



INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 1056

PUNCHED TAPE BLOCK FORMATS
FOR THE NUMERICAL CONTROL OF MACHINES
CODING OF PREPARATORY FUNCTIONS G
AND MISCELLANEOUS FUNCTIONS M

1st EDITION

April 1969

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BRIEF HISTORY

The ISO Recommendation R 1056, *Punched tape block formats for the numerical control of machines - Coding of preparatory functions G and miscellaneous functions M*, was drawn up by Technical Committee ISO/TC 97, *Computers and information processing*, the Secretariat of which is held by the United States of America Standards Institute (USASI).

Work on this question led, in 1967, to the adoption of a Draft ISO Recommendation.

In August 1967, this Draft ISO Recommendation (No. 1316) was circulated to all the ISO Member Bodies for enquiry. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

Australia	Israel	Switzerland
Belgium	Netherlands	Turkey
Czechoslovakia	New Zealand	U.A.R.
Denmark	Poland	United Kingdom
France	Portugal	U.S.A.
Germany	Spain	
Iran	Sweden	

Two Member Bodies opposed the approval of the Draft :

Italy
Japan

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in April 1969, to accept it as an ISO RECOMMENDATION.

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INTRODUCTION

The ISO Recommendations

- R 1057, *Interchangeable punched tape variable block format for positioning and straight-cut numerically controlled machines,*
- R 1058, *Punched tape variable block format for positioning and straight-cut numerically controlled machines,*
- R 1059, *Punched tape fixed block format for positioning and straight-cut numerically controlled machines,*

specify the block formats of punched tapes used for the numerical control of machines (addresses, blocks, words, etc.). However, for the “preparatory function” G and “miscellaneous function” M words, it was found better to establish a separate ISO Recommendation, the content of which may be used for each type of formats. It is, however, possible that the current study on contouring will require the addition of some functions in the list given by this ISO Recommendation.

1. SCOPE

This ISO Recommendation defines the coding of “preparatory functions” G and “miscellaneous functions” M used for the numerical control of machines, by means of a two-digit code.