

双通道设置方法一：

两个通道分别设置（见 CHAN1/CHAN2 的设置）

NCK

MD10000 AXCONF_MACHAX_TAB[0]=X1
MD10000 AXCONF_MACHAX_TAB[1]=Z1
MD10000 AXCONF_MACHAX_TAB[2]=X2
MD10000 AXCONF_MACHAX_TAB[3]=Z2
MD10000 AXCONF_MACHAX_TAB[4]=C1
MD10010 ASSIGN_CHAN_TO_MODE_GROUP[0]=1
MD10010 ASSIGN_CHAN_TO_MODE_GROUP[1]=1

CHAN1

MD20050 AXCONF_GEOAX_ASSIGN_TAB[0]=1
MD20050 AXCONF_GEOAX_ASSIGN_TAB[1]=0
MD20050 AXCONF_GEOAX_ASSIGN_TAB[2]=2
MD20060 AXCONF_GEOAX_NAME_TAB[0]=X
MD20060 AXCONF_GEOAX_NAME_TAB[1]=Y
MD20060 AXCONF_GEOAX_NAME_TAB[2]=Z
MD20070 AXCONF_MACHAX_USED[0]=1
MD20070 AXCONF_MACHAX_USED[1]=2
MD20070 AXCONF_MACHAX_USED[2]=5
MD20080 AXCONF_CHANAX_NAME_TAB[0]=X
MD20080 AXCONF_CHANAX_NAME_TAB[1]=Z
MD20080 AXCONF_CHANAX_NAME_TAB[2]=C

CHAN2

MD20050 AXCONF_GEOAX_ASSIGN_TAB[0]=1
MD20050 AXCONF_GEOAX_ASSIGN_TAB[1]=0
MD20050 AXCONF_GEOAX_ASSIGN_TAB[2]=2
MD20060 AXCONF_GEOAX_NAME_TAB[0]=X
MD20060 AXCONF_GEOAX_NAME_TAB[1]=Y
MD20060 AXCONF_GEOAX_NAME_TAB[2]=Z
MD20070 AXCONF_MACHAX_USED[0]=3
MD20070 AXCONF_MACHAX_USED[1]=4
MD20070 AXCONF_MACHAX_USED[2]=0
MD20080 AXCONF_CHANAX_NAME_TAB[0]=X
MD20080 AXCONF_CHANAX_NAME_TAB[1]=Z

下图为 MD9034 MA_NUM_DISPLAYED_CHANNELS=1 时 CHAN1 和 CHAN2 的分别显示

机床坐标系下的 CHAN1

Machine	CHAN1	Auto	MPF DIR CH1P.MPF
Channel reset			
Program aborted			
ROV			
G fct + trans.			
Auxiliary functions			
Machine	Position	D-to-go	
X1	100.00000 mm	0.00000	
Z1	100.00000 mm	0.00000	
C1	0.00000 mm	0.00000	
Spindles			
Axis feedrate			
G500			
Current block MPF\CH1P.MPF			
G01X100F2000			
Feedrate [mm/min]			
Act. 0.00000 100.0 %			
Set 0.00000			
Zoom act. val.			
Tool			
Preselected tool:			
G01 G40			
Program levels			
Overstore			
DRF offset			
Program control			
Block search			
Handwheel			
Correct program			
Program overview			

机床坐标系下的 CHAN2

Machine	CHAN2	Auto	MPF DIR CH2P.MPF
Channel reset			
Program aborted			
ROV			
G fct + trans.			
Auxiliary functions			
Machine	Position	D-to-go	
X2	200.00000 mm	0.00000	
Z2	200.00000 mm	0.00000	
Spindles			
Axis feedrate			
G500			
Current block MPF\CH2P.MPF			
G01X200F2000			
Feedrate [mm/min]			
Act. 0.00000 100.0 %			
Set 0.00000			
Zoom act. val.			
Tool			
Preselected tool:			
G01 G40			
Program levels			
Overstore			
DRF offset			
Program control			
Block search			
Handwheel			
Correct program			
Program overview			

