Table 2.1 Input Format

No.	Address		Metric output		Inch input		B: Basic
			Metric input	Inch input	Metric input	Inch input	O: Optional
1	Program No.		O4		O4		B
2	Sequence No.		N4		N4		B
3	G function		G3		G3		B
4	Cordinate Word	Linear axis	a + 43	a + 34	a + 53	a + 34	B
		Rotary axis	b + 43	b + 43	b + 43	b + 43	O
5	Feed/min		F40	F31	F50	F31	B
6	Feed/min 1/10		F41	F32	F51	F32	B
7	Feed/rev		F22	F13 .	F22	F13	O
8	Feed/rev 1/10		F23	F14	F23	F14	O
9	S-function		S2		S2		B
			S5		S5		O
10	T-function		T2		T2		B
			T4		T4		O
11	M-function		M3		M3		B
12	Tool Offset No.		H2 or D2		H2 or D2		B
13	B-function		B3		B3		O
14	Dwell		P53		P53		B
15	Program No. designation		P4		P4		B
16	Sequence No. designation		P4		P4		B
17	No. of repititions		L8		L8		B