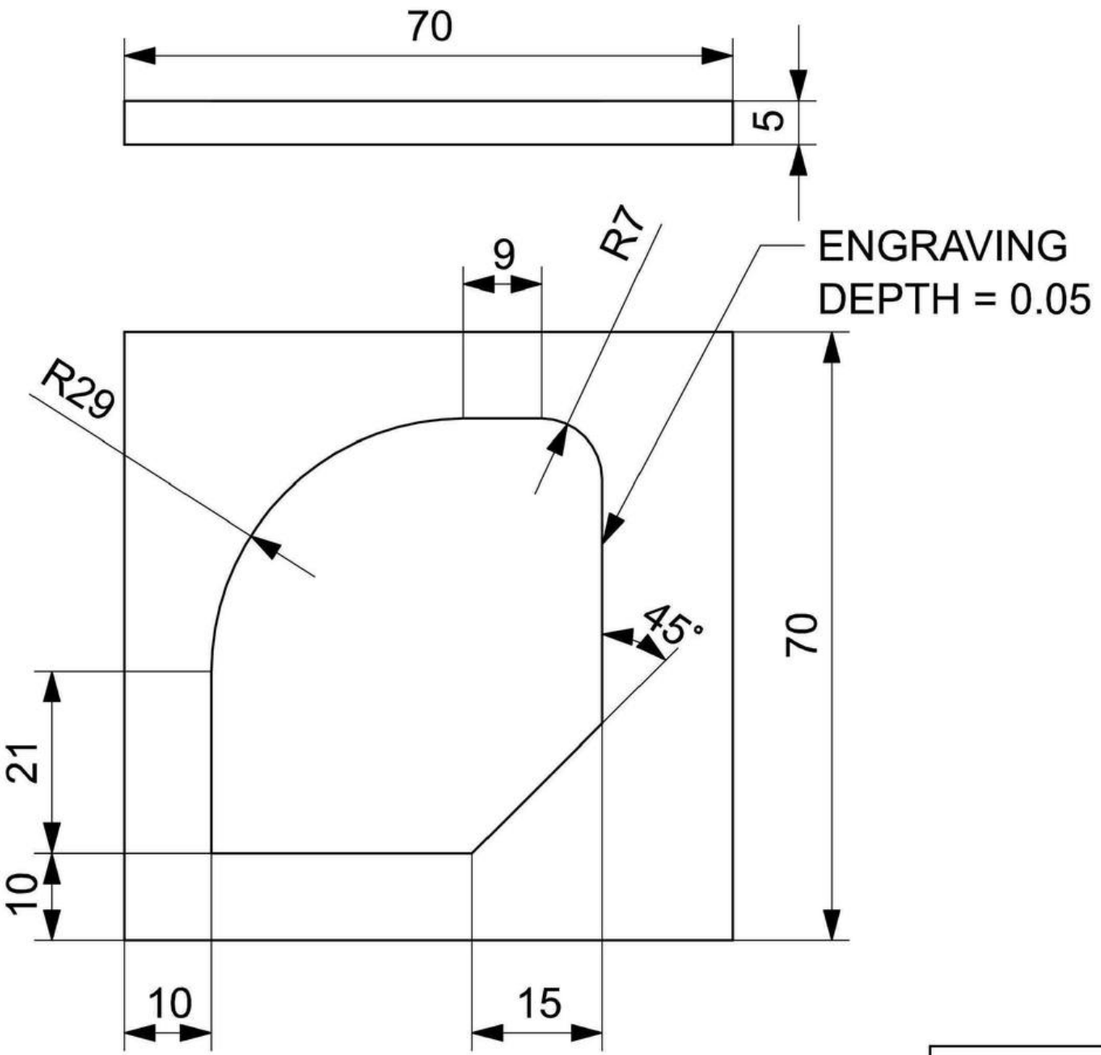
LENGTH OR DIA	MACHININIG DEVIATION TO ISI:2102(MEDIUM GRADE) UNLESS SPECIFIED OTHERWISE															
	UP TO 6	6 30	30 120	120 315	315 1000	1000 2000	2000 4000	4000 ABOVE	LENGTH IN mm OF SHORTER SIDE OF ANGLE				MACHINING FINISH MICRONS			
									UP TO 6	6-30	30-120	120-400	▽	▽▽	▽▽▽	▽▽▽▽
	±0.1	±0.2	±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

