2.9.11 INCH/METRIC DESIGNATION BY G CODE (G20, G21)[+] (CONT'D)

· Take the following procedure after the command of G20/G21 selection.

A. Program absolute zero point for all axes before move command.

B. In principle, make the display reset operation when current position display (external) is used.

· The tool offset values are processed differently in the G20 mode and the G21 mode. G20/G21 must be commanded after modifying the tool offset values.

Stored off-set values	Processing in G20 (Inch)	Processing in G21 (Metric)
15000 ──►	1.5000	15.000 mm

2.9.12 STORED STROKE LIMIT (G22, G23)[+]

This function is for checking the current tool position during manual or automatic operation for entry into the prohibited area specified by parameters or by G22. If the tool enters a prohibited area, machine operation is stopped and an error sign is displayed.

· 1st prohibited area

The area outside the area specified by a parameter is a prohibited area. Generally, this can be used as a substitute of overtravel checking function. Upper limit point A and lower limit point B are specified by parameters.
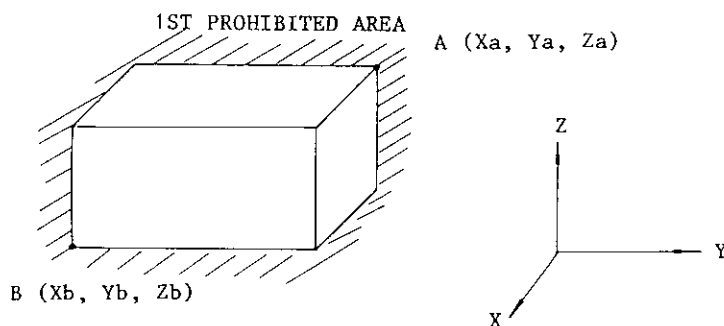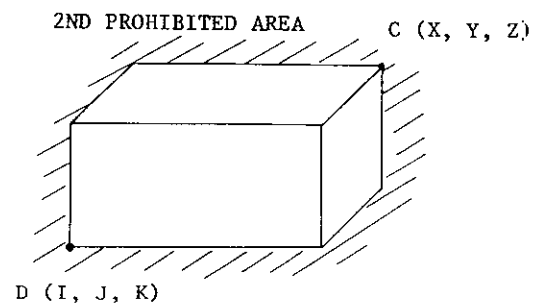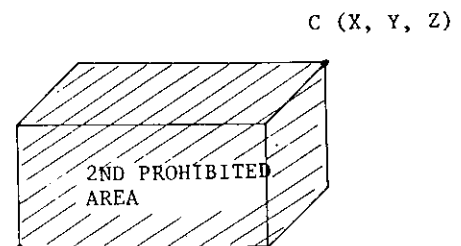

Fig. 2.26

· 2nd prohibited area

The boundary of the 2nd prohibited area is specified by a parameter setting or by G22. The inside or the outside of the boundary can selectively be made a prohibited area by means of parameter setting.

G22 X··· Y··· Z··· I··· J··· K··· ;

$$\underbrace{\qquad\qquad}_{\substack{\text{C point}\\ \text{Upper limit}}} \underbrace{\qquad\qquad}_{\substack{\text{D point}\\ \text{Lower limit}}}$$

With this command, the checking of the 2nd prohibited area is started, and with G23 ;, the check function is cleared.

Where 2nd prohibited area is outside.

Where 2nd prohibited area is inside.

Fig. 2.27