
INTERNATIONAL STANDARD



4343

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Numerical control of machines — NC processor output — Minor elements of 2000-type records (post-processor commands)

*Commande numérique des machines — Informations de sortie des processeurs CN — Éléments mineurs
des enregistrements de type 2000 (instruction post-processeur)*

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Descriptors : data processing, numerical control, language processors, vocabulary.

FOREWORD

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Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 4343 was developed by Technical Committee ISO/TC 97, *Computers and information processing*, and was circulated to the member bodies in April 1976.

It has been approved by the member bodies of the following countries :

Australia	Japan	South Africa, Rep. of
Belgium	Korea, Rep. of	Turkey
Brazil	Mexico	United Kingdom
Czechoslovakia	Netherlands	U.S.A.
France	New Zealand	U.S.S.R.
Germany	Poland	
Hungary	Romania	

No member body expressed disapproval of the document.

Numerical control of machines — NC processor output — Minor elements of 2000-type records (post-processor commands)

0 INTRODUCTION

0.1 The output of a general purpose numerical control processor is information used as input to a post-processor. This information is called CLDATA, which is derived from the term "centre line data".

0.2 The logical structure of CLDATA records and the listing and definition of major words are given in ISO 3592.

0.3 This International Standard defines, in the context of major word, the minor elements that can be associated in a post-processor statement with each of these major words (for an example of major and minor portions of a processor input statement, see the footnote to clause 1).

0.4 Although this International Standard defines the CLDATA processor output of post-processor statements, there is usually a one-to-one correspondence between the minor elements of a post-processor statement in the input language and the words of the corresponding 2000-type record in CLDATA. In consequence, the symbolic input language has been chosen to describe the representation of the CLDATA records in this International Standard.

0.5 Therefore, unless otherwise stated, the syntax and semantic definitions contained in this International Standard apply to both the input language statements and the corresponding CLDATA output.

0.6 This International Standard is intended to define, in general terms, the elements of the set of post-processor statements that are commonly used. The writer of a post-processor is expected to use this International Standard for the selection of post-processor statements. The user of the input language (i.e. the part programmer) is expected to use the documentation of the appropriate post-processor that he intends to execute.

0.7 The existing numerical control processors allow minor elements of post-processor statements in any order without restriction. Post-processors usually check the validity of particular element strings. The syntax definitions given in this International Standard are examples of common usage.

0.8 The syntax, semantics and minor elements given under the heading of each major word are the result of several years' study of documents representing existing practice.

0.9 The integer code numbers (IC)¹⁾ given in this International Standard are the code numbers that are used to represent the input language vocabulary key words in CLDATA.

1 SCOPE

1.1 This International Standard defines the elements of a set of post-processor statements that are commonly used in numerical control software.

It utilizes

a) the syntax and semantics of the major and minor elements²⁾ of the input language of this set,

and specifies

b) the syntax and semantics of the corresponding CLDATA processor output of type 2000, W4 to W245,

c) the rules governing the interpretation of the syntax of CLDATA.

1.2 This International Standard does not prescribe

a) the mechanism by which the statements are processed and the CLDATA developed;

b) the medium on which the input language statements or the CLDATA are recorded;

c) the order of statements within a part program.

1.3 The rules used for the syntax definitions are shown in annex A.

1) A register of keywords and their associated integer codes is maintained by the Secretariat of TC 97/SC 9 (as at June 1977, AFNOR, Paris). The TC 97/SC 9 Secretariat should be consulted for the possible assignment of codes for vocabulary not included in this International Standard.

2) The following example indicates the major and minor portions of a processor input statement and of the corresponding CLDATA record :

SPINDL/RPM, 5000, RANGE, 2

The major word is SPINDL

The minor element list is "RPM, 5000, RANGE, 2"

The minor elements are "RPM, 5000" and "RANGE, 2"

2 FIELD OF APPLICATION

2.1 Each processor using one of the ISO numerical control programming languages shall be capable of producing CLDATA minor elements as defined in this International Standard, possibly by means of some interface routine.

2.2 Each post-processor shall be capable of using as its input at least a sub-set of the minor elements specified in this International Standard.

3 REFERENCES

ISO 841, *Numerical control of machines – Axis and motion nomenclature.*

ISO 1056, *Numerical control of machines – Punched tape block formats – Coding of preparatory functions G and miscellaneous functions M.*

ISO 3592, *Numerical control processor output – Logical structure.*

4 LOGICAL STRUCTURE OF 2000-TYPE RECORDS

4.1 2000-type records carry post-processor instructions and are formed of words as follows :

Word W1 (integer) = record sequence number

Word W2 (integer) = 2000

Word W3 (integer) = n (integer code number representing major word)

Words W4 onwards may contain a minor element list as defined in clause 5 of this International Standard.

4.2 A minor element can consist of one or more items.

4.3 Each item is contained in one logical word and can be one of the following :

- a) an integer representing a key vocabulary minor word;
- b) a real number;
- c) a character item.

4.4 If the logical word represents a character item, the six left-hand positions of the physical representations shall be used, any remaining positions being filled with the space character.

If character data in the equivalent input part program statement consist of less than six characters, on numerical control processor output the data shall be right-justified within the first six characters, with leading space characters inserted as necessary.

5 MINOR ELEMENT LISTS

5.1 In this International Standard, a separate logical page is used for each major word.

5.2 On each of the following logical pages, major words and key vocabulary minor words are shown in capital letters. Its integer code number is shown alongside each word.

5.3 Scalar values, represented by real numbers in the logical words of CLDATA, are shown by the symbols a , b , c , d , etc.

5.4 Character items are represented by "character item" (see 4.4).

5.5 Where an alternative, but non-standard, order of the items within a minor element is known to be frequently used, the non-standard order is shown in parentheses in the minor element definitions. These orders of the items shall be understood to be non-preferred.

5.6 The key vocabulary minor words, their integer code numbers and brief definitions are listed in alphabetical order and in numerical order in annex B.

5.7 Cross-references between the minor words and the major words that use them are given in annex C.

5.8 The major words utilized in this International Standard are listed in annex D for reference purposes. The standard definition of major words is embodied in ISO 3592.

A I R

[Integer code $n = 1011$]

Air. Controls the supply of air.

SyntaxAIR / $\begin{matrix} \text{ON} \\ \text{OFF} \end{matrix}$ [a]**Minor element definitions and integer code numbers**

ON	IC = 71	Specifies air is on.
OFF	IC = 72	Specifies air is off.
a		Specifies the time in seconds during which air is on.

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A U X F U N

[Integer code $n = 1022$]

Auxiliary function. Provides facilities to insert miscellaneous function (M) code numbers on control tape.

Syntax

AUXFUN / a_0^n [, a]

Minor element definitions

a

Specifies miscellaneous function (M) code number to be output in a single block.

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C H U C K

[Integer code $n = 1073$]

Chuck. Specifies the chuck to be used.

Syntax

CHUCK/ a, b, c, d [e, f]

CHUCK/ a, g

Minor element definitions (see figures 1 and 2)

<i>a</i>	Specifies the identity number of the chuck.
<i>b</i>	Specifies the position of the clamping plane of the chuck in terms of the machine-tool co-ordinate system.
<i>c</i>	Specifies the maximum outer diameter of the chuck.
<i>d</i>	Specifies the position of the outer plane surface of the chuck in terms of the chuck co-ordinate system.
<i>e</i>	Specifies either the diameter of the hole of an external clamping chuck (if <i>f</i> has a negative value) or the diameter of a mounting arbor (if <i>f</i> has a positive value).
<i>f</i>	Specifies either the depth of the hole of an external clamping chuck (if negative), or the length of a mounting arbor (if positive), in terms of the chuck co-ordinate system.
<i>g</i>	Specifies the position on the x-axis of the part co-ordinate origin in terms of the machine-tool co-ordinate system.

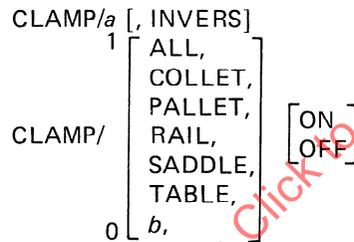
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C L A M P

[Integer code $n = 1074$]

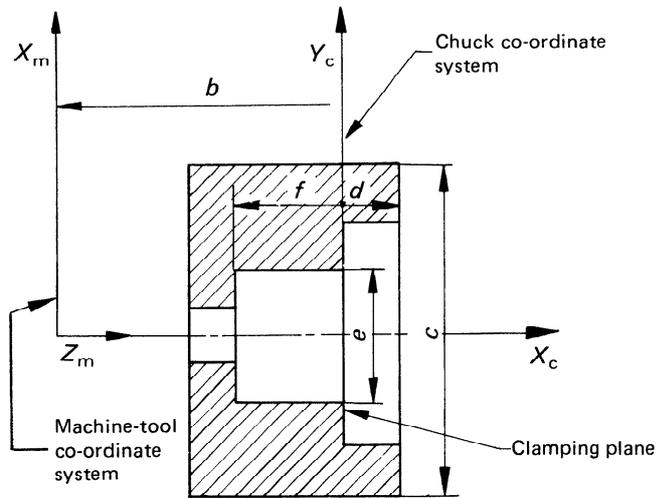
Clamp. Controls a holding operation.

Syntax



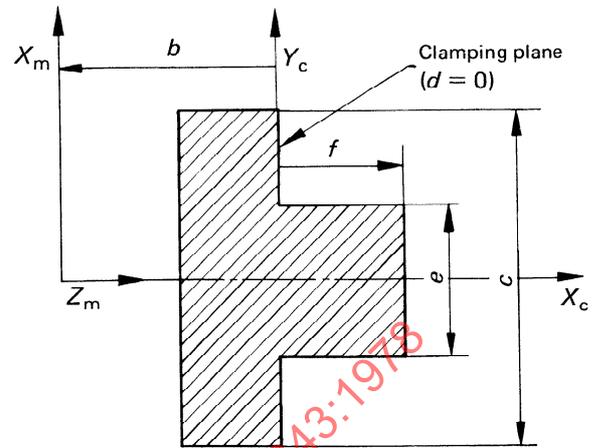
Minor element definitions and integer code numbers (See figures 3 and 4)

<i>a</i>		Specifies the position of the clamping plane in terms of the part co-ordinate system.
INVERS	IC = 6	Specifies rotation of the part by 180° in the XY plane before clamping.
ALL	IC = 51	Specifies all holding devices.
COLLET	IC = 139	Specifies a collet device.
PALLET	IC = 239	Specifies a pallet device.
RAIL	IC = 93	Specifies a rail device.
SADDLE	IC = 150	Specifies a saddle device.
TABLE	IC = 177	Specifies a table device.
<i>b</i>		Specifies a device by number.
ON	IC = 71	Initiates the operation.
OFF	IC = 72	Terminates the operation.



