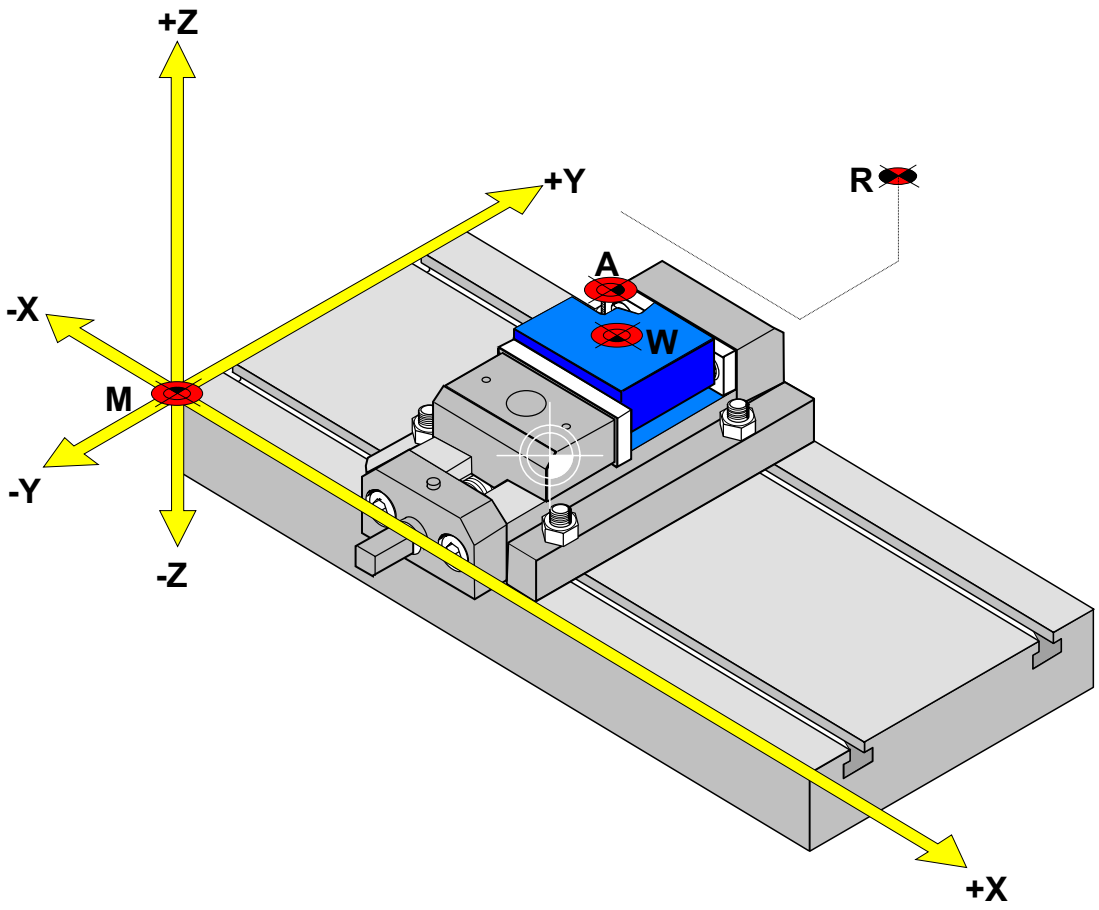
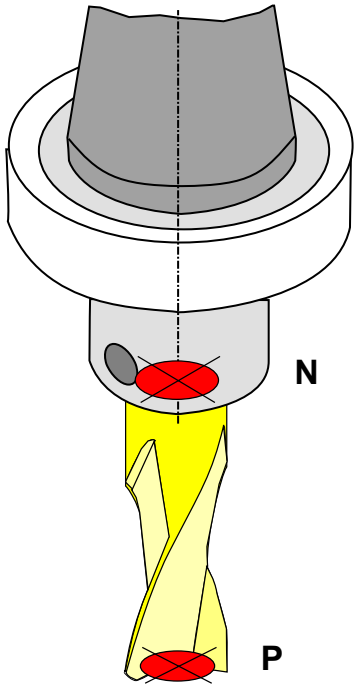
RAPPEL
CNC/FRAISAGE

