Системные макро-переменные OPENCNCMACRO.
Feed Control Word (#1504)

	Description
Bit 0	Feedhold Inhibit. 0(default): feedhold enabled, 1: feedhold disabled. When feed hold is disabled: • When the feed hold button is held down, the machine stops in the single block stop mode. However, single block stop operation is not performed when the single block mode is disabled with variable #1502. • When the feed hold botton is pressed then released, the feed hold lamp(by MLC S bit) come on, but the machine does not stop; program execution continues and the machine stops at the first block where feed hold is enabled.
Bit 1	Override Inhibit. 0(default): override enabled, 1: override disabled. When ederate override is disabled, an override of 100% is always applied regardless of the setting of the ederate override switch(by MLC Register) on the machine operator's panel
Bit2	(*not yet implement*) Exact stop inhibit. 0(default): exact stop enabled, 1: exact stop disabled. When exact stop check is disabled, no exact stop check(position check) is made even in blocks including those which do not perform cutting

- When the power is turned on, the value of this variable is 0.
- When feed hold is disabled:
  1. When the feed hold button is held down, the machine stops in the single block stop mode. However, single block stop operation is not performed when the single block mode is disabled with variable #1502.
  2. When the feed hold botton is pressed then released, the feed hold lamp(by MLC S bit) come on, but the machine does not stop; program execution continues and the machine stops at the first block where feed hold is enabled.
- When feedrate override is disabled, an override of 100% is always applied regardless of the setting of the feedrate override switch(by MLC Register) on the machine operator's panel.
- When exact stop check is disabled, no exact stop check(position check) is made even in blocks including those which do not perform cutting.