2.11.4 VARIABLES (CONT'D)
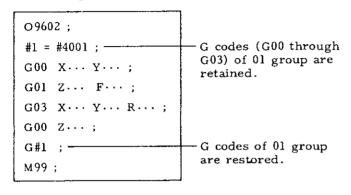
#4001 through #4120 connot be placed to the left-hand of the operation expression.

Sample Program

Main Program

```
G65 P9602 〈Argument Designation〉 ;
```

Macro Program

```
O9602 ;
#1 = #4001 ; ──────── ── G codes (G00 through
G00  X··· Y··· ;          G03) of 01 group are
G01  Z··· F··· ;          retained.
G03  X··· Y··· R··· ;
G00  Z··· ;
G#1  ; ──────────────── G codes of 01 group
M99 ;                     are restored.
```

J. Positional Information (#5001 Through #5014)

When system variables #5001 through #5104 are specified, various positional information can be obtained.
The unit of the information is millimeters or inches.

	Unit
Metric input	0.001 millimeter
Inch input	0.0001 inch
Deg input †	0.001 degree

In the user macro body, the "input unit x 10" feature is invalid.

System Variable	Positional Information	Read During Move
#5001	X-axis block end position (ABSIO)	Enabled
#5002	Y-axis block end position (ABSIO)	
#5003	Z-axis block end position (ABSIO)	
#5004	4th block end position (ABSIO)	

System Variable	Positional Information	Read During Move
#5021	X-axis current position (ABSMT)	Enabled(Note)
#5022	Y-axis current position (ABSMT)	
#5023	Z-axis current position (ABSMT)	
#5024	4th current position (ABSMT)	
#5041	X-axis current position (ABSOT)	Enabled(Note)
#5042	Y-axis current position (ABSOT)	
#5043	Z-axis current position (ABSOT)	
#5044	4th current position (ABSOT)	
#5061	X-axis skip signal position (ABSKP)	Enabled(Note)
#5062	Y-axis skip signal position (ABSKP)	
#5063	Z-axis skip signal position (ABSKP)	
#5064	4th skip signal position (ABSKP)	
#5083	Tool length correction amount	Enabled
#5101	X-axis servo position deflection amount	Enabled(Note)
#5102	Y-axis servo position deflection amount	
#5103	Z-axis serve position deflection amount	
#5104	4th servo position deflection amount	

Note: Reading of #5021 to #5024, #5041 to #5044, and #5101 to #5104, when commanded during movement, will be performed after completion of the movement.