1.3 G Code List

Code	Group	Description	Modal	Page
G00	1	Rapid Move	Y	10
G01	1	Linear Feed Move	Y	10
G02	1	Clockwise Arc Feed Move	Y	11
G03	1	Counter Clockwise Arc Feed Move	Y	11
G04	0	Dwell	N	14
G09	0	Exact stop	N.	14
G10	0	Fixture and Tool Offset Setting	N	15
G12	1	Clockwise Circle	Y	18
G13	1	Counter Clockwise Circle	Y	18
G15	11	Polar Coordinate Cancel	Y	18
G16	11	Polar Coordinate	Y	18
G17	2	XY Plane Select	Y	20
G18	2	ZX Plane Select	Y	20
G19	2	YZ Plane Select	Y	20
G20	6	Inch	Y	20
G21	6	Millimeter	Y	20
G28	0	Zero Return	N	21
G30	0	2 nd , 3 rd , 4 th Zero Return	N	22
G31	1	Probe function	N	22
G32	1	Threading*	N	23
G40	7	Cutter Compensation Cancel	Y	23
G41	7	Cutter Compensation Left	Y	25
G42	7	Cutter Compensation Right	Y	25
G43	8	Tool Length Offset + Enable	Y	25
G44	8	Tool Length Offset - Enable	Y	25
G49	8	Tool Length Offset Cancel	Y	25
G50	9	Cancel Scaling	Y	25
G51	9	Scale Axes	Y	25
G52	0	Local Coordinate System Shift	Y	26

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Padhraic Smyth

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Therapy in an easy to read format connecting ethical standards to real life scenarios. This book not only focuses on the various aspects of legal issues and codes of ethics but also includes ethical decision making models and exploration into the philosophy behind ethical decision making By challenging readers to understand their own morals values and beliefs this in depth guide encourages critical thinking real world application and classroom discussion using case illustrations exercises and examples of real dialogue in every chapter FOUNDATIONS OF COUNSELING PEOPLE Michael E. Illovsky, 2013-04-01 Those in the counseling profession are interacting more with people from other cultures the U S sphere of influence throughout the world is spreading increasingly we are providing services to clients who are not Caucasian or of European heritage and our educational programs have been active in training both domestic students of diverse ethnic backgrounds as well as foreign students These factors combine to contribute to the need for those who provide counseling to understand the elements involved in interacting with a wide spectrum of people This book meets that need by providing a brief synopsis on such topics as common factors values universals cross cultural competence and models approaches and psychological perspectives of human behavior theories of personality The emphasis is on material that relies more on the use of the scientific method and data instead of anecdotal and experiential literature For the reader who is interested in obtaining information from which statements are derived there are references to investigate the material further Unlike other book that stress the barriers between counselor and client this book adds the perspective that there are factors that facilitate interactions between the two There are also frequent cross cultural examples in the book To facilitate awareness of similarities and differences in views of human behavior samples of African Arab Chinese and European American perspectives are represented. There is also a relatively large section on applications. This consists of such subjects as cross cultural aspects of psychological theories ethics research tests Euro American approaches and experiences client characteristics client and counselor interactions and therapeutic techniques Many other topics are covered as well Students and professionals in the fields of counseling and psychology will find this book to be an invaluable addition to their library

Association,1999 October 2022 - Surplus Record Machinery & Equipment Directory Surplus Record,2022-10-01
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