission from the master station within a set time (parameter setting value), and an emergency stop occurs. The emergency stop is cancelled if the data from the preparation sequence is retransmitted and the communication is established.
	10h	Number of framing error occurrences The framing error is caused by a stop bit detection error. A mismatch of the number of stop bits, baud rate or data length, etc. is the cause.
	20h	Number of parity error occurrences The parity error is caused by a parity error detection in the horizontal direction. A mismatch of the parity addition specifications (validity, even/odd) or a transmission mistake, etc., is the cause.
	40h	Number of overrun error occurrences The overrun error can be caused by a response fault during reception on the NC side.

<table>
<tr><th>Diagnosis register</th><th>Details</th></tr>
<tr><td>R1885</td><td>Number of transmission data illegal detections
As with R1883, the number of transmission data illegal detections is indicated, but when normal communication is carried out, this register is cleared to 0.</td></tr>
<tr><td>R1886 to R1889</td><td>Reception preparation sequence
The preparation sequence sent from the master station is displayed in the transmitted format.
(Display example)
<table>
<tr><td></td><td>76543210</td><td>HEX</td><td></td></tr>
<tr><td>R1886</td><td>00000101</td><td>05</td><td>ENQ</td></tr>
<tr><td></td><td>01100010</td><td>62</td><td>SAi station address (Example for station 1)</td></tr>
<tr><td>R1887</td><td>00110000</td><td>30</td><td>Transmission data size from master station to slave station (Example for 13 bytes)</td></tr>
<tr><td></td><td>01000100</td><td>44</td><td>(ASCII 30H, 44H = 0dH = 13d)</td></tr>
<tr><td>R1888</td><td>00110000</td><td>30</td><td>Transmission data size from slave station to master station (Example for 9 bytes)</td></tr>
<tr><td></td><td>00111001</td><td>39</td><td>(ASCII 30H, 39H = 09h = 9d)</td></tr>
<tr><td>R1889</td><td>00000011</td><td>03</td><td>ETX</td></tr>
<tr><td></td><td>00011001</td><td>31</td><td>BCC</td></tr>
</table></td></tr>
</table>

(Note 1) R1880 to R1889 hold the contents even when the NC power is turned OFF.

(Note 2) R1886 to R1889 save the contents only when the preparation sequence is correctly sent to the local station.
The previously received contents are saved until the preparation sequence is established. After clearing the contents of R1886 to R1889, if the contents are not saved in the register even after the preparation sequence is received, check the following items.
- The master station transmission has not started
- The transmission route is not connected or is incorrectly connected
- The station No. setting is incorrect
- The communication conditions, such as the baud rate and data length, are incorrect.
- A BCC error has occurred because of a noise or a difference in ground levels.
- The rotary switch setting is incorrect.

(Note 3) If the preparation sequence is not established (does not shift to the normal sequence) even after being saved in the register, the following factors can be considered.
- The transmission byte size differs from the master station setting.
- The preparation sequence of the other slave stations is not established.

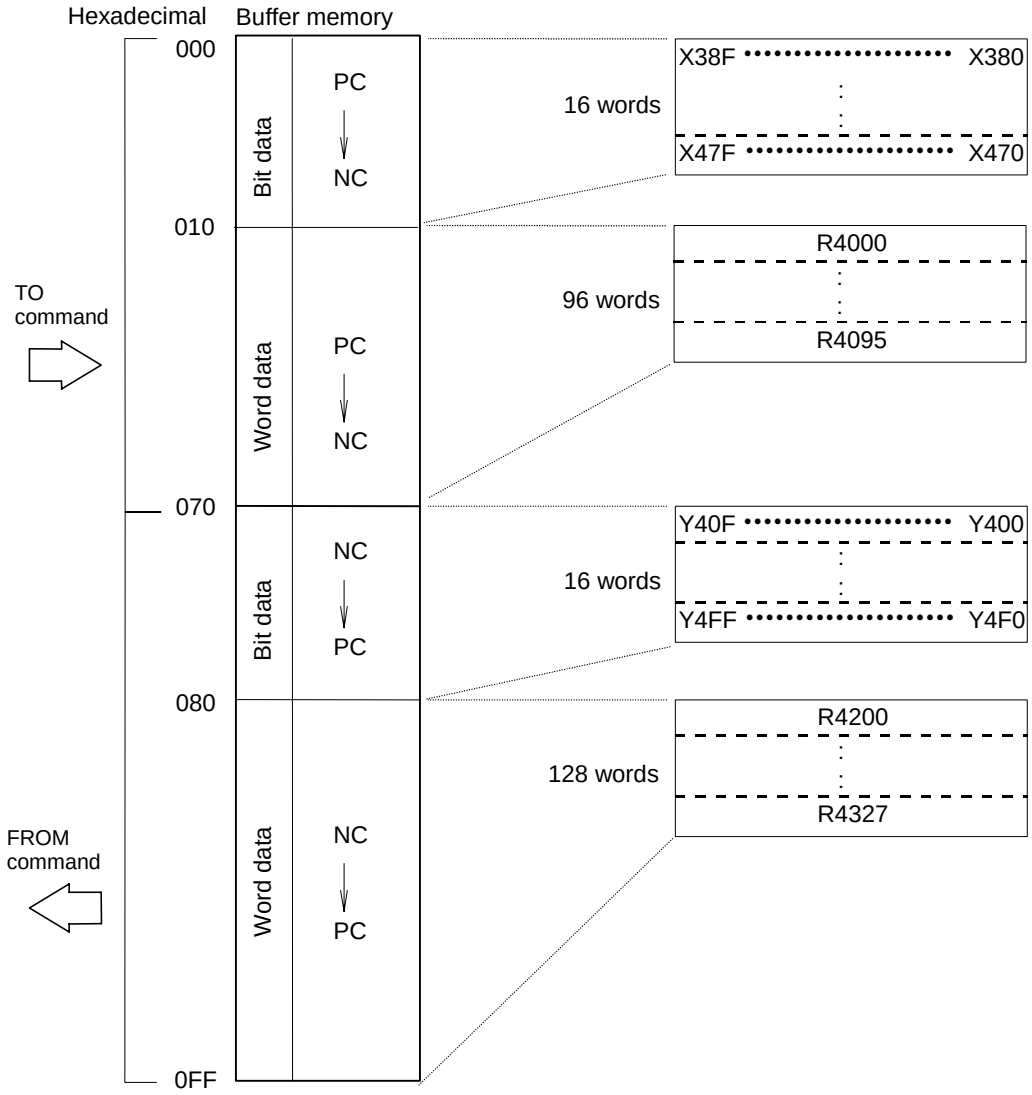
6.6.3 MELSEC Bus Connection

(1) Outline

An external PLC (Mitsubishi MELSEC-A/QnA Series) can be connected with a bus.

(2) Assigning the input/output I/F

The NC's internal buffer memory is configured of 112 words (bit data: 256 points, word data: 96 words) and 144 output words (bit data: 256 points, word data: 128 words). The input data sent from the MELSEC is stored in 000 to 06F, and is set in the NC input (X380 to X47F, R4000 to R4095) in that image.
The data set in NC output (Y400 to Y4FF, R4200 to R4327) by the built-in PLC is stored in the buffer memory 070 to FF in that image, and is sent to the MELSEC.



(3) R register

If the FROM/TO command is not executed within 500ms (when R1880 value is 48 or more), emergency stop will be applied.
The time that there is no interrupt request from MELSEC is counted and stored in the R register.
R1880: Current timeout counter
R1881: Maximum timeout counter after power ON
R1882: Maximum timeout counter after system is started up (this is backed up)

6.6.4 CC-Link

(1) Outline

An NC unit can be directly connected to the network as a MELSEC CC-Link master/local station.
The CC-Link master/local card (HR576) must be mounted into the expansion slot to connect the NC unit.
The user PLC ladder format must be GX-Developer to use this function.
The transient commands for the MELSEC A Series cannot be used when using this function.
When connecting with GOT, set the GOT as the remote device station. (It cannot be connected as an intelligent station.)

(2) Operation

The input/output signal device numbers used to control the CC-Link master/local card (HR576), mounted in the expansion slot (RT bus), with the built-in PLC are shown below.
The device numbers do not differ depending on the slot into which the card is mounted.
Refer to the MELSEC "CC-Link System Master/Local Card User's Manual" for details on the input/output signals.

(3) List of signals

Device name	Device range	Remarks
X	X0 to X1FF (Avoid overlapping with the range for real I/O)	Only remote input
Y	Y0 to Y1FF (Avoid overlapping with the range for real I/O)	Only remote output
M	M0 to M8191	Remote input, remote output, remote register (read/write), special relay, special register
L	L0 to L255	
D	D0 to D1023	
R	R4000 to R4499, R6400 to R7199	

Details of the input/output signals are shown below.

Master/local card (HR576) to NC				NC to master/local card (HR576)			
Input No.	Signal name	Usability		Output No.	Signal name	Usability	
		Master station	Local station			Master station	Local station
X480	Unit error	○	○	Y500	Refresh command	○	○
X481	Data link state at host station	○	○	Y501	(Prohibited to use)	–	–
X482	Parameter setting status	○	×	Y502			
X483	Data link status at other station	○	○	Y503			
X484	Unit reset acceptance completed	○	○	Y504	Unit reset request	○	○
X485	(Prohibited to use)	–	–	Y505	(Prohibited to use)	–	–
X486	Data link startup normal completion	○	×	Y506	Data link start request	○	×
X487	Data link startup error completion	○	×	Y507	(Prohibited to use)	–	–
X488	Data link startup by EEPROM parameter normal completion	×	×	Y508	Data link startup request from EEPROM parameter	×	×
X489	Data link startup by EEPROM parameter error completion	×	×	Y509	(Prohibited to use)	–	–
X48A	Parameter registration to EEPROM normal completion	×	×	Y50A	Parameter registration request to EEPROM	×	×
X48B	Parameter registration to EEPROM error completion	×	×	Y50B	(Prohibited to use)	–	–
X48C	(Prohibited to use)	–	–	Y50C			
X48D				Y50D			
X48E				Y50E			
X48F	Unit ready	○	○	Y50F			
X490	(Prohibited to use)	–	–	Y510			
X491				Y511			
X492				Y512			
X493				Y513			
X494				Y514			
X495				Y515			
X496				Y516			
X497				Y517			
X498				Y518			
X499				Y519			
X49A				Y51A			
X49B				Y51B			
X49C				Y51C			
X49D				Y51D			
X49E				Y51E			
X49F				Y51F			

○ : Usable, × : Not usable

To use the CC-Link function, turn the refresh instruction (Y500) ON after starting up the NC.
When the NC is the master station, turn data link start (Y506) ON.

6.6.5 MR-J2-CT Link

(1) Outline

The MR-J2-CT link function connects the NC and MR-J2-CT (auxiliary axis), and controls up to four MR-J2-CT axes using command signals from the NC.
The number of connected MR-J2-CT axes is set with the parameters.

#	Item		Details	Setting range
1044 (PR)	auxno	MR-J2-CT Connections	Specify the number of MR-J2-CTs connected.	0 to 4

(Note) The MR-J2-CT will not start up if the set number of axes is not greater than the number of actual axes.