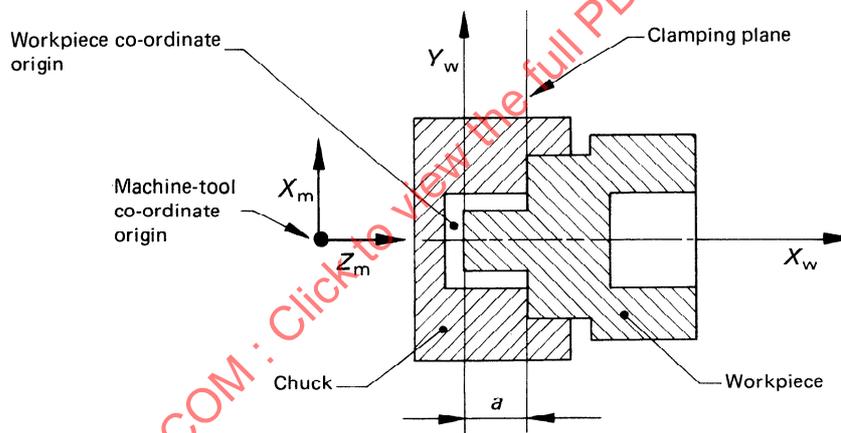
CHUCK/*a, b, c, d, e, f*
 for example : CHUCK/11, 240, 300, 60, 120, - 100

FIGURE 1 – Description of an external clamping chuck



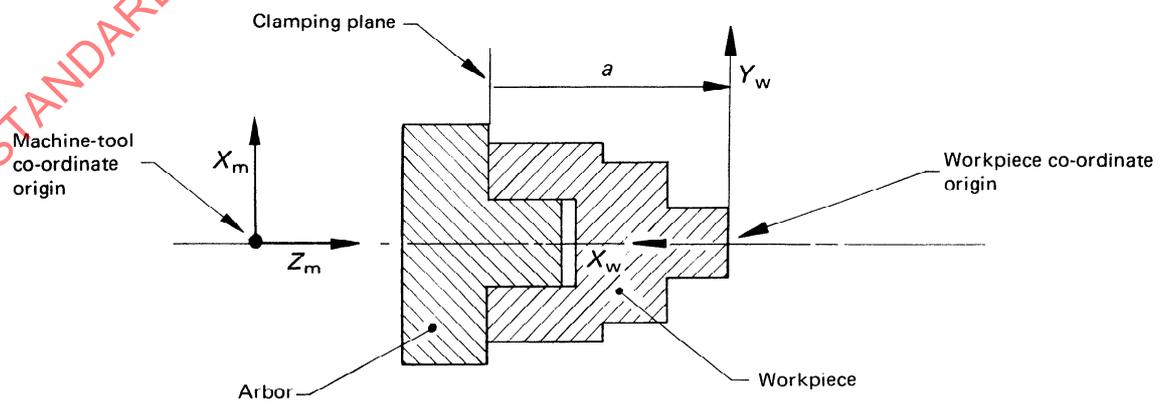
CHUCK/*a, b, c, d, e, f*
 for example : CHUCK/12, 240, 300, 0, 120, 100

FIGURE 2 – Description of a mounting arbor



CLAMP/*a*
 for example : CLAMP/80

FIGURE 3 – Clamping with an external clamping chuck



CLAMP/*a*, INVERS
 for example : CLAMP/300, INVERS

FIGURE 4 – Clamping at a mounting arbor in a position turned through 180°

CLDIST

[Integer code $n = 1071$]

Clearance distance. Indicates a clearance envelope for collision avoidance at the given distance from the surface.

Syntax

CLDIST/ a

Minor element definitions

a

Specifies thickness of the clearance envelope.

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C L E A R P

[Integer code $n = 1004$]

Clearance plane. Specifies a clearance plane to which the tool tip will be moved when RETRACT (7) is encountered.

Syntax

```
CLEARP/[symbol, a,] b, c, d, e
          [XYPLAN,] e
CLEARP/ YZPLAN, e
          ZXPLAN, e
```

Minor element definitions and integer code numbers

symbol, a

Optionally inserted by the processor where the symbolic plane is previously defined.

a is either a subscript, if any, or zero.

 b, c, d

Specify the X, Y, Z components of the plane normal unit vector.

 e

Specifies the distance of the plane from the part co-ordinate origin in the direction of the plane normal unit vector.

XYPLAN, e IC = 33

Defines the position of a plane normal to the Z -axis in the part co-ordinate system.

YZPLAN, e IC = 37

Defines the position of a plane normal to the X -axis in the part co-ordinate system.

ZXPLAN, e IC = 41

Defines the position of a plane normal to the Y -axis in the part co-ordinate system.

CLRSRF

[Integer code $n = 1057$]

Clearance surface. Specifies a clearance surface to which the tool tip will be moved when RETRACT (7) is encountered*.

Syntax

CLRSRF/[[PLANE,] symbol, a ,] b , c , d , e

Minor element definitions and integer code numbers

PLANE, symbol, a IC = 3003

Inserted by the processor when the symbolic plane is previously defined.

a is either a subscript, if any, or zero.

b , c , d

Specify the X , Y , Z components of the plane normal unit vector.

e

Specifies the distance of the plane from the part co-ordinate origin in the direction of the plane normal unit vector.

* Currently, only planes are defined as clearance surfaces.

COOLNT

[Integer code $n = 1030$]

Coolant. Specifies coolant flow, or type, or both.

Syntax

ON
 OFF
 COOLNT / FLOOD ^{n} ₀[, a]
 MIST
 TAPKUL

Minor element definitions and integer code numbers

ON	IC = 71	Initiates coolant.
OFF	IC = 72	Terminates coolant.
FLOOD	IC = 89	Initiates flood coolant.
MIST	IC = 90	Initiates mist coolant.
TAPKUL	IC = 91	Initiates tapping coolant.
a		Specifies the required delivery pipe.

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C O U P L E

[Integer code $n = 1049$]

Couple. Commands the synchronization of feedrate and spindle speed for threading operations.

Syntax

C O U P L E / $\begin{matrix} \text{O N} \\ \text{O F F} \end{matrix}$

Minor element definitions and integer code numbers

ON	IC = 71	Initiates the synchronization of feedrate and spindle speed.
OFF	IC = 72	Cancels the synchronization of feedrate and spindle speed.

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CUTCOM

[Integer code $n = 1007$]

Cutter compensation. Commands the inclusion of cutter compensation information on the control tape and optionally specifies the relationship of workpiece to cutter, the plane of compensation and the cutter compensation register to be used.

Syntax

```
CUTCOM / ON
          OFF
          RIGHT [, LENGTH [, a] ]
          LEFT
```

```
CUTCOM / ON
          OFF
          RIGHT [, XCOORD, b] [, YCOORD, c] [, ZCOORD, d]
          LEFT
```

```
CUTCOM / ON
          OFF
          RIGHT [ , XYPLAN ] [ , OSETNO, e ]
          LEFT [ , YZPLAN ]
                [ , ZXPLAN ]
          e
```

```
CUTCOM / ON
          OFF
          RIGHT [, RADIUS, f]
          LEFT
```

Minor element definitions and integer code numbers

ON	IC = 71	Causes cutter compensation information to be output.
OFF	IC = 72	Causes cancellation of the last CUTCOM command.
RIGHT	IC = 24	Specifies position of the cutter in relation to the workpiece in accordance with ISO 1056.
LEFT	IC = 8	
LENGTH	IC = 9	Specifies tool length compensation.
LENGTH, <i>a</i>	IC = 9	Specifies a cutter compensation register to be used with length compensation.
XCOORD, <i>b</i>	IC = 116	Specifies a cutter compensation register to be associated with the <i>X</i> -axis.
YCOORD, <i>c</i>	IC = 117	Specifies a cutter compensation register to be associated with the <i>Y</i> -axis.
ZCOORD, <i>d</i>	IC = 118	Specifies a cutter compensation register to be associated with the <i>Z</i> -axis.
XYPLAN	IC = 33	Specifies the plane of compensation.
YZPLAN	IC = 37	
ZXPLAN	IC = 41	

e OSETNO, e }	IC = 508	Specifies the cutter compensation register to be used.
RADIUS, f	IC = 23	Specifies a cutter compensation register to be associated with the radius.

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CYCLE

[Integer code $n = 1054$]

Cycle. Specifies or identifies operations to be carried out at each point of a 5000-type motion record.

General syntax

The syntax is of the following general form.

CYCLE/operation depth feedrate clearance modifier

where

operation defines the type of machining cycle, for example

DRILL, TAP, etc.

depth defines the distance(s) from the point* along the spindle axis over which the machining operation will be performed,

feedrate defines the feedrate to be used in the cycle,

clearance defines a distance above the point(s)* to which the tool will first be positioned at rapid,

and modifier allows the modification of the basic machining cycle.

* Each point of the 5000-type motion record at which the cycle is to be performed.

Syntax

CYCLE/ DRILL
FACE
TAP , *a*, IPM, *b*
BORE IPR, *c* [, *f*] [, RAPTO, *g*] [, DWELL [, *h*]] [, ORIENT [, *o*]]
REAM MMPM, *d*
MMPR, *e*

CYCLE/ DEEP
BRKCHP $\left[\begin{array}{l} n \\ \cdot 1 [a,] \\ \cdot 1 \\ 1 \end{array} \right. \left. \begin{array}{l} IPM, b \\ IPR, c \\ MMPM, d \\ MMPR, e \end{array} \right] [, f] [, n] [, RAPTO, g] [, DWELL [, h]]$
[, TIMES, *p*]

CYCLE/ DEEP
BRKCHP , *a*, INCR $\left[\begin{array}{l} n \\ \cdot 1 [q,] \\ \cdot 1 \\ 1 \end{array} \right. \left. \begin{array}{l} IPM, b \\ IPR, c \\ MMPM, d \\ MMPR, e \end{array} \right] [, f] [, r] [, RAPTO, g]$
[, DWELL [, *h*]] [, TIMES, *p*]

CYCLE/THRU, $\left[\begin{array}{l} n \\ \cdot 1 [a,] \\ \cdot 1 \\ 1 \end{array} \right. \left. \begin{array}{l} IPM, b \\ IPR, c \\ MMPM, d \\ MMPR, e \end{array} \right] [, f] [, DWELL [, h]]$

CYCLE/CSINK, *k*, *l* [, *m*], IPM, *b*
IPR, *c* [, *f*] [, *n*] [, RAPTO, *g*] [, DWELL [, *h*]]
MMPM, *d*
MMPR, *e*

CYCLE/ ON
OFF
MANUAL

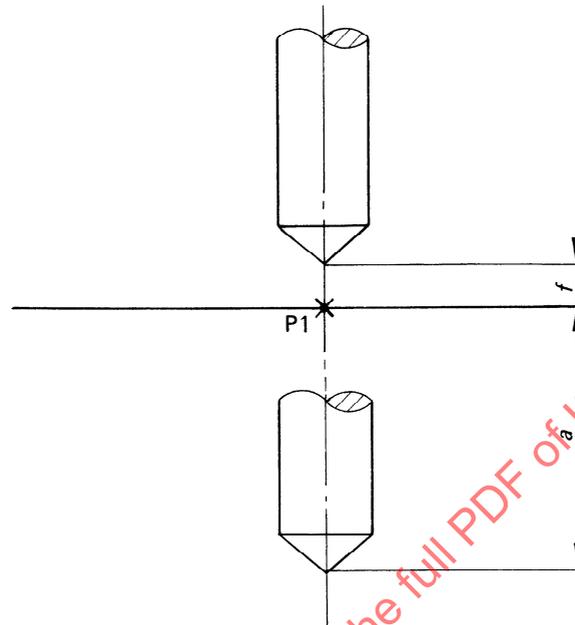
Minor element definitions and integer code numbers

ON	IC = 71		Re-establishes the sequence of operations carried out at each point that was suppressed by an OFF (72) command.
OFF (NOMORE)	IC = 72 IC = 53	}	Suppresses the sequence of operations in the manner of the G80 in ISO 1056.
MANUAL	IC = 158		Specifies that the tool is to stop at each point to allow the operator to perform a non-tape operation.
DRILL	IC = 163		Specifies a sequence of operations equivalent to the G81 fixed cycle in ISO 1056 (see figure 5 for example).
FACE	IC = 81		Specifies a sequence of operations equivalent to the G82 fixed cycle in ISO 1056 (see figure 6 for example).
TAP	IC = 168		Specifies a sequence of operations equivalent to the G84 fixed cycle in ISO 1056 (see figure 7 for example).
BORE	IC = 82		Specifies a sequence of operations equivalent to the G86 fixed cycle in ISO 1056.
REAM	IC = 262		Specifies a sequence of operations equivalent to the G85 fixed cycle in ISO 1056 (see figure 8 for example).
DEEP	IC = 153		Specifies a sequence of operations equivalent to the G83 fixed cycle in ISO 1056 (see figures 9 to 12 for examples). The sequence includes retraction at rapid to the clearance f after each peck.
BRKCHP (STEP)	IC = 288 IC = 92	}	Specifies a sequence of operations equivalent to the G83 fixed cycle in ISO 1056 (see figure 13 for example). The sequence includes a dwell or a small retraction between each peck of the operation.
THRU	IC = 152		Specifies a feed-in, rapid-in, feed-in, rapid-in operation with a final rapid-out, used for drilling multiple walls separated by air spaces (see figure 14 for example).
CSINK	IC = 256		Specifies a sequence of operations equivalent to the G82 fixed cycle in ISO 1056 (see figures 15 and 16 for example).