工件坐标系下的 CHAN1

Machine	CHAN1	Jog	MPF DIR CH1P.MPF
Channel reset			
Program aborted			
ROV			
G fct + trans.			
Auxiliary functions			
Work	Position	Repos offset	
X	0.00000 mm	0.00000	
Z	0.00000 mm	0.00000	
C	0.00000 mm	0.00000	
Spindles			
Axis feedrate			
G500			
Feedrate [mm/min]			
Act. 0.00000 100.0 %			
Set 0.00000			
Zoom act. val.			
Tool			
Preselected tool:			
G01 G40			
Program levels			
Overstore			
DRF offset			
Program control			
Block search			
Handwheel			
Correct program			
Program overview			

工件坐标系下的 CHAN2

Machine	CHAN2	Auto	MPF DIR CH2P.MPF
Channel reset			
Program aborted			
ROV			
G fct + trans.			
Auxiliary functions			
Work	Position	D-to-go	
X	200.00000 mm	0.00000	
Z	200.00000 mm	0.00000	
Spindles			
Axis feedrate			
G500			
Current block MPF\CH2P.MPF			
G01X200F2000			
Feedrate [mm/min]			
Act. 0.00000 100.0 %			
Set 0.00000			
Zoom act. val.			
Tool			
Preselected tool:			
G01 G40			
Program levels			
Overstore			
DRF offset			
Program control			
Block search			
Handwheel			
Correct program			
Program overview			

下图为 MD9034 MA_NUM_DISPLAYED_CHANNELS=2 时的显示，机床坐标系显示

Machine	CHAN1	Jog	MPF:DIR CH1P:MPF			
☒ Channel reset			Program aborted			
			ROV	G factor + transfer		
CHAN1 MPF\CH1P.MPF			CHAN2 MPF\CH2P.MPF			
			Auxiliary functions			
Machine	Position	Repos offset	Machine	Position	Repos offset	TFS
X1	0.00000 mm	0.00000	X2	0.00000 mm	0.00000	
Z1	0.00000 mm	0.00000	Z2	0.00000 mm	0.00000	
C1	0.00000 mm	0.00000				
						Program run
TFS			TFS			
T			T			
F			F			
0.00000		100 %	0.00000		100 %	Act. val.
0.00000		mm/min	0.00000		mm/min	MCS
S			S			

下图为 MD9034 MA_NUM_DISPLAYED_CHANNELS=2 时的显示，工件坐标系显示

Machine	CHAN1	JOG Ref	MPF:DIR CH1P:MPF	
☒ Channel reset			Program aborted	G factor + transfer
			ROV	
CHAN1 MPF:CH1P:MPF		CHAN2 MPF:CH2P:MPF		Auxiliary functions
Work	Position	Work	Position	TFS
X	0.00000 mm	X	0.00000 mm	
Z	0.00000 mm	Z	0.00000 mm	
C	0.00000 mm			
				Program run
TFS		TFS		
T		T		
F	0.00000 100 %	F	0.00000 100 %	Act. val. MCS
	0.00000 mm/min		0.00000 mm/min	
S		S		

双通道设置方法二：

两个通道相同设置，通过轴数据将轴分配给通道

NCK

MD10000 AXCONF_MACHAX_TAB[0]=X11
MD10000 AXCONF_MACHAX_TAB[1]=Z11
MD10000 AXCONF_MACHAX_TAB[2]=X21
MD10000 AXCONF_MACHAX_TAB[3]=Z21
MD10000 AXCONF_MACHAX_TAB[4]=C1
MD10010 ASSIGN_CHAN_TO_MODE_GROUP[0]=1
MD10010 ASSIGN_CHAN_TO_MODE_GROUP[1]=1

