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In order for the CNC to assume the value allocated to register R156, one must activate mark M1956 as described in the PLCI Manual (section 5.5.2. Writing internal CNC variables). Spindle controlled either by the CNC or by the PLCI The CNC may have two internal spindle analog outputs, that of the CNC itself and the one set by the PLCI.

### CNC 8025 GP, M, MS - Fagor Automation

Page 98 FAGOR 8025/8030 CNC Models: T, TG, TS PROGRAMMING MANUAL Ref. 9701 (in) Page 99 It includes the necessary information for new users as well as advanced subjects for those who are already familiar with this CNC product. It may not be necessary to read this whole manual.

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Page 279 Starting plane Reference plane 8025/8030 CNC PROGRAMMING MANUAL... Page 280 2. The spindle starts rotating clockwise (M03) at 500 rev/min. 3. The Z axis moves 98 mm in rapid to Z-98 (reference plane). 4. The Z axis moves a further 22 mm at the working feedrate (F100) to point Z-120 (full drilling depth). Page 281 6.32.5.2. G82.

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MODIFICATIONS TO THE LAN MANUAL (REF. 9701) Section 2.2 (page 3). P616(7) The first 2 paragraphs change. They should say: If "P616(7)=0" the 8025 T CNC uses pin 15 of connector I/O1 as the input for the Feed-Hold, Transfer-Inhibit and M-done signals as described in the Installation manual, chapter 1 section "Inputs of connector I/O 1"

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