



**Technical Paper**  
**PLCopen Technical Committee 2 – Task Force**  
**Function Blocks for motion control:**  
**Part 4 – Coordinated Motion**

**PLCopen Document**  
**Version 1.0, Published**

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## Appendix 1. Compliance Procedure and Compliance List

Listed in this Appendix are the requirements for the compliance statement from the supplier of the Motion Control Function Blocks. The compliance statement consists of two main groups: supported data types (see Appendix 1.2 Supported Data types) and supported Function Blocks, in combination with the applicable inputs and outputs see (Appendix 1.2 Supported Data types and its paragraphs). The supplier is required fill out the tables for the used data types and Function Blocks, according to their product, committing their support to the specification.

By submitting these tables to PLCopen, and after approval by PLCopen, the list will be published on the PLCopen website, [www.plcopen.org](http://www.plcopen.org) , as well as a shortform overview, as specified in Appendix 1.5 Short overview of the Functions Blocks.

In addition to this approval, the supplier is granted access and usage rights of the PLCopen Motion Control logo, as described in chapter Appendix 1.6 The PLCopen Motion Control Logo and Its Usage.

### Data types

The data type REAL listed in the Function Blocks and parameters (e.g. for velocity, acceleration, distance, etc.) may be exchanged to SINT, INT, DINT or LREAL without to be seen as incompliant to this standard, as long as they are consistent for the whole set of Function Blocks and parameters.

Implementation allows the extension of data types as long as the basic data type is kept. For example: WORD may be changed to DWORD, but not to REAL.

### Function Blocks and Inputs and Outputs

An implementation which claims compliance with this PLCopen specification shall offer a set of Function Blocks for motion control, meaning one or more Function Blocks, with at least the **basic** input and output variables, marked as “**B**” in the tables. These inputs and outputs have to be supported to be compliant.

For higher-level systems and future extensions any subset of the **extended** input and output variables, marked as “**E**” in the tables can be implemented.

Vendor specific additions are marked with “**V**”, and can be listed as such in the supplier documentation.

- |                                                        |                                                                   |
|--------------------------------------------------------|-------------------------------------------------------------------|
| - <b>Basic</b> input/output variables are mandatory    | Marked in the tables with the letter “ <b>B</b> ”                 |
| - <b>Extended</b> input /output variables are optional | Marked in the tables with the letter “ <b>E</b> ”                 |
| - <b>Vendor Specific</b> additions                     | Marked in the vendor’s compliance documentation with “ <b>V</b> ” |

All the vendor specific items will not be listed in the comparison table on the PLCopen website, but in the detailed vendor specific list, which also is published.

All vendor specific in- and outputs of all FBs must be listed in the certification list of the supplier. With this, the certification listing from a supplier describes all the I/Os of the relevant FBs, including vendor-specific extensions, and thus showing the complete FBs as used by the supplier.

**Appendix 1.1. Statement of Supplier**

Supplier name	OMRON Corporation
Supplier address	2-1, 2 CHOME, NISHIKUSATSU
City	KUSATSU-CITY
Country	JAPAN
Telephone	+81-77-565-5215
Fax	+81-77-565-5568
Email address	naoki_seno@omron.co.jp
Product Name	Machine Automation Controller, NJ-series Automation Software, Sysmac Studio
Product version	1.0
Release date	29/07/2011

I hereby state that the following tables as filled out and submitted do match our product as well as the accompanying user manual, as stated above.

Name of representation (person):  
Naoki Seno,  
General Manager of Automation Development Dept.  
Automation Systems Division HQ. Development Center

Date of signature (dd/mm/yyyy):  
29/07/2011

Signature:



## Appendix 1.2. Supported Data types

Defined datatypes with MC library:	Supported	If not supported, which datatype used
BOOL	Y	
INT	Y	
WORD	Y	
REAL	Y	
ENUM	Y	

**Table 1: Supported datatypes**

Within the specification the following derived datatypes are defined. Which structure is used in this system:

