Sample Program

Tapping Cycle (for Incremental Command)

Main Program

```
G91 ;
G65 P9601 L··· R··· Z··· ;
```

└── Argument designation of #26

└── Argument designation of #18

Macro Program

```
O9601 ;
#3003 = 1 ;      ── Single block switch ──
                    invalidated
G00 Z#18 ;
#3004 = 7 ──       ┌ Feed hold invalidated
                   │ Feedrate override invalidated
G01 Z#26 ;         └ Exact stop invalidated
M05 ;
M04 ;
#3004 = 0 ;──
G00 Z-#18 ;
M05 ;
M03 ;
#3003 = 0 ;──
M99 ;
```
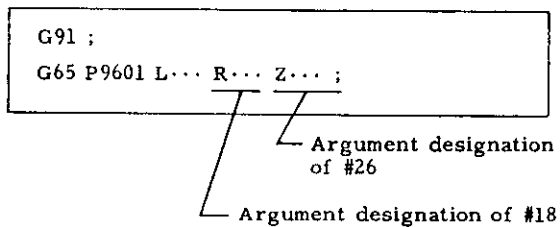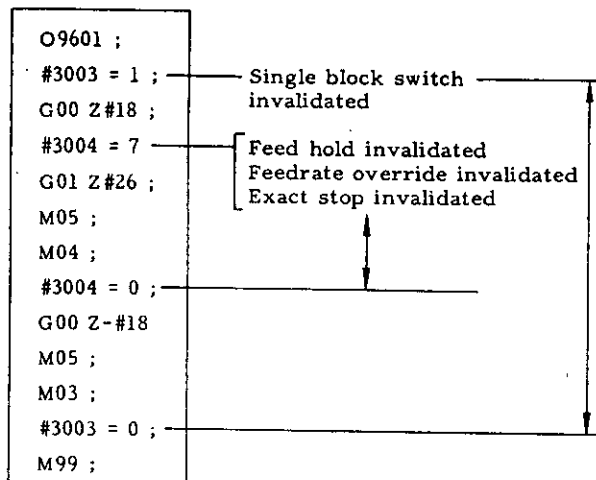
H. RS232C Data Output (#3100)

When system variable #3100 is specified, messages
and NC internal data can be outputted to external
equipment via RS232C data input/output inter-
face. If the external equipment is a printer,
the above information is printed.

a. Output of Messages

#3100 = (《Message》)

When this command is specified, the message
enclosed by control-in and control-out is outputted,
via RS232C interface.

Each output message is followed by CR/LF
(Carriage Return/Line Feed). Hence, when
#3100 = ( ) is specified, only CR/LF is outputted,
which is useful in tabulating the punched data.

b. Output of Data

#3100 = ⟨ variable ⟩

When this command is specified, the value of
the local variable, common variable, or system
variable at the right-hand is outputted vis RS232C
interface as the signed decimal 8-digit data.

c. The above output is performed when system
variable #3100 is executed in the macro program.
It is required, therefore, to previously attach
the external equipment such as a printer via
RS232C interface and preset the parameters that
use the interface.

Sample Program

#3100 = ( ); ··· Carriage return/line feed

#3100 = (TOOL OFFSET 01 AND 02):

#3100 = #2501 ; ··· = 10.000 mm

#3100 = #2502 ; ··· = -35.524 mm

#3100 = ( );

Printout Data

```
TOOL OFFSET 01 AND 02
⊔⊔   10.000 ⊔⊔ ~   35.524
```

└Two spaces precede signed decimal.
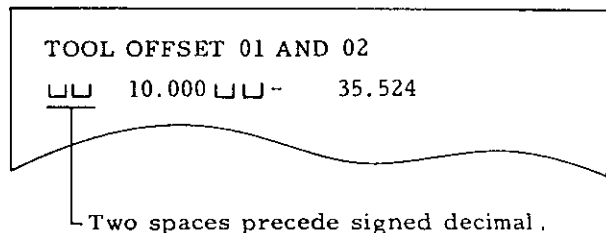
I. Modal Information (#4001 Through #4120)

When one of system variables #4001 through
#4120 is specified, the modal commands that are
specified up to the immediately preceding block
can be known. These modal commands are some-
times called the current values of modal informa-
tion commands.

System Variable	Modal Information
#4001	G code (group 01)
⟩	⟩
#4021	G code (group 21)
#4102	B code
#4107	D code
#4109	F code
#4111	H code
#4113	M code
#4114	Sequence number
#4115	Program number
#4119	S code
#4120	T code