IO-Link interface description

1 General information

1.1 Document version

20230405 IO-Link Interface description (replaces earlier versions)

1.2 Valid for firmware version

2.04.07 and higher

2 Table of contents

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3 The most important in brief

- The cylinder can be used with and without IO-Link
- The configuration data can be written via IO-Link, after which the cylinder can also be operated without IO-Link (via digital signals), but with the new configuration.
- If the IO-Link connection is active, an operating mode (Motion Mode) must be selected. In mode 0, the cylinder is not moved.
- The variables are stored in the IODD together with their description. The meaning of the variables can also be viewed without instructions via the IO-Link master.

IMPORTANT	
	The cyclic process data may be written during operation. The cylinder should be stopped for writing the remaining data. When writing the data, load shedding or even a restart of the device could occur.

IMPORTANT	
	Under no circumstances may the configuration variables be written to cyclically. Writing to these variables too frequently can damage the device. All important properties that must be controlled cyclically can be controlled via the cyclic process data.

IMPORTANT	
	In normal IO-Link operation, the current consumption remains well below 200mA, so all commercially available masters can provide the supply. However, if a large load is to be attached to one of the digital outputs (possible up to 250mA), then a master with a correspondingly higher output current must also be used.

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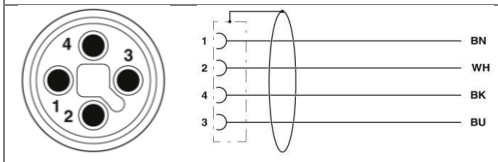
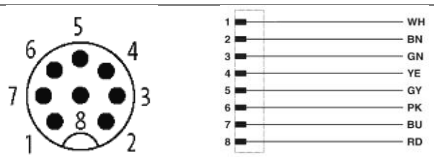
4 Connection

Power	Signal
Plug M12x1, 4-pole T-coded according to EN 61076-2-11	**Plug M12x1, 8-pin** A-coded according to EN 61076-2-101 (Shielded cables are recommended)
	

Pin assignment Digital I/O

Pin	Farbe	Funktion	Pin	Farbe	Funktion
1	BN	Power voltage 24V-48V ± 15% (max. 10A) At 48V the use of a brake chopper is recommended.	**1**	WH	DO Ready / IO Link CQ
2	WH	Functional earth (FE)	**2**	BN	Logic voltage 24V ± 15% (max. 500mA)
3	BU	GND 0V	**3**	GN	DO is extended (optional)
4	BK	reserved, do not connect	**4**	YE	DO is retracted (optional)
			5	GY	DI Retract (optional)
			6	PK	DI Extend (optional)
			7	BU	GND 0V
			8	RD	DI Teach / Reset / Powerless

TABLE 1: CONNECTION

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5 Process data structure

Process input data (Slave->Master):

Byte Nr.:	**0**	**1**	**2-5**	**6-9**	**10-13**
Variable:	State	Statusbits	Actual Position	Actual Speed	Actual Force
Datatype:	Uint8	Uint8	Float32	Float32	Float32
Details:	Chapter 7.1	Chapter 0	Chapter 7.3	Chapter 7.3	Chapter 7.3

TABLE 2: PROCESS INPUT DATA

Process output data (Master->Slave):

Bytenr.:	**0**	**1-4**	**5**	**6**	**7**
Variable:	Motion Mode	Target Position	Override 1	Override 2	Override 3
Datatype:	Uint8	Float32	Uint8	Uint8	Uint8
Details:	Chapter 6	Chapter 6	Chapter 6.7	Chapter 6.7	Chapter 6.7

TABLE 3: PROCESS OUTPUT DATA

Note	
	The above tables show the structure of the process data. The transmission sequence in the IO-Link telegram is shown in the table from left to right.

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6 Description of the operating modes

The mode is selected via the cyclic process data with the variable “Motion Mode”.

6.1 UserMode_Off = 0

Power Supply of the Axis is cut off. If a command is triggered via the digital IO, it is immediately reset. No movement is executed.

6.2 UserMode_DIO = 1

The device can be controlled via the digital IO. The mode is essentially the same as operation without active IO-Link, but the variables can be read and written.

If no command level is present at the digital IOs, the device stops and remains in control at the current position. If coming from mode 0, the controller remains switched off.

This mode can also be seen as a stop-command in IO-Link mode.

6.3 UserMode_Teach = 2

The Axis is teached via a new learning run. First, the device travels in the direction corresponding to the “DirectionOfTravel” variable. Speed, acceleration, deceleration, and force of the learning run are set with the variables “Max. Speed Teach Mode”, “Max. Acceleration”, “Max. Deceleration” and “Max. Force”. If “Max. Force” = 0, the force is set using the force potentiometer.