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<i>a</i>			Specifies the distance from the point along the spindle axis over which the machining operation will be performed.
IPM, <i>b</i> (<i>b</i> , IPM)	IC = 73	}	Specifies magnitude of velocity of feed movement to be used during cycle, in inches per minute.
IPR, <i>c</i> (<i>c</i> , IPR)	IC = 74	}	
MMPM, <i>d</i> (<i>d</i> , MMPM)	IC = 315	}	
MMPR, <i>e</i> (<i>e</i> , MMPR)	IC = 316	}	
<i>f</i>			Specifies a distance above the point to which the tool will first be positioned at rapid.
RAPTO, <i>g</i>	IC = 280		Specifies a rapid movement which modifies the basic cycle (see the examples in figures 17 to 19).
DWELL, <i>h</i>	IC = 279		Specifies in seconds a period of no tool motion.
<i>k</i>			Specifies the diameter of countersink.
<i>l</i>			Specifies the included angle of the countersink.
<i>m</i>			Specifies the diameter of the pilot hole. Used to calculate the secondary rapid distance from the point (see figure 16 for example).
<i>r</i>			Specifies the clearance distance above the last established.
ORIENT [<i>o</i>]	IC = 246		Specifies an index position at which the spindle may be stopped in boring cycles.
TIME, <i>p</i>	IC = 28		Specifies a rapid retraction to <i>f</i> above the point every <i>p</i> pecks.
INCR, <i>q</i>	IC = 66		Specifies that the values of <i>q</i> are successive incremental distances rather than absolute from the point.

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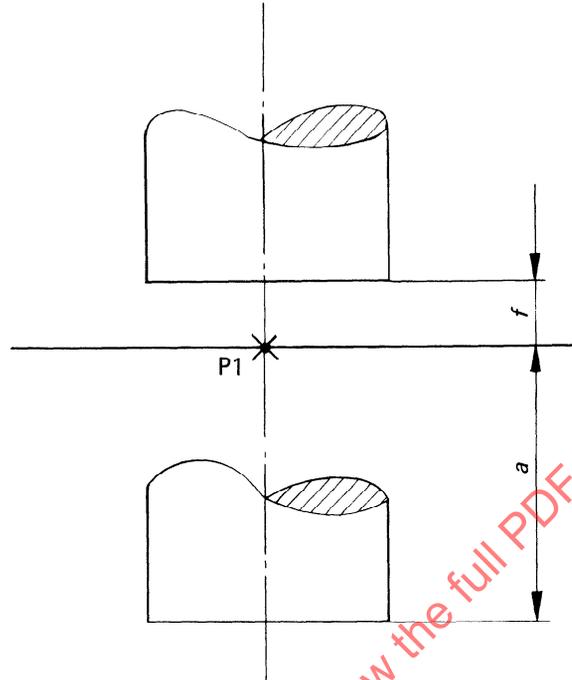
CYCLE/DRILL, a , IPM, b , f 

- 1 Position at rapid to f above the point P1
- 2 Feed a distance $f + a$
- 3 Rapid retract to a position f above P1

FIGURE 5

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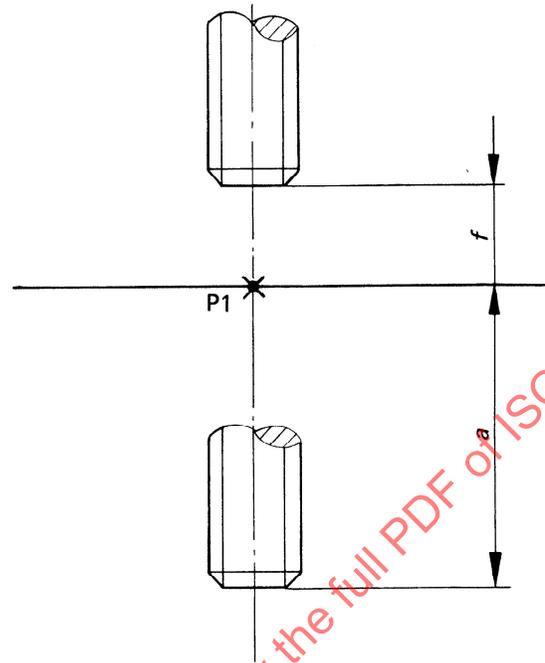
CYCLE/FACE, a , IPM, b , f



- 1 Position at rapid to f above the point P1
- 2 Feed a distance $f + a$
- 3 Dwell
- 4 Rapid retract to a position f above P1

FIGURE 6

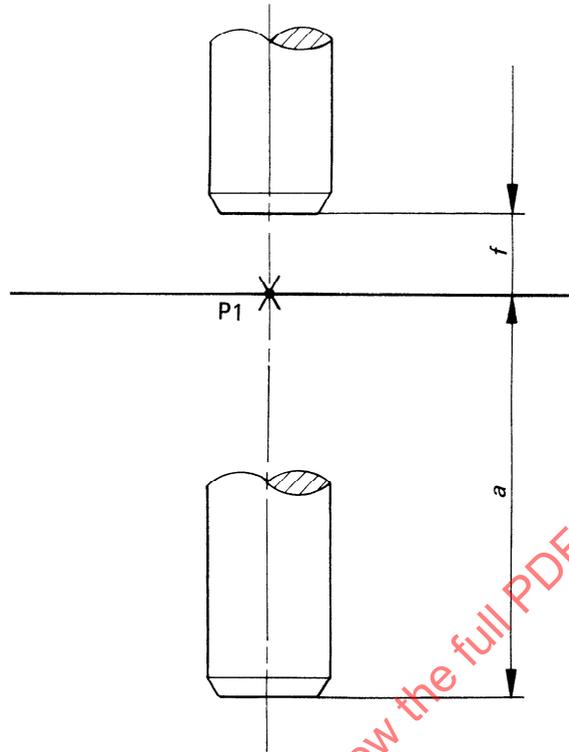
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CYCLE/TAP, a , IPM, b , f 

- 1 Position at rapid to f above the point P1
- 2 Feed a distance $f + a$
- 3 Spindle reverse and retract at feed to a position f above P1
- 4 Reinststate the initial spindle condition.

FIGURE 7

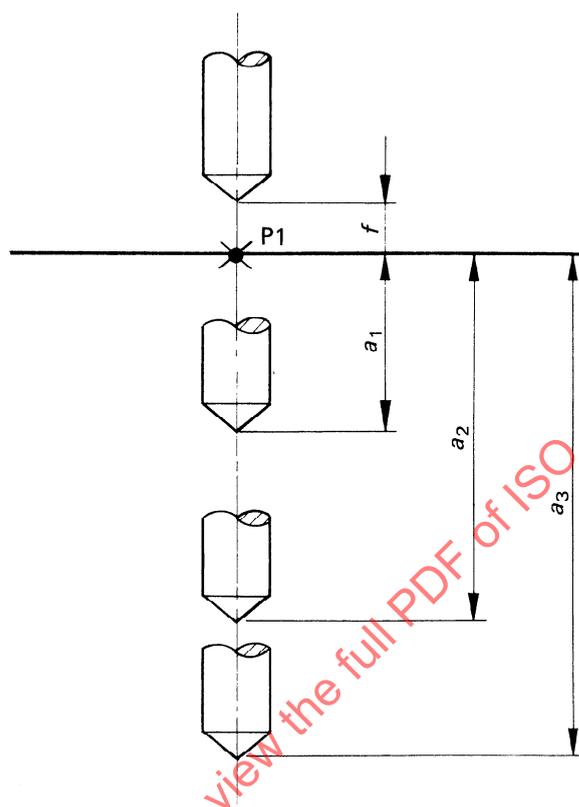
CYCLE/BORE, a , IPM, b , f



- 1 Position at rapid to f above the point P1
- 2 Feed a distance $f + a$
- 3 Retract at feedrate to a position f above P1

FIGURE 8

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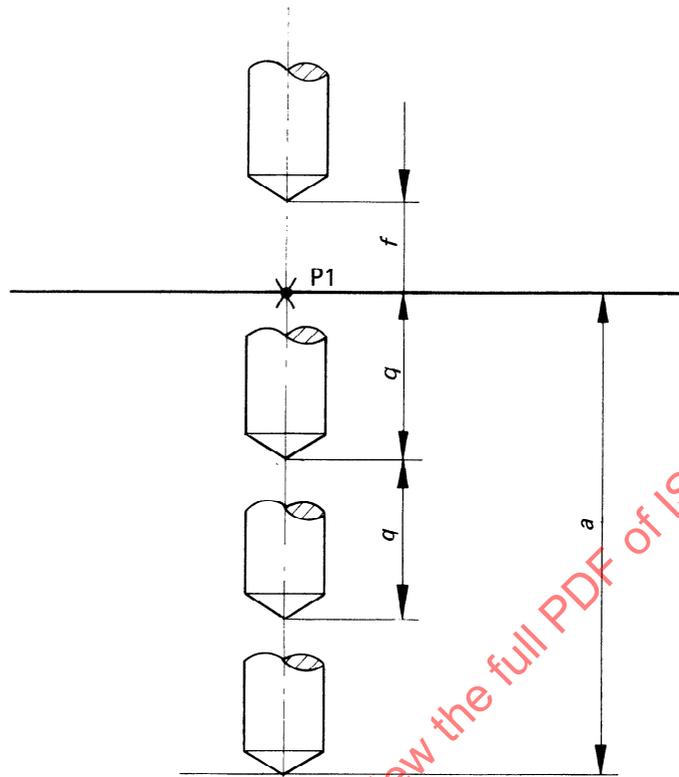
CYCLE/DEEP, $a_1, a_2, a_3, \dots, a_z$, IPM, b, f, n 

When subscript Z equals 3, the following sequence is generated :

- 1 Position at rapid to f above the point P1
- 2 Feed a distance $f + a_1$
- 3 Retract at rapid to a position f above P1
- 4 Rapid a distance $f + a_1$ less specified (n) clearance
- 5 Feed to a position a_2 below P1
- 6 Retract at rapid to a position f above P1
- 7 Rapid a distance $f + a_2$ less specified (n) clearance
- 8 Feed to a position a_3 below P1
- 9 Retract at rapid to a position f above P1

FIGURE 9

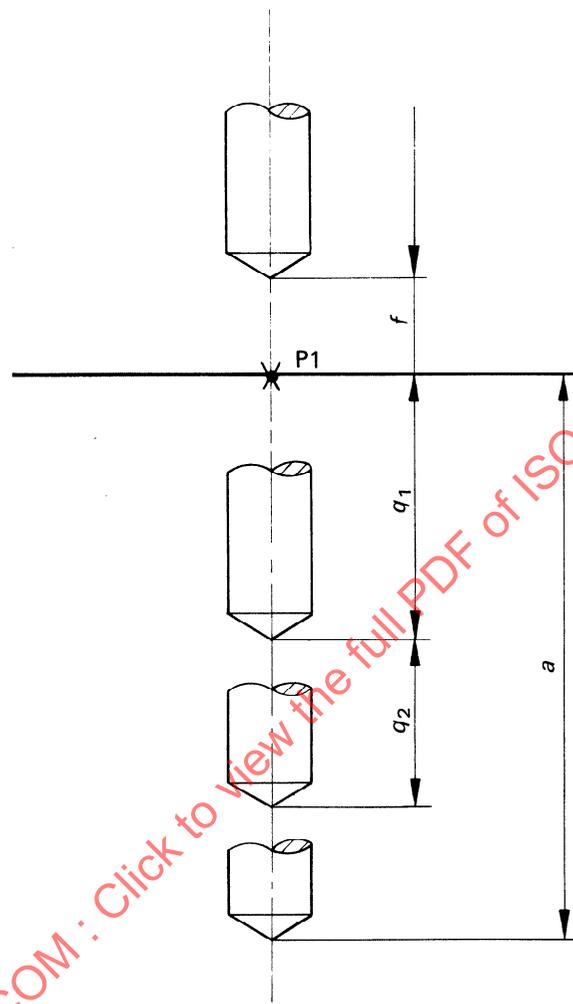
CYCLE/DEEP, a , INCR, q , IPM, b , f
 where a is less than $3q$



