

Mnemonic	ABSIO	ABSMT	ABSOT	ABSKP
Meaning	End position of block immediately before.	Command current position (same as POS.MACHINE display).	Command current position (same as POS.UNIVERSAL display).	Position at which skip signal did not go on in G31 block.
Coordinate system	Work coordinate system	Machine coordinate system	Work coordinate system	Work coordinate system
Tool position, Tool length, Tool radius compensation Amount	Not included		Included	Included

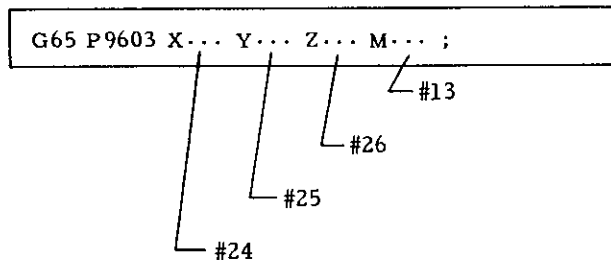
Notes:

1. When the skip signal is not turned on in G31 block, the skip signal position is at the end of G31 block.
2. The "input unit x 10" feature is valid up to the macro call block (the argument designation part by G65 or G66) but is invalid in the user macro body.
3. System variables #5001 through #5104 may not be placed to the left-hand of operational expression.

Sample Program

The tool is positioned to the specified location (X, Y, Z) on machine coordinate system, performs the specified M feature, and returns to the start point.

Main Program



Macro Program

```

O9603 ;
#1 = #5001 ;
#2 = #5002 ;
#3 = #5003 ;
G91 ;
G00 X [#24-#5021] Y [#25-#5022];
G00 Z [#26-#5023];
M#13 ;
G00 Z#3 ;
G00 X#1 Y#2 ;
M99 ;

```

List of Variables

Variable No.	Meaning
#1 to #33	Local variables.
#100 to #149	Common variables (reset to "blank" at power-off).
#500 to #509	Common variables (retained at power-off).
#1000 to #1015	Interface input signals (each signal for each bit).
#1032	Interface input signal ($\sum_{i=0}^{15} \# [1000 + i * 2i]$).
#1100 to #1115	Interface output signals (each signal for each bit).
#1132	Interface output signal ($\sum_{i=0}^{15} \# [1100 + i * 2i]$).
#2001 to #2099	Tool offset amount.
#2500 to #2806	Work coordinate system shift amount, external work coordinate system correction amount.
#3000	Alarm message display.
#3001	Clock 1 (in units of 1 ms).
#3002	Clock 2 (in units of 1 s).
#3003	Single block stop, auxiliary function complete wait control.
#3004	Feed-hold, feedrate-override, and exact-stop control.
#3100	RS232C data output (print out feature).
#4001 to #4120	Current value of modal information command.