Derived datatypes:	Where used	Supported	Which structure
AXES_GROUP_REF	Nearly all FBs	Y	_sGROUP_REF :
IDENT_IN_GROUP_REF	MC_AddAxisToGroup MC_RemoveAxisFromGroup	N	
MC_BUFFER_MODE	In all buffered FBs	Y	_eMC_BUFFER_MODE : _mcAborting _mcBuffered _mcBlendingHigh _mcBlendingLow _mcBlendingNext _mcBlendingPrevious
MC_KIN_REF	MC_SetKinTransform MC_ReadKinTransform	N	
MC_EXECUTION_MODE	MC_SetKinTransform	N	
MC_COORD_REF	MC_SetCoordinateTransformation	N	
MC_GROUP_BUFFER_MODE	MC_MoveLinearAbsolute MC_MoveCircularAbsolute	N	
MC_TRANSITION_MODE	MC_MoveLinearAbsolute MC_MoveLinearRelative MC_MoveCircularAbsolute MC_MoveCircularRelative MC_MoveCircular2D	Y	_eMC_TRANSITION_MODE : _mcTMNone _mcTMCornerSuperimposed
MC_CIRC_PATHCHOICE	MC_MoveCircularAbsolute MC_MoveCircularRelative MC_MoveCircular2D	Y	_eMC_CIRC_PATHCHOICE : _mcCW _mcCCW
MC_PATH_DATA_REF MC_PATH_REF	MC_PathSelect MC_MovePath	N	

**Table 2: Supported derived datatypes**

## Appendix 1.3. Supported Buffer Modes

No.	MC_BUFFER_MODE	Supported
0	Aborting	Y
1	Buffered	Y
2	BlendingLow	Y
3	BlendingPrevious	Y
4	BlendingNext	Y
5	BlendingHigh	Y

**Table 3: Overview of buffer modes**

## Appendix 1.4. Supported Transition Modes

No.	MC_TRANSITION_MODE	Supported
0	TMNone	Y
1	TMMaxVelocity	N
2	TMDefinedVelocity	N
3	TMCornerDistance	N
4	TMMaxCornerDeviation	N
5 - 9	Reserved by PLCopen	N
10 - ...	Supplier specific modes	Y 10 : TMCORNERSUPERIMPOSED

**Table 4: Overview of available transition modes**

**Appendix 1.5. Short overview of the Function Blocks**

<b>Coordinated Function Blocks</b>	<b>Supported Yes / No</b>	<b>Comments (&lt;= 48 char.)</b>
MC_AddAxisToGroup	No	
MC_RemoveAxisFromGroup	No	
MC_UngroupAllAxes	No	
MC_GroupReadConfiguration	No	
MC_GroupEnable	Yes	
MC_GroupDisable	Yes	
MC_GroupHome	No	
MC_SetKinTransform	No	
MC_SetCartesianTransform	No	
MC_SetCoordinateTransform	No	
MC_ReadKinTransform	No	
MC_ReadCartesianTransform	No	
MC_ReadCoordinateTransform	No	
MC_GroupSetPosition	No	
MC_GroupReadActualPosition	No	
MC_GroupReadActualVelocity	No	
MC_GroupReadActualAcceleration	No	
MC_GroupStop	Yes	
MC_GroupHalt	No	
MC_GroupInterrupt	No	
MC_GroupContinue	No	
MC_GroupReadStatus	No	
MC_GroupReadError	No	
MC_GroupReset	Yes	
MC_MoveLinearAbsolute	Yes	
MC_MoveLinearRelative	Yes	
MC_MoveCircularAbsolute	No	MC_MoveCircular2D is used instead
MC_MoveCircularRelative	No	MC_MoveCircular2D is used instead
MC_MoveDirectAbsolute	No	
MC_MoveDirectRelative	No	
MC_PathSelect	No	
MC_MovePath	No	
MC_GroupSetOverride	Yes	
<b>Coordinated</b>	<b>Supported Yes / No</b>	<b>Comments (&lt;= 48 char.)</b>
MC_SyncAxisToGroup	No	
MC_SyncGroupToAxis	No	
MC_SetDynCoordTransform	No	
MC_TrackConveyorbelt	No	
MC_TrackRotaryTable	No	

**Table 5: Short overview of the Function Blocks**

### Appendix A 5.1. MC\_AddAxisToGroup

If Supported	MC_AddAxisToGroup	Sup. Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
B	Axis		
VAR_INPUT			
B	Execute		
E	IdentInGroup		
VAR_OUTPUT			
B	Done		
E	Busy		
B	Error		
E	ErrorID		