CHAN1

MD20050 AXCONF_GEOAX_ASSIGN_TAB[0]=1
MD20050 AXCONF_GEOAX_ASSIGN_TAB[1]=0
MD20050 AXCONF_GEOAX_ASSIGN_TAB[2]=2
MD20060 AXCONF_GEOAX_NAME_TAB[0]=X
MD20060 AXCONF_GEOAX_NAME_TAB[1]=Y
MD20060 AXCONF_GEOAX_NAME_TAB[2]=Z
MD20070 AXCONF_MACHAX_USED[0]=1
MD20070 AXCONF_MACHAX_USED[1]=2
MD20070 AXCONF_MACHAX_USED[2]=3
MD20070 AXCONF_MACHAX_USED[3]=4
MD20070 AXCONF_MACHAX_USED[4]=5
MD20080 AXCONF_CHANAX_NAME_TAB[0]=X1
MD20080 AXCONF_CHANAX_NAME_TAB[1]=Z1
MD20080 AXCONF_CHANAX_NAME_TAB[2]=X2
MD20080 AXCONF_CHANAX_NAME_TAB[3]=Z2
MD20080 AXCONF_CHANAX_NAME_TAB[4]=C

CHAN2

MD20050 AXCONF_GEOAX_ASSIGN_TAB[0]=3
MD20050 AXCONF_GEOAX_ASSIGN_TAB[1]=0
MD20050 AXCONF_GEOAX_ASSIGN_TAB[2]=4
MD20060 AXCONF_GEOAX_NAME_TAB[0]=X
MD20060 AXCONF_GEOAX_NAME_TAB[1]=Y
MD20060 AXCONF_GEOAX_NAME_TAB[2]=Z
MD20070 AXCONF_MACHAX_USED[0]=1
MD20070 AXCONF_MACHAX_USED[1]=2
MD20070 AXCONF_MACHAX_USED[2]=3
MD20070 AXCONF_MACHAX_USED[3]=4
MD20070 AXCONF_MACHAX_USED[4]=5
MD20080 AXCONF_CHANAX_NAME_TAB[0]=X1
MD20080 AXCONF_CHANAX_NAME_TAB[1]=Z1
MD20080 AXCONF_CHANAX_NAME_TAB[2]=X2
MD20080 AXCONF_CHANAX_NAME_TAB[3]=Z2
MD20080 AXCONF_CHANAX_NAME_TAB[4]=C

AXIS

MD30550 AXCONF_ASSIGN_MASER_CHAN=1 (X11 轴)
MD30550 AXCONF_ASSIGN_MASER_CHAN=1 (Z11 轴)
MD30550 AXCONF_ASSIGN_MASER_CHAN=2 (X21 轴)
MD30550 AXCONF_ASSIGN_MASER_CHAN=2 (Z21 轴)
MD30550 AXCONF_ASSIGN_MASER_CHAN=1 (C1 轴)