The learning run can only be started when the device is in Idle status. From operation, the mode “UserMode_Off = 0” must be selected first.

6.4 UserMode_MoveOut = 3

A movement to the outer end position is triggered according to the “End Position Out” variable. Speed, acceleration, deceleration, and force of the movement are set with the variables “Max. Speed Out”, “Max. Acceleration”, “Max. Deceleration” and “Max. Force”. If “Max. Speed Out” = 0 or “Max. Force” = 0, the values are set using the speed or force potentiometers respectively.

6.5 UserMode_MoveIn = 4

A movement to the inner end position is triggered according to the “End Position In” variable. Speed, acceleration, deceleration, and force of the movement are set with the variables “Max. Speed In”, “Max. Acceleration”, “Max. Deceleration” and “Max. Force”. If “Max. Speed In” =0 or “Max. Force” = 0, the values are set using the speed or force potentiometers respectively.

6.6 UserMode_FreePos = 5

The target position is specified via the “Target Position” process variable. The axis follows this target position. Speed, acceleration, deceleration, and force of the movement are set with the variables “Max. Speed free positioning”, “Max. Acceleration”, “Max. Deceleration” and “Max. Force free positioning”.

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HINWEIS	
	The target position “Target Position” must lie between the two end positions “End Position In” and “End Position Out”, otherwise no movement is started.

6.7 UserMode_FreePosPro = 6

Based on mode “UserMode_FreePos” = 5. In addition, the preconfigured values for speed, force and acceleration/deceleration can be scaled from 0% to 255% via the process variables “Override 1-3”.

Assignment:

Process variable	Scaled value
Override 1	Speed
Override 2	Force
Override 3	Acceleration/ Deceleration

TABLE 4: OVERRIDE ASSIGNMENT

HINWEIS	
	If “Override 1”, “Override 2” or “Override 3” = 0, no movement is executed with “Motion Mode” = 6

6.8 UserMode_HomeDirect = 7

With this mode, the axis can be referenced manually. The actual position is set equal to the “Target Position” process variable. The “Homed” status bit is set active.

WICHTIG	
	When referencing manually, **it must be taken into consideration that the parameterized end positions (“End Position Out” and “End Position In”) are still approached when using User Mode 3 and 4**, as these end positions are not altered when referencing via Mode 7. These end positions may have to be adapted to the application to prevent unwanted behaviour

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6.9 UserMode_PosSequence = 11 to 14

A positioning sequence is a preconfigured motion sequence that can be triggered with a simple command. Up to four sequences can be preconfigured in the parameters, which can then be triggered via User Mode 11 to 14.

Target Position (1)	rw	0.000	d	mm
Target Speed (1)	rw	0	d	mm/s
Target Acceleration (1)	rw	2	d	m/s²
Target Deceleration (1)	rw	2	d	m/s²
Target Positioning Time (1)	rw	0.000	d	ms
Target Positioning Force (1)	rw	400.00	d	N
Target Positioning Mode (1)	rw	Absolute	d	

FIGURE 1: POSITIONING SEQUENCES

The following applies:

Mode 11: Current actual position → Positioning Sequence 1
Mode 12: Current actual position → Positioning Sequence 2
Mode 13: Current actual position → Positioning Sequence 3
Mode 14: Current actual position → Positioning Sequence 4

The target position must be within a valid range (see chapter 6.7) and the target speed/acceleration/deceleration must not be 0. If the target positioning time is = 0, the target position is approached with the preconfigured values for speed/acceleration/deceleration. If the target positioning time > 0, the target speed is recalculated so that the movement (from the current position to the target position) is carried out within the preconfigured time. The target acceleration/deceleration parameters are used when calculating the path, and the target speed parameter serves as a limit value if the target positioning time cannot be reached (if, for example, the acceleration/deceleration selected was too small).

HINWEIS	
	The “Target Positioning Mode” sequence parameter is still under development. In the case of all positioning sequences, the target positions are absolute.

