

1.1 Customize external expansion port

The system provides 6 customizable input ports, and each input port can trigger the execution of macro program files,

The switch type must be connected to a recoverable one-touch switch;

When the switch is pressed, long pressed, and released, different macro program files can be executed respectively;

The corresponding relationship is as follows:

External key	【Short press】	【release】	【Keep press】
extern key 1	extnc1-1.nc	extnc0-1.nc	extnc2-1.nc
extern key 2	extnc1-2.nc	extnc0-2.nc	extnc2-2.nc
extern key 3	extnc1-3.nc	extnc0-3.nc	extnc2-3.nc
extern key 4	extnc1-4.nc	extnc0-4.nc	extnc2-4.nc
extern key 5	extnc1-5.nc	extnc0-5.nc	extnc2-5.nc
extern key 6	extnc1-6.nc	extnc0-6.nc	extnc2-6.nc

1.1.1 Input port configuration

Enter the [IO] interface and assign pins to the expansion key 1-6;

Stat	Port Name	Enable	Pin No.	Polarity
● Fixed Probe signal		x	NULL	N
● Floating Probe signal		x	NULL	N
extern key 1		x	NULL	N
extern key 2		x	NULL	N
extern key 3		x	NULL	N
extern key 4		x	NULL	N
extern key 5		x	NULL	N
extern key 6		x	NULL	N
extern START		x	NULL	N
extern PAUSE		x	NULL	N
extern Estop		x	NULL	N
Spindle stop signal(M300)		x	NULL	N

IN	IN01	IN02	IN03	IN04	IN05	IN06	IN07	IN08	IN09	IN10	IN11	IN12	IN13
	IN14	IN15	IN16	IN17	IN18	IN19	IN20	IN21	IN22	IN23	IN24		
MPG	X1	X10	X100	HX	HY	HZ	HA	HB		2		22	
OUT	OUT01	OUT02	OUT03	OUT04	OUT05	OUT06	OUT07	OUT08	OUT09	OUT10	OUT11	OUT12	OUT13
	OUT14	OUT15	OUT16	OUT17	OUT18	OUT19	OUT20	OUT21					
▲	Out Open	Out Close		Change Polarity									

1.1.2 Executing file loading

Write the executable files extnc0-x.nc, extnc1-x.nc, extnc2-x.nc corresponding to the extension keys, and place them in the upgrade package named [install] in the folder for upgrade;