### Appendix A 5.2. MC\_RemoveAxisFromGroup

If Supported	MC_RemoveAxisFromGroup	Sup. Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Execute		
E	IdentInGroup		
VAR_OUTPUT			
B	Done		
E	Busy		
B	Error		
E	ErrorID		

### Appendix A 5.3. MC\_UngroupAllAxes

If Supported	MC_UngroupAllAxes	Sup. Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Execute		
VAR_OUTPUT			
B	Done		
E	Busy		
B	Error		
E	ErrorID		

### Appendix A 5.4. MC\_GroupReadConfiguration

If Supported	MC_GroupReadConfiguration	Sup. Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Enable		
B	IdentInGroup		
E	CoordSystem		
VAR_OUTPUT			
B	Axis		
B	Valid		
E	Busy		
B	Error		
E	ErrorID		

### Appendix A 5.5. MC\_GroupEnable

If Supported	MC_GroupEnable	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup	Y	
VAR_INPUT			
B	Execute	Y	
VAR_OUTPUT			
B	Done	Y	
E	Busy	Y	
B	Error	Y	
E	ErrorID	Y	
V	CommandAborted	Y	

### Appendix A 5.6. MC\_GroupDisable

If Supported	MC_GroupDisable	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup	Y	
VAR_INPUT			
B	Execute	Y	
VAR_OUTPUT			
B	Done	Y	
E	Busy	Y	
B	Error	Y	
E	ErrorID	Y	
V	CommandAborted	Y	

### Appendix A 5.7. MC\_GroupHome

If Supported	MC_GroupHome	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Execute		
B	Position		
E	CoordSystem		
E	BufferMode		
VAR_OUTPUT			
B	Done		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		



### Appendix A 5.8. MC\_SetKinTransform

If Supported	MC_SetKinTransform	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Execute		
E	KinTransform		
E	ExecutionMode		
VAR_OUTPUT			
B	Done		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		

### Appendix A 5.9. MC\_SetCartesianTransform

If Supported	MC_SetCartesianTransform	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Execute		
B	TransX		
B	TransY		
B	TransZ		
B	RotAngle1		
B	RotAngle2		
B	RotAngle3		
E	ExecutionMode		
VAR_OUTPUT			
B	Done		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		

### Appendix A 5.10. MC\_SetCoordinateTransform

If Supported	MC_SetCoordinateTransform	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Execute		
E	CoordTransform		
E	ExecutionMode		
VAR_OUTPUT			
B	Done		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		

### Appendix A 5.11. MC\_ReadKinTransform

If Supported	MC_ReadKinTransform	Sup. Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Enable		
VAR_OUTPUT			
B	Valid		
E	Busy		
B	KinTransform		
B	Error		
E	ErrorID		

### Appendix A 5.12. MC\_ReadCartesianTransform

If Supported	MC_ReadCartesianTransform	Sup. Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Enable		
VAR_OUTPUT			
B	Valid		
E	Busy		
B	TransX		
B	TransY		
B	TransZ		
B	RotAngle1		
B	RotAngle2		
B	RotAngle3		
B	Error		
E	ErrorID		

### Appendix A 5.13. MC\_ReadCoordinateTransform

If Supported	MC_ReadCoordinateTransform	Sup. Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Enable		
VAR_OUTPUT			
B	Valid		
E	Busy		
B	CoordTransform		
B	Error		
E	ErrorID		

### Appendix A 5.14. MC\_GroupSetPosition

If Supported	MC_GroupSetPosition	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Execute		
B	Position		
E	Relative		
E	CoordSystem		
E	BufferMode		
VAR_OUTPUT			
B	Done		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		

### Appendix A 5.15. MC\_GroupReadActualPosition

If Supported	MC_GroupReadActualPosition	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Enable		
E	CoordSystem		
VAR_OUTPUT			
B	Valid		
E	Busy		
B	Error		
E	ErrorID		
B	Position		

### Appendix A 5.16. MC\_GroupReadActualVelocity

If Supported	MC_GroupReadActualVelocity	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Enable		
E	CoordSystem		
VAR_OUTPUT			
B	Valid		
E	Busy		
B	Error		
E	ErrorID		
B	Velocity		
E	PathVelocity		