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Example for a movement sequence with Target Position = 50mm, Target Speed = 300mm/s, Target Acceleration/Deceleration = 2m/s^2, Target Positioning Time = 0:

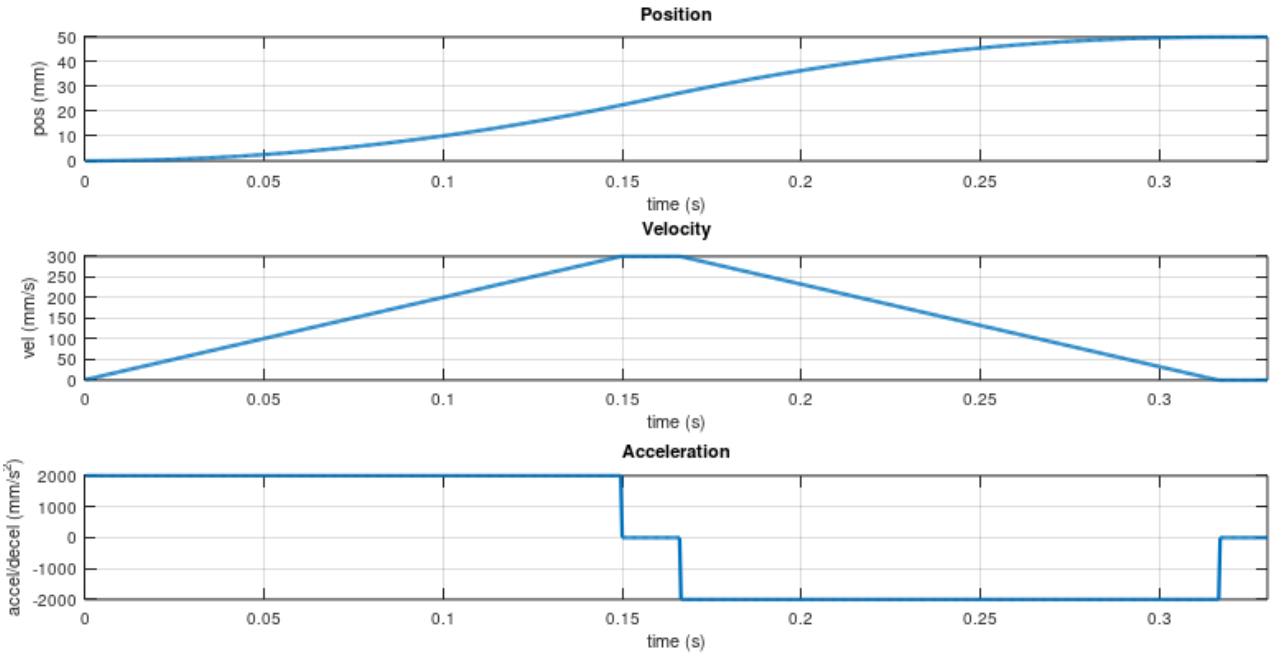

FIGURE 2: POSITIONING SEQUENCE EXAMPLE 1

Example for a movement sequence with Target Position = 50mm, Target Speed = 300mm/s, Target Acceleration/Deceleration = 2m/s^2, Target Positioning Time = 0.5s:

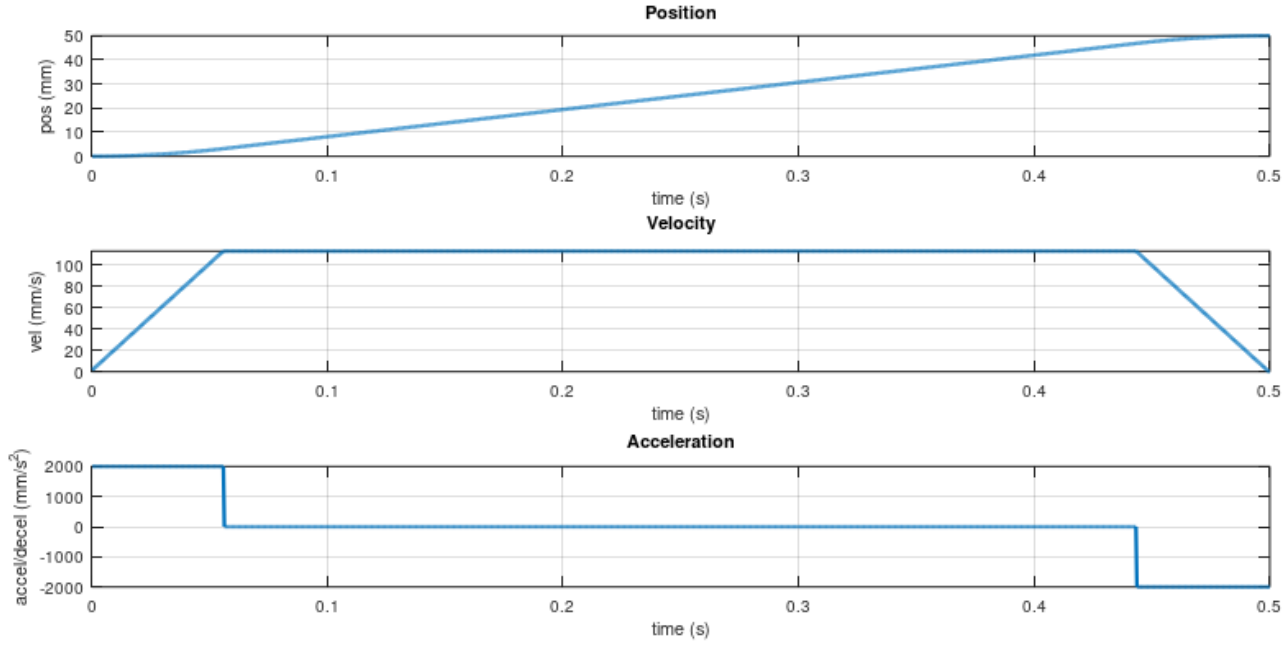

FIGURE 3: POSITIONING SEQUENCE EXAMPLE 2

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6.10 UserMode_PressIn = 21 to 27

The Press In Mode uses the positioning sequences (see Chapter 6.9) to sequentially move to two pre-configured positions automatically. There are two variants:

- In mode 21 to 23, the first sequence is completed (i.e. with stop), then the second sequence is triggered.
- In modes 25 to 27 there is a smooth transition between the two sequences. If the target speed of the second sequence is lower than that of the first, the first position will be reached at the target speed of the second sequence. If the target speed of the second sequence is higher than that of the first sequence, the first position will be reached with the target speed of the first sequence

The following applies:

Mode 21 and 25: Current actual position → Sequence 1 → Sequence 2
Mode 22 and 26: Current actual position → Sequence 2 → Sequence 3
Mode 23 and 27: Current actual position → Sequence 3 → Sequence 4

HINWEIS	
	A target positioning time can also be configured for the press-in modes. In modes 25 to 27 (with a smooth transition) however, the cumulative time of both sequences can will be imprecise. It is recommended to select Target Positioning Time = 0 for these modes and to define the movement via Target Speed.

HINWEIS	
	If the current actual position of the cylinder lies between both target positions when starting a press-in mode via mode 25 to 27, the first position is ignored and the cylinder moves directly to position 2.

6.11 UserMode_Reset = 255

Serves to reset one (or more) present errors. The error state is exited again when changing from Motion Mode 255 to another Mode (e.g. Mode 1).

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7 Feedback

The current values for position, speed and force are reported back directly via process variables.

7.1 Status byte

The status is reported back via a process byte with the following content:

Value	State	Meaning
0	Idle	Switched off or at standstill
1	Ready	The device is ready to accept a command
2	Active	Positioning mode active
3	Error	Error condition
4	Teach	Teach run in progress

TABLE 5: STATUSBYTE

7.2 Status bits

Further process data are available for evaluation; these are stored in the process data in the form of 8 status bits:

Value	State	Meaning
7	Tracking Error Tolerance Exceeded	Configured tracking error tolerance “Max. Tracking Error” is exceeded. This bit is set even if tracking error monitoring is deactivated (“Tracking Error Monitoring” = False).
6	Warning active	Temperature or voltage has exceeded the warning limit, or axis is in error
5	Motion command completed	A movement command has finished successfully
4	Motion Mode active	A movement command is in execution
3	Limit switch in	The position of the axis is located at “Pos. Sensor Signal In (limit switch)”, within the tolerance “Tolerance Position Sensor Signal In (Limit Switch)”
2	Limit switch out	The position of the axis is located at “Pos. Sensor Signal Out (limit switch)”, within the tolerance “Tolerance Position Sensor Signal Out (Limit Switch)”
1	Homed	The device is referenced
0	Ready	The device is ready to accept a command. If no power supply is connected, this bit will stay False

TABLE 6: STATUSBITS

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7.3 Actual Position, Actual Speed & Actual Force

The “Actual Position” process variable is returned in every operating state. The process variables “Actual Speed” and “Actual Force” are only returned when the controller is active.

HINWEIS	
	The “Actual Force” process variable is calculated using the motor current and is therefore only an estimate of the force currently acting on the axis. Due to friction effects, the actual acting force is expected to be smaller than the process data value

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8 Notes on parameterization

The axis can be freely parameterized using the variables in Table 8. In the previous chapters, most of the parameters have been described in terms of the relevant modes (see chapter 6). Below are notes on other parameters.

8.1 Tracking Error

The tracking error monitoring compares the target value of the pathplanner and the actual value of the axis during a motion sequence. The error tolerance is set using the “Max. Tracking Error” variable. If the axis is in tracking error, it is **always reported back** using the status bit “Tracking Error Tolerance Exceeded”. If tracking error monitoring is switched on (“Tracking Error Monitoring” = True), in the event of a tracking error, the axis will go into error state (status byte = 3) and the axis will be switched off.

