OEM DROs

Function	OEMCode	OEM Buttons	OEMCode
Jog Inc Inc DRO	1	F	
Pulse Freq DRO	2	Program Run screen select	1
Slow Jog % DRO	3	MDI screen select	2
X min DRO	4	Toolpath screen select	3
Y min DRO	5	Positioning screen select	4
Z min DRO	6	Diagnostics screen select	5
A min DRO	7	Corrections screen select	6
B min DRO	8	Tables screen select	7
C min DRO	9	Inc Inc Up	100
X max DRO	10	Inc Inc Down	101
Y max DRO	11	Reset Interp	102
Z max DRO	12	Jog mode toggle	103
A max DRO	13	Goto Safe Z	104
B max DRO	14	Home Z then X then Y, A, B, C - set machine coords	105
C max DRO	15	Units	106
X G92 Axis Off DRO	16	Mach coords	107
Y G92 Axis Off DRO	17	Feed raise	108
Z G92 Axis Off DRO	18	Feed lower	109
A G92 Axis Off DRO	19	Spindle CW, reset THC height	110
B G92 Axis Off DRO	20	Slow Jog Up	111
C G92 Axis Off DRO	21	Slow Jog Dn	112
Queue Depth DRO	22	Flood toggle	113
Time Scale DRO	23	Mist toggle	114
PWM Base DRO	24	Edit G-code	115
Torch Correction Speed DRO	25	Zero radius DRO on X	116
Torch Height Corrorrection DRO	26	Zero radius DRO on Y	117
Torch Height Max DRO	27	Zero radius DRO on Z	118
CPU Load DRO	28	Software limits	119
Encoder 1 (X) position DRO	29	Touch button for Tool length offset	120
Encoder 2 (Y) position DRO	30	Tool Tab Save	121
Encoder 3 (Z) position DRO	31	Fixture Tab Save	122
Tool length offset	32	Torch Enable Toggle	123
X axis Ref Sw DRO	33	Torch Cal Zero	124
Y axis Ref Sw DRO	34	Enc Load X	125
Z axis Ref Sw DRO	35	Enc To X	126
A axis Ref Sw DRO	36	Enc Load Y	127
B axis Ref Sw DRO	37	Enc To Y	128
C axis Ref Sw DRO	38	Enc Load Z	129
True spindle DRO	39	Enc To Z	130
Worst Case DRO	40	Toggle Mill/Turn mode	131
Tool X Offset DRO	41	Tool Path Toggle	132
Tool Z Offset DRO	42	Zero X Encoder	133
Tool Dia DRO	43	Zero Y Encoder	134
Tool Tip Rad DRO	44	Zero Z Encoder	135
Touch Correction DRO	45	Tool Offset Tog	136
Current Fixture Number DRO	46	Fixture Off	137
Part X Offset DRO	47	Go Home	138
Part Y Offset DRO	48	Part X Offset Touch	139
Part Z Offset DRO	49	Part Y Offset Touch	140
Part A Offset DRO	50	Part Z Offset Touch	141
Part B Offset DRO	51	Part A Offset Touch	142
Part C Offset DRO	52	Part B Offset Touch	143
CPU Speed DRO	53	Part C Offset Touch	144
Safe Z DRO	54	Tool X Offset Touch	145
Overidden Feed Rate DRO	55	Tool Z Offset Touch	146
Pulley DRO	56	Joy Throttle select	147
Max Spindle Speed on current pulley DRO	57	Touch Corr Enable Toggle	148
Velocity per Rev DRO	58	Auto Lim Override Toggle	149
X Scale DRO	59	OverRide Limits	150
Y Scale DRO	60	SS on Act4 Toggle	151
Z Scale DRO	61	reserved	152
A Scale DRO	62	reserved	153
B Scale DRO	63	reserved	154
C Scale DRO	64	Units/rev - Units/min toggle	155
Lowest Torch Correction DRO	65	Set this line as next to execute	156
Threading Entrance Angle DRO	66	Jog Follow	157
Max Entrance Points DRO	67	Joystick ON	158
Rotational Time Error DRO	68	Joystick OFF	159
Entrance Trigger DRO	69	Regen toolpath display	160
Time Correction Derivative DRO	70	Zero X-Z to stock as defined in DROs (Turn)	161
Interrupts per spindle rev DRO	71	Coordinate mode (G90/91)	162
Current Spin Counts DRO	72	Raise spindle speed	163
Spin Adder DRO	73	Lower spindle speed	164
Spin up/down increment DRO.	74	Laser Probe Enable Toggle	165
Stock Size DRO	75	Zero laser grid at current location	166