SINUMERIK 810D / 840D-M


+Z
+Y
R
A
W
-X
M
-Y
-Z
+X


N
P

M

A

W

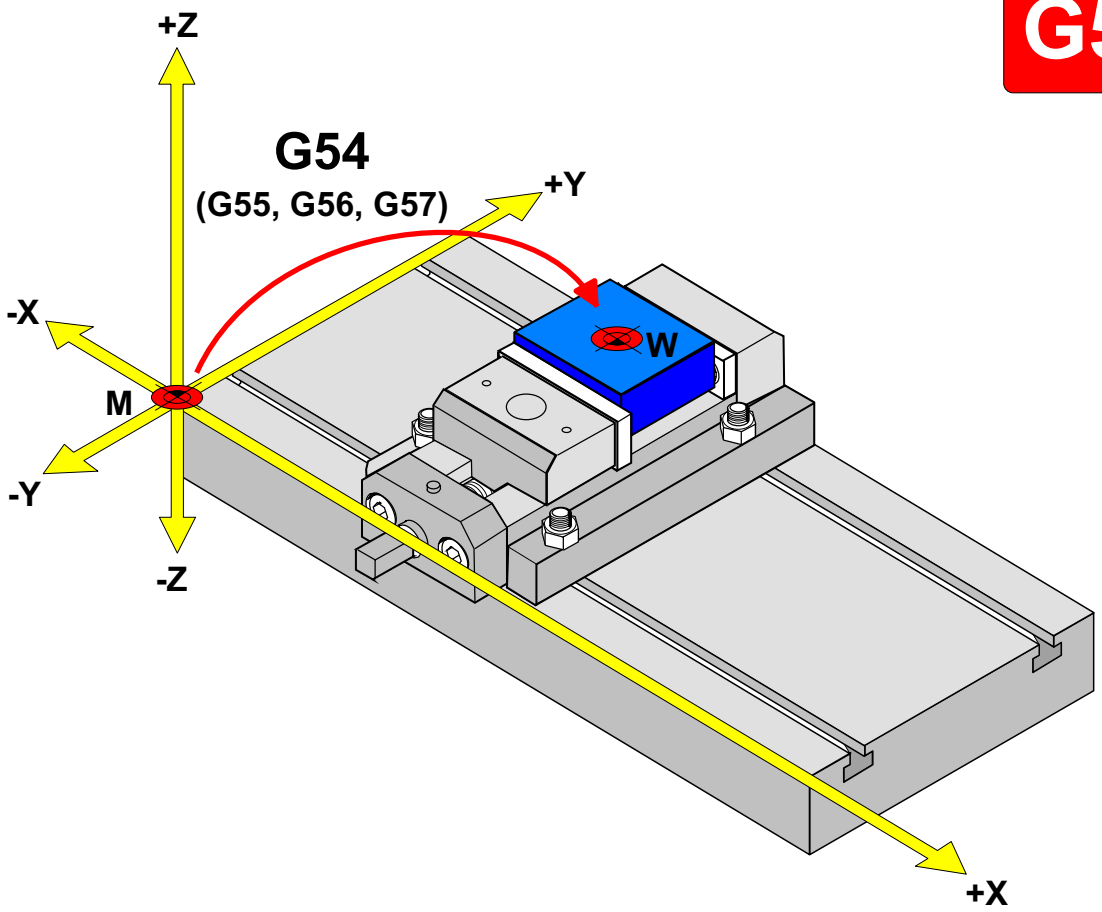
R

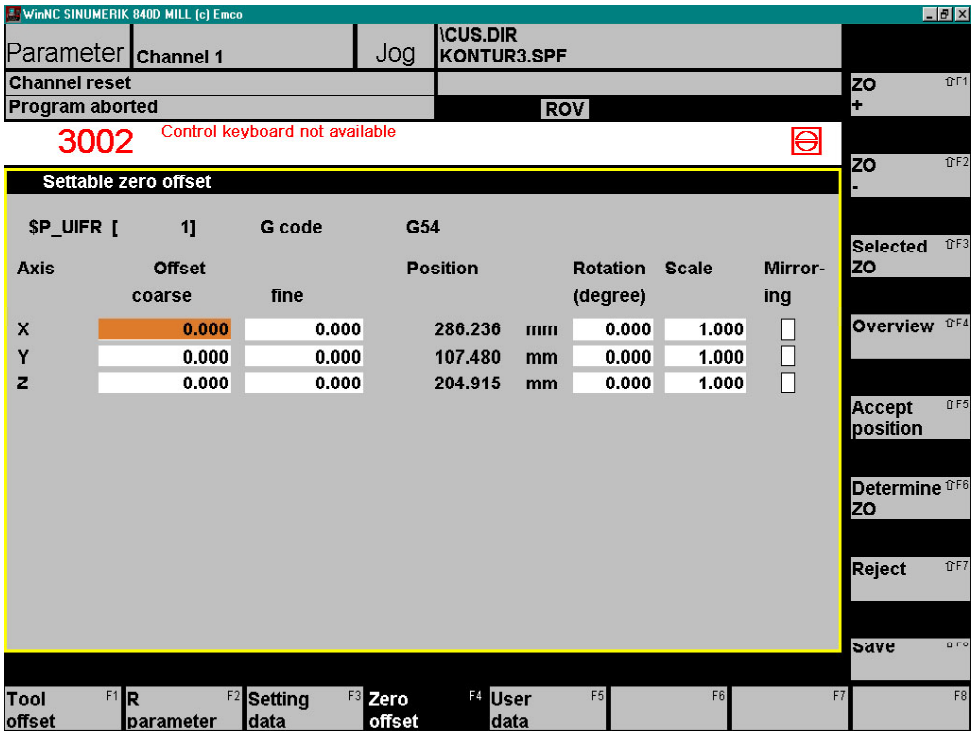
T

N

P

G54

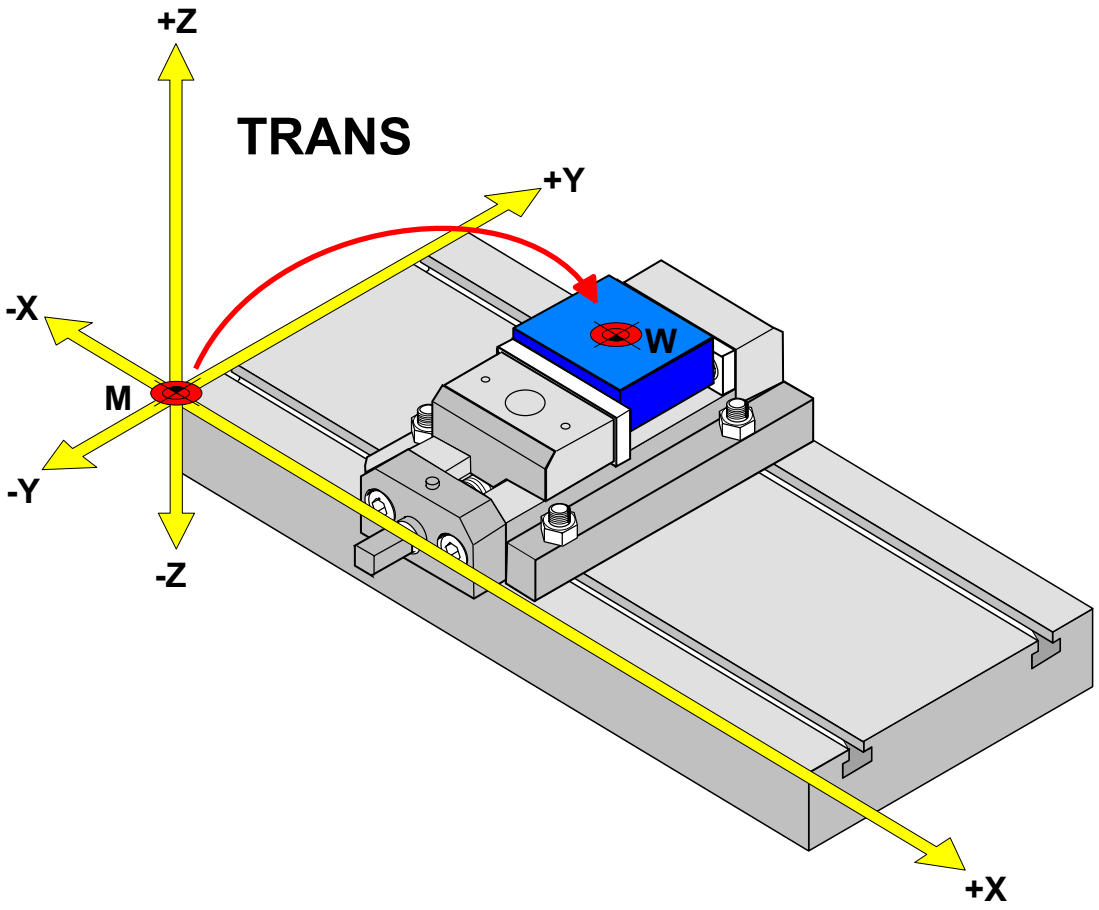




N0005 G54 LF

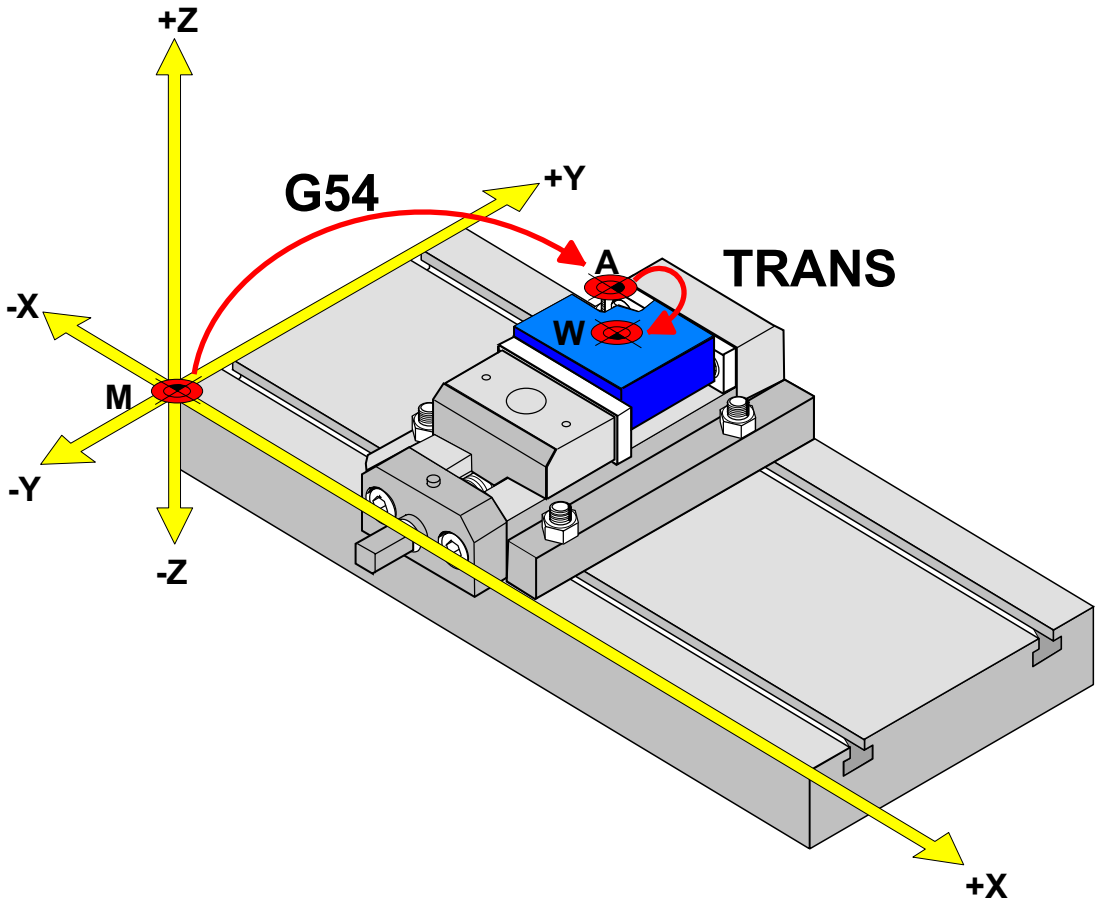
TRANS

ATRANS

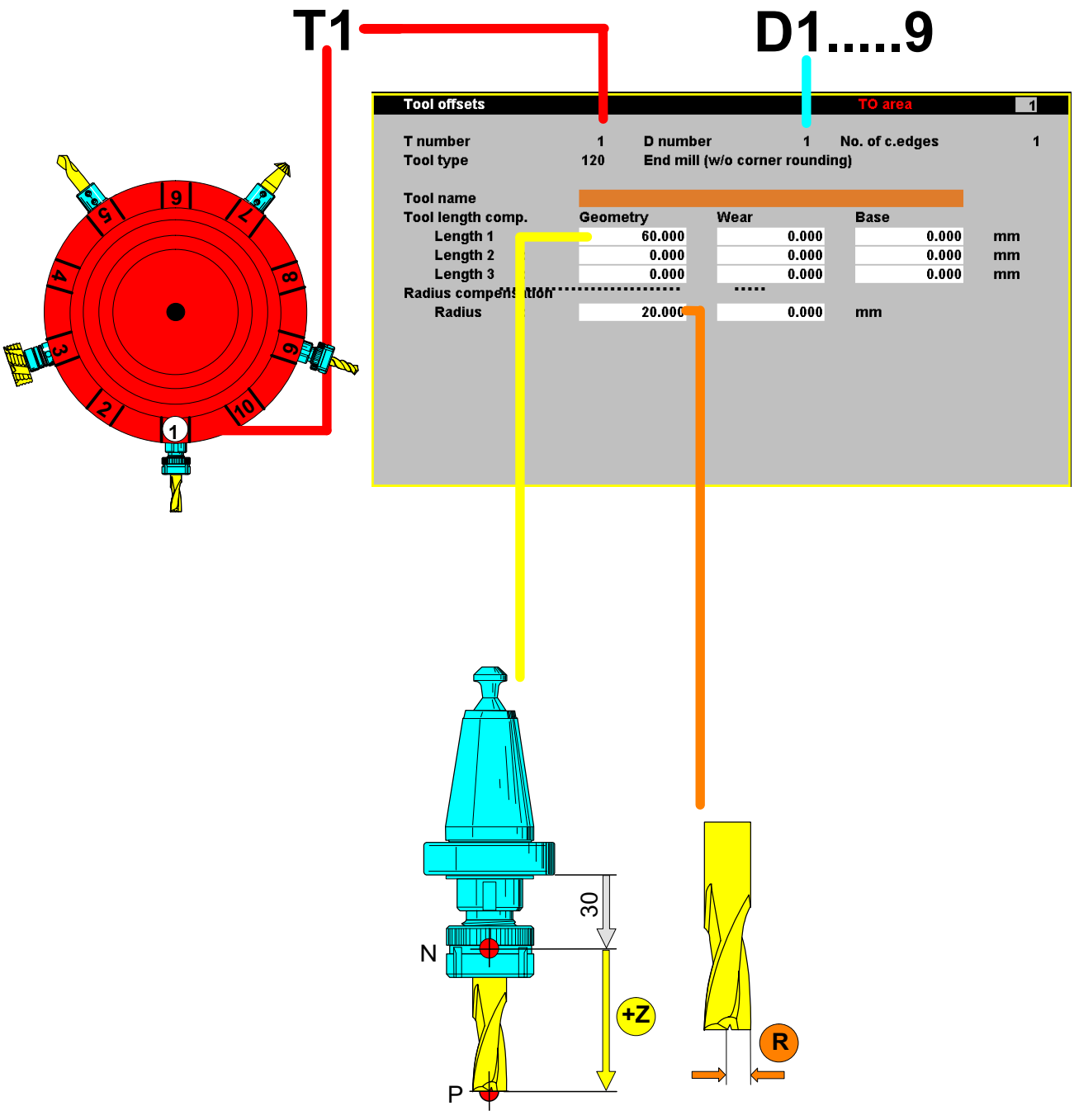


N0005 TRANS X... Y... Z... LF

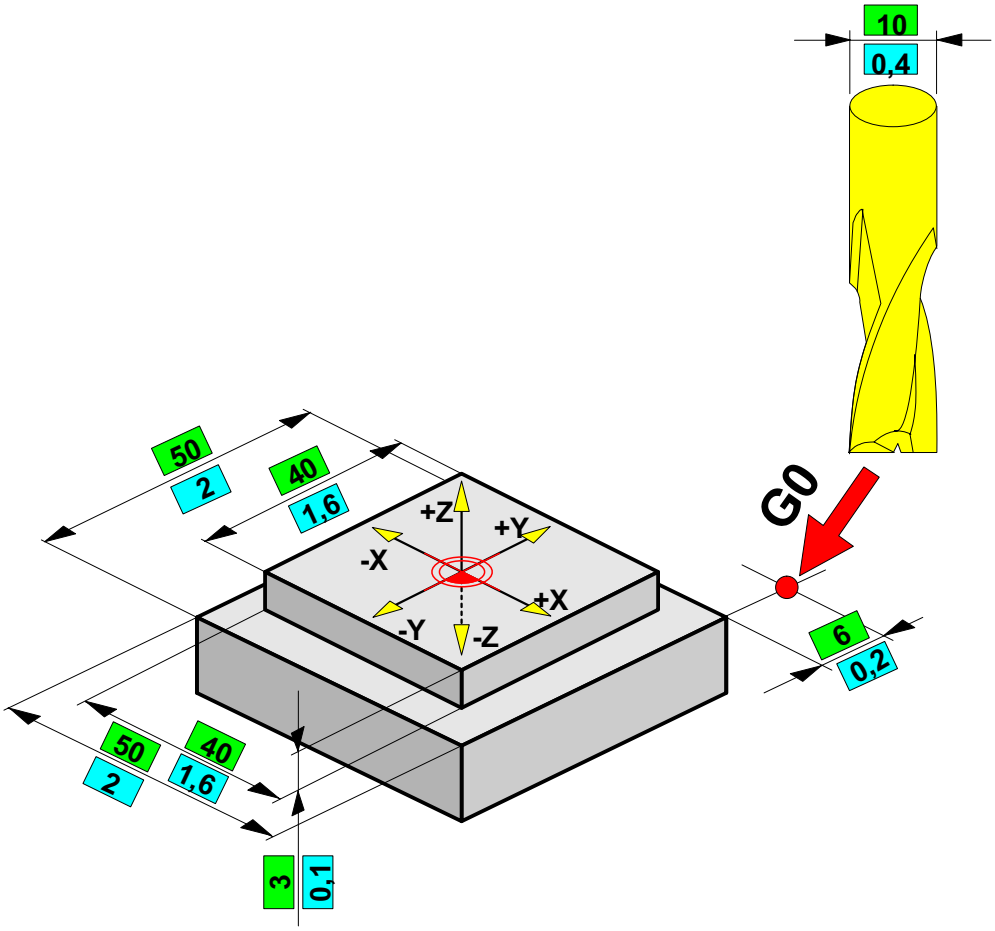
G54 + TRANS




```
N0005  G54  LF

N0010  TRANS  X ...  Y ...  Z ...  LF
```

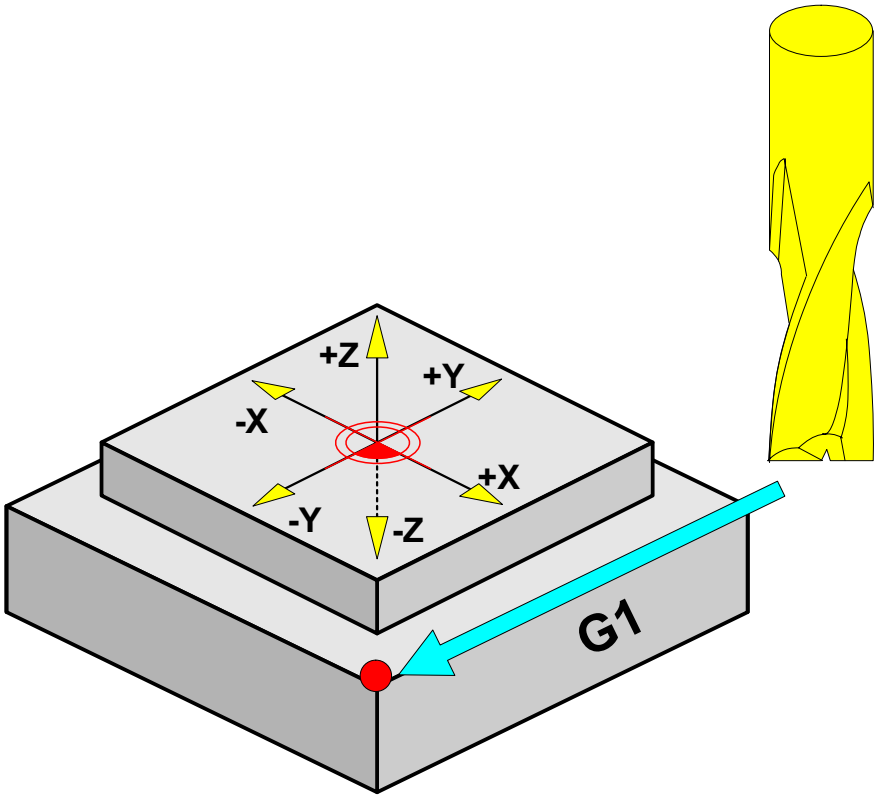

T1
D1.....9
Tool offsets
TO area
1
T number
1
D number
1
No. of c.edges
1
Tool type
120
End mill (w/o corner rounding)
Tool name
Tool length comp.
Geometry
Wear
Base
Length 1
60.000
0.000
0.000
mm
Length 2
0.000
0.000
0.000
mm
Length 3
0.000
0.000
0.000
mm
Radius compensation
Radius
20.000
0.000
mm
9
5
7
4
8
3
6
2
10
1
30
N
+Z
P
R

