

Signals to technology functions

3800 ... 3805		Signals to axis/spindle [r/w]						
Data block		Interface PLC -----> NCK						
Byte	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
380x 5000								
380x 5001								
380x 5002								
380x 5003	Stop HIAxMove	Stop Corr	Stop DEPBCS	Stop DEPMCS	Resume HIAxMove	Resume Corr	Resume DEPBCS	Resume DEPMCS
380x 5004 (grinding) (reciprocating)	PLC controls axis	AxStop, stop	Stop at next reversal point	Change reversal point	Set reversal point	AxResum e	AxReset	OscillAxEx t Reversal
380x 5005 (grinding)								
380x 5006 (spindle)				Positionin g the spindle	Automatic gear stage change	Specified direction of rotation CCW	Specified direction of rotation CW	Spindle STOP

5.9.3 Signals from axis/spindle

General signals from axis/spindle

3900 ... 3905		Signals from axis/spindle [r]						
Data block		NCK interface -----> PLC						
Byte	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
390x 0000	Position reached with exact stop, fine [F-B1]	with exact stop, coarse [F-B1]		Reference d/synchro nized 1 [F-R1]		Encoder limit frequency exceeded 1 [F-A3]		Spindle/ no axis [F-S1]
390x 0001	Current controller active [F-A2]	Speed control loop active [F-A2]	Position controller active [F-A2]	Axis/spindl e stationary ($n < n_{min}$) [F-A2]	Follow up mode active [F-A2]			
390x 0002		Power Fixed stop limited	Fixed stop reached [F-F1]	Activate travel to fixed stop [F-F1]	Measurem ent active [F-M5]			Cam active
390x 0003								
	Motion command		Travel request Handwheel active					