Mazak Adapter V1.4 Data Type OutPut By Controller

Y = Yes(supported), N = No (Not Supported), O = Optional (User selectable)

		Type	SubType	Category	Units	Comment / description	Fusion T (v1.4.0)	Fusion M (v1.4.0)	Matrix 1/2 (v1.4.0)	Smart (v1.4.0)	SmoothC (v1.4.0)	SmoothX/G (v1.4.0)
DEVICE												
		AVAILABILITY		EVENT								Y
		FUNCTIONAL_MODE		EVENT		*Optional on SmoothX/G*						O
	new in V1.4	Equipment Mode Indicators		Event		*Condition based maintenance*						Y
AXES												
		ACTUATOR		CONDITION		*Servo Alarms*						Y
		SYSTEM		CONDITION		*Spindle Alarms*						Y
	Axes-Rotary											
		LOAD		SAMPLE	PERCENT	*load For Spindle*						Y
		LOAD		SAMPLE	PERCENT	*Load For Axis*						Y
		ROTARY_MODE		EVENT		*Spindle or Contour*						Y
		ANGLE	ACTUAL	SAMPLE	DEGREE	*coordinateSystem="MACHINE*						Y
		ANGLE	ACTUAL	SAMPLE	DEGREE	*coordinateSystem="WORK"*						Y
		ROTARY_VELOCITY	ACTUAL	SAMPLE	REVOLUTION/MINUTE	*Spindle RPM*						Y
		ANGULAR_VELOCITY	ACTUAL	SAMPLE	DEGREE/SECOND	*C axis feed*						Y
		TEMPERATURE		SAMPLE	CELSIUS	*Spindle moter temp*						Y
		AXIS_STATE		EVENT		*HOME/TRAVEL/STOPPED*						Y
	new in V1.4	TEMPERATURE	ACTUAL	SAMPLE	CELSIUS	*Servo Temperature(A4 servo s/w or newer)*						Y
	Axes-Linear											
		POSITION	ACTUAL	SAMPLE	MILLIMETER	*coordinateSystem="MACHINE"*						Y
		POSITION	ACTUAL	SAMPLE	MILLIMETER	*coordinateSystem="WORK"*						Y
		LOAD		SAMPLE	PERCENT	*Load For Axis*						Y
		AXIS_FEEDRATE	ACTUAL	SAMPLE	MILLIMETER/SECOND	*Feedfor individual Axis*						Y
		AXIS_STATE		EVENT		*HOME/TRAVEL/STOPPED*						Y
	new in V1.4	TEMPERATURE	ACTUAL	SAMPLE	CELSIUS	*Servo Temperature(A4 servo s/w or newer)*						Y
CONTROLLER												
		COMMUNICATIONS		CONDITION		*Alarm Output by Category*						Y
		LOGIC_PROGRAM		CONDITION		*Alarm Output by Category*						Y
		SYSTEM		CONDITION		*Alarm Output by Category*						Y
		EMERGENCY_STOP		EVENT		*Fusion T, MT not able*						Y
		ACCUMULATED_TIME	x:AUTO	SAMPLE	SECOND	*Mazak Clock*						Y
		ACCUMULATED_TIME	x:TOTAL	SAMPLE	SECOND	*Mazak Clock*						Y
		ACCUMULATED_TIME	x:CUT	SAMPLE	SECOND	*Mazak Clock*						Y
		ACCUMULATED_TIME	x:TOTALCUTTIME	SAMPLE	SECOND	*Mazak Clock*						Y
		PALLET_ID		EVENT		*Pallet Number (not valid in palletech machine)*						Y

PATH											
	PATH_FEEDRATE_OVERRIDE	RAPID	EVENT		*Rapid override*						Y
	PATH_FEEDRATE_OVERRIDE	PROGRAMMED	EVENT		*Feed Override*						Y
	ROTARY_VELOCITY_OVERRIDE		EVENT		*Spindle Override*						Y
	PROGRAM		EVENT		*WorkNo*						Y
	PROGRAM	x:SUB	EVENT		*Sub program Work No*						Y
	PART_COUNT		EVENT		*Parts counter value*						Y
	PATH_FEEDRATE	ACTUAL	SAMPLE	MILLIMETER/SECOND	*Composite feedrate (all Axis vector)*						Y
	TOOL_NUMBER		EVENT		*Current Tool in Spindle*						Y
	EXECUTION		EVENT		*State of execution*						Y
	CONTROLLER_MODE		EVENT		*Mode of Controller(SEMI_AUTOMATIC / EDIT not suported)*						Y
	PROGRAM_COMMENT		EVENT		*Workno Comment*						Y
	PROGRAM_COMMENT	x:SUB	EVENT		*Sub WorkNo comment*						Y
	MOTION_PROGRAM		CONDITION		*Alarm Output by Category*						Y
	SYSTEM		CONDITION		*Alarm Output by Category*						Y
	x:TOOL_GROUP		EVENT		*Tool Group #*						Y
	x:TOOL_SUFFIX		EVENT		*Tool Suffix*						Y
	x:UNIT		EVENT		*Mazatrol Unit Number*						Y
	x:SEQUENCE_NUMBER		EVENT		*Mazatrol Sequence Number*						Y
new in V1.4	CONTROLLER_MODE_OVERRIDE	SINGLE_BLOCK	EVENT		*OFF/ON*						Y
new in V1.4	CONTROLLER_MODE_OVERRIDE	DRY_RUN	EVENT		*OFF/ON*						Y
new in V1.4	LINE_LABEL		EVENT		*Nxxx in program*						Y
new in V1.4	LINE_NUMBER	INCREMENTAL	EVENT								Y
ELECTRIC											
	SYSTEM		CONDITION		*Alarm Output by Category*						Y
HYDRAULIC											
	SYSTEM		CONDITION		*Alarm Output by Category*						Y
COOLANT											
	SYSTEM		CONDITION		*Alarm Output by Category*						Y
PNEUMATIC											
	SYSTEM		CONDITION		*Alarm Output by Category*						Y
LUBRICATION											
	SYSTEM		CONDITION		*Alarm Output by Category*						Y
DOOR											
	DOOR_STATE		EVENT		*CLOSED/UNLATCHED (No OPEN)*						Y
RESOURCES											
PERSONNEL											
new in V1.4	USER		EVENT		*From Smooth CNC DATAGUARD*						Y

* PLC signal address changes per machine model.

Last updated August 30, 2019 Subject to change without notice.