- 1 Position at rapid to f above the point P1
- 2 Feed a distance $f + q$
- 3 Retract at rapid to a position f above P1
- 4 Rapid a distance $f + q$ less some fixed clearance
- 5 Feed to a position $2q$ below P1
- 6 Retract at rapid to a position f above P1
- 7 Rapid a distance $f + 2q$ less some fixed clearance
- 8 Feed to a position a below P1
- 9 Retract at rapid to a position f above P1

FIGURE 10

CYCLE/DEEP, a , INCR, q_1 , q_2 , MPR, b , f
 where a is less than $q_1 + 2q_2$

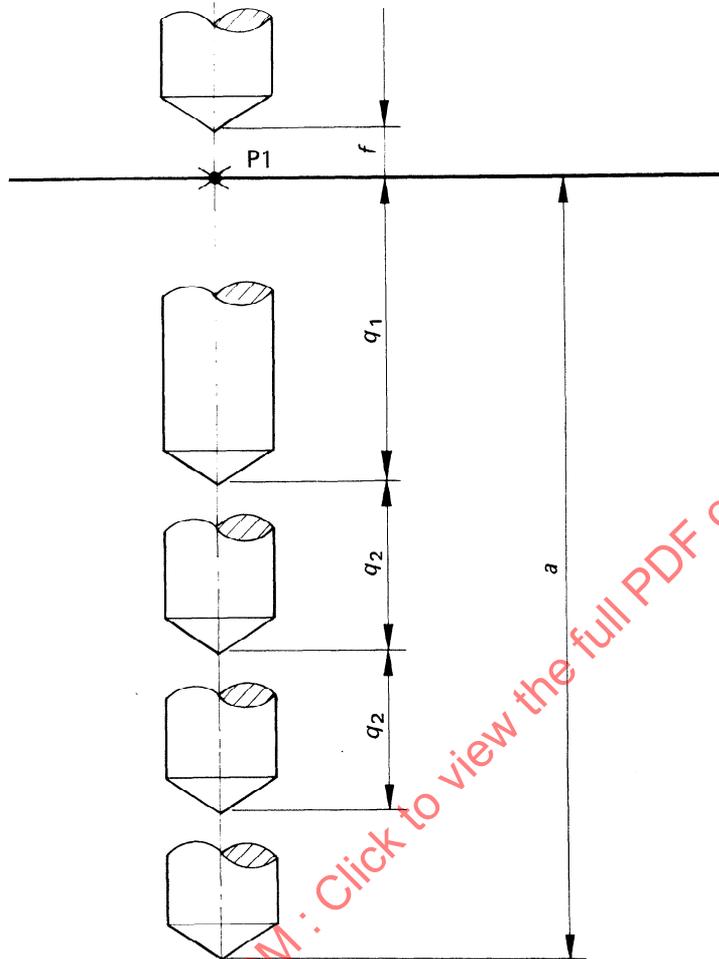


- 1 Position at rapid to f above the point P1
- 2 Feed a distance $f + q_1$
- 3 Retract at rapid to a position f above P1
- 4 Rapid a distance $f + q_1$ less some fixed clearance
- 5 Feed to a position $q_1 + q_2$ below P1
- 6 Retract at rapid to a position f above P1
- 7 Rapid a distance $f + q_1 + q_2$ less some fixed clearance
- 8 Feed to a position a below P1
- 9 Retract at rapid to a position f above P1

FIGURE 11

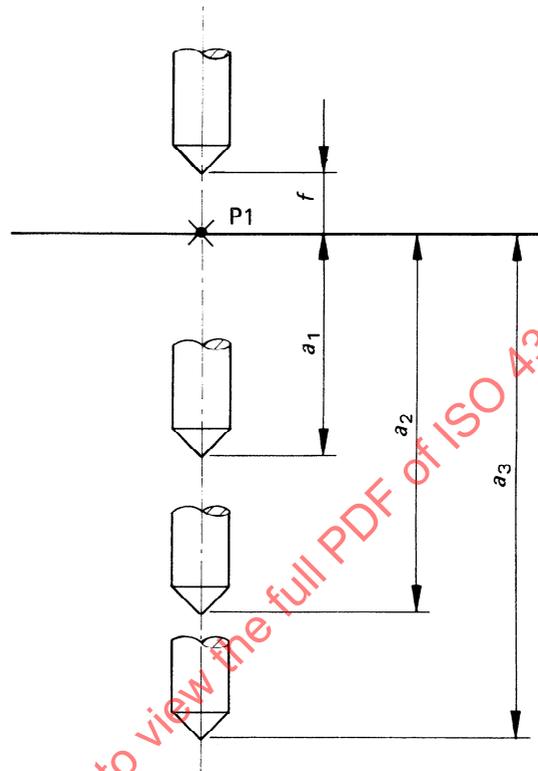
CYCLE/DEEP, a , INCR, q_1 , q_2 , MMPR, b , f

NOTE — This is the same statement as figure 11. This time, however, it is assumed that $q_1 + 2q_2 < a < q_1 + 3q_2$.



- 1 Position at rapid to f above the point P1
- 2 Feed a distance $f + q_1$
- 3 Retract at rapid to a position f above P1
- 4 Rapid a distance $f + q_1$ less some fixed clearance
- 5 Feed to a position $q_1 + q_2$ below P1
- 6 Retract at rapid to a position f above P1
- 7 Rapid a distance $f + q_1 + q_2$ less some fixed clearance
- 8 Feed to a position $f + q_1 + q_2 + q_2$ below P1
- 9 Retract at rapid to a position f above P1
- 10 Rapid a distance $f + q_1 + q_2 + q_2$ less some fixed clearance
- 11 Feed to a position a below P1
- 12 Retract at rapid to a position f above P1

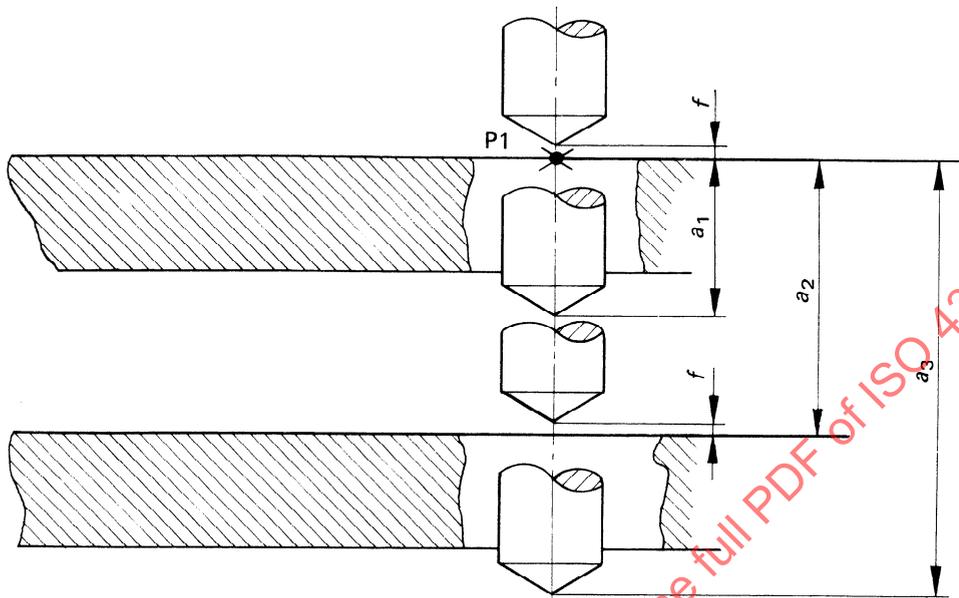
FIGURE 12

CYCLE/BRKCHP, $a_1, a_2, a_3, \dots, a_z, \text{IPM}, b, f$ 

- 1 Position at rapid to f above the point P1
- 2 Feed a distance $f + a_1$
- 3 Dwell or small retraction
- 4 Feed to a point at a distance a_2 below P1
- 5 Dwell or small retraction
- 6 Feed to a point at a distance a_3 below P1
- 7 Retract at rapid to a position f above P1

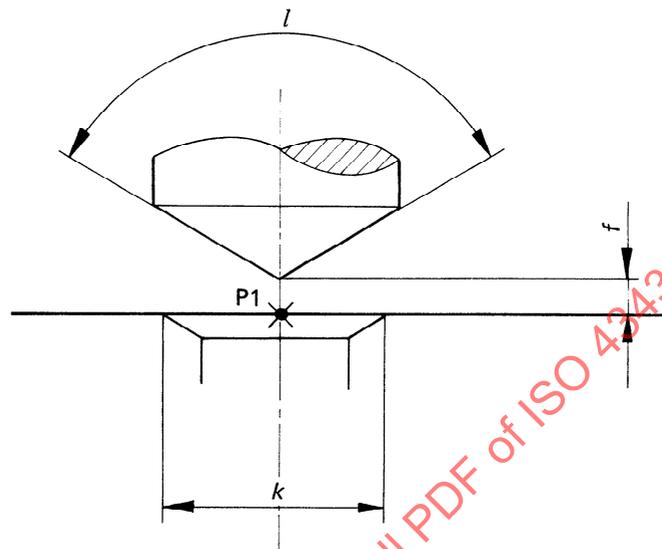
FIGURE 13

CYCLE/THRU, $a_1, a_2, a_3, \dots, a_z$, IPM, b, f



- 1 Position at rapid to f above the point P1
- 2 Feed a distance $f + a_1$
- 3 Rapid to a position $a_2 - f$ below P1
- 4 Feed to a position a_3 below P1
- 5 Retract at rapid to a position f above P1

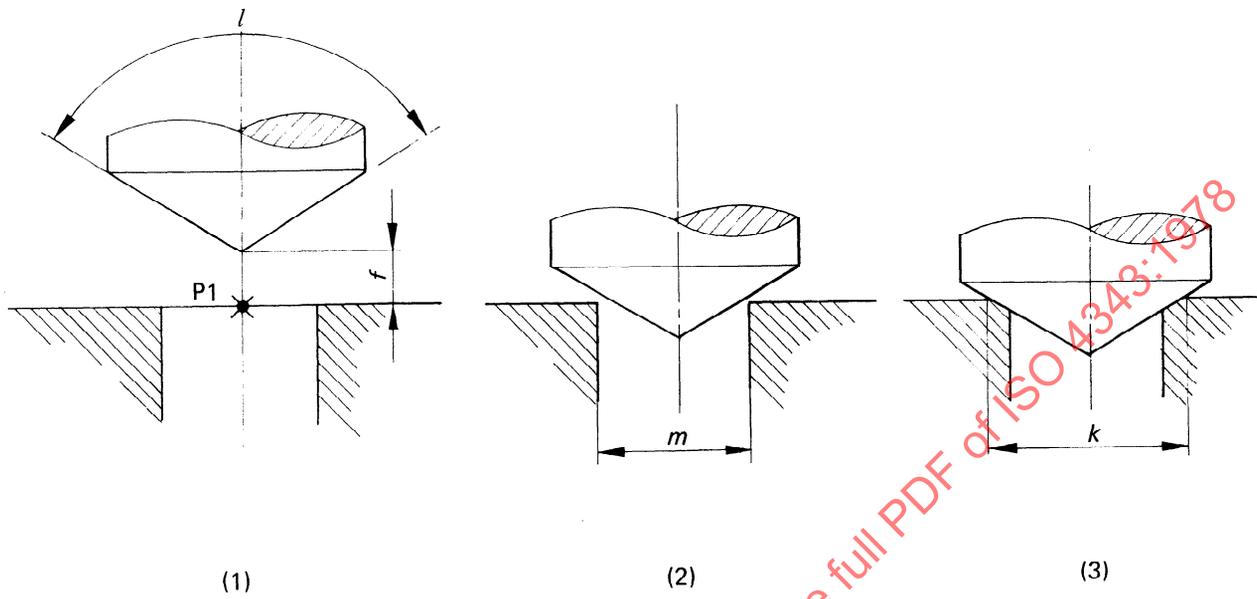
FIGURE 14

CYCLE/CSINK, k, l, IPM, b, f 

- 1 Position at rapid to f above point $P1$
- 2 Feed to depth, cutting diameter k (i.e. a distance $f + [k/(2 \tan 1/2)]$)
- 3 Dwell
- 4 Retract at rapid to a position f above $P1$