(2) List of signals

(a) NC → MR-J2-CT (R1700 to R1723, R1784)

Signal name	J2CT control command 4	J2CT control command 3	J2CT control command 2	J2CT control command 1	J2CT control command L	J2CT control command H
Abbrev.	CTCM4	CTCM3	CTCM2	CTCM1	CTCML	CTCMH
J2CT 1st axis	R1700	R1701	R1702	R1703	R1704	R1705
J2CT 2nd axis	R1706	R1707	R1708	R1709	R1710	R1711
J2CT 3rd axis	R1712	R1713	R1714	R1715	R1716	R1717
J2CT 4th axis	R1718	R1719	R1720	R1721	R1722	R1723

J2CT control command 4 (R1700: CTCM4)		
bit	Abbrev.	Name
bit0	OV1	Override 1
bit1	OV2	Override 2
bit2	OV4	Override 4
bit3	OV8	Override 8
bit4	OV16	Override 16
bit5	OV32	Override 32
bit6	OV64	Override 64
bit7	OV	Override valid
bit8		Spare
bit9		Spare
bit10		Spare
bit11		Spare
bit12		Spare
bit13		Spare
bit14		Spare
bit15		Spare

J2CT control command 3 (R1701: CTCM3)		
bit	Abbrev.	Name
bit0	ST1	Station selection 1
bit1	ST2	Station selection 2
bit2	ST4	Station selection 4
bit3	ST8	Station selection 8
bit4	ST16	Station selection 16
bit5	ST32	Station selection 32
bit6	ST64	Station selection 64
bit7	ST128	Station selection 128
bit8	ST256	Station selection 256
bit9		Spare
bit10		Spare
bit11		Spare
bit12		Spare
bit13		Spare
bit14		Spare
bit15		Spare

J2CT control command 2 (R1702: CTCM2)		
bit	**Abbrev.**	**Name**
bit0	ST	Operation start
bit1	DIR	Rotation direction
bit2	STS	Arbitrary point feed command valid
bit3	PUS	Stopper positioning command valid
bit4	MP1	Incremental feed magnification 1
bit5	MP2	Incremental feed magnification 2
bit6	PR1	Operation parameter selection 1
bit7	PR2	Operation parameter selection 2
bit8		Spare
bit9		Spare
bit10		Spare
bit11		Spare
bit12		Spare
bit13		Spare
bit14		Spare
bit15		Spare

J2CT control command 1 (R1703: CTCM1)		
bit	**Abbrev.**	**Name**
bit0	*SVR	Servo OFF
bit1	QEMG	PLC emergency stop
bit2	*PRT1	Data protect 1
bit3	MRST	MC reset
bit4	*IT+	Interlock +
bit5	*IT-	Interlock -
bit6	RDF	Ready OFF
bit7	H	Handle mode
bit8	AUT	Automatic operation mode
bit9	MAN	Manual operation mode
bit10	J	Jog mode
bit11	ZRN	Reference position mode
bit12		
bit13	AZS	Zero point initialization mode
bit14	ZST	Basic position set
bit15	S	Incremental mode

Control command coordinate L (R1704: CTCML)		
bit	**Abbrev.**	**Name**
bit0 to bit15		Arbitrary coordinate (low-order) 1/1000mm (°) unit

Control command coordinate H (R1705: CTCMH)		
bit	**Abbrev.**	**Name**
bit0 to bit15		Arbitrary coordinate (high-order) 1/1000mm (°) unit

J2CT operation adjustment mode valid (R1784)		
bit	**Abbrev.**	**Name**
bit0	-	J2CT operation adjustment mode valid signal (common for all axes)

(b) MR-J2-CT → NC (R1600 to R1615, R1656)

Signal name	J2CT status 4	J2CT status 3	J2CT status 2	J2CT status 1
Abbrev.	CTST4	CTST3	CTST2	CTST1
J2CT 1st axis	R1600	R1601	R1602	R1603
J2CT 2nd axis	R1604	R1605	R1606	R1607
J2CT 3rd axis	R1608	R1609	R1610	R1611
J2CT 4th axis	R1612	R1613	R1614	R1615

J2CT status 4 (R1600: CTST4)		
bit	Abbrev.	Name
bit0	PSW1	Position switch 1
bit1	PSW2	Position switch 2
bit2	PSW3	Position switch 3
bit3	PSW4	Position switch 4
bit4	PSW5	Position switch 5
bit5	PSW6	Position switch 6
bit6	PSW7	Position switch 7
bit7	PSW8	Position switch 8
bit8	PMV	In positioning operation
bit9	PFN	Positioning complete
bit10	PSI	In stopper
bit11		Spare
bit12		Spare
bit13		Spare
bit14		Spare
bit15		Spare

J2CT status 3 (R1601: CTST3)		
bit	Abbrev.	Name
bit0	ST01	Station position 1
bit1	ST02	Station position 2
bit2	ST04	Station position 4
bit3	ST08	Station position 8
bit4	ST016	Station position 16
bit5	ST032	Station position 32
bit6	ST064	Station position 64
bit7	ST0128	Station position 128
bit8	ST0256	Station position 256
bit9		Spare
bit10		Spare
bit11		Spare
bit12		Spare
bit13		Spare
bit14		Spare
bit15		Spare

J2CT status 2 (R1602: CTST2)		
bit	Abbrev.	Name
bit0	AUTO	In automatic operation mode
bit1	MANO	In manual operation mode
bit2	JO	In jog mode
bit3	ARNN	In reference position return
bit4	ZRNO	In reference position return mode
bit5		
bit6	AZSO	In zero point initialization mode
bit7	SO	In incremental mode
bit8	AL1	MC alarm 1
bit9	AL2	MC alarm 2
bit10	AL4	MC alarm 4
bit11	BAL	Battery drop
bit12	ABS	Absolute position power shutoff movement over
bit13	ZSN	Absolute position loss
bit14	ZSF	Initialization set completed
bit15	ZSE	Initialization set error completed

J2CT status 1 (R1603: CTST1)		
bit	Abbrev.	Name
bit0	RDY	Servo ready
bit1	INP	In-position
bit2	SMZ	Smoothing zero
bit3	AX1	Axis selection output
bit4	MVP	In axis movement +
bit5	MVM	In axis movement -
bit6	TLQ	Reaching torque limit
bit7	ADJ	Adjusting machine
bit8	ZP	Reference position reached
bit9	RST	In reset
bit10	HO	In handle mode
bit11	MA	Controller preparation complete
bit12	SA	Servo preparation complete
bit13	JSTA	Automatic set position reached
bit14	JST	Set position reached
bit15	NEAR	Near set position

J2CT In n-th axis operation adjustment mode (R1656)		
bit	Abbrev.	Name
bit0	-	In J2CT 1st axis operation adjustment mode
bit1	-	In J2CT 2nd axis operation adjustment mode
bit2	-	In J2CT 3rd axis operation adjustment mode
bit3	-	In J2CT 4th axis operation adjustment mode

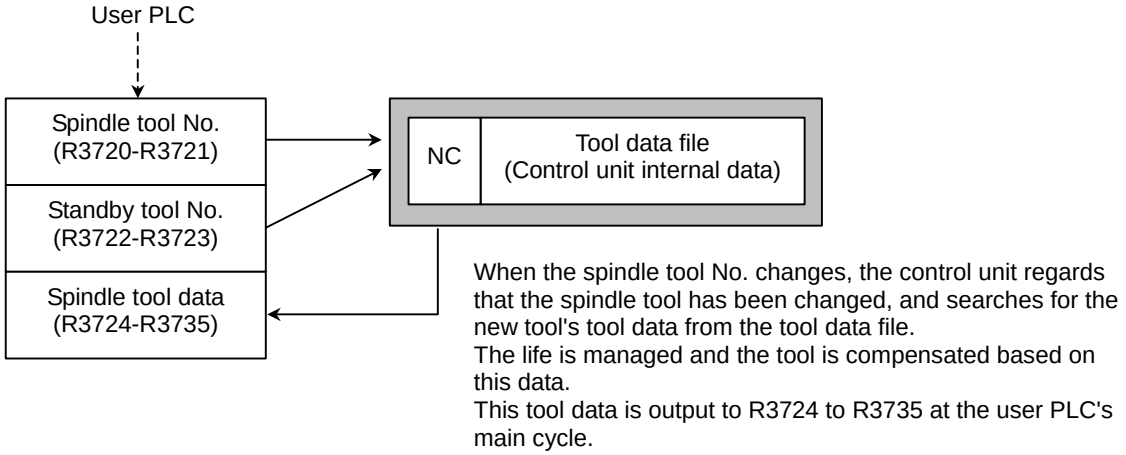
6.6.6 Other File Registers

(1) Life management interface

(a) Outline

The tool life is managed based on the spindle tool No. and standby tool No.
The spindle tool No. is used for the screen display data and for the tool for which the tool life is to be managed. The life management data for the tool to be managed is set in the spindle tool data.
The standby tool data is used as screen data.

(b) Operation



When the spindle tool No. changes, the control unit regards that the spindle tool has been changed, and searches for the new tool's tool data from the tool data file.
The life is managed and the tool is compensated based on this data.
This tool data is output to R3724 to R3735 at the user PLC's main cycle.

(c) Related signals

Tool alarm 1 (TAL1: Y2C8)
Tool alarm 2 (TAL2: Y2C9)
Data count valid (TCFF: Y2CA)
Tool life management input (TLF1: Y2CB)
Tool group number designation (R150, R151)
In tool life management (TLF0: X20B)
Tool life over (TL0V: X20E)
New tool change (TCRQ: X22C)

(2) NSK Megatorque Motor Connection Interface

(a) Outline

This function transmits commands by serial communication (RS232C specifications) to the dedicated drive unit of the NSK megatorque motor by assigning commands to the control unit from the 2nd miscellaneous function, the PLC and pulse train input.

(b) Command method

The command and numeric value following address B designated by the 2nd miscellaneous function are set as a signed binary in the R register used by the PLC. Then, the control unit creates a positioning command from the command and numeric command, and sends this to the drive unit with serial communication (RS232C specifications).
When the handle mode of the R register used by the PLC is turned ON, the pulse train input by the handle will be sent to the drive unit as a movement command.
Issue the command with the number of connected megatorque axes set in base specification parameter "#1045 nskno" (number of connected megatorque motors) and the input/output base parameter for communication set. Up to 16 axes can be connected as the megatorque motor axes.

(c) R register details

PLC → NC

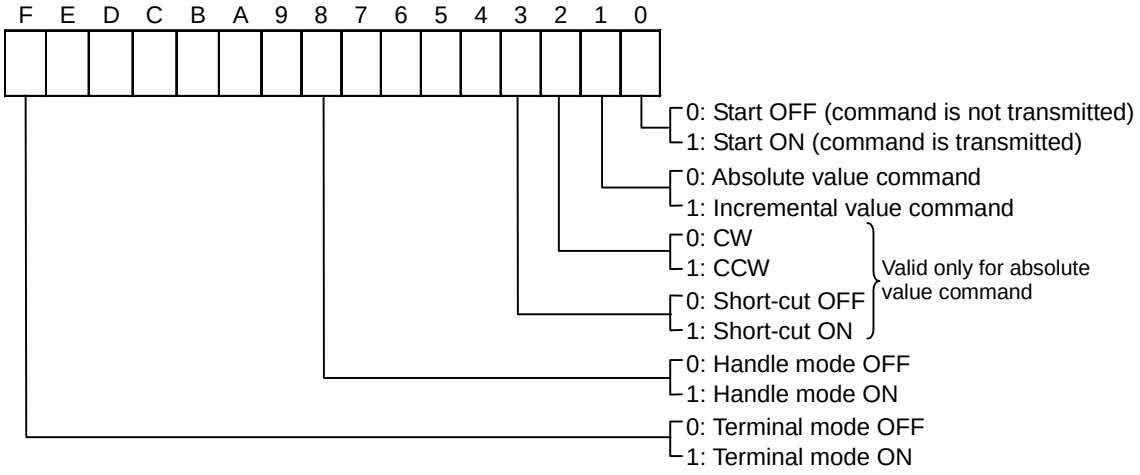
B contact	Signal name		1st axis	2nd axis	3rd axis	4th axis	5th axis	6th axis	7th axis	8th axis
—	NSK AXIS COMMAND	P C	R5000	R5006	R5012	R5018	R5024	R5030	R5036	R5042
			9th axis	10th axis	11th axis	12th axis	13th axis	14th axis	15th axis	16th axis
			R5048	R5054	R5060	R5066	R5072	R5078	R5084	R5090

[Function]

This signal sets the commands for creating and transmitting the commands to the NSK drive unit.

[Operation]

(1) This signal is valid for the axis set in the base specification parameters "#1045 nskno" (number of connected megatorque motors).
(2) Set the other commands before turning ON the start axis designation bit (bit0) for this signal.