机床坐标系下的 CHAN1										机床坐标系下的 CHAN2																																																													
Machine	CHAN1		Jog	MPF:DIR CH1P:MPF		Program aborted				Machine	CHAN2		Jog	MPF:DIR CH2P:MPF		Program aborted																																																							
☒ Channel reset				ROV								☒ Channel reset				ROV																																																							
<table><tr><th>Machine</th><th>Position</th><th>Repos offset</th></tr><tr><td>X11</td><td>0.00000 mm</td><td>0.00000</td></tr><tr><td>Z11</td><td>0.00000 mm</td><td>0.00000</td></tr><tr><td>X21</td><td>0.00000 mm</td><td></td></tr><tr><td>Z21</td><td>0.00000 mm</td><td></td></tr><tr><td>C1</td><td>0.00000 mm</td><td>0.00000</td></tr></table>										Machine	Position	Repos offset	X11	0.00000 mm	0.00000	Z11	0.00000 mm	0.00000	X21	0.00000 mm		Z21	0.00000 mm		C1	0.00000 mm	0.00000	G fct + transf.		Auxiliary functions		Spindles		Axis feedrate		<table><tr><th>Machine</th><th>Position</th><th>Repos offset</th></tr><tr><td>X11</td><td>0.00000 mm</td><td></td></tr><tr><td>Z11</td><td>0.00000 mm</td><td></td></tr><tr><td>X21</td><td>0.00000 mm</td><td>0.00000</td></tr><tr><td>Z21</td><td>0.00000 mm</td><td>0.00000</td></tr><tr><td>C1</td><td>0.00000 mm</td><td></td></tr></table>										Machine	Position	Repos offset	X11	0.00000 mm		Z11	0.00000 mm		X21	0.00000 mm	0.00000	Z21	0.00000 mm	0.00000	C1	0.00000 mm		G fct + transf.		Auxiliary functions		Spindles		Axis feedrate	
Machine	Position	Repos offset																																																																					
X11	0.00000 mm	0.00000																																																																					
Z11	0.00000 mm	0.00000																																																																					
X21	0.00000 mm																																																																						
Z21	0.00000 mm																																																																						
C1	0.00000 mm	0.00000																																																																					
Machine	Position	Repos offset																																																																					
X11	0.00000 mm																																																																						
Z11	0.00000 mm																																																																						
X21	0.00000 mm	0.00000																																																																					
Z21	0.00000 mm	0.00000																																																																					
C1	0.00000 mm																																																																						
☒ G500										☒ G500																																																													
						Feedrate [mm/min]				Feedrate [mm/min]																																																													
						Act.		0.00000 100.0 %		Act.		0.00000 100.0 %																																																											
						Set		0.00000		Set		0.00000																																																											
						Tool		Act. val. WCS		Tool						Act. val. WCS																																																							
						Preselected tool:				Preselected tool:																																																													
						G01		G40		G01		G40																																																											
Preset Scratch Handwheel INC										Preset Scratch Handwheel INC																																																													

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下图为 MD9034 MA_NUM_DISPLAYED_CHANNELS=2 时的显示，机床坐标系显示

Machine			CHAN1			Jog			MPF:DIR CH1P:MPF			Program aborted			G factor + transfer					
☒ Channel reset									ROV											
CHAN1 MPF:CH1P:MPF									CHAN2 MPF:CH2P:MPF									Auxiliary functions		
Machine			Position			Repos offset			Machine			Position			Repos offset			TFS		
X11			0.00000 mm			0.00000			X21			0.00000 mm			0.00000					
Z11			0.00000 mm			0.00000			Z21			0.00000 mm			0.00000					
X21			0.00000 mm						X11			0.00000 mm								
Z21			0.00000 mm						Z11			0.00000 mm						Program run		
C1			0.00000 mm			0.00000			C1			0.00000 mm								
TFS									TFS											
T									T											
F			0.00000			100 %			F			0.00000			100 %			Act. val. MCS		
S			0.00000			mm/min			S			0.00000			mm/min					

下图为 MD9034 MA_NUM_DISPLAYED_CHANNELS=2 时的显示，工件坐标系显示

Machine		CHAN1		Jog		MPF:DIR CH1P:MPF					
☒ Channel reset						Program aborted				G factor + transfer	
						ROV					
										Auxiliary functions	
CHAN1 MPF\CH1P:MPF				CHAN2 MPF\CH2P:MPF							
Work		Position		Repos offset		Work		Position		Repos offset	
X		0.0000 mm		0.0000		X		0.0000 mm		0.0000	
Z		0.0000 mm		0.0000		Z		0.0000 mm		0.0000	
X2		0.0000 mm				X1		0.0000 mm			
Z2		0.0000 mm				Z1		0.0000 mm			
C		0.0000 mm		0.0000		C		0.0000 mm			
TFS				TFS				TFS			
T				T				T			
F				F				F			
0.0000 100 %				0.0000 100 %				0.0000 100 %			
mm/min				mm/min				mm/min			
S				S				S			

