

6.2.5 PLAYBACK FUNCTION (CONT'D)

PROG(PLAYBACK)		O0010N0000	
O0010;			
G91 G28 X0 Y0 Z0;			
G92 X9 Y0 Z0;			
G90 G00 X0.4 Y0.2 Z0.3;			
N0001 G00 X0.700;			
N0002 G01 Z0.600 F20;			
N0003 G00 Y1.000;			
N0004 G01 X0.700 Y1.000 Z0.600 F100;			
POS	X	.700	Y1.000
(UNIV)	Z	.600	
N0005 G01X0.5		RDY	

Fig. 6.32



BY DEPRESSING WR KEY,
POSITION X IS ADDED TO
THE KEYED-IN VALUE.

PROG(PLAYBACK)		O0010N0000	
O0010;			
G91 G28 X0 Y0 Z0;			
G92 X0 Y0 Z0;			
G90 G00 X0.4 Y0.2 Z0.3;			
N0001 G00 X0.700;			
N0002 G01 Z0.600 F20;			
N0003 G00 Y1.000;			
N0004 G01 X0.700 Y1.000 Z0.600 F100;			
POS	X	.700	Y1.000
(UNIV)	Z	.600	
N0005 G01 X1.200		RDY	

Fig. 6.33

- (1) Key-in N, 0, 0, 0, 5.
- (2) Key-in G, 0, 1.
- (3) Depress the WR key after keying-in X0.5.
- (4) Depress the WR key after keying-in Y-0.2
- (5) Depress the WR key after keying-in Z.
- (6) Key-in F, 1, 0, 0.
- (7) Depress the EOB key.
- (8) Depress the INSRT key.

Then, block of N0005 G01 X1.200 Y0.800 Z0.600
F0.600 F100; will be stored in the part program.