

Table 6.5 Range of Program Commands

No.	Address		Metric Output		Inch Output	
			Metric Input	Inch Input	Metric Input	Inch Input
1	Program Number	O	1 to 9999	1 to 9999	1 to 9999	1 to 9999
2	Sequence Number	N	1 to 9999	1 to 9999	1 to 9999	1 to 9999
3	G-function	G	0 to 199	0 to 199	0 to 199	0 to 199
4	Coordinate address					
	Linear axis		± 8388.607 mm	± 330.2601 in.	± 21307.061 mm	± 838.8607 in.
	Rotary axis		± 8388.607 deg	± 8388.607 deg	± 8388.607 deg	± 8388.607 deg
	Max cumulative value		± 99999.999 mm	± 9999.99999 in.	± 99999.999 mm	± 9999.99999 in.
5	Feed per minute	F	1 to 8100 mm/min	0.1 to 313.0 in./min	1 to 20574.0 mm/min	0.1 to 810.0 in./min
6	Feed per minute 1/10		0.1 to 8100.0 mm/min	0.01 to 313.00 in./min	0.1 to 20574.0 mm/min	0.01 to 810.00 in./min
7	Feed per revolution		0.01 to 99.99 mm/rev	0.0001 to 3.936 in./rev	0.01 to 99.99 mm/rev	0.0001 to 3.936 in./rev
8	Feed per revolution 1/10		0.01 to 99.999 mm/rev	0.001 to 3.9366 in./rev	0.001 to 99.999 mm/rev	0.0001 to 3.9366 in./rev
9	S-function	S2	0 to 99	0 to 99	0 to 99	0 to 99
		S5	0 to 99999	0 to 99999	0 to 99999	0 to 99999
10	T-function	T2	0 to 99	0 to 99	0 to 99	0 to 99
		T4	0 to 9999	0 to 9999	0 to 9999	0 to 9999
11	M-function	M	0 to 199	0 to 199	0 to 199	0 to 199
12	Tool offset No.	H	0 to 99	0 to 99	0 to 99	0 to 99
		D	0 to 99	0 to 99	0 to 99	0 to 99
13	B-function	B	0 to 999	0 to 999	0 to 999	0 to 999
14	Dwell	P	0 to 99999.999 sec	0 to 99999.999 sec	0 to 99999.999 sec	0 to 99999.999 sec
15	Program No. designation	P	1 to 9999	1 to 9999	1 to 9999	1 to 9999
16	Sequence No. designation	P	1 to 9999	1 to 9999	1 to 9999	1 to 9999
17	No. of repetitions	L	99999999	99999999	99999999	99999999