

Element	Description
Value	<p>Value assignment to the system variable.</p> <p>In the case of SPTP segments: The assignment applies only for this segment.</p> <p>The system variables can also be assigned values by means of a function call. The same restrictions apply to these functions as to functions in the trigger.</p> <p>(&gt;&gt;&gt; <i>11.11.3 "Constraints for functions in the trigger" Page 542</i>)</p>
C_SPL	<ul style="list-style-type: none"> <li>With C_SPL: the end point is approximated. \$APO defines the earliest point at which the approximate positioning can begin.</li> <li>Only possible for individual motions, not for segments.</li> <li>Without C_SPL: the motion stops exactly at the end point.</li> </ul>
#BASE, #TOOL	<p>Only permissible if the end point was specified in Cartesian coordinates.</p> <ul style="list-style-type: none"> <li>#BASE (default): The coordinates of this end point refer to the coordinate system that belongs to the physical base.</li> <li>#TOOL: The coordinates of this end point refer to the coordinate system that belongs to the physical tool.</li> </ul> <p>\$IPO_MODE has no influence on the meaning of #BASE and #TOOL.</p>

**Example**

(>>> *"Example" Page 478*)

**11.6.11 System variables for WITH****Spline block, individual spline motion**

For spline blocks and individual spline motions, it is possible to write to the following system variables using the WITH line:

\$ACC  
 \$ACC\_AXIS  
 \$ACC\_EXTAX  
 \$APO  
 \$BASE  
 \$CIRC\_TYPE  
 \$COLLMON\_TOL\_PRO  
 \$DERI  
 \$ECO\_LEVEL  
 \$EXT\_IPO\_MODE  
 \$GEAR\_JERK  
 \$IPO\_MODE  
 \$JERK  
 \$JOINT\_OFFSET  
 \$LASER\_MODE