[Cautions]

(1) Start axis designation (bit0)
  (a) When this bit is ON for several axes, the command will be set in order from the smallest axis No.
  (b) After this bit turns ON, do not turn it OFF until the status (R5001) command transmission complete bit (bit1) turns ON.
  (c) Do not turn this bit ON while the motor is rotating. If a command is transmitted while the motor is rotating, an error will occur.
  (d) Always turn this bit OFF if a command does not need to be transmitted.
  (e) When this bit is turned OFF, all statuses (R5001) other than the R232C error (R5001 bitC) will be cleared.
  (f) The positioning command will not be transmitted during the handle mode or terminal mode.
(2) CW/CCW designation (bit2)
  (a) This bit designation is valid only for the absolute value command (bit1 OFF). It is invalid for the incremental value command (bit1 ON), when the drive unit coordinate mode is set to direct coordinate system designation, or when the shortcut is ON (bit3 ON).
  (b) If the rotation direction is reversed by the drive unit's coordinate direction setting, the direction will be CCW when this bit is OFF, and CW when ON.
(3) Short-cut designation (bit3)
  (a) This bit designation is valid only for the absolute value command (bit1 OFF). It is invalid for the incremental value command (bit1 ON), or when the drive unit coordinate mode is set to direct coordinate system designation.

(4) Handle mode designation (bit8)
  (a) While this bit is ON, the other control axes (NC axis, PLC axis) cannot be selected as handle feed axes. The pulse train can be input to the megatorque axis only with the 1st handle.
  (b) If pulse train is input by the handle while the motor is rotating (rotating with a command other than the movement command by the pulse train input), an error will occur.
  (c) Turn the handle mode designation bit OFF for axes that do not need to be started.
  (d) The start axis designation bit (bit0) will be invalid even if turned ON while this bit is ON.
  (e) The movement command by the pulse train input will not be transmitted during the terminal mode.

(5) Terminal mode designation (bitF)
  (a) If this bit is ON for even one axis, the command for the megatorque axis by the 2nd miscellaneous function, the PLC and pulse train input will not be transmitted to any axes. The current position will not be updated.
  (b) Always turn this bit OFF when not using the NSK Terminal screen.

NC → PLC

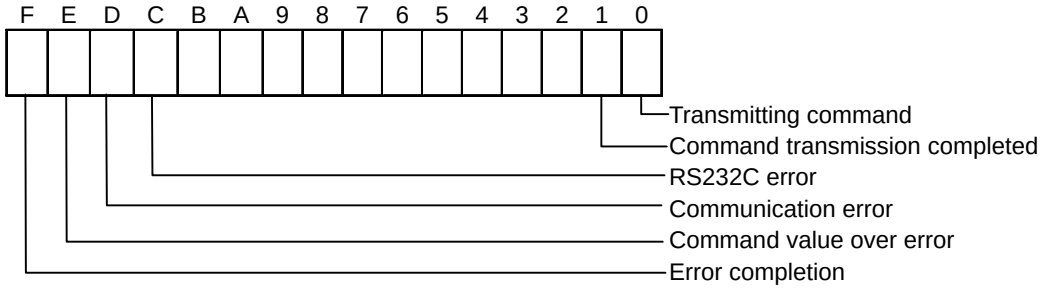
B contact	Signal name		1st axis	2nd axis	3rd axis	4th axis	5th axis	6th axis	7th axis	8th axis
—	NSK AXIS STATUS	PC	R5001	R5007	R5013	R5019	R5025	R5031	R5037	R5043
			9th axis	10th axis	11th axis	12th axis	13th axis	14th axis	15th axis	16th axis
			R5049	R5055	R5061	R5067	R5073	R5079	R5085	R5091

[Function]

This signal informs the status regarding the command transmitted to the NSK drive unit.

[Operation]

(1) This signal makes a notice regarding the axis set in the base specification parameter "#1045 nskno" (Megatorque motor connections).



(a) Transmitting command (bit0) turns ON while a command is being transmitted from the control unit to the drive unit.
(b) Command transmission completed (bit1) turns ON when the transmission of the command from the control unit to the drive unit is completed normally.
(c) RS232C error (bitC) turns ON when an error occurs in the communication control between the control unit and drive unit. This bit turns OFF when the communication control is recovered to the normal state.
(d) Communication error (bitD) turns ON when the command was not correctly transmitted from the control unit to the drive unit.
(e) Command value over error (bitE) turns ON when the command value sent from the control unit to the drive unit exceeds the valid range of the command value set in the drive unit, or when the start axis designation bit (R5000 bit0) turns ON while a command value (R5002/R5003) exceeding the setting range is set.
(f) Error completion (bitF) turns ON when a command is transmitted from the control unit to the drive unit while the motor is rotating.

[Cautions]

(1) When the start axis designation bit (R5000 bit0) turns OFF, the status command transmission completed (bit1), communication error (bitD), command value over error (bitE) and error completion (bitF) signals will turn OFF.
(2) Command transmission complete (bit1) will not be output during the handle mode (R5000 bit8 ON).
(3) During the handle mode (R5000 bit8 ON), the communication error (bitD), command value over error (bitE) and error completion (bitF) signals will be turned OFF by the control unit when the command transmission by the pulse train input is completed.

PLC → NC

B contact	Signal name		1st axis	2nd axis	3rd axis	4th axis	5th axis	6th axis	7th axis	8th axis
—	NSK AXIS COMMAND VALUE	PC	R5002,3	R5008,9	R5014,5	R5020,1	R5026,7	R5032,3	R5038,9	R5044,5
			9th axis	10th axis	11th axis	12th axis	13th axis	14th axis	15th axis	16th axis
			R5050,1	R5056,7	R5062,3	R5068,9	R5074,5	R5080,1	R5086,7	R5092,3

[Function]

The command's numerical data is notified to the control unit by setting numerical data of the command to be transmitted to the NSK drive unit as a signed binary.

[Operation]

(1) This signal is valid for the axis set in the base specification parameter "#1045 nskno" (number of connected megatorque motors).
(2) The setting range is -99999999 to 99999999 [0.001° unit].

[Cautions]

(1) When the start axis designation bit (R5000 bit0) turns OFF, the status command transmission completed (bit1), communication error (bitD), command value over error (bitE) and error completion (bitF) signals will turn OFF.

NC → PLC

B contact	Signal name		1st axis	2nd axis	3rd axis	4th axis	5th axis	6th axis	7th axis	8th axis
—	NSK AXIS CURRENT POSITION	PC	R5004,5	R5010,1	R5016,7	R5022,3	R5028,9	R5033,5	R5040,1	R5046,7
			9th axis	10th axis	11th axis	12th axis	13th axis	14th axis	15th axis	16th axis
			R5052,3	R5058,9	R5064,5	R5070,1	R5076,7	R5082,3	R5088,9	R5094,5

[Function]

This signal informs the current position of the NSK megatorque axis.

[Operation]

(1) The control unit outputs the user coordinate value of angle unit as a signed binary. (The unit is 0.001°.)
(2) This signal is valid only for the axis set in the base specification parameter "#1045 nskno" (Megatorque motor connections), and is always updated.

(3) Expanded PLC constants

(a) Outline

The parameters #6349 to #6396 can newly be used as PLC constants.
The setting range is ±8 digits. (-99999999 to 99999999).
The set data is set in the file register and backed up.

(b) Operation

#	Corresponding file register	
	HIGH side	LOW side
6349	R4901	R4900
6350	R4903	R4902
6351	R4905	R4904
6352	R4907	R4906
6353	R4909	R4908
6354	R4911	R4910
6355	R4913	R4912
6356	R4915	R4914
6357	R4917	R4916
6358	R4919	R4918
6359	R4921	R4920
6360	R4923	R4922
6361	R4925	R4924
6362	R4927	R4926
6363	R4929	R4928
6364	R4931	R4930

#	Corresponding file register	
	HIGH side	LOW side
6365	R4933	R4932
6366	R4935	R4934
6367	R4937	R4936
6368	R4939	R4938
6369	R4941	R4940
6370	R4943	R4942
6371	R4945	R4944
6372	R4947	R4946
6373	R4949	R4948
6374	R4951	R4950
6375	R4953	R4952
6376	R4955	R4954
6377	R4957	R4956
6378	R4959	R4958
6379	R4961	R4960
6380	R4963	R4962

#	Corresponding file register	
	HIGH side	LOW side
6381	R4965	R4964
6382	R4967	R4966
6383	R4969	R4968
6384	R4971	R4970
6385	R4973	R4972
6386	R4975	R4974
6387	R4977	R4976
6388	R4979	R4978
6389	R4981	R4980
6390	R4983	R4982
6391	R4985	R4984
6392	R4987	R4986
6393	R4989	R4988
6394	R4991	R4990
6395	R4993	R4992
6396	R4995	R4994

The expanded PLC constant data can be input and output with the parameters and maintenance data.

(1) Parameter input/output
The data can be input and output with "#3 PARAMETER" on the DATA IN/OUT screen.
The PLC constants in the expanded section are output with N6349 to N6396 after the conventional N6301 to N6348.

(2) Maintenance data input/output
The data can be input/output by selecting "ALL1" for "#99 MAINTENANCE DATA" on the DATA IN/OUT screen.
The PLC constants in the expanded section are input and output with the new 0 No. "0120".
The conventional PLC constants are input and output with "0105" so when backing up all PLC constants by independently designating the 0 No., output "0105" and "0120". ("0105" contains the conventional PLC constants and workpiece counter.)

7. SPINDLE CONTROL

7.1 Outline of Functions

Spindle speed can be directly controlled by a 6-digit S code command.
When the S analog function specifications are valid, the controller selects an appropriate spindle speed corresponding to the 6-digit command following the S code and outputs (spindle gear shift command) it to the machine side (PLC). The controller also outputs S command data (analog voltage or serial connection data) corresponding to the gear input (spindle gear select input) and spindle speed specified by the machine side (PLC).

7.1.1 Related Parameters

The PLC can have up to four gear stages.
The table below lists the four gear stages and the corresponding parameters.

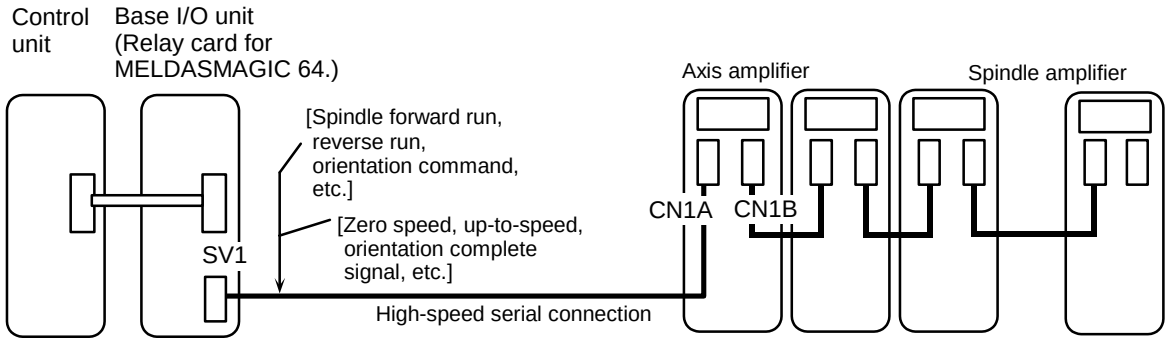
Parameters

Parameter name / Gear stage	Spindle limit speed	Maximum spindle speed	Spindle shift speed	Tap cycle maximum speed	Oriented speed	Minimum speed	Output signal		Input signal	
							GR2	GR1	GI1	GI2
1	Slimt1 #3001	Smax1 #3005	Ssift1 #3009	Stap1 #3013	Sori #3021	Smin #3023	0	0	0	0
2	Slimt2 #3002	Smax2 #3006	Ssift2 #3010	Stap2 #3014			0	1	0	1
3	Slimt3 #3003	Smax3 #3007	Ssift3 #3011	Stap3 #3015			1	0	1	0
4	Slimt4 #3004	Smax4 #3007	Ssift4 #3012	Stap4 #3016			1	1	1	1

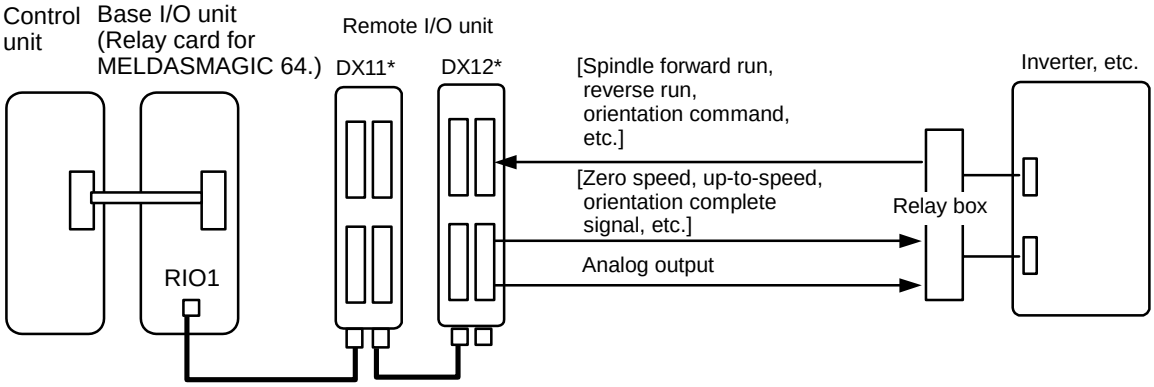
(Note 1) The upper line shows the parameter name, and the bottom line shows the parameter No.
(Note 2) Set the parameter for the gear stage not being used to 0.

