

F modal

Command	Data type	Description	PS	AX	RW	Range
M_SSEC_FMDL_FA	T_FLOATBIN	Program command F modal (FA)	O	--	R	
M_SSEC_FMDL_FM	T_FLOATBIN	Manual feedrate (FM)	O	--	R	
M_SSEC_FMDL_FS	T_FLOATBIN	Synchronous feedrate (FS)	O	--	R	
M_SSEC_FMDL_FE	T_FLOATBIN	Thread cutting lead (FE)	O	--	R	
M_SSEC_FMDL_DWELL	T_FLOATBIN	Remaining dwell time	O	--	R	
M_SSEC_FMDL_G96S(x)	T_LONG	Constant surface speed control (Surface speed S) (x=1 to 6)	O	--	R	