G0



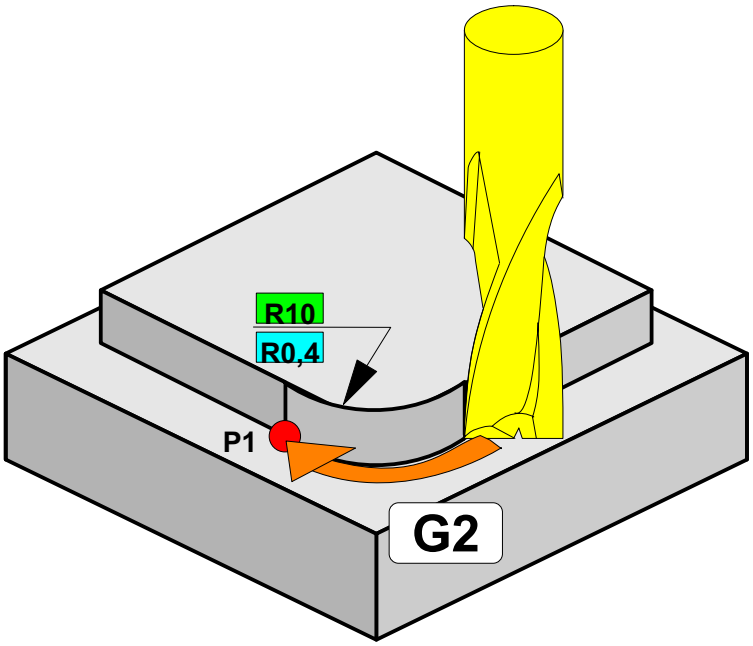
N1234 G0 X25 Y31 Z-3 LF mm

G1



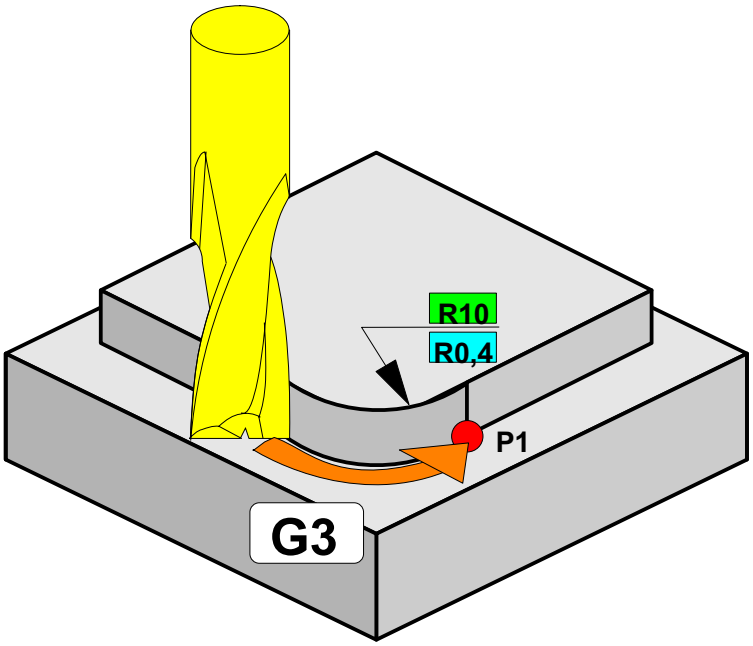
N1234 G1 X25 Y-25 LF mm

G2



N1234 G2 X... Y... CR=10 LF mm

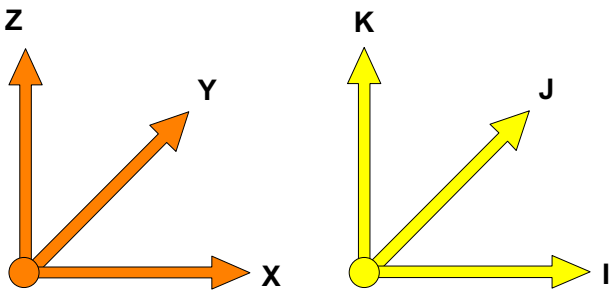
G3

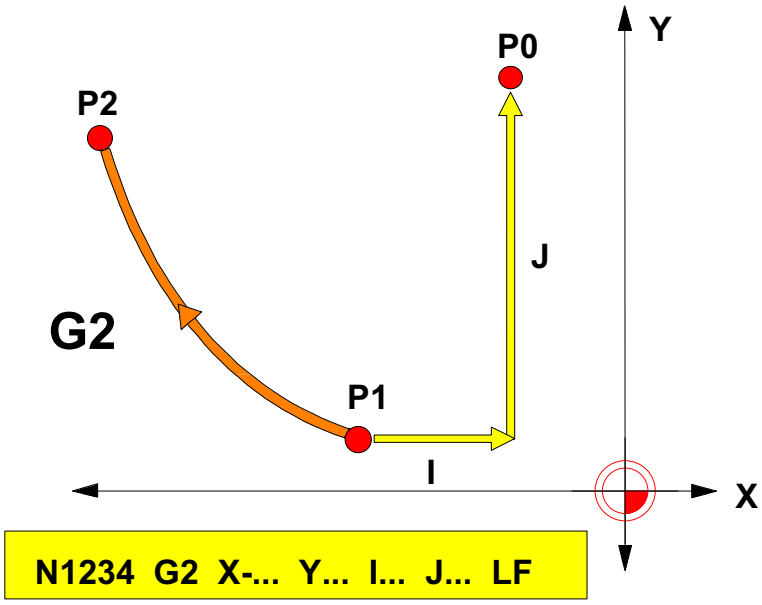


N1234 G3 X... Y... CR=10 LF mm

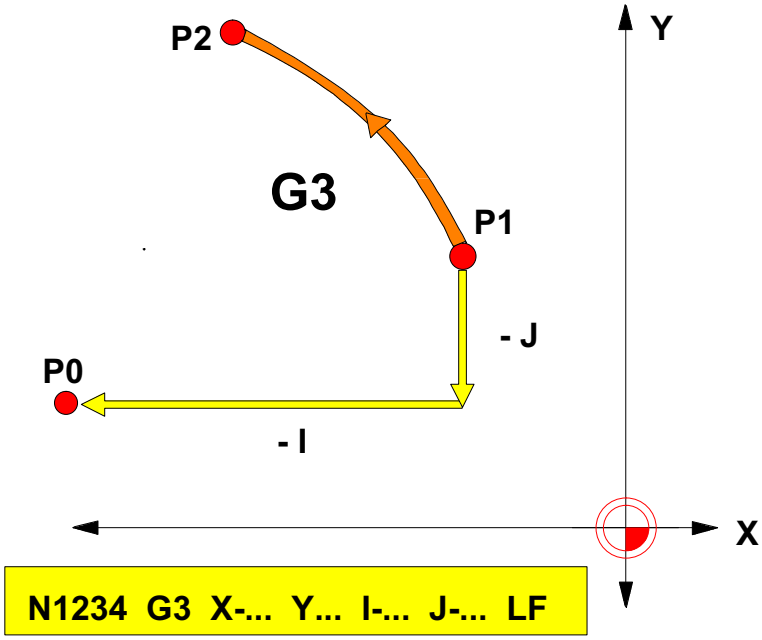
G2

G3



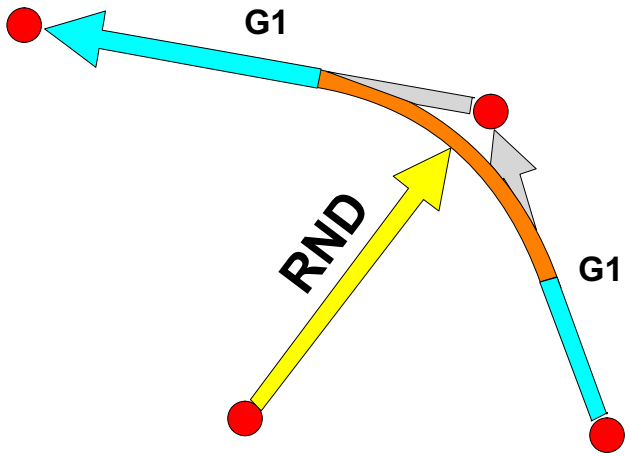


N1234 G2 X-... Y... I... J... LF



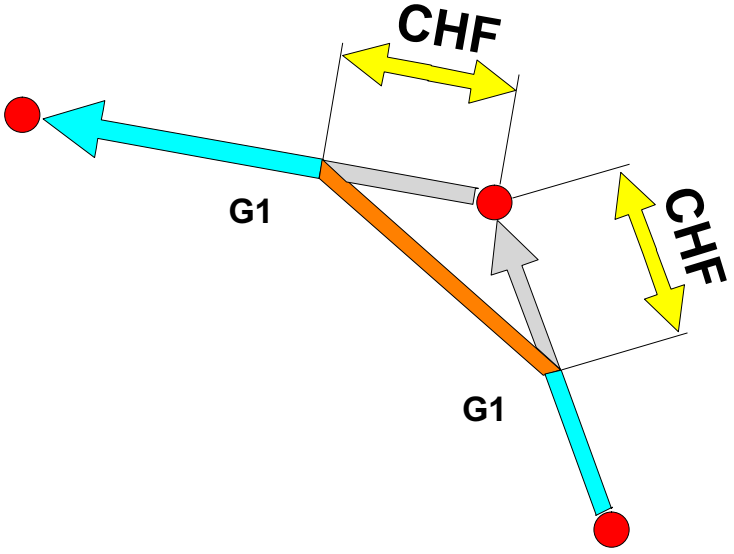
N1234 G3 X-... Y... I-... J-... LF

RND



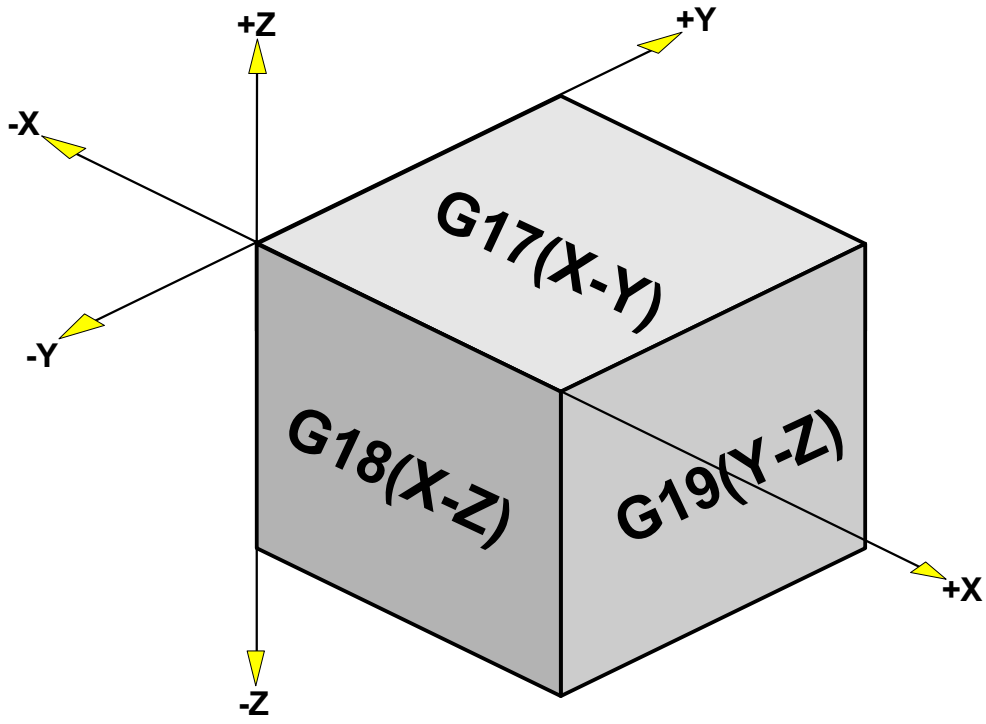

```
N0042  G1  X...  Y...  RND=...  LF
N0043  G1  X...  Y...  LF
```

CHF

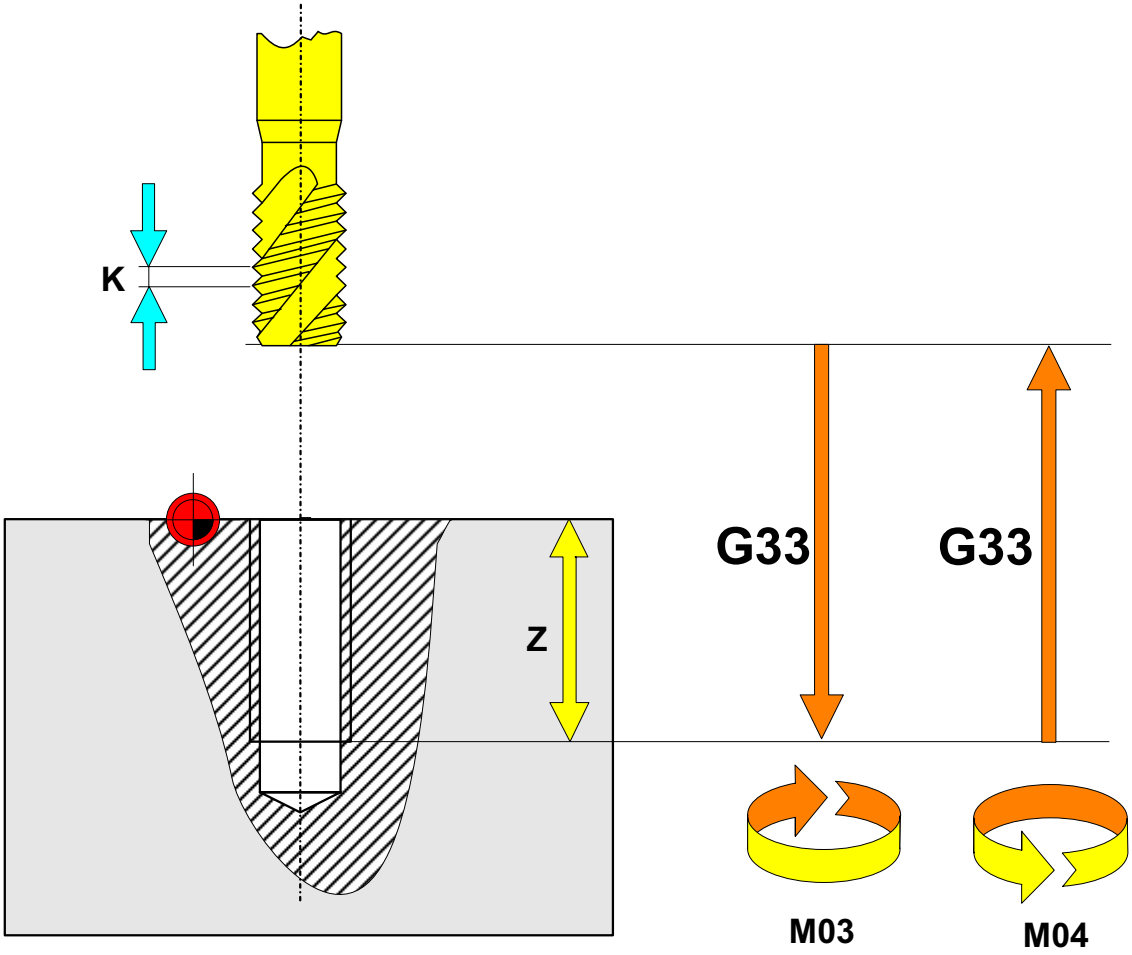



```
N0042  G1  X...  Y...  CHF=...  LF
N0043  G1  X...  Y...  LF
```

G17
G18
G19



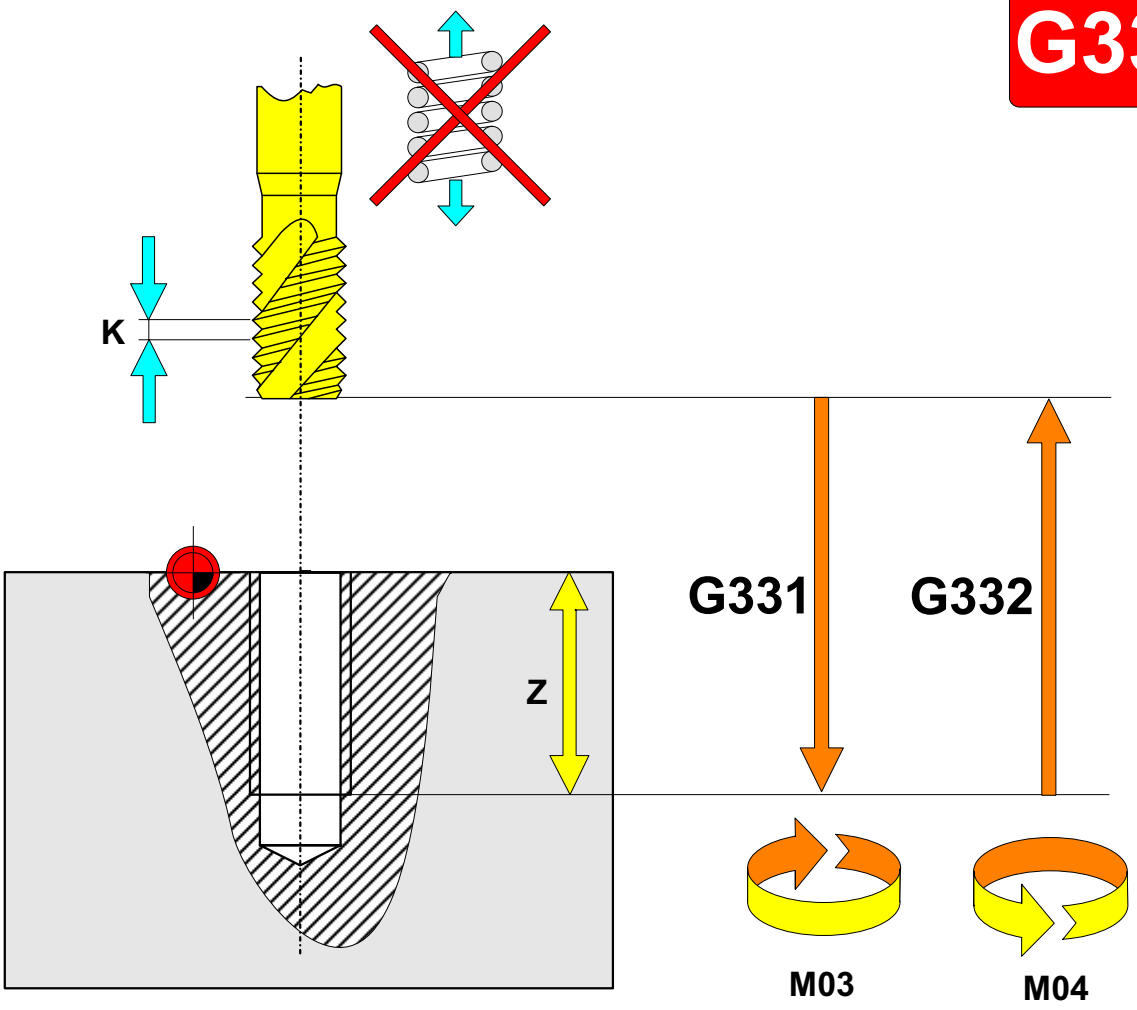
G33



N0100 G33 Z-... K... M03 LF

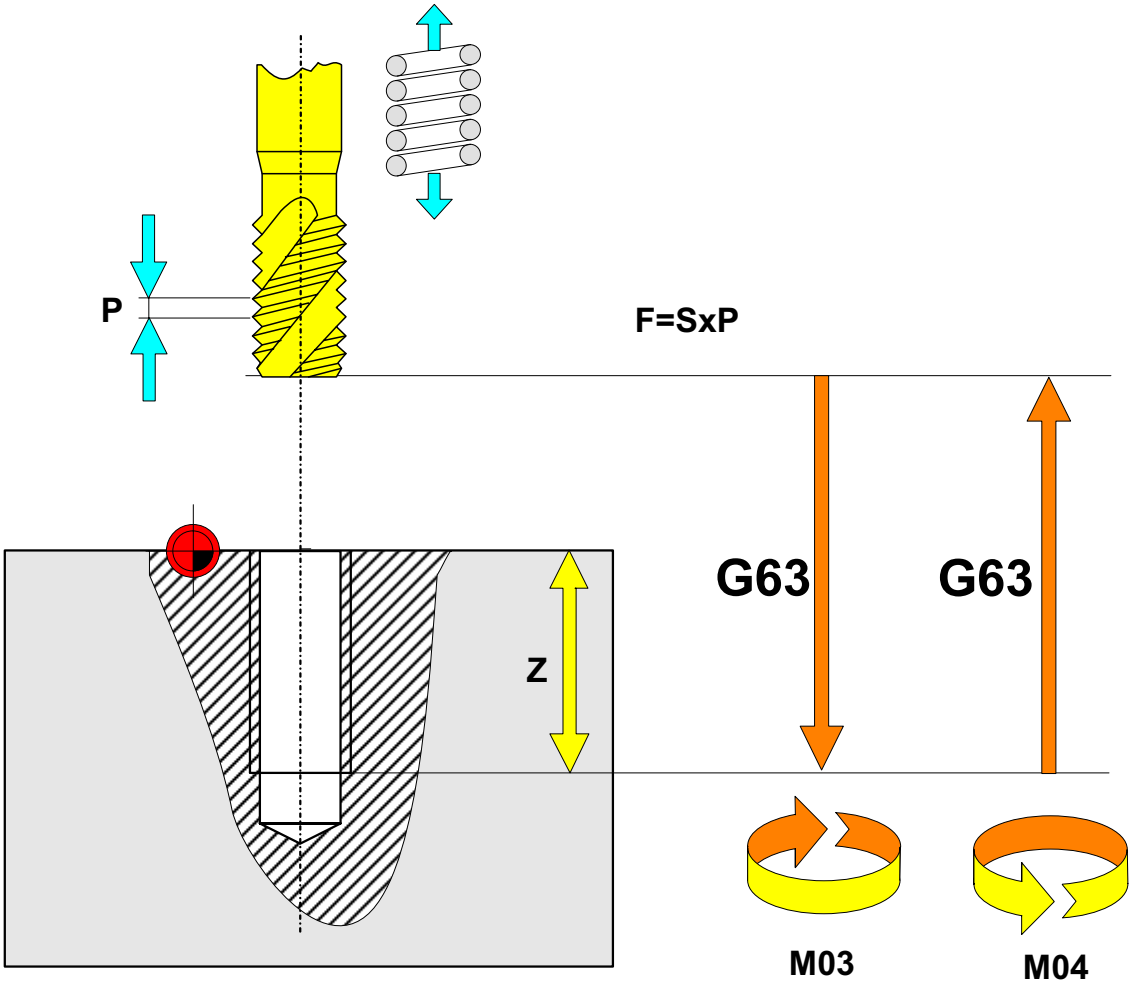
N0105 G33 Z... K... M04 LF

G331
G332




```
N0095  SPOS=...(°) LF

N0100  G331  Z-...  K...  M03  LF

N0105  G332  Z...  K... LF
```

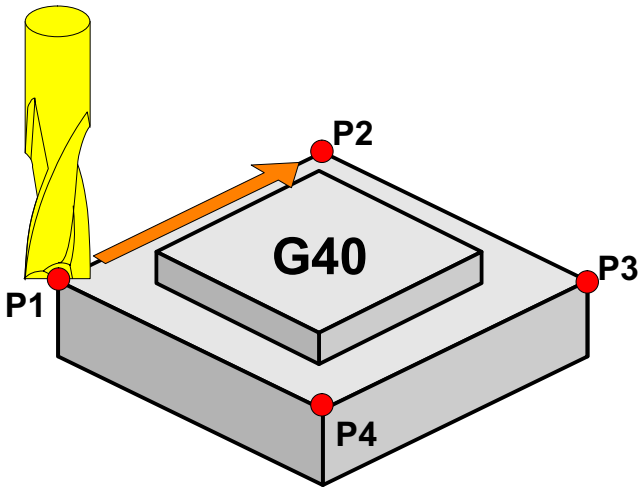
G63



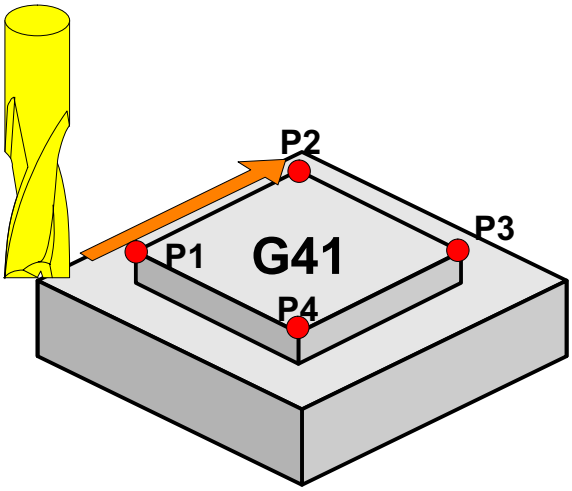

```
N0060  G63 Z-...  F...  M3  LF
```

```
N0065  G63 Z-...  F...  M4  LF
```

