Table 2.1 Input Format

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| No. | Address | | Metric output | | Inch input | | B: Basic  O: Optional |
| Metric input | Inch input | Metric input | Inch input |
| 1 | Program No. | | O4 | | O4 | | B |
| 2 | Sequence No. | | N4 | | N4 | | B |
| 3 | G function | | G3 | | G3 | | B |
| 4 | Coordinate Word | Linear axis | a + 43 | a + 34 | a + 53 | a + 34 | B |
| Rotary axis | b + 43 | b + 43 | b + 43 | b + 43 | O |
| 5 | Feed/min | | F40 | F31 | F50 | F31 | B |
| 6 | Feed/min 1/10 | | F41 | F32 | F51 | F32 | B |
| 7 | Feed/rev | | F22 | F13 . | F22 | F13 | O |
| 8 | Feed/rev 1/10 | | F23 | FI4 | F23 | F14 | O |
| 9 | S-function |  | S2 | | S2 | | B |
|  | S5 | | S5 | | O |
| 10 | T-function |  | T2 | | T2 | | B |
|  | T4 | | T4 | | O |
| 11 | M-function | | M3 | | M3 | | B |
| 12 | Tool Offset No. | | H2 or D2 | | H2 or D2 | | B |
| 13 | B-function | | B3 | | B3 | | O |
| 14 | Dwell | | P53 | | P53 | | B |
| 15 | Program No. designation | | P4 | | P4 | | B |
| 16 | Sequence No. designation | | P4 | | P4 | | B |
| 17 | No. of repetitions | | L8 | | L8 | | B |

**-2-**