

OEM DROs

Function	OEMCode
Jog Inc Inc DRO	1
Pulse Freq DRO	2
Slow Jog % DRO	3
X min DRO	4
Y min DRO	5
Z min DRO	6
A min DRO	7
B min DRO	8
C min DRO	9
X max DRO	10
Y max DRO	11
Z max DRO	12
A max DRO	13
B max DRO	14
C max DRO	15
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Y G92 Axis Off DRO	17
Z G92 Axis Off DRO	18
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B G92 Axis Off DRO	20
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y soft limits Min	215
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Sub Program depth	222
Rapid Override	223
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Y DRO	801
Z DRO	802
A DRO	803
B DRO	804
C DRO	805
X Vel DRO	806
Y Vel DRO	807
Z Vel DRO	808
A Vel DRO	809
B Vel DRO	810
C Vel DRO	811
Blended Velocity DRO	813
Elapsed DRO	814
Estimate DRO	815
Curr Line no DRO	816
Spindle requested DRO	817
Feedrate DRO	818
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Tool number DRO	824
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Rot B diameter DRO	826
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X Fixture Orig Off DRO	830
Y Fixture Off DRO	831
Y Fixture Orig Off DRO	831
Z Fixture Off DRO	832
Z Fixture Orig Off DRO	832
A Fixture Off DRO	833
A Fixture Orig Off DRO	833
B Fixture Orig Off DRO	834
B Fixture Off DRO	834
C Fixture Orig Off DRO	835
C Fixture Off DRO	835
Current Tool length DRO	836

Standard Buttons	
Function	FCode
Cycle start	1000
Pause	1001
Rewind	1002
Stop	1003
Single	1004
Resume	1005
Edit File	1006
Zero All	1007
Zero X	1008
Zero Y	1009
Zero Z	1010
Zero A	1011
Zero B	1012
Zero C	1013
Feedrate reset	1014
Estimate Job	1015
Run from here	1016
GotoZs	1017
Coord System	1018
Verify	1020
Reset	1021
Ref X	1022
Ref Y	1023
Ref Z	1024
Ref A	1025
Ref B	1026
Ref C	1027
Joystick Toggle	1028
Softlimits Toggle	1029
Radius Tracking Toggle	1030
Jog Toggle	1030

Standard LEDs	
Function	FCode
Reset LED	0
Inch LED	1
MMs LED	2
Idle LED	3
Start LED	4
Pause LED	5
Tool change LED	6
X ref LED	7
Y ref LED	8
Z ref LED	9
A ref LED	10
B ref LED	11
C ref LED	12
Dwell LED	13
Joystick enable LED	14
Fixture LED	16
Active 1 LED	21
Active 2 LED	22
Active 3 LED	23
Active 4 LED	24
Digitise In LED	25
Index LED	26
Limit OV LED	27
X++ Limit LED	28
X-- Limit LED	29
X-- Home LED	30
Y++ Limit LED	31
Y-- Limit LED	32
Y-- Home LED	33
Z++ Limit LED	34
Z-- Limit LED	35
Z-- Home LED	36
A++ Limit LED	37
A-- Limit LED	38
A-- Home LED	39
B++ Limit LED	40
B-- Limit LED	41
B-- Home LED	42
C++ Limit LED	43
C-- Limit LED	44
C-- Home LED	45
Enable 1 LED	46
Enable 2 LED	47
Enable 3 LED	48
Enable 4 LED	49
Enable 5 LED	50
Enable 6 LED	51
Output 1/Extrn1 Active LED	52
Output 2/Extrn2 Active LED	53
Output 3/Extrn3 Active LED	54
Digitise Out LED	55

Standard DROs	
Function	FCode
X DRO	0
Y DRO	1
Z DRO	2
A DRO	3
B DRO	4
C DRO	5
X Vel DRO	6
Y Vel DRO	7
Z Vel DRO	8
A Vel DRO	9
B Vel DRO	10
C Vel DRO	11
Blended Velocity DRO	13
Elapsed DRO	14
Estimate DRO	15
Curr Line no DRO	16
Spindle requested DRO	17
Feedrate DRO	18
Feedrate Override (FRO)	21
Tool number DRO	24
Rot A diameter DRO	25
Rot B diameter DRO	26
Rot C diameter DRO	27
Jog Inc DRO	28
X Fixture Off DRO	30
X Fixture Orig Off DRO	30
Y Fixture Off DRO	31
Y Fixture Orig Off DRO	31
Z Fixture Off DRO	32
Z Fixture Orig Off DRO	32
A Fixture Off DRO	33
A Fixture Orig Off DRO	33
B Fixture Orig Off DRO	34
B Fixture Off DRO	34
C Fixture Orig Off DRO	35
C Fixture Off DRO	35
Current Tool length DRO	36

