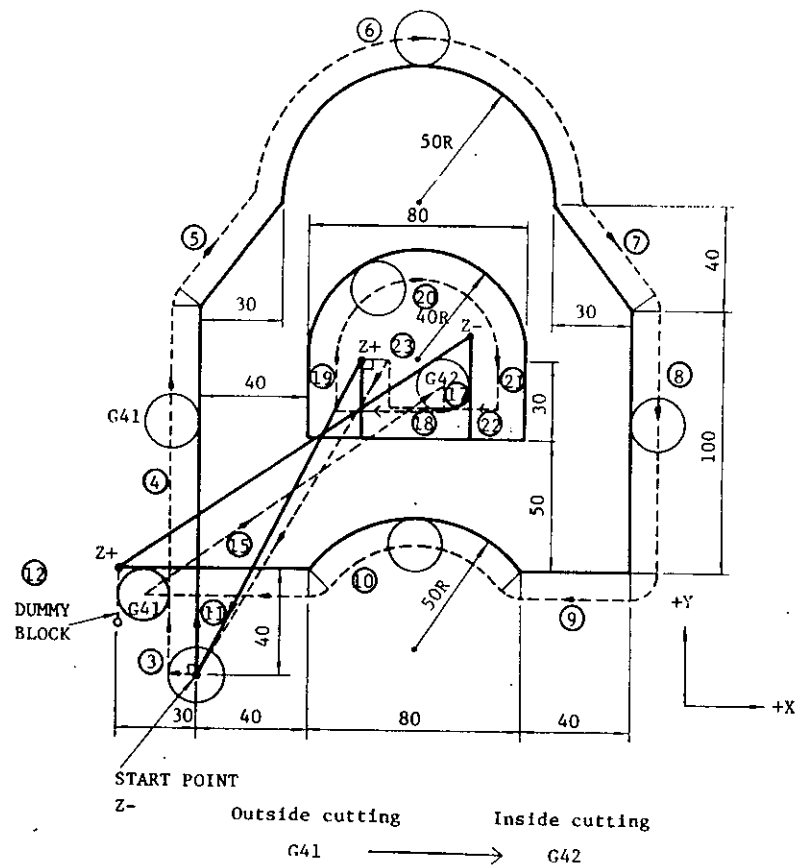


EXAMPLE A



- | | | | |
|-------------------------|--|------------------------------------|---|
| ① G91 G01 A-2500 F150 ; | Incremental; Z axis lowering | ⑫ J-2000 ; | Dummy block (for modifying offset position) |
| ② G17 (G01) F300 ; | XY plane designation, feed command | ⑬ Z2500 ; | Z axis elevation |
| ③ G41 D21 ; | Tool radius compensation start command with tool offset No. 21 | ⑭ M01 ; | Optional stop |
| ④ Y14000 ; | Offset to a point on the normal line of start point of this block. | ⑮ G42 (G01) X13000 Y9000 F2000 ; | Switching of direction of compensation (left + right) |
| ⑤ X3000 Y4000 ; | | ⑯ Z-2500 F150 ; | Z axis lowering |
| ⑥ G02 X10000 I5000 ; | | ⑰ Y-4000 F300 ; | |
| ⑦ G01 X3000 Y-4000 ; | Outer Cutting | ⑱ X-6000 ; | |
| ⑧ Y-10000 ; | | ⑲ Y3000 ; | |
| ⑨ X-4000 ; | | ⑳ G02 X8000 I4000 ; | Inner Cutting |
| ⑩ G03 X-8000 R5000 ; | R designation circular arc | ㉑ G01 Y-3000 ; | |
| ⑪ G01 X-7000 ; | | ㉒ X-6000 ; | |
| | | ㉓ Y3000 ; | Offset to a point on the normal line of end point of this block |
| | | ㉔ Z2500 ; | Z axis elevation |
| | | ㉕ G40 (G01) X-6000 Y-12000 F2000 ; | Compensation cancel command |

The same effect is obtained even when the commands in parentheses are not made. They are entered for ease of understanding.

Fig. 2.59