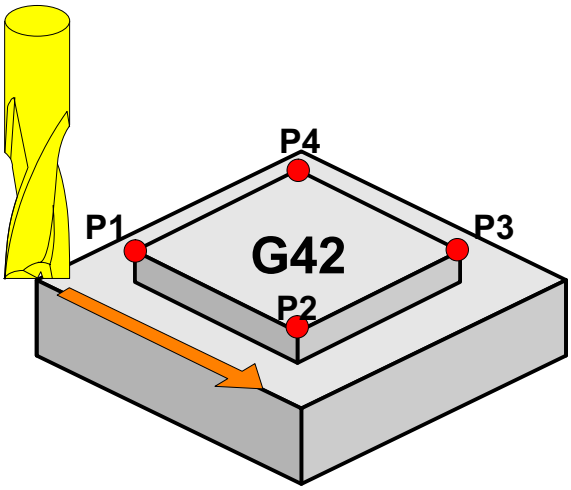
G40



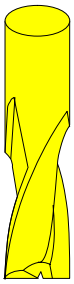
G41

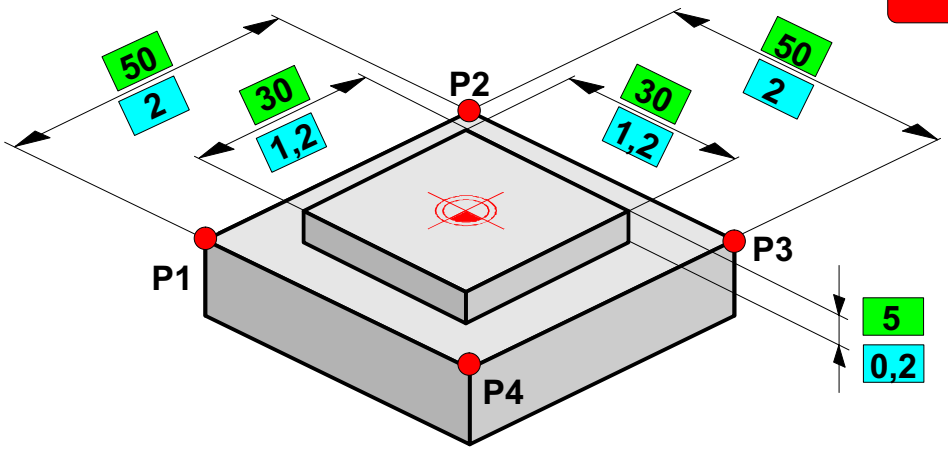


G42



G90





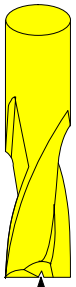

```
N0100  G1  X-25  Y-25  Z-5 LF
N0105  X-25  Y25  LF
N0110  X25  Y25  LF
N0115  X25  Y-25  LF
N0120  X-25  Y-25  LF
```

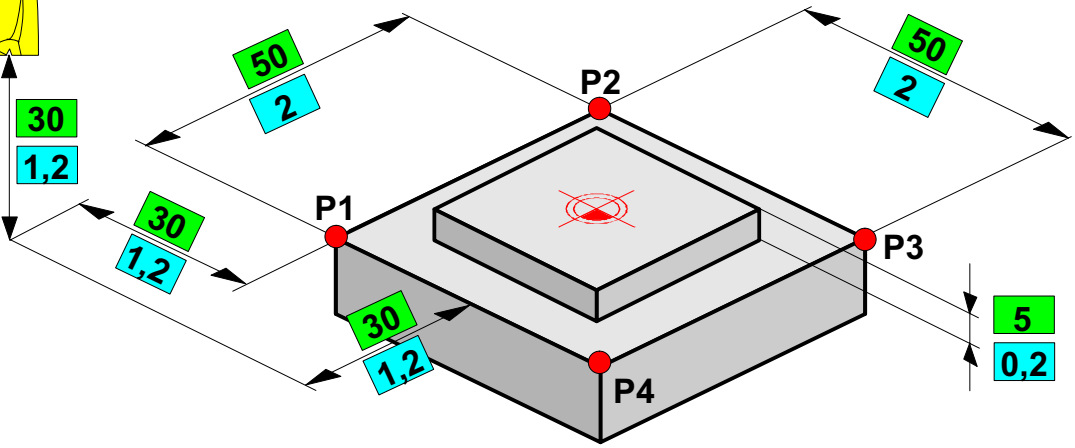
mm

```
N0100  G1  X-1  Y-1  Z-0.2 LF
N0105  X-1  Y1  LF
N0110  X1  Y1  LF
N0115  X1  Y-1  LF
N0120  X-1  Y-1  LF
```

Inch

G91






```
N0100  G1  X30  Y30  Z-30  LF
N0105  X0  Y50  LF
N0110  X50  Y0  LF
N0115  X0  Y-50  LF
N0120  X-50  Y0  LF
```

mm

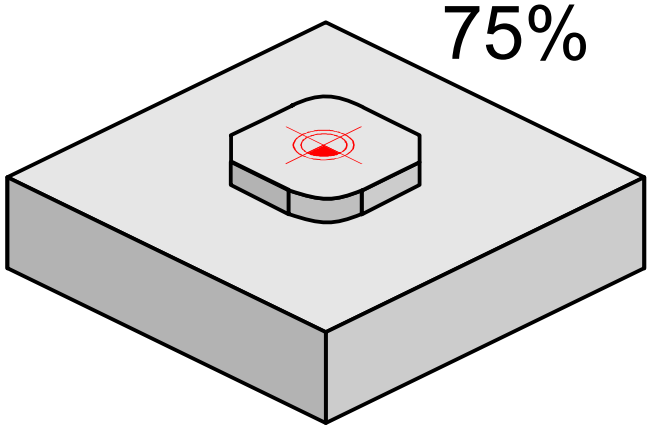
```
N0100  G1  X1.2  Y1.2  Z-1.2 LF
N0105  X0  Y2  LF
N0110  X2  Y0  LF
N0115  X0  Y-2  LF
N0120  X-2  Y0  LF
```

Inch

SCALE

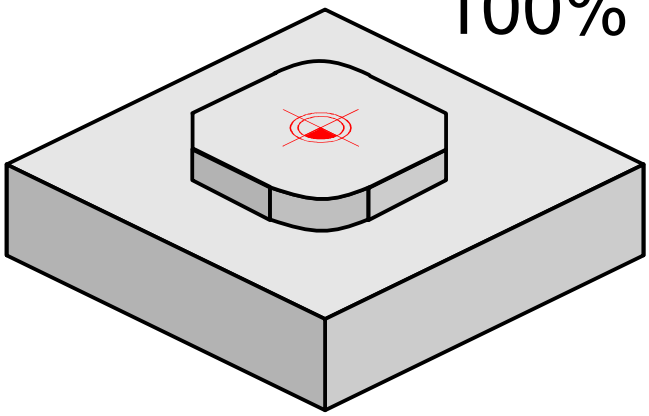
ASCALE

75%



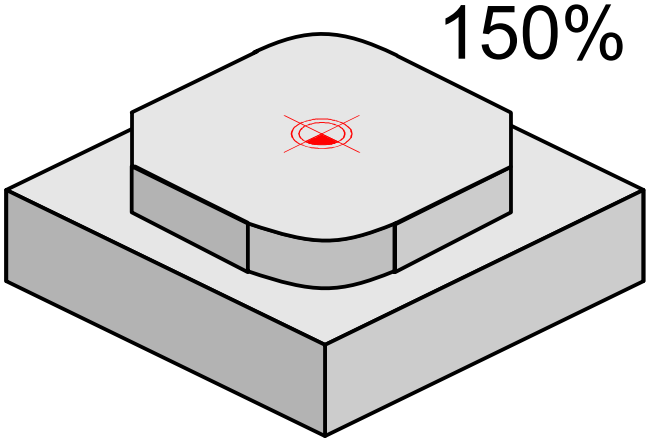
```
N0005 G54 LF
N0010 TRANS X ... Y ...
N0015 ASCALE X 0.75 Y 0.75 LF
N0020 ...
N0075 SCALE  LF
N0080 M30 LF
```

100%



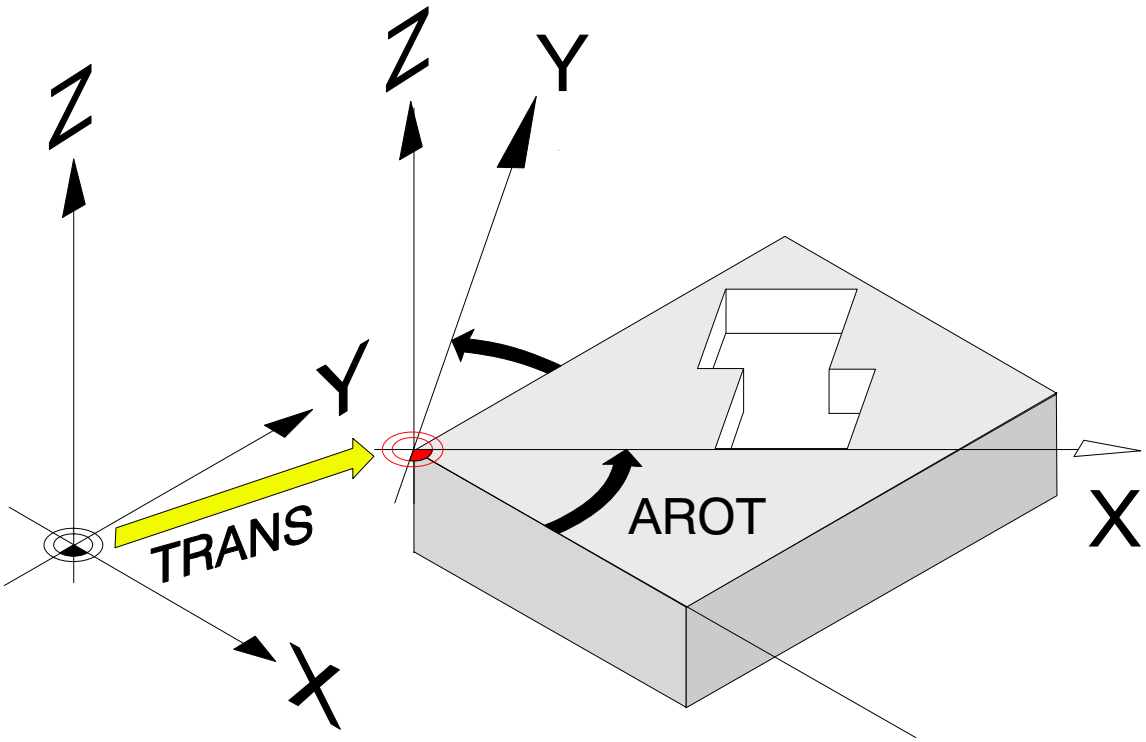
```
N0005 G54 LF
N0010 TRANS X ... Y ...  LF
N0015 ...

N0075 ...
N0080 M30 LF
```

