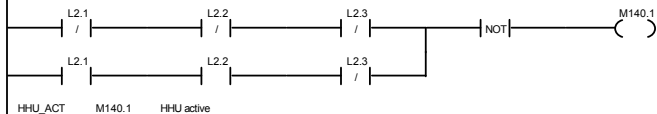


地址	名称	变量类型	数据类型	注释
	EN	IN	BOOL	
LW0	PORT	IN	WORD	No. of the handwheel port (1/2/3)
L2.0	ENABLE	IN	BOOL	P5 - Enable button
L2.1	AX_A	IN	BOOL	PIN8 - Axis code A - definition please refer properties of this subroutine
L2.2	AX_B	IN	BOOL	PIN9 - Axis code B
L2.3	AX_C	IN	BOOL	PIN10 - Axis code C
L2.4	Key_Tp	IN	BOOL	PIN11 - Traverse key +
L2.5	Key_Tn	IN	BOOL	PIN12 - Traverse key -
L2.6	Key_R	IN	BOOL	PIN13 - Rapid overlay
L2.7	INC1	IN	BOOL	PIN14 - F1 - INC1
L3.0	INC10	IN	BOOL	PIN15 - F2 - INC10
L3.1	INC100	IN	BOOL	PIN17 - F3 - INC100
		IN		
		IN_OUT		
		OUT		
L3.2	X_sel	TEMP	BOOL	
L3.3	Y_sel	TEMP	BOOL	
L3.4	Z_sel	TEMP	BOOL	
L3.5	AX4_sel	TEMP	BOOL	
L3.6	AX5_sel	TEMP	BOOL	
		TEMP		

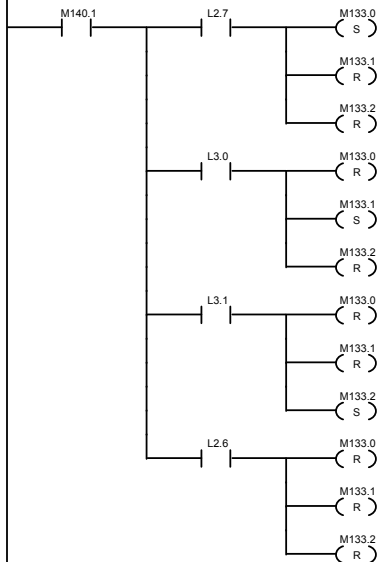
网络 1 If any one of the axis is selected, HHU is active
Axis selection:

AX_AAX_BAX_C
1 1 0 no axis selected
0 1 0Z axis selected
0 1 1X axis selected
1 1 1Y axis selected
1 0 14th axis selected
0 0 15th axis selected



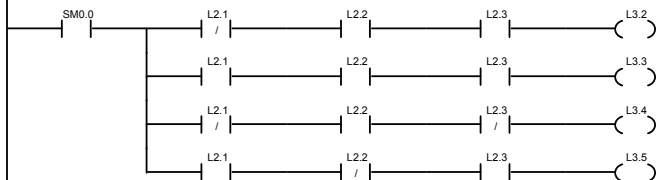
HHU_ACT M140.1 HHU active

网络 2 Increment selection for handwheel



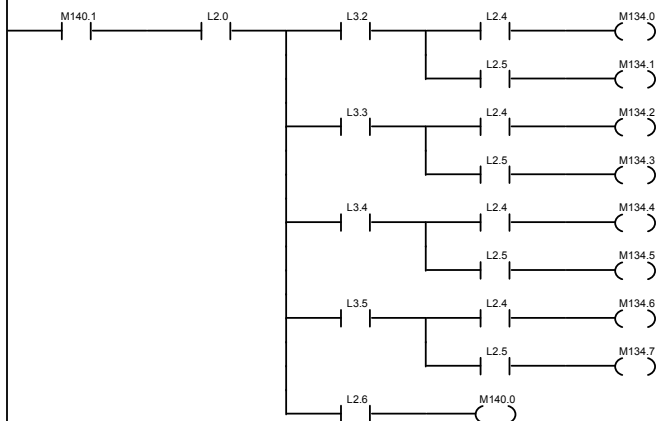
HHU_ACT M140.1 HHU active
INC_BUF_B0 M133.0 INC buffer Bit0: INC1
INC_BUF_B1 M133.1 INC buffer Bit1: INC10
INC_BUF_B2 M133.2 INC buffer Bit2: INC100

