

EXAMPLE (Reference program)

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N1 G92 X200 Y100 ;
N3 G54 G90 X100 Y200 ;
N4 G53 X300 Y100 ;
N5 X300 Y0 ;
N6 G52 ;
N7 X0 Y0 ;

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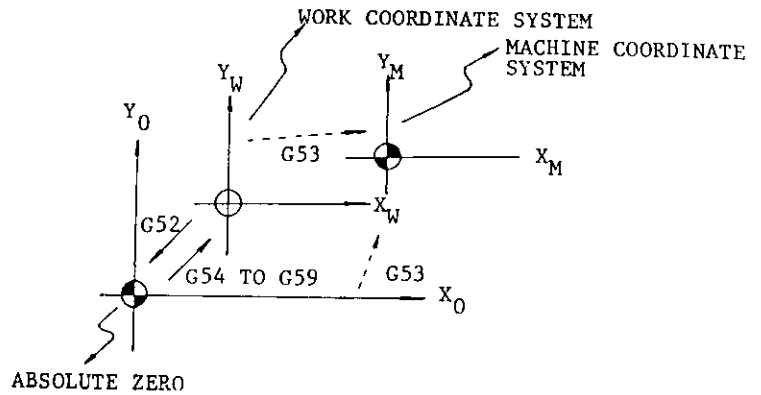


Fig. 2.74

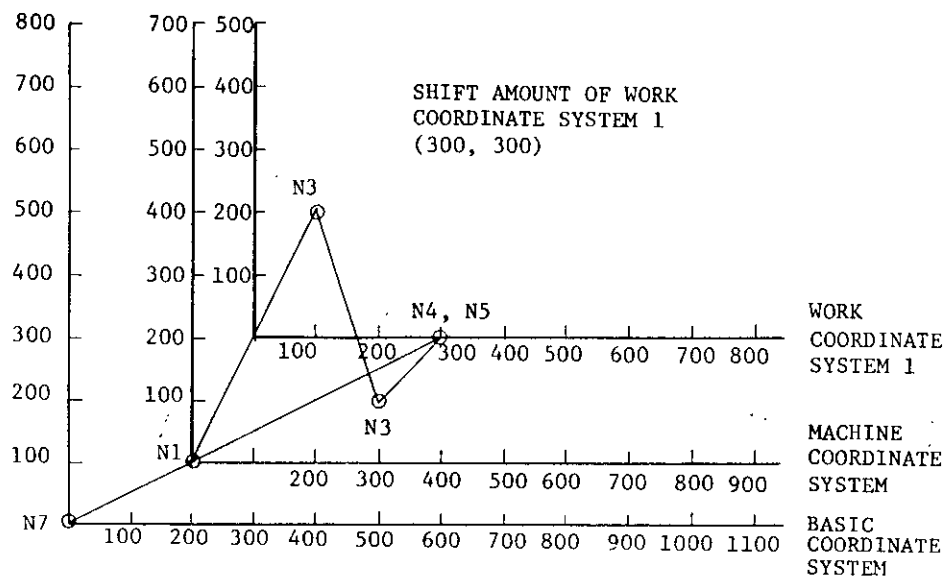


Fig. 2.75

NOTES:

- The shift amounts for work coordinate systems can be specified by programs with G10 commands, in addition to the MDI writing. For details, refer to 2.9.8 TOOL OFFSET VALUE DESIGNATION (G10).
- Work coordinate systems set up by G54 through G59 are canceled by the G52 command, and the basic coordinate system becomes effective again.
- When once a work coordinate system has been set up by any of the commands G54 through G59, the selected shift amounts can not be changed even when they are rewritten.

The rewritten shift amounts will become effective when a new work coordinate system command is executed.

- G53 commands should only be given under the following conditions. If these conditions are not satisfied, the commands are regarded as errors.
 - The mirror image function is not used.
 - No canned cycle is in use and no tool compensation C is in use.
 - If a 01 group G code is used, it is G00, G01 or G60 and nothing else.