NC ASR Tutorial
Quick Reference Guide

G08.2 X_ Y_ Z_ I_ J_ K_ R_ H_ L_ D_ (- OR -) G08.2 X_ Y_ Z_ A_ B_ C_ R_ H_ L_ D_

Tokens Explained:

X_Y_Z_ are the linear axis target positions to move to

I_J_K_ are the target tool vectors to reorient to - cannot be used with A_B_C_

A_B_C are the target rotary axis positions - cannot be used with I_J_K_

R_ (optional) is the incremental distance the tool tip will retract, along the current tool vector, from the current tool tip position.

H_ (optional) is a Z-axis MACHINE POSITION that the control will attempt to retract to, before reorienting to a newly established work plane (transform plane). If the incremental tool retract (R parameter above) causes the Z-axis to retract above the position called out with this setting, the axis will NOT reposition, and will reorient at that location.

L_ (optional) is the incremental safety clearance distance (plane), above the newly desired target position that the tool tip will use to approach when moving to target position - an error will be reported and the program will stop if the tool tip cannot clear this distance from the target position at the start of the final approach move.

D_ (optional) is the linearization override parameter – used to override the current linearization setting - D0 forces linearization off; D1 forces linearization on - this parameter is optional; when not present the control uses the current linearization interpolation mode G43.4.

1
Start Position
R - incremental retract

2
H - Minimum Z-axis Plane
(machine position)

3
Re-Orient Tool Angle

4
L - Incremental Approach Pane

5
Target Position

6
Target Position