

- When M95 is given, the subsequent blocks will control the machine in mirror-image fashion, that is, movements in the specified coordinate direction will be reversed.

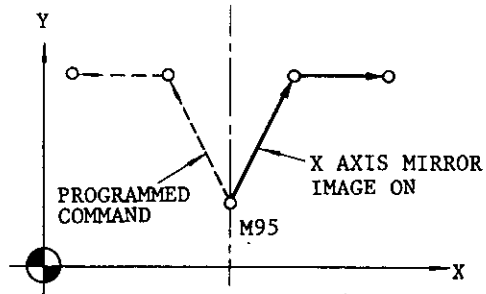


Fig. 2.8

With both the absolute and increment move commands, the same mirror image effect will be obtained. The block including M95 command constitutes the mirror point.

- When M94 is given, mirror image effect will be cancelled on the subsequent blocks. Mirror image operation must be started and cancelled at the same position.

NOTES:

- When G28 or G29 is used to change tools or for ending machining processes, make sure to cancel the mirror image effect by means of M94. If mirror image effect is not cancelled when G28 or G29 is given, an error "058" is shown.
- The mirror image effect is not effective on the offset movement resulting from the tool length offset function.
- Do not switch the designation of mirror image axis during operations under M95 (ON) mode.
- Displayed current position by POS key in mirror image fashion indicates the actual motion of tool. Displayed data by COM key show programmed commands.
- Program must be made so that mirror image operation starts and stops at the same position. If the start position and the stop position are not the same, movements of the machine after cancelling mirror image will be shifted by the difference between both positions.
- When the operation is reset, it will be in M94 mode.