

Explanation of Custom G-Code

Users can customize the content of G-codes **G100** to **G199**.

This can be done by adding corresponding subroutines in the beginning of the NC file in the slib (Subroutine Library) file.

For instance, you can add them in either slib-g.nc or slibuser.nc.

The correspondence of G-code subroutines is as follows:

| G-code | Subroutine Number |
|--------|-------------------|
| G100 | O9100 |
| G101 | O9101 |
| | |
| G199 | O9199 |

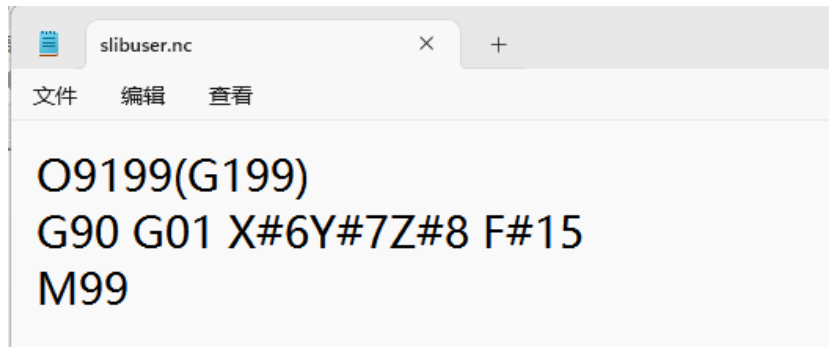
The local variable table is as follows:

| Macro Address | Programming Word | Taking G100 as an example |
|---------------|------------------|--|
| #0 | X | G90 G100 X100: #0=100; G91 G100 X100: #0=100+Current Workpiece Coordinate Value; G100 : #0= Current Workpiece Coordinate Value |
| #1 | Y | G90 G100 Y100: #1=100; G91 G100 Y100: #1=100+Current Workpiece Coordinate Value; G100 : #1= Current Workpiece Coordinate Value; |
| #2 | Z | Same as #0 and #1 |
| #3 | A | Same as #0 and #1 |
| #4 | B | Same as #0 and #1 |
| #5 | C | Same as #0 and #1 |
| #6 | I | G100 I100: #6=100 G100 : #6=The value of I from the previous line |
| #7 | J | G100 J100: #7=100 G100 : #7=The value of J from the previous line |
| #8 | K | Same as #6 and #7 |
| #9 | R | Same as #6 and #7 |
| #10 | L | Same as #6 and #7 |
| #11 | H | Same as #6 and #7 |
| #12 | P | Same as #6 and #7 |
| #13 | Q | Same as #6 and #7 |
| #14 | D | Same as #6 and #7 |
| #15 | F | Same as #6 and #7 |
| #16 | S | Same as #6 and #7 |
| #17 | T | Same as #6 and #7 |

For example:

G199 I100 J200 K300 F500

Add subroutines and write specific actions in slibuser.nc.



Place slibuser.nc in the install or psys folder for upgrading.

The result of running G199 I100 J200 K300 F500 would be the machine moving at a speed of 500 mm/min, simultaneously positioning XYZ to coordinates 100, 200, and 300 respectively.

Note:

It is not allowed to add the same subroutine in multiple files at the beginning of SLIB.