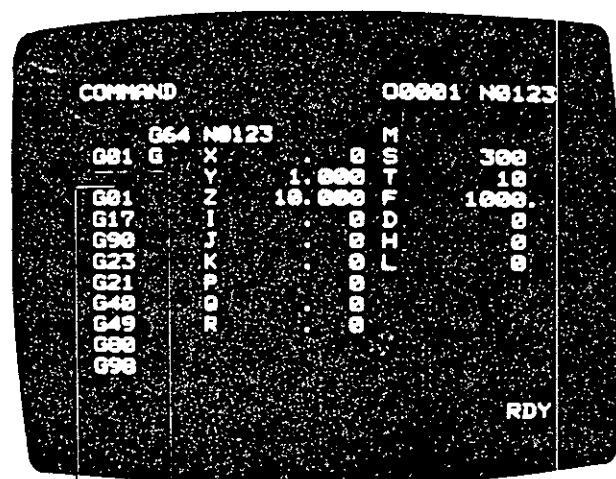## 4.3.2.1 COMMAND DATA DISPLAY

The display shows the block data of under execution or just before execution in which compensation calculations have been completed. The conditions of the data to be displayed is as follows.
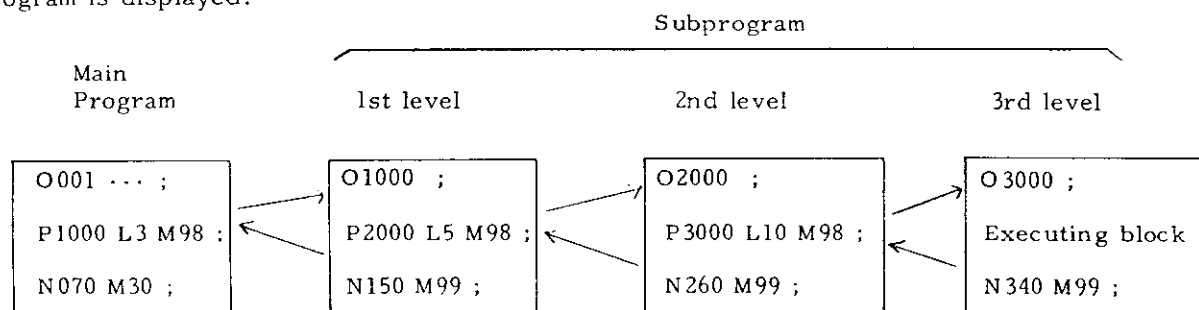
1. The data shows the contents of the active register during an automatic operation or a feed hold.

2. While the control is stopped at a block end, the contents of the buffer register are displayed. If the buffer register blank (BUF is not displayed), the contents of the just executed block are displayed.

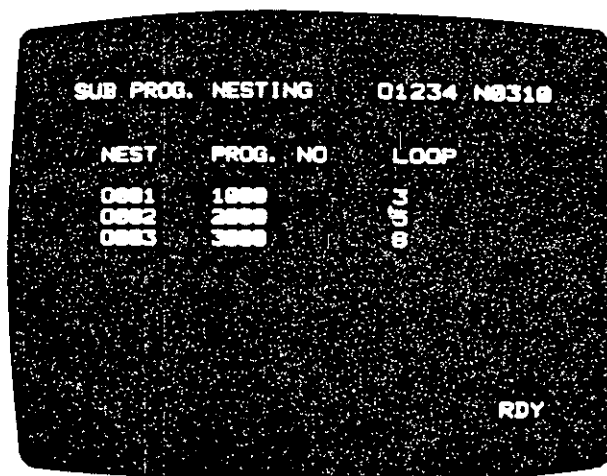3. In the MDI operation, the current block data are displayed after cycle is indicated.

Display of non-modal G code
Display of G code under execution

4.3.2.2 DISPLAY OF REMAINING MUNBER OF REPETITIONS OF SUBPROGRAM (SUB PROG. NESTING)

The remaining number of repetitions of a subprogram is displayed.

Subprogram

Main Program	1st level	2nd level	3rd level
O001 ··· ; P1000 L3 M98 ; N070 M30 ;	O1000 ; P2000 L5 M98 ; N150 M99 ;	O2000 ; P3000 L10 M98 ; N260 M99 ;	O3000 ; Executing block N340 M99 ;

The subprogram has executed the 3rd level twice and entered into the execution of 3rd time of the 3rd level.

Remaining number of repetitions
Sequence number of subprogram start
Subprogram level (up to 4)

Fig. 4.16 Example of SUB PROG. NESTING