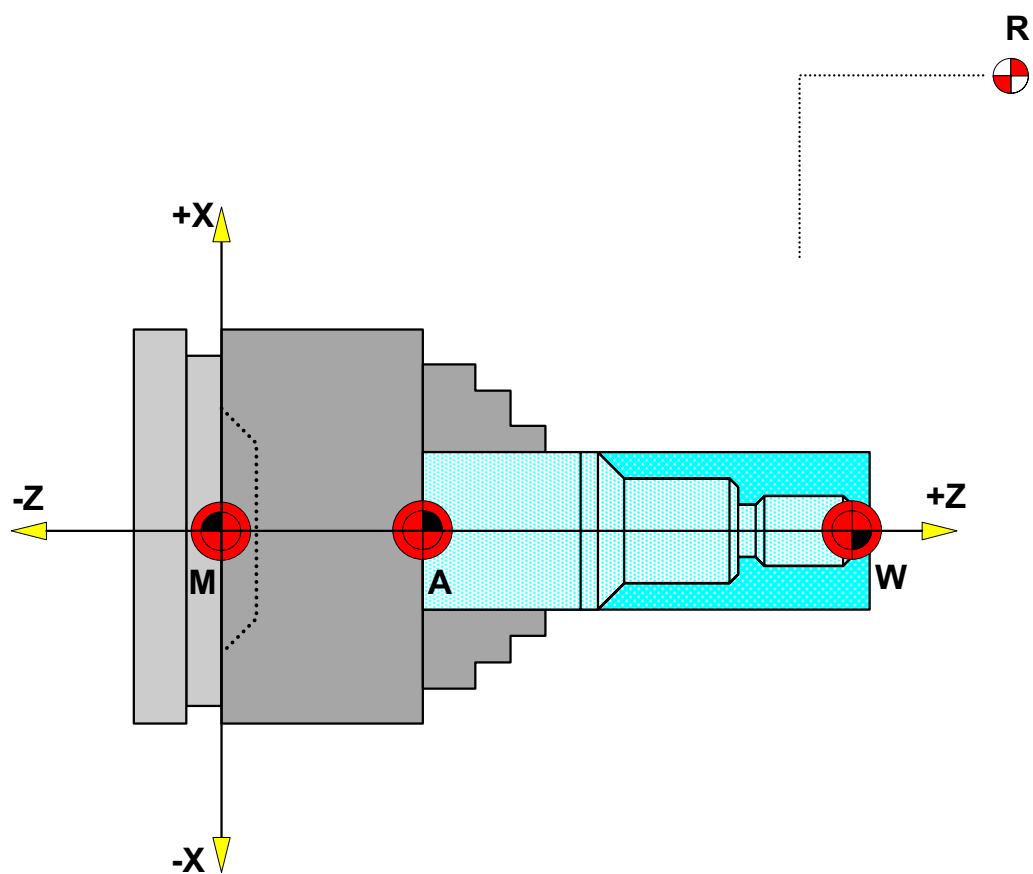


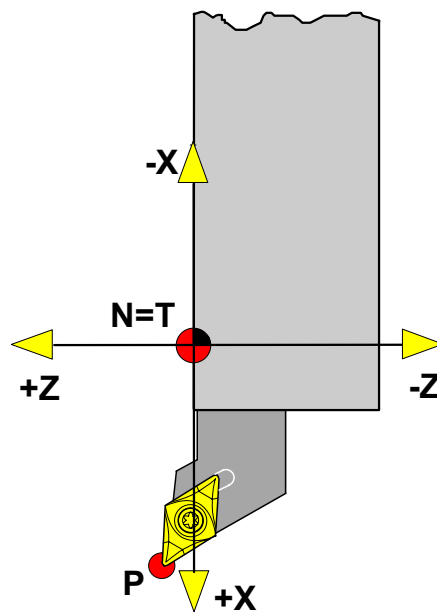
RAPPEL

CNC/TOURNAGE

Structure d'un programme ISO

أوامر تحضيرية	G54 TRANS X25 Y-25 Z9.5	نقل نقاط الصفر
القسم الأول من البرنامج مرحلة التشغيل 1	T1 D1	.
	S1990 F500 M3	معلومات تقنية السرعة S[rpm] و التغذية F [mm/min]
	G0 X-47 Y-20 Z5	حركة سريعة إلى نقطة بدء التشغيل ثم بدء التشغيل
	G1 Z-5	
	G1 X20 Y15	
		
		
		
	M05	إيقاف دوران الأداة
	G0 Z50	حركة سريعة إلى نقطة تبديل الأداة
القسم الثاني من البرنامج مرحلة التشغيل 2	T2 D1	
	S2000 F180 M3	السرعة S[rpm] و التغذية F [mm/min]
	G0 X0 Y0 Z2	حركة سريعة إلى نقطة بدء التشغيل ثم بدء التشغيل
	G1 Z-8	
	G1 X30 Y10	
	M05	إيقاف دوران الأداة
	G0 Z50	حركة سريعة إلى نقطة تبديل الأداة
نهاية البرنامج	M30	







M

Origine de la machine



A

Point d'arrêt de la pièce



W

Origine de la pièce



R

Référence de la machine



T

Référence des portes-outils



N

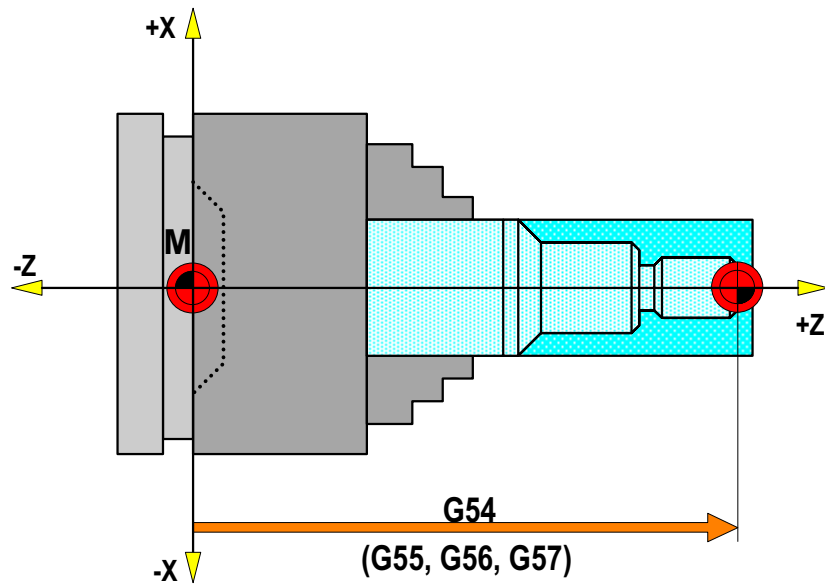
Référence du système d'outillage



P

Point tranchant d'outil

G54



WinNC SINUMERIK 840D TURN [c] Emco

Parameter Channel 1 Ref Jog

Channel reset

Program aborted

ROV

10620↓ Z- Software limit overtravel

Settable zero offset

Axis	Offset		Position	Rotation (degree)	Scale	Mirror- ing
	coarse	fine				
X	0.000	0.000	41.000 mm	0.000	1.000	☐
Z	0.000	0.000	81.000 mm	0.000	1.000	☐

SP_UIFR [1] G code G54

Selected ZO

Overview

Accept position

Determine ZO

Reject

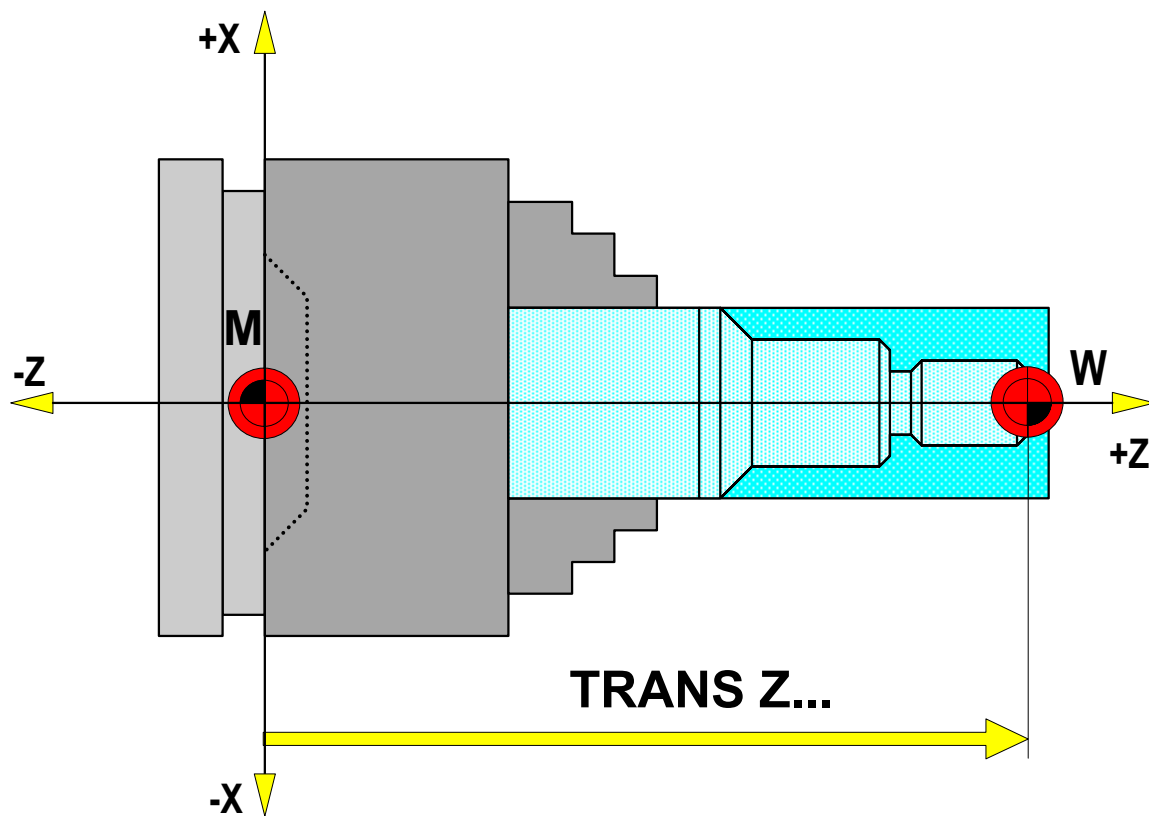
Save

Tool offset F1 R parameter F2 Setting data F3 Zero offset F4 User data F5 F6 F7 F8