7.1.2 Connection Method

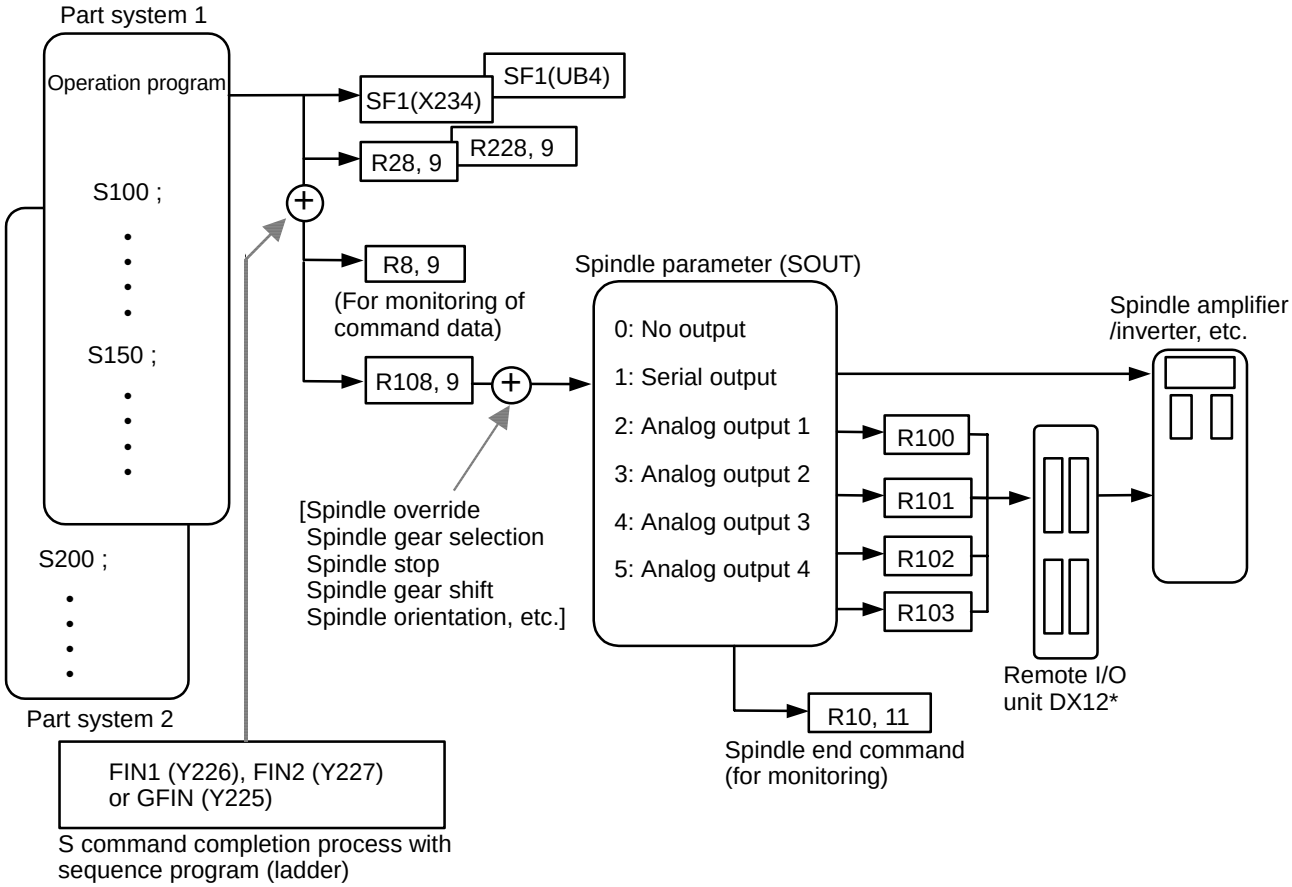
(1) To serially connect the controller and spindle controller



(2) To analog connect the controller and spindle controller



7.1.3 Flow of Spindle (S) Data



Outline explanation

(1) The spindle command start signal (SF1) is output when the spindle (S) command is issued.
(2) After the designated processes is executed by SF1 with the sequence program, the M function finish or gear shift complete signal is returned to the controller.
(3) Data corresponding to the S command is output to file registers R8 and 9 or R108 or 109 with the completion signal. The speed is output to R8, 9 and R108, 109.
(4) The R108 and 109 data is transferred to the spindle amplifier with serial communication according to the spindle parameter SOUT value or is transferred to the inverter, etc., as analog voltage via the remote I/O unit.

(Note) If the spindle command is issued from both the 1st and 2nd part systems, the command issued later will be applied.

8. HANDLING OF M, S, T, B FUNCTIONS

The following abbreviations are used in the subsequent explanations.

(1) Miscellaneous function (command) ——— M function (command)

(2) Spindle function (command) ——— S function (command)

(3) Tool function (command) ——— T function (command)

(4) 2nd miscellaneous function (command) ——— B function (command)

(5) Miscellaneous function strobe 1 to 4 ——— MF (MF1, 2, 3, 4)

(6) Spindle function strobe 1 to 4 ——— SF

(7) Tool function strobe 1 to 4 ——— TF

(8) 2nd miscellaneous function strobe ——— BF

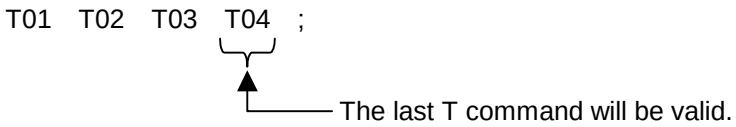
(9) Miscellaneous function finish 1, 2 ——— FIN1, FIN2

8.1 Command Format

(1) The maximum number of commands that can be issued in one block are shown below.

Function	When using built-in PLC (when released to user)	Standard PLCs
M function	4 commands	1 command (BCD2 digit)
S function	2 or 4 commands (Form : Sn = xxxx)	1 command (8-bit binary)
T function	1 command	1 command (BCD2 digit)
B function	1 command	—

(2) The command can have up to eight digits for the built-in PLC, and two digits for the standard PLC.
(3) The number of S functions depends on the model.
(4) A program error will not occur even if more commands than the maximum number are issued. The latter commands will be valid.
(EX.) When four T commands are issued though only one T command can be used.



8.2 Miscellaneous Function Finish

After the PLC (machine) finished the specified operations for the M, S, T, B commands output with automatic operation (memory, MDI, or tape) or manual numerical commands from the CNC, the finish signal will be returned to the CNC. However, there are two types of finish signals as shown below. Use these accordingly in one sequence.

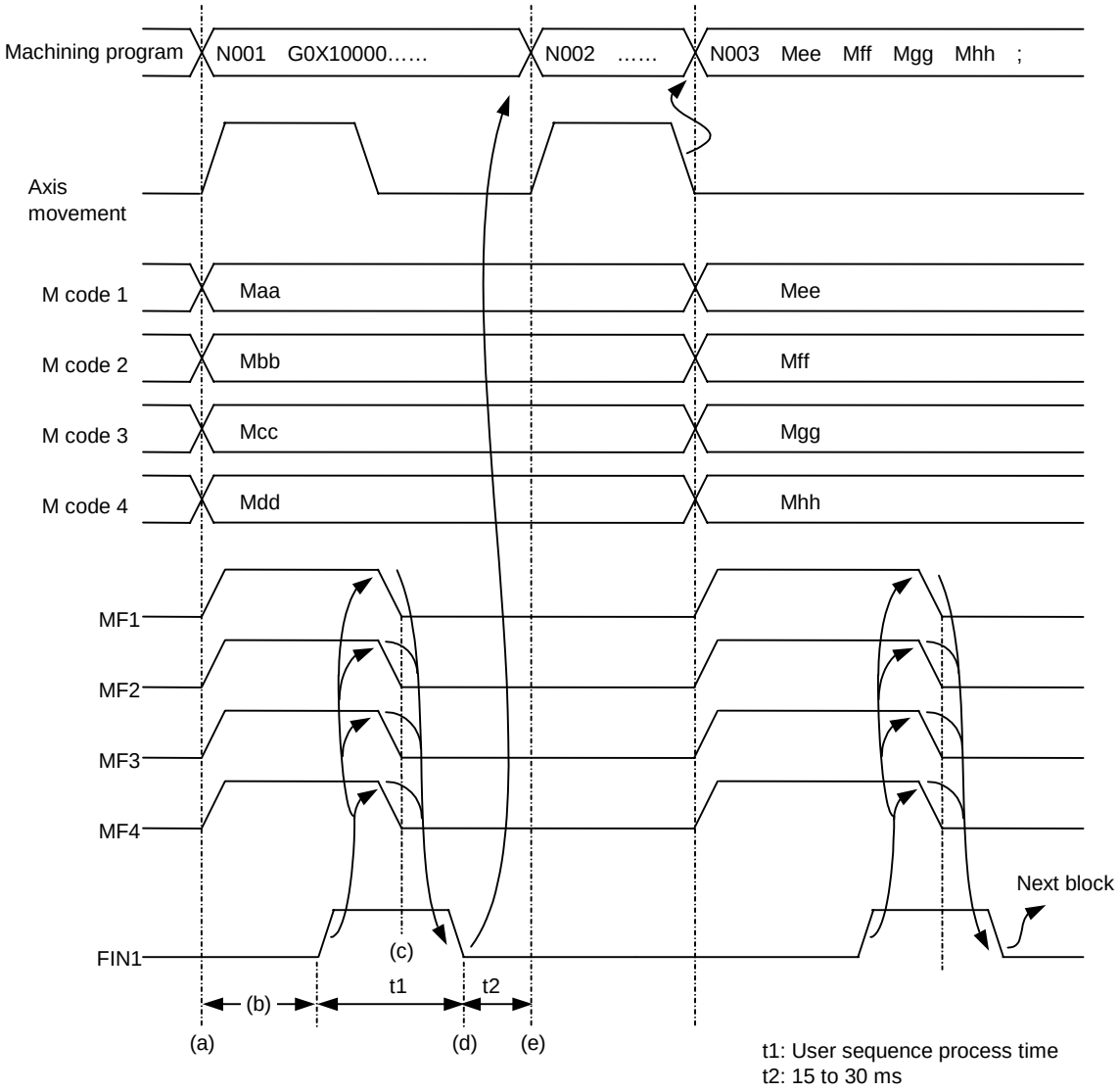
(1) FIN1 ... CNC proceeds to next block at falling edge of finish signal (FIN1).
(2) FIN2 ... CNC proceeds to next block at rising edge of finish signal (FIN2).

The details for FIN1 and FIN2 are also described in the section "6. Explanation of Interface Signals". Examples of the M function are given in the following section.

