



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

[illegible]

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.