HINWEIS	
	If the axis goes into the error state due to a following error, this is **not** signaled by a flashing pattern on the red LED on the axis. In this case, all LEDs go out

HINWEIS	
	A typical application error when using the FreePosPro mode ("Motion Mode" = 6, see Chapter 6.7) is setting "Override 2" to 0 (target force). In this case, the "Tracking Error Tolerance Exceeded" process data bit reports a following error, even though no movement has yet been carried out

8.2 Control Mode

Special operating modes can be set using the “Control Mode (Bistable, Omnistable)” variable. Currently, only the modes “Omnistable” = 0 and “Bistable” = 1. These modes influence, among other, the function of Motion Mode 3 and 4 and are already documented in the operating instructions ***_Manual_CTL_EN).

HINWEIS	
	The «Bistable» mode is intended for applications in which the cylinder is controlled via digital in- and outputs (DIOs). For more information, refere to the corresponding operating instructions. If this mode is active, movements that are currently active can can only be aborted with «Motion Mode» = 0.

8.3 Reservierte Parameter

Following parameters currently have no functionality and can be ignored:

- Reserved, Index 79
- Rated Power Voltage, Index 81

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9 IO-Link Error Codes

The following error states can be read out via the IO-Link events:

Name	Code
Undertemperature Micro Controller	6210
Overtemperature Micro Controller	6211
Undertemperature Controller Board	6212
Overtemperature Controller Board	6213
Undertemperature Encoder Board	6214
Overtemperature Encoder Board	6215
Overtemperature Power Stage Phase U	6216
Overtemperature Power Stage Phase V	6217
Overtemperature Power Stage Phase W	6218
Overtemperature Motor Phase U	6219
Overtemperature Motor Phase V	6220
Overtemperature Motor Phase W	6221
Controller Error (e.g. Overcurrent)	6222
Internal Error	6223
Tracking Error	6224

TABLE 7: IO-LINK ERROR CODES

HINWEIS	
	How to read out the events depends on the respective IO-Link master. See the relevant manufacturer documentation.

9.1 Notes on IO-Link Error Codes

9.1.1 Overtemperature

Error codes **6210** to **6221** indicate thermal overload of the axis. For example, the axis was moving for too long with too much load. The axis may be driving against an end stop with high force or its movement is blocked (e.g. after incorrect referencing, etc.). See the data sheet for the permissible RMS loads for the respective axis type and spindle pitch.

9.1.2 Controller Error

Error code **6222** reports an error in the internal current-, speed- or position controller, for example if unexpectedly high currents occur.

9.1.3 Internal Error

Error Code **6223** reports an unexpected internal firmware error.

9.1.4 Tracking Error

Error code **6224** reports that the axis is in a following error. See chapter 8.1

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10 Simple application examples

10.1 Approaching two taught-in end positions

This procedure corresponds to the use of the digital inputs and outputs. However, the wiring can be saved and everything can be controlled via the software.

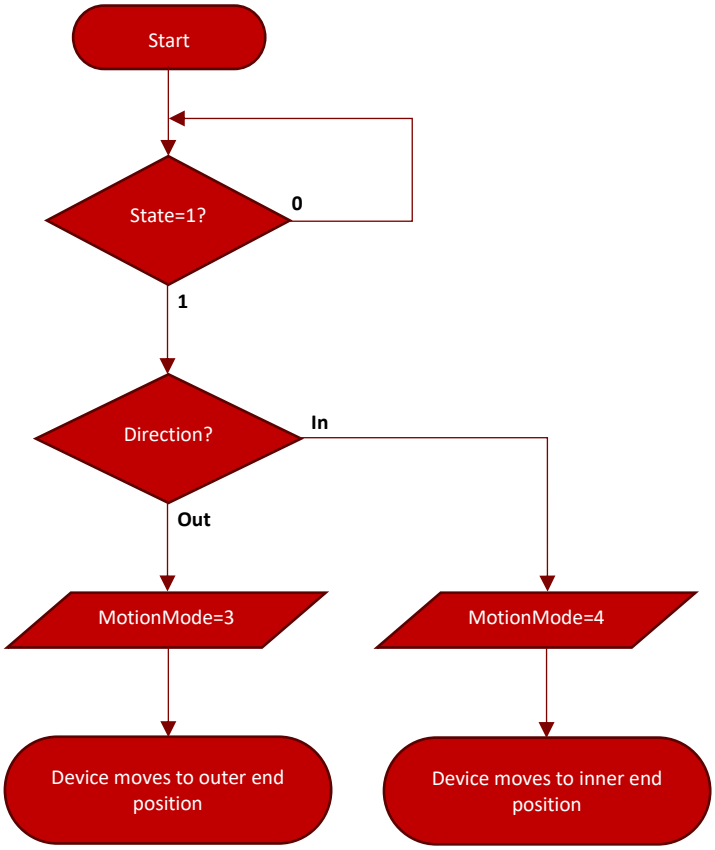

FIGURE 4: APPROACHING TWO TAUGHT IN END POSITIONS

The first movement is performed slowly to detect the end stop.