FIGURE 15

CYCLE/CSINK, k, l, m, IPM, b, f

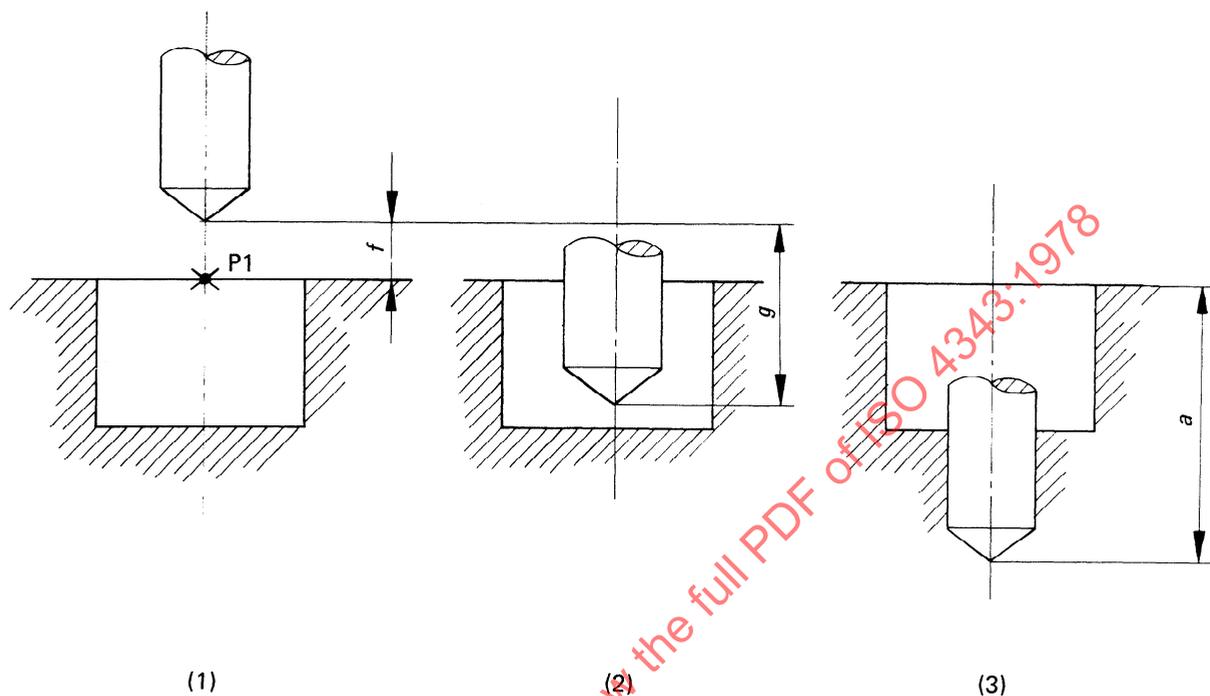


- 1 Rapid to f above $P1$
- 2 Rapid to a position, cutting a diameter m , less some clearance
- 3 Feed to a position, cutting diameter k
- 4 Dwell
- 5 Retract at rapid to a position f above $P1$

NOTE — 1 and 2 would usually be combined for the tool-axis motions.

FIGURE 16

CYCLE/DRILL, a , IPM, b , f , RAPTO, g

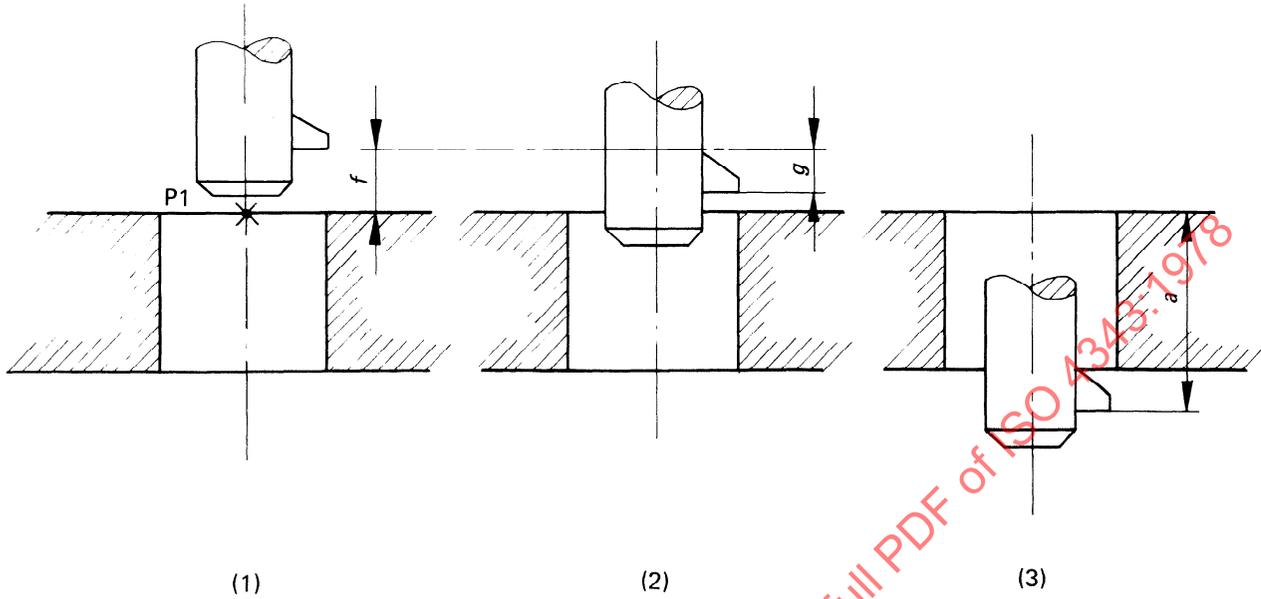


- 1 Rapid to f above P1
- 2 Rapid further distance g
- 3 Feed to a position a below P1
- 4 Retract at rapid to a position f above P1

NOTE – 1 and 2 would usually be combined for the tool-axis motions.

FIGURE 17

CYCLE/BORE, a , IPM, b , f , RAPTO, g

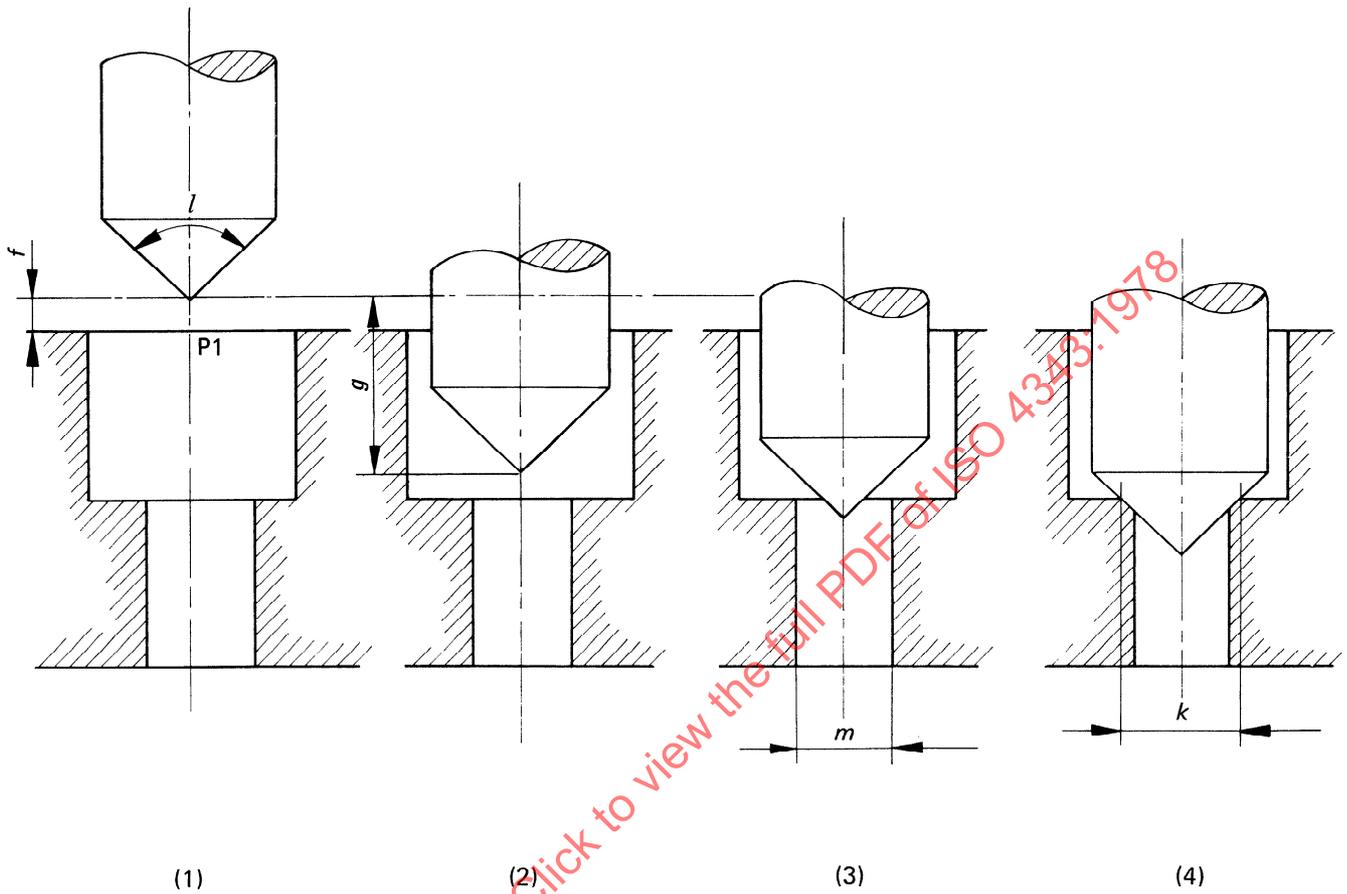


- 1 Rapid to f above point P1
- 2 Rapid further distance g
- 3 Feed to a position a below P1
- 4 Retract at feedrate to a position f above P1

NOTE – 1 and 2 would usually be combined for the tool-axis motions.

FIGURE 18

CYCLE/CSINK, $k, l, m, \text{IPM}, b, f, \text{RAPTO}, g$



- 1 Rapid to f above P1
- 2 Rapid further distance g
- 3 Rapid further to a position, cutting a diameter m , less some clearance
- 4 Feed to a position, cutting diameter k
- 5 Dwell
- 6 Retract at rapid to a position f above P1

NOTE — 1, 2 and 3 would usually be combined for the tool-axis motions.

FIGURE 19

D E L A Y

[Integer code $n = 1010$]

Delay. Specifies time, or number of revolutions, of no motion.

Syntax

$$\text{DELAY} / \overset{a}{\text{REV}}, b$$

Minor element definitions and integer code numbers

 a

REV, b
(b , REV)

IC = 97

Specifies duration of the dwell in seconds.

Specifies duration of the dwell in terms of b revolutions of the spindle.

DISPLY

[Integer code $n = 1021$]

Display. Used to control console lights or to control the presentation of display words for the machine-tool operator.

