

Table 4.2 List of Standard Output Signals

	D <sub>7</sub>	D <sub>6</sub>	D <sub>5</sub>	D <sub>4</sub>	D <sub>3</sub>	D <sub>2</sub>	D <sub>1</sub>	D <sub>0</sub>
#1200	M30	M02	M01	M00	DEN	OP	SPL	STL
					POSITION- ING COM- PLETED	FEED- ING	TEMPO- RARY STOP	CYCLE START
#1201	2ZPα	2ZPZ	2ZPY	2ZPX	1ZPα	1ZPZ	1ZPY	1ZPX
	SECOND REFERENCE POINT LAMP				FIRST REFERENCE POINT LAMP			
#1202	4ZPα	4ZPZ	4ZPY	4ZPX	3ZPα	3ZPZ	3ZPY	3ZPX
	FOURTH REFERENCE POINT LAMP				THIRD REFERENCE POINT LAMP			
#1216	T8/T28	T7/T24	T6/T22	T5/T21	T4/T18	T3/T14	T2/T12	T1/T11
	T FUNCTION BINARY/BCD OUTPUT							
#1217	T16/T48	T15/T44	T14/T42	T13/T41	T12/T38	T11/T34	T10/T32	T9/T31
	T FUNCTION BINARY/BCD OUTPUT							
#1218	TAP	M04S	TLMO	G80S	EREND	ESEND	RST	AL
	TAPPING	SPINDLE	TOOL	CHANNED	EXTERNAL	EXTERNAL	RESET	ALARM
			LENGTH	CYCLE	DATA	DATA		
			MEASURE-		INPUT	INPUT		
			MENT		COMPLET-	COMPLET-		
					ED	ED		
#1219	SRV	SSP	EMF	EF	BF	TF	SF	MF
	SPINDLE	SPINDLE	MF	EXTERNAL	B-	T-	S-	M-
	REVERSE	STOP		OPERA-	FUNC-	FUNC-	FUNC-	FUNC-
				TION	TION	TION	TION	FION
	FOR CANNED CYCLE							
#1220	SB8	SB7	SB6	SB5	SB4	SB3	SB2	SB1
	S-FUNCTION BINARY OUTPUT							
#1221					SB12	SB11	SB10	SB9
	S-FUNCTION BINARY OUTPUT							
#1222	M8	M7	M6	M5	M4	M3	M2	M1
	M-FUNCTION BINARY/BCD OUTPUT							
#1223	OS	EDTS	IER	4NGC	AUTO	MAN	RDY	RWD
	ORIENTA-	EDITING	INPUT	4TH	AUTO-	MANUAL	PREPARA-	REWIND
	TION		ERROR	AXIS	MATIC		TION	
				NEBLECT			COMPLETED	