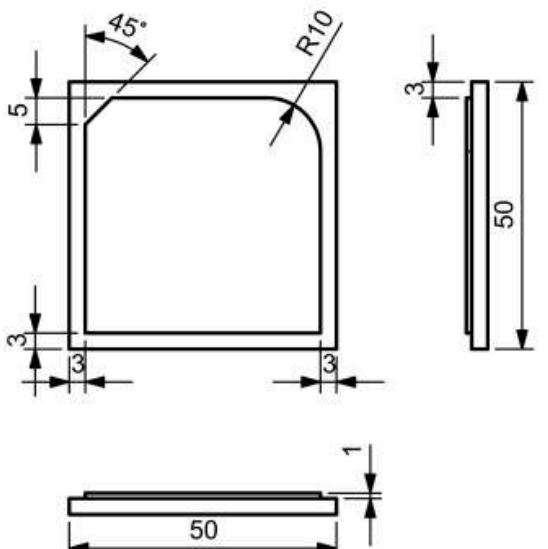
LENGTH OR DIA	MACHININIG DEVIATION TO ISI:2102(MEDIUM GRADE) UNLESS SPECIFIED OTHERWISE															
	UP TO 6	6 30	30 120	120 315	315 1000	1000 2000	2000 4000	4000 ABOVE	LENGTH IN mm OF SHORTER SIDE OF ANGLE				MACHINING FINISH MICRONS			
									UP TO 6	6-30	30-120	120-400	▽	▽▽	▽▽▽	▽▽▽▽
	±0.1	±0.2	±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/CIM/CNC/M2
APPROVED BY:	SCALE : 1:1	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

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
M97	LOCAL SUBPROGRAM CALL
M99	SUBPROGRAM RETURN

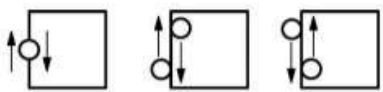
N	SEQUENCE OR BLOCK NUMBER
T	TOOL SELECTION
S	SPINDLE SPEED IN RPM
F	FEED IN mm/min
R	RADIUS OF CIRCLE
P	PROGRAM LINE NUMBER (GO TO N....)
L	REPEATS SUBPROGRAM CALL



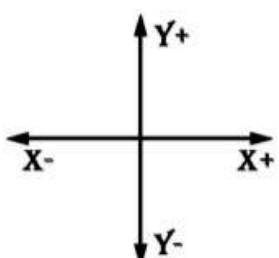
G01



G02 G03



G40 G41 G42



G54-G57

PROGRAM

```
O00001
G28
T1 M06
G54 G40 G90 G21
M03 S1500
M08
G00 X-20 Y25
G00 Z10
G01 Z0 F100
M97 P1 L4

G00 Z10
G28
M09
M05
M30
```

```
N1
G91 G01 Z-0.25
G90 G01 G41 X3 Y25 F300 D01

G01 X3 Y42
G01 X8 Y47
G01 X37 Y47
G02 X47 Y37 R10
G01 X47 Y3
G01 X3 Y3
G01 X3 Y25
G01 G40 X-20 Y25
M99
```

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)