

Data on current NC program and running status

Command	Description
SECT_PRG_MAIN_O	O: Program number (main program)
SECT_PRG_MAIN_N	N: Sequence number (main program)
SECT_PRG_MAIN_B	B: Block number (main program)
SECT_PRG_SUB_O	O: Program number (subprogram)
SECT_PRG_SUB_N	N: Sequence number (subprogram)
SECT_PRG_SUB_B	B: Block number (subprogram)
SECT_PRG_NEST	Subprogram call level
SECT_PRG_MAIN_O_DEV	Search completed main program storage destination
SECT_PRG_SUB_O_DEV	Search completed subprogram storage location
SECT_G_GROUP1	G command value (group 1 command)
SECT_G_GROUP2	G command value (Group 2 command)
SECT_G_GROUP3	G command value (Group 3 command)
SECT_G_GROUP4	G command value (group 4 command)
SECT_G_GROUP5	G command value (group 5 command)
SECT_G_GROUP6	G command value (group 6 command)
SECT_G_GROUP7	G command value (group 7 command)
SECT_G_GROUP8	G command value (group 8 command)
SECT_G_GROUP9	G command value (group 9 directive)
SECT_G_GROUP10	G command value (group 10 command)
SECT_G_GROUP11	G command value (group 11 command)
SECT_G_GROUP12	G command value (group 12 command)
SECT_G_GROUP13	G command value (group 13 command)
SECT_G_GROUP14	G command value (group 14 command)
SECT_G_GROUP15	G command value (group 15 command)
SECT_G_GROUP16	G command value (group 16 command)
SECT_G_GROUP17	G command value (group 17 command)
SECT_G_GROUP18	G command value (group 18 command)
SECT_G_GROUP19	G command value (group 19 directive)
SECT_G_GROUP20	G command value (group 20 command)
SECT_G_GROUP21	G command value (group 21 command)

SECT_G_GROUP22	G command value (group 22 command)
SECT_G_GROUP23	G command value (group 23 command)
SECT_G_GROUP24	G command value (group 24 command)
SECT_G_GROUP25	G command value (group 25 command)
SECT_G_GROUP26	G command value (group 26 command)
SECT_G_GROUP27	G command value (group 27 directive)
SECT_G_GROUP28	G command value (group 28 command)
SECT_G_GROUP29	G command value (group 29 command)
SECT_G_GROUP30	G command value (group 30 command)
SECT_FA	FA: F command feed speed
SECT_FS	FS: Synchronous feed speed
SECT_FC	Fc: Automatic effective feedrate
SECT_FE	FE: Screw lead
SECT_DWELL	Dwell remaining time
SECT_SINGLE_B_STS	Invalid state: single block
SECT_MSTFIN_STS	Invalid state: MST complete
SECT_FEEDHOLD_STS	Invalid state: feed hold
SECT_OVERRIDE_STS	Invalid state: Override
SECT_IGSACT_STS	Invalid state: Exact
SECT_ACT_MAIN_COMMENT	Program comment
SECT_RUN_STATUS	Operating condition
SECT_RUN_MODE	Operation mode
SECT_SUB_SYSTEM_INFO1	Sub-line information 1
SECT_SUB_SYSTEM_INFO2	Sub-line information 2
SECT_CURRENT_PROG	Running program (type 1)
SECT_ALARM_INFO_COM	Alarm information (common to the system)
SECT_ALARM_INFO_SYS	Alarm information (system independent)
SECT_ACT_REAL_P_NO	Running program number
SECT_ACT_REAL_B_NO	Running block number
SECT_PLC_MESSAGE	PLC message information
SECT_PRG_MAIN_O_MEM	O: Search program number of memory operation
SECT_TOOL_COMPENSATION1	Tool correction number 1
SECT_TOOL_COMPENSATION2	Tool correction number 2

SECT_UPDATE_AXIS_INFO	Axis information update counter
SECT_CURRENT_PROG2	Running program (type 2)
SECT_CURRENT_PROG3	Running program (type 3)
SECT_CURRENT_PROG4	Running program (type 4)
SECT_ALARM_CHG_CNT	Alarm message update information
SECT_PRG_TREE_O	Program tree information O: Program number
SECT_PRG_TREE_N	Program tree information N: Sequence number
SECT_PRG_TREE_B	Program tree information B: Block number
SECT_PRG_TREE_L	Program tree information L: Loop count
SECT_PRG_TREE_MODE	Program tree information operation mode
SECT_MDI_STATUS	MDI setting status