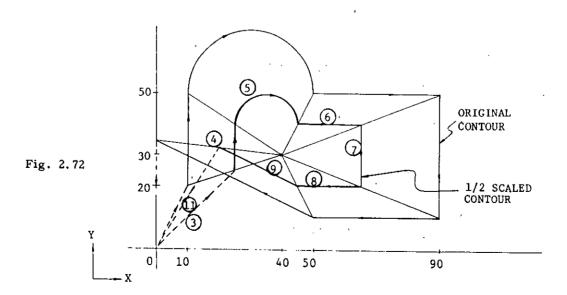
- Block commands G51 I... J... K... P...;
 and G50; should be programmed independently.
 If X, Y and Z commands coincide in the same block, an alarm will occur.
- When the scale ratio of one or more is programmed, the resultant command value should not exceed the maximum.
- Scale ratio 0 cannot be commanded. If commanded, an alarm will occur.
- · Scaling is not effective on compensation value.
- Canned cycles cannot be executed with scaling commanded on Z-axis. If scaling is commanded on Z-axis during canned cycle execution, an alarm will occur.

- When operation is reset (reset pushbutton, M02, M30 command), scaling is turned off.
- Display of command and position will show the values of command and position after scaling is finished.
- The following Gcodes cannot be commanded during scaling. If commanded, an alarm will occur.
 - G28, G29, G30, G31, G36, G37, G38, G53, G92
- Scaling (G51) command cannot be given during tool radius compensation C.
- · Alarm codes for scaling are listed below.

EXAMPLE

Reduction by half in respect with the point (40, 30) specified as the center.

- (1) N100 G92 X0 Y0 Z0;
- (2) N101 G51 I40. J30. P 0.5 · · · Center of 1/2 scaled contour (40, 30)
- N102 G90 G00 X10. Y20. ;
- (4) N103 G01 Y50, F1000;
- (5) N104 G02 X50. 120. ;
- (6) N105 G01 X90.;
- \sim
- (7) N106 Y10.;
- (8) N107 X50.;
- (9) N108 X0 Y35.;
- (10) N109 G50 ;
- · · · · · Scaling cancel
- (11) N110 G00 X0 Y0 :



Scaling range