

cnc_machine3

Declaration

#include "fwlib32.h" or "fwlib64.h"

FWLIBAPI short WINAPI cnc_machine3(unsigned short FlibHndl, short axis, short length, short type, ODBAXIS *machine);

Description

Reads the machine position data of axis specified with "axis".
The machine position is stored in "data[0]" of "ODBAXIS".
All axes can be read at a time by specifying ALL_AXES for "axis".
In that case, an machine position of each axis is stored in the data array of ODBAXIS.

The decimal point position of the machine position can be acquired in the [cnc_getfigure](#) function.

You can chose whether the read data includes amount of servo delay and acceleration/deceleration delay or not by the argument "type"

Arguments

FlibHndl [in]

Specify the library handle. See "[Library handle](#)" for details.

axis [in]

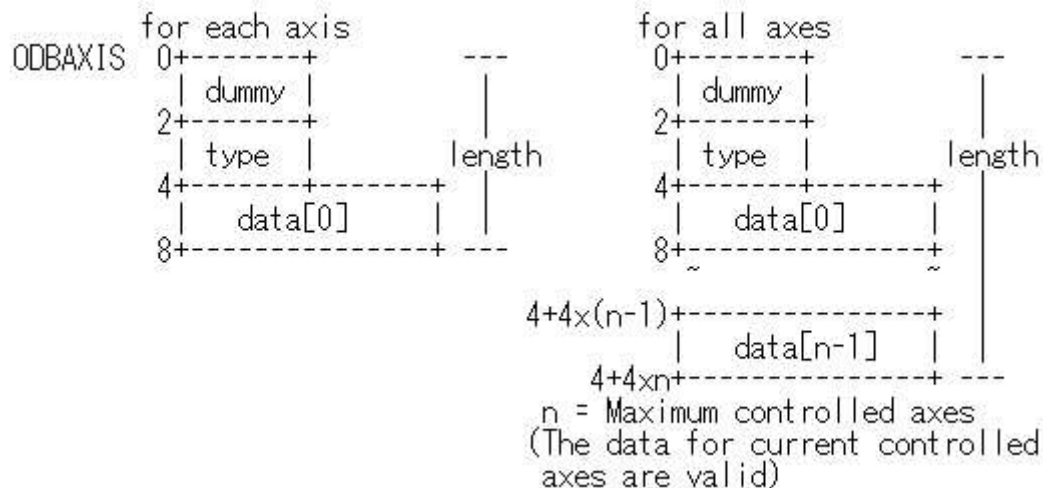
Specify axis number to read.

ALL_AXES : for all axes(ALL_AXES : -1)

1,..,m : for each axis (m : number of controlled axis)

length [in]

Specify the length of the data block(size of ODBAXIS structure)



type [in]

Specify kind of the machine position to read

Value	Position to read	Servo delay Acc/Dec delay
0	Machine position of machine unit	Included
1	Machine position depend on MCN(No.3104#0)	Not included
2	Machine position of machine unit	Not included

machine [out]

Pointer to the ODBAXIS structure including the machine position data of the controlled axes. The ODBAXIS structure is as follows.

```
typedef struct odbaxis {  
    short    dummy ;  
    short    type ;  
    long     data[MAX_AXIS] ;  
    /* Machine position data of controlled axis. */  
} ODBAXIS ;  
/* MAX_AXIS is the maximum controlled axes. */
```

Return

EW_OK is returned on successful completion, otherwise any value except EW_OK is returned.

The major error codes are as follows.

Return code	Meaning/Error handling
EW_LENGTH (2)	data block length error Size of ODBAXIS structure(length) is illegal.
EW_ATTRIB (4)	data attribute error The specification of axis number (axis) is improper.

As for the other return codes or the details, see "[Return status of Data window function](#)"

CNC option

For HSSB connection,

The extended driver/library function is necessary.

CNC parameter

This function is related to the following CNC parameter.
See the manual of CNC parameter for details.

1001#0 ---influenced by setting if "type" is 0 or 2

0000#2 ---influenced by setting if "type" is 1

3104#0 ---influenced by setting if "type" is 1

11313#7 ---influenced by setting if "type" is 0

11300#5 ---influenced by setting if "type" is 2

CNC mode

This function can be used in any CNC mode.

Available CNC

	0i-A	0i-B/C(Note)	0i-D	0i-F	15	15i	16	18	21	16i-A	18i-A	21i-A	16i-B	18i-B	21i-B	30i-A	30i-B
M (Machining)	X	X	H	H	X	X	X	X	X	X	X	X	X	X	X	H	H
T (Turning)	X	X	H	H	X	-	X	X	X	X	X	X	X	X	X	H	H
LC (Loader)	-	-	-	-	-	-	X	X	X	X	X	X	X	X	X	-	-

	0i-D	0i-F	16i	18i	30i-A	30i-B
P (Punch press)	H	H	X	X	-	H
L (Laser)	-	-	X	-	-	H
W (Wire)	-	-	X	X	X	X

Power Mate i-D	X
Power Mate i-H	X
Power Motion i-A	X

"O" : Both Ethernet and HSSB

"E" : Ethernet

"H" : HSSB

"X" : Cannot be used

"-" : None

Note) 0i-C does not support the HSSB function.