Afterwards, it is possible to switch back and forth between modes 3 and 4 as desired. A movement can also be stopped on the way by changing to mode 1 (position controller remains active) or mode 0 (position controller is deactivated).

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10.2 Free positioning via cyclic data

Free positioning via the cyclic data can be set up as follows. As soon as the device is ready for operation (State=1 or Ready Bit=1), an end position can be approached. The device is then referenced and can be moved in free positioning mode.

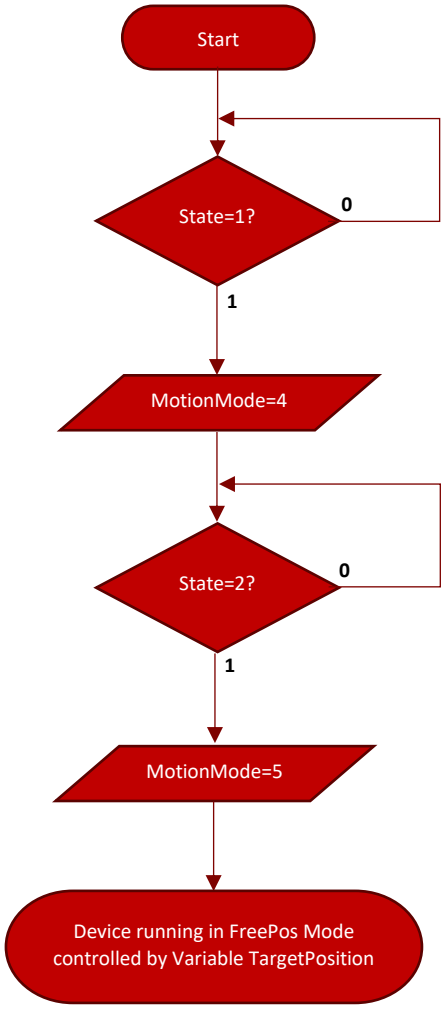

FIGURE 5: POSITIONING VIA CYCLICAL DATA

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10.3 Teaching a new travel range

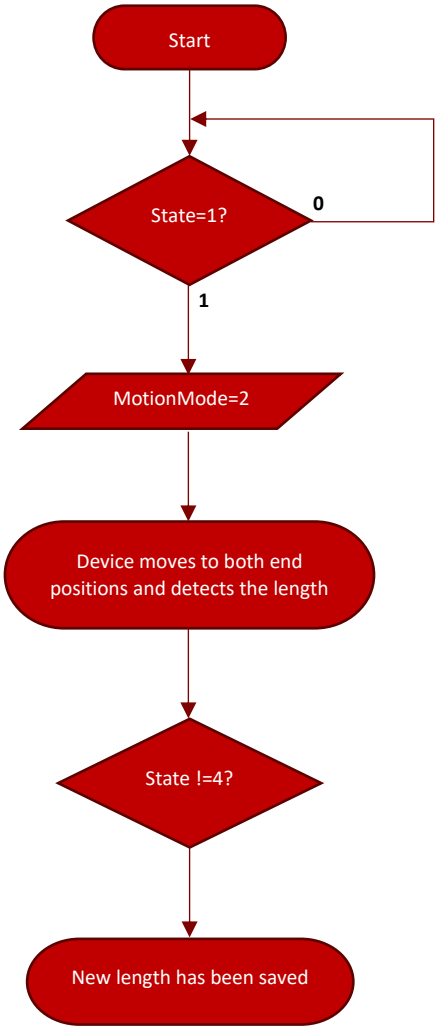

FIGURE 6: TEACHING A NEW TRAVEL RANGE

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11 Variable list

11.1 configuration (read/write)