Laser X Grid DRO	76	Z inhibit toggle	167
Laser Y Grid DRO	77	Ignore Tool Change toggle	168
Repetitions DRO	78	Close current file	169
Lower Z-Inhibit By DRO	79	Re-load last file	170
Z-Inhibit DRO	80	Jog increment cycle	171
Port Bit-test DRO (diagnostic)	81	Clear error label	172
Anti-dive limit DRO	82	Spindle CCW toggle	173
X Machine Coord DRO	83	Parallel Port Encoder3 MPG Jog Toggle	174
Y Machine Coord DRO	84	Cycle axis controlled by MPG 1	175
Z Machine Coord DRO	85	Block Delete "switch" toggle	176
A Machine Coord DRO	86	Optional Stop "switch" toggle	177
B Machine Coord DRO	87	Offline toggle	178
C Machine Coord DRO	88	Display Abs Machine coordinates (i.e. macnine coords ON)	179
Blend factor DRO	89	Display Work + G92 coordinates (i.e. Machine coords OFF)	180
Number of spindle disc slots DRO	90	Display Work coords (i.e. not with G92)	181
G73 Pull-off value DRO	91	??? Toggle Spindle actual	182
Tangential lift threshold angle DRO	92	Home X, Home Z (Turn)	184
Tangential lift Z level DRO	93	Select X for MPG 1	185
reserved	94	Select Y for MPG 1	186
reserved	95	Select Z for MPG 1	187
reserved	96	Select A for MPG 1	188
CV Feedrate DRO	97	Select B for MPG 1	189
Feed override increment value DRO	98	Select C for MPG 1	190

Description		Description	
??? Spindle ratio DRO	99	Select Jog Increment 1	191
Encoder 4 position DRO	100	Select Jog Increment 2	192
MPG 1 count DRO	101	Select Jog Increment 3	193
MPG 2 count DRO	102	Select Jog Increment 4	194
MPG 3 count DRO	103	Select Jog Increment 5	195
Rapid feedrate DRO	104	Select Jog Increment 6	196
Diameter of current tool DRO	105	Select Jog Increment 7	197
Tip direction of current tool DRO	106	Select Jog Increment 8	198
Tool nose radius of current tool DRO	107	Select Jog Increment 9	199
X offset of current tool DRO	108	Select Jog Increment 10	200
Z offset of current tool DRO	109	Feed override Off	201
X wear offset of current tool DRO	110	Feed override Jog	202
Z wear offset of current tool DRO	111	Feed override Feed	203
Tool turret angle of current tool DRO	112	Jog mode Continuous	204
Velocity of MPG 1 DRO	113	Jog mode Step	205
Velocity of MPG 2 DRO	114	Joystick On	206
Velocity of MPG 3 DRO	115	Joystick Off	207
Angle of taper to be cut with MPG tapering DRO	116	Clear Z tool offset (Turn)	208
Spindle speed as surface speed DRO	117	Clear X tool offset (Turn)	209
Angle of rotation of X/Y coordinate system (cf G68)	118	Set stock correction to Zero (Turn)	210
Laser grid spacing DRO	119	Home X Home Z (Turn)	211
Number of incremental jogs that can be buffered DRO	120	Home X (Turn)	212
Minimum spindle speed on current pulley DRO	121	Home Z (Turn)	213
Feed rate ignoring that set in F word DRO	122	Show recent G-code files list	214
Tool post offset (between front and rear posts DRO	123	Display history	215
Current velocity of MPG 1 DRO	124	Load G-code	216
Current velocity of MPG 2 DRO	125	Tool flip toggle (Turn front/rear toolposts)	217
Feedrate for use with MPG step jogs DRO	126	Z-inhibit ON	218
Error between Encoder 1 and abs X position DRO	127	Z-inhibit OFF	219
Error between Encoder 2 and abs Y position DRO	128	Port Bit-Test Set (diagnostic)	220
Error between Encoder 3 and abs Z position DRO	129	Anti-dive enabled toggle	221
