2.9.21 TOOL RADIUS COMPENSATION C (G40, G41, G42) † (CONT'D)

B. Outside corner (over 180°):
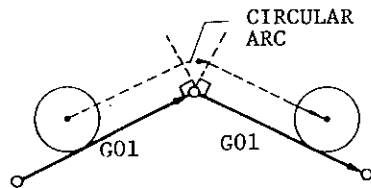Circular path type (in the case of M96)

Fig. 2.42

In this case, movement of circular path is included in the former block.

Code M97 can be used to machine the outside corner by the intersection computation, depending on the work. Refer to 2.8.6 CIRCULAR PATH MODE ON/OFF ON TOOL RADIUS COMPENSATION C (M97, M96) for details.

M96 ··· Tool radius compensation circular path ON

M97 ··· Tool radius compensation circular path OFF (execution of intersection computation)

Normally, M96 is used for this operation, however, when there is a possibility of an "overcut" in cutting special shapes with the M96, M97 should be used.

C. Movement in G00 mode

The instruction G00 positions tools independently along each axis toward the final offset position. Care should be taken on the cutter path.
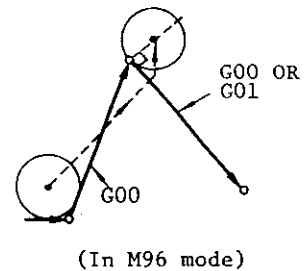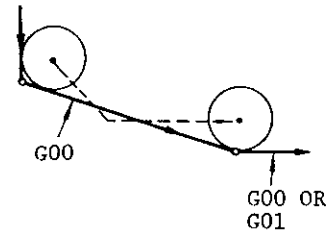

(In M96 mode)

Fig. 2.43