2.9.3 LINEAR INTERPOLATION (G01) (CONT'D)

Table 2.22

F-function			In minimum F command unit	
			Feedrate in basic three axes	Feedrate of rotary axes
Metric output	Metric input	F40	1 mm/min	1 deg/min
	Inch input	F31	0.1 in./min	2.54 deg/min
Inch output	Metric input	F50	1 mm/min	0.3937 deg/min
	Inch input	F31	0.1 in./min	1 deg/min

Note: Feedrate of linear 4th as the same as that of basic three axes.

2.9.4 CIRCULAR INTERPOLATION (G02, G03)

With the following commands, the tool is controlled along the specified circular pathes on the XY, ZX, or YZ plane, at a tangential speed specified by the F code.

XY plane G17 $\left\{\begin{matrix}G02\\G03\end{matrix}\right\}$ X··· Y··· $\left\{\begin{matrix}R\cdots\\I\cdots\ J\cdots\end{matrix}\right\}$ F··· ;

ZX plane G18 $\left\{\begin{matrix}G02\\G03\end{matrix}\right\}$ Z··· X··· $\left\{\begin{matrix}R\cdots\\K\cdots\ I\cdots\end{matrix}\right\}$ F··· ;

YZ plane G19 $\left\{\begin{matrix}G02\\G03\end{matrix}\right\}$ Y··· Z··· $\left\{\begin{matrix}R\cdots\\J\cdots\ K\cdots\end{matrix}\right\}$ F··· ;

The moving direction of the tool along the circle is as follows.

G02: Clockwise

G03: Counter-clockwise

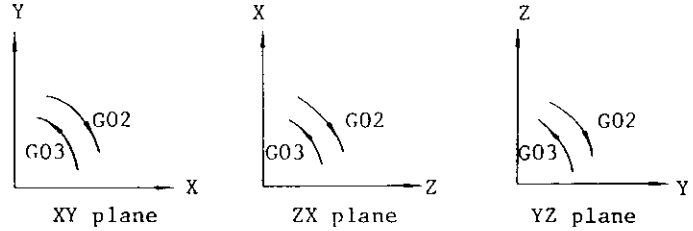

Fig. 2.13