N0005 G54 LF

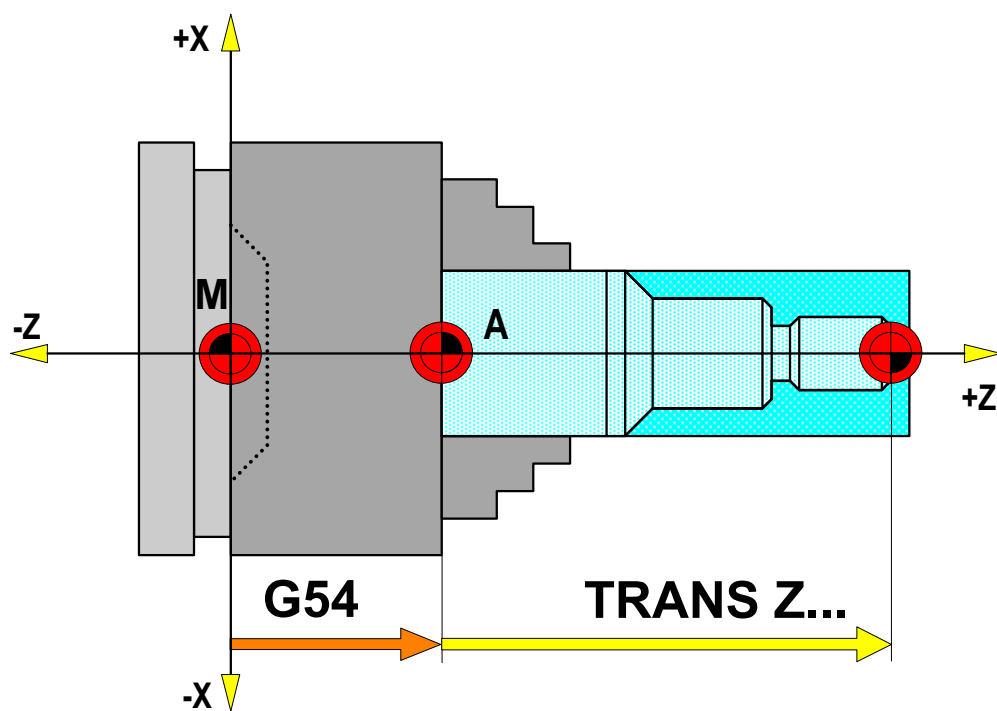
TRANS

ATRANS



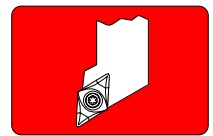
N0005 TRANS Z... LF

G54 + TRANS



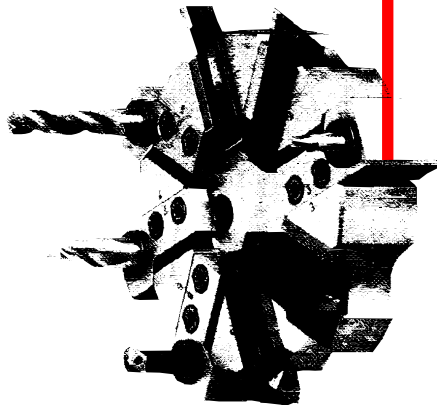
N0005 G54 LF

N0010 TRANS Z ... LF



T1

D1



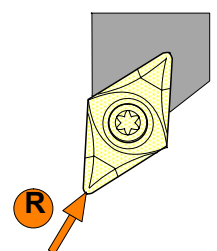
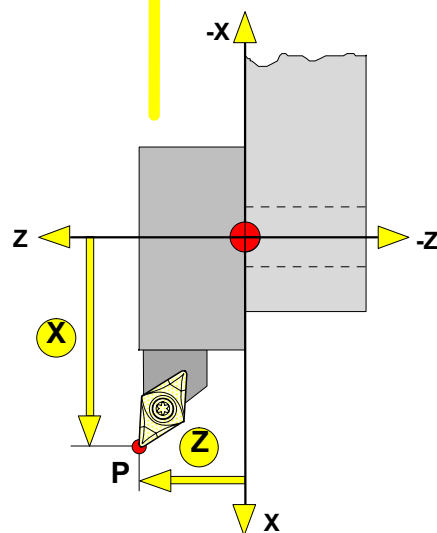
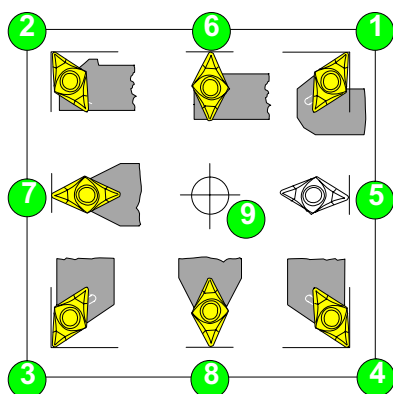
WinNC SINUMERIK 8400 TURN (c) Emco

Parameter	Channel 1	Ref	Jog
Channel reset			
Program aborted			ROV

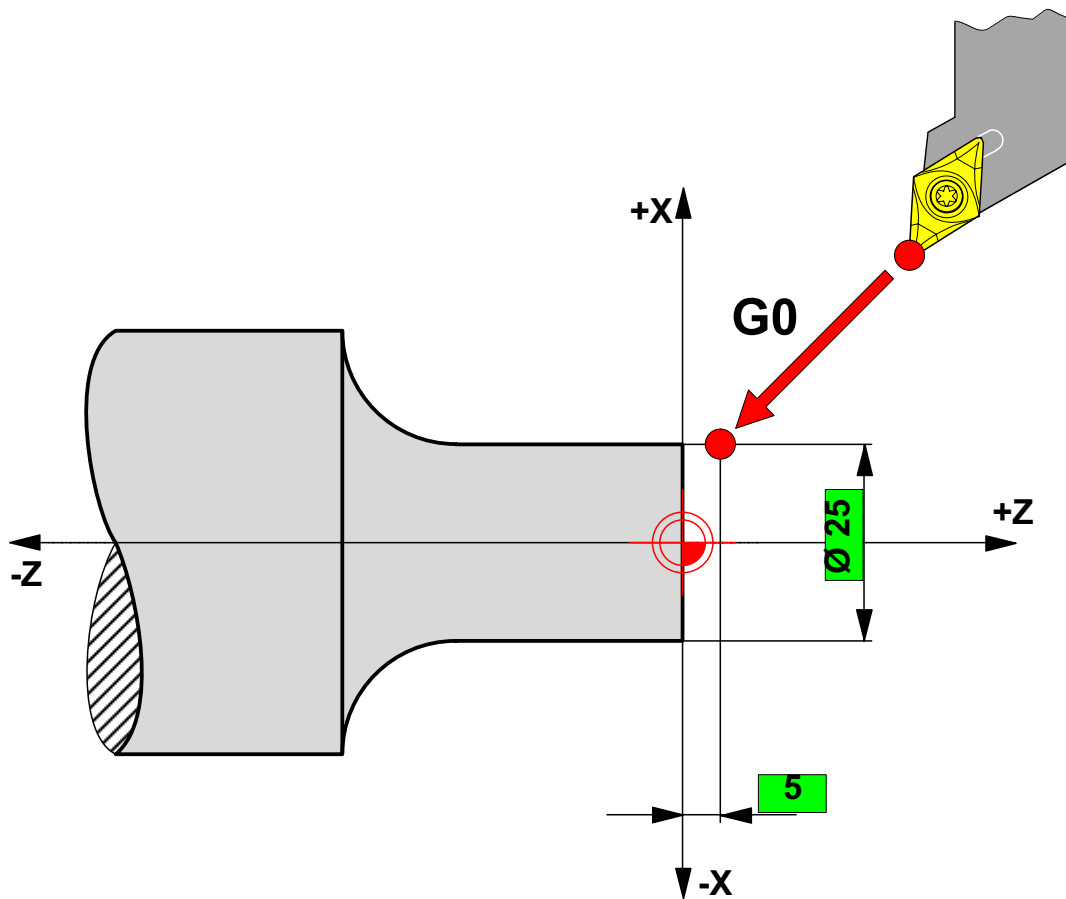
10620 ↓ Z-Software limit overtravel

Tool offsets				TO area	1
T number	1	D number	1	No. of c.edges	1
Tool type	510	Finishing tool			
C. edge pos.	3				
Tool length comp.		Geometry	Wear	Base	
Length 1	:	0.000	0.000	0.000	mm
Length 2	:	21.000	0.000	0.000	mm
Radius compensation					
Radius	:	400	0.000		mm
Technology					
Clear.angle	:	45	Deg.		
D 25 res:	:	000			

Tool offset F1 R parameter F2 Setting data F3 Zero offset F4 User data F5 F6 F7 Determine compens. F8

