

## Plc functions for parameter 178

This is plc function that we can change between normal open and normal close,

For example: Auto Lube is wired signal normal close. If you wire normal open, the control Centroid will show alarm “ Low Lube” you have to add 1 to value of parameter 178.

|                    |   |
|--------------------|---|
| LubeNONC           | IS MEM200 ; P178 Bit 0 (1)                                |
| SpindleNONC        | IS MEM201 ; P178 Bit 1 (2)                                |
| AirSignalNONC      | IS MEM202 ; P178 Bit 2 (4)                                |
| ToolCounterNONC    | IS MEM203 ; P178 Bit 3 (8)                                |
| ServoFaultNONC     | IS MEM204 ; P178 Bit 4 (16)                               |
| ZeroSpeedNONC      | IS MEM205 ; P178 Bit 5 (32)                               |
| OrientCompleteNONC | IS MEM206 ; P178 Bit 6 (64)                               |
| ;NoReverseSpindle  | IS MEM207 ; P178 Bit 7 (128)                              |
| ReverseClamp       | IS MEM208 ; P178 Bit 8 (256)                              |
| SpinRangeNONC      | IS MEM209 ; P178 Bit 9 (512)                              |
| ChillerFaultNONC   | IS MEM210 ; P178 Bit 10 (1024)                            |
| DoorSWNONC         | IS MEM211 ; P178 Bit 11 (2048)                            |
| ToolThruNONC       | IS MEM212 ; P178 Bit 12 (4096) /ATC Lock NONC for Lathe . |
| ;uP178Bit13        | IS MEM213 ; P178 Bit 13 (8192)                            |
| ;uP178Bit14        | IS MEM214 ; P178 Bit 14 (16384)                           |
| ;uP178Bit15        | IS MEM215 ; P178 Bit 15 (32768)                           |