MILLING - MIRROR

120

120

(0,0)

25
25
25