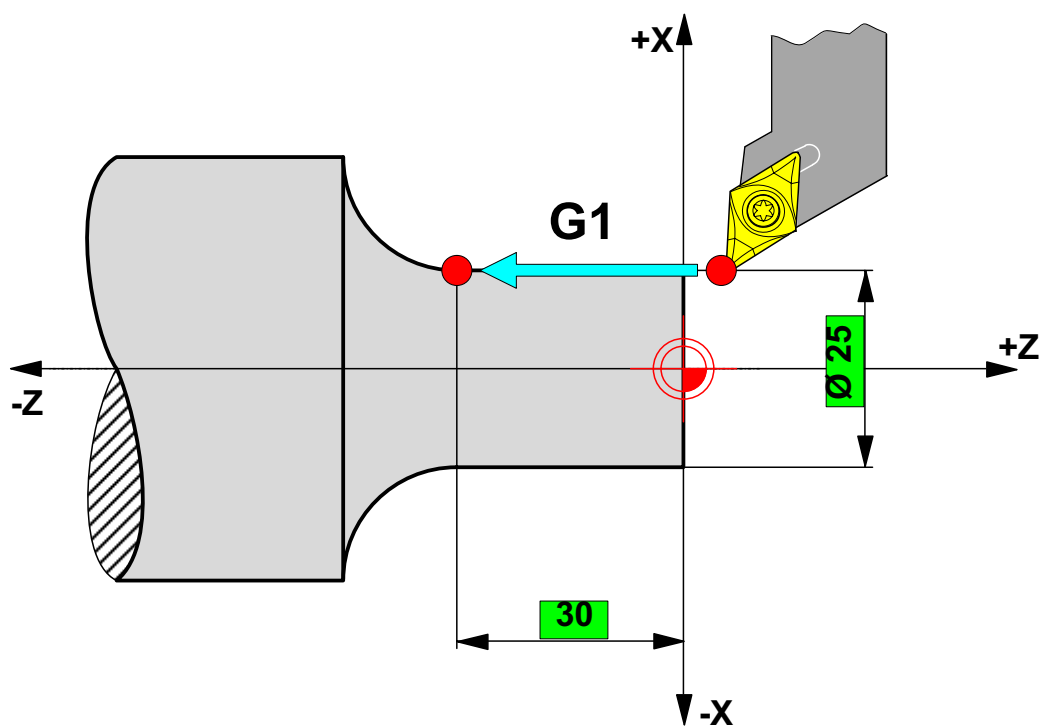


G0



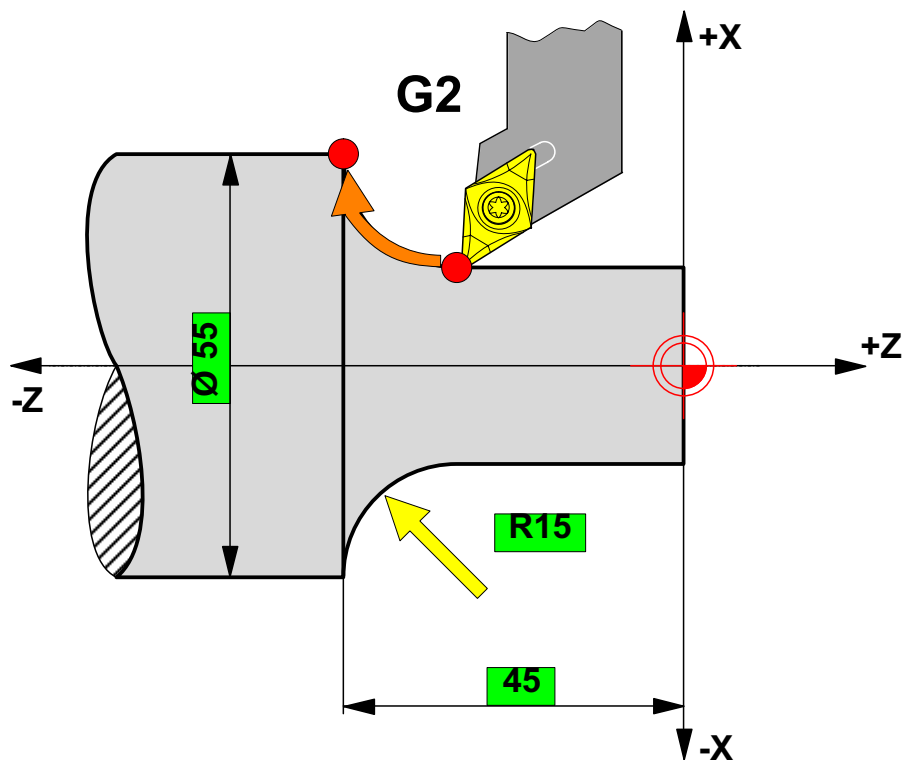
N1234 G0 X25 Z5 LF mm

G1



N1234 G1 X25 Z-30 LF mm

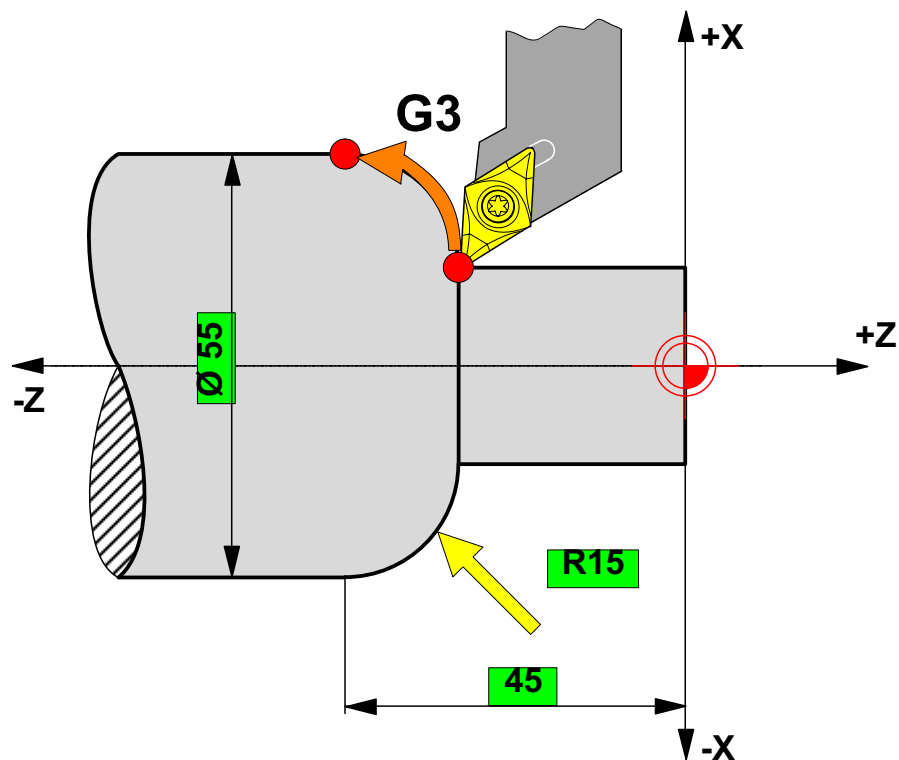
G2



N1234 G2 X55 Z-45 CR=15 LF

mm

G3

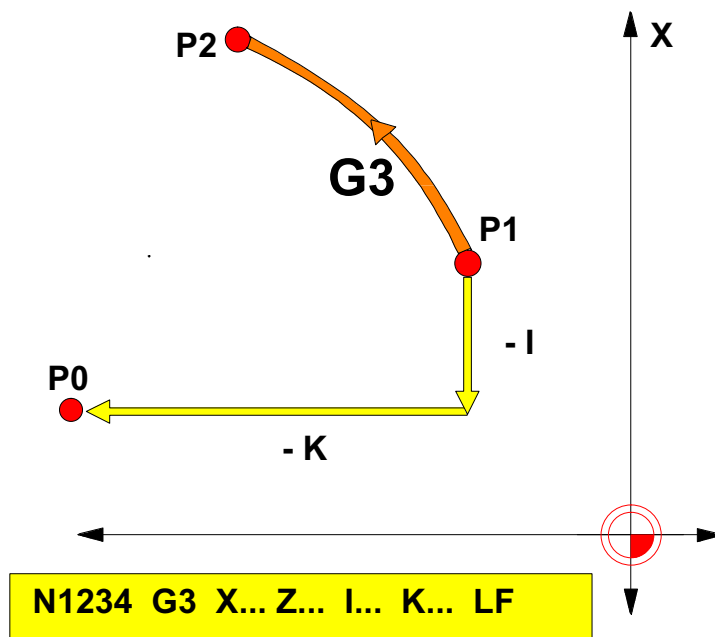
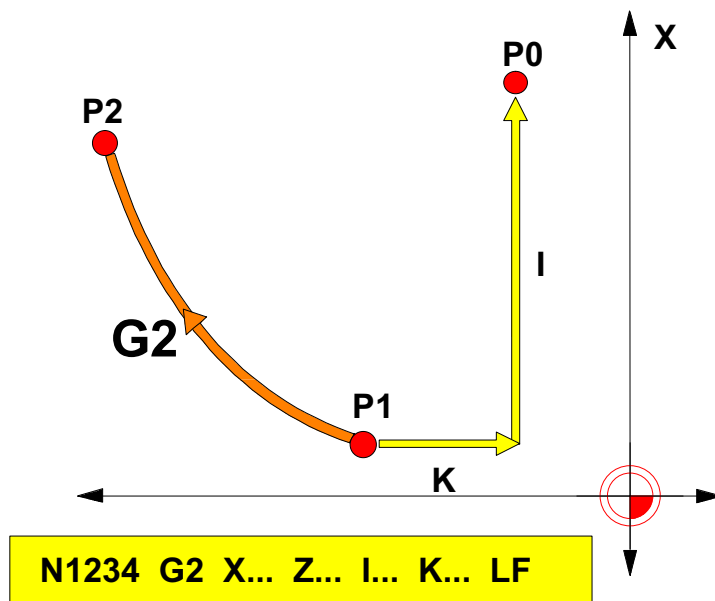
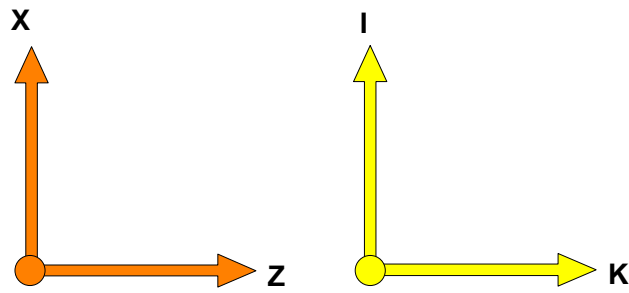


N1234 G3 X55 Z-45 CR=15 LF

mm

G2

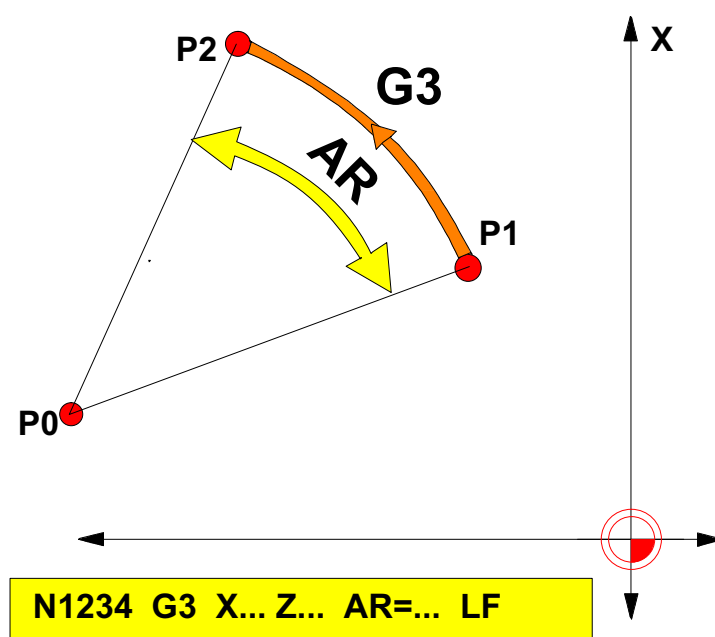
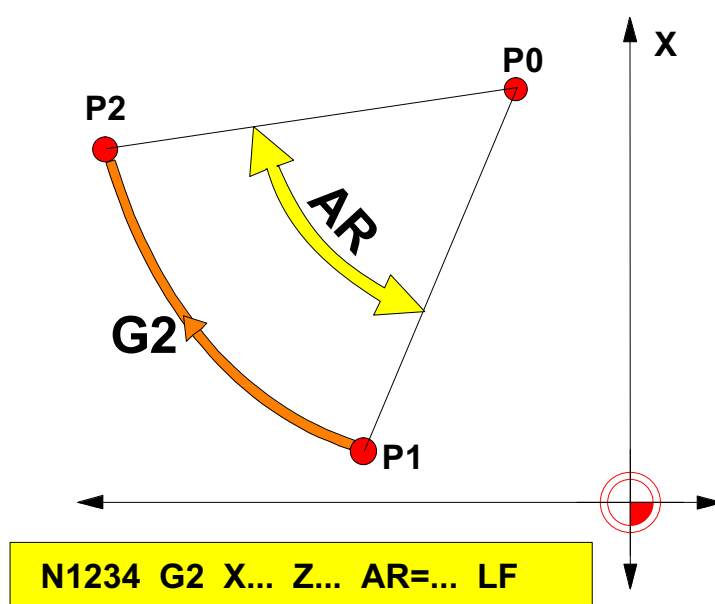
G3

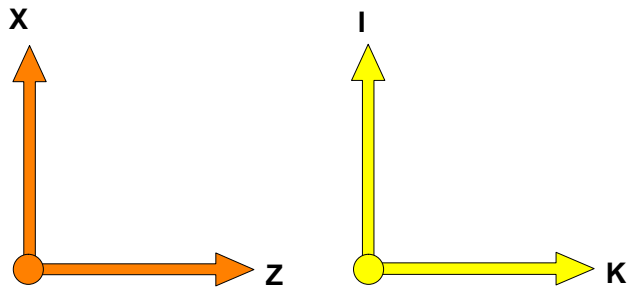


G2

G3

AR<360°!

