70

5

9

R7

R29

ENGRAVING
DEPTH = 0.05

45°

70

21

10

10

15

TITLE :		
DRAWN BY :	**TKMCE**	
CHECKED BY :	MATERIAL : ALUMINUM	DRG.NO : ME/WS/MO/CNC/M1
APPROVED BY :	SCALE : 2:1	QTY : 1

A4

PREPARATORY FUNCTION

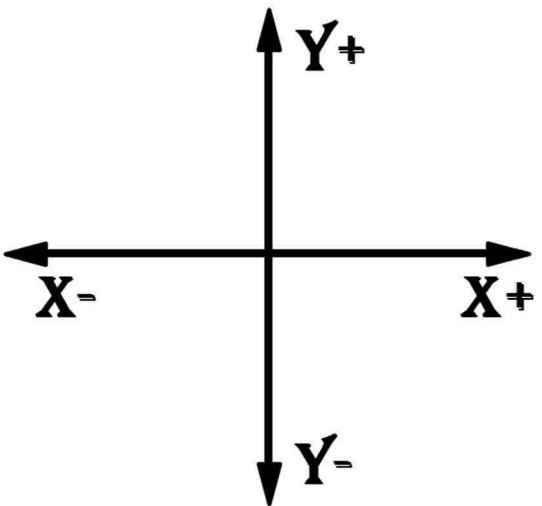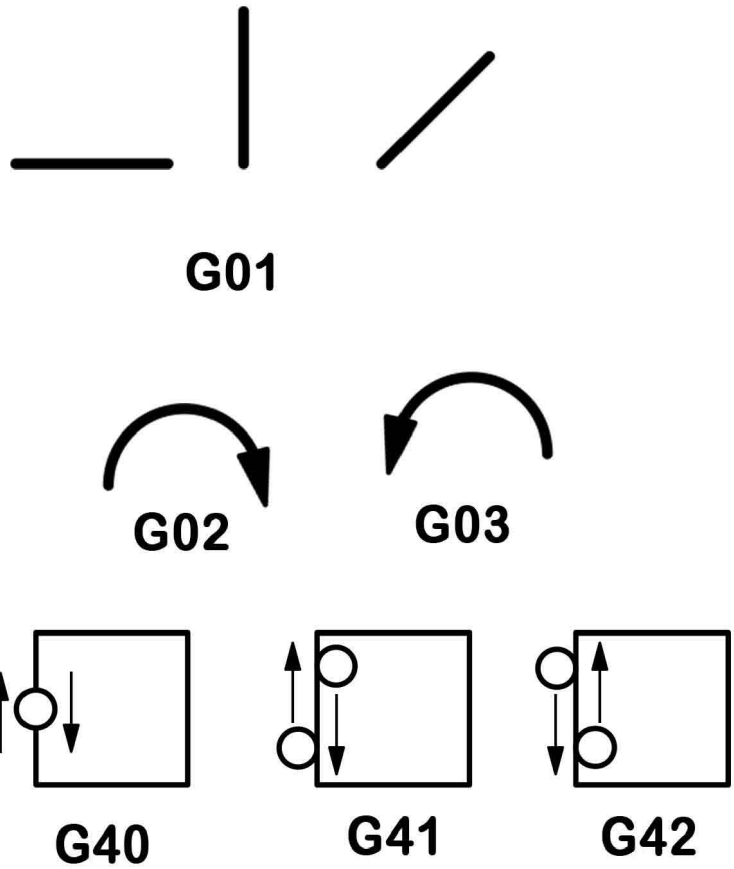| G00	RAPID POSITIONING
G01	LINEAR INTERPOLATION
G02	CW CIRCULAR INTERPOLATION
G03	CCW CIRCULAR INTERPOLATION
G20	DIMENSION IN INCH
G21	DIMENSION IN MM
G28	RETURN TO HOME
G40	NO CUTTER RADIUS COMPENSATION
G41	CUTTER RADIUS COMPENSATION-LEFT
G42	CUTTER RADIUS COMPENSATION-RIGHT
G54-G57	WORK ZERO (ZERO OFFSET)
G90	ABSOLUTE DIMENSION
G91	INCREMENTAL DIMENSION

PREPARATORY FUNCTION FOR MOVEMENT
 G00, G01, G02,...
PREPARATORY FUNCTION FOR PRESETTING
 G20, G54, G90,...

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

N	SEQUENCE OR BLOCK NUMBER
T	TOOL SELECTION
S	SPINDLE SPEED IN RPM
F	FEED IN mm/min
R	RADIUS OF CIRCLE

G01

G02 **G03**

G40 **G41** **G42**

Y+
X- X+
Y-

G54-G57

PROGRAM

O00001

G28

T1 M06

G54 G40 G21 G90

M03 S1500

M08

G00 X10 Y10

G00 Z10

G01 Z-0.05 F100

G01 X10 Y31 F300

G02 X39 Y60 R29

G01 X48 Y60

G02 X55 Y53 R7

G01 X55 Y25

G01 X40 Y10

G01 X10 Y10

G00 Z10

G28

M09

M05

M30

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)