Time (uSec) in interrupt handler DRO	130	THC Anti-dive OFF	222
SLS Dist - laser position measurement DRO	131	THC Anti-dive ON	223
Axis 6 Tripcount - system debug use only DRO	132	Flood ON	224
??? Engine lookahead DRO	133	Flood OFF	225
Count of actual pulses output on X - debug use only DRO	134	Mist ON	226
Count of actual pulses output on Y - debug use only DRO	135	Mist OFF	227
Count of actual pulses output on Z - debug use only DRO	136	Load Teach file	228
Count of actual pulses output on A - debug use only DRO	137	Toolpath Machine/Job toggle	229
Count of actual pulses output on B - debug use only DRO	138	Display Wizard selection window	230
Count of actual pulses output on C - debug use only DRO	139	Load the normal screens when Wizard done	231
Actual count from encoder 1 - debug use only DRO	140	Simple Complex screen toggle	232
Actual count from encoder 2 - debug use only DRO	141	Output 4 ON	233
Actual count from encoder 3 - debug use only DRO	142	Output 4 OFF	234
Actual count from encoder 4 - debug use only DRO	143	Output 5 ON	235
Actual count from encoder 5 - debug use only DRO	144	Output 5 OFF	236
Actual count from encoder 6 - debug use only DRO	145	Output 6 ON	237
ModBus input 64 DRO	146	Output 6 OFF	238
ModBus input 65 DRO	147	Set Help context	239
ModBus input 66 DRO	148	Def-Ref all axes	240
ModBus input 67 DRO	149	Tangential toggle	241
Softlimit X Maximum DRO	150	Save XYZ to G59.254 work offset	242
Softlimit Y Maximum DRO	151	do G0G53 to G59.254 offset location	243
Softlimit Z Maximum DRO	152	Move to G59.254 with midpoint selection	244
Softlimit A Maximum DRO	153	Toggle Jog Mode through Cont/Step/MPG as relevant	245
Softlimit B Maximum DRO	154	Force Referenced on all axes	246
Softlimit C Maximum DRO	155	CV feed toggle	247
Softlimit X Minimum DRO	156	CV feed OFF	248
Softlimit Y Minimum DRO	157	CV feed ON	249
Softlimit Z Minimum DRO	158	Disable movement on axis X	250
Softlimit A Minimum DRO	159	Disable movement on axis Y	251
Softlimit B Minimum DRO	160	Disable movement on axis Z	252
Softlimit C Minimum DRO	161	Disable movement on axis A	253
Distance from front to rear toolpost DRO	162	Disable movement on axis B	254
Part X radius/diameter for Touching to tooltable DRO	175	Disable movement on axis C	255
Part Z location for Touching to tooltable DRO	176	Engine OFFline	257
reserved DRO	177	Engine ONline	258
Machine X coord - X Work Offset DRO	178	Select encoder jog on axis X	259
Machine Y coord - Y Work Offset DRO	179	Select encoder jog on axis Y	260
Machine Z coord - Z Work Offset - Tool length DRO	180	Select encoder jog on axis Z	261
Machine A coord - A Work Offset DRO	181	Select encoder jog on axis A	262
Machine B coord - B Work Offset DRO	182	Select encoder jog on axis B	263
Machine C coord - C Work Offset DRO	183	Select encoder jog on axis C	264
X Cont. Pnt. coord (Machine - Work - G52/G92) DRO	184	Select Step value 1	265
Y Cont. Pnt. coord (Machine - Work - G52/G92) DRO	185	Select Step value 2	266
Z Cont. Pnt. coord (Machine - Work - Tool len. - G52/G92)	186	Select Step value 3	267
A Cont. Pnt. coord (Machine - Work - G52/G92) DRO	187	Select Step value 4	268
B Cont. Pnt. coord (Machine - Work - G52/G92) DRO	188	Select Step value 5	269
C Cont. Pnt. coord (Machine - Work - G52/G92) DRO	189	Select Step value 6	270