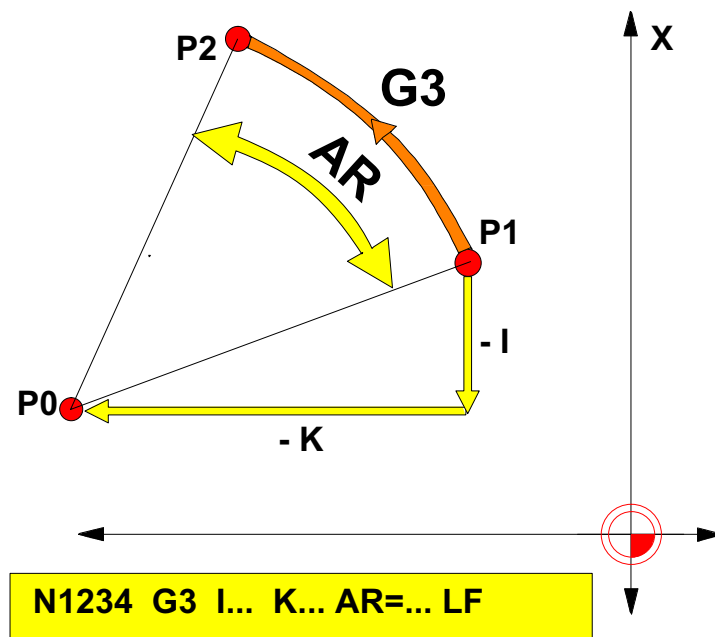
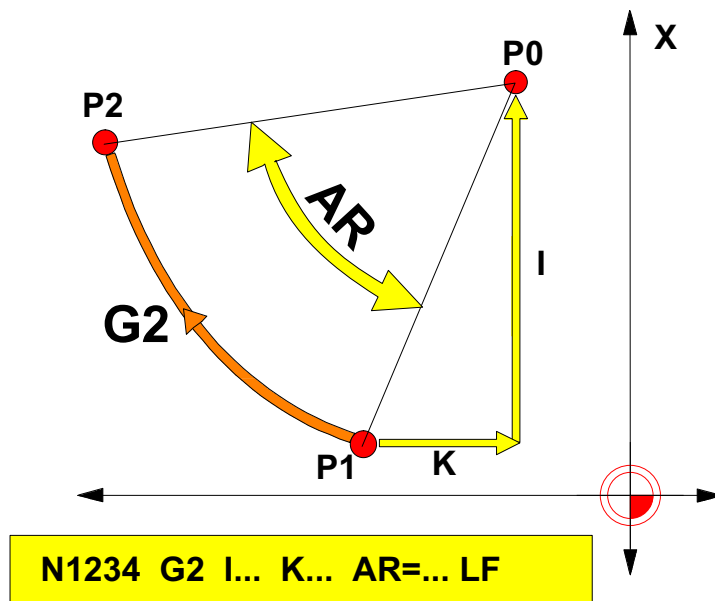


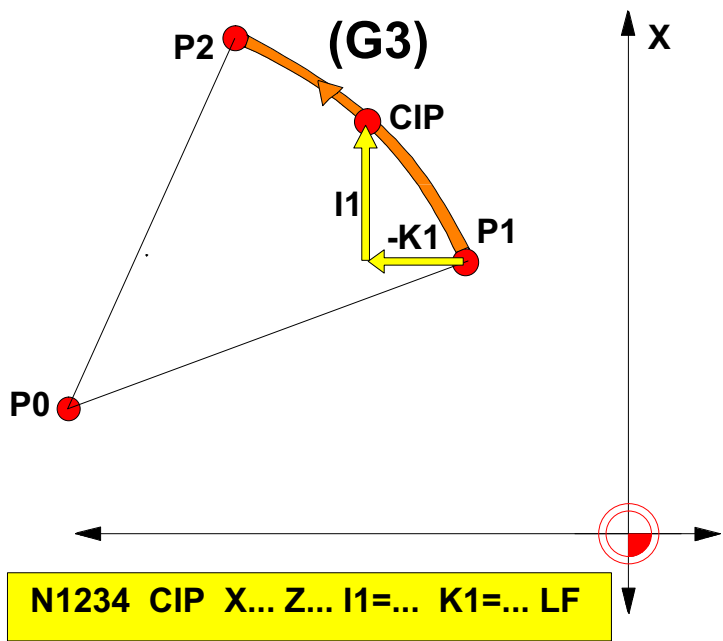
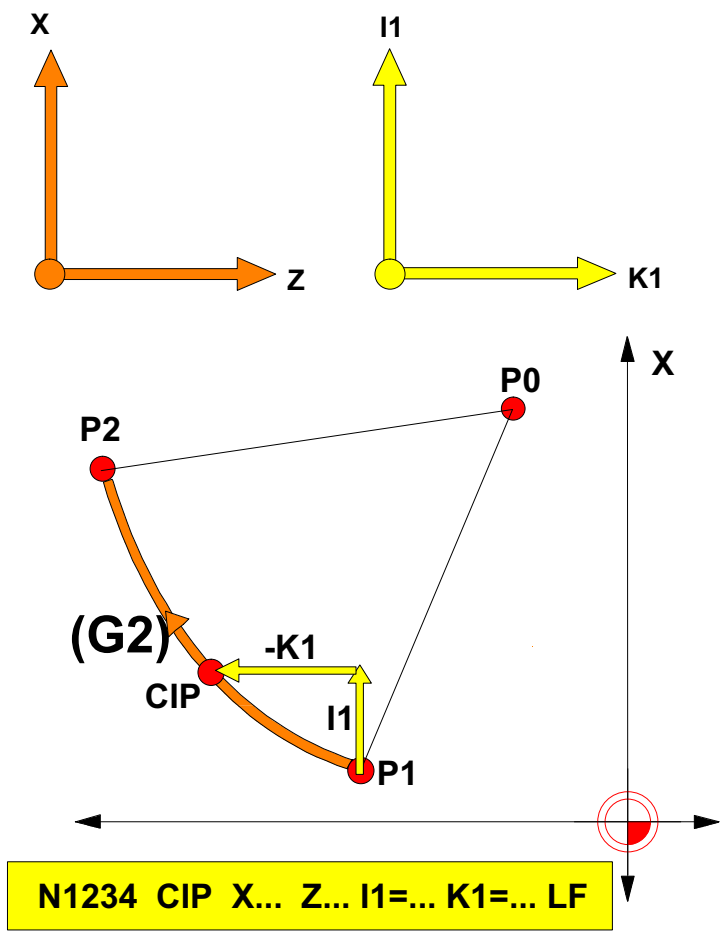


G2

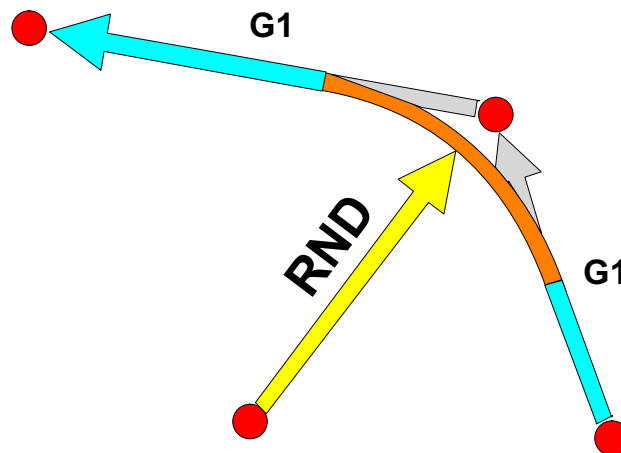
G3

AR<360°!