150%



```
N0005 G54 LF
N0010 TRANS X ... Y ...
N0020 ASCALE X 1.5 Y 1.5
N0020...
N0075 SCALE
N0080 M30 LF
```

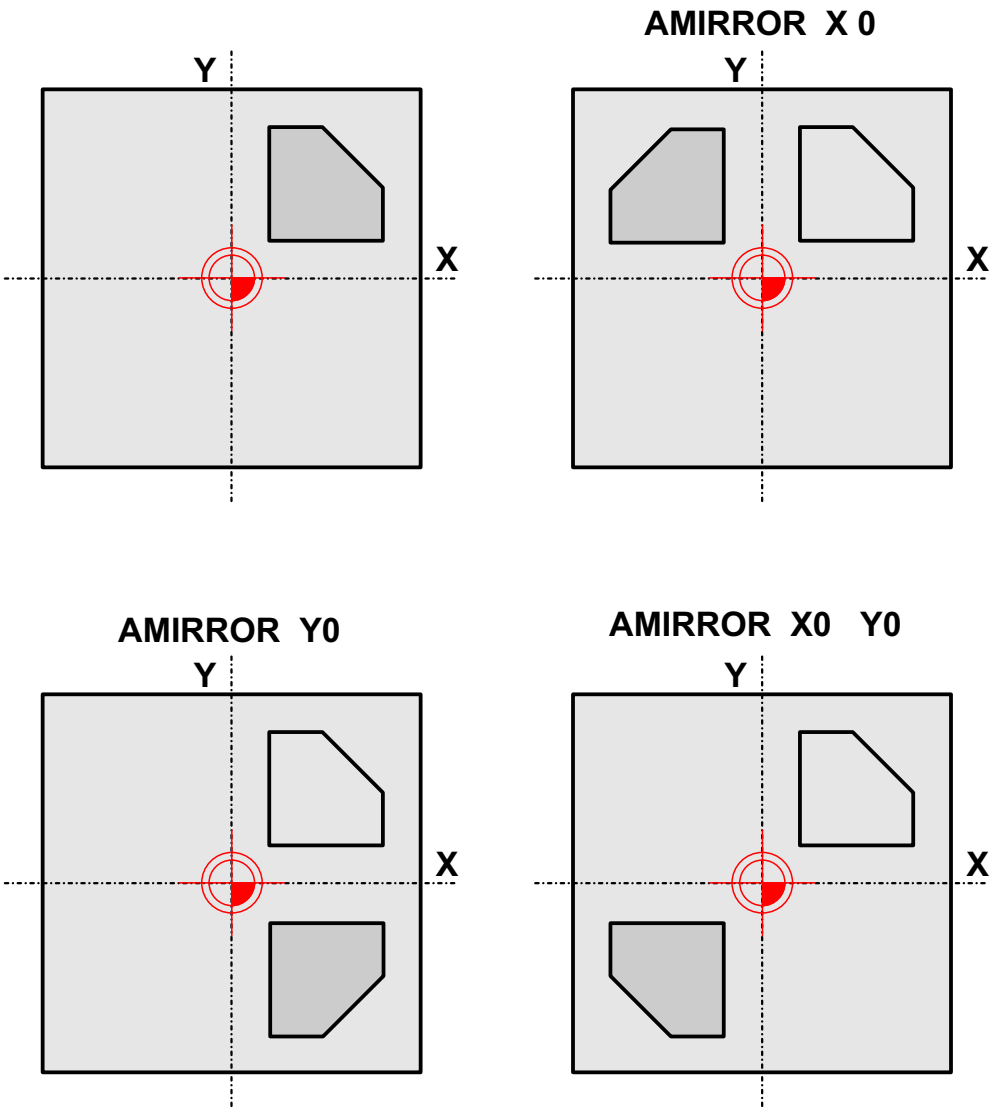
ROT
AROT



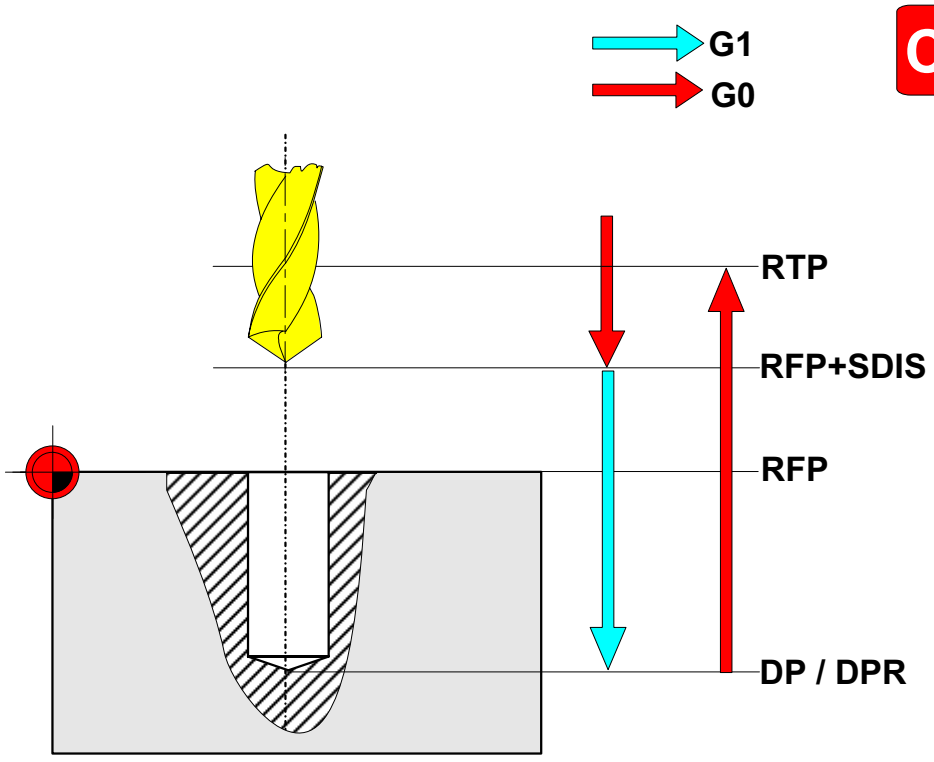
N005 AROT Z30

N005 AROT RPL=30

MIRROR
AMIRROR

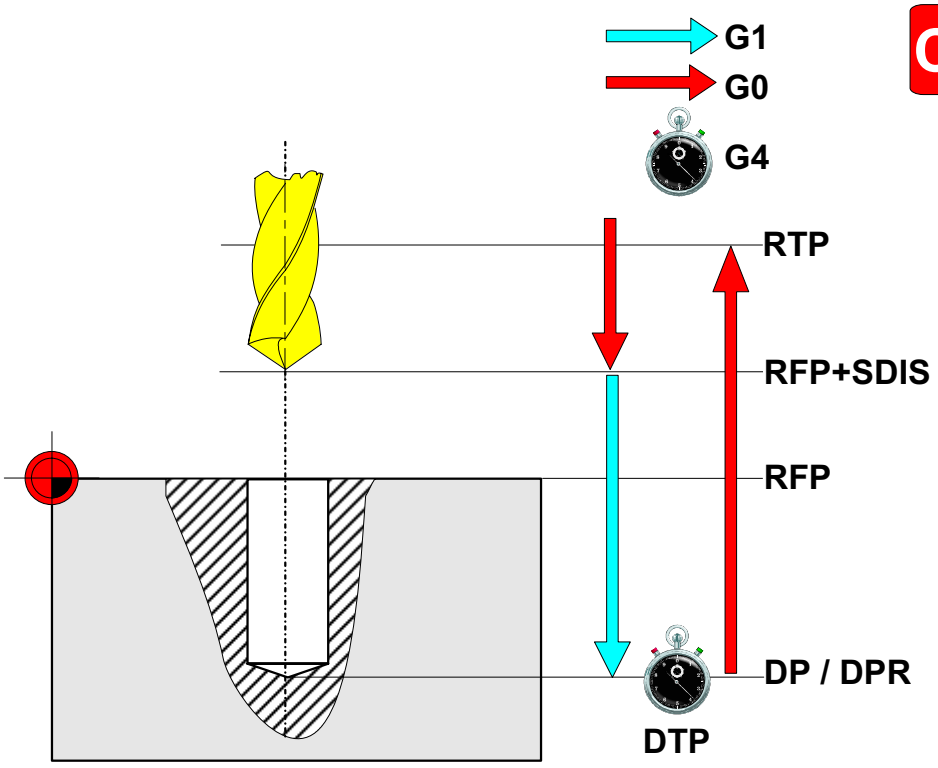


CYCLE81



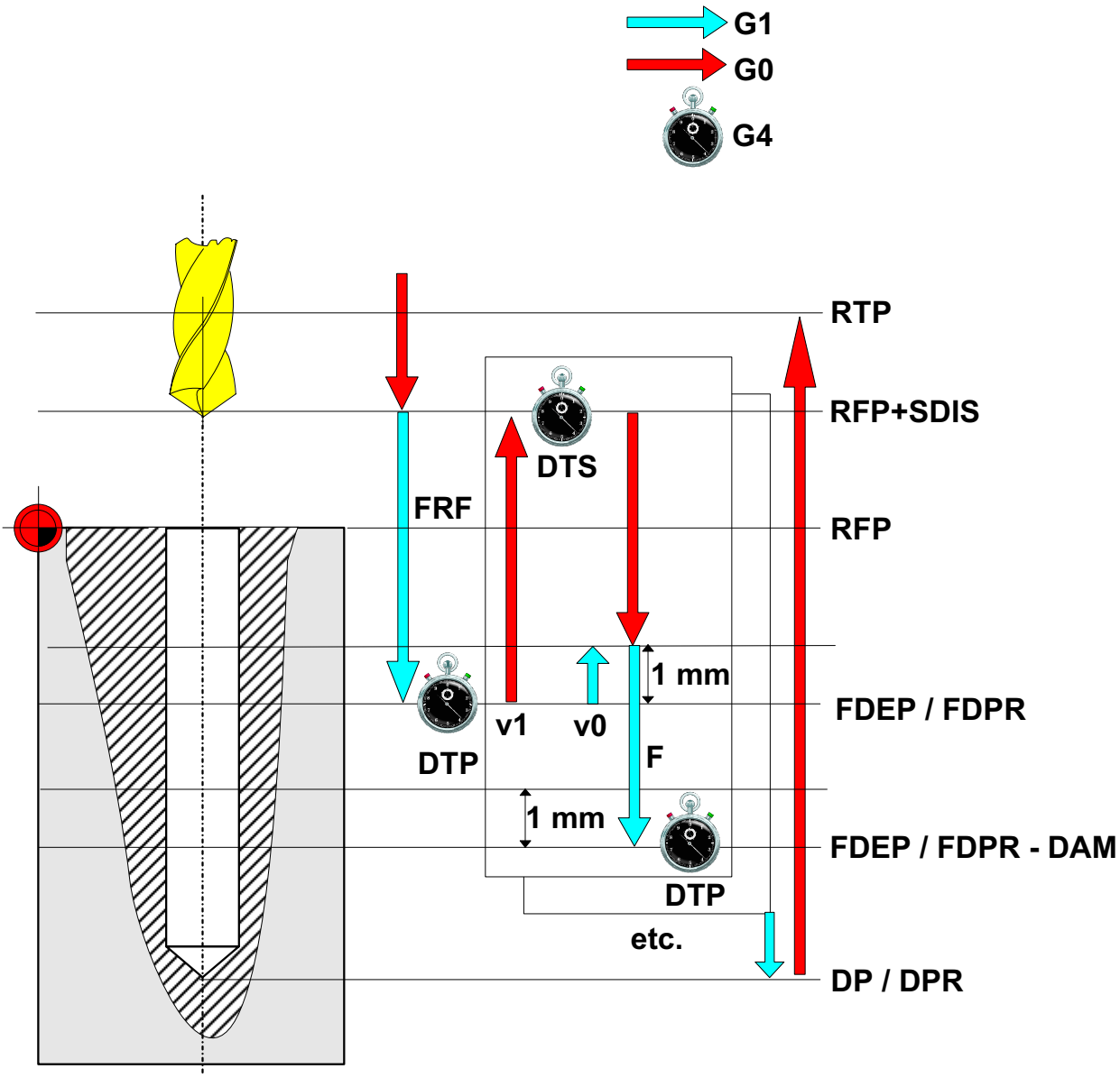
N100 CYCLE 81 (RTP, RFP, SDIS, DP, DPR)

CYCLE82



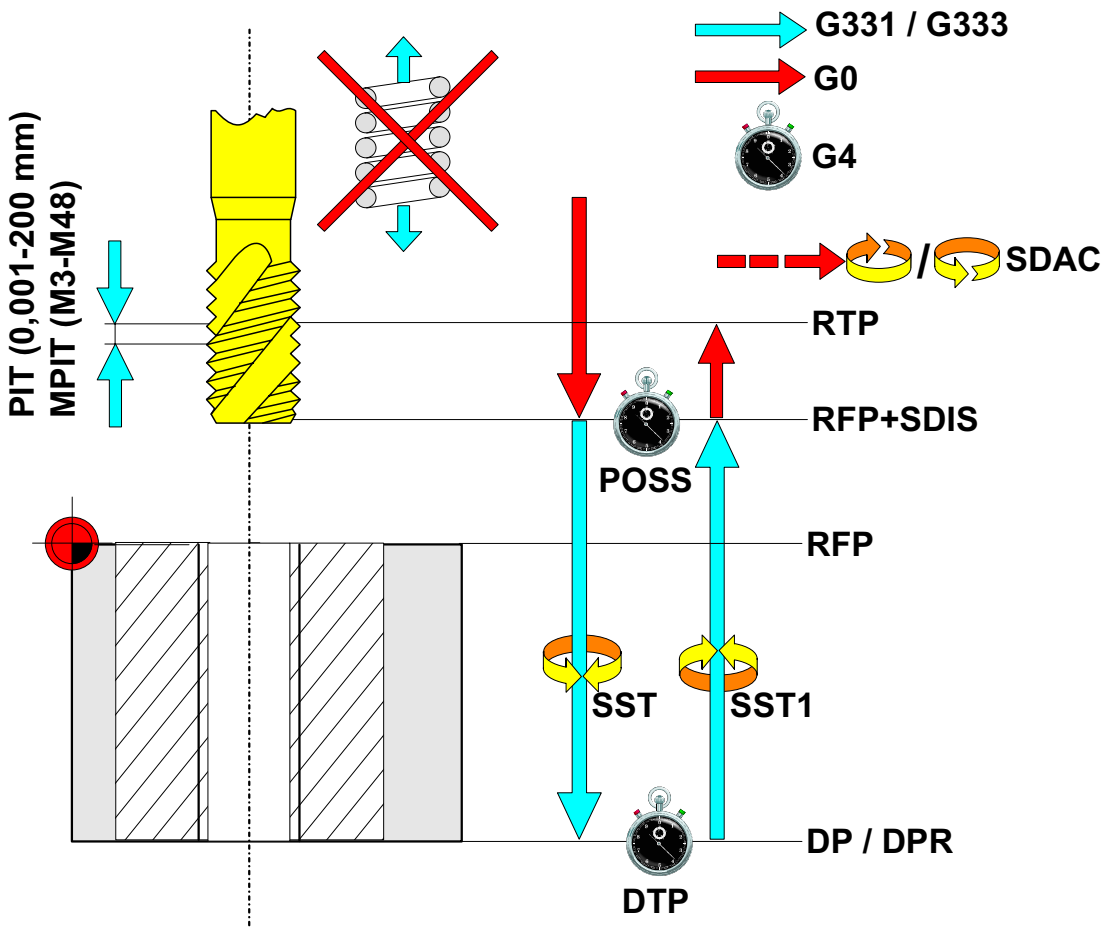
N100 CYCLE 82 (RTP, RFP, SDIS, DP, DPR, DTP)

CYCLE83



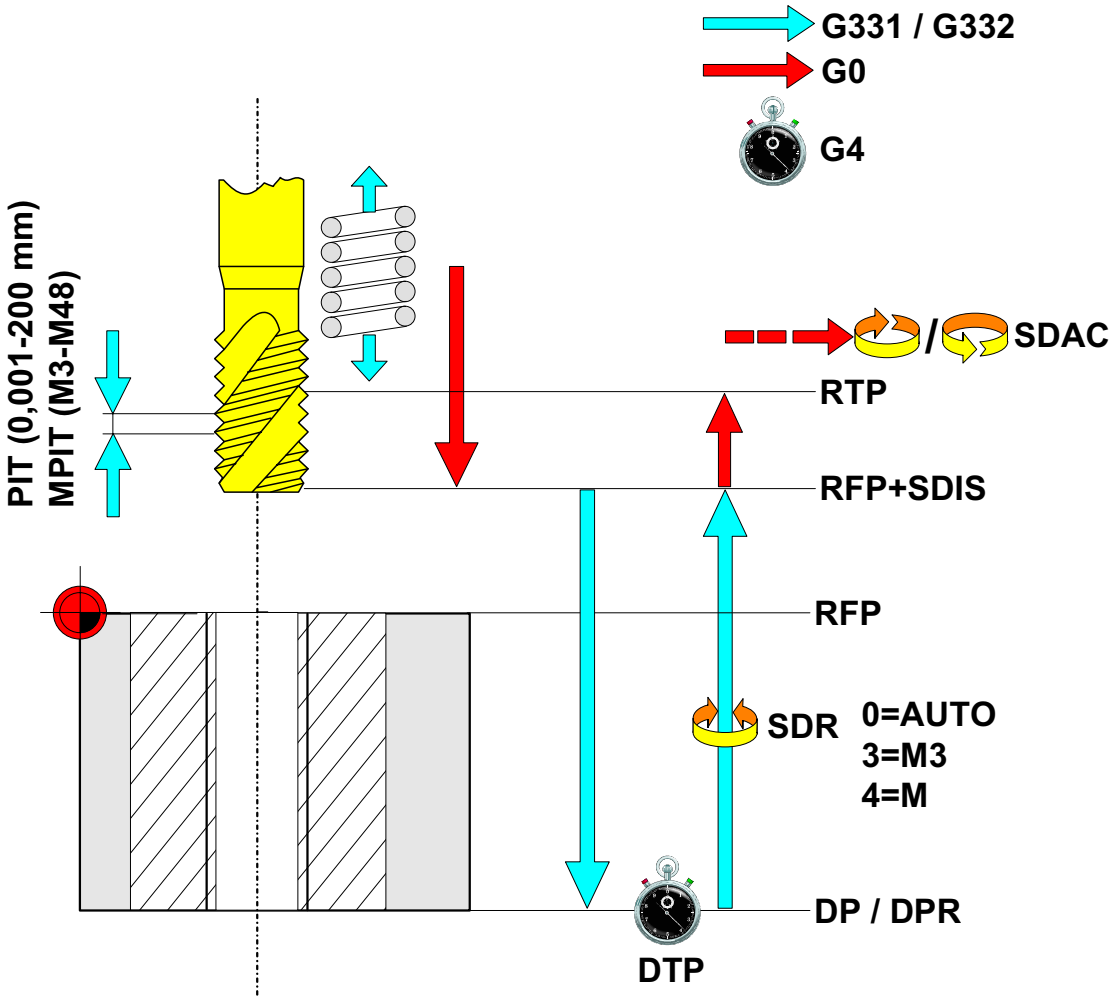
N 100 CYCLE83 (RTP,RFP,SDIS,DP,DPR,FDEP,FDPR,DAM,DTP,DTS,FRF,VARI)

CYCLE84



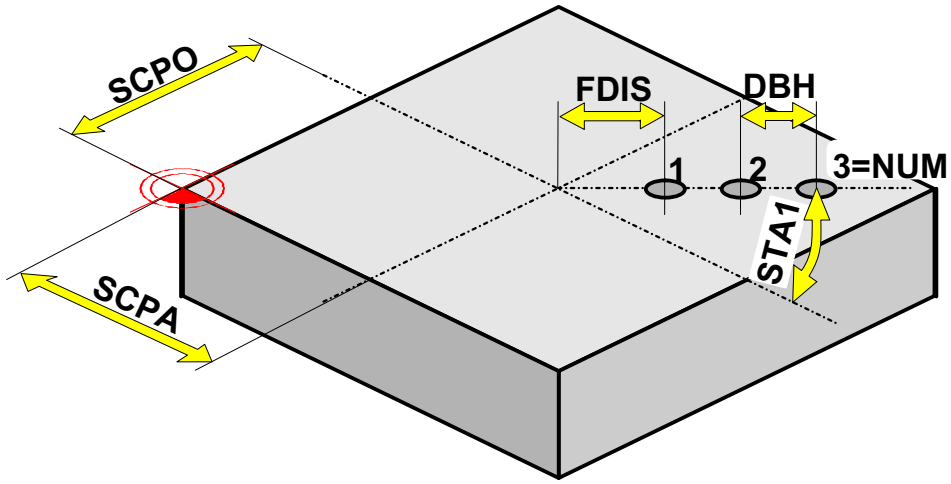
N0100 CYCLE 84 (RTP,RFP,SDIS,DP,DPR,DTP,SDAC,MPIT,PIT,POSS,SST,SST1)

CYCLE840



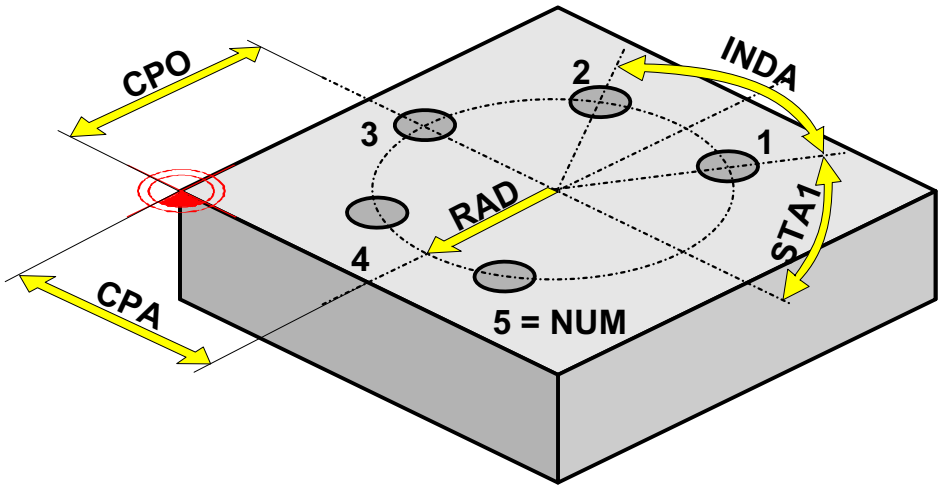
N0100 CYCLE 840 (RTP,RFP,SDIS,DP,DPR,DTP,SDR,SDAC,ENC,MPIT,PIT)

HOLES1



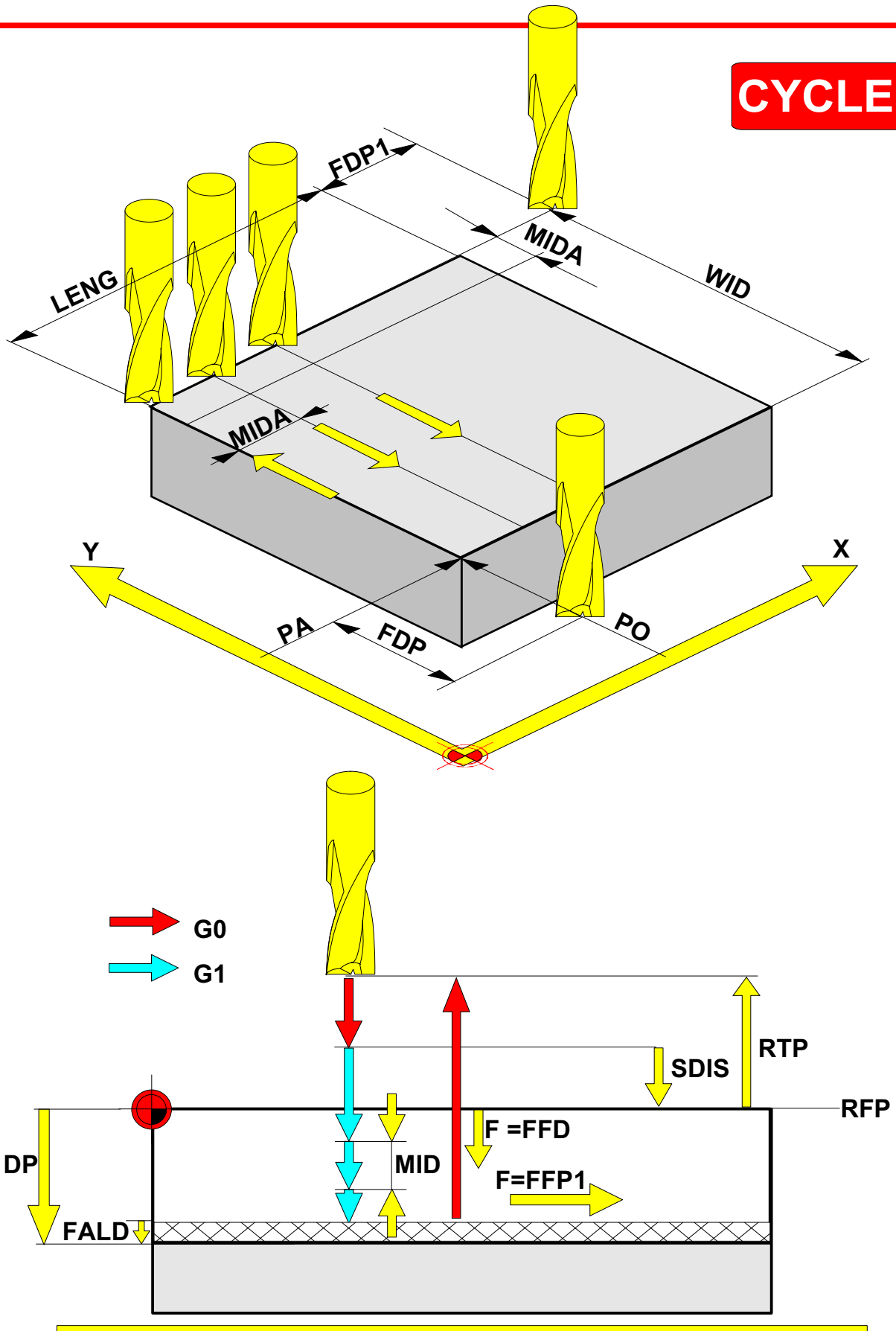

```
N100  MCALL CYCLE .....
N105  HOLES1 (SPCA, SPCO, STA1, FDIS, DBH, NUM)
N110  MCALL
```

