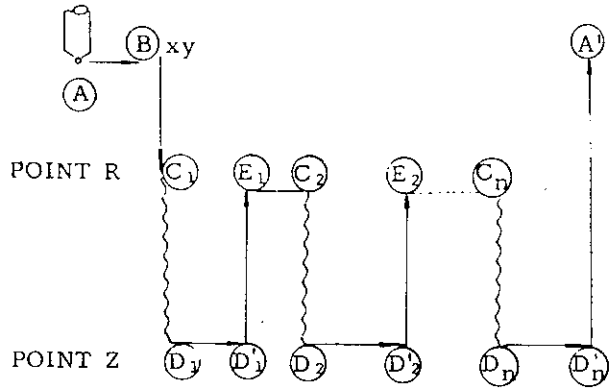
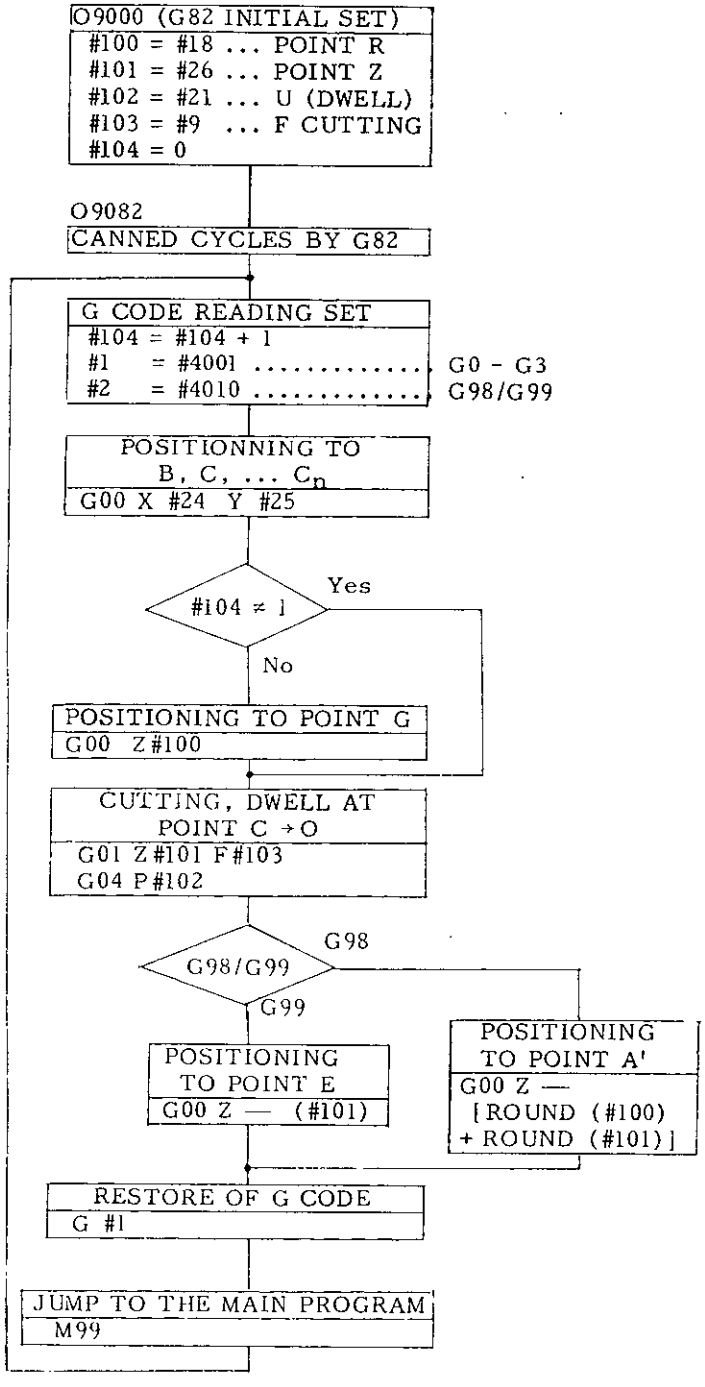
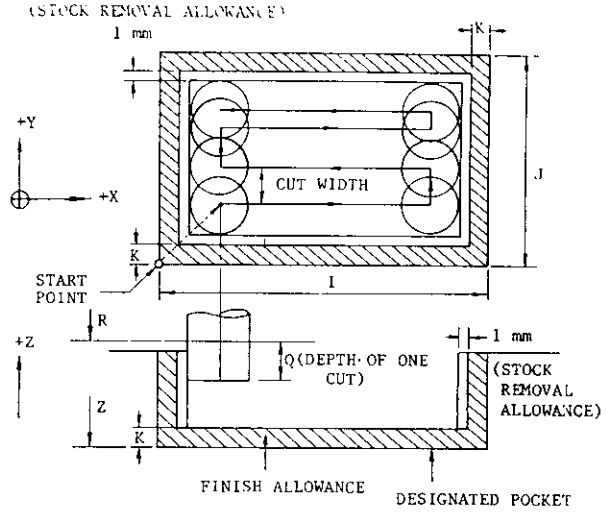




(2) Pocket Mill

A. The cycle for the pocket machining shown below is created by user macros as follow:



B. Macro Call Command

G65 P9061 X··· Y··· Z··· R··· I··· J··· K···
T··· Q··· D··· F··· E··· ;

where,

X, Y: The absolute coordinate values of the start point (the lower left position of the pocket).

Z: The absolute position of the bottom of the pocket.

R: The absolute position of rapid traverse tool return.

I, J: X-axis and Y-axis lengths of the pocket (unsigned).

K: Finish allowance (left-over allowance, unsigned). Default value is 0.

T: Cut width rate (designated in %).
Cut width = tool radius x T/100

Q: Z-axis cut depth for each time (unsigned).

D: Tool offset number.

F: Feedrate on XY plane.

E: Feedrate at Z-axis cut.
(Tool is fed 4 times as fast as E up to the point 1 mm to the preceding cut bottom.)