RND

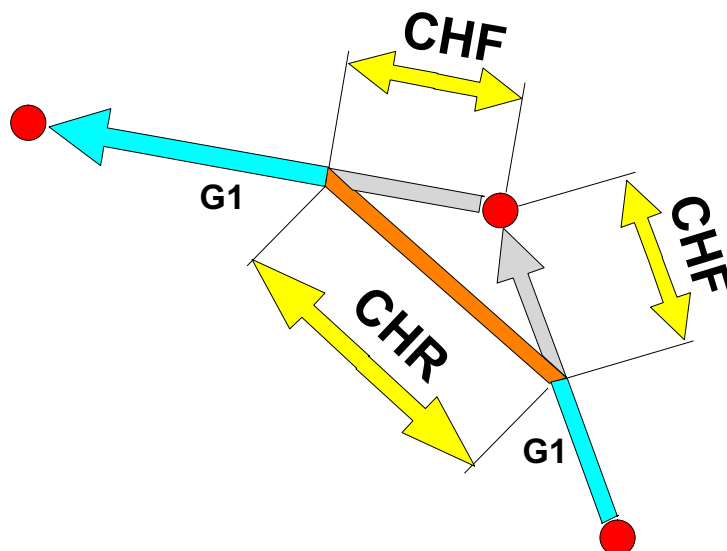


N0042 G1 X... Z... RND=... LF

N0043 G1 X... Z... LF

CHF

CHR

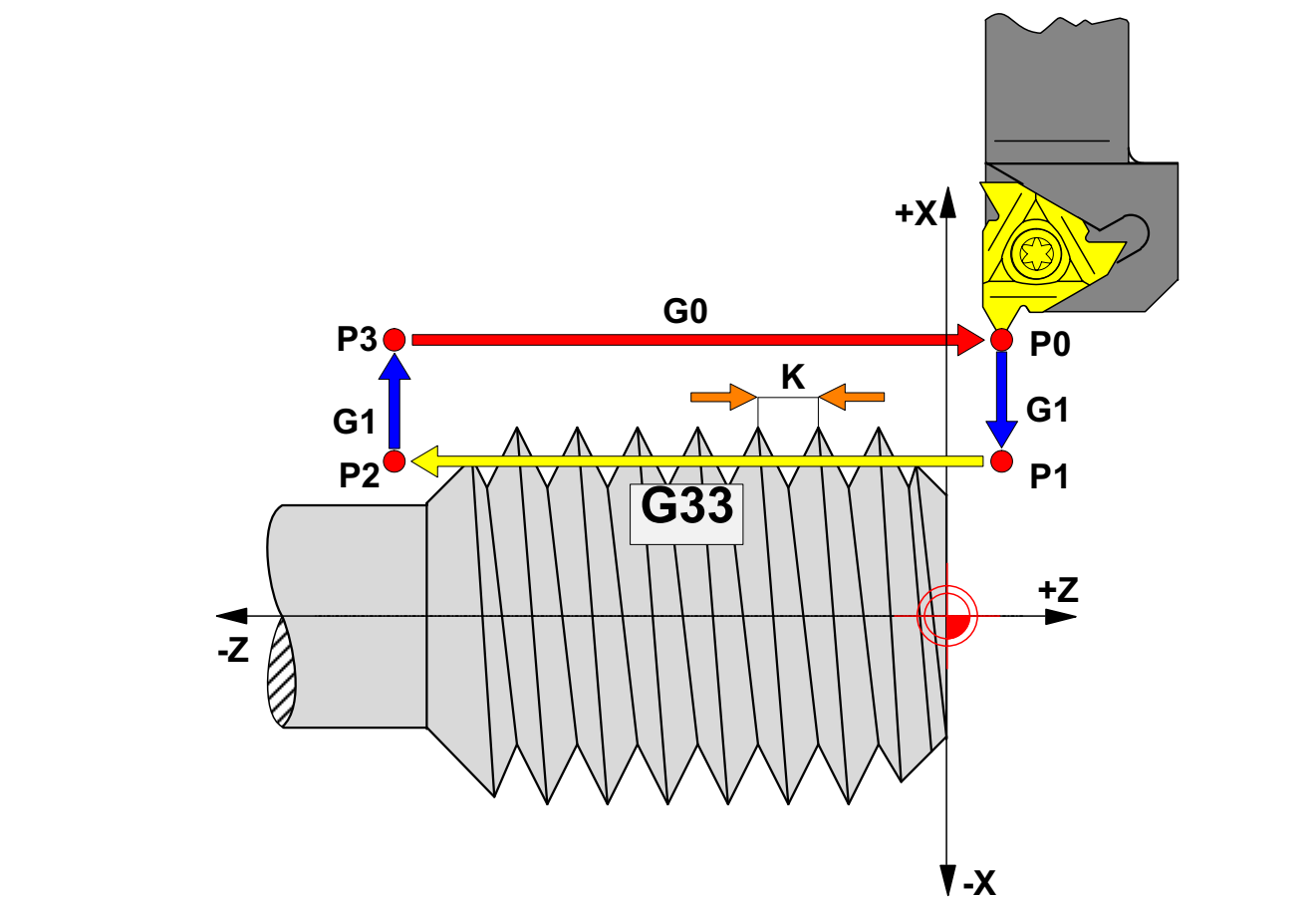


N0042 G1 X... Z... CHF=... LF

N0043 G1 X... Z... LF

N0042 G1 X... Z... CHR=... LF

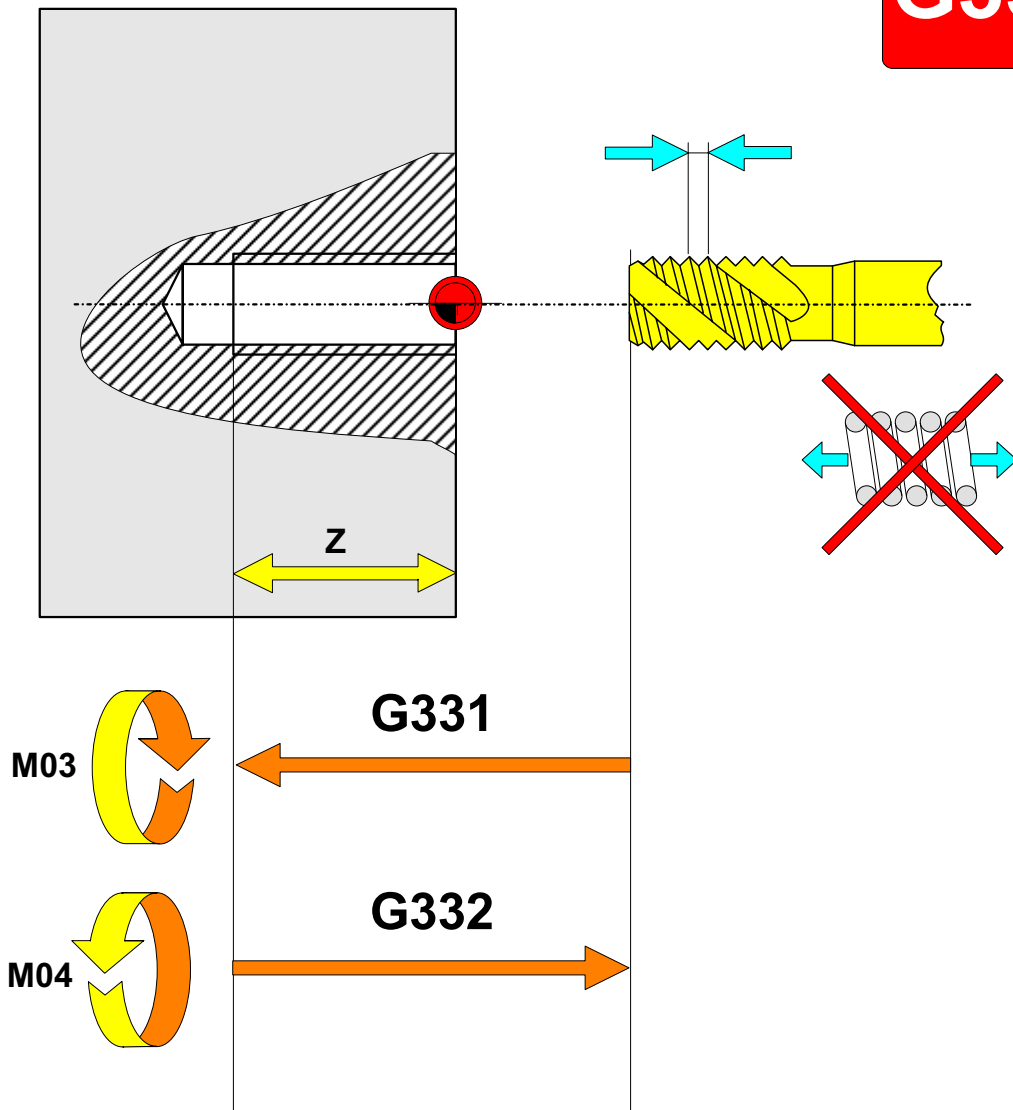
N0043 G1 X... Z... LF



N1234 G33 X... Z... K.. LF

G331

G332



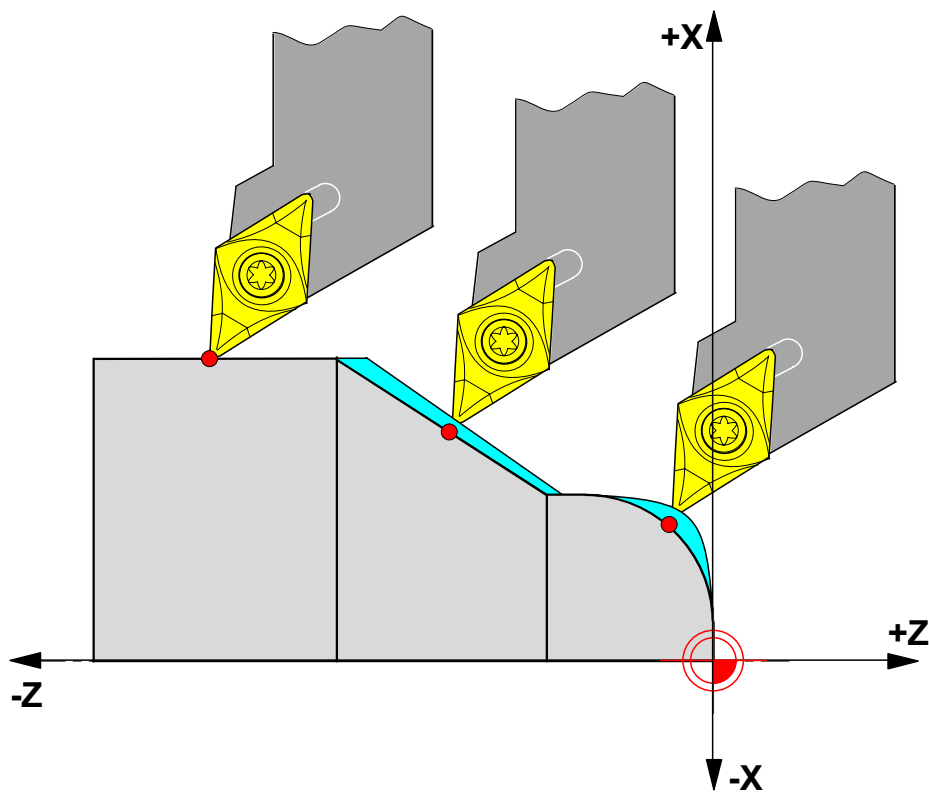
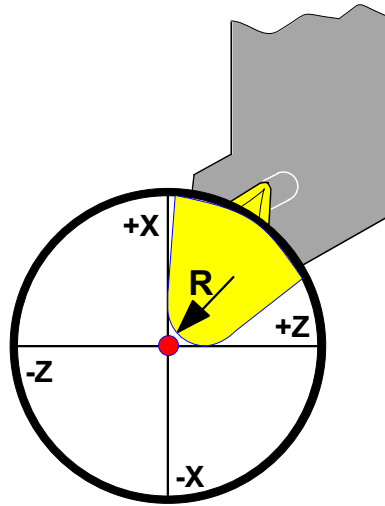
N0095 SPOS=...(°) LF

