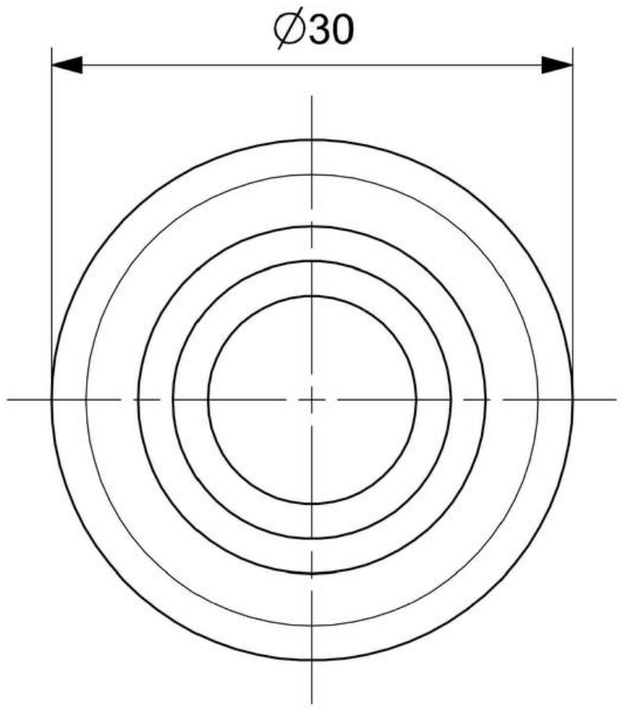
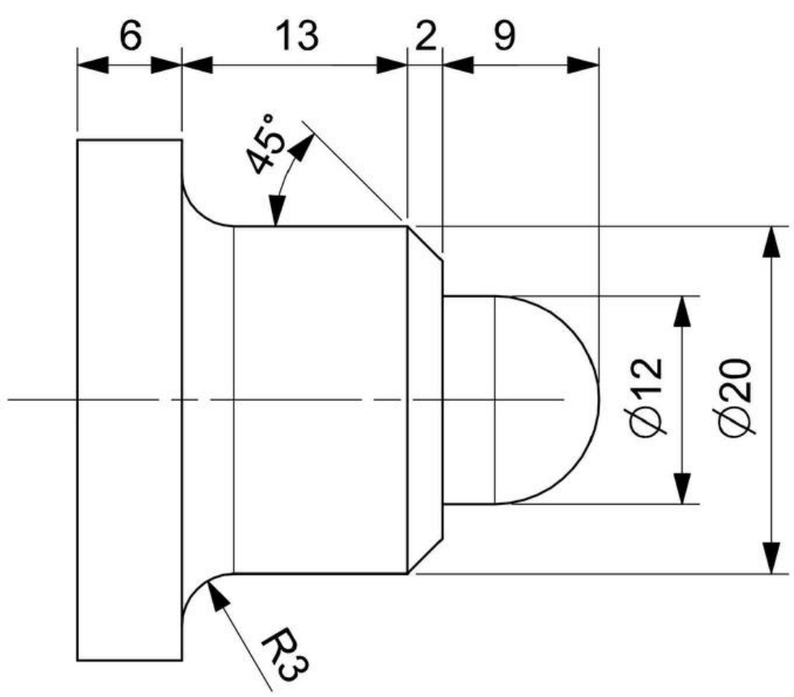
LENGTH OR DIA	MACHININIG DEVIATION TO ISI:2102(MEDIUM GRADE) UNLESS SPECIFIED OTHERWISE															
	UP TO 6	6 30	30 120	120 315	315 1000	1000 2000	2000 4000	4000 ABOVE	LENGTH IN mm OF SHORTER SIDE OF ANGLE				MACHINING FINISH MICRONS			
									UP TO 6	6-30	30-120	120-400	▽	▽▽	▽▽▽	▽▽▽▽
	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0	±60'	±30'	±20'	±10'	8-25	1.6-8	0.025-1.6	<0.025





