#6120 ··· Sets G code which calls the macro of program number O9010.

#6121 ··· Sets G code which calls the macro of program number O9011.

$\big\}$

#6129 ··· Sets G code which calls the macro of program number O9019.

NOTE: Macro call by arbitrary G code permits only single nesting. Namely, the macro which was called by the macro call using arbitrary G code or the macro call with M code or T code does not permit another macro call by arbitrary G code.

(4) Macro Call by M Code

G··· X··· Y··· Mxx ;

This command may call macros. In this case, the macro is executed after the execution of the move command in the same block. MF and M codes are not transmitted. For Mxx, four sets of M codes of except for M00, M01, M02, M30, M90 through M99 may be set for the parameter.

#6130 ··· Sets M code which calls the macro of program number O9001.

#6131 ··· Sets M code which calls the macro of program number O9002.

#6132 ··· Sets M code·which calls the macro of program number O9003.

#6133 ··· Sets M code which calls the macro of program number O9004.

NOTE THAT THE MACRO CALL BY M CODE DOES NOT PERMIT ARGUMENT DESIGNATION.

When these M codes are specified in the macros called by the macro call using arbitrary G code or by the macro call using M code or T code, the macro call is not executed but is handled as a usual M code.

(5) Macro Call by T Code

All the T code commands provide a macro call command.

G··· X··· Y··· Txxxx ;

With this command, the macro of program number O9000 is executed after the move command in the same block is executed:

Transmission of·T code and TF signal is not performed. Whether a T code is to be used as a macro call command may be specified by the following parameter:

Parameter No.

#6134

0 ··· T code designation is handled as a T code.

1 ··· T code designation is handled as a macro call command to call the macro of program number O9000.

When a T code is specified as a macro call command, the value designated by T "xxxx" (up to decimal 4 digits) becomes the argument of common variable #149. NOTE THAT THE ARGUMENT DESIGNATION OTHER THAN THIS IS NOT PERMITTED. When a T code is designated in the macro called by the macro call by arbitrary G code or by the macro call by M code or T code, the macro call is not executed but is handled as a usual T code.
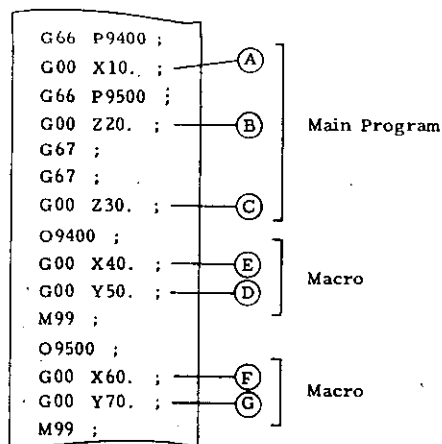
(6) Multiple Call

A. G65 Simple Call And G66 Modal Call

As a subprogram is called from another subprogram, a user macro may be called from another user macro. Quadruple nesting is permitted for simple call and modal call combined. Multiple call is disabled for the macro call by arbitrary G code, or M code or T code.

B. Multiple Call by G66 Modal Call

In modal call, each time a move command is executed, the designated macro is run. This is also valid for the move command in the macro called by multiple call. The macros are sequentially executed from the one designated latest.

Sample Program

The above sample program is executed in the following order:

Ⓐ → Ⓔ → Ⓓ → Ⓑ → Ⓕ → Ⓔ → Ⓓ → Ⓖ → Ⓔ → Ⓓ → Ⓒ