EXAMPLE A

(a) G41 (G42)
     .
     .
     .
     G01 X··· F··· ;
     G40 X··· Y··· ;
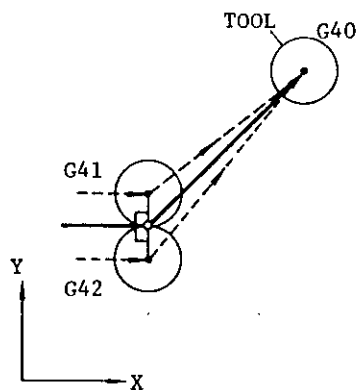
(b) G41 (G42)
     .
     .
     .
     G02 X··· Y··· I··· J··· ;
     G01 G40 X··· Y··· ;
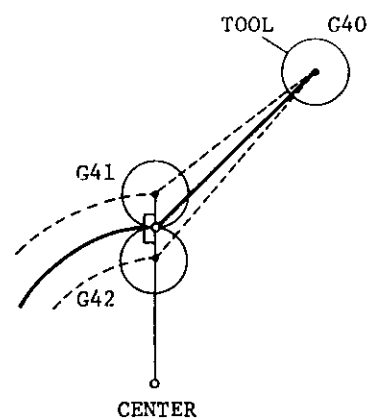
Fig. 2.50

EXAMPLE B

(c) G41 (G42)
     .
     .
     .
     G02 X··· Y··· I··· J··· ;
     G01 X··· Y··· ;
     G40 ;
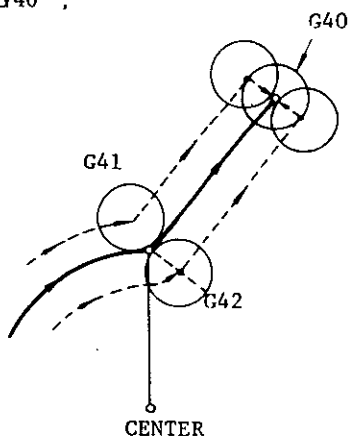
(d) G41 (G42)
     .
     .
     .
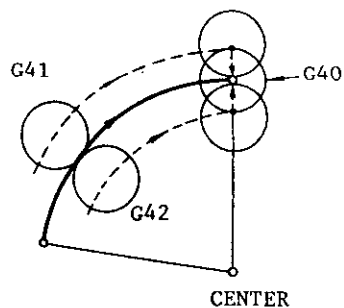   G02 X··· Y··· I··· J··· ;
     G01 G40 ;

Fig. 2.51

In all cases (a) through (d) described above, the tool reaches the programmed end point via the offset position on the normal line at the end point of the block immediately before G40.

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