网络 3 Axis selection



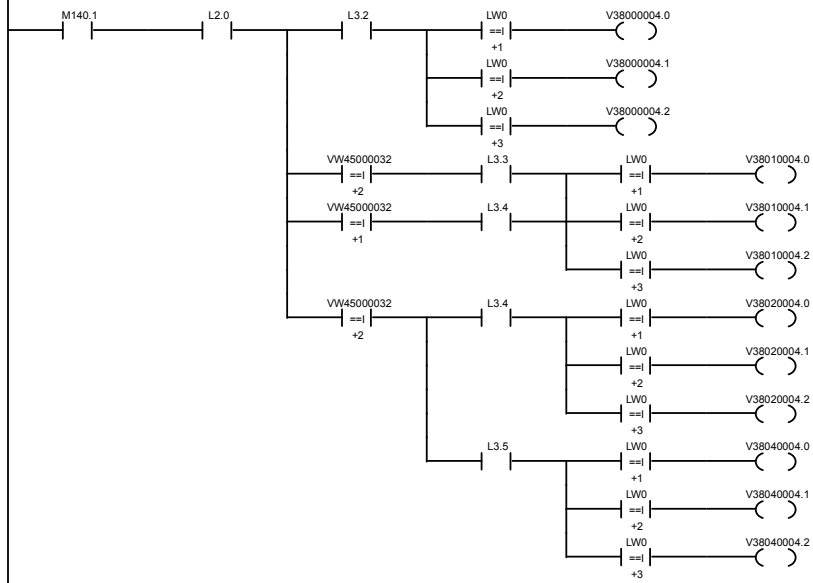
ONE SM0.0 Flag with defined ONE signal

网络 4 Traverse keys



HHU_ACT M140.1 HHU active
HHU_AX1N M134.1 HHU traverse key: 1st axis minus
HHU_AX1P M134.0 HHU traverse key: 1st axis plus
HHU_AX2N M134.3 HHU traverse key: 2nd axis minus
HHU_AX2P M134.2 HHU traverse key: 2nd axis plus
HHU_AX3N M134.5 HHU traverse key: 3rd axis minus
HHU_AX3P M134.4 HHU traverse key: 3rd axis plus
HHU_AX4N M134.7 HHU traverse key: 4th axis minus
HHU_AX4P M134.6 HHU traverse key: 4th axis plus
HHU_RAPID M140.0 HHU rapid overlay

网络 5 Handwheel selection



HHU_ACT	M140.1	HHU active
MD14510_16	VW45000032	MD14510[16]: 0: free; 1: turning; 2: milling
N_1_HW1_SEL	V38000004.0	Signal to Axis Interface: Activate Handwheel 1
N_1_HW2_SEL	V38000004.1	Signal to Axis Interface: Activate Handwheel 2
N_1_HW3_SEL	V38000004.2	Signal to Axis Interface: Activate Handwheel 3
N_2_HW1_SEL	V38010004.0	Signal to Axis Interface: Activate Handwheel 1
N_2_HW2_SEL	V38010004.1	Signal to Axis Interface: Activate Handwheel 2
N_2_HW3_SEL	V38010004.2	Signal to Axis Interface: Activate Handwheel 3
N_3_HW1_SEL	V38020004.0	Signal to Axis Interface: Activate Handwheel 1
N_3_HW2_SEL	V38020004.1	Signal to Axis Interface: Activate Handwheel 2
N_3_HW3_SEL	V38020004.2	Signal to Axis Interface: Activate Handwheel 3
N_5_HW1_SEL	V38040004.0	Signal to Axis Interface: Activate Handwheel 1
N_5_HW2_SEL	V38040004.1	Signal to Axis Interface: Activate Handwheel 2
N_5_HW3_SEL	V38040004.2	Signal to Axis Interface: Activate Handwheel 3