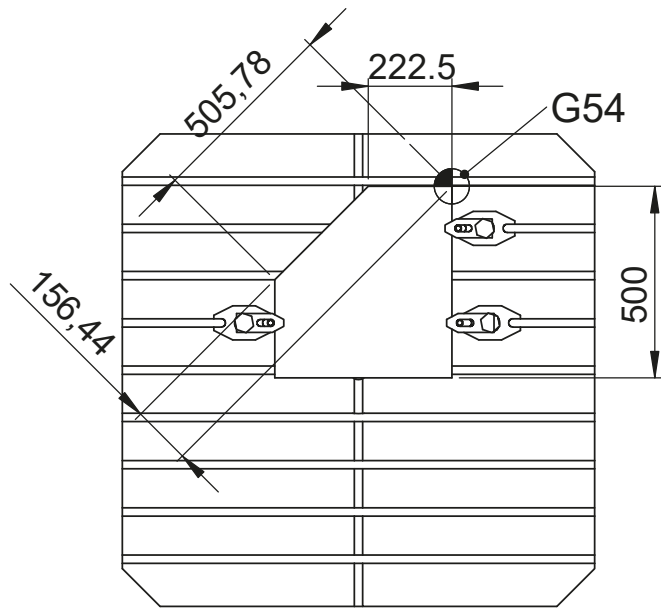


EXAMPLE 1: Creation of the G55 offset, obtained from the G54 offset but after the table rotation of B45°

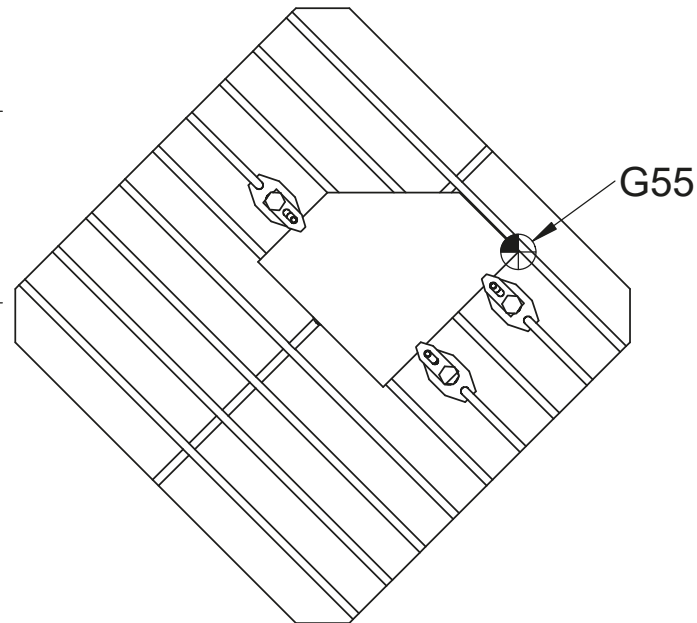
EXAMPLE 2: Creation of G56 offset obtained from a G54 offset but after a table rotation of B45° WITH TRANSLATION, with dimensions defined before the rotation

EXAMPLE 3: Creation of the G54.1P1 offset, obtained from a G54 offset but after a table rotation of B45° WITH TRANSLATION, with dimensions defined AFTER the rotation



