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You would probably have to take into account the program run time before IF[#3012 GE 20000] GOTO9999 Block is executed. For example, lets say that the last time IF[#3012 GE 20000] GOTO9999 executed the time was 7:59:59; in this case the conditional statement would test false.

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At blocks containing M00, M01, M02 or M30, blocks containing M codes for which buffering is suppressed by setting parameter (No.3411-3432), and blocks containing prevention buffering G codes like G53, the CNC stops to pre-read the NC statement after that.

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Quite clear. Stefan

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