Name	Index	Datatype	Value Range	Unit	Single Values
Max. Speed In	64	Float32T	0 to 600	mm/s	
Max. Speed Out	65	Float32T	0 to 600	mm/s	
Max. Speed free Positioning	66	Float32T	1 to 600	mm/s	
Max. Force	67	Float32T	0 to 450	N	
Max. Acceleration	68	Float32T	0.01 to 20	mm/s^2	
Max. Deceleration	69	Float32T	0.01 to 20	mm/s^2	
Max. Tracking Error	70	Float32T	0.01 to 10000	mm	
Tracking Error Monitoring	71	Float32T			false (false), true (true)
Position Tolerance for Status Feedback	72	BooleanT	0.01 to 10000	mm	
Tolerance Position Sensor Signal Out (Limit Switch)	73	Float32T	0.01 to 10000	mm	
Tolerance Position Sensor Signal In (Limit Switch)	74	Float32T		mm	
End Position Out	75	Float32T		mm	
End Position In	76	Float32T		mm	
Pos. Sensor Signal Out (limit switch)	77	Float32T		mm	
Pos. Sensor Signal In (limit switch)	78	Float32T		mm	
Reserved	79	Float32T	0.1 to 10		
Max. Speed Teach Mode	80	Float32T	1 to 200	mm/s	
Rated Power Voltage	81	Float32T	24 to 48	V	
Control Mode (Bistable, Omnistable)	82	Float32T			Omnistable (0), Bistable (1), PWM Mode (2), DIO-Ramp (3), DIO-Press (4)
Direction of Travel	83	UIntegerT_8			extend (1), retract (0)
Max. Force free positioning	84	UIntegerT_8	0 to 450	N	
Target Position (1)	90	Float32T		mm	
Target Speed (1)	91	Float32T	0 to 600	mm/s	
Target Acceleration (1)	92	Float32T	0.01 to 20	mm/s^2	
Target Deceleration (1)	93	Float32T	0.01 to 20	mm/s^2	
Target Positioning Time (1)	94	Float32T	0 to 10000000	ms	
Target Position (2)	100	Float32T		mm	
Target Speed (2)	101	Float32T	0 to 600	mm/s	
Target Acceleration (2)	102	Float32T	0.01 to 20	mm/s^2	
Target Deceleration (2)	103	Float32T	0.01 to 20	mm/s^2	
Target Positioning Time (2)	104	Float32T	0 to 10000000	ms	
Target Position (3)	110	Float32T		mm	
Target Speed (3)	111	Float32T	0 to 600	mm/s	
Target Acceleration (3)	112	Float32T	0.01 to 20	mm/s^2	
Target Deceleration (3)	113	Float32T	0.01 to 20	mm/s^2	
Target Positioning Time (3)	114	Float32T	0 to 10000000	ms	
Target Position (4)	120	Float32T		mm	
Target Speed (4)	121	Float32T	0 to 600	mm/s	
Target Acceleration (4)	122	Float32T	0.01 to 20	mm/s^2	
Target Deceleration (4)	123	Float32T	0.01 to 20	mm/s^2	
Target Positioning Time (4)	124	Float32T	0 to 10000000	ms	
Target Positioning Force (1)	240	Float32T	0 to 450	N	

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Target Positioning Force (2)	241	Float32T	0 to 450	N	
Target Positioning Force (3)	242	Float32T	0 to 450	N	
Target Positioning Force (4)	243	Float32T	0 to 450	N	
Target Positioning Mode (1)	244	UIntegerT_32			Absolute (0), Relative (1)
Target Positioning Mode (2)	245	UIntegerT_32			Absolute (0), Relative (1)
Target Positioning Mode (3)	246	UIntegerT_32			Absolute (0), Relative (1)
Target Positioning Mode (4)	247	UIntegerT_32			Absolute (0), Relative (1)

TABLE 8: READ/WRITE VARIABLES

HINWEIS	
	The “Value Range” in the table above applies to a spindle pitch of 10mm (type CTC-060-K10 or CTL-060-K10). For other types (e.g. CTC-060-K05) see the corresponding IODD. Current IODDs can be found online on the IODDfinder platform: IODDfinder (io-link.com)

HINWEIS	
	Detailed description of the parameters is in progress. The most important parameters are described in chapters 6, 7, 0

11.2 Diagnose (read only)

Name	Index	Datatype	Value Range	Single Values
Lubrication Countdown (in development)	140	Float32T		
Lifetime Countdown (in development)	141	Float32T		
Reserved	142	Float32T		
Temperature Board	143	Float32T		
Temperature Encoder	144	Float32T		
Temperature Power Unit	145	Float32T		
Reserved	146	Float32T		
Temperature Motor	147	Float32T		
Actual Tracking Error (in development)	148	Float32T		
Actual Control Voltage	149	Float32T		
Actual Power Intermediate Circuit Voltage	150	Float32T		
Reserved	151	Float32T		
Cycle Counter	152	IntegerT_32		
EEPROM Version	153	IntegerT_32		
Error counter for "Undervoltage Logic"	160	IntegerT_16		
Error counter for "Overvoltage Logic"	161	IntegerT_16		
Error counter for "Undervoltage Power"	162	IntegerT_16		
Error counter for "Overvoltage Power"	163	IntegerT_16		
Error counter for "Undertemperature Micro Controller"	164	IntegerT_16		
Error counter for "Overtemperature Micro Controller"	165	IntegerT_16		
Error counter for "Undertemperature Controller Board"	166	IntegerT_16		
Error counter for "Overtemperature Controller Board"	167	IntegerT_16		
Error counter for "Undertemperature Encoder Board"	168	IntegerT_16		

