

5.8 Channel Signals

5.8.1 Signals to NC channel

Control signals to NC channel

3200		Signals to NCK channel [r/w]						
Data Block		PLC interface -----> NCK						
Byte	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
3200 0000		Activate dry run feed [F-V1]	M01 Activate [F-K1]	Single block ⁴⁾ Activate [F-K1]	DRF Activate	Forward travel Activate	Reverse travel Activate	
3200 0001	Activate program test [F-K1]						Enable protection zones	Activate referencing [F-R1]
3200 0002	Activate "Skip block 7"	Activate "Skip block 6"	Activate "Skip block 5"	Activate "Skip block 4"	Activate "Skip block 3"	Activate "Skip block 2"	Activate "Skip block 1"	Activate "Skip block 0" [F-K1]
3200 0003	Nibbling and punching							
			Stroke initiated manually 2	Delayed stroke	Stroke does not run	Stroke suppressed	Stroke initiated manually	Stroke disable
3200 0004	Feedrate override ²⁾ [F-V1]							
	H	G	F	E	D	C	B	O
3200 0005	Rapid traverse override ³⁾ [F-V1]							
	H	G	F	E	D	C	B	O
3200 0006	Feedrate override ¹⁾ active [F-V1]	Rapid traverse override active [F-V1]	Limited path velocity	Program level abort [F-K1]	Delete number of subroutine cycles	Delete distance to-go [F-A2]	Read-in disable [F-K1]	Feedrate disable [F-V1]
3200 0007			Suppress Start Lock	NC stop axes plus spindle [F-K1]	NC stop [F-K1]	NC Stop at block limit [F-K1]	NC Start [F-K1]	NC Start disable [F-K1]
3200 0008	Activate machine-related protection zone							
	Area 8	Area 7	Area 6	Area 5	Area 4	Area 3	Area 2	Area 1
3200 0009	Activate machine-related protection zone							
							Area 10	Area 9
3200 0010	Activate channel-specific protection zone							
	Area 8	Area 7	Area 6	Area 5	Area 4	Area 3	Area 2	Area 1
3200 0011	Activate channel-specific protection zone							
							Area 10	Area 9
3200 0012								