EXAMPLE
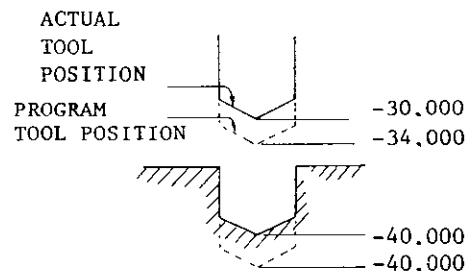
H10 ··· Offset value: -3.0

H11 ··· Offset value: 4.0

CRT display including offset value
(Z direction only)

N101 G92 Z0 ;   0.000

N102 G90 G00 X1.0 Y2.0 ;   0.000

N103 G43 Z-20. H10 ;   -23.000

N104 G01 Z-30. F1000 ;   -33.000

N105 G00 Z0 H00 ;   0.000

ACTUAL
TOOL
POSITION

PROGRAMMED   ── -20.000
TOOL POSITION   ── -23.000

                            ── -30.000
                            ── -33.000
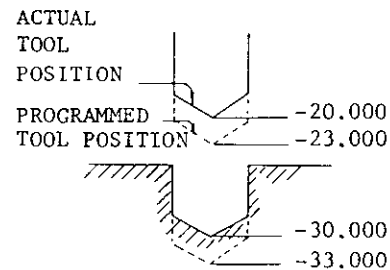
N201 G00 X-2.0 Y-2.0 ;

N202 G44 Z-30. H11 ;   -34.000

N203 G01 Z-40. F1000 ;   -44.000

N204 G00 Z0 H00 ;   0.000

ACTUAL
TOOL
POSITION

PROGRAM   ── -30.000
TOOL POSITION   ── -34.000

                            ── -40.000
                            ── -40.000

NOTES:

· When the tool offset value is changed by the MDI function while programs in the offset mode is in execution, the change is effective from the block containing D code.

· The tool position offset function or the tool radius compensation function is effective on the tool which is already offset by the tool length compensation function.

· G43, G44 and G49 can be programmed in canned cycles. If they are programmed, this is regarded as an input error.

· When a G92 command involving the Z axis is given during the execution of a program in the tool length compensation mode, the tool length compensation is canceled. In principle, when G92 is to be programmed, the existing tool length compensation mode should first be canceled.

· During the automatic execution of a program in the tool length compensation mode, the number of the effective tool compensation memory (H code number) can be displayed. For this, refer to 4.3.2 DISPLAY OF COMMAND DATA.