双通道设置方法二(修正):

两个通道相同设置，通过轴数据将轴分配给通道，上面方法二在显示轴的顺序上不理想所以要做个修正，注意通道 CHAN1 和 CHAN2 的数据设定。

NCK

MD10000 AXCONF_MACHAX_TAB[0]=X11
MD10000 AXCONF_MACHAX_TAB[1]=Z11
MD10000 AXCONF_MACHAX_TAB[2]=X21
MD10000 AXCONF_MACHAX_TAB[3]=Z21
MD10000 AXCONF_MACHAX_TAB[4]=C1
MD10010 ASSIGN_CHAN_TO_MODE_GROUP[0]=1
MD10010 ASSIGN_CHAN_TO_MODE_GROUP[1]=1

CHAN1

MD20050 AXCONF_GEOAX_ASSIGN_TAB[0]=1
MD20050 AXCONF_GEOAX_ASSIGN_TAB[1]=0
MD20050 AXCONF_GEOAX_ASSIGN_TAB[2]=2
MD20060 AXCONF_GEOAX_NAME_TAB[0]=X
MD20060 AXCONF_GEOAX_NAME_TAB[1]=Y
MD20060 AXCONF_GEOAX_NAME_TAB[2]=Z
MD20070 AXCONF_MACHAX_USED[0]=1
MD20070 AXCONF_MACHAX_USED[1]=2
MD20070 AXCONF_MACHAX_USED[2]=5
MD20070 AXCONF_MACHAX_USED[3]=3
MD20070 AXCONF_MACHAX_USED[4]=4
MD20080 AXCONF_CHANAX_NAME_TAB[0]=X1
MD20080 AXCONF_CHANAX_NAME_TAB[1]=Z1
MD20080 AXCONF_CHANAX_NAME_TAB[2]=C
MD20080 AXCONF_CHANAX_NAME_TAB[3]=X2
MD20080 AXCONF_CHANAX_NAME_TAB[4]=Z2

MD20050 AXCONF_GEOAX_ASSIGN_TAB[0]=1
MD20050 AXCONF_GEOAX_ASSIGN_TAB[1]=0
MD20050 AXCONF_GEOAX_ASSIGN_TAB[2]=2
MD20060 AXCONF_GEOAX_NAME_TAB[0]=X
MD20060 AXCONF_GEOAX_NAME_TAB[1]=Y
MD20060 AXCONF_GEOAX_NAME_TAB[2]=Z
MD20070 AXCONF_MACHAX_USED[0]=3
MD20070 AXCONF_MACHAX_USED[1]=4
MD20070 AXCONF_MACHAX_USED[2]=1
MD20070 AXCONF_MACHAX_USED[3]=2
MD20070 AXCONF_MACHAX_USED[4]=5
MD20080 AXCONF_CHANAX_NAME_TAB[0]=X2
MD20080 AXCONF_CHANAX_NAME_TAB[1]=Z2
MD20080 AXCONF_CHANAX_NAME_TAB[2]=X1
MD20080 AXCONF_CHANAX_NAME_TAB[3]=Z1
MD20080 AXCONF_CHANAX_NAME_TAB[4]=C

AXIS

MD30550 AXCONF_ASSIGN_MASER_CHAN=1 (X11 轴)
MD30550 AXCONF_ASSIGN_MASER_CHAN=1 (Z11 轴)
MD30550 AXCONF_ASSIGN_MASER_CHAN=2 (X21 轴)
MD30550 AXCONF_ASSIGN_MASER_CHAN=2 (Z21 轴)
MD30550 AXCONF_ASSIGN_MASER_CHAN=1 (C1 轴)