### Appendix A 5.17. MC\_GroupReadActualAcceleration

If Supported	MC_GroupReadActualAcceleration	Sup. Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Enable		
E	CoordSystem		
VAR_OUTPUT			
B	Valid		
E	Busy		
B	Error		
E	ErrorID		
B	Acceleration		
E	Path Acceleration		

### Appendix A 5.18. MC\_GroupStop

If Supported	MC_GroupStop	Sup. Y/N	Comments
VAR_IN_OUT			
B	AxesGroup	Y	
VAR_INPUT			
B	Execute	Y	
E	Deceleration	Y	
E	Jerk	Y	
E	BufferMode	Y	
VAR_OUTPUT			
B	Done	Y	
E	Busy	Y	
E	Active	Y	
E	CommandAborted	Y	
B	Error	Y	
E	ErrorID	Y	

### Appendix A 5.19. MC\_GroupHalt

If Supported	MC_GroupHalt	Sup. Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Execute		
E	Deceleration		
E	Jerk		
E	BufferMode		
VAR_OUTPUT			
B	Done		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		

### Appendix A 5.20. MC\_GroupInterrupt

If Supported	MC_GroupInterrupt	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Execute		
E	Deceleration		
E	Jerk		
VAR_OUTPUT			
B	Done		
E	Busy		
E	Comman Aborted		
B	Error		
E	ErrorID		

### Appendix A 5.21. MC\_GroupContinue

If Supported	MC_GroupContinue	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Execute		
VAR_OUTPUT			
B	Done		
E	Busy		
E	Comman Aborted		
B	Error		
E	ErrorID		

### Appendix A 5.22. MC\_GroupReadStatus

If Supported	MC_GroupReadStatus	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Enable		
VAR_OUTPUT			
B	Valid		
E	Busy		
B	GroupMoving		
B	GroupHoming		
B	GroupErrorStop		
B	GroupStandby		
B	GroupStopping		
B	GroupDisabled		
E	ConstantVelocity		
E	Accelerating		
E	Decelerating		
E	InPosition		
B	Error		
E	ErrorID		

### Appendix A 5.23. MC\_GroupReadError

If Supported	MC_GroupReadError	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Enable		
VAR_OUTPUT			
B	Valid		
E	Busy		
B	Error		
E	ErrorID		
B	GroupErrorID		

### Appendix A 5.24. MC\_GroupReset

If Supported	MC_GroupReset	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup	Y	
VAR_INPUT			
B	Execute	Y	
VAR_OUTPUT			
B	Done	Y	
E	Busy	Y	
B	Error	Y	
E	ErrorID	Y	
V	Failure	Y	TRUE when the instruction was not executed correctly

### Appendix A 5.25. MC\_MoveLinearAbsolute

If Supported	MC_MoveLinearAbsolute	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup	Y	
VAR_INPUT			
B	Execute	Y	
B	Position	Y	
E	Velocity	Y	
E	Acceleration	Y	
E	Deceleration	Y	
E	Jerk	Y	
E	CoordSystem	Y	
E	BufferMode	Y	
E	TransitionMode	Y	
E	TransitionParameter	N	
VAR_OUTPUT			
B	Done	Y	
E	Busy	Y	
E	Active	Y	
E	CommandAborted	Y	
B	Error	Y	
E	ErrorID	Y	

**Appendix A 5.26. MC\_MoveLinearRelative**

If Supported	MC_MoveLinearRelative	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup	Y	
VAR_INPUT			
B	Execute	Y	
B	Distance	Y	
E	Velocity	Y	
E	Acceleration	Y	
E	Deceleration	Y	
E	Jerk	Y	
E	CoordSystem	Y	
E	BufferMode	Y	
E	TransitionMode	Y	
E	TransitionParameter	N	
VAR_OUTPUT			
B	Done	Y	
E	Busy	Y	
E	Active	Y	
E	CommandAborted	Y	
B	Error	Y	
E	ErrorID	Y	

**Appendix A 5.27. MC\_MoveCircularAbsolute**

If Supported	MC_MoveCircularAbsolute	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Execute		
B	CircMode		
B	AuxPoint		
B	EndPoint		
E	PathChoice		
E	Velocity		
E	Acceleration		
E	Deceleration		
E	Jerk		
E	CoordSystem		
E	BufferMode		
E	TransitionMode		
E	TransitionParameter		
VAR_OUTPUT			
B	Done		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		