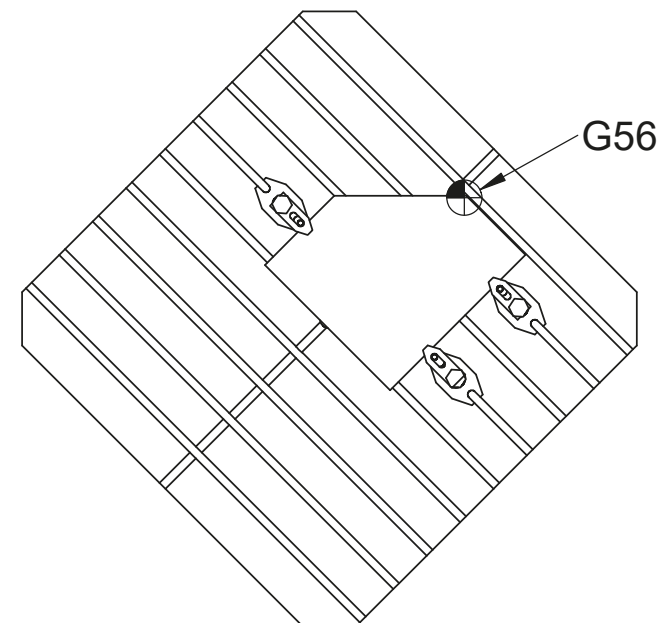
B0 TABLE

G54  
G65P8001B45M2



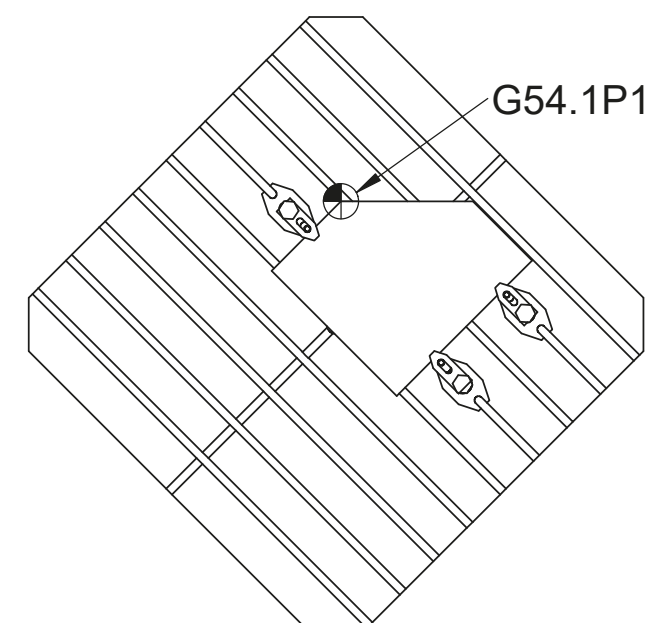
B45 TABLE

G54  
G65P8001B45M3X225.5S1



B45 TABLE

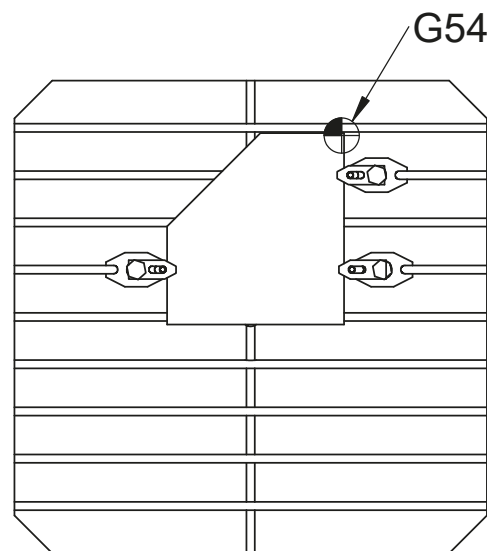
G54  
G65P8001B45M3X505.78Z-156.44S0



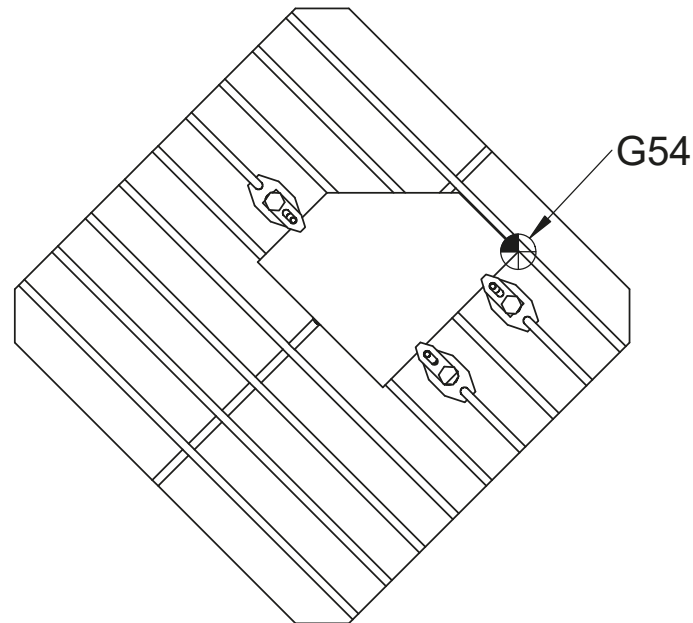
B45 TABLE

EXAMPLE 4: Moving the active offset to compensate for the 45° table rotation

G54  
G65P8001B45



B0 TABLE



B45 TABLE

Parameter description:

G65 P8001 B\_\_ M\_\_ X\_\_ Y\_\_ Z\_\_ S\_\_

where:

B=table rotation degrees

M = rotated origin to be recalculated

B1=G54

B2=G55

...

B101 = G54.1 P1


B102 = G54.1 P2

X\_Y\_Z\_ = origin translation coordinates

S = sequence definition parameter

S0 = rotate and translate

S1 = translate and rotate

		www.cncofcourse.com		Scale:	Material:
				Non-quoted chamfers 0.5 mm General tolerances: UNI ISO 2768-m	
				Dis. N°:	FA01
				Detail:	
MOD	DESCRIPTION	DATE	NAME		