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Error counter for "Overtemperature Encoder Board"	169	IntegerT_16		
Error counter for "Overtemperature Power Stage Phase U"	170	IntegerT_16		
Error counter for "Overtemperature Power Stage Phase V"	171	IntegerT_16		
Error counter for "Overtemperature Power Stage Phase W"	172	IntegerT_16		
Error counter for "Overtemperature Motor Phase U"	173	IntegerT_16		
Error counter for "Overtemperature Motor Phase V"	174	IntegerT_16		
Error counter for "Overtemperature Motor Phase W"	175	IntegerT_16		
Error Counter Controller Error	176	IntegerT_16		
Error Counter Internal Error	177	IntegerT_16		
Max. Temperature Controller Board	178	Float32T		
Max. Temperature Encoder	179	Float32T		
Max. Temperature Power Unit	180	Float32T		
Reserved	181	Float32T		
Max. Temperature Motor	182	Float32T		
Cycle Stamp Undervoltage Logic	183	IntegerT_32		
Cycle Stamp Overvoltage Logic	184	IntegerT_32		
Cycle Stamp Undervoltage Power	185	IntegerT_32		
Cycle Stamp Overvoltage Power	186	IntegerT_32		
Cycle Stamp Undertemperature Micro Controller	187	IntegerT_32		
Cycle Stamp Overtemperature Micro Controller	188	IntegerT_32		
Cycle Stamp Undertemperature Controller Board	189	IntegerT_32		
Cycle Stamp Overtemperature Controller Board	190	IntegerT_32		
Cycle Stamp Undertemperature Encoder Board	191	IntegerT_32		
Cycle Stamp Overtemperature Encoder Board	192	IntegerT_32		
Cycle Stamp Overtemperature Power Stage Phase U	193	IntegerT_32		
Cycle Stamp Overtemperature Power Stage Phase V	194	IntegerT_32		
Cycle Stamp Overtemperature Power Stage Phase W	195	IntegerT_32		
Cycle Stamp Overtemperature Motor Phase U	196	IntegerT_32		
Cycle Stamp Overtemperature Motor Phase V	197	IntegerT_32		
Cycle Stamp Overtemperature Motor Phase W	198	IntegerT_32		
Cycle Stamp Controller Error	199	IntegerT_32		
Cycle Stamp Internal Error	202	IntegerT_32		
Operating Hours	203	IntegerT_32		

TABLE 9: READ ONLY VARIABLES

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12 Appendix

12.1 Firmware Version History

Version	Release date	Description of changes	Compatible IODD
2.01.01	03.05.2022	First Release	Cyltronic-CTC-060-***-20220322-IODD1.1
2.03.01	10.08.2022	New Features: - New Device ID (separate ID per spindle pitch) - Force in “free positioning mode” now defined via “Max. force free positioning” instead of “Max. force” and potentiometer Essential Bugfixes: - Improved saving of parameters - Behavior in UserModeOff improved (no more disturbances by DIOs) - Timing behavior in Basic Mode (Modes 0 and 1) improved - Quieter position controller	From Cyltronic-CTC-060-***-20220719-IODD1.1
2.03.03	30.08.2022	Essential Bugfixes: - Improved saving of parameters - Bugfix at transition between modes 2 and 5/6 to 3 and 4 - Bugfix when homing with DIOs	From Cyltronic-CTC-060-***-20220719-IODD1.1
2.04.07	07.02.2023	New Features: - Controller with Pathplaner - Tracking Error - UserMode 11-14 & 21-27: Positioning Sequences & Press-In Mode - UserMode 7: Manual Referencing - Compatible for CTL Essential Bugfixes: - Process variable Actual Force is now calculated through actual current instead of target current - Application Reset fixed for CTC K05 and for CTL K05/10 - Loss of Parameters fixed	From Cyltronic-CTC-060-***-20230207-IODD1.1

12.2 IO-Link Interface Description History

Version	Description of changes
20230207	Initial document for History
20230405	- More detailed description of the operating modes with correspondingly relevant variables - Added general parameterization notes - Corrected indices in the variable list - Added units in variable list - Added IO-Link Error Codes - Added IO-Link interface description history

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12.3 List of figures

12.4 List of tables

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