X axis home location used by G28 DRO	190	Select Step value 7	271
Y axis home location used by G28 DRO	191	Select Step value 8	272
Z axis home location used by G28 DRO	192	Select Step value 9	273
A axis home location used by G28 DRO	193	Select Step value 10	274
B axis home location used by G28 DRO	194	Set Jog mode STEP	275
C axis home location used by G28 DRO	195	Set Jog mode CONT	276
X axis Distance to Go DRO	196	Increment feedrate	277
Y axis Distance to Go DRO	197	Decrement feedrate	278
Z axis Distance to Go DRO	198	Run reverse	279
A axis Distance to Go DRO	199	Switch to last used Wizard	280
B axis Distance to Go DRO	200	Cycle axis controlled by MPG 2	281
C axis Distance to Go DRO	201	Toggle taper mode on MPG 2	282
Overriden spindle speed DRO	202	Toggle dual MPG flag	283
Current pulley reversed direction	203	Toggle shuttle mode for MPG	284
Current X offset of Turn tool	204	Return to paused state	285
reserved	205	Remember paused state	286
reserved	206	Toggle override of rapid feeds	287
reserved	207	Crop current dwell now	288
Encoder X reading corrected by offsets	208	??? Set formlas	289
Encoder Y reading corrected by offsets	209	Inhibit jog of X axis	290
Encoder Z reading corrected by offsets	210	Inhibit jog of Y axis	291

X soft limits Max	211	Inhibit jog of Z axis	292
y soft limits Max	212	Inhibit jog of A axis	293
Z soft limits Max	213	Inhibit jog of B axis	294
X soft limits Min	214	Inhibit jog of C axis	295
y soft limits Min	215	Do screw calibration routine	296
Z soft limits Min	216	Unconditional crop any dwell now	297
Spindle Seconds CW	217	reserved	298
reserved	218	Toggle bypass feed (enables value in OEM DRO 122)	299
reserved	219	Toggle current tool is in front toolpost	300
Brains exe time (ms)	220	Code for OEMTriggers runs the macro in SetTriggerMacro	301
Probe Radius	221	Cycle MPG jogging mode	302
Sub Program depth	222	Set MPG jogging mode = Velocity	303
Rapid Override	223	Set MPG jogging mode = Velocity/Step	304
X DRO	800	Set MPG jogging mode = do single eaxct steps	305
Y DRO	801	Set MPG jogging mode = do multiple exact steps	306
Z DRO	802	Push to jog X++	307
A DRO	803	Push to jog X--	308
B DRO	804	Push to jog Y++	309
C DRO	805	Push to jog Y--	310
X Vel DRO	806	Push to jog Z++	311
Y Vel DRO	807	Push to jog Z--	312
Z Vel DRO	808	Push to jog A++	313
A Vel DRO	809	Push to jog A--	314
B Vel DRO	810	Calibrate MPGs	315
C Vel DRO	811	Save tool table	316
Blended Velocity DRO	813	Save work offset table	317
Elapsed DRO	814	Drag on toolpath does Zoom toggle	318
Estimate DRO	815	Drag on toolpath does Pan toggle	319
Curr Line no DRO	816	Display Wizard select dialog	320
Spindle requested DRO	817	Run Newfangled Wizard	321
Feedrate DRO	818	Emergency bailout - tester use only	322
Feedrate Override (FRO)	821	Toggle visibility of screen 50	323
Tool number DRO	824	Turn mode tool touch off X axis	324
Rot A diameter DRO	825	Toggle use of spindle step line to control Torch volts	325
Rot B diameter DRO	826	Turn mode tool touch off Z axis	326
Rot C diameter DRO	827	Select MPG jog mode	327
Jog Inc DRO	828	Cycle start	1000
X Fixture Off DRO	830	Pause	1001
X Fixture Orig Off DRO	830	Rewind	1002
Y Fixture Off DRO	831	Stop	1003
Y Fixture Orig Off DRO	831	Single	1004