OEM Buttons

Function	OEMCode
Program Run screen select	1
MDI screen select	2
Toolpath screen select	3
Positioning screen select	4
Diagnostics screen select	5
Corrections screen select	6
Tables screen select	7
Inc Inc Up	100
Inc Inc Down	101
Reset Interp	102
Jog mode toggle	103
Goto Safe Z	104
Home Z then X then Y, A, B, C - set machine coords	105
Units	106
Mach coords	107
Feed raise	108
Feed lower	109
Spindle CW, reset THC height	110
Slow Jog Up	111
Slow Jog Dn	112
Flood toggle	113
Mist toggle	114
Edit G-code	115
Zero radius DRO on X	116
Zero radius DRO on Y	117
Zero radius DRO on Z	118
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Touch button for Tool length offset	120
Tool Tab Save	121
Fixture Tab Save	122
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Torch Cal Zero	124
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Enc To X	126
Enc Load Y	127
Enc To Y	128
Enc Load Z	129
Enc To Z	130
Toggle Mill/Turn mode	131
Tool Path Toggle	132
Zero X Encoder	133
Zero Y Encoder	134
Zero Z Encoder	135
Tool Offset Tog	136
Fixture Off	137
Go Home	138
Part X Offset Touch	139
Part Y Offset Touch	140
Part Z Offset Touch	141
Part A Offset Touch	142
Part B Offset Touch	143
Part C Offset Touch	144
Tool X Offset Touch	145

Tool Z Offset Touch	146
Joy Throttle select	147
Touch Corr Enable Toggle	148
Auto Lim Override Toggle	149
OverRide Limits	150
SS on Act4 Toggle	151
reserved	152
reserved	153
reserved	154
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Joystick OFF	159
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Raise spindle speed	163
Lower spindle speed	164
Laser Probe Enable Toggle	165
Zero laser grid at current location	166
Z inhibit toggle	167
Ignore Tool Change toggle	168
Close current file	169
Re-load last file	170
Jog increment cycle	171
Clear error label	172
Spindle CCW toggle	173
Parallel Port Encoder3 MPG Jog Toggle	174
Cycle axis controlled by MPG 1	175
Block Delete "switch" toggle	176
Optional Stop "switch" toggle	177
Offline toggle	178
Display Abs Machine coordinates (i.e. machine coords ON)	179
Display Work + G92 coordinates (i.e. Machine coords OFF)	180
Display Work coords (i.e. not with G92)	181
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Home X, Home Z (Turn)	184
Select X for MPG 1	185
Select Y for MPG 1	186
Select Z for MPG 1	187
Select A for MPG 1	188
Select B for MPG 1	189
Select C for MPG 1	190
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Select Jog Increment 2	192
Select Jog Increment 3	193
Select Jog Increment 4	194
Select Jog Increment 5	195
Select Jog Increment 6	196
Select Jog Increment 7	197
Select Jog Increment 8	198
Select Jog Increment 9	199
Select Jog Increment 10	200
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Jog mode Continuous	204
Jog mode Step	205
Joystick On	206
Joystick Off	207
Clear Z tool offset (Turn)	208
Clear X tool offset (Turn)	209
Set stock correction to Zero (Turn)	210
Home X Home Z (Turn)	211
Home X (Turn)	212
Home Z (Turn)	213
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Display history	215
Load G-code	216
Tool flip toggle (Turn front/rear toolposts)	217
Z-inhibit ON	218
Z-inhibit OFF	219
Port Bit-Test Set (diagnostic)	220
Anti-dive enabled toggle	221
THC Anti-dive OFF	222
THC Anti-dive ON	223
Flood ON	224
Flood OFF	225
Mist ON	226
Mist OFF	227
Load Teach file	228
Toolpath Machine/Job toggle	229
Display Wizard selection window	230
Load the normal screens when Wizard done	231
Simple Complex screen toggle	232
Output 4 ON	233
Output 4 OFF	234
Output 5 ON	235
Output 5 OFF	236
Output 6 ON	237
Output 6 OFF	238
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Def-Ref all axes	240
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CV feed ON	249
Disable movement on axis X	250
Disable movement on axis Y	251
Disable movement on axis Z	252
Disable movement on axis A	253
Disable movement on axis B	254
Disable movement on axis C	255
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Engine ONline	258
Select encoder jog on axis X	259
Select encoder jog on axis Y	260
Select encoder jog on axis Z	261
Select encoder jog on axis A	262
Select encoder jog on axis B	263
Select encoder jog on axis C	264
Select Step value 1	265
Select Step value 2	266
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Select Step value 7	271
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Select Step value 9	273
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Set Jog mode CONT	276
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Inhibit jog of Y axis	291
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Inhibit jog of A axis	293
Inhibit jog of B axis	294
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Set MPG jogging mode = do single exact steps	305
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Push to jog Y--	310
Push to jog Z++	311
Push to jog Z--	312

