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When executing the program, the coordination of Z axis starts from +1.0, and the system works downwards until it reaches -1.0 (W5) and stop the work . CHMER CNC EDM OPERATION MANUAL 3- 120 No. E CODE Descriptions E12 Z-AXIS ← Work along the X axis (X+ or X-) until the preset coordination (W5) is reached. If the depth setting is larger than the current work coordination, the Z axis works ...

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