HOLES2



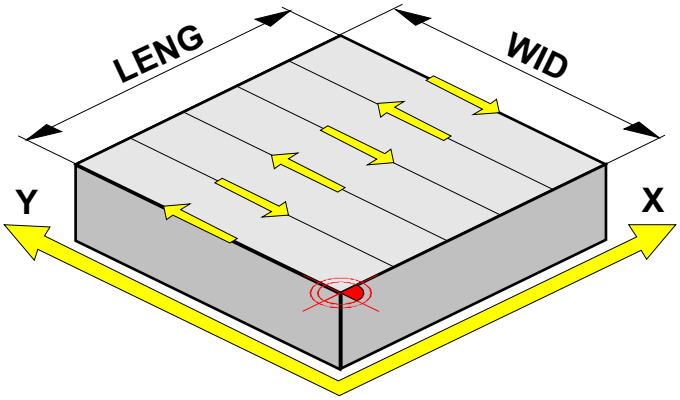

```
N100  MCALL   CYCLE .....
N105  HOLES2 (CPA, CPO, RAD, STA1, INDA, NUM),
N110  MCALL
```

CYCLE71

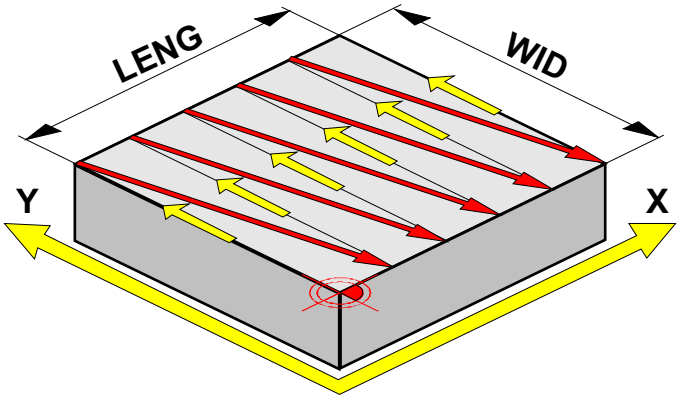


CYCLE 71 (RTP, RFP, SDIS, DP, PA, PO, LENG, WID, STA, MID, MIDA, FDP, FALD, FFP1, FDP1, VARI)

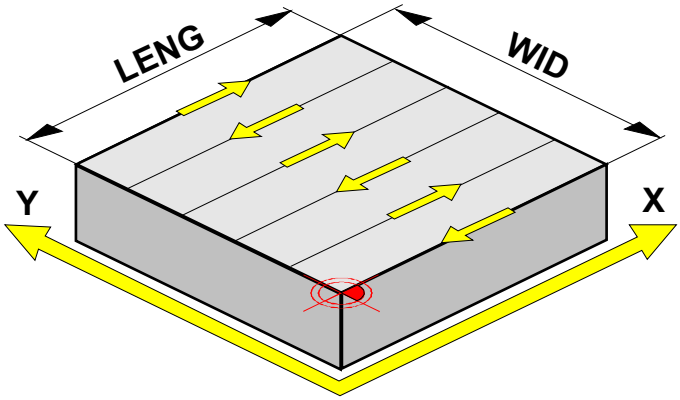
VARI = 4x



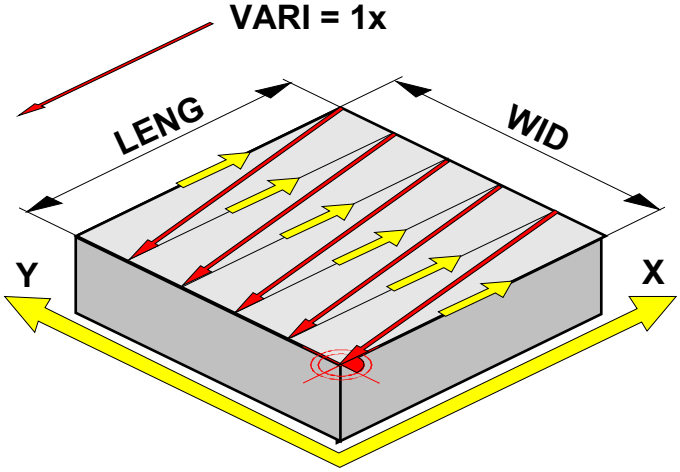
VARI = 2x



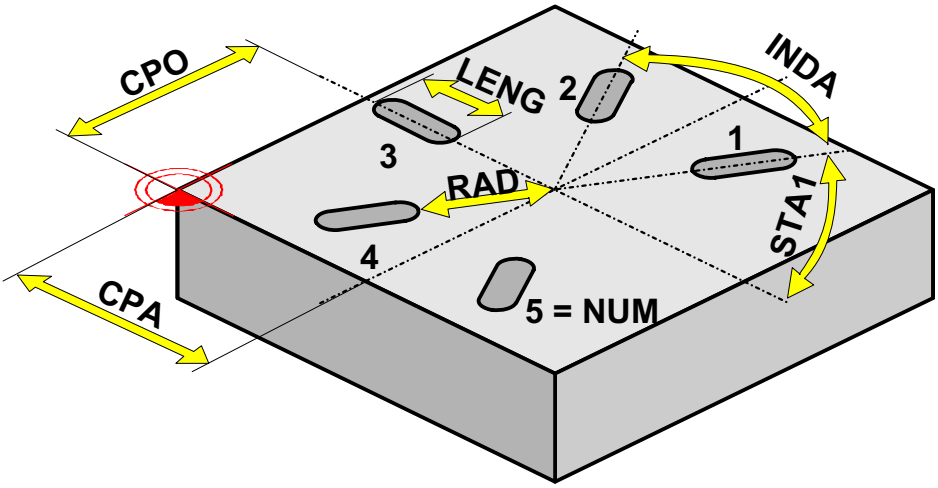
VARI = 3x

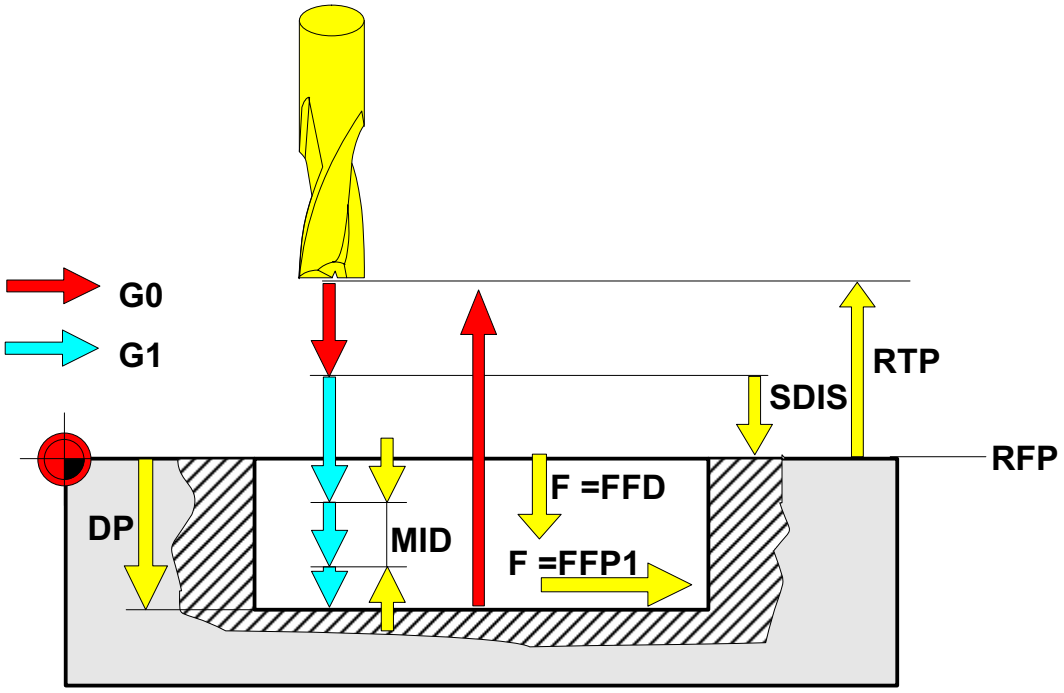


VARI = 1x



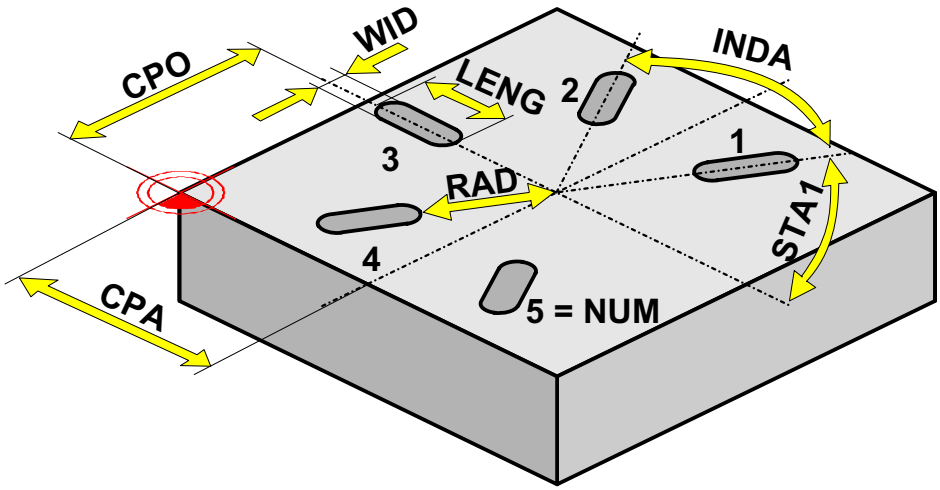
LONGHOLE

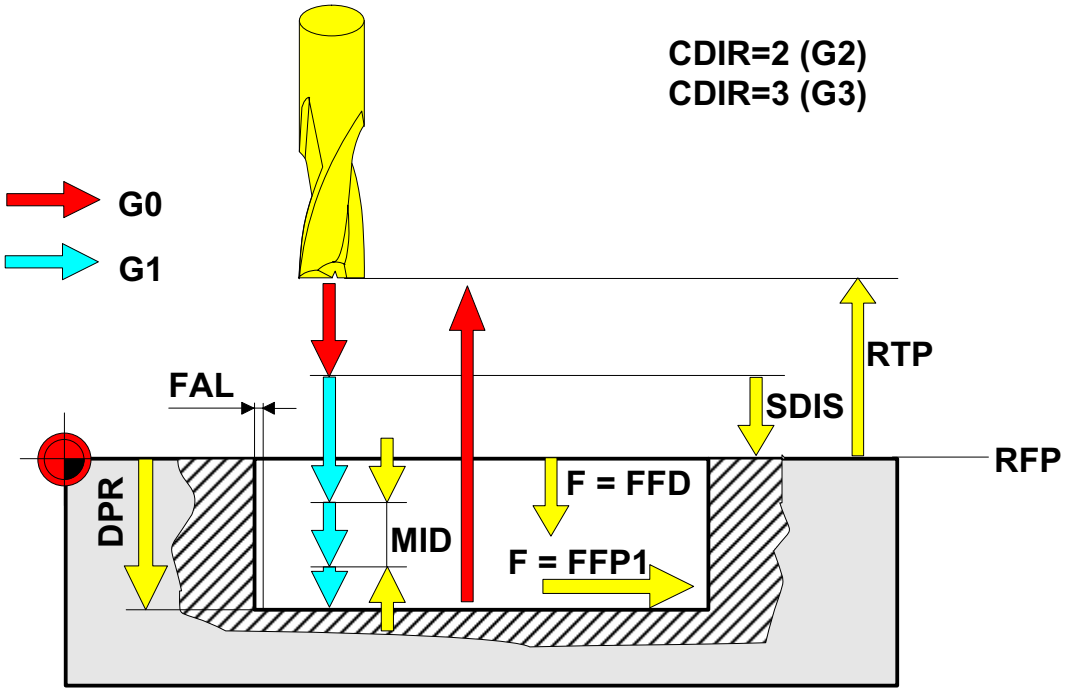




LANGHOLE (RTP, RFP, SDIS, DP, DPR, NUM, LENG, CPA, CPO, RAD, STA1, INDA, FFD, FFP1, MID)

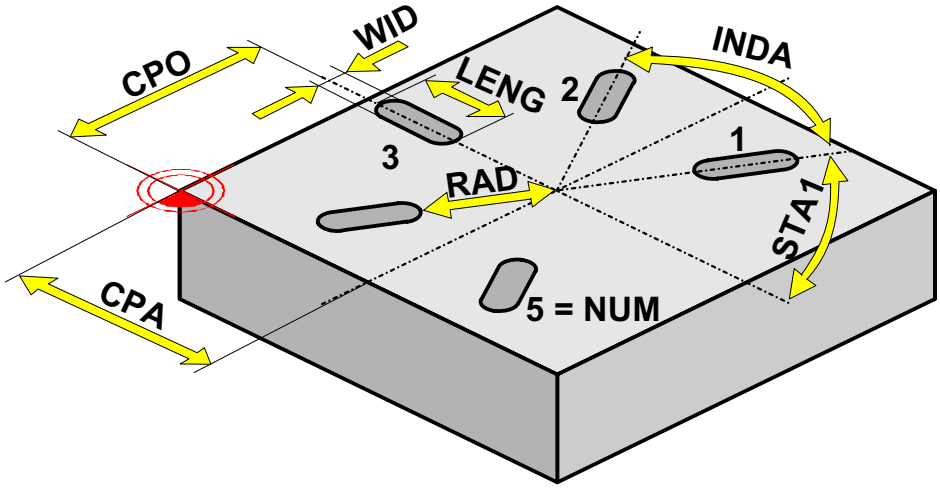
SLOT 1
VAR=1

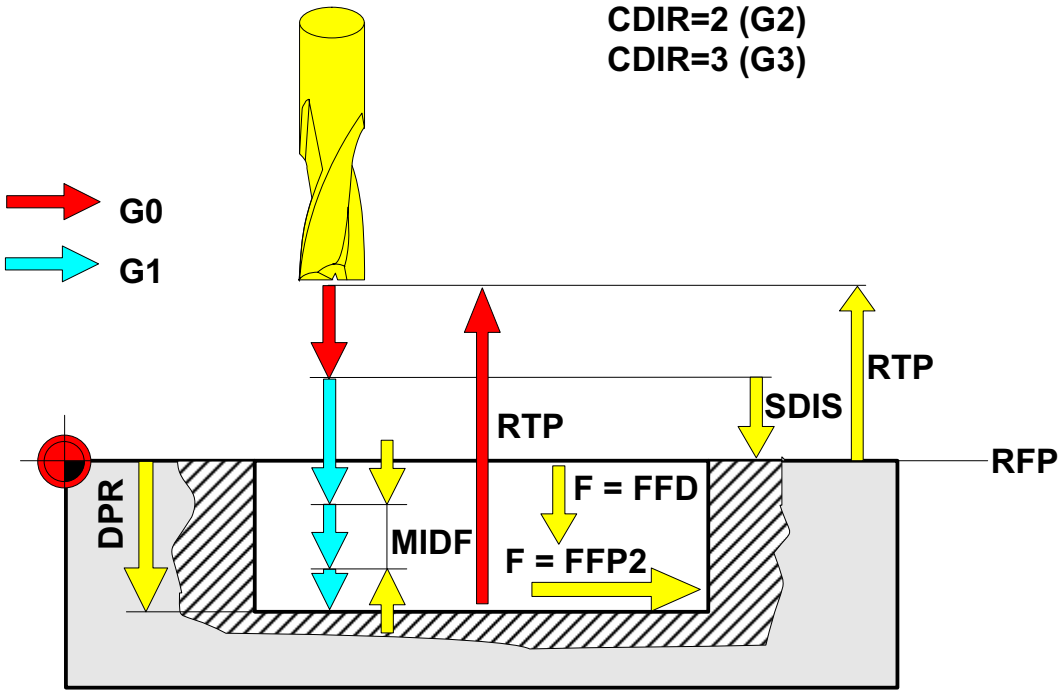




SLOT 1 (RTP, RFP, SDIS, DP, DPR, NUM, LENG, WID, CPA, CPO, RAD, STA1 INDA, FFD, FFP1, MID, CDIR, FAL, VARI, MIDF, FFP2, SSF)

