



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
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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: