

INTERNATIONAL
STANDARD
ISO 3592

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Second edition
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Industrial automation systems — Numerical control of machines — NC processor output — File structure and language format

Systèmes d'automatisation industrielle — Commande numérique des machines — Informations de sortie des processeurs CN — Structure de fichier et format de langage

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this International Standard may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 3592 was prepared by Technical Committee ISO/TC 184, *Industrial automation systems and integration*, Subcommittee SC 1, *Physical device control*.

This second edition cancels and replaces the first edition (ISO 3592:1978), which has been technically revised.

Annexes A and B form a normative part of this International Standard.

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Introduction

The output of a general purpose numerical control processor is information used as input to a post processor. This information is called CLDATA, which was originally derived from "cutter location data."

CLDATA provides a general language to pass manufacturing information from a numerical control processor to a post processor, where the general language is converted to the specific format required by the particular numerical control equipment.

Numerical control is applied to many types of machines, but the language defined in this International Standard has been developed primarily for numerically controlled machine tools – hence the words "tool" and "part" are used in the description of the language to indicate the working element and processed element respectively. Many of the vocabulary words are also derived from metal working terminology.

The CLDATA reference language (RL) is stream oriented, containing special characters to delimit the elements of the RL. Annex A describes the rules for representing the RL on record oriented media, and it is this representation that is used for the purpose of describing the RL in this International Standard.