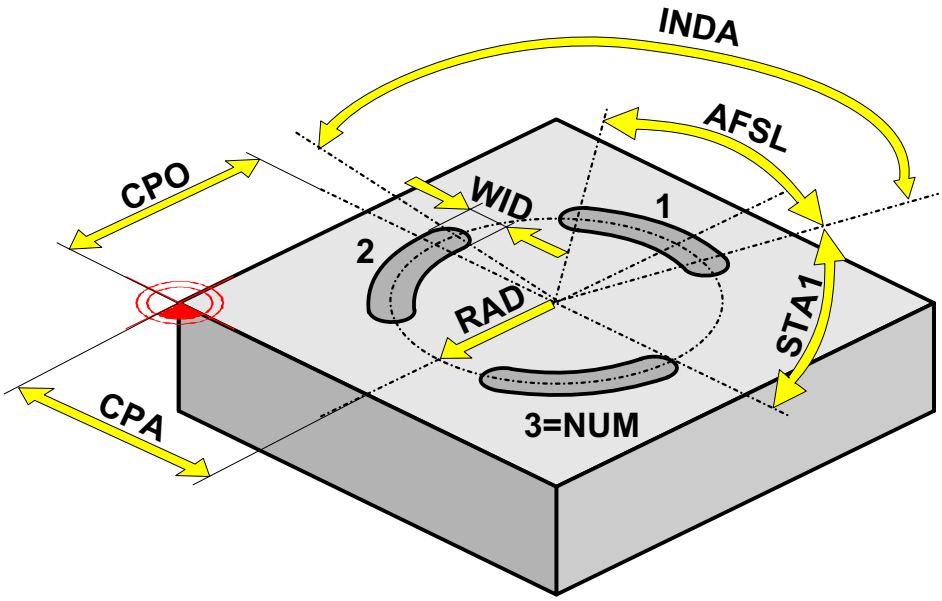
SLOT 1
VARI=2

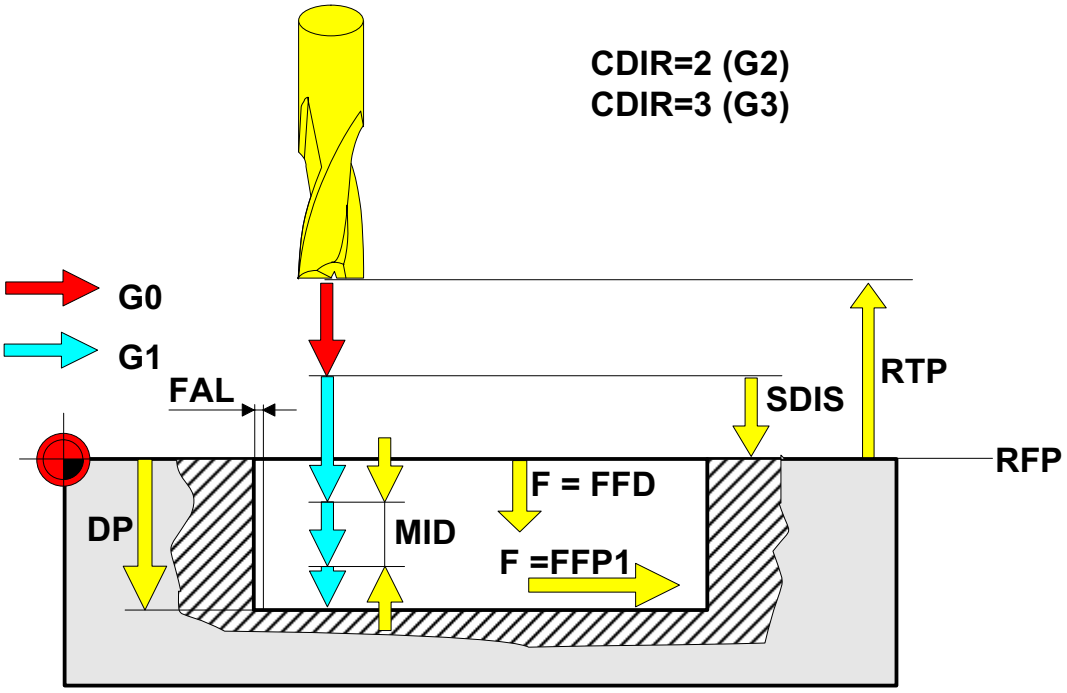




SLOT 1 (RTP, RFP, SDIS, DP, DPR, NUM, LENG, WID, CPA, CPO, RAD, STA1 INDA, FFD, FFP1, MID, CDIR, FAL, VARI, MIDF, FFP2, SSF)

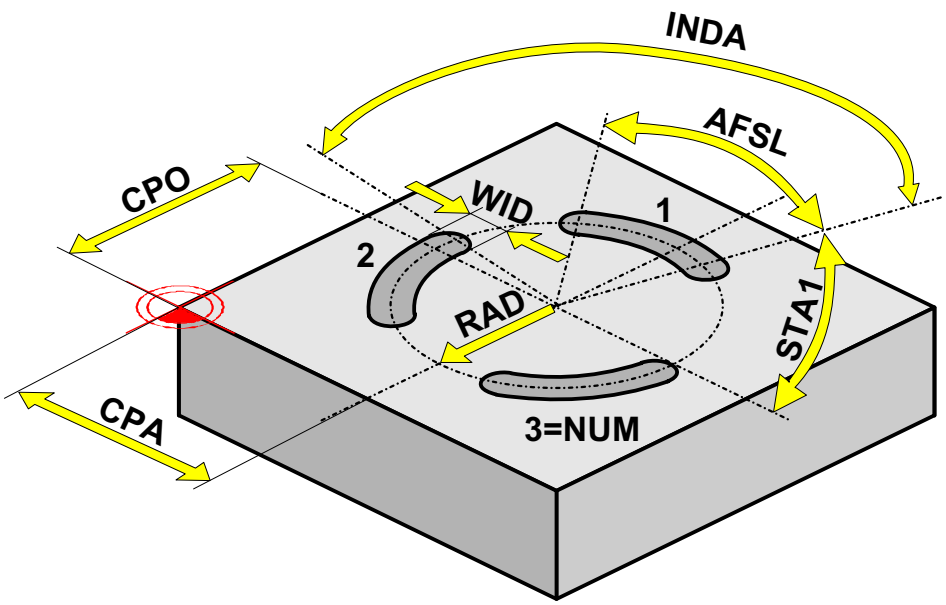
SLOT 2
VARI=1

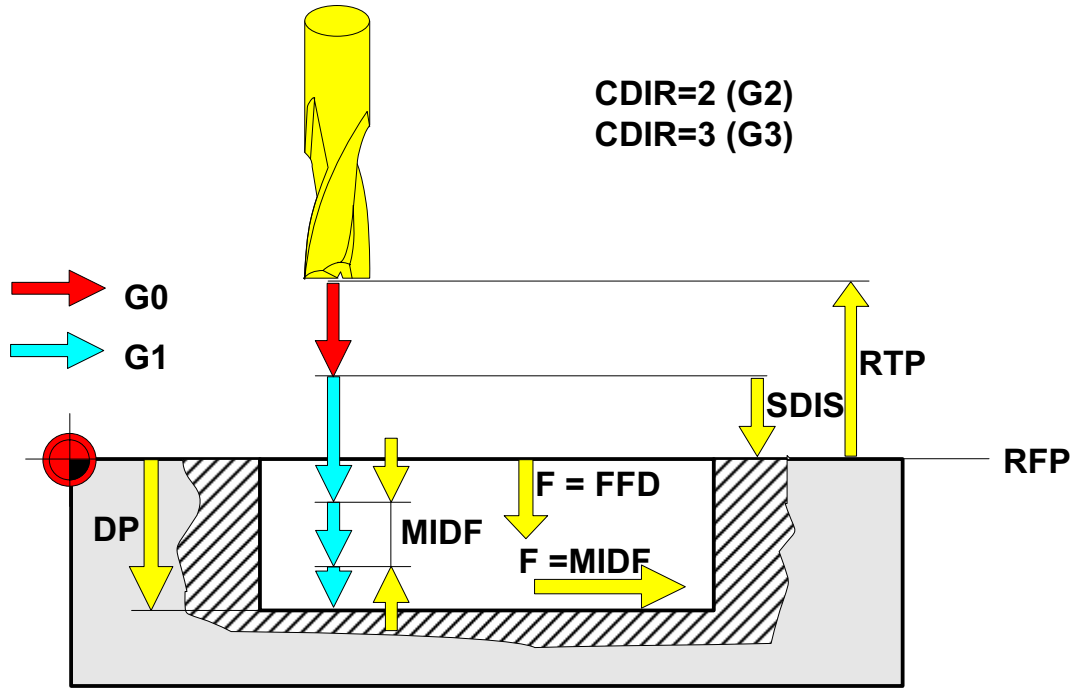




SLOT 2 (RTP, RFP, SDIS, DP, DPR, NUM, AFSL, WID, CPA, CPO, RAD, STA1, INDA, FFD, FFP1, MID, CDIR, FAL, VARI, MIDF, FFP2, SSF)

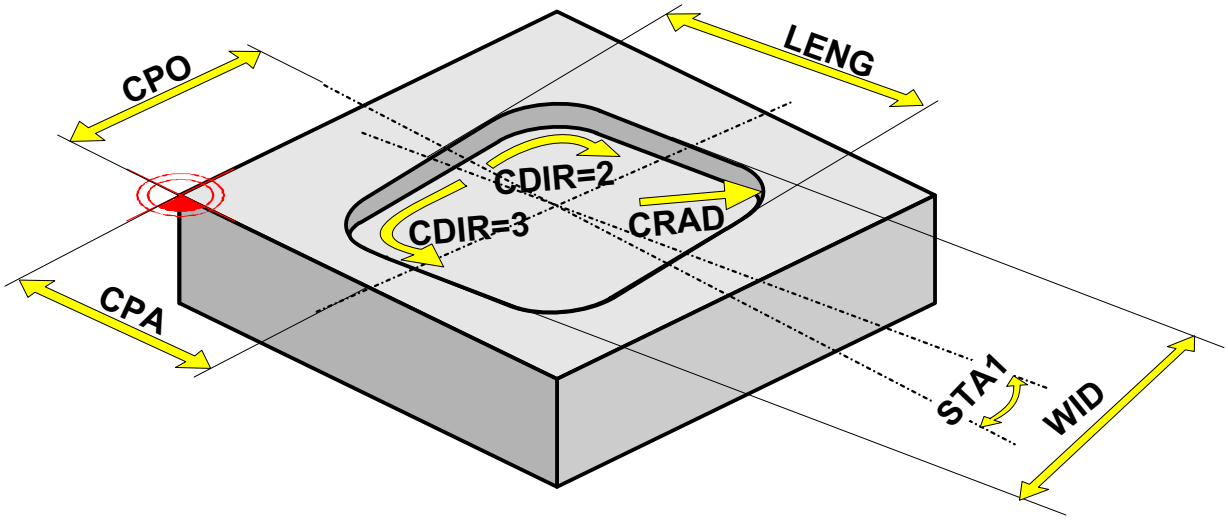
SLOT 2
VARI=2

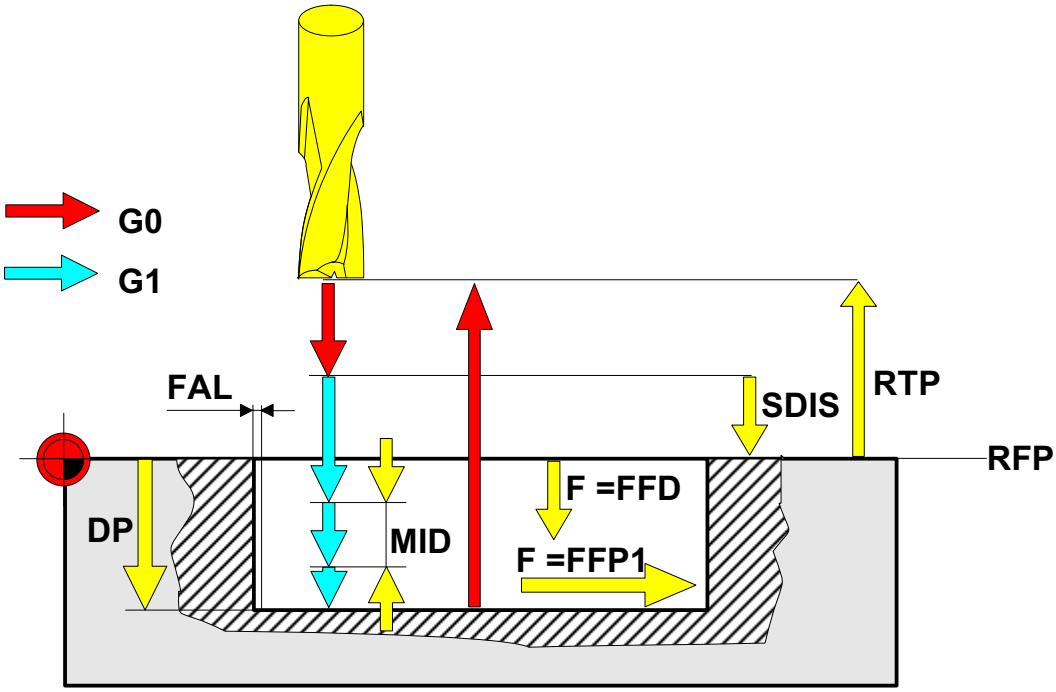




SLOT 2 (RTP, RFP, SDIS, DP, DPR, NUM, AFSL, WID, CPA, CPO, RAD, STA1, INDA, FFD, FFP1, MID, CDIR, FAL, VARI, MIDF, FFP2, SSF)

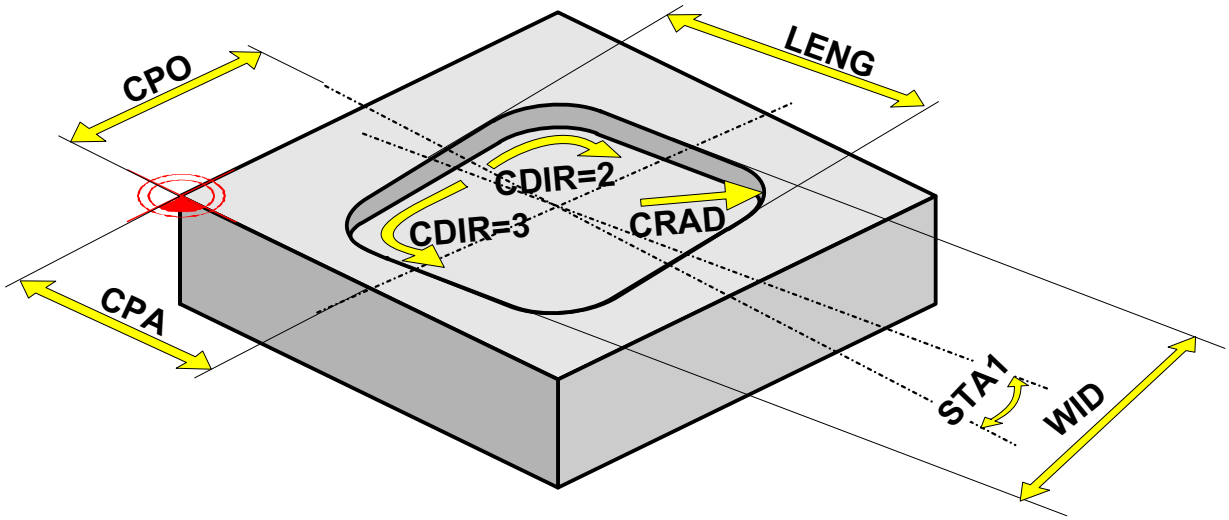
POCKET1 VARI=1

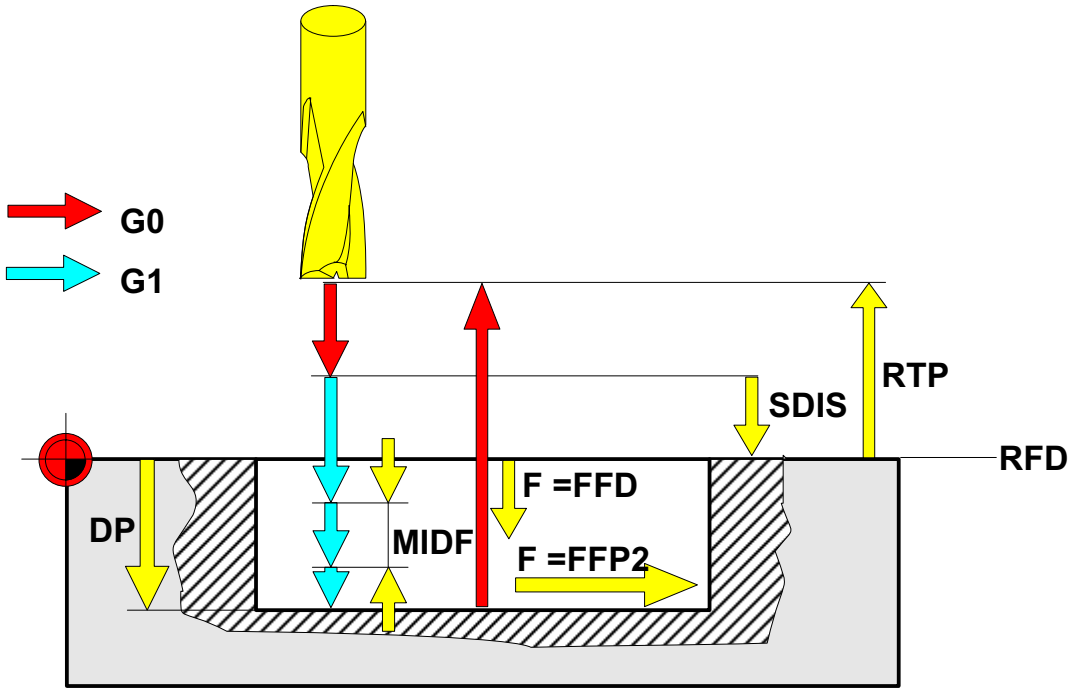




POCKET 1 (RTP, RFP, SDIS, DP, DPR, LENG, WID, CRAD, CPA, CPO, STA1, FFD, FFP1, MID, CDIR, FAL, VARI, MIDF, FFP2, SSF)

