

2.9.28 OUTPUT FOR EXTERNAL MOTION (G80, G81)[†]

G81 X... Y... L... ;

With this command, the control outputs external motion signals to the machine after each positioning.

The L number specifies the number of repeated positioning motions. G81 is a modal G code, and remains effective until cancellation with G80. G81 may be used either for this purpose or as a canned cycle command code, depending on the setting of the parameter #6018D0.

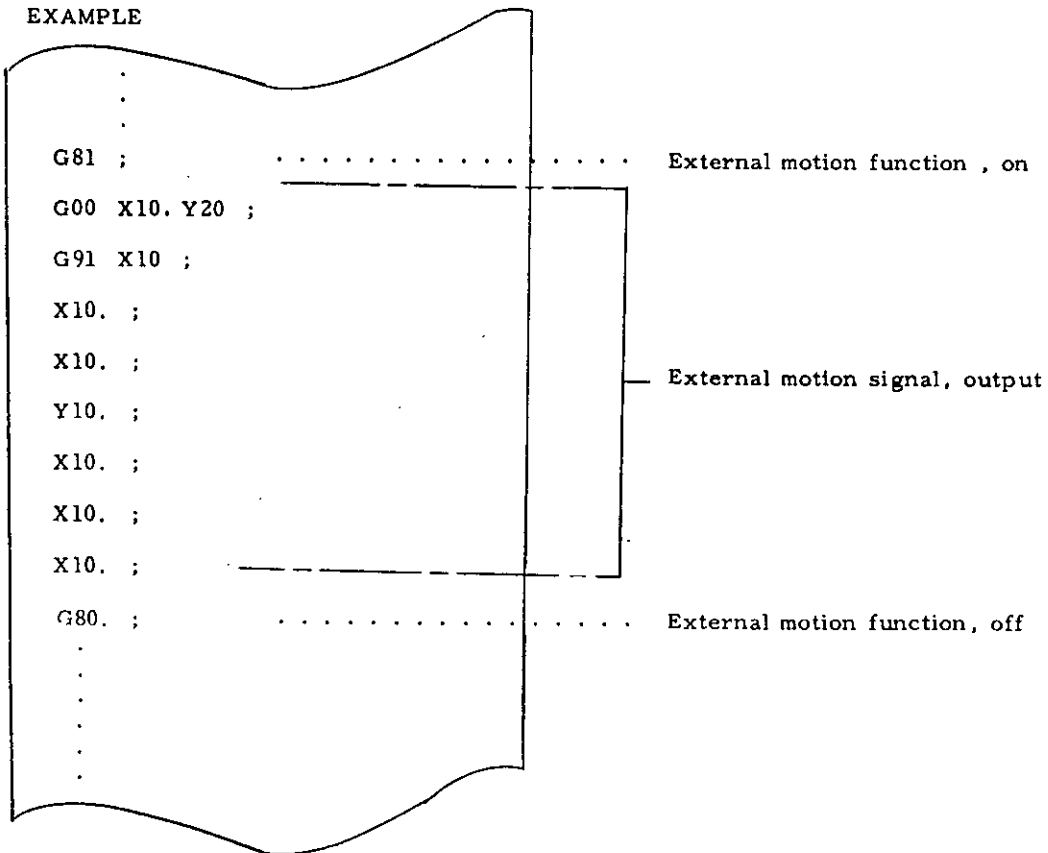


Fig. 2.80