Push to jog A++	313
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Save work offset table	317
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Run Newfangled Wizard	321
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Turn mode tool touch off X axis	324
Toggle use of spindle step line to control Torch volts	325
Turn mode tool touch off Z axis	326
Select MPG jog mode	327
Cycle start	1000
Pause	1001
Rewind	1002
Stop	1003
Single	1004
Resume	1005
Edit File	1006
Zero All	1007
Zero X	1008
Zero Y	1009
Zero Z	1010
Zero A	1011
Zero B	1012
Zero C	1013
Feedrate reset	1014
Estimate Job	1015
Run from here	1016
GotoZs	1017
Coord System	1018
Verify	1020
Reset	1021
Ref X	1022
Ref Y	1023
Ref Z	1024
Ref A	1025
Ref B	1026
Ref C	1027
Joystick Toggle	1028
Softlimits Toggle	1029
Radius Tracking Toggle	1030
Jog Toggle	1031

OEM LEDs

Function	FCode
G92 LED	10
Spindle CW LED	11
Mist LED	12
Flood LED	13
Jog mode Cont LED	14
Jog mode Incr LED	15
Mach coords warn LED	16
Feed override LED	17
Estimating LED	18
Emergency LED	19
A radius corr. LED	20
B radius corr. LED	21
C radius corr. LED	22
Software limits LED	23
Torch En LED	24
True spindle Acc LED	25
True spindle Dec LED	26
Tool Path LED	27
Tool Offset on LED	28
Part Offset on LED (always in 6.11)	29
Throttle is Slow Jog LED	30
Throttle is Feedrate LED	31
reserved	32
Auto Lim override LED	33
Override Limits/home switches LED	34
SS on Act4 LED	35
THC Arc Good LED	36
Torch Up active LED	37
Torch Down active LED	38
Feed per Rev LED	39
Feed per Min LED	40
X Scale LED	41
Y Scale LED	42
Z Scale LED	43
A Scale LED	44
B Scale LED	45
C Scale LED	46
reserved	47
Abs Coordinate Mode LED	48
Incremental Coordinate Mode LED	49
Threading Sync Mode LED (Turn)	50
Laser Probe enabled LED	51
Z-Inhibit ON LED	52
Ignore Tool Change ON LED	53
CV Mode ON LED	54
M30 Repeats Enabled LED	55
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MPG Jog On LED	57
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MPG 1 Jogs X axis LED	59
MPG 1 Jogs Y axis LED	60
MPG 1 Jogs Z axis LED	61
MPG 1 Jogs A axis LED	62
MPG 1 Jogs B axis LED	63

MPG 1 Jogs C axis LED	64
Optional Stop On LED	65
Block Delete On LED	66
Offline indicator LED	67
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Anti-dive enabled LED	70
Spindle speed stable LED	71
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Output 5 Active LED	78
Output 6 Active LED	79
Pause Active LED	80
Tangential control Active LED	81
Single Step mode Active LED	82
Jogging enabled LED	83
CV feed enabled LED	84
Enhanced Pulsing NOT in use LED	85
Axis inhibited X LED	86
Axis inhibited Y LED	87
Axis inhibited Z LED	88
Axis inhibited A LED	89
Axis inhibited B LED	90
Axis inhibited C LED	91
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Timing signal active (Turn) LED	93
Hotkeys enabled LED	94
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Units per rev mode LED	96
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MPG 2 Jogs Y axis LED	99
MPG 2 Jogs Z axis LED	100
MPG 2 Jogs A axis LED	101
MPG 2 Jogs B axis LED	102
MPG 2 Jogs C axis LED	103
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Rear tool post selected LED	115
Spindle is running LED	116
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MPG jog Velocity/Step mode selected LED	118
MPG jog single exact step mode selected LED	119

MPG jog multiple steps selected LED	120
X++ jogging switch active LED	121
X-- jogging switch active LED	122
Y++ jogging switch active LED	123
Y-- jogging switch active LED	124
Z++ jogging switch active LED	125
Z-- jogging switch active LED	126
A++ jogging switch active LED	127
A-- jogging switch active LED	128
Mouse in tool path Zooms LED	129
Mouse in tool path Pans LED	130
Reset LED	800
Inch LED	801
MMs LED	802
Idle LED	803
Start LED	804
Pause LED	805
Tool change LED	806
X ref LED	807
Y ref LED	808
Z ref LED	809
A ref LED	810
B ref LED	811
C ref LED	812
Dwell LED	813
Joystick enable LED	814
Fixture LED	816
Active 1 LED	821
Active 2 LED	822
Active 3 LED	823
Active 4 LED	824
Digitise In LED	825
Index LED	826
Limit OV LED	827
X++ Limit LED	828
X-- Limit LED	829
X-- Home LED	830
Y++ Limit LED	831
Y-- Limit LED	832
Y-- Home LED	833
Z++ Limit LED	834
Z-- Limit LED	835
Z-- Home LED	836
A++ Limit LED	837
A-- Limit LED	838
A-- Home LED	839
B++ Limit LED	840
B-- Limit LED	841
B-- Home LED	842
C++ Limit LED	843
C-- Limit LED	844
C-- Home LED	845
Enable 1 LED	846
Enable 2 LED	847
Enable 3 LED	848
Enable 4 LED	849

Enable 5 LED	850
Enable 6 LED	851
Output 1/Extrn1 Active LED	852
Output 2/Extrn2 Active LED	853
Output 3/Extrn3 Active LED	854
Digitise Out LED	855