

Counter

Command	Data type	Description	PS	AX	RW	Range
M_SSEC_CNTR_POS_WRK	T_FLOATBIN/T_LONG	Workpiece coordinate position counter	0	0	R	
M_SSEC_CNTR_POS_MCH	T_FLOATBIN/T_LONG	Machine position counter	0	0	R	
M_SSEC_CNTR_POS_CURRENT	T_FLOATBIN/T_LONG	Current position counter	0	0	R	
M_SSEC_CNTR_POS_RELATV	T_FLOATBIN/T_LONG	Relative position counter	0	0	R	
M_SSEC_CNTR_POS_PROGRAM	T_FLOATBIN/T_LONG	Program position counter	0	0	R	
M_SSEC_CNTR_DISTANCE	T_FLOATBIN/T_LONG	Remaining command	0	0	R	
M_SSEC_CNTR_SKIP	T_FLOATBIN/T_LONG	Skip coordinate counter (Workpiece coordinate)	0	0	R	
M_SSEC_CNTR_INTER	T_FLOATBIN/T_LONG	Manual interruption amount 1 (ABS Off)	0	0	R	
M_SSEC_CNTR_INTER2	T_FLOATBIN/T_LONG	Manual interruption amount 2 (ABS On)	0	0	R	
M_SSEC_CNTR_NEXT	T_FLOATBIN/T_LONG	Next command	0	0	R	
M_SSEC_CNTR_POS_RESTART	T_FLOATBIN/T_LONG	Restart position counter (Workpiece coordinate)	0	0	R	
M_SSEC_CNTR_POS_RE_DIST	T_FLOATBIN/T_LONG	Remaining restart distance counter	0	0	R	
M_SSEC_CNTR_POS_RE_MCH	T_FLOATBIN/T_LONG	Restart position counter (Machine coordinate)	0	0	R	
M_SSEC_CNTR_POS_PROG2	T_FLOATBIN/T_LONG	Program position counter 2	0	0	R	
M_SSEC_CNTR_POS_TLM	T_FLOATBIN/T_LONG	TLM position counter	0	0	R	
M_SSEC_CNTR_TLM_SKIP	T_FLOATBIN/T_LONG	TLM skip position counter (mxtlms)	0	0	R	
M_SSEC_CNTR_TLM	T_FLOATBIN/T_LONG	TLM position counter (mxtlm)	0	0	R	
M_SSEC_CNTR_MXSKPM	T_FLOATBIN/T_LONG	Skip coordinate counter (Machine coordinate)	0	0	R	
M_SSEC_CNTR_MXSKPR	T_FLOATBIN/T_LONG	Remaining skip distance counter	0	0	R	
M_SSEC_CNTR_LM	T_LONG	Interpolation combined vector length (lm)	0	--	R	
M_SSEC_CNTR_POS_CURRENT_B	T_FLOATBIN/T_LONG	Current position B counter	0	0	R	
M_SSEC_CNTR_SKIP_WORK	T_FLOATBIN/T_LONG	Skip machine value (manual skip position)	0	0	R	-
M_SSEC_CNTR_SKP_COORD_POS	T_FLOATBIN	Skip coordinate position (skip coordinate counter)	0	0	R	Special

M_SSEC_CNTR_MEAS_POS	T_FLOATBIN	Measure position	O	O	R	Special
M_SSEC_CNTR_POS_TIP_M	T_FLOATBIN	Tip machine position	O	O	R	-
M_SSEC_CNTR_POS_TIP_W	T_FLOATBIN	Tip workpiece position	O	O	R	-
M_SSEC_CNTR_POS_T_HDL	T_FLOATBIN	Tool axis movement (ABS OFF)	O	O	R	-
M_SSEC_CNTR_POS_MECHA1	T_FLOATBIN	1st mechanical axis angle	O	-	R	0.000 to 720.000(Display with PLC unit)
M_SSEC_CNTR_POS_MECHA2	T_FLOATBIN	2nd mechanical axis angle	O	-	R	0.000 to 720.000(Display with PLC unit)
M_SSEC_CNTR_GTR_POS_MCH	T_FLOATBIN/T_LONG	Machine position counter (for trace)	O	O	R	
M_SSEC_CNTR_GTR_POS_WRK	T_FLOATBIN/T_LONG	Workpiece coordinate counter (for trace)	O	O	R	
M_SSEC_CNTR_POS_MCH_DATA	T_FLOATBIN/T_LONG	Machine position counter (inclined axis disabled)	O	O	R	
M_SSEC_CNTR_POS_FB	T_FLOATBIN/T_LONG	Feedback position	O	O	R	
M_SSEC_CNTR_TABLE	T_FLOATBIN/T_LONG	Table coordinate system counter	O	O	R	
M_SSEC_CNTR_WORKPOS	T_FLOATBIN/T_LONG	Workpiece install position coordinate system counter	O	O	R	
M_SSEC_CNTR_SLOPE	T_FLOATBIN/T_LONG	Inclined surface coordinate system counter	O	O	R	
M_SSEC_CNTR_CNTR_ZERO	T_FLOATBIN/T_LONG	Counter zero	O	O	W	±99999.999
M_SSEC_CNTR_ORG_ZERO	T_FLOATBIN/T_LONG	Origin zero	O	O	W	Disabled
M_SSEC_CNTR_ORG_CANCEL	T_FLOATBIN/T_LONG	Origin cancel	O	O	W	Disabled