机床坐标系下的 CHAN1

Machine	CHAN1	JOG Ref	MPF DIR CH1P.MPF
Channel reset			
Program aborted			
ROV			
Machine Position			
X11	0.00000 mm		
Z11	0.00000 mm		
C1	0.00000 mm		
X21	0.00000 mm		
Z21	0.00000 mm		
Feedrate [mm/min]		REF	
Act. 0.00000 100.0 %			
Set 0.00000			
Tool			
Preselected tool:			
G01 G40			

机床坐标系下的 CHAN2

Machine	CHAN2	Jog	MPF DIR CH2P.MPF
Channel reset			
Program aborted			
ROV			
Machine Position Repetition offset			
X21	0.00000 mm	0.00000	
Z21	0.00000 mm	0.00000	
X11	0.00000 mm		
Z11	0.00000 mm		
C1	0.00000 mm		
Feedrate [mm/min]		Zoom act. val.	
Act. 0.00000 100.0 %			
Set 0.00000			
Tool		Act. val. WCS	
Preselected tool:			
G01 G40			

工件坐标系下的 CHAN1

Machine	CHAN1	Jog	MPF DIR CH1P.MPF
Channel reset			
Program aborted			
ROV			
Work Position Repetition offset			
X	0.00000 mm	0.00000	
Z	0.00000 mm	0.00000	
C	0.00000 mm	0.00000	
X21	0.00000 mm		
Z21	0.00000 mm		
Feedrate [mm/min]		Zoom act. val.	
Act. 0.00000 100.0 %			
Set 0.00000			
Tool		Act. val. MCS	
Preselected tool:			
G01 G40			

工件坐标系下的 CHAN2

Machine	CHAN2	Jog	MPF DIR CH2P.MPF
Channel reset			
Program aborted			
ROV			
Work Position Repetition offset			
X	0.00000 mm	0.00000	
Z	0.00000 mm	0.00000	
C	0.00000 mm	0.00000	
X21	0.00000 mm		
Z21	0.00000 mm		
C21	0.00000 mm		
Feedrate [mm/min]		Zoom act. val.	
Act. 0.00000 100.0 %			
Set 0.00000			
Tool		Act. val. MCS	
Preselected tool:			
G01 G40			

下图为 MD9034 MA_NUM_DISPLAYED_CHANNELS=2 时的显示，机床坐标系显示

Machine	CHAN1	JOG Ref	MPF DIR CH1P.MPF	
☒ Channel reset			Program aborted	
		ROV		G factor + transfer
				Auxiliary functions
CHAN1 MPF\CH1P.MPF		CHAN2 MPF\CH2P.MPF		TFS
Machine	Position	Machine	Position	
X11	0.00000 mm	X21	0.00000 mm	
Z11	0.00000 mm	Z21	0.00000 mm	
C1	0.00000 mm	X11	0.00000 mm	
X21	0.00000 mm	Z11	0.00000 mm	
Z21	0.00000 mm	C1	0.00000 mm	Program run
TFS		TFS		
T		T		
F	0.00000 100 %	F	0.00000 100 %	Act. vol. MCS
	0.00000 mm/min		0.00000 mm/min	
S		S		

下图为 MD9034 MA_NUM_DISPLAYED_CHANNELS=2 时的显示，工件坐标系显示

Machine	CHAN1	JOG Ref	MPF DIR CH1P.MPF	
☒ Channel reset			Program aborted	
		ROV		G factor + transfer
				Auxiliary functions
CHAN1 MPF\CH1P.MPF		CHAN2 MPF\CH2P.MPF		TFS
Work	Position	Work	Position	
X	0.00000 mm	X	0.00000 mm	
Z	0.00000 mm	Z	0.00000 mm	
C	0.00000 mm	X1	0.00000 mm	
X2	0.00000 mm	Z1	0.00000 mm	
Z2	0.00000 mm	C	0.00000 mm	Program run
TFS		TFS		
T		T		
F	0.00000 100 %	F	0.00000 100 %	Act. vol. MCS
	0.00000 mm/min		0.00000 mm/min	
S		S		



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