NOTE
DO NOT SCALE THE DRAWING .
ALL DIMENSIONS ARE IN MILLIMETERS .
REMOVE SHARP EDGES AND BURRS

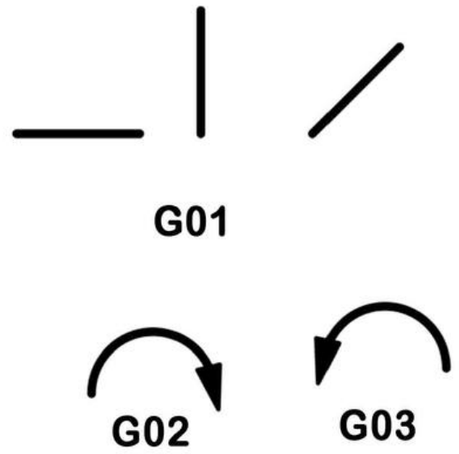
http://www.facebook.com/afsalabba.in
http://www.youtube.com/c/afsalabbaabba

	TITLE :	
DRAWN BY :	**TKMCE**	
CHECKED BY :	MATERIAL : ALUMINUM	DRG.NO : ME/WS/MO/CNC/L1
APPROVED BY:	SCALE : 2:1	QTY : 1

PREPARATORY FUNCTION

G00	RAPID POSITIONING
G01	LINEAR INTERPOLATION
G02	CW CIRCULAR INTERPOLATION
G03	CCW CIRCULAR INTERPOLATION
G70	DIMENSION IN INCH
G71	DIMENSION IN MM
G75	RETURN TO HOME
G90	ABSOLUTE DIMENSION
G91	INCREMENTAL DIMENSION

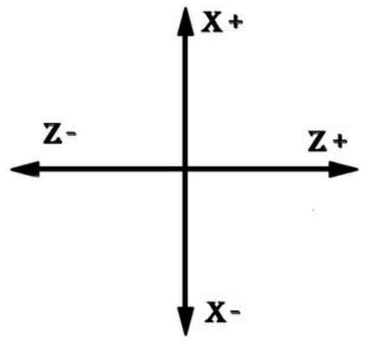
PREPARATORY FUNCTION FOR MOVEMENT
G00, G01, G02,...
PREPARATORY FUNCTION FOR PRESETTING
G70, G90, G91,...



MISCELLANEOUS FUNCTION

M00	PROGRAM STOP
M01	OPTIONAL STOP
M02	PROGRAM END WITH OUT RESET
M03	SPINDLE ON CW
M04	SPINDLE ON CCW
M05	SPINDLE STOP
M06	TOOL CHANGE
M08	COOLANT ON
M09	COOLANT OFF
M30	PROGRAM END WITH RESET

N	SEQUENCE OR BLOCK NUMBER
T	TOOL SELECTION
S	SPINDLE SPEED IN RPM
F	FEED IN mm/rev
CR	RADIUS OF CIRCLE



PROGRAM

```
G75 X0 Z0
T1 D1
G96 S200 LIMS=1500 M03
M08
G00 X36 Z2
CYCLE95("AB:BC",1,0.2,0.4,0,0.15,0.1,0.05,9, , , )
G00 X36 Z2
G75 X0 Z0
M05
M09
M30

AB:
G01 X0 Z0 F0.1
G03 X12 Z-6 CR=6
G01 X12 Z-9
G01 X16 Z-9
G01 X20 Z-11
G01 X20 Z-21
G02 X26 Z-24 CR=3
G01 X30 Z-24
G01 X30 Z-30
G01 X32 Z-30
BC:
```

MACHINE ON

- MAIN PANEL ON
- STABILIZER ON
- RESET BUTTON PRESS (STABILIZER)
- MACHINE MAIN POWER ON

RUNING SET UP

- EMERGENCY RELEASE
- RESET (EMERGENCY)