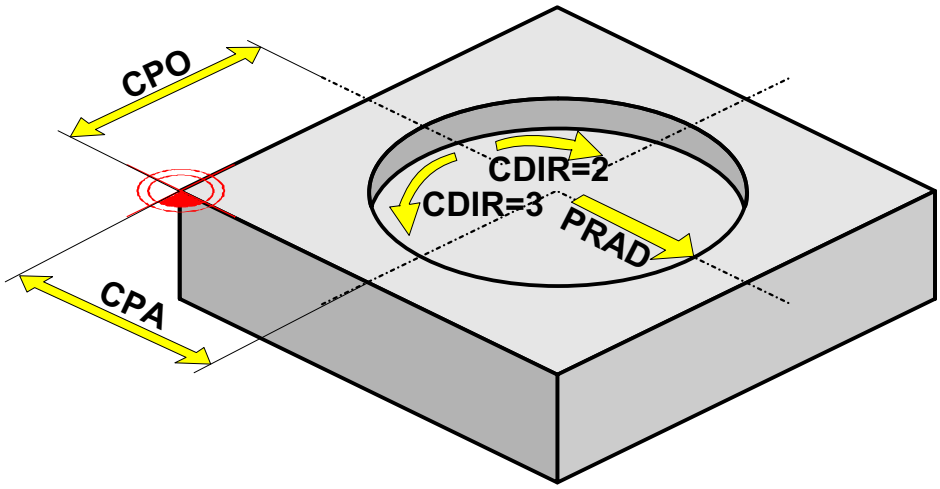
POCKET1
VARI=2

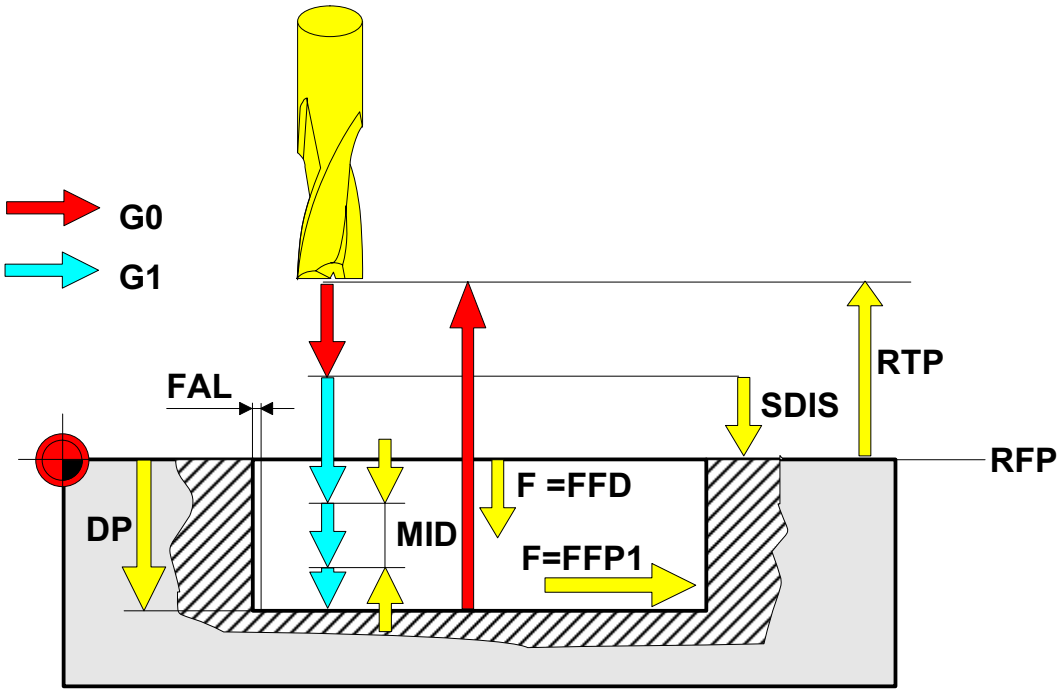




POCKET 1 (RTP, RFP, SDIS, DP, DPR, LENG, WID, CRAD, CPA, CPO, STA1, FFD, FFP1, MID, CDIR, FAL, VARI, MIDF, FFP2, SSF)

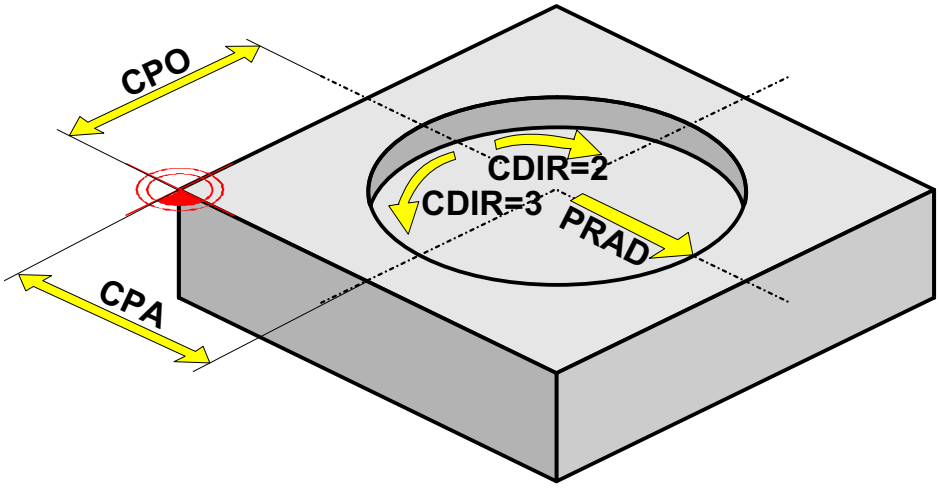
POCKET2
VARI=1

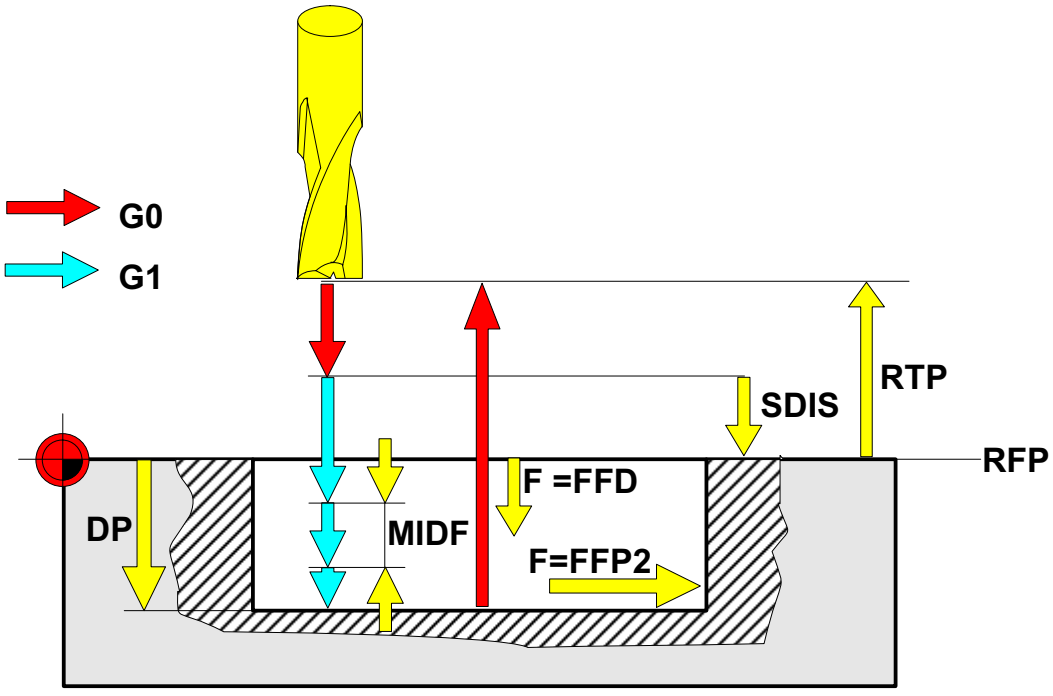




POCKET 2 (RTP, RFP, SDIS, DP, DPR, PRAD, CPA, CPO, FFD, FFP1, MID, CDIR, FAL, VARI, MIDF, FFP2, SSF)

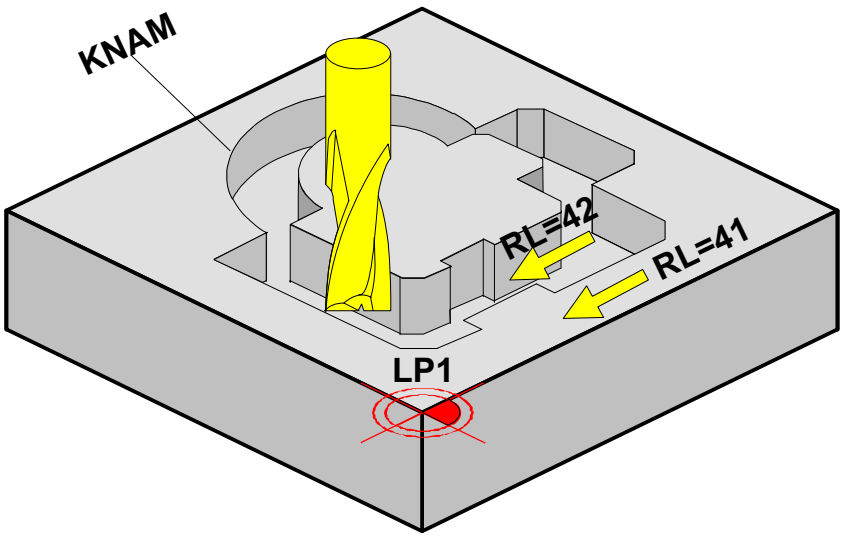
POCKET2
VARI=2

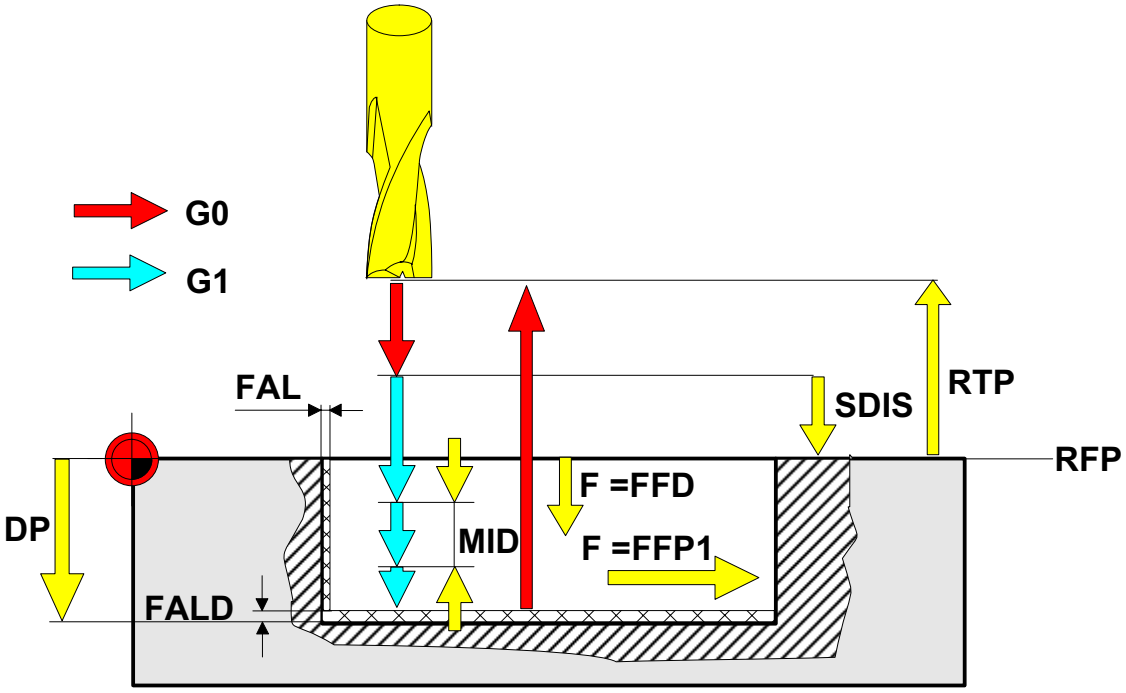




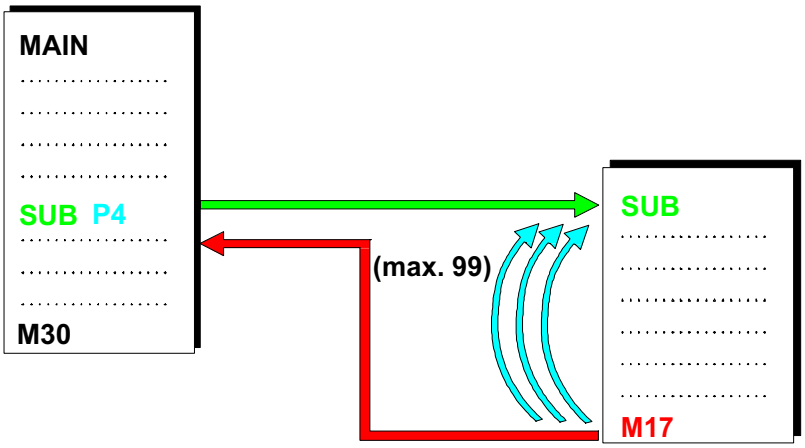
POCKET 2 (RTP, RFP, SDIS, DP, DPR, PRAD, CPA, CPO, FFD, FFP1, MID, CDIR, FAL, VARI, MIDF, FFP2, SSF)

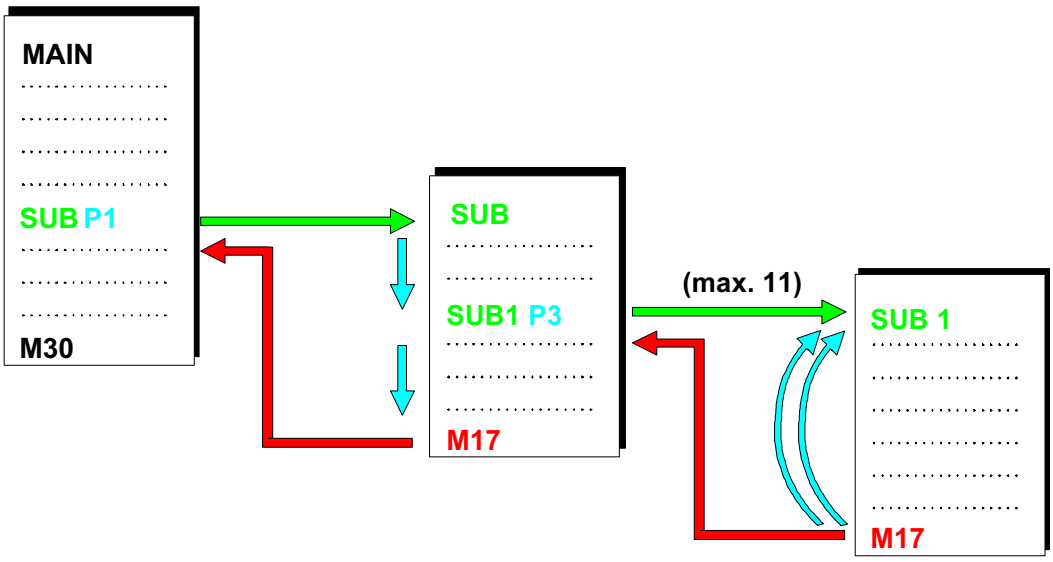
CYCLE72





CYCLE 72 (KNAM, RTP, RFP, SDIS, DP, MID, FAL, FALD, FFP1, VARI, RL, AS1, LP1, FF3, AS2, LP2)


MAIN
SUB P4
M30
(max. 99)
SUB
M17


MAIN
SUB P1
M30
SUB
SUB1 P3
M17
(max. 11)
SUB 1
M17