

%

O0013 (EXERCISE MOTION TYPES)

(Program 1 Milling Code)

N010 G___ G90 G94 G54 (Specify measurement system mode)

N020 T01 M06 (select #4 center drill)

N030 S___ M03 T02 (start spindle)

N040 G00 X___ Y___ (rapid above hole 11)

N050 G43 H01 Z___ M08 (rapid to workpiece)

N060 G__ Z___ F___ (center drill hole)

N070 G__ Z___ (rapid retract)

N080 X___ (rapid above hole 12)

N090 G__ Z___ (center drill hole)

N100 ___ ___ (rapid retract)

N110 ___ (rapid above hole 13)

N120 ___ ___ (center drill hole)

N130 ___ ___ (rapid retract)

N140 ___ (rapid above hole 14)

N150 ___ ___ (center drill hole)

N160 ___ ___ M09 (rapid retract)

N163 G91 G28 Z0 (retract to tool change position) N165 M01 (optional stop)

N170 T02 M06 (select 12.0 mm [or 1/2] inch drill)

N180 G90 G54 S___ M03 T03 (start spindle)

N190 G__ X___ Y___ (rapid to hole 11)

N200 G43 H02 Z___ M08 (rapid to workpiece)

N210 G__ Z___ F___ (drill hole 11)

N220 ___ Z___ (rapid retract)

N230 _____ (rapid to hole 12)
N240 _____ (drill hole)
N250 _____ (rapid retract)
N260 _____ (rapid to hole 13)
N270 _____ (drill hole)
N280 _____ (rapid retract)
N290 _____ (rapid to hole 14)
N300 _____ (drill hole)
N310 _____ M09 (rapid retract)
N313 G91 G28 Z0 (retract to tool change position) N315 M01 (optional stop)
N320 T03 M06 (select 20.0 mm [or 3/4 inch] end mill)
N330 G90 G54 S_____ M03 T01 (start spindle)
N340 _____ (rapid to milling start pt. 1)
N350 G43 H03 Z_____ M08 (rapid to workpiece)
N360 G01 Z_____ F50.0 (fast-feed move to cutting depth)
N370 _____ F_____ (machine to pt. 2)
N380 G_____ R_____ (machine to pt. 3)
N390 _____ (machine to pt. 4)
N400 _____ (machine to pt. 5)
N410 _____ (machine to pt. 6)
N420 _____ (machine to pt. 7)
N430 _____ (machine to pt. 8)
N440 _____ (machine to pt. 9)
N450 _____ (exit cut to pt. 10)
N460 G00 Z_____ M09 (rapid retract)
N470 G91 G28 Z0.0

N480 G28 X0.0 Y0.0

N490 M30

%