

X Input	Name	Description
X0	X-OT	X axis overtravel (limit switch)
X1	Y-OT	Y axis overtravel
X2	Z-OT	Z axis overtravel
X3	1CL.OL	Tool clamp overload / clamp fault
X4	SPCLAL	Spindle alarm
X5	TUN.PB	Tool unclamp pushbutton (manual)
X6	MGF.SW	Spindle gear / mode flag (likely)
X7	LUB.L	Lubrication low level
X8	AIR.L	Air pressure low
X9	TUN.SW	Tool unclamp status switch
Xa	CTS.TL	Coolant temperature limit (high)
Xb	R.AL	General alarm / ready alarm
Xc	ACL.SW	Auto clamp switch / confirmation
Xd	TCL.SW	Tool clamp switch (status)
Xe	CTSFAL	Coolant system fault
Xf	DRF.SW	Door safety switch
X10	MG.OL	Motor overload
X11	ANG.PB	Angle positioning button (spindle orient)
X12	MCCV.PPB	Machine clamp / unclamp
X13	MCWPB	Machine clamp pushbutton
X14	DRL.SW	Door lock switch
X15	MG.TCK	Magazine check / tool check
X16	MGB.SW	Magazine base switch
X17	T.CTR	Tool counter / ATC position counter
X18	X-ZERO	X home switch
X19	Y-ZERO	Y home switch
X1a	Z-ZERO	Z home switch
X1b	A-ZERO	A axis home
X1c	AUN.SW	Auto / manual mode switch
X1d	CTNK.L	Coolant tank low level
X1e	CTNK.H	Coolant tank high level
X1f	CHP.OL	Chip conveyor overload
X40	-X.PB	Jog X negative
X41	+Y.PB	Jog Y positive
X42	-Z.PB	Jog Z negative
X43	+A.PB	Jog A positive
X44	ST.PB	Start pushbutton
X45	STP.PB	Stop pushbutton
X46	MST.PB	Machine start
X47	HST.PB	Hold (feed hold)
X48	MODE.1	Mode select bit 1
X49	MODE.2	Mode select bit 2
X4a	JOV.4	Jog override bit
X4b	JOV.2	Jog override bit
X4c	BDT.PB	Block delete toggle
X4d	PRS.PB	Program restart / preset
X4e	DRY.PB	Dry run mode
X4f	ABS.PB	Absolute mode select
X50	OT.PB	Overtravel release button
X51	+X.PB	Jog X positive
X52	-Y.PB	Jog Y negative
X53	+Z.PB	Jog Z positive
X54	-A.PB	Jog A negative

X55	EMG	Emergency stop
X56	FREE	Free mode / enable
X57	F1.PB	Function key F1
X58	MODE.4	Mode select bit 4
X59	JOV.1	Jog override bit
X5a	JOV.8	Jog override bit
X5b	SBK.PB	Single block mode
X5c	OPS.PB	Optional stop
X5d	MLK.PB	Machine lock
X5e	ZLK.PB	Z axis lock
X5f	SRT.PB	Cycle start
X60	F3.PB	Function key F3
X61	DOP.PB	Door open button
X62	JOV.16	Jog override bit
X63	RAP.2	Rapid override level 2
X64	MGF.PB	Spindle gear/manual function
X65	SOV.2	Spindle override bit
X66	PR.KEY	Protection key / enable key
X67	MPG10	MPG scale ×10
X68	MPG.A	MPG axis select A
X69	MPG.Y	MPG axis select Y
X6a	MCW.PB	Manual CW
X6b	CCW.PB	Manual CCW
X6c	1CL.PB	Clamp 1 pushbutton
X6d	APO.PB	Approach button
X6e	SCW.PB	Spindle CW
X6f	SCCWPB	Spindle CCW
X70	2CL.PB	Secondary clamp pushbutton
X71	BZ.CUT	Buzzer / cut signal
X72	RAP.1	Rapid override level 1
X73	MGB.PB	Magazine button
X74	SOV.1	Spindle override bit
X75	SOV.4	Spindle override bit
X76	MPG100	MPG scale ×100
X77	CSP.PB	Cycle stop pushbutton
X78	MPG.Z	MPG axis Z
X79	MPG.X	MPG axis X
X7a	MCCWPB	Manual CCW (alt)
X7b	CCCWPB	Unknown CCW variant
X7c	ARB.PB	Arbitrary function button
X7d	WL.PB	Work light toggle
X7e	SSP.PB	Spindle stop
X7f	SOR.PB	Spindle orient