Z Fixture Off DRO	832	Resume	1005
Z Fixture Orig Off DRO	832	Edit File	1006
A Fixture Off DRO	833	Zero All	1007
A Fixture Orig Off DRO	833	Zero X	1008
B Fixture Orig Off DRO	834	Zero Y	1009
B Fixture Off DRO	834	Zero Z	1010
C Fixture Orig Off DRO	835	Zero A	1011
C Fixture Off DRO	835	Zero B	1012
Current Tool length DRO	836	Zero C	1013
		Feedrate reset	1014
		Estimate Job	1015
OEM LEDs		Run from here	1016
Function	FCode	GotoZs	1017
G92 LED	10	Coord System	1018
Spindle CW LED	11	Verify	1020
Mist LED	12	Reset	1021
Flood LED	13	Ref X	1022
Jog mode Cont LED	14	Ref Y	1023
Jog mode Incr LED	15	Ref Z	1024
Mach coords warn LED	16	Ref A	1025
Feed override LED	17	Ref B	1026
Estimating LED	18	Ref C	1027
Emergency LED	19	Joystick Toggle	1028
A radius corr. LED	20	Softlimits Toggle	1029
B radius corr. LED	21	Radius Tracking Toggle	1030
C radius corr. LED	22	Jog Toggle	1031
Software limits LED	23		
Torch En LED	24		
True spindle Acc LED	25	Standard DROs	
True spindle Dec LED	26	Function	FCode
Tool Path LED	27	X DRO	0
Tool Offset on LED	28	Y DRO	1
Part Offset on LED (always in 6.11)	29	Z DRO	2
Throttle is Slow Jog LED	30	A DRO	3
Throttle is Feedrate LED	31	B DRO	4
reserved	32	C DRO	5
Auto Lim override LED	33	X Vel DRO	6
Override Limits/home switches LED	34	Y Vel DRO	7
SS on Act4 LED	35	Z Vel DRO	8
THC Arc Good LED	36	A Vel DRO	9
Torch Up active LED	37	B Vel DRO	10
Torch Down active LED	38	C Vel DRO	11
Feed per Rev LED	39	Blended Velocity DRO	13
Feed per Min LED	40	Elapsed DRO	14
X Scale LED	41	Estimate DRO	15
Y Scale LED	42	Curr Line no DRO	16
Z Scale LED	43	Spindle requested DRO	17
A Scale LED	44	Feedrate DRO	18
B Scale LED	45	Feedrate Override (FRO)	21
C Scale LED	46	Tool number DRO	24
reserved	47	Rot A diameter DRO	25
Abs Coordinate Mode LED	48	Rot B diameter DRO	26
Incremental Coordinate Mode LED	49	Rot C diameter DRO	27
Threading Sync Mode LED (Turn)	50	Jog Inc DRO	28
Laser Probe enabled LED	51	X Fixture Off DRO	30
Z-Inhibit ON LED	52	X Fixture Orig Off DRO	30
Ignore Tool Change ON LED	53	Y Fixture Off DRO	31
CV Mode ON LED	54	Y Fixture Orig Off DRO	31
M30 Repeats Enabled LED	55	Z Fixture Off DRO	32

LED Name	Number	Function	FCode
CV mode OFF LED	56	Z Fixture Orig Off DRO	32
MPG Jog On LED	57	A Fixture Off DRO	33
Cont. Jog is at full speed LED	58	A Fixture Orig Off DRO	33
MPG 1 Jogs X axis LED	59	B Fixture Orig Off DRO	34
MPG 1 Jogs Y axis LED	60	B Fixture Off DRO	34
MPG 1 Jogs Z axis LED	61	C Fixture Orig Off DRO	35
MPG 1 Jogs A axis LED	62	C Fixture Off DRO	35
MPG 1 Jogs B axis LED	63	Current Tool length DRO	36
MPG 1 Jogs C axis LED	64		
Optional Stop On LED	65		
Block Delete On LED	66	Standard Buttons	
Offline indicator LED	67		
Threading feed related to true Spindle speed LED	68	Note: To use these button codes in OEM trigger input you need to add 1000 to the values given in the table	
Index signal awaited LED (Turn)	69	Function	FCode
Anti-dive enabled LED	70	Cycle start	0
Spindle speed stable LED	71	Pause	1
IJ Mode is Absolute LED	72	Rewind	2
IJ Mode is Incremental LED	73	Stop	3
G-code teaching file is open LED	74	Single	4
Offset in effect on at least one axis LED	75	Resume	5
reserved	76	Edit File	6
Output 4 Active LED	77	Zero All	7
Output 5 Active LED	78	Zero X	8
Output 6 Active LED	79	Zero Y	9
