

Rotary axis configuration parameter

Command	Data type	Description	PS	AX	RW	Range
M_SSEC_MPROTAX_RECTANGULAR_AX_I	T_CHAR	Orthogonal coordinate horizontal axis name	O	--	RW	A,B,C,U,V,W,X,Y,Z
M_SSEC_MPROTAX_RECTANGULAR_AX_J	T_CHAR	Orthogonal coordinate vertical axis name	O	--	RW	A,B,C,U,V,W,X,Y,Z
M_SSEC_MPROTAX_RECTANGULAR_AX_K	T_CHAR	Orthogonal coordinate height axis name	O	--	RW	A,B,C,U,V,W,X,Y,Z
M_SSEC_MPROTAX_G92_COORD	T_CHAR	Origin zero set coordinate selection	O	--	RW	0,1
M_SSEC_MPROTAX_NO_TIP_POSITION	T_CHAR	Tool handle feed function selection	O	--	RW	0,1
M_SSEC_MPROTAX_NO_ABS	T_CHAR	Selection of tool axis travel amount display at manual ABS switch ON/OFF	O	--	RW	0,1
M_SSEC_MPROTAX_SINGU_PASS_TYPE	T_CHAR	Singular point passage type	O	--	RW	0,1
M_SSEC_MPROTAX_SINGU_CHK_HOLD	T_FLOATBIN	Near singular judgment angle	O	--	RW	0.000 to 5.000
M_SSEC_MPROTAX_SLCT_PRG_COORD	T_CHAR	Near singular judgment angle	O	--	RW	0,1
M_SSEC_MPROTAX_IJK_VEC_MR	T_CHAR	Posture vector mirror image selection	O	--	RW	0,1
M_SSEC_MPROTAX_SLCT_INT_MODE	T_CHAR	Tool centre point control interpolation type select	O	--	RW	0,1
M_SSEC_MPROTAX_SLCT_STD_POS	T_CHAR	Rotary axis basic position selection	O	--	RW	0,1
M_SSEC_MPROTAX_MCHN_SPD_CTRL	T_CHAR	Machine speed fluctuation suppression	O	--	RW	0,1
M_SSEC_MPROTAX_SELECT_ROT_AX_T1	T_CHAR	Rotary axis selection of base-side tool axis	O	--	RW	0 to 3,12,13,21,23,31,32
M_SSEC_MPROTAX_TILT_ANG_T1	T_FLOATBIN/T_LONG	Inclination angle of base-side tool axis	O	--	RW	±359.999
M_SSEC_MPROTAX_ROT_AX_NAME_T1	T_CHAR	Rotary axis name of base-side tool axis	O	--	RW	0,A,B,C,U,V,W,X,Y,Z
M_SSEC_MPROTAX_DIR_ROT_AX_T1	T_CHAR	Rotation direction of base-side tool axis	O	--	RW	0,1
M_SSEC_MPROTAX_CENTER_OFS_T1H	T_FLOATBIN/T_LONG	Horizontal axis rotation center offset of base-side tool axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_CENTER_OFS_T1V	T_FLOATBIN/T_LONG	Vertical axis rotation center offset of base-side tool axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_CENTER_OFS_T1T	T_FLOATBIN/T_LONG	Height axis rotation center offset of base-side tool axis	O	--	RW	±99999.999