Syntax

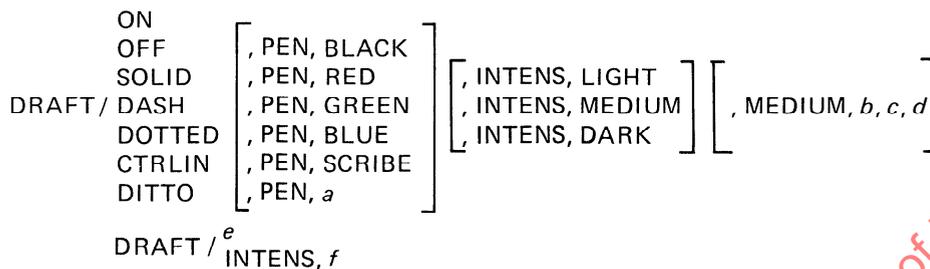
DISPLY / ^{*a*} ON
 OFF
 DISPLY / ^{*n*} ₁ [character string]

Minor element definitions and integer code numbers

<i>a</i>		Specifies a console light or display pattern.
ON	IC = 71	Commands the display action.
OFF	IC = 72	Inhibits the display action.

Draft. Specifies information pertaining to a drafting machine.

Syntax



Minor element definitions and integer code numbers

ON	IC = 71	Specifies drafting action.
OFF	IC = 72	Specifies no drafting action.
SOLID	IC = 123	Specifies continuous line _____
DASH	IC = 124	Specifies dashed line -----
DOTTED	IC = 125	Specifies dotted line
CTRLIN	IC = 126	Specifies dash-dotted line -.-.-.-.-
DITTO	IC = 127	Specifies double-dotted line
PEN, BLACK	IC = 128, 130	Specifies black line.
PEN, RED	IC = 128, 131	Specifies red line.
PEN, GREEN	IC = 128, 132	Specifies green line.
PEN, BLUE	IC = 128, 133	Specifies blue line.
PEN, SCRIBE	IC = 128, 129	Specifies scribed line.
PEN, a	IC = 128	Specifies pen by number.
INTENS, LIGHT	IC = 134, 100	Specifies light intensity of line.
INTENS, MEDIUM	IC = 134, 61	Specifies medium intensity of line.
INTENS, DARK	IC = 134, 137	Specifies dark intensity of line.
MEDIUM, b, c, d	IC = 61	Specifies code numbers which indicate the paper type, size and orientation respectively.
^e		Specifies line type by number.
INTENS, f	IC = 134	Specifies intensity of line by number.

F E D R A T

[Integer code $n = 1009$]

Feedrate. Specifies magnitude of feed movement velocity.

Syntax

$$\text{FEDRAT}/a \left[\begin{array}{l} , \text{AUTO} \\ , \text{STEP} \end{array} \right]$$

$$\text{FEDRAT} / \left\{ \begin{array}{l} \text{IPM}, b \\ \text{MMPM}, c \\ \text{PERMIN}, d \\ \text{IPR}, e \\ \text{MMPR}, f \\ \text{PERREV}, g \end{array} \left[\begin{array}{l} , \text{MAXIPM}, h \\ , \text{MXMMPM}, i \\ , \text{MXPERM}, j \end{array} \right] \left[\begin{array}{l} , \text{RANGE}, k \\ , [\text{RANGE}] \\ \text{LOW} \\ \text{MEDIUM} \\ \text{HIGH} \end{array} \right] \right\}$$

Minor element definitions and integer code numbers

<i>a</i>		Specifies the velocity.
AUTO	IC = 88	Specifies that the acceleration/deceleration function be used.
STEP	IC = 92	Specifies that acceleration/deceleration be achieved with a stepping function.
IPM, <i>b</i> (<i>b</i> , IPM)	IC = 73	Specifies velocity in inches per minute.
MMPM, <i>c</i>	IC = 315	Specifies velocity in millimetres per minute.
PERMIN, <i>d</i> (<i>d</i> , PERMIN)	IC = 501	Specifies velocity per minute in units of the part program.
IPR, <i>e</i> (<i>e</i> , IPR)	IC = 74	Specifies velocity in inches per revolution of the spindle.
MMPR, <i>f</i>	IC = 316	Specifies velocity in millimetres per revolution of the spindle.
PERREV, <i>g</i>	IC = 504	Specifies velocity per revolution of the spindle in the units of the part program.
MAXIPM, <i>h</i>	IC = 96	Specifies maximum permitted velocity in inches per minute.

MXMMPM, <i>i</i>	IC = 506	Specifies maximum permitted velocity in millimetres per minute.
MXPERM, <i>j</i>	IC = 507	Specifies maximum permitted velocity in the units of the part program.
RANGE, <i>k</i>	IC = 145	Specifies range by number.
RANGE, LOW	IC = 145, 63	Specifies a low, medium or high range.
RANGE, MEDIUM	IC = 145, 61	
RANGE, HIGH	IC = 145, 62	
LOW	IC = 63	
MEDIUM	IC = 61	
HIGH	IC = 62	

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H E A D

[Integer code $n = 1002$]

Head. Specifies a particular machine headstock when a choice of more than one is available.

Syntax

HEAD /
 BOTH
 HIGH
 LOW
 LEFT
 MAIN
 QUILL
 RAM
 RIGHT
 SADDLE
a

Minor element definitions and integer code numbers

BOTH	IC = 83	Specifies both headstocks.
HIGH	IC = 62	Specifies the higher headstock.
LOW	IC = 63	Specifies the lower headstock.
LEFT	IC = 8	Specifies the left-hand headstock.
MAIN	IC = 93	Specifies the main headstock.
QUILL	IC = 287	Specifies the quill headstock.
RAM	IC = 500	Specifies the ram headstock.
RIGHT	IC = 24	Specifies the right-hand headstock.
SADDLE	IC = 150	Specifies the saddle headstock.
<i>a</i>		Scalar specifies the desired headstock by number.

I N S E R T

[Integer code $n = 1046$]

Insert. Specifies that the following characters shall be inserted directly as control system commands.

Syntax

INSERT/ $\begin{matrix} n \\ 1 \end{matrix}$ [character item]

As the maximum size of a CLDATA record is 245 words, the maximum size of n in current implementations is 80.

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LEADER

[Integer code $n = 1013$]

Leader. Specifies the length of leader punched in a code, parity, and unit given by the post-processor.

Syntax

LEADER/ a

Minor element definitions

 a

Specifies the length of leader to be punched.

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LETTER

[Integer code $n = 1043$]

Letter. Specifies the position on the plot of the characters given in an immediately following PPRINT (1044) statement.

Syntax

LETTER/ $a, b, c [, d]$

LETTER/ a, b XAXIS
 /NOW' YAXIS LENGTH, f , AT, g [, CONST, h, i] [, XYPLAN] [, YZPLAN] [, ZXPLAN]
 ATANGL, e ' ALL

Minor element definitions and integer code numbers

a, b		Specifies the position on the plot for the first character of the PPRINT statement.
c		Specifies the scaling factor.
d		Specifies the number of letters.
NOW	IC = 161	Specifies that the script be placed at the current position.
XAXIS YAXIS	IC = 84 IC = 85	Specifies that the script be placed along the relevant axis.
ATANGL, e	IC = 1	
LENGTH, f , AT, g	IC = 9, 189	Specifies the number of characters, f , to be taken from the PPRINT statement and, g , the height of the script.
ALL	IC = 51	Specifies that all the characters in the PPRINT statement be used.

CONST, h, i IC = 64

Specifies that a numeric value or a special character be plotted. A following PPRINT record is unnecessary in such a case.

If $h < -1$, a symbol is to be plotted, where i is a numeric code for the symbol required.

If $h \geq -1$, a numeric value is to be plotted, this value being given by i .

If $h = -1$, no decimal places or decimal point are given, for example $i = 99$.

If $h = 0$, no decimal places with a decimal point are given, for example $i = 99$.

If $h > 0$, i decimal places with a decimal point are given, for example $i = 99.000$.

XYPLAN	IC = 33	}
YZPLAN	IC = 37	
ZXPLAN	IC = 41	

Specify the projection plane or planes to which the LETTER command applies.

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L I N T O L

[Integer code $n = 1067$]

Linearization tolerance. Specifies an acceptable deviation from the straight line motion of the tool tip.

Syntax

LINTOL / ^aON
OFF

Minor element definitions and integer code numbers

<i>a</i>		Specifies the magnitude of the allowable deviation.
ON	IC = 71	Initiates the linearization algorithm.
OFF	IC = 72	Cancels the linearization algorithm.

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LOADTL

[Integer code $n = 1055$]

Load tool. Commands the loading of the tool.

Syntax

$$\text{LOADTL/ [TOOL, Symbol, } a,] b [, \text{LENGTH, } c]$$

$$\left\{ [, \text{SETOOL, } d, e, f] [, \text{SETANG, } g] \right.$$

$$[, \text{ATANGL, } h] \left[[, \text{HOLDER, } i] \left[[, \text{HOLDER, }] \begin{matrix} \text{LARGE} \\ \text{SMALL} \end{matrix} \right] [, \text{MANUAL}] \left[\begin{matrix} \text{CLW} \\ \text{CCLW} \end{matrix} \right] \right.$$

$$\left. \left[, \text{ADJUST} \left[[, \text{NOW}] \left[[, \text{NEXT}] \right] \right] [, \text{DIAMET, } j] \left[[, \text{OSETNO, } k [, l] \right] \right] \right\}$$

$$\text{LOADTL/}m [, n]$$

Minor element definitions and integer code numbers

TOOL, Symbol, a	IC = 3017	Inserted by the processor when the symbolic tool is previously defined.
b		a is either a subscript, if any, or zero.
b		Specifies identification number or magazine position of the tool.
LENGTH, c	IC = 9	Specifies the length of the tool.
SETOOL, d, e, f	IC = 155	Specifies the X, Y, Z distances from the reference point on the tool to the control point on the tool holder with the setting angle applied.
SETANG, g	IC = 156	Specifies setting angle of tool. g corresponds to angle between machine axis and tool axis in degrees.
ATANGL, h	IC = 1	Specifies angle of tool axis to holder axis in degrees.
HOLDER, i	IC = 157	Specifies the holding device used to grip the tool.
[HOLDER,] LARGE	IC = 157,7	Specifies the larger holding device.
[HOLDER,] SMALL	IC = 157,26	Specifies the smaller holding device.
MANUAL	IC = 158	Specifies that the tool is to be loaded manually by the operator.

DIAMET, <i>j</i>	IC = 509	Specifies the tool diameter.
ADJUST	IC = 159	Specifies that tool compensations be applied.
ADJUST, NOW ADJUST, NEXT	IC = 159, 161 IC = 159, 162	Specifies that compensation be applied in the current or next block respectively.
OSETNO, <i>k</i>	IC = 508	Specifies the correction dial number.
OSETNO, <i>k, l</i>	IC = 508	Specifies the two axis correction dial numbers.
<i>m, n</i>		Specifies the identity number of the tool and magazine position.
CLW CCLW	IC = 60 IC = 59	Specifies direction of rotation of a turret mechanism.

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MACHIN

[Integer code $n = 1015$]

Machine. Identifies the post-processor for a particular machine/control system and provides parameters to initialize it.

Syntax

$$\text{MACHIN/name [, } a \text{] } \begin{matrix} n \\ \left[\begin{matrix} \text{symbol} \\ \text{WORD} \\ b \end{matrix} \right] \\ 0 \end{matrix}$$

Minor element definitions

name

The specification in character data of the required post-processor to be linked to the processor.

a

Identification number of the post-processor.

$$\begin{matrix} n \\ \left[\begin{matrix} \text{symbol} \\ \text{WORD} \\ b \end{matrix} \right] \\ 1 \end{matrix}$$

These elements provide for the initialization and alteration of specific internal post-processor parameters. The identification, definition and usage of each parameter will be documented for each post-processor by the post-processor writer.

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M C H T O L

[Integer code $n = 1016$]

Machining tolerance. Specifies the maximum allowable error due to machine slide dynamics at discontinuities.

Syntax
$$\text{MCHTOL} \begin{matrix} / a \\ b, c \end{matrix}$$
Minor element definitions a

Specifies the magnitude of the allowable error.

 b, c

Specifies the magnitude of the allowable overshoot and undershoot error.