8.2.1 Operation Sequence 1 (Using FIN1 with M Command)

Machining program **(Example)**

```
N001  G0X10000  Maa  Mbb  Mcc  Mdd;
N002  G0Z–2000;
N003  Mee  Mff  Mgg  Mhh;
```



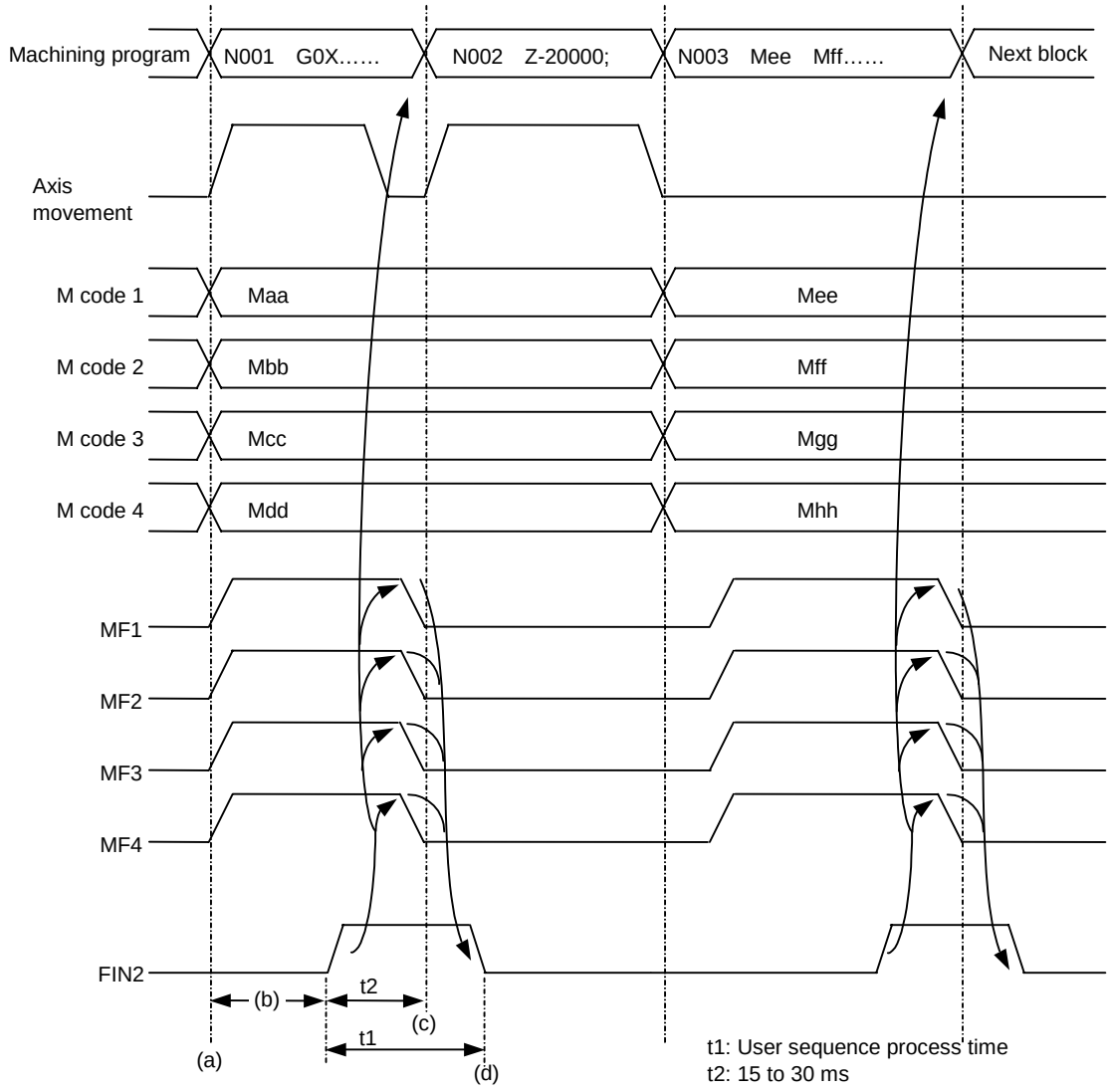
[Explanation of operation]

(a) The CNC outputs the M code data n (BCD) and MFn to the PLC (machine).
Refer to the section "8.5 Precautions Related to M, S, T, B Functions" for details on the M code data and MF output timing.
(b) The PLC (machine) confirms that the MF signal has turned ON, reads the M code data, and executes the specified operation. Then, it turns FIN1 ON.
(c) The CNC confirms that FIN1 has turned ON, and then turns MF OFF.
(d) The PLC (machine) confirms that MF has turned OFF, and then turns FIN1 OFF.
(e) The CNC confirms that FIN1 has turned OFF, and then proceeds to the next block.

8.2.2 Operation Sequence 2 (Using FIN2 with M Command)

Machining program **(Example)**

```
N001  G0X10000  Maa  Mbb  Mcc  Mdd;
N002  G0Z–20000;
N003  Mee  Mff  Mgg  Mhh;
```



[Explanation of operation]

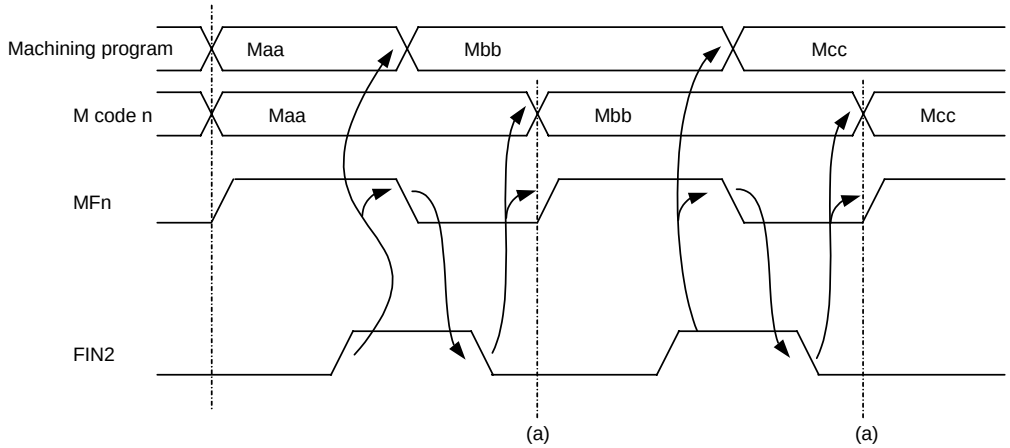
(a) The CNC outputs the M code data n (BCD) and MFn to the PLC (machine).
Refer to the section "8.5 Precautions Related to M, S, T, B Functions" for details on the M code data and MF output timing.

(b) The PLC (machine) confirms that the MF signal has turned ON, reads the M code data, and executes the specified operation. Then, it turns FIN2 ON.

(c) The CNC confirms that FIN2 has turned ON, and proceeds to the next block simultaneously with the turning OFF of MF.

(d) The PLC (machine) confirms that MF has turned OFF, and then turns FIN2 OFF.

8.2.3 When M Commands Continue (Using FIN2 with M Command)



[Explanation of operation]

The general operation is the same as "8.2.2 Operation sequence 2" on the previous page.

(a) The CNC confirms that FIN2 has turned OFF, and then output the next code signal and MF.

8.3 M Code Independent Output

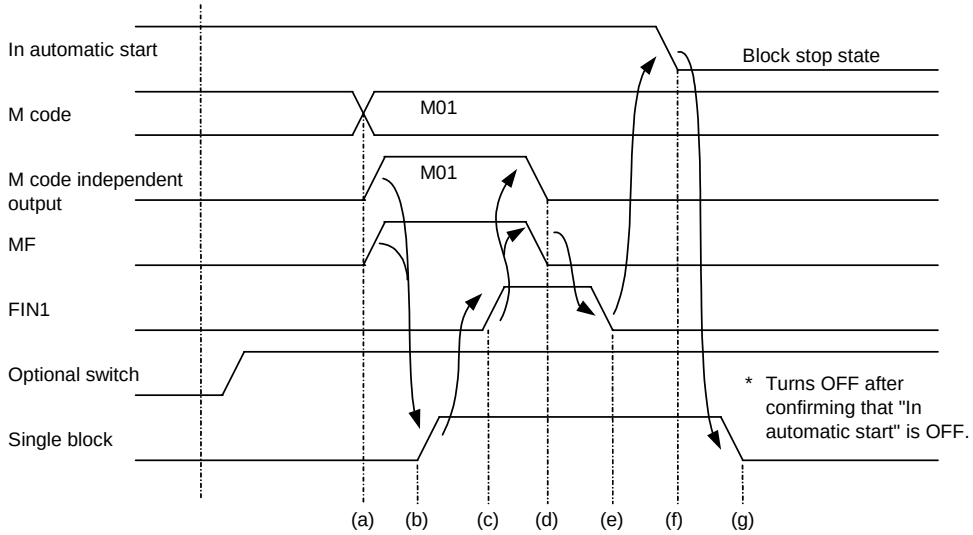
The following four types of M codes output "M code independent output" signal (decode signals) separately from their code signals and MF.
The M code independent output is generally used with the following details, but the CNC outputs only the decode signal, and the operation and finish signal processes, etc., are carried out by the user PLC (machine).

M00	Program stop	
	<Example of process>	The block stop state is entered when M00 is commanded.
M01	Optional stop	
	<Example of process>	The optional stop state is entered when M01 is commanded and the optional stop selection switch is selected.
M02, M30	Program end	
	<Example of process>	When M02 or M30 is commanded, "Reset" or "Reset & rewind" is returned to the CNC, and the reset state is entered.

8.3.1 Operation Sequence

The "M code independent output" signal turns ON when M00, M01, M02 or M30 is commanded during automatic operation (memory, MDI or tape) or by the manual numerical command, and turns OFF with the "FIN1", "FIN2", "Reset 1", "Reset 2" or "Reset & rewind" signal.

(1) Example of M01 process (stopping the block with the M01 command)



[Explanation of operation]

(a) The CNC outputs the M code data and MF to the PLC (machine).
Refer to the section "8.5 Precautions Related to M, S, T, B Functions" for details on the M code data and MF output timing.

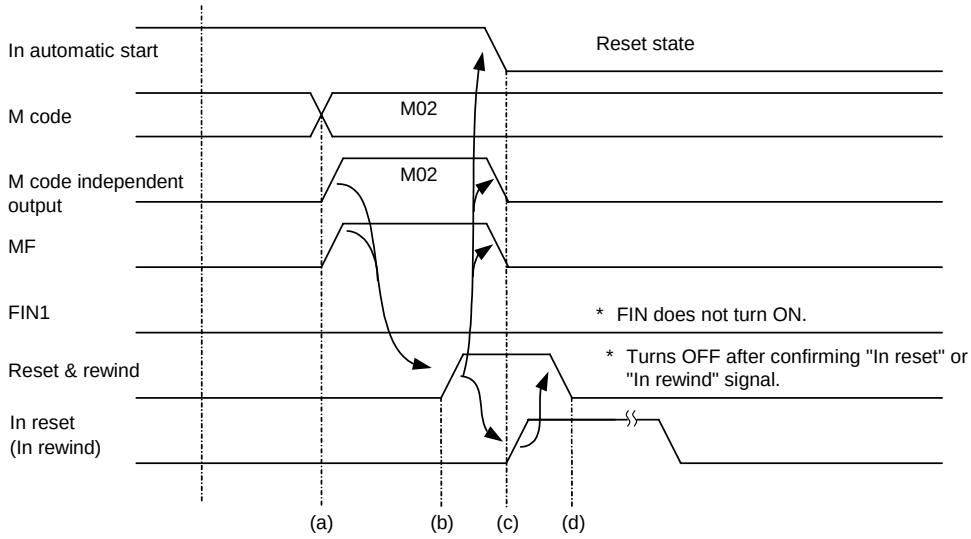
(b) (c) The PLC (machine) confirms that the MF signal has turned ON, and then carries out the specified operation. It then confirms that the "Optional switch" is ON, and then turns "Single block" and "FIN1" ON.

(d) (e) The CNC confirms that FIN1 has turned ON, and then turns the MF and "M code independent output" signal OFF. The PLC (machine) confirms that MF has turned OFF, and then turns FIN1 OFF.

(f) The CNC confirms that FIN1 has turned OFF, and then turns "In automatic start" signal OFF.

(g) The PLC (machine) confirms that "In automatic start" signal has turned OFF, and then turns the "Single block" OFF at the next automatic start.

