2.1.3 DECIMAL POINT PROGRAMMING

Numerals containing a decimal point may be used as the dimensional data of addresses related to coordinates (distance), time and speed.

Decimal points can be used in the following address words.

Coordinate words: X, Y, Z, I, J, K, A, B, C, U, V, W, Q, R

Time word: P

Feed rate word: F

EXAMPLE

	[mm]	[inch]
X15. ———	X15.000 mm	or X15.0000 inches
Y20.5 ———	Y20.500 mm	or Y20.5000 inches
(G94)F25.6 —	F25.0 mm/min (for F4.0)	or F25.6 inches/min (for F3.1)
G95F.2+ ——	F0.20 mm/rev (for F2.2)	or F0.200 inches/rev (for F1.3)
G04P1. ———	Dwell 1.000 sec	

Normally, when data without a decimal point is inputted, the control regards "1" as 0.001 mm (or 0.0001 inches, or 0.001 deg.), but with a parameter setting, the control may be made to regard "1" as 1 mm (or 1 inch or 1 deg.). Refer to parameter #6019$_{D6}$).

2.1.4 LABEL SKIP FUNCTION

In the cases named below, the label skip function becomes effective, and LSK is displayed on the CRT.

- When the power supply is turned on.
- When the RESET key is pushed.

While the label skip function is effective, all data on the punched tape up to the first EOB code are neglected. When LSK is displayed on the CRT in the MEM (memory) or EDIT (editing) mode, it indicates the presence of a pointer at the leading end of the part program.

2.1.5 BUFFER REGISTER

During normal operation, one block of data is read in advance and compensation computing is made for the follow-on operation.

In the tool radius compensation C+ mode, two blocks of data or up to 4 blocks of data are read in advance and compensation computing required for the next operation is executed. One block can contain up to 128 characters including EOB.

2.1.6 MULTI-ACTIVE REGISTERS+

For the portion of part programs sandwiched in between M93 and M92, up to 5 blocks of data are read in advance.

M code	Meaning
M92 ◥	Multi-active register off
M93	Multi-active register on

Note: When power is applied or the control is reset, the control is in the state of M code marked with ◥.

Inter-block stoppage can be eliminated when the program is so made that the automatic operation time of advance reading of 5 blocks is longer than processing time of advance reading of next 5 blocks of data.

NOTE:

Advance reading is not made for every 5 blocks but is always ready to be made up to 5 blocks in M93 mode.