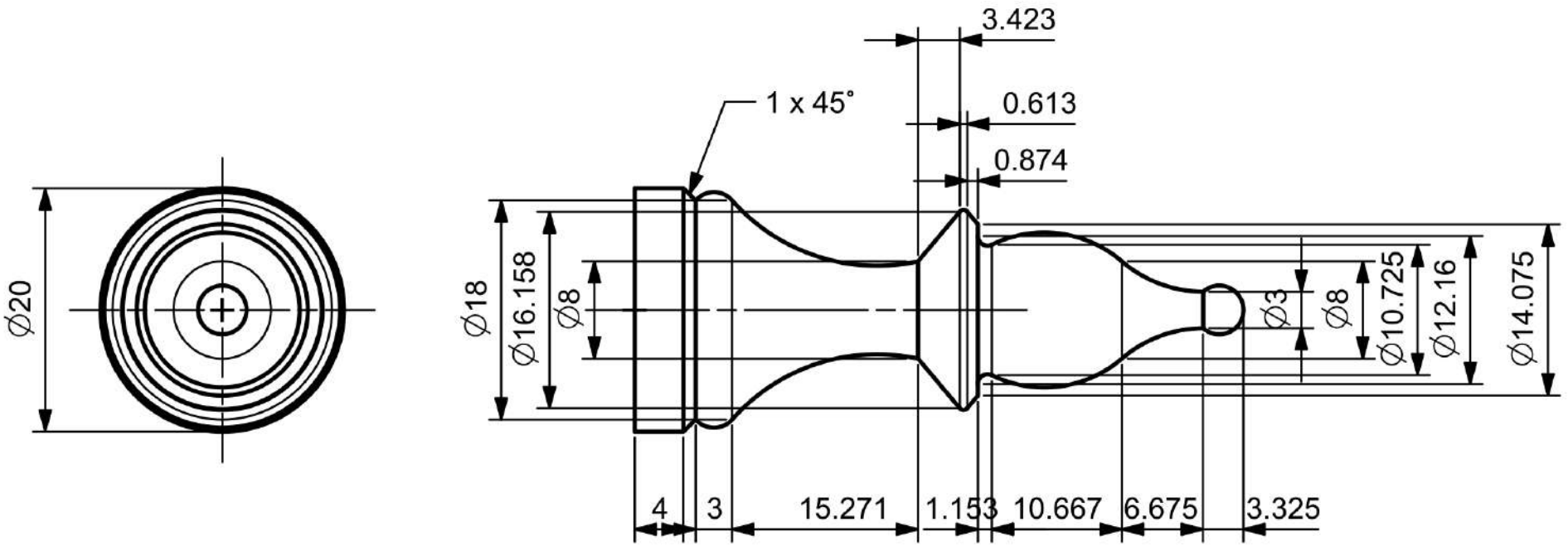
LENGTH OR DIA	MACHININIG DEVIATION TO ISI:2102(MEDIUM GRADE) UNLESS SPECIFIED OTHERWISE															
	UP TO 6	6 30	30 120	120 315	315 1000	1000 2000	2000 4000	4000 ABOVE	LENGTH IN mm OF SHORTER SIDE OF ANGLE				MACHINING FINISH MICRONS			
									UP TO 6	6-30	30-120	120-400	▽	▽▽	▽▽▽	▽▽▽▽
	±0.1	±0.2	±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 : ALUMINIUM	DRG.NO : ME/CIM/CNC/M2	
APPROVED BY:	SCALE :	QTY :	

PREPARATORY FUNCTIONS

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
G96	CONSTANT SURFACE SPEED COMMAND (S-CUTTING SPEED, LIMS- MAX. RPM)
G97	SPINDLE SPEED COMMAND (S- RPM)

MISCELLANEOUS FUNCTIONS

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

ADDRESS CHARACTERS

N	SEQUENCE OR BLOCK NUMBER
T	TOOL SELECTION
D	OFFSET PAGE NUMBER
S	SPINDLE SPEED IN RPM
F	FEED IN mm/rev
CR	RADIUS OF ARC
R	R PARAMETERS (VARIABLES)

CYCLE

CYCLE95	STOCK REMOVAL

FUNCTIONS

IF	CONDITION (TRUE OR FAULT)
GOTO	JUMP MARKER
=	ASSIGNMENT
==	EQUAL
>	GREATER THAN
<	LESS THAN
>=	GREATER THAN OR EQUAL
<=	LESS THAN OR EQUAL

PROGRAM

```
N10
G75 X0 Z0
T4D1
G00 X0 Z0
M00
G75 X0 Z0
M01

N20
G75 X0 Z0
T1D1
G97 S1500 M03
M08
G00 X28 Z2
G01 X28 Z0 F0.05
G01 X-1 Z0
G00 X28 Z2
G75 X0 Z0
M01

N30
G75 X0 Z0
T7D1
G96 S200 LIMS=1500 M03
M08
G00 X28 Z2
CYCLE95( "AB:BC", 1.00000, 0.20000, 0.40000, 0.00000, 0.10000, 0.10000,
0.05000, 9,  , ,)
G00 X28 Z2
G75 X0 Z0
M05
M09
M01


N40
G75 X0 Z0
T3D1
G97 S600 M03
```

```
M08
G00 X28 Z2
G00 X28 Z-54
R1=20
N1005
G01 X=R1 Z-54 F=0.1
G01 X=R1+0.5 Z-54
R1=R1-0.5
IF R1>=-1 GOTO N1005
IF R1<-1 GOTO N1006
N1006
G00 X28 Z-54
G00 X28 Z2
G75 X0 Z0
M09
M05
M30
```

```
AB:
G01 X0 Z0
G03 X3 Z-3.325 CR=2
G02 X8 Z-10 CR=10.324
G03 X10.724 Z-20.666 CR=10.324
G02 X12.160 Z-21.819 CR=.8
G01 X14.075 Z-21.819
G01 X16.158 Z-22.693
G03 X16.158 Z-23.306 CR=.4
G01 X8 Z-26.729
G02 X18 Z-42 CR=15.848
G03 X18 Z-45 CR=2
G01 X20 Z-46
G01 X20 Z-54
G01 X26 Z-54
BC:
```