M_SSEC_MPROTAX_CENTER_ERR_T1H	T_FLOATBIN/T_LONG	Horizontal axis rotation center error compensation amount of base-side tool axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_CENTER_ERR_T1V	T_FLOATBIN/T_LONG	Vertical axis rotation center error compensation amount of base-side tool axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_SELECT_ROT_AX_T2	T_CHAR	Rotary axis selection of tool-side tool axis	O	--	RW	0 to 3,12,13,21,23,31,32
M_SSEC_MPROTAX_TILT_ANG_T2	T_FLOATBIN/T_LONG	Inclination angle of tool-side tool axis	O	--	RW	±359.999
M_SSEC_MPROTAX_ROT_AX_NAME_T2	T_CHAR	Rotary axis name of tool-side tool axis	O	--	RW	0,A,B,C,U,V,W,X,Y,Z
M_SSEC_MPROTAX_DIR_ROT_AX_T2	T_CHAR	Rotation direction of tool-side tool axis	O	--	RW	0,1
M_SSEC_MPROTAX_CENTER_OFS_T2H	T_FLOATBIN/T_LONG	Horizontal axis rotation center offset of tool-side tool axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_CENTER_OFS_T2V	T_FLOATBIN/T_LONG	Vertical axis rotation center offset of tool-side tool axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_CENTER_OFS_T2T	T_FLOATBIN/T_LONG	Height axis rotation center offset of tool-side tool axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_CENTER_ERR_T2H	T_FLOATBIN/T_LONG	Horizontal axis rotation center error compensation amount of tool-side tool axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_CENTER_ERR_T2V	T_FLOATBIN/T_LONG	Vertical axis rotation center error compensation amount of tool-side tool axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_SELECT_ROT_AX_W1	T_CHAR	Rotary axis selection of tool-side table axis	O	--	RW	0 to 3,12,13,21,23,31,32
M_SSEC_MPROTAX_TILT_ANG_W1	T_FLOATBIN/T_LONG	Inclination angle of tool-side table axis	O	--	RW	±359.999
M_SSEC_MPROTAX_ROT_AX_NAME_W1	T_CHAR	Rotary axis name of tool-side table axis	O	--	RW	0,A,B,C,U,V,W,X,Y,Z
M_SSEC_MPROTAX_DIR_ROT_AX_W1	T_CHAR	Rotation direction of tool-side table axis	O	--	RW	0,1
M_SSEC_MPROTAX_CENTER_OFS_W1H	T_FLOATBIN/T_LONG	Horizontal axis rotation center offset of tool-side table axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_CENTER_OFS_W1V	T_FLOATBIN/T_LONG	Vertical axis rotation center offset of tool-side table axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_CENTER_OFS_W1T	T_FLOATBIN/T_LONG	Height axis rotation center offset of tool-side table axis	O	--	RW	±99999.999

M_SSEC_MPROTAX_CENTER_ERR_W1H	T_FLOATBIN/T_LONG	Horizontal axis rotation center error compensation amount of tool-side table axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_CENTER_ERR_W1V	T_FLOATBIN/T_LONG	Vertical axis rotation center error compensation amount of tool-side table axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_SELECT_ROT_AX_W2	T_CHAR	Rotary axis selection of workpiece-side table axis	O	--	RW	0 to 3,12,13,21,23,31,32
M_SSEC_MPROTAX_TILT_ANG_W2	T_FLOATBIN/T_LONG	Inclination angle of workpiece-side table axis	O	--	RW	±359.999
M_SSEC_MPROTAX_ROT_AX_NAME_W2	T_CHAR	Rotary axis name of workpiece-side table axis	O	--	RW	0,A,B,C,U,V,W,X,Y,Z
M_SSEC_MPROTAX_DIR_ROT_AX_W2	T_CHAR	Rotation direction of workpiece-side table axis	O	--	RW	0,1
M_SSEC_MPROTAX_CENTER_OFS_W2H	T_FLOATBIN/T_LONG	Horizontal axis rotation center offset of workpiece-side table axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_CENTER_OFS_W2V	T_FLOATBIN/T_LONG	Vertical axis rotation center offset of workpiece-side table axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_CENTER_OFS_W2T	T_FLOATBIN/T_LONG	Height axis rotation center offset of workpiece-side table axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_CENTER_ERR_W2H	T_FLOATBIN/T_LONG	Horizontal axis rotation center error compensation amount of workpiece-side table axis	O	--	RW	±99999.999
M_SSEC_MPROTAX_CENTER_ERR_W2V	T_FLOATBIN/T_LONG	Vertical axis rotation center error compensation amount of workpiece-side table axis	O	--	RW	±99999.999