N0100 G331 X... Z... K... M03 LF

N0105 G332 X... Z... K... LF

G41

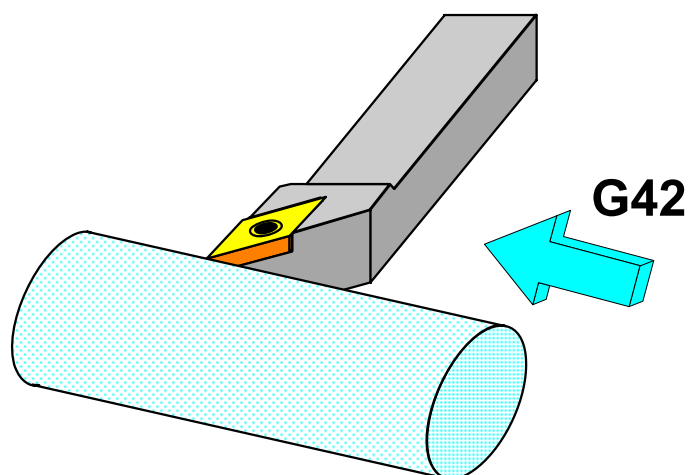
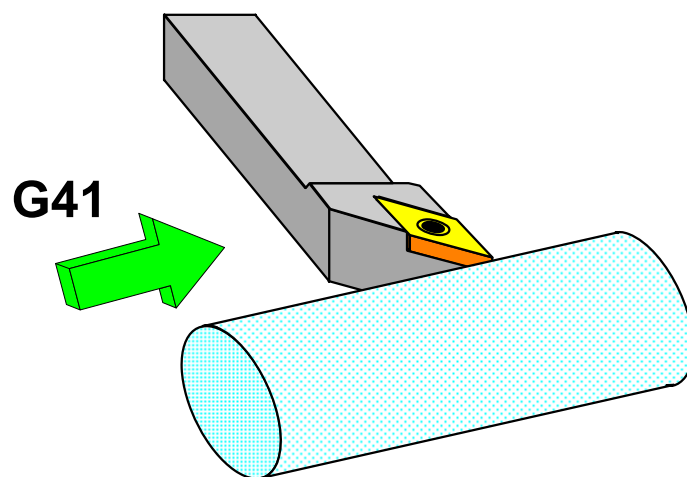
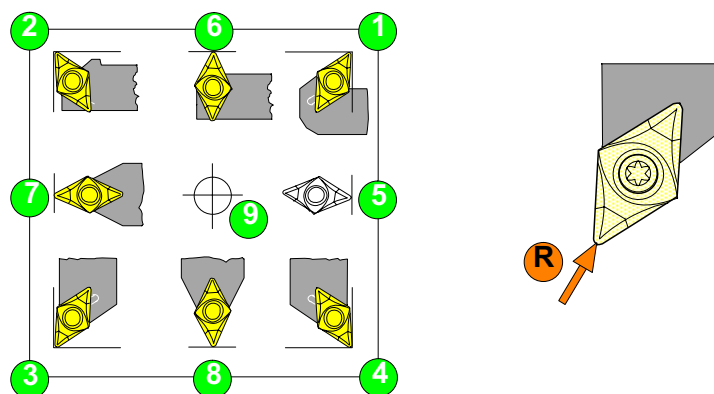
G42



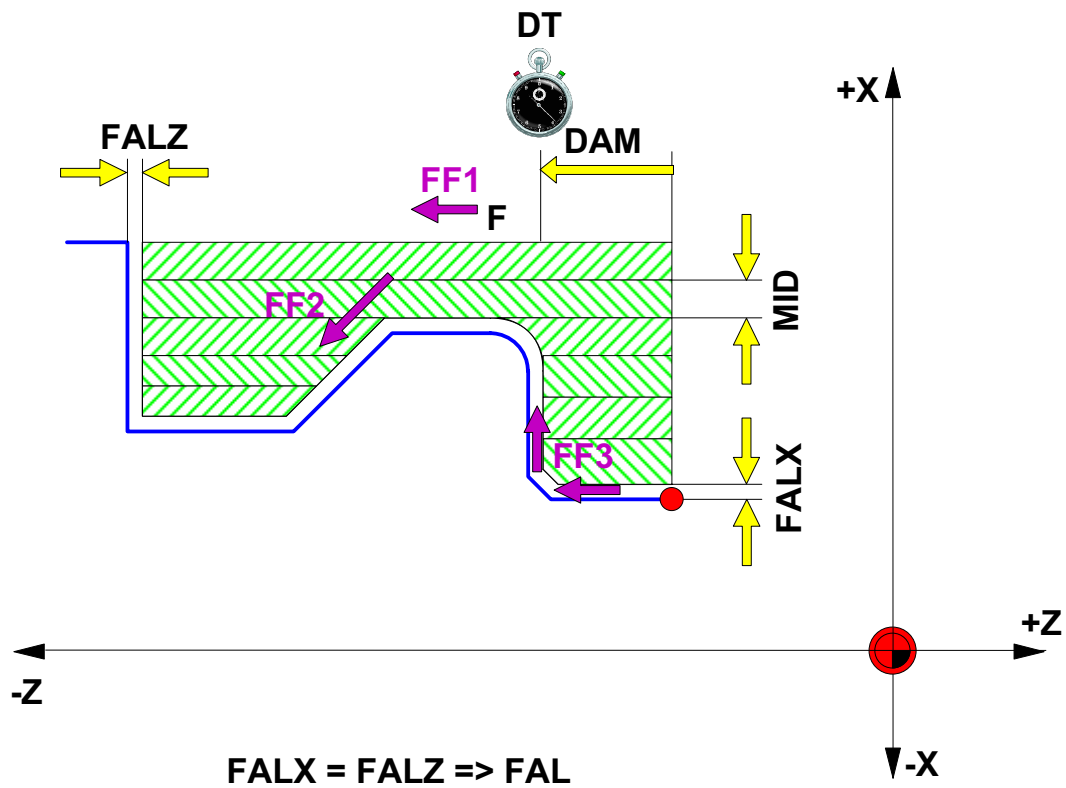
G41

G42

G40



CYCLE 95

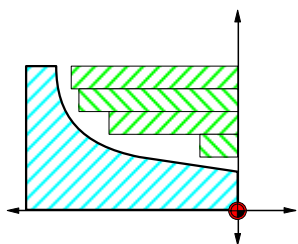


N0100 CYCLE95 (NPP,MID,FALZ,FALX,FAL,FF1,FF2,FF3,VARI,DT,DAM)

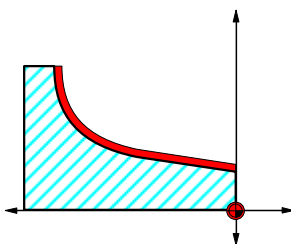
NPP	KONTUR1
MID	mm
FALZ	mm
FALX	mm
FAL	mm
FF1	mm/min, mm/U
FF2	mm/min, mm/U
FF3	mm/min, mm/U
VARI	1-12
DT	sec
DAM	mm

CYCLE 95

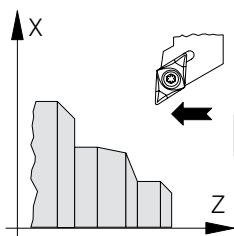
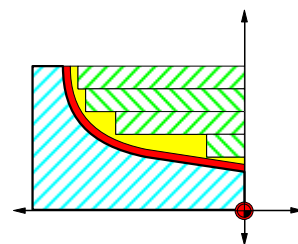
VARI 1 - 4



