#6015					D3	D2	D1	D0

#6018	D7	D6	D5	D4		D2	D1	D0

D3, D2, D1, D0

Specify whether or not the automatic coordinate system setting is effective on the 4th-, Z-, Y- and X-axes, respectively.

1: Effective

0: Ineffective

NOTE: The automatic coordinate system is established with the following parameters:

Metric system; #6636 – #6639

Inch system; #6630 – #6633

#6016					D3	D2	D1	D0

D3, D2, D1, D0

Specify whether or not reference point return is effective on the 4th-, Z-, Y- and X-axes, respectively.

1: Makes reference point return effective.

0: Makes reference point return ineffective.

#6017	D7	D6	D5	D4	D3	D2	D1	D0

D7 - D0

Specify whether or not a hole is to be made on channels 8-1, respectively, in a code corresponding to symbol "#" (used with user macro) in the EIA code.

1: Hole

0: No hole

Example:
D7 - D0 = 01001001

The code with holes on channels 7, 4 and 1 is considered equivalent to symbol "#" in the EIA code. No code for use by the unit can be set.

NOTE: The specification of D7 - D0 =00000000 assumes that symbol "#" is not used in the EIA code.

D7 1: Provides dwell at hole bottom in the canned cycles of G76 and G77.

0: Does not provide dwell at hole bottom in the canned cycles of G76 and G77.

NOTE: The dwell time is set with #6210.

D6 1: Establishes M03 for G74 and M04 for G84 as the M code for output at hole bottom in the canned cycles of G74 and G84.

0: Reverses the M code in effect before the canned cycles for output at hole bottom in the canned cycle of G74 and G84.

Before canned cycle	Hole bottom
M03	⟶ M04
M04	⟶ M03

NOTE: This specification is effective when D4 = 0 in #6018.

D5 1: Rotates the spindle forward and in reverse, outputting M05 at hole bottom in the canned cycles of G74 and G84.

0: Rotates the spindle forward and in reverse, not outputting M05 at hole bottom in the canned cycles of G74 and G84.

NOTE: This specification is effective when D4 = 0 in #6018.

D4 1: Outputs a read-only signal (SSP, SRV, OSS) in the canned cycles.

0: Outputs the M code in the canned cycles.

D2 1: Causes the X and Y movement in the canned cycles to follow the G code in group 01 (G02 and G03 regarded as G01).

0: Causes the X and Y movement in the canned cycles to stay in rapid traverse.

D1 1: Outputs the FMF signal twice in a canned cycle.

0: Outputs the FMF signal once in a canned cycle.

D0 1: Outputs the external operation signal EF at the end of positioning by G81 (G81 being external operation function).

0: Does not output the external operation signal EF at the end of positioning by G81 (G81 being canned cycle).