Haas Parameter	G Code		Haas Parameter	M Macro Call
91	9010		81	9000
92	9011		82	9001
93	9012		83	9002
94	9013		84	9003
95	9014		85	9004
96	9015		86	9005
97	9016		87	9006
98	9017		88	9007
99	9018		89	9008
100	9019		90	9009

G Code Aliasing   *M Code Aliasing*

Setting an aliasing parameter to 0 disables aliasing for the associated subroutine. If an aliasing parameter is set to a G–code and the associated subroutine is not in memory, then an alarm will be given.

COMMUNICATION WITH EXTERNAL DEVICES – DPRNT[ ]

Macros allow additional capabilities to communicate with peripheral devices. One can do digitizing of parts, provide runtime inspection reports, or synchronize controls with user provided devices. The commands provided for this are POPEN, DPRNT[ ] and PCLOS.

Communication Preparatory Commands

POPEN and PCLOS are not required on the Haas mill. It has been included so that programs from different controls can be sent to the Haas control.

Formatted Output

The DPRNT statement allows the programmer to send formatted text to the serial port. Any text and any variable can be printed to the serial port. The form of the DPRNT statement is as follows: DPRNT [<text> <#nnnn[wf]>...] :

DPRNT must be the only command in the block. In the previous example, <text> is any character from A to Z or the letters (+,-,/,*,. and the space). When an asterisk is output, it is converted to a space. The <#nnnn[wf]> is a variable followed by a format. The variable number can be any macro variable. The format [wf] is required and consists of two digits within square brackets. Remember that macro variables are real numbers with a whole part and a fractional part. The first digit in the format designates the total places reserved in the output for the whole part. The second digit designates the total places reserved for the fractional part. The total places reserved for output cannot be equal to zero or greater that eight. Thus the following formats are illegal: [00] [54] [45] [36] /* not legal formats */

A decimal point is printed out between the whole part and the fractional part. The fractional part is rounded to the least significant place. When zero places are reserved for the fractional part, then no decimal point is printed out. Trailing zeros are printed if there is a fractional part. At least one place is reserved for the whole part, even when a zero is used. If the value of the whole part has

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