## 2.9.21 TOOL RADIUS COMPENSATION C (G40, G41, G42)† (CONT'D)

EXAMPLE

```
G17 G01 G41 X··· Y··· D··· F··· ;
X··· Y··· ;
   .
   .
   .
X··· Y··· ;
G04 P1000 ;
X··· Y··· ;
   .
   .
   .
   .
   .
X··· Y··· ;
Z··· ;
Z··· ;
X··· Y··· ;
   .
   .
X··· Y··· ;
G40 X··· Y··· ;
```

Blocks without movement in compensation plane. (When these blocks are within two, machining is made smoothly.)

· If no movement instruction is programmed in three continuous blocks, offset in the block immediate before them is made on the normal line at the end point. Where movement in the compensation plane cannot be programmed in three or more continuous blocks for retracting in the third axis or the like, and offsetting on the normal line is not satisfactory, a dummy block can be inserted by I, J or K.

EXAMPLE

```
N001 G17 G01 G41 X··· Y··· D··· F··· ;
N002 X··· Y··· ;
        .
        .
        .
N010 X··· Y··· ;
N011 I··· J··· ;
N012 Z··· ;
        .
        .
        .
N019 Z··· ;
N020 X··· Y··· ;
        .
        .
        .
N029 X··· Y··· ;
N030 G40 X··· Y··· ;
```

XY plane

Dummy block

Z axis
3 blocks
or above

XY plane

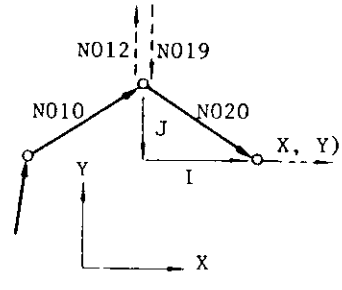


Fig. 2.45