### Appendix A 5.28. MC\_MoveCircularRelative

If Supported	MC_MoveCircularRelative	Sup. Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Execute		
B	CircMode		
B	AuxPoint		
B	EndPoint		
E	PathChoice		
E	Velocity		
E	Acceleration		
E	Deceleration		
E	Jerk		
E	CoordSystem		
E	BufferMode		
E	TransitionMode		
E	TransitionParameter		
VAR_OUTPUT			
B	Done		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		

### Appendix A 5.29. MC\_MoveDirectAbsolute

If Supported	MC_MoveDirectAbsolute	Sup. Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Execute		
B	Position		
E	CoordSystem		
E	BufferMode		
E	TransitionMode		
E	TransitionParameter		
VAR_OUTPUT			
B	Done		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		



### Appendix A 5.30. MC\_MoveDirectRelative

If Supported	MC_MoveDirectRelative	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
VAR_INPUT			
B	Execute		
B	Distance		
E	CoordSystem		
E	BufferMode		
E	TransitionMode		
E	TransitionParameter		
VAR_OUTPUT			
B	Done		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		

### Appendix A 5.31. MC\_PathSelect

If Supported	MC_PathSelect	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
B	PathData		
B	PathDescription		
VAR_INPUT			
B	Execute		
E	CoordSystem		
VAR_OUTPUT			
B	Done		
E	Busy		
B	Error		
E	ErrorID		

### Appendix A 5.32. MC\_MovePath

If Supported	MC_MovePath	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
B	PathData		
VAR_INPUT			
B	Execute		
E	CoordSystem		
E	BufferMode		
E	TransitionMode		
E	TransitionParameter		
VAR_OUTPUT			
B	Done		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		

### Appendix A 5.33. MC\_GroupSetOverride

If Supported	MC_GroupSetOverride	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup	Y	
VAR_INPUT			
B	Enable	Y	
B	VelFactor	Y	
E	AccFactor	Y	Reserved in Version 1.0
E	JerkFactor	Y	Reserved in Version 1.0
VAR_OUTPUT			
B	Enabled	Y	
E	Busy	Y	
B	Error	Y	
E	ErrorID	Y	

### Appendix A 5.34. MC\_SyncAxisToGroup

If Supported	MC_SyncAxisToGroup	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
B	SlaveAxis		
VAR_INPUT			
B	Execute		
E	RatioNumerator		
E	RatioDenominator		
E	Acceleration		
E	Deceleration		
E	Jerk		
E	CoordSystem		
E	BufferMode		
VAR_OUTPUT			
B	InSync		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		

### Appendix A 5.35 MC\_SyncGroupToAxis

If Supported	MC_SyncGroupToAxis	Sup.Y/N	Comments
VAR_IN_OUT			
B	Master		
B	AxesGroup		
B	PathData		
VAR_INPUT			
B	Execute		
E	Mode		
E	TuCNumerator		
E	TuCDenominator		
E	Acceleration		
E	Deceleration		
E	Jerk		
E	CoordSystem		
E	BufferMode		
VAR_OUTPUT			
B	InSync		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		

### Appendix A 5.36. MC\_SetDynCoordTransform

If Supported	MC_SetDynCoordTransform	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
B	MasterAxesGroup		
B	CoordTransform		
VAR_INPUT			
B	Execute		
E	Mode		
E	CoordSystem		
E	BufferMode		
VAR_OUTPUT			
B	Done		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		

### Appendix A 5.37. MC\_TrackConveyorBelt

If Supported	MC_TrackConveyorBelt	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
E	ConveyorBelt		
VAR_INPUT			
B	Execute		
B	ConveyorBeltOrigin		
E	InitialObjectPosition		
E	CoordSystem		
E	BufferMode		
VAR_OUTPUT			
B	Done		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		

### Appendix A 5.38. MC\_TrackRotaryTable

If Supported	MC_TrackRotaryTable	Sup.Y/N	Comments
VAR_IN_OUT			
B	AxesGroup		
E	RotaryTable		
VAR_INPUT			
B	Execute		
B	RotaryTableOrigin		
E	InitialObjectPosition		
E	CoordSystem		
E	BufferMode		
VAR_OUTPUT			
E	Done		
E	Busy		
E	Active		
E	CommandAborted		
B	Error		
E	ErrorID		