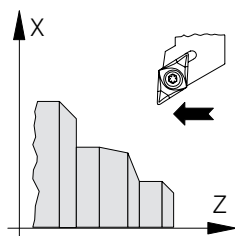
VARI 5 - 8



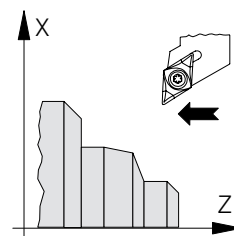
VARI 9 - 12



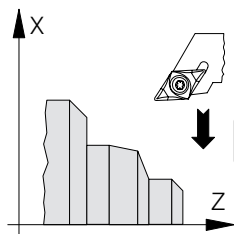
VARI=1



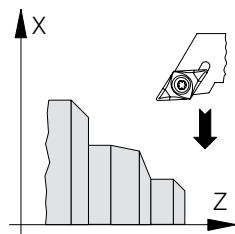
VARI=5



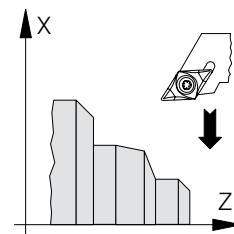
VARI=9



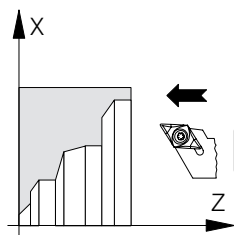
VARI=2



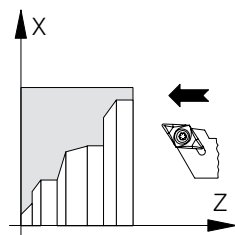
VARI=6



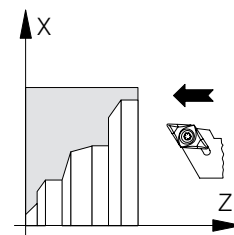
VARI=10



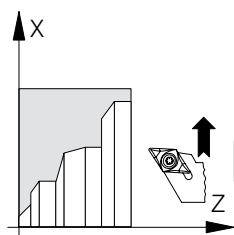
VARI=3



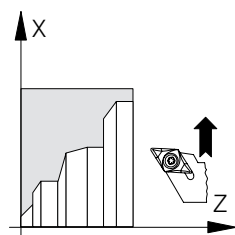
VARI=7



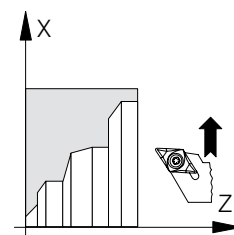
VARI=11



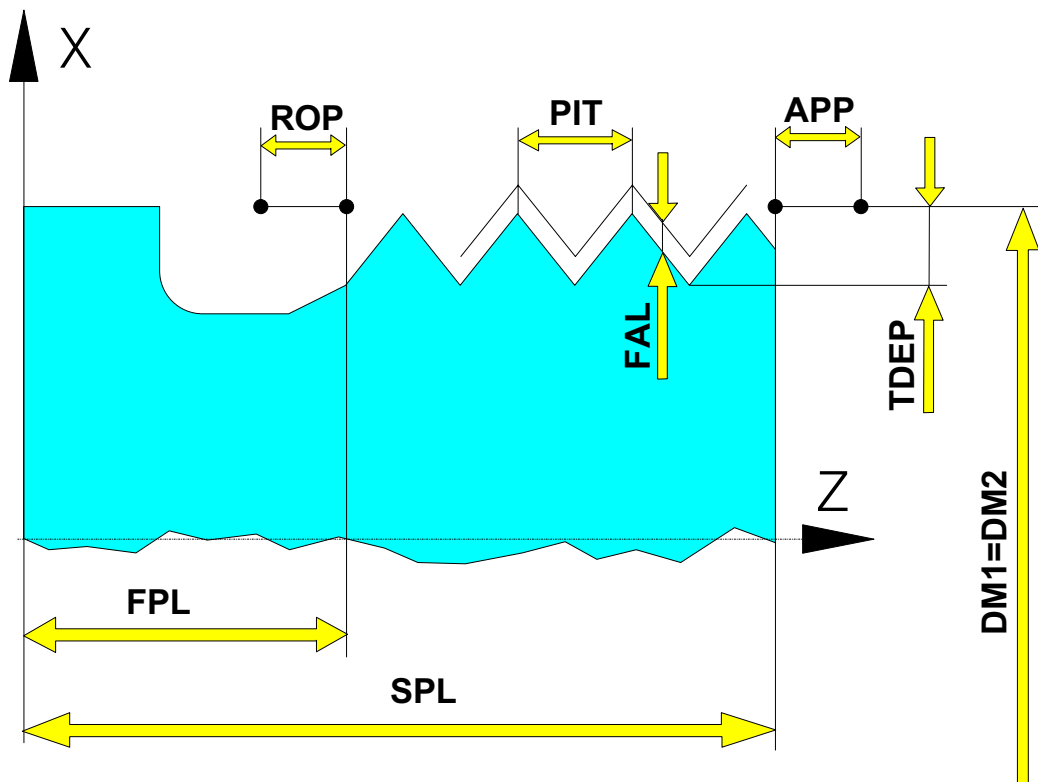
VARI=4



VARI=8

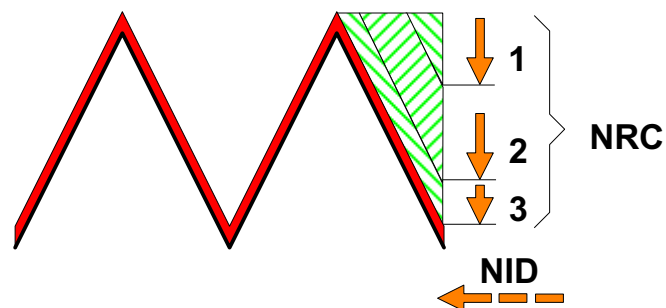
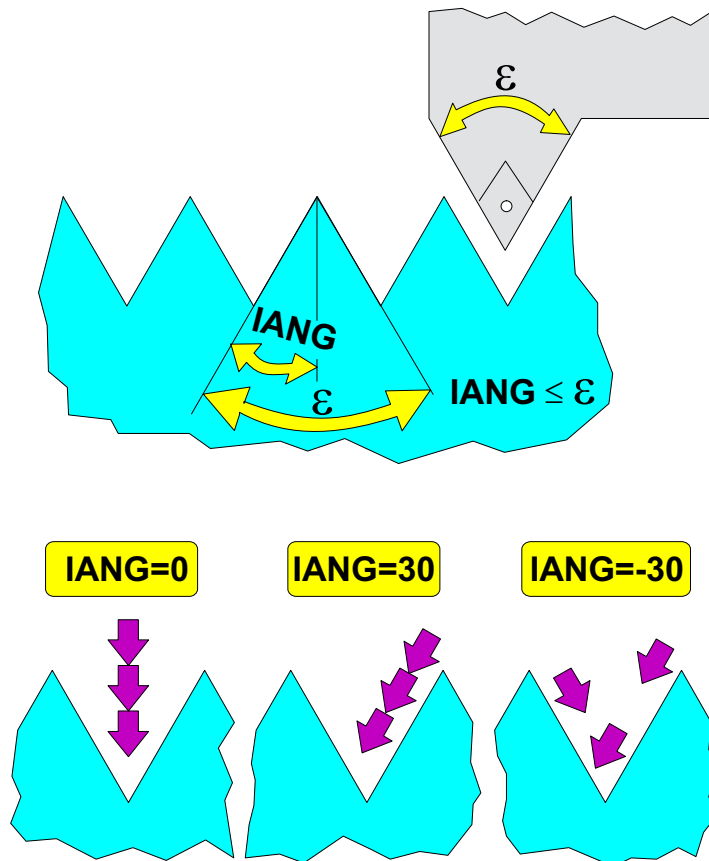


VARI=12

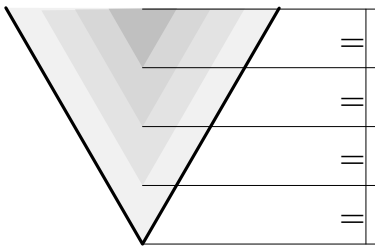
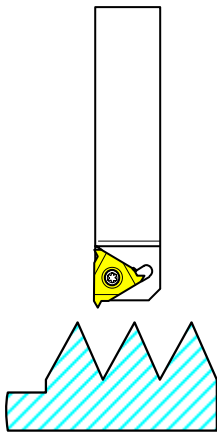
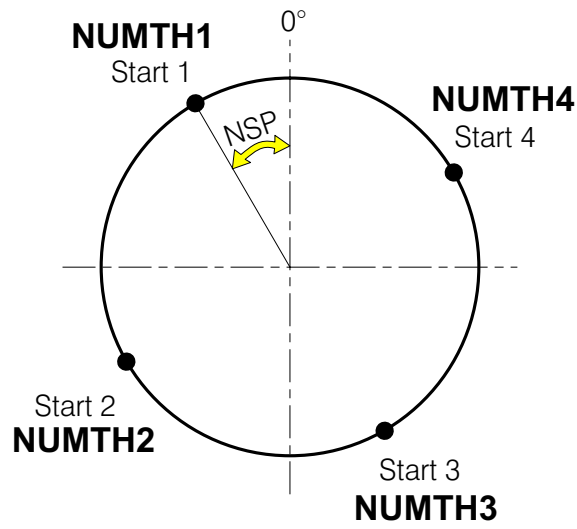


**N0100 CYCLE97 (PIT,MPIT,SPL,FPL,DM1,DM2,APP,ROP,TDEP,
FAL,IANG,NSP,NRC,NID,VARI,NUMTH)**

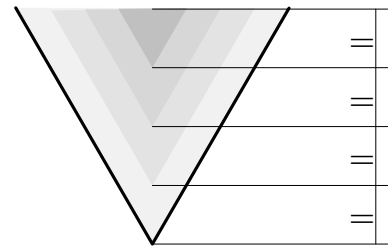
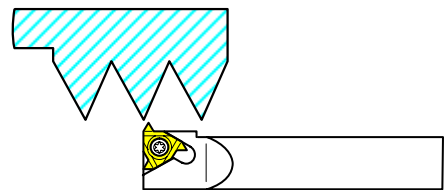
CYCLE 97