(2) Example of M02 process (carrying out "Reset & rewind" with M02 command)



[Explanation of operation]

(a) The CNC outputs the M code data and MF to the PLC (machine).
Refer to the section "8.5 Precautions Related to M, S, T, B Functions" for details on the M code data and MF output timing.

(b) The PLC (machine) confirms that the MF signal has turned ON, and then carries out the specified operation. It then turns "Reset & rewind" ON.

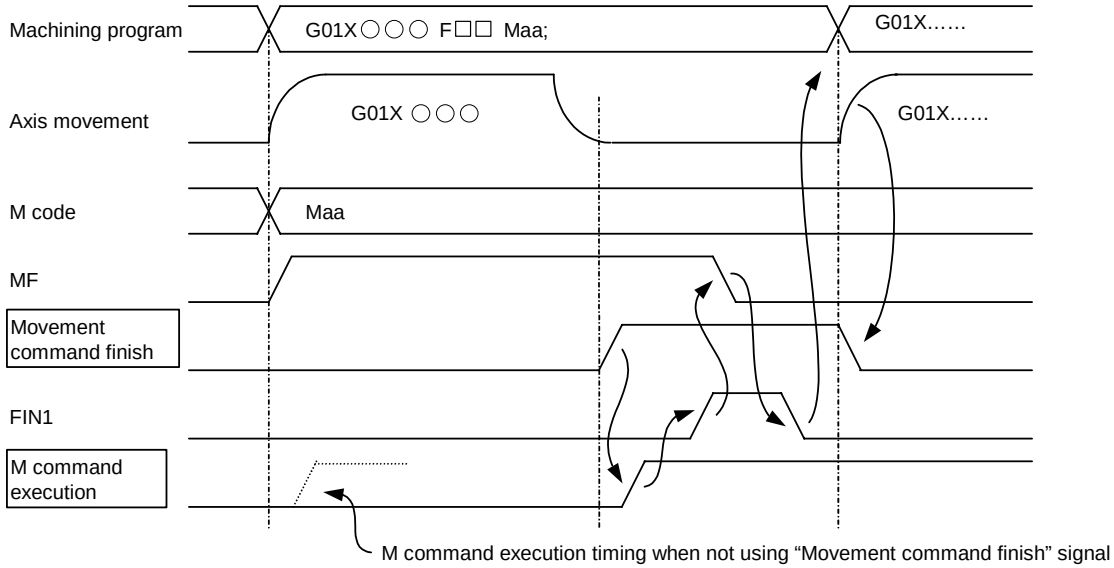
(c) The CNC confirms that "Reset & rewind" has turned ON, then turns MF, "M code independent output" and "In automatic start" OFF, and then starts the rewinding operation.

(d) The PLC (machine) confirms the "In reset" or "In rewind" signals, and then turns the "Reset & rewind" signal OFF.

8.4 Axis Movement and M Commands

If an M command is issued in the same block as a movement command, whether to process the M command simultaneously with the movement command or to process it after the movement is finished, depends on the "Movement command finish (DEN)" signal output from the CNC.

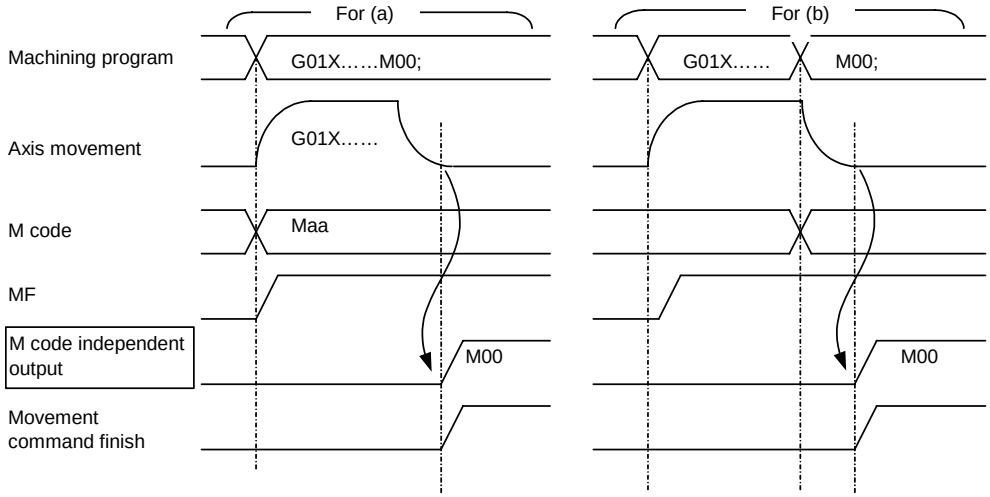
(1) Axis movement and general M command (To execute M command after movement command is finished)



(2) Axis movement and M code independent output command

(a) When the M code independent output command is issued in the same block as a movement command, the M code independent output will be output after the movement command is finished.

(b) Even when the M code independent output command is issued without movement command, it will be output after the axis movement in the previous command block is finished.



(Note 1) Refer to the section "8.3 M Code Independent Output" for details on the PLC (machine) process for the M code independent output.

8.5 Precautions Related to M, S, T, B Functions

(1) M code data and MF output timing (Also applies to S, T, B signal)
When the built-in PLC is used, the M code data n and MFn are output simultaneously to the user PLC.
When the standard PLC is used, MF is output to the machine approx. 40 to 60 ms behind the M code data.
When outputting the M code data and MF to the machine with the user PLC of built-in PLC, insert an appropriate time timer on the MF side.

(2) The finish signals (FIN1, FIN2) are commonly used for the M, S, T, B functions, so turn them ON in conditions where all function operations have been finished.

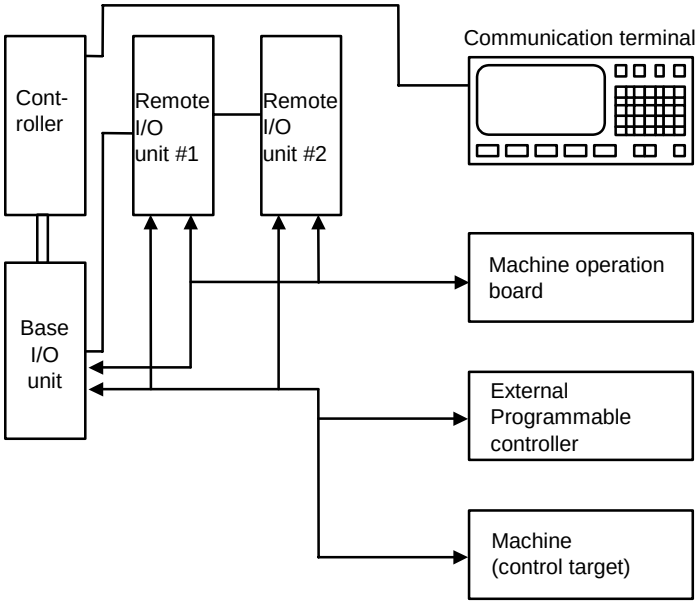
(3) When the "M function lock" signal (AFL) is turned ON, the M, S, T, B functions (including M commands in fixed cycle) issued during automatic operation (memory, MDI or tape) and manual numerical command, will not be executed. In other words, the code signal, MF, SF, TF and BF signals will not be output (updated). However, when the M code independent output (M00, M01, M02, M30) is commanded, the "M code independent output", "M code data" and MF will be output as usual.

(4) The 2nd miscellaneous (B) function can be selected from address A, B or C using the setup parameters. The "B function" refers to when address "B" is selected.

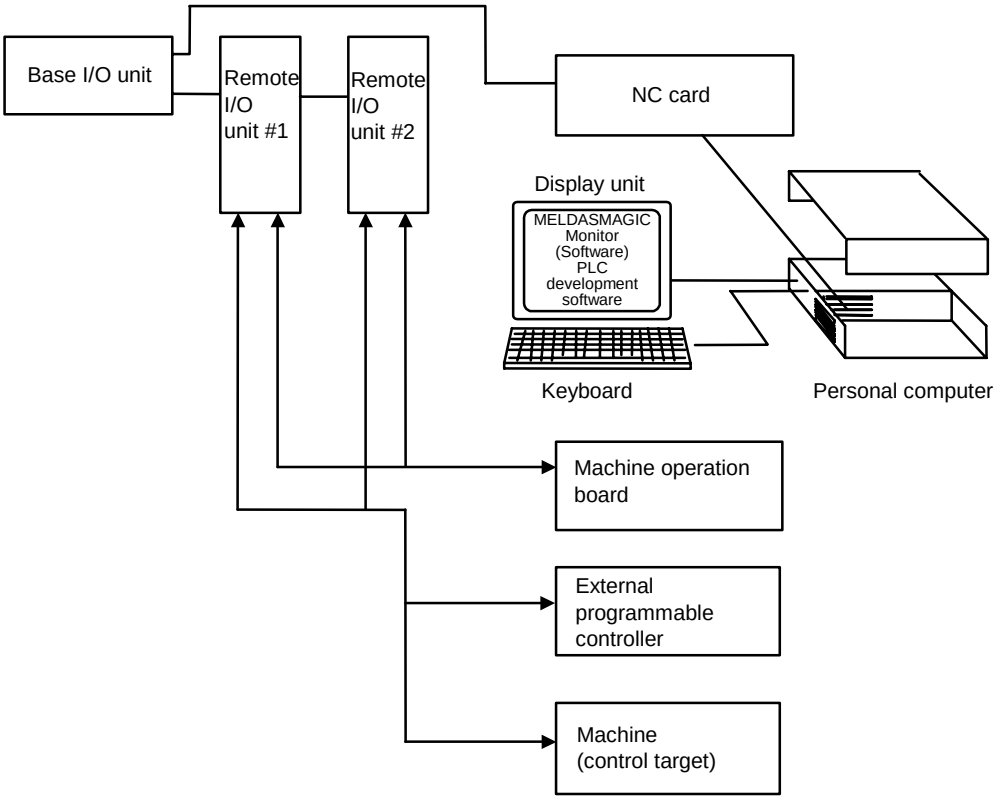
9. STANDARD PLC INTERFACE

By setting Setup parameter "#1038 plcsel" to "1", the standard PLC with fixed signal name can be selected for the base I/O Unit, remote I/O unit connector.
In this case, the required sequence processes will be carried out by the external programmable controller.