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M O D E

[Integer code $n = 1003$]

Mode. Specifies the working mode.

Syntax

$$\text{MODE} / \begin{matrix} n \\ \left[\begin{matrix} \text{symbol} \\ \text{WORD} \\ a \end{matrix} \right] \\ 1 \end{matrix}$$

Minor element definitions

$$\left[\begin{matrix} \text{symbol} \\ \text{WORD} \\ a \end{matrix} \right]$$

These elements specify the working mode. The identification of each is specific to each post-processor.

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OFSTNO

[Integer code $n = 1083$]

Offset switch number. Specifies association of the tool with a particular compensation switch at the machine.

Syntax

OFSTNO / ^a [, b]
NOMORE [, c]

Minor element definitions and integer code numbers

<i>a</i>		Specifies the first correction dial number to be associated with the tool currently in action.
<i>b</i>		Specifies the second correction dial number to be associated with the tool currently in action.
NOMORE	IC = 53	Specifies that the compensation switch number(s) in the last mentioned OFSTNO statement is(are) no longer associated with the tool currently in action.
NOMORE, <i>c</i>	IC = 53	Specifies that the compensation switch number <i>c</i> is no longer associated with the tool currently in action.

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O P S K I P

[Integer code $n = 1012$]

Optional skip. Provides the facility for the operator to optionally skip control blocks.

Syntax

OPSKIP / ON
OFF**Minor element definitions and integer code numbers**

ON	IC = 71	Indicates the beginning of the information to be optionally skipped.
OFF	IC = 72	Indicates the end of the information to be optionally skipped.

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ORIGIN

[Integer code $n = 1027$]

Origin. Specifies the machine-tool co-ordinate system origin in terms of the part reference system.

Syntax

ORIGIN/ a, b ₀ ^{n} [, c]

Minor element definitions

a, b Specifies X and Y co-ordinates

c A first c specifies the Z co-ordinate. Any other c specifies other machine axis parameters.

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OV PLOT

[Integer code $n = 1042$]

Over plot. Specifies a contour to be superimposed on a previous plot.

Syntax

OV PLOT / ON
OFF [, XYPLAN] [, YZPLAN] [, ZXPLAN] [$\left[\begin{matrix} a, b, d, e \\ a, b, c, d, e, f \end{matrix} \right]$ [, SCALE, g]

Minor element definitions and integer code numbers

ON (START)	IC = 71 IC = 57	}	Specifies plot of all cutter co-ordinates until OFF encountered.
OFF (NOMORE)	IC = 72 IC = 53		
XYPLAN	IC = 33	}	Specifies projection plane(s).
YZPLAN	IC = 37		
ZXPLAN	IC = 41		
a, b, d, e a, b, c, d, e, f		}	Specifies the rectangular CLDATA co-ordinates corresponding to the opposite corners of the range of CLDATA to be plotted.
SCALE, g	IC = 25		

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P A R T N O

[Integer code $n = 1045$]

Part number. Provides the part-program identification.

Syntax

PARTNO/ n ₁[character item]

As the maximum size of a CLDATA record is 245 words, the maximum size of n in current implementations is 80.

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PIERCE

[Integer code $n = 1090$]

Pierce. Specifies the condition of the gas mixture for a torch in order to pierce the plate and sustain the cutting action (used on flame cutters).

Syntax

PIERCE / $\begin{matrix} \text{OFF} \\ \text{ON} \end{matrix}$ [*a, b, c, d*]

Minor element definitions and integer code numbers

OFF	IC = 72	Specifies the off condition of the torch.
ON	IC = 71	Specifies the on condition of the torch.
<i>a</i>		Specifies the heating period in seconds.
<i>b</i>		Specifies the setting for fuel gas valve.
<i>c</i>		Specifies the setting for heating oxygen valve.
<i>d</i>		Specifies the setting for cutting oxygen valve.

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PITCH

[Integer code $n = 1050$]

Pitch. Specifies thread pitch.

Syntax

$$\text{PITCH}/a \left[\begin{array}{l} \text{, INCR, } b \\ \text{, DECR, } c \end{array} \right] [\text{, MULTRD, } d]$$

Minor element definitions and integer code numbers

a		Specifies the thread pitch.
INCR, b	IC = 66	Specifies the rate of increase or decrease in the pitch.
DECR, c	IC = 65	
MULTRD, d	IC = 119	Specifies the number of starts in a multiple thread.

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PPFUN

[Integer code $n = 1079$]

Post-processor function. Specifies special commands or instructions given by the part-programmer for the use of the post-processor.

Syntax

$$\text{PPFUN / WORD} \begin{matrix} \text{symbol} \\ a \end{matrix} \begin{matrix} n \\ 0 \end{matrix} \left[\begin{matrix} \text{symbol} \\ \text{WORD} \\ a \end{matrix} \right]$$

Minor element definitions

$$\begin{matrix} n \\ 1 \end{matrix} \left[\begin{matrix} \text{symbol} \\ \text{WORD} \\ a \end{matrix} \right]$$

These elements provide for the initialization and alteration of specific internal post-processor parameters. The identification, definition and use of each parameter will be documented for each post-processor by the post-processor writer.

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P P L O T

[Integer code $n = 1014$]

Post-processor plot. Generates a plot of CLDATA co-ordinates.

Syntax

P P L O T / ON
OFF [, XYPLAN] [, YZPLAN] [, ZXPLAN] [, a, b, d, e] [, a, b, c, d, e, f] [, SCALE, g]

P P L O T / MEDIUM, h, i, j

P P L O T / PEN, BLACK
RED
GREEN
BLUE
SCRIBE
 k
 k, l, m

P P L O T / SOLID
DASH
DOTTED
CTRLIN
SYMBOL, n [XYPLAN
, YZPLAN
ZXPLAN]

Minor element definitions and integer code numbers

OFF (NOMORE)	IC = 72 IC = 53	} }	Stops plotting of CLDATA co-ordinates.
ON (START)	IC = 71 IC = 57	} }	Starts plotting of CLDATA co-ordinates.
XYPLAN YZPLAN ZXPLAN	IC = 33 IC = 37 IC = 41	} } }	Specifies projection plane(s).

<i>a, b, d, e</i>		Specifies the rectangular CLDATA co-ordinates corresponding to the opposite corners of the range of CLDATA to be plotted.
<i>a, b, c, d, e, f</i>		
SCALE, <i>g</i>	IC = 25	Specifies a scaling factor.
MEDIUM, <i>h, i, j</i>	IC = 61	Specifies code numbers which indicate paper type, size and orientation respectively.
PEN, BLACK RED GREEN BLUE SCRIBE <i>k</i>	IC = 128, 130 IC = 128, 131 IC = 128, 132 IC = 128, 133 IC = 128, 129 IC = 128	Specifies pen by colour or type.
PEN, <i>k, l, m</i>	IC = 128	Specifies pen type, size and colour respectively.
SOLID	IC = 123	Specifies continuous line _____
DASH	IC = 124	Specifies dashed line -----
DOTTED	IC = 125	Specifies dotted line
CTRLIN	IC = 126	Specifies dash-dotted line -.-.-.-.-
SYMBOL, <i>n</i>	IC = 235	Specifies the symbol by code number which will be plotted at each of the co-ordinates given.
XYPLAN YZPLAN ZXPLAN	IC = 33 IC = 37 IC = 41	Specifies the view to which the line or symbol specification applies.

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P P R I N T

[Integer code $n = 1044$]

Post-processor print. Indicates that the characters which follow the printed on the post-processor output listing or plotted as specified by a previous LETTER (1043) command.

Syntax

$$\text{PPRINT} / \underset{1}{n} [\text{character item}]$$

As the maximum size of a CLDATA record is 245 words, the maximum size of n in current implementations is 80.

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P R E F U N

[Integer code $n = 1048$]

Preparatory function. Provides facility to insert preparatory function (G) code numbers on control tape.

Syntax
$$\text{PREFUN/a}_0^n[.a]$$
Minor element definitions a

Specifies the preparatory function (G) code number or numbers to be output in a single block.

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R E W I N D

[Integer code $n = 1006$]

Rewind. Commands the rewinding of the control tape back to some TMARK (1005) or start of program position.

Syntax

REWIND/[*a*]

Minor element definitions

a

Specifies a tape mark identification.

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NOTE – Most control systems only rewind to the start of program position. Rewind to a TMARK is normally manually initiated.

ROTABL

[Integer code $n = 1026$]

Rotate table. Commands rotation of the table to the specified position or through the given angle.

Syntax

$$\text{ROTABL / INCR, } b \left[\begin{array}{l} \text{, CLW} \\ \text{, CCLW} \end{array} \right] \left[\text{, ROTREF} \right] \left[\begin{array}{l} \text{NOW} \\ \text{NEXT} \end{array} \right]$$

Minor element definitions and integer code numbers

a	IC = 1	}	Specifies positioning to an angle a in degrees where the direction of rotation and the absolute zero position are as defined in ISO 841.
ATANGL, a (a , ATANGL)	IC = 1		
INCR, b (b , INCR)	IC = 66 IC = 66	}	Specifies rotation by an angle b in degrees where the direction of rotation is as specified in ISO 841.
CLW CCLW	IC = 60 IC = 59		
ROTREF	IC = 68		Specifies a rotation of the part programmer's reference system.
NOW	IC = 161		Specifies that the rotation command be output immediately.
NEXT	IC = 162		Specifies that the rotation command be output with the next motion command.

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ROTHED

[Integer code $n = 1035$]

Rotate head. Commands rotation of the machine-tool head to the specified position or through the given angle.

Syntax

$$\text{ROTHED} / \text{INCR}, b \left[\begin{array}{l} \text{CLW} \\ \text{CCLW} \end{array} \right] [, \text{ROTREF}] \left[\begin{array}{l} \text{NOW} \\ \text{NEXT} \end{array} \right]$$

Minor element definitions and integer code numbers

a ATANGL, a (a , ATANGL)	IC = 1 IC = 1	}	Specifies positioning to an angle a in degrees where the direction of rotation and the absolute zero position are as specified in ISO 841.
INCR, b (b , INCR)	IC = 66		
CLW CCLW	IC = 60 IC = 59	}	Specifies that the direction of rotation is negative or positive respectively.
ROTREF	IC = 68		
NOW	IC = 161		Specifies that the rotation command be output immediately.
NEXT	IC = 162		Specifies that the rotation command be output with the next motion command.

S A F P O S

[Integer code $n = 1094$]

Safe position. Indicates a position for tool changing.

Syntax

SAFPOS/ a

SAFPOS/ $b, c [, a]$

SAFPOS/NOMORE

Minor element definitions and integer code numbers

a

Specifies the Z height to which the tool reference point has to be retracted for tool changing (given in terms of workpiece co-ordinate system).

b, c

Specify the X and Y co-ordinates to which the tool reference point has to be moved for tool changing.

NOMORE

IC = 53

Specifies that an earlier stated safe position (SAFPOS statement) is no longer valid.

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SELCTL

[Integer code $n = 1056$]

Select tool. Commands tool selection for subsequent loading.

Syntax

$$\text{SELCTL/} \left\{ \begin{array}{l} [\text{TOOL, Symbol, } a,] b [, \text{LENGTH, } c] \\ [, \text{SETOOL, } d, e, f] [, \text{SETANG, } g] [, \text{ATANGLE, } h] \\ \left[\begin{array}{l} \text{, HOLDER, } i \\ \text{, [HOLDER,] } \end{array} \right. \left. \begin{array}{l} \text{LARGE} \\ \text{SMALL} \end{array} \right] [, \text{MANUAL}] [, \text{DIAMET, } j] \left[\begin{array}{l} \text{, CLW} \\ \text{, CCLW} \end{array} \right] \\ \left[\text{, ADJUST} \left[\begin{array}{l} \text{, NOW} \\ \text{, NEXT} \end{array} \right] \right] \left[\text{, OSETNO, } k [, l] \right] \end{array} \right\}$$

Minor element definitions and integer code numbers

TOOL, Symbol, a	IC = 3017	Inserted by the processor when the symbolic tool is previously defined.
b		Specifies identification number or magazine position of the tool.
LENGTH, c	IC = 9	Specifies the length of the tool.
SETOOL, d, e, f	IC = 155	Specifies the X, Y, Z distances from the reference point on the tool to the control point on the tool holder with the setting angle applied.
SETANG, g	IC = 156	Specifies setting angle of tool. g corresponds to angle between machine axis and tool axis in degrees.

