

G modal

Command	Data type	Description	PS	AX	RW	Range
M_SSEC_GMDL_G(x)	T_DOUBLE	G code (x=Group1 to 21)	O	--	R	
M_SSEC_GMDL_GEO_MC_NO	T_SHORT	Tool compensation No. of shape (diameter) compensation modal	O	--	R	
M_SSEC_GMDL_GEO_RADIUS	T_LONG	Compensation amount of shape (diameter) compensation modal	O	--	R	
M_SSEC_GMDL_GEO_WEAR	T_LONG	Wear amount of shape (diameter) compensation modal	O	--	R	
M_SSEC_GMDL_WEAR_MC_NO	T_SHORT	Tool compensation No. of diameter compensation modal	O	--	R	
M_SSEC_GMDL_TPOS	T_FLOATBIN/T_LONG	Position compensation vector of tool being used	O	O	R	
M_SSEC_GMDL LENG_MC_NO	T_SHORT	Tool compensation No. of length compensation modal	O	--	R	
M_SSEC_GMDL LENG_AXIS	T_STR	Axis name of length compensation modal	O	O	R	
M_SSEC_GMDL LENG_OFFSET	T_LONG	Compensation amount of length compensation modal	O	--	R	
M_SSEC_GMDL LENG_WEAR	T_LONG	Wear amount of length compensation modal	O	--	R	
M_SSEC_GMDL_H_COMP_AL	T_LONG	Information of axis in length compensation (All axes)	O	--	R	
M_SSEC_GMDL_H_COMP_NO	T_LONG	Tool compensation No. of length compensation modal	O	O	R	
M_SSEC_GMDL_SCALE_MAG	T_FLOATBIN/T_LONG	Scaling magnification (G50P_) [Grp11]	O	--	R	
M_SSEC_GMDL_COORD_ROT	T_FLOATBIN/T_LONG	Coordinate rotation angle (G68R_) [Grp16]	O	--	R	
M_SSEC_GMDL_H_SPEED_MODE	T_LONG	High speed machining mode (G5P_)	O	--	R	
M_SSEC_GMDL_GMOV	T_CHAR	gmov cutting/non-cutting command	O	--	R	
M_SSEC_GMDL_AWOFS_NO	T_CHAR	Extended workpiece selection (G54.1P_)	O	--	R	

M_SSEC_GMDL_CUTTING_STS	T_SHORT	In cutting information	O	--	R	
M_SSEC_GMDL_SCALE_MAG2	T_FLOATBIN	Scaling magnification (G50P_)[Grp11] (Compatible with Magic)	O	--	R	
M_SSEC_GMDL_COORD_ROT2	T_FLOATBIN	Coordinate rotation angle (G68R_)[Grp16] (Compatible with Magic)	O	--	R	
M_SSEC_GMDL_3D_DISP_STS	T_CHAR	3-dimensional coordinate conversion status (For displaying workpiece coordinate selection G68)	O	--	R	
M_SSEC_GMDL_H_SPEED_SPLINE	T_LONG	Spline interpolation mode	O	--	R	0: Spline OFF, 1: Spline ON
M_SSEC_GMDL_H_SPEED_SSS	T_LONG	SSS control	O	--	R	0: SSS control OFF, 1: SSS control ON
M_SSEC_GMDL_PREMOD	T_CHAR	High-accuracy control mode (G08P)	O	--	R	0: High-accuracy control OFF, 1: High-accuracy control ON