int CiSeries::getSpeeds()

{

GLogger.LogMessage("iSeries::getSpeeds enter\n", 3);

if (!\_adapter->mConnected)

return -1;

double spindlespeed=0, feedrate=0;

ODBSPEED speed;

/\* Data type. 0 ( feed rate ), 1 ( spindle speed ) , -1 ( all ) \*/

short ret = cnc\_rdspeed(\_adapter->mFlibhndl, -1, &speed);

if (ret == EW\_OK)

{

spindlespeed=speed.acts.data;

if(speed.acts.dec>0)

spindlespeed=spindlespeed / pow( 10.0, (double) speed.acts.dec);

feedrate=speed.actf.data;

if(speed.actf.dec>0)

feedrate=feedrate / pow( 10.0, (double) speed.actf.dec);

}

else // Error

{

GLogger.Warning(StdStringFormat("Error: iSeries::getSpeeds=%d\n", ret));

LogErrorMessage("Error: iSeries::cnc\_rdspeed", ret);

}

if(spindlespeed==0)

{

std::string feed,X, Y, Z, A, B,mode,execution;

mode=\_adapter->GetMTCTagValue("controllermode");

execution=\_adapter->GetMTCTagValue("execution");

feed=\_adapter->GetMTCTagValue("path\_feedratefrt");

X=\_adapter->GetMTCTagValue("Xabs");

Y=\_adapter->GetMTCTagValue("Yabs");

Z=\_adapter->GetMTCTagValue("Zabs");

A=\_adapter->GetMTCTagValue("Aabs");

B=\_adapter->GetMTCTagValue("Babs");

// If moving and in auto mode, assume spindle on

if( (mode == "AUTOMATIC" ) &&

(execution == "EXECUTING" )&&

(

lastFeed!=feed ||

lastX!=X ||

lastY!= Y ||

lastZ!=Z

//|| lastA!=A

//||lastB!=B

)

)

mLag=4; // 3 cycles - 3 seconds;

else

mLag--;

if(mLag<0) mLag=0;

if(mLag>0)

{

spindlespeed = 99.0; // \_adapter->SetMTCTagValue("Srpm","99.0");

}

else

{

spindlespeed = 0; // \_adapter->SetMTCTagValue("Srpm","0");

}

}

\_adapter->SetMTCTagValue("path\_feedratefrt", StdStringFormat("%8.4f", feedrate));

\_adapter->SetMTCTagValue("Srpm", StdStringFormat("%8.4f", spindlespeed));

GLogger.LogMessage("iSeries::getSpeeds done\n", 3);

GLogger.LogMessage("iSeries::getSpindleLoad\n", 5);

#if 0

short nspd;

ret = cnc\_rdnspdl(\_adapter->mFlibhndl, &nspd);

if (ret != EW\_OK)

{

LOGONCE GLogger.Fatal("iSeries::cnc\_rdnspdl Failed\n");

return -1;

}

ODBSPN \*load = static\_cast<ODBSPN \*>(alloca(nspd \* sizeof(ODBSPN)));

//ODBSPLOAD load[MAX\_SPINDLES]; /\* 4 = maximum spinlde number \*/

ret = cnc\_rdspload (\_adapter->mFlibhndl, -1, load);

if (ret != EW\_OK)

{

LOGONCE GLogger.Fatal(StdStringFormat("iSeries::cnc\_rdspload Failed\n"));

return ret;

}

\_adapter->SetMTCTagValue("Sload", StdStringFormat("%8.4f", load[0].data[0]));

#endif

GLogger.LogMessage("iSeries::getLoads Leave\n", 3);

return EW\_OK;

}