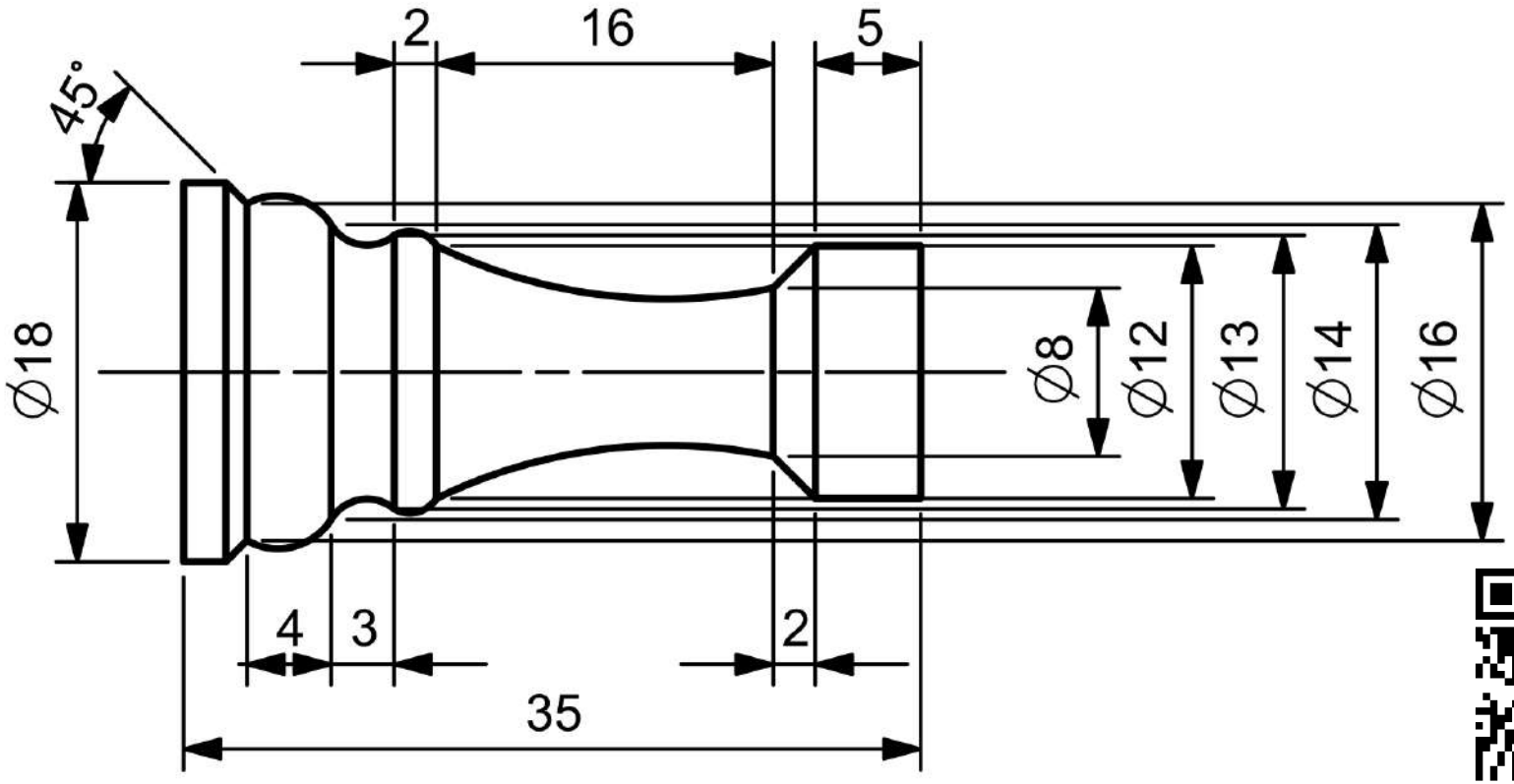
LENGTH OR DIA	MACHININIG DEVIATION TO ISI:2102(MEDIUM GRADE) UNLESS SPECIFIED OTHERWISE															
	UP TO 6	6 30	30 120	120 315	315 1000	1000 2000	2000 4000	4000 ABOVE	LENGTH IN mm OF SHORTER SIDE OF ANGLE				MACHINING FINISH MICRONS			
									UP TO 6	6-30	30-120	120-400	▽	▽▽	▽▽▽	▽▽▽▽
	±0.1	±0.2	±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 :	
APPROVED BY:	SCALE : 2:1	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)

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

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

FUNCTIONS

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

PROGRAM

```
;***STOPPER***
N10
G75 X0 Z0
T4 D1 ; SLEEVE (STOPPER)
G00 X0 Z0
M00
G75 X0 Z0
M01

;***FACING***
N20
G75 X0 Z0
T1 D1 ; PCLNR 2020 K12
G96 S200 LIMS=1500 M03
M08
G00 X22 Z2
G01 X22 Z0.25 F0.1
G01 X-2 Z0.25
G00 X22 Z2
G01 X22 Z0 F0.1
G01 X-2 Z0
G00 X22 Z2
G75 X0 Z0
M05
M09
M01

;***CONTOURING***
N30
G75 X0 Z0
T7 D1 ; MVJNR 2020 K16
```

```
G96 S200 LIMS=1500 M03
M08
G00 X22 Z2
CYCLE95( "AB:BC", 1.00000, 0.20000, 0.40000, 0.00000, 0.15000, 0.10000, 0.05000, 9,  , ,)
G00 X22 Z2
G75 X0 Z0
M05
M09
M01

;***PARTING***
N40
G75 X0 Z0
T3D1 ; CFIR 2020 K06
G97 M03 S1200
M08
G00 X22 Z2
G00 X22 Z-38
R1=20
N100
G01 X=R1 Z-38 F0.05
G01 X=R1+0.5 Z-38
R1=R1-2
IF R1>=-1 GOTO N100
IF R1<-1 GOTO N200
N200
G00 X22 Z-38
G00 X22 Z2
G75 X0 Z0
M09
M05
M30

;***CONTOUR***
AB:
```

```
G01 X0 Z0 F0.1
G01 X12 Z0
G01 X12 Z-5
G01 X8 Z-7
G01 X8 Z-9
G02 X12 Z-23 CR=25
G03 X13 Z-25 CR=1.5
G02 X14 Z-28 CR=2
G03 X16 Z-32 CR=3
G01 X18 Z-33
G01 X18 Z-35
G01 X18 Z-38
G01 X20 Z-38
BC:
```