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Selecting zero offset table "G53", "G54-G59"

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The NC functions G54 to G59 select and enable the zero offset tables (e.g. Zero Offset G54) to move the machine coordinate system in space. The NC function G53 disables all zero offset tables. Enabling the zero offset is based on the Motion command option *opt-pcs* (command options for kinematic product coordinate system). The ZO table should be available and stored under "PCS sets" before it is enabled.

G53 to G59 act modally and deselect each other.

Syntax

Function name	G53-G59
Modal group	Select zero offset table

Example

```
N10 G1 G54              ; Activate the PCS with ZO table of G54
N20 G90 X10 Y10 Z10 F100  ; Move to X10 Y10 Z10 based on PCS
N30 G53                 ; All ZO table off
```

Configuration

The offset distances for the machine coordinates in the kinematics can be configured in the following Data Layer path:

*motion/cfg/coord-systems/pcs/[set]/**

Add "PCS sets group" with the name "G54".... "G59" manually with the payload of PCS set names.

Respective Motion command

KinPCSP