**2.1.2 ADDRESS AND FUNCTION CHARACTERS**

Address characters and their meanings are shown

in Table 2.2.

Table 2.2 Address Characters

|  |  |  |
| --- | --- | --- |
| Address Characters | Meanings | B: Basic  O: Optional |
| A | Additional rotary axis parallel to X -axis | O |
| B | Additional rotary axis parallel to Y-axis | O |
| C | Additional rotary axis parallel to Z-axis | O |
| D | Tool radius offset number | B, O |
| E | User macro character | O |
| F | Feedrate | B |
| G | Preparatory function | B, O |
| H | Tool length offset number | B |
| I | X-coordinate of arc center Radius for circle cutting | B, O |
| J | Y-coordinate of arc center  Cutting depth for circle cutting | B ,O |
| K | Z-coordinate arc center | B |
| L | Number of repetitions | B, O |
| M | Miscellaneous functions | B |
| N | Sequence number | B |
| 0 | Program number | B |
| P | Dwell time, Program No. and sequence No.  designation in subprogram | B, O |
| Q | Depth of cut, shift of canned cycle s | O |
| R | Point R for canned cycles  Radius designation of a circular arc | O, B |
| S | Spindle-speed function | B |
| T | Tool function | B |
| U | Additional linear axis parallel to X-axis | O |
| V | Additional linear axis parallel to Y-axis | O |
| W | Additional linear axis parallel to Z-axis | O |
| X | X-coordinate | B |
| Y | Y-coordinate | B |
| Z | Z-coordinate | B |

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