

M350 instruction description

G31

-Scan command code

Instruction format:

G31 X Y Z A B C P L K Q F

-X Y Z A B C: Axis movement target position;

-P: Input port ;

-L: Effective level;

-K: scanning method;

-Q: Stop mode after the signal is valid;

-F: Moving speed;

Related macro address:

The mechanical coordinates of each axis when the scan signal is valid

#1925: X MACH Pos;

#1926: Y MACH Pos;

#1927: Z MACH Pos;

#1928: 4th MACH Pos;

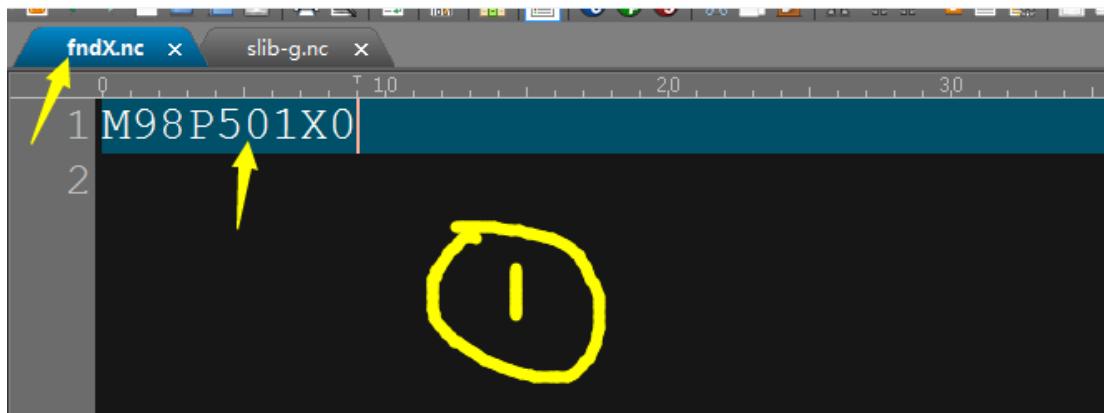
#1929: 5th MACH Pos;

Example:

X axis go to home;

file path:/install/fndX.nc and/install/slib-g.nc

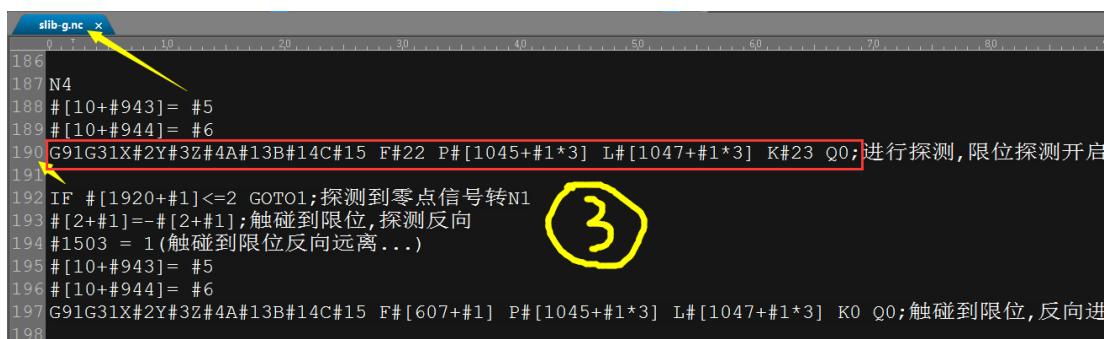
Calling process:



```
fndX.nc x      slib-g.nc x
0 1,0 2,0 3,0
1 M98P501X0
2
```



```
slib-g.nc x
0 10 20 30 40 50 60
156
157 0501(单轴寻零)
158 IF #[1046+#1*3]==0 GOTO30;如果零点功能未使能,结束
159
160 #1618=0 //寻零开始标志
161 (初始化各轴探测距离)
162 #2=0
163 #3=0
164 #4=0
165 #5=0
166 #6=0
167 #13=0
```



```
slib-g.nc x
0 10 20 30 40 50 60 70 80 90
186
187 N4
188 #[10+#943]= #5
189 #[10+#944]= #6
190 G91G31X#2Y#3Z#4A#13B#14C#15 F#22 P#[1045+#1*3] L#[1047+#1*3] K#23 Q0;进行探测,限位探测开启
191
192 IF #[1920+#1]<=2 GOTO1;探测到零点信号转N1
193 #[2+#1]=-#[2+#1];触碰到限位,探测反向
194 #1503 = 1(触碰到限位反向远离...)
195 #[10+#943]= #5
196 #[10+#944]= #6
197 G91G31X#2Y#3Z#4A#13B#14C#15 F#[607+#1] P#[1045+#1*3] L#[1047+#1*3] K0 Q0;触碰到限位,反向进
198
```

Other system internal use cases are not listed one by one!