

Procedure Specification

Number PS01-08
Revision A

1

IOC Data Table

Number (Address)	Data Contents (Input Area)							
	7	6	5	4	3	2	1	0
00	Clock Out		Table Right Forward Limit	Table Left Forward Limit	DIP Switch SW4	DIP Switch SW3	DIP Switch SW2	DIP Switch SW1
01	Dress Encoder phase B	Dress Encoder phase A	Manual Pulse G. phase B	Manual Pulse G. phase A		Dress Encoder pulse	Manual Pulse G. pulse	NMI
02								Battery LOW
03		Table Right End Stop Limit	Pressure Check Limit	Dress Backward Limit	Dress Forward Limit	HYD. Pump ON Relay Input	Column Backward Limit	Column Forward Limit
04								
05								
06								
07								
08		Retract Auto SW (ON)	Plunge (Both edges) Feed SW	Table Stop SW	INT. Down Feed Amount $2^3 a$ $2^2 a$ $2^1 a$ $2^0 a$			
09		Manual Retract ON	Column Forward SW	Table Right Forward SW	Fine Grinding Amount $2^3 b$ $2^2 b$ $2^2 b$ $2^2 b$			
10		Dress Auto SW ON	Column Auto SW	Table Left Forward SW	Mode Setting $2^3 c$ $2^2 c$ $2^2 c$ $2^2 c$			
11		Dress Manual ON	Column Retreat SW	Feed Up Button	Fine Grinding Allowance $2^3 d$ $2^2 d$ $2^2 d$ $2^2 d$			
12		Dress Interrupt	MPG ON/OFF	Feed Down Button	Spark Out Counter $2^3 e$ $2^2 e$ $2^2 e$ $2^2 e$			
13		×10	×1	Jog Feed Button				
14		Table 取り残し Reverse button	Table Speed: High	Traverse SW				
15		Manual Dress Mode		Plunge (Right Feed Button)				



OKAMOTO MACHINE TOOL WORKS, LTD.

YOKOHAMA JAPAN

Number (Address)	Data Contents (Input Area)							
	7	6	5	4	3	2	1	0
16	Retract Amount 10^{-2}				Retract Amount 10^{-3}			
	$2^3 g$	$2^2 g$	$2^1 g$	$2^0 g$	$2^3 f$	$2^2 f$	$2^1 f$	$2^0 f$
17	Retract Amount 10^{-0}				Retract Amount 10^{-1}			
	$2^3 i$	$2^2 i$	$2^1 i$	$2^0 i$	$2^3 h$	$2^2 h$	$2^1 h$	$2^0 h$
18					Number of Dressing Time			
					$2^3 j$	$2^2 j$	$2^1 j$	$2^0 j$
19	Grinding Wheel Wearing Compensation 10^{-2}				Grinding Wheel Wearing Compensation 10^{-3}			
	$2^3 l$	$2^2 l$	$2^1 l$	$2^0 l$	$2^3 k$	$2^2 k$	$2^1 k$	$2^0 k$
20	Dress Interval 10^{-1}				Dress Interval 10^{-2}			
	$2^3 n$	$2^2 n$	$2^1 n$	$2^0 n$	$2^3 m$	$2^2 m$	$2^1 m$	$2^0 m$
21	Dress Interval: Fine 10^{-2}				Dress Interval: Fine 10^{-3}			
	$2^3 p$	$2^2 p$	$2^1 p$	$2^0 p$	$2^3 o$	$2^2 o$	$2^1 o$	$2^0 o$
22								
23								
24							SB 9	SB 1
							DGN	10^{-4}
25							SB 10	SB 1
							Reset B	10^{-3}
26							SB 10	SB 1
							Reset A	10^{-2}
27								SB 1
								10^{-1}
28								SB 1
								10^0
29								SB 1
								10^1
30								SB 1
								10^2
31								SB 1
								10^3

Number (Address)	Data Contents (Output Area)							
	7	6	5	4	3	2	1	0
3 2	W.D.T		MPG Down Pulse	MPG Up Pulse	L E D 2	L E D 1	R T S 1	R T S 0
3 3	CPU RUN Relay	Cycle End Relay	Fine Grinding Relay	Dressing Relay	In Cycl e Relay	Table Right End Stop Solenoid	Column Reverse Solenoid	Column Forward Solenoid
3 4	Table Reverse Pulse	Table High Speed Solenoid	Dress End Pulse	Cycle End Pulse	Dress Revers e Solenoi d	Dress Forward Solenoid	Table Left Forward Solenoid	Table Right Forward Solenoid
3 5								
3 6								
3 7								
3 8								
3 9								
4 0	1 st axis 7-segment display (HL1)							
	d p	g	f	e	d	c	b	a
4 1	1 st axis 7-segment display (HL2)							
	d p	g	f	e	d	c	b	a
4 2	1 st axis 7-segment display (HL3)							
	d p	g	f	e	d	c	b	a
4 3	1 st axis 7-segment display (HL4)							
	d p	g	f	e	d	c	b	a
4 4	1 st axis 7-segment display (HL5)							
	d p	g	f	e	d	c	b	a
4 5	1 st axis 7-segment display (HL6)							
	d p	g	f	e	d	c	b	a
4 6	1 st axis 7-segment display (HL7)							
	d p	g	f	e	d	c	b	a
4 7	1 st axis 7-segment display (HL8)							
	d p	g	f	e	d	c	b	a



OKAMOTO MACHINE TOOL WORKS, LTD.

YOKOHAMA JAPAN

Number (Address)	Data Contents (Output Area)							
	7	6	5	4	3	2	1	0
4 8	2 nd axis 7-segment display (HL1)							
	d p	g	f	e	d	c	b	a
4 9	2 nd axis 7-segment display (HL2)							
	d p	g	f	e	d	c	b	a
5 0	2 nd axis 7-segment display (HL3)							
	d p	g	f	e	d	c	b	a
5 1	2 nd axis 7-segment display (HL4)							
	d p	g	f	e	d	c	b	a
5 2	2 nd axis 7-segment display (HL5)							
	d p	g	f	e	d	c	b	a
5 3	2 nd axis 7-segment display (HL6)							
	d p	g	f	e	d	c	b	a
5 4	2 nd axis 7-segment display (HL7)							
	d p	g	f	e	d	c	b	a
5 5	2 nd axis 7-segment display (HL8)							
	d p	g	f	e	d	c	b	a
5 6								
5 7								
5 8								
5 9								
6 0								
6 1								
6 2								
6 3								



Number (Address)	Data Contents							
	7	6	5	4	3	2	1	0
6 4								
6 5								
6 6								
6 7								
6 8								
6 9								
7 0	Dress counter value display							
7 1	Scale counter value display							
7 2								
7 3								
7 4								
7 5								
7 6								
7 7								
7 8								
7 9								



Number (Address)	Data Contents							
	7	6	5	4	3	2	1	0
8 0								
8 1								
8 2								
8 3								
8 4								
8 5								
8 6								
8 7								
8 8								
8 9								
9 0								
9 1								
9 2	Slave 1 servo motor mechanical coordination value (Decimal)							
9 3	Slave 1 servo motor feed back coordination value (Decimal)							
9 4	Slave 1 servo motor deviation counter value (Decimal)							
9 5	Slave 1 servo motor state data value (Decimal)							

