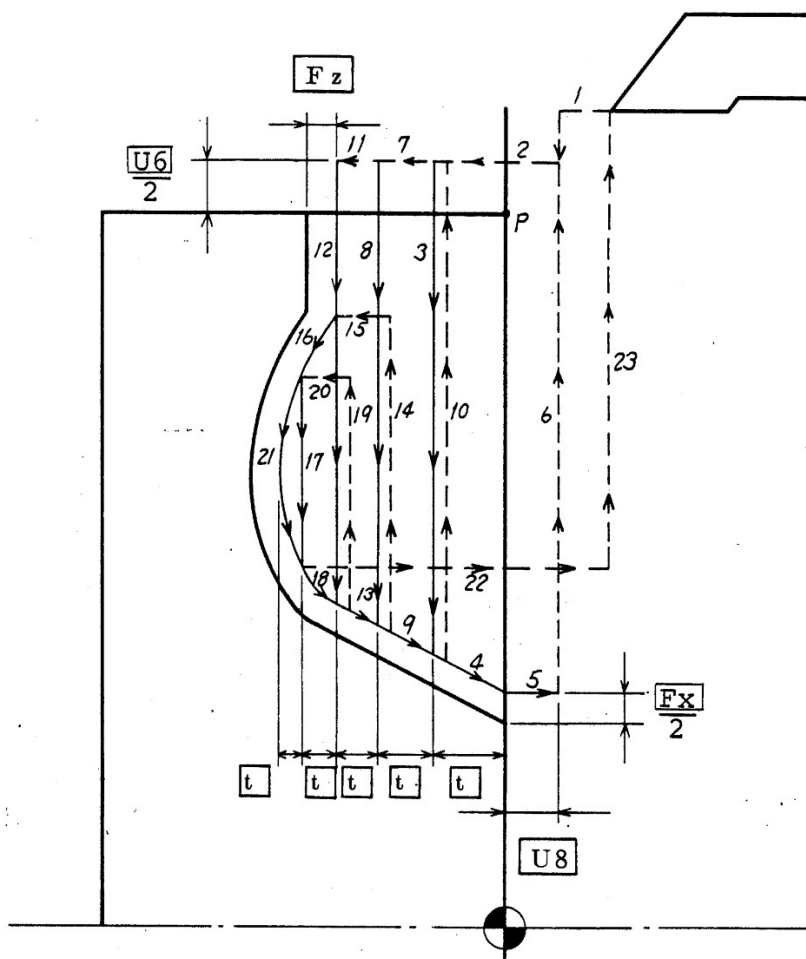3-3-6   Tool path in BAR FCE rough cutting

P :   CPT-X, Z set by program process data

t_1:   DEPTH (first cut) set by program process data

F_x: FIN-X set by program common data " PNO 0".

F_z: FIN-Z set by program common data " PNO 0"

U6:   Safety contour clearance (O.D.) set by parameter U6 .

U8:   Safety contour clearance (face) set by parameter U8 .

Notes (1)   The tool paths 3, 8 and 12 are the same as tool paths
            10, 14 and 19, respectively.

      (2)   As in BAR OUT roughing cycle, the feedrate increases at
            the tool path 21 portion. The parameter U23 is used to
            determine whether feedrate should be increased or not.
            The feedrate increase rate is set by the parameter U56
            and U57 .