

D. Shape requiring care

Do not program a wedge shape having an accute angle.

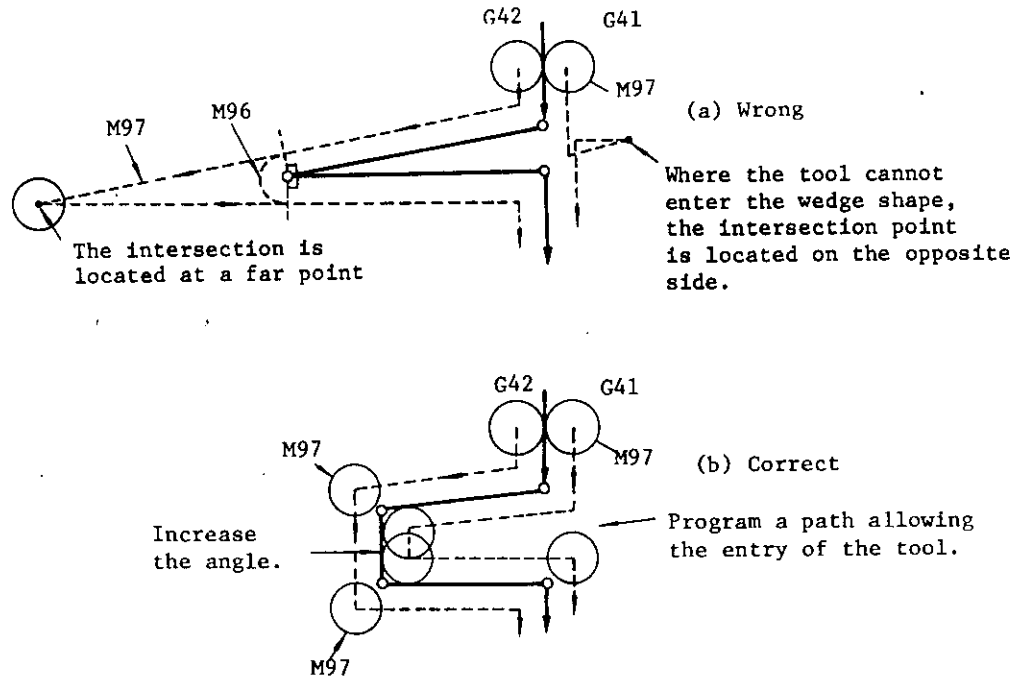


Fig. 2.44

5. Command involving no movement in compensation mode

The control normally reads in advance two blocks during tool radius compensation mode and computes the tool path. If either of these blocks give no coordinate instructions such as G04 (dwell), the control reads the block further ahead and makes computing.

The blocks with no coordinate instructions can be processed continuously up to two blocks. When coordinate instructions are missing in three or more blocks, tool radius compensation becomes impossible and accurate tool path cannot be obtained. Therefore, in a program where G41 or G42 is used, ensure that, after them, three or more blocks without movement command plane will not follow.