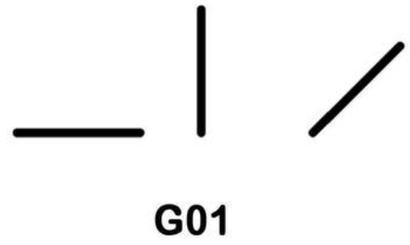
http://www.facebook.com/afsalabba.in
http://www.youtube.com/c/afsalabbaabba

	TITLE :		
DRAWN BY :	TKMCE		
CHECKED BY :	MATERIAL : ALUMINUM	DRG.NO : ME/WS/MO/CNC/M1	
APPROVED BY:	SCALE : 2:1	QTY : 1	

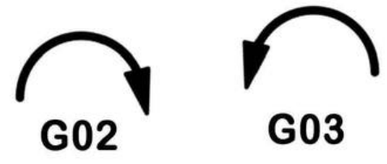
PREPARATORY FUNCTION

G00	RAPID POSITIONING
G01	LINEAR INTERPOLATION
G02	CW CIRCULAR INTERPOLATION
G03	CCW CIRCULAR INTERPOLATION
G20	DIMENSION IN INCH
G21	DIMENSION IN MM
G28	RETURN TO HOME
G40	NO CUTTER RADIUS COMPENSATION
G41	CUTTER RADIUS COMPENSATION-LEFT
G42	CUTTER RADIUS COMPENSATION-RIGHT
G54-G57	WORK ZERO (ZERO OFFSET)
G90	ABSOLUTE DIMENSION
G91	INCREMENTAL DIMENSION

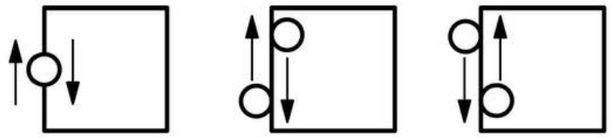
PREPARATORY FUNCTION FOR MOVEMENT
G00, G01, G02,...
PREPARATORY FUNCTION FOR PRESETTING
G20, G54, G90,...



G01



G02 G03

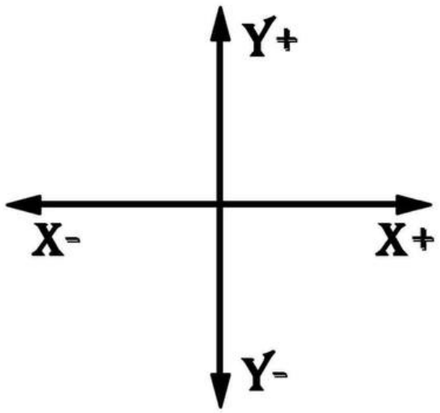


G40 G41 G42

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/min
R	RADIUS OF CIRCLE



G54-G57

PROGRAM

O00001
G28
T1 M06
G54 G40 G21 G90
M03 S1500
M08
G00 X10 Y10
G00 Z10
G01 Z-0.05 F100
G01 X10 Y31 F300
G02 X39 Y60 R29
G01 X48 Y60
G02 X55 Y53 R7
G01 X55 Y25
G01 X40 Y10
G01 X10 Y10
G00 Z10
G28
M09
M05
M30

MACHINE ON

- COMPRESSOR ON
- MAIN PANEL ON
- STABILIZER ON
- SELECT THREE PHASE (MENU-3)
- START BUTTON PRESS
- MACHINE MAIN POWER ON
- POWER ON

RUNING SET UP

- ALARM
  - RESET (LOW AIR)
  - RESET (EMERGENCY)
  - RESET (SERVO)
- SETTING
  - PAGE DOWN
  - 51 SAFTY.. - ON
  - WRIT ENTER – Y
- ZERO RET
- ALL
- HAND JOG (2)