Pause Active LED	80	Zero Z	10
Tangential control Active LED	81	Zero A	11
Single Step mode Active LED	82	Zero B	12
Jogging enabled LED	83	Zero C	13
CV feed enabled LED	84	Feedrate reset	14
Enhanced Pulsing NOT in use LED	85	Estimate Job	15
Axis inhibited X LED	86	Run from here	16
Axis inhibited Y LED	87	GotoZs	17
Axis inhibited Z LED	88	Coord System	18
Axis inhibited A LED	89	Verify	20
Axis inhibited B LED	90	Reset	21
Axis inhibited C LED	91	Ref X	22
Diameter mode active (Turn) LED	92	Ref Y	23
Timing signal active (Turn) LED	93	Ref Z	24
Hotkeys enabled LED	94	Ref A	25
Units per minute mode LED	95	Ref B	26
Units per rev mode LED	96	Ref C	27
Running in reverse (duplicated by 112) LED	97	Joystick Toggle	28
MPG 2 Jogs X axis LED	98	Softlimits Toggle	29
MPG 2 Jogs Y axis LED	99	Radius Tracking Toggle	30
MPG 2 Jogs Z axis LED	100	Jog Toggle	31
MPG 2 Jogs A axis LED	101		
MPG 2 Jogs B axis LED	102		
MPG 2 Jogs C axis LED	103	Standard LEDs	
MPG 2 in taper mode LED	104	Function	FCode
Two MPGs in use LED	105	Reset LED	0
Shuttle mode in use LED	106	Inch LED	1
Spindle is in CSS (G96) mode LED	107	MMs LED	2
X/Y coordinate system is currently rotated LED	108	Idle LED	3
Rapids being overidden LED	109	Start LED	4
Axis formula mappin ON LED	110	Pause LED	5
Feedhold when part of a block executed - remainder pendin	111	Tool change LED	6
Running in reverse (duplicate) LED - do not use	112	X ref LED	7
Alternative feedrate in use (see OEM DRO 122) LED	113	Y ref LED	8
Front tool post selected LED	114	Z ref LED	9
Rear tool post selected LED	115	A ref LED	10
Spindle is running LED	116	B ref LED	11
MPG jog Velocity mode selected LED	117	C ref LED	12
MPG jog Velocity/Step mode selected LED	118	Dwell LED	13
MPG jog single exact step mode selected LED	119	Joystick enable LED	14
MPG jog multiple steps selected LED	120	Fixture LED	16
X++ jogging switch active LED	121	Active 1 LED	21
X-- jogging switch active LED	122	Active 2 LED	22
Y++ jogging switch active LED	123	Active 3 LED	23
Y-- jogging switch active LED	124	Active 4 LED	24
Z++ jogging switch active LED	125	Digitise In LED	25
Z-- jogging switch active LED	126	Index LED	26
A++ jogging switch active LED	127	Limit OV LED	27
A-- jogging switch active LED	128	X++ Limit LED	28
Mouse in tool path Zooms LED	129	X-- Limit LED	29
Mouse in tool path Pans LED	130	X-- Home LED	30
Reset LED	800	Y++ Limit LED	31
Inch LED	801	Y-- Limit LED	32
MMs LED	802	Y-- Home LED	33
Idle LED	803	Z++ Limit LED	34
Start LED	804	Z-- Limit LED	35
Pause LED	805	Z-- Home LED	36
Tool change LED	806	A++ Limit LED	37
X ref LED	807	A-- Limit LED	38
Y ref LED	808	A-- Home LED	39
Z ref LED	809	B++ Limit LED	40
A ref LED	810	B-- Limit LED	41
B ref LED	811	B-- Home LED	42
C ref LED	812	C++ Limit LED	43
Dwell LED	813	C-- Limit LED	44
Joystick enable LED	814	C-- Home LED	45
Fixture LED	816	Enable 1 LED	46
Active 1 LED	821	Enable 2 LED	47
Active 2 LED	822	Enable 3 LED	48
Active 3 LED	823	Enable 4 LED	49
Active 4 LED	824	Enable 5 LED	50
Digitise In LED	825	Enable 6 LED	51
Index LED	826	Output 1/Extrn1 Active LED	52
Limit OV LED	827	Output 2/Extrn2 Active LED	53
X++ Limit LED	828	Output 3/Extrn3 Active LED	54
X-- Limit LED	829	Digitise Out LED	55

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