ATANGL, <i>h</i>	IC = 1	Specifies angle of tool axis to holder axis in degrees.
HOLDER, <i>i</i>	IC = 157	Specifies the holding device used to grip the tool.
[HOLDER,] LARGE	IC = 157,7	Specifies the larger holding device.
[HOLDER,] SMALL	IC = 157,26	Specifies the smaller holding device.
MANUAL	IC = 158	Specifies that the tool is to be loaded manually by the operator.
DIAMET, <i>j</i>	IC = 509	Specifies the tool diameter.
CLW	IC = 60	Specifies direction of rotation of a selection mechanism.
CCLW	IC = 59	
ADJUST	IC = 159	Specifies that tool compensations be applied.
ADJUST, NOW	IC = 159, 161	Specifies that compensation be applied in the current or next block respectively.
ADJUST, NEXT	IC = 159, 162	
OSETNO, <i>k</i>	IC = 508	Specifies the correction dial number.
OSETNO, <i>k, l</i>	IC = 508	Specifies the two axis correction dial numbers.

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S E Q N O

[Integer code $n = 1019$]

Sequence number. Permits modification of the sequence numbering of control blocks.

Syntax

```

OFF
ON
AUTO
SEQNO/ a [, INCR, b]
        [a,] INCR, c [, d]
CONST, e

```

Minor element definitions and integer code numbers

OFF	IC = 72	Specifies interruption of numbering of blocks.
ON	IC = 71	Reactivates the last method of sequence numbering.
AUTO	IC = 88	Specifies that the sequence number is to correspond to the CLDATA sequence number.
<i>a</i>		Specifies that the next block is to be numbered <i>a</i> . Unless further instructed, numbering will then revert back to previous system.
INCR, <i>b</i>	IC = 66	Specifies that the sequence number for each <i>b</i> th block will be incremented by 1.
INCR, <i>c, d</i>	IC = 66	Specifies that the sequence number for each <i>d</i> th block is to be incremented by <i>c</i> .
CONST, <i>e</i>	IC = 64	Specifies that subsequent blocks are to be numbered <i>e</i> .

SPINDL

[Integer code $n = 1031$]

Spindle. Specifies spindle functions.

Syntax

$$\text{SPINDL / } \begin{bmatrix} \overset{a}{\text{SFM}} \\ \text{RPM} \\ \text{SMM} \end{bmatrix}, b \left\{ \begin{bmatrix} \text{, CLW} \\ \text{, CCLW} \end{bmatrix} \begin{bmatrix} \text{RANGE, } c \text{ [, } f \text{]} \\ \text{LOW} \\ \text{, [RANGE,]} \text{ MEDIUM} \\ \text{HIGH} \end{bmatrix} \right.$$

$$\left. \begin{bmatrix} \text{MAXRPM} \\ \text{MAXIPM} \\ \text{MXMMPM} \end{bmatrix}, d \left[\begin{bmatrix} \text{, RADIUS, } e \\ \text{, XCOORD} \\ \text{, YCOORD} \\ \text{, ZCOORD} \end{bmatrix} \right] \right\}$$

ON
OFF
SPINDL / LOCK
NEUTRL
ORIENT

Minor element definitions and integer code numbers

a		Specifies speed in revolutions per minute.
SFM, b	IC = 115	Specifies peripheral cutting speed in feet per minute.
RPM, b	IC = 78	Specifies speed in revolutions per minute.
SMM, b	IC = 505	Specifies peripheral cutting speed in metres per minute.
CLW	IC = 60	Specifies clockwise and anticlockwise spindle rotation as defined in ISO 1056.
CCLW	IC = 59	
RANGE, c, f	IC = 145	Specifies outer and inner ranges.

RANGE, <i>c</i>	IC = 145	}	Specifies a given range.
LOW	IC = 63		
RANGE, LOW	IC = 63		
MEDIUM	IC = 61		
RANGE, MEDIUM	IC = 61		
HIGH	IC = 62		
RANGE, HIGH	IC = 62		
MAXRPM, <i>d</i>	IC = 79		Specifies maximum permitted revolutions per minute.
MAXIPM, <i>d</i>	IC = 96		Specifies maximum permitted feedrate in inches per minute.
MXMMPM, <i>d</i>	IC = 506		Specifies maximum permitted feedrate in millimetres per minute.
RADIUS, <i>e</i>	IC = 23		Specifies the value of the radius to be used in calculation of cutting speed.
XCOORD	IC = 116	}	Specifies that the current value of the given co-ordinate will be used in calculation of cutting speed.
YCOORD	IC = 117		
ZCOORD	IC = 118		
ON	IC = 71		Establishes or re-establishes spindle speed.
OFF	IC = 72		Stops spindle.
LOCK	IC = 114		Specifies locking of the spindle.
NEUTRL	IC = 166		Specifies disengagement of the spindle drive.
ORIENT	IC = 246		Specifies indexing of the spindle to a fixed position, then locking.

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S T A N

[Integer code $n = 1080$]

Setting angle. Specifies the angle at which the tool is to be set.

SyntaxSTAN/ a **Minor element definitions** a

Specifies angle between machine axis and tool axis in degrees.

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T H R E A D

[Integer code $n = 1036$]

Thread. Activates the threading mode for the next move only.

Syntax

$$\text{THREAD} / \left\{ \begin{array}{l} \text{FACE,} \\ \text{TURN,} \\ \text{TAPER,} \end{array} \left[\begin{array}{l} \text{INCR, } a, \\ \text{DECR, } b, \end{array} \right] \left[\begin{array}{l} \text{TPI, } c, \\ \text{MMPR, } d, \end{array} \right] [\text{MULTRD, } e,] \\ \\ \left[\text{DEPTH, } f, \right] \left[\begin{array}{l} \text{CUTS, } g \\ \text{CUTS, } h, i, \end{array} \right] [\text{FINCUT, } j,] [\text{CUTANG, } k,] \\ \\ \left. \left[\text{OSETNO, } l, m, \right] \right\}$$

Syntax note — All of the above elements are shown as optional and are enclosed in braces, i.e. $\{ \}$ showing that they can appear in any order. It is necessary, however, for at least one of the elements to appear in the statement.

The final comma of the last element appearing in the statement should not be used (see example given in figure 20).

Minor element definitions and integer code numbers

FACE	IC = 81	Specifies a thread normal to the axis of rotation.
TURN	IC = 80	Specifies a thread parallel to the axis of rotation.
TAPER	IC = 540	Specifies a thread at an angle to the principal axes of machine.
INCR, a	IC = 66 } IC = 65 }	Specifies the rate of increase or decrease in the lead of the thread.
DECR, b		

TPI, <i>c</i>	IC = 143	Specifies the number of threads per inch.
MMPR, <i>d</i>	IC = 316	Specifies the lead of the thread in millimetres per revolution.
MULTRD, <i>e</i>	IC = 119	Specifies the number of starts in a multiple thread.
DEPTH, <i>f</i>	IC = 510	Specifies the total depth of the threading operation.
CUTS, <i>g</i>	IC = 511	Specifies the number of cuts over the total depth.
CUTS, <i>h, i</i>	IC = 511	Specifies the number of cuts <i>h</i> , of depth <i>i</i> .
FINCUT, <i>j</i>	IC = 512	Specifies the number of finishing cuts at final depth.
CUTANG, <i>k</i>	IC = 160	Specifies the angle of the plunge direction.
OSETNO, <i>l, m</i>	IC = 508	Specifies two correction switch dials activated alternately for each threading cut.

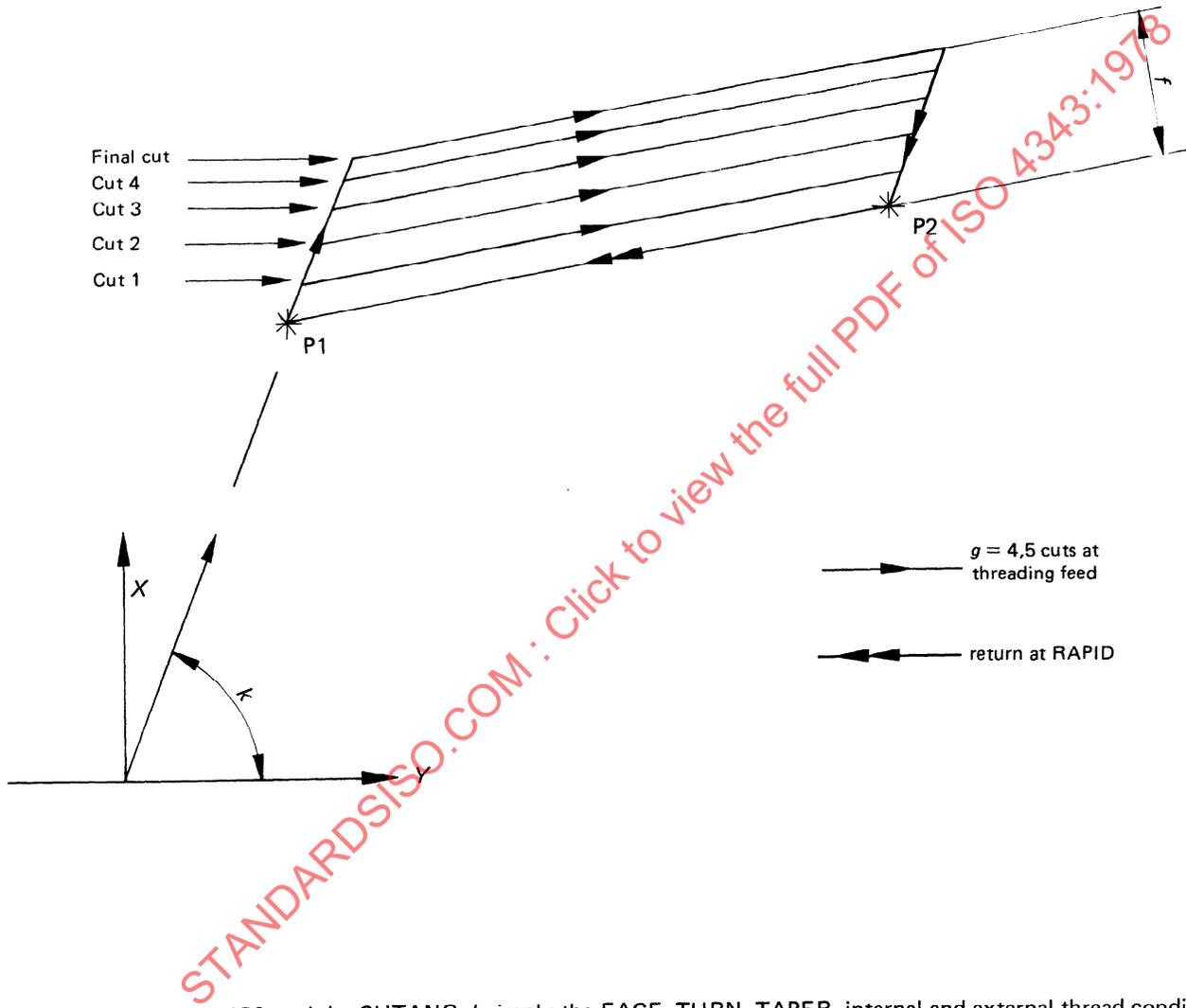
Figure 20 shows an example of the use of some of the above elements.

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GO TO/P1

THREAD/TPI, c , DEPTH, f , CUTS, g , CUTANG, k

GO TO/P2



The relationship of P1 and P2, and the CUTANG, k , imply the FACE, TURN, TAPER, internal and external thread conditions.

FIGURE 20