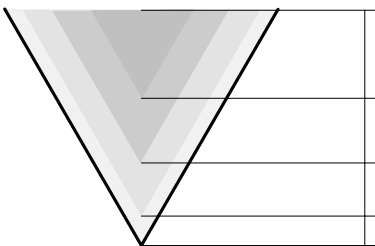
CYCLE 97



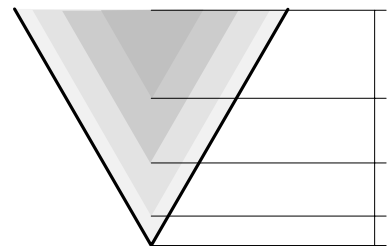
VARI = 1



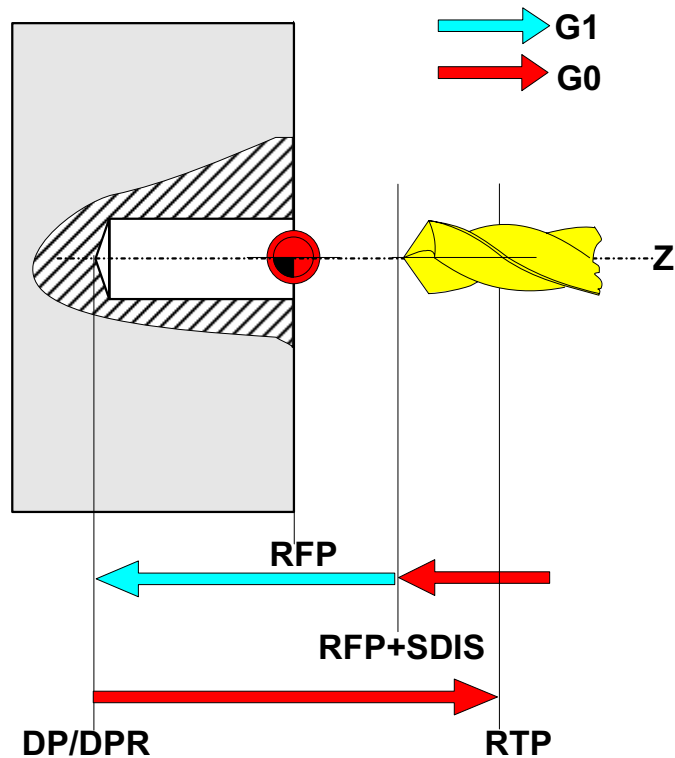
VARI = 2



VARI = 3

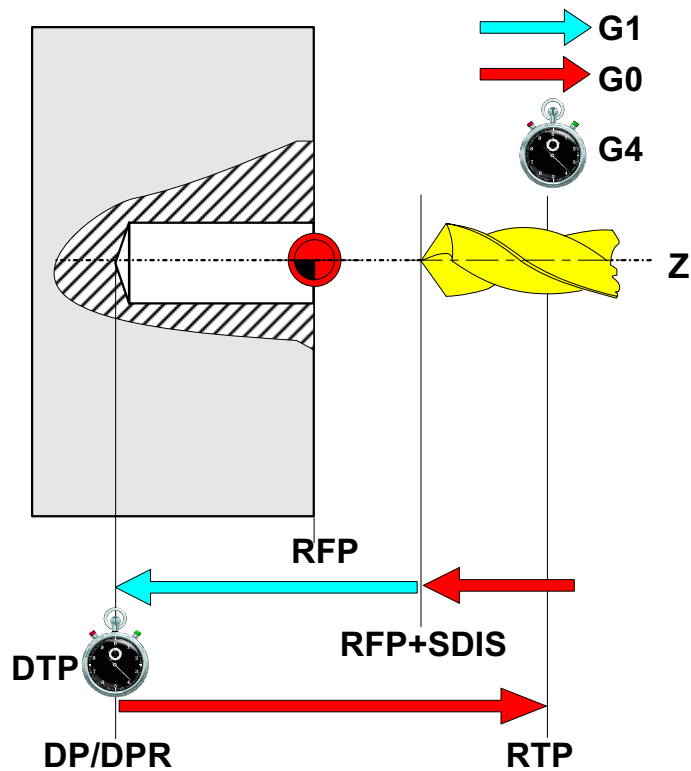


VARI = 4



CYCLE 81

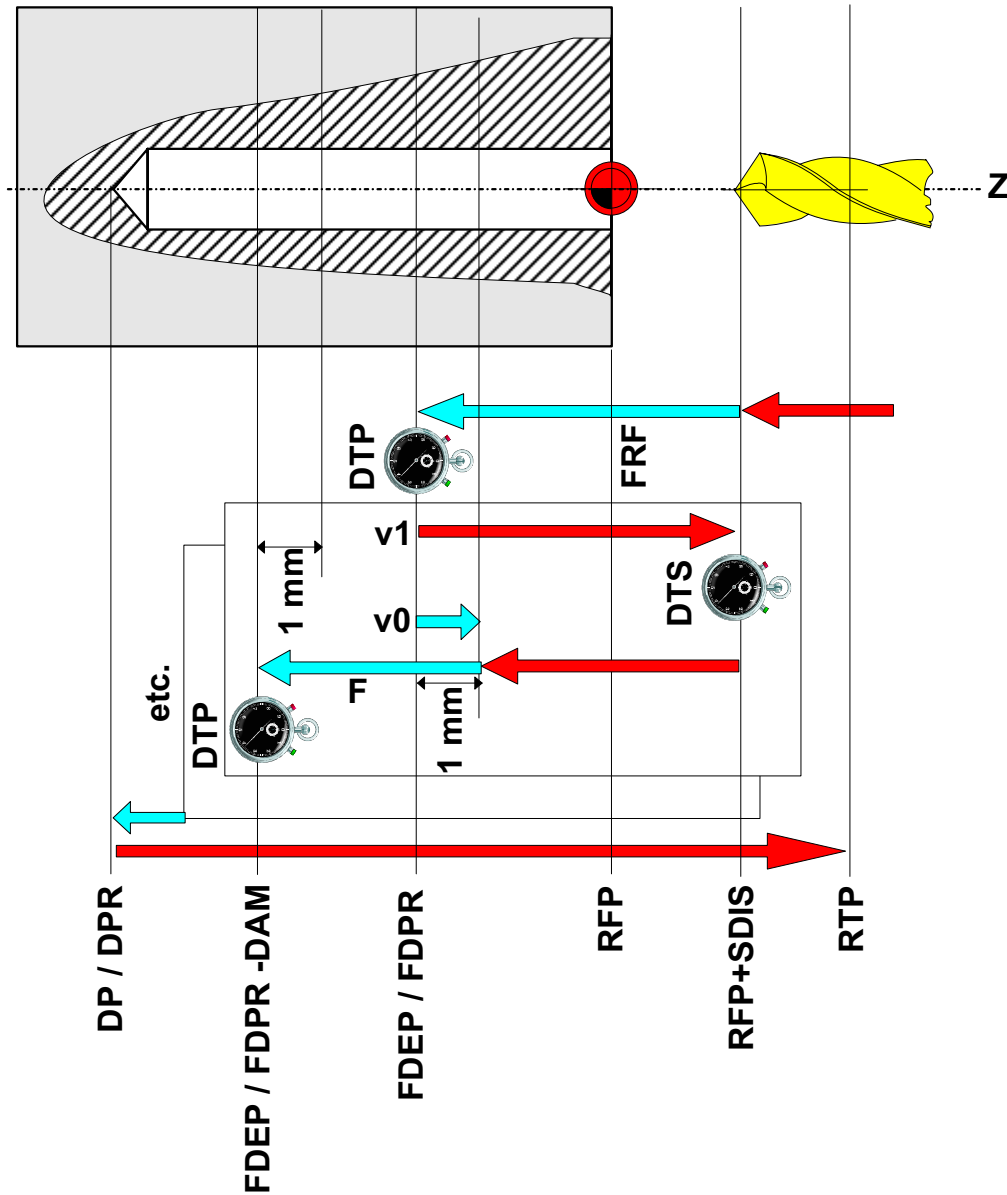
N100 CYCLE 81 (RTP, RFP, SDIS, DP, DPR)



CYCLE 82

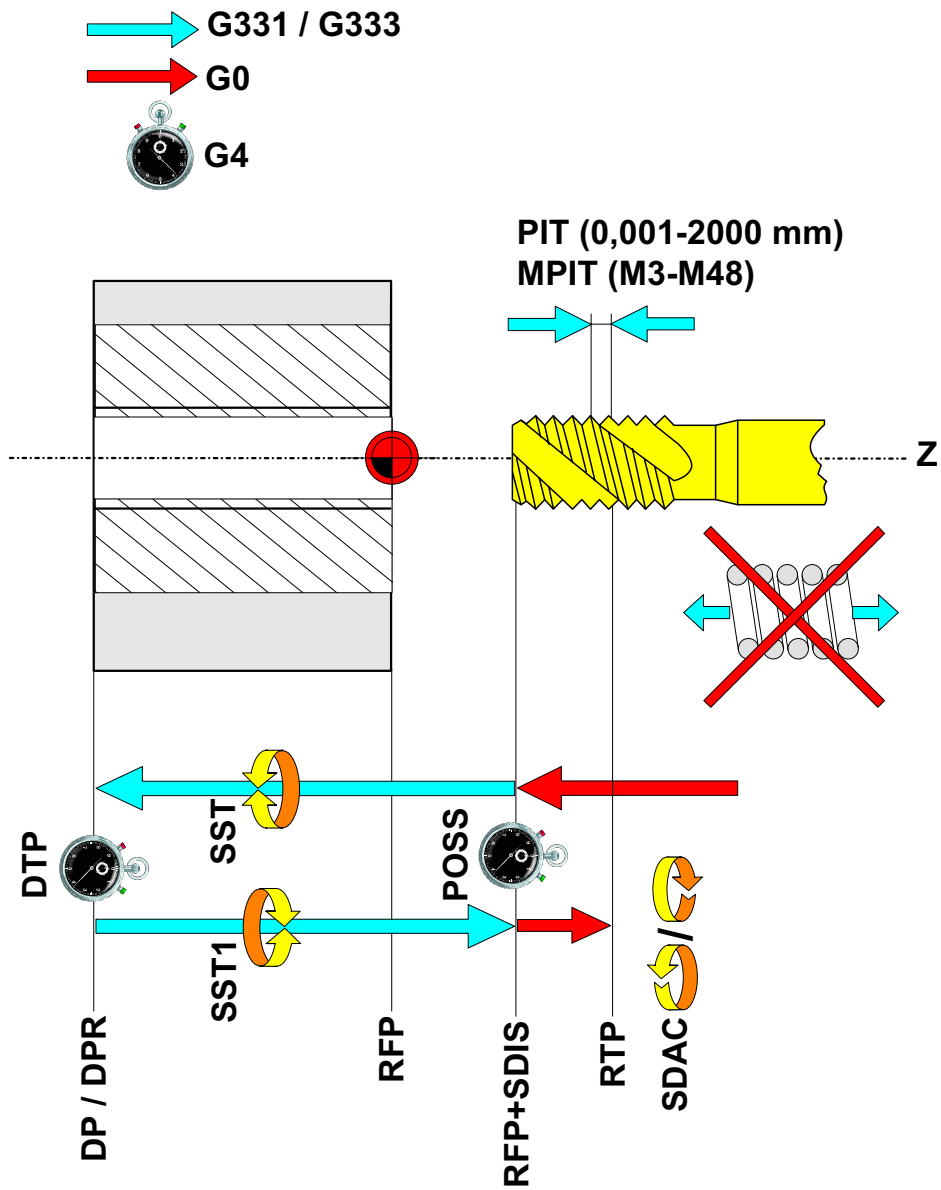
N100 CYCLE 82 (RTP, RFP, SDIS, DP, DPR, DTP)

CYCLE83



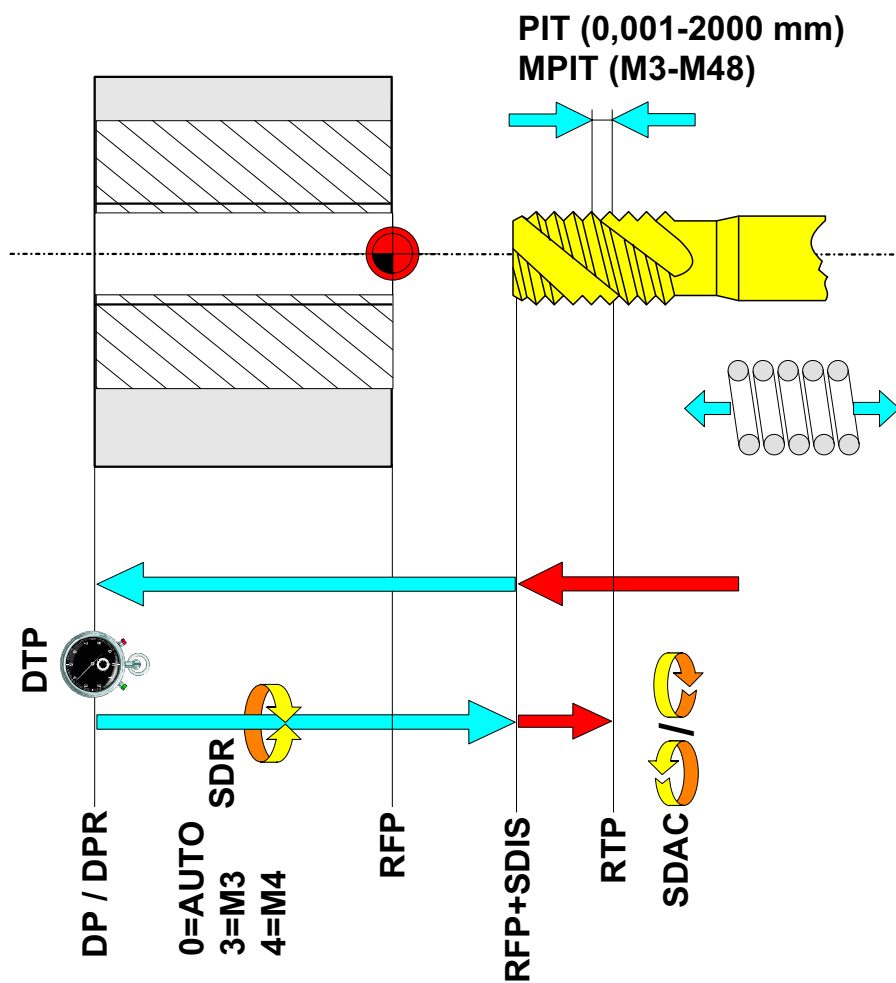
N 100 CYCLE83 (RTP,RFP,SDIS,DP,DPR,FDEP,FDPR,DAM,DTP,DTS,FRF,VARI)

CYCLE84



N0100 CYCLE 84 (RTP,RFP,SDIS,DP,DPR,DTP,SDAC,MPIT,PIT,POSS,SST,SST1)

CYCLE840



N0100 CYCLE 840 (RTP,RFP,SDIS,DP,DPR,DTP,SDR,SDAC,ENC,MPIT,PIT)

Sous Programme SUB