Outline configuration diagram for the M60 Series



Outline configuration diagram for the MELDASMAGIC64

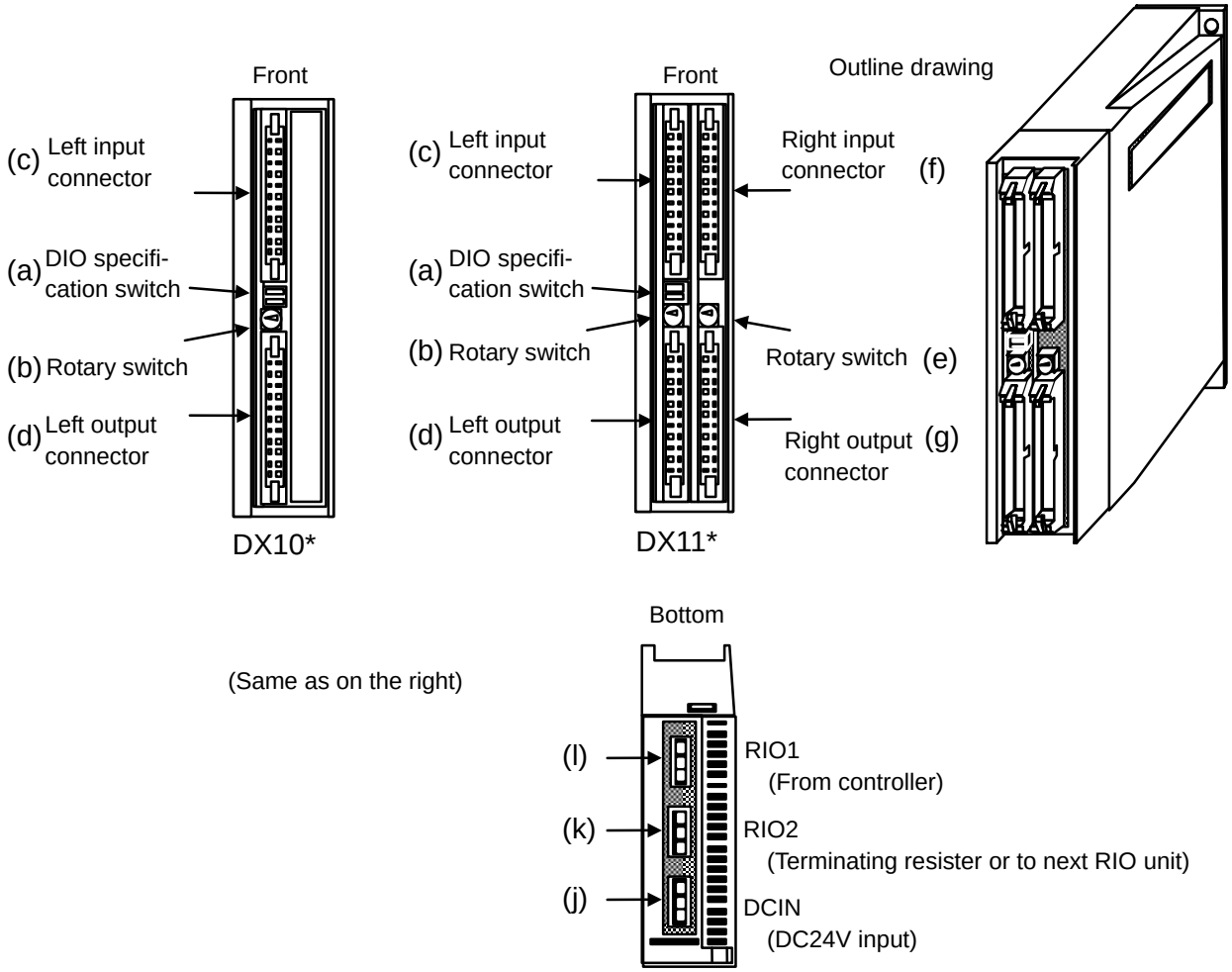


9.1 Relation of Functions and Remote I/O Unit

When using the standard PLC, Base I/O unit will be required. However, all of the functions provided with the standard PLC cannot be realized only with the base I/O unit. If the remaining functions provided by the standard PLC are to be used, another DX10* or DX11* will be required.

9.1.1 Relation of RIO Unit and Devices

The configuration of the remote I/O units (hereafter RIO unit) DX10* and DX11* are shown below. Each unit has a rotary switch for setting the unit No., and for establishing a relation with the device No. (X, Y).



No. of remote I/O unit input/output points

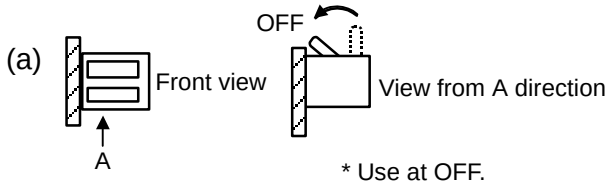
Unit model	Compatible machine control signal	Left	Right	Total
DX10* (FCUA-DX10*)	Digital input signal (DI) (Photocoupler insulation)	32 points	—	32 points
	Digital output signal (DO) (Non-insulated)	32 points	—	32 points
DX11* (FCUA-DX11*)	Digital input signal (DI) (Photocoupler insulation)	32 points	32 points	64 points
	Digital output signal (DO) (Non-insulated)	32 points	16 points	48 points

(Note) The * mark in the table is 0 when the output is a sink type, and is 1 when the output is a source type. The input is changeable.
Items (a) to (g) are described in the following pages.

(1) DIO specification setting switch

This switch is not used currently, and must always be set to OFF.

DIO specification setting switch



(2) Rotary switch for setting No. of channels

Rotary switch for setting No. of channels (b) (e)

Set between 0 and 3 (7).

The devices to be input are determined according to the rotary switch for setting No. of channels are shown below. The signals (function) corresponding to those devices will be valid. Refer to Tables 9-1-X and Tables 9-2-X for the correspondence of the devices and signals (functions).

RIO unit		Rotary switch setting No.		Read in device No.	Output device No.
First I/O unit	Left card	Rotary switch (b)	0	X00 to X1F from connector (c)	Y00 to Y1F from connector (d)
	Right card	Rotary switch (e)	1	X20 to X3F from connector (f)	Y20 to Y2F from connector (g)
Second I/O unit	Left card	Rotary switch (b)	2	X40 to X5F from connector (c)	Y40 to Y5F from connector (d)
	Right card	Rotary switch (e)	3	X60 to X7F from connector (f)	Y60 to Y6F from connector (g)

(3) Relation of connector pins and devices

Refer to the section "2.1.3 Relation of Connector Pins and Devices".

9.2 Special Process Signals

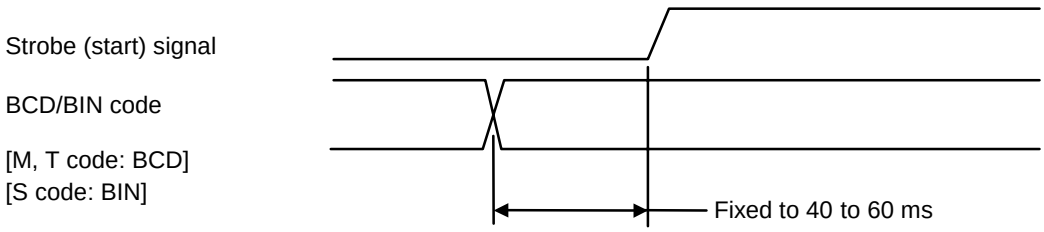
(1) Reset & rewind
The input (X24) on the second card and the reset button on the communication terminal's operation board are processed in the same manner as reset & rewind.

(2) Manual absolute
The manual absolute signal is assigned to the option remote I/O unit (third card) pins.
If there is no option remote I/O unit (third card), the manual absolute will constantly operate in the on state.
If the option remote I/O unit (third card) is mounted, the state of the X41 input signal will be followed.

(3) The data protect key, servo off, block start interlock, cutting start interlock and interlock signals are assigned to the option remote I/O unit (third/fourth card) pins. These signals are back contact handled (significant when input is open) signals, so the conventional input signal must be short circuited with the common (+24 V) to prevent the signals from operating. However, if the option remote I/O unit (third/fourth card) is not mounted, the equivalent processes will be carried out.

(4) NC alarm 1
The conventional details of the NC alarm 1 output to the second card (Y24) are the system alarm. However, if the option remote I/O unit (fourth card) is not mounted, the other alarms (NC alarms 2, 3, 4) will not be output. Thus, as long as the option remote I/O unit (fourth card) is not mounted, the logical AND of the NC alarms 1, 2, 3 and 4 will be output.
Even in this case, the output of NC alarm 4 can be prevented by setting the Setup parameter "bit selection parameter #6469 bit 0" to on.

(5) M command start, S command start, T command start output timing
The BCD/BIN code and strobe (start) timing of the M, S and T commands is shown below.



9.3 Standard PLC Input/Output Signals

The method of reading the input/output signal table is shown below.

Head device of each card

Input Signal Table from Machine

No.0: First card • • • Base I/O unit

Table 9-1-1

Device	Abbreviation	Signal name	Left upper line	Device	Abbreviation	Signal name	Left upper line
X0	ST	Automatic operatio start	B20	X8	MEM	Memory mode	B12
X1	*SP	*Automatic operation halt	B19	X9	T	Tape mode	B11
X2	SBK	Single block	B18	XA	D	MDI mode	B10
X3	DRN	Dry run	B17	XB	J	Jog mode	B09
X4	MLK	Machine lock (Supplement 1)	B16	XC	H	Handle mode	B08
X5	BDT	Optional block skip	B15	XD	S	Incremental mode	B07
X6		Z axis cancel (Supplement 2)	B14	XE	ZRN	Reference position return mode	B06
X7	AFL	Miscellaneous function lock	B13	XF	RT	Rapid traverse	B05

Device	Abbreviation	Signal name	Left upper line	Device	Abbreviation	Signal name	Left upper line
X10	HS11	Handle axis selection 1	A20	X18		* Reference position return near point detection 1	A12
X11	HS12	Handle axis selection 2	A19	X19		* Reference position return near point detection 2	A11
X12	HS14	Handle axis selection 4	A18	X1A		* Reference position return near point detection 3	A10
X13	GFIN	Gear shift completed	A17	X1B		* Reference position return near point detection 4	A09
X14	*JV1	*Manual feedrate 1	A16	X1C	ROV1	Rapid traverse override 1	A08
X15	*JV2	*Manual feedrate 2	A15	X1D	ROV2	Rapid traverse override 2	A07
X16	*JV4	*Manual feedrate 4	A14	X1E	GI1	Spindle gear select input 1	A06
X17	*JV8	*Manual feedrate 8	A13	X1F	GI2	Spindle gear select input 2	A05

No.1: Second card • • • Base I/O unit

Table 9-1-2

Device	Abbreviation	Signal name	Right upper line	Device	Abbreviation	Signal name	Right upper line
X20		*Stroke end -1	B20	X28		*Stroke end +1	B12
X21		*Stroke end -2	B19	X29		*Stroke end +2	B11
X22		*Stroke end -3	B18	X2A		*Stroke end +3	B10
X23		*Stroke end -4	B17	X2B		*Stroke end +4	B09
X24	RRW	Reset & rewind	B16	X2C	FIN1	Miscellaneous function completed 1	B08
X25		(Reset & rewind)	B15	X2D	SP1	Spindle override 1	B07
X26	*JV16	*Manual feedrate 16	B14	X2E	SP2	Spindle override 2	B06
X27		Emergency stop	B13	X2F	SP3	Spindle override 4	B05

Device	Abbreviation	Signal name	Right upper line	Device	Abbreviation	Signal name	Right upper line
X30	+J1	Axis feed direction +1	A20	X38	MP1	Incremental feed magnification 1	A12
X31	+J2	Axis feed direction +2	A19	X39	MP2	Incremental feed magnification 2	A11
X32	+J3	Axis feed direction +3	A18	X3A	MP4	Incremental feed magnification 4	A10
X33	+J4	Axis feed direction +4	A17	X3B	*FV1	*Cutting override 1	A09
X34	-J1	Axis feed direction -1	A16	X3C	*FV2	*Cutting override 2	A08
X35	-J2	Axis feed direction -2	A15	X3D	*FV4	*Cutting override 4	A07
X36	-J3	Axis feed direction -3	A14	X3E	*FV8	*Cutting override 8	A06
X37	-J4	Axis feed direction -4	A13	X3F	*FV16	*Cutting override 16	A05

(Note 1) The connector pin No. of the reference position return near-point detection and stroke end are basically fixed.
(Refer to the section "2.7 Fixed Signals".)

(Supplement 1) Machine lock is applied on all axes by turning the "Machine lock" signal on.
(Supplement 2) Machine lock is applied on the Z axis by turning the "Z axis cancel" signal on.

(Note 1) Signals marked with * in the signal name are handled as B contacts.

(Note 2) Do not connect anything to the inputs corresponding to blank columns in the table.

Input Signals from Machine

No.0: First card • • • Base I/O unit

Table 9-1-1

Device	Abbreviation	Signal name	Left upper line	Device	Abbreviation	Signal name	Left upper line
X0	ST	Auto operation start	B20	X8	MEM	Memory mode	B12
X1	*SP	*Auto operation pause	B19	X9	T	Tape mode	B11
X2	SBK	Single block	B18	XA	D	MDI mode	B10
X3	DRN	Dry run	B17	XB	J	Jog mode	B09
X4	MLK	Machine lock (Supplement 1)	B16	XC	H	Handle mode	B08
X5	BDT	Optional block skip	B15	XD	S	Incremental mode	B07
X6		Z axis cancel (Supplement 2)	B14	XE	ZRN	Reference position return mode	B06
X7	AFL	Miscellaneous function lock	B13	XF	RT	Rapid traverse	B05

Device	Abbreviation	Signal name	Left upper line	Device	Abbreviation	Signal name	Left upper line
X10	HS11	Handle axis selection 1	A20	X18		* Reference position return near point detection 1	A12
X11	HS12	Handle axis selection 2	A19	X19		* Reference position return near point detection 2	A11
X12	HS14	Handle axis selection 4	A18	X1A		* Reference position return near point detection 3	A10
X13	GFIN	Gear shift completed	A17	X1B		* Reference position return near point detection 4	A09
X14	*JV1	*Manual feedrate 1	A16	X1C	ROV1	Rapid traverse override 1	A08
X15	*JV2	*Manual feedrate 2	A15	X1D	ROV2	Rapid traverse override 2	A07
X16	*JV4	*Manual feedrate 4	A14	X1E	GI1	Spindle gear select input 1	A06
X17	*JV8	*Manual feedrate 8	A13	X1F	GI2	Spindle gear select input 2	A05

No.1: Second card • • • Base I/O unit

Table 9-1-2

Device	Abbreviation	Signal name	Right upper line	Device	Abbreviation	Signal name	Right upper line
X20		*Stroke end -1	B20	X28		*Stroke end +1	B12
X21		*Stroke end -2	B19	X29		*Stroke end +2	B11
X22		*Stroke end -3	B18	X2A		*Stroke end +3	B10
X23		*Stroke end -4	B17	X2B		*Stroke end +4	B09
X24	RRW	Reset & rewind	B16	X2C	FIN1	Miscellaneous function completed 1	B08
X25		(Reset & rewind)	B15	X2D	SP1	Spindle override 1	B07
X26	*JV16	*Manual feedrate 16	B14	X2E	SP2	Spindle override 2	B06
X27		Emergency stop	B13	X2F	SP3	Spindle override 4	B05

Device	Abbreviation	Signal name	Right upper line	Device	Abbreviation	Signal name	Right upper line
X30	+J1	Axis feed direction +1	A20	X38	MP1	Incremental feed magnification 1	A12
X31	+J2	Axis feed direction +2	A19	X39	MP2	Incremental feed magnification 2	A11
X32	+J3	Axis feed direction +3	A18	X3A	MP4	Incremental feed magnification 4	A10
X33	+J4	Axis feed direction +4	A17	X3B	*FV1	*Cutting override 1	A09
X34	-J1	Axis feed direction -1	A16	X3C	*FV2	*Cutting override 2	A08
X35	-J2	Axis feed direction -2	A15	X3D	*FV4	*Cutting override 4	A07
X36	-J3	Axis feed direction -3	A14	X3E	*FV8	*Cutting override 8	A06
X37	-J4	Axis feed direction -4	A13	X3F	*FV16	*Cutting override 16	A05

(Note 1) The connector pin No. of the reference position return near-point detection and stroke end signal are basically fixed.
(Refer to the section "2.7 Fixed Signals".)

(Supplement 1) Machine lock is applied on all axes by turning the "Machine lock" signal on.
(Supplement 2) Machine lock is applied on the Z axis by turning the "Z axis cancel" signal on.

Input Signals from Machine

No.2: Third card • • • DX1**

Table 9-1-3

Device	Abbreviation	Signal name	Left upper line	Device	Abbreviation	Signal name	Left upper line
X40	ERD	Error detect	B20	X48		(Reset & rewind)	B12
X41	ABS	Manual absolute	B19	X49	FIN2	Miscellaneous function completed 2	B11
X42	*KEY1	*Data protection key 1	B18	X4A		—	B10
X43	*KEY2	*Data protection key 2	B17	X4B		—	B09
X44	*KEY3	*Data protection key 3	B16	X4C	PB	Play back	B08
X45	SSTP	Spindle stop	B15	X4D		—	B07
X46	SSFT	Spindle gear shift	B14	X4E	OVSL	Manual override valid	B06
X47	SORC	Spindle orientation	B13	X4F	OVC	Override cancel	B05

Device	Abbreviation	Signal name	Left upper line	Device	Abbreviation	Signal name	Left upper line
X50	DTCH1	Axis detach 1	A20	X58	*SVF1	*Servo off 1	A12
X51	DTCH2	Axis detach 2	A19	X59	*SVF2	*Servo off 2	A11
X52	DTCH3	Axis detach 3	A18	X5A	*SVF3	*Servo off 3	A10
X53	DTCH4	Axis detach 4	A17	X5B	*SVF4	*Servo off 4	A09
X54		—	A16	X5C			A08
X55		—	A15	X5D			A07
X56		—	A14	X5E	SRN	Spindle forward run (For SPJ)	A06
X57		—	A13	X5F	UIT	Macro interrupt	A05

No.3: Fourth card • • • DX1**

Table 9-1-4

Device	Abbreviation	Signal name	Right upper line	Device	Abbreviation	Signal name	Right upper line
X60		—	B20	X68		—	B12
X61		—	B19	X69		—	B11
X62		—	B18	X6A		—	B10
X63		—	B17	X6B		—	B09
X64			B16	X6C			B08
X65			B15	X6D			B07
X66	*BSL	*Block start interlock	B14	X6E	SRI	Spindle reverse run (For SPJ)	B06
X67	*CSL	*Cutting block start interlock	B13	X6F	ITLK	*Interlock (Supplement 1)	B05

Device	Abbreviation	Signal name	Right upper line	Device	Abbreviation	Signal name	Right upper line
X70			A20	X78			A12
X71			A19	X79			A11
X72			A18	X7A			A10
X73			A17	X7B			A09
X74			A16	X7C			A08
X75			A15	X7D			A07
X76			A14	X7E			A06
X77			A13	X7F			A05

(Supplement 1) An interlock is applied on all axes by turning the "Interlock" signal on (actually by "turning off" as this is a B contact).

Output Signals to Machine

No.0: First card • • • Base I/O unit

Table 9-2-1

Device	Abbreviation	Signal name	Left lower line	Device	Abbreviation	Signal name	Left lower line
Y0	MA	Controller ready	B20	Y8		M-BCD code M11	B12
Y1	SA	Servo ready	B19	Y9		M-BCD code M12	B11
Y2	OP	In auto operation	B18	YA		M-BCD code M14	B10
Y3	STL	In auto operation start	B17	YB		M-BCD code M18	B09
Y4	SPL	In auto operation pause	B16	YC		M-BCD code M21	B08
Y5	RST	In reset	B15	YD		M-BCD code M22	B07
Y6	GR1	Spindle gear shift 1	B14	YE		M-BCD code M24	B06
Y7	GR2	Spindle gear shift 2	B13	YF		M-BCD code M28	B05

Device	Abbreviation	Signal name	Left lower line	Device	Abbreviation	Signal name	Left lower line
Y10		S-BIN code S1	A20	Y18		T-BCD code T11	A12
Y11		S-BIN code S2	A19	Y19		T-BCD code T12	A11
Y12		S-BIN code S4	A18	Y1A		T-BCD code T14	A10
Y13		S-BIN code S8	A17	Y1B		T-BCD code T18	A09
Y14		S-BIN code S16	A16	Y1C		T-BCD code T21	A08
Y15		S-BIN code S32	A15	Y1D		T-BCD code T22	A07
Y16		S-BIN code S64	A14	Y1E		T-BCD code T24	A06
Y17		S-BIN code S128	A13	Y1F		T-BCD code T28	A05

No.1: Second card • • • Base I/O unit

Table 9-2-2

Device	Abbreviation	Signal name	Right lower line	Device	Abbreviation	Signal name	Right lower line
Y20	ZP11	1st reference position reached 1	B20	Y28	DM00	M code independent output M00	B12
Y21	ZP12	1st reference position reached 2	B19	Y29	DM01	M code independent output M01	B11
Y22	ZP13	1st reference position reached 3	B18	Y2A	DM02	M code independent output M02	B10
Y23	ZP14	1st reference position reached 4	B17	Y2B	DM03	M code independent output M30	B09
Y24	AL1	NC alarm 1	B16	Y2C	MF1	M command strobe MF	B08
Y25			B15	Y2D	SF1	S command strobe SF	B07
Y26			B14	Y2E	TF1	T command strobe TF	B06
Y27			B13	Y2F	DEN	Motion command complete	B05

Device	Abbreviation	Signal name	—	Device	Abbreviation	Signal name	—
Y30	—	—	A20	Y38	—	—	A12
Y31	—	—	A19	Y39	—	—	A11
Y32	—	—	A18	Y3A	—	—	A10
Y33	—	—	A17	Y3B	—	—	A09
Y34	—	—	A16	Y3C	—	—	A08
Y35	—	—	A15	Y3D	—	—	A07
Y36	—	—	A14	Y3E	—	—	A06
Y37	—	—	A13	Y3F	—	—	A05

Output Signals to Machine

No.2: Third card • • • DX1**

Table 9-2-3

Device	Abbreviation	Signal name	Left lower line	Device	Abbreviation	Signal name	Left lower line
Y40	RWD	In rewind	B20	Y48	AX1	Axis selected 1st axis	B12
Y41	RPN	In rapid traverse	B19	Y49	AX2	Axis selected 2nd axis	B11
Y42	CUT	In cutting feed	B18	Y4A	AX3	Axis selected 3rd axis	B10
Y43	TAP	In tap	B17	Y4B	AX4	Axis selected 4th axis	B09
Y44	THRD	In thread cutting	B16	Y4C	RDY1	Servo ready 1st axis	B08
Y45	INCH	In inch unit select	B15	Y4D	RDY2	Servo ready 2nd axis	B07
Y46			B14	Y4E	RDY3	Servo ready 3rd axis	B06
Y47			B13	Y4F	RDY4	Servo ready 4th axis	B05

Device	Abbreviation	Signal name	Left lower line	Device	Abbreviation	Signal name	Left lower line
Y50	CSS	In constant surface speed	A20	Y58	ORAO	Spindle in-position (For SPJ)	A12
Y51	SKIP	In skip	A19	Y59			A11
Y52	F1DN	In F1-digit command	A18	Y5A			A10
Y53			A17	Y5B			A09
Y54	SYN	In synchronous feed	A16	Y5C			A08
Y55	FLO	In spindle alarm (For SPJ)	A15	Y5D			A07
Y56	ZSO	Spindle zero speed (For SPJ)	A14	Y5E			A06
Y57	USO	Spindle speed reached (For SPJ)	A13	Y5F			A05

No.3: Fourth card • • • DX1**

Table 9-2-4

Device	Abbreviation	Signal name	Right lower line	Device	Abbreviation	Signal name	Right lower line
Y60	ZP21	2nd reference position reached 1	B20	Y68	AL2	NC alarm 2	B12
Y61	ZP22	2nd reference position reached 2	B19	Y69	AL3	NC alarm 3	B11
Y62	ZP23	2nd reference position reached 3	B18	Y6A	AL4	NC alarm 4	B10
Y63	ZP24	2nd reference position reached 4	B17	Y6B	TIMP	All axes in-position	B09
Y64	MMS	Manual numeric value command	B16	Y6C	TSMZ	All axes smoothing zero	B08
Y65			B15	Y6D			B07
Y66			B14	Y6E	ZRNN	In reference position return	B06
Y67			B13	Y6F			B05

Device	Abbreviation	Signal name	—	Device	Abbreviation	Signal name	—
Y70	—	—	A20	Y78	—	—	A12
Y71	—	—	A19	Y79	—	—	A11
Y72	—	—	A18	Y7A	—	—	A10
Y73	—	—	A17	Y7B	—	—	A09
Y74	—	—	A16	Y7C	—	—	A08
Y75	—	—	A15	Y7D	—	—	A07
Y76	—	—	A14	Y7E	—	—	A06
Y77	—	—	A13	Y7F	—	—	A05

Revision History

Date of revision	Manual No.	Revision details
Feb. 1998	BNP-B2211*	First edition created.
Sept. 2002	BNP-B2211C	The contents revised to correspond to M64AS, M64S, M65S and M66S. Miswrite is corrected. Design of the cover and the back cover were changed. Manual name changed from "MELDAS64 MELDASMAGIC64 PLC Interface Manual" to "MELDAS 60/60S Series MELDASMAGIC64 PLC Interface Manual". MODEL, MODEL CODE, and Manual No. were added on the back cover. Revisions to comply with M60S Series Version B0.
May 2004	BNP-B2211D	Revisions for correspondence to M60S system software version C0. Input/output signal table arrangement revised. Explanation on interface signals added. Mistakes corrected.

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MODEL	M60 Series/MAGIC64
MODEL CODE	008-098
Manual No.	BNP-B2211D(ENG)

(0405) MEE