

## 8. Edge Adjustment

The origin and angle are adjusted on the basis of the locations of three points along the edges.

**G121 A\_ X\_ Y\_ I\_ J\_ Q\_ B\_ C\_ H\_ Z\_ D\_ W\_**

I	A:	Sensing pattern	(A1)
I	X:	Corner target point X	(0)
I	Y:	Corner target point Y	(0)
I	I:	1st locating point	(Alarm)
I	J:	2nd locating point	(Alarm)
I	Q:	3rd locating point	(Alarm)
	B:	Setting for origin coordinate X	(Corner target point X)
	C:	Setting for origin coordinate Y	(Corner target point Y)
	H:	Position to end fast feed down	(Tracing start height)
	Z:	Height to return to after sensing	(Position to end fast feed down)
	D:	Length of locating run	(50 mm)
	W:	Calibration value number	(0)

\* The commands shown in parentheses ( ) are the default commands in case of missing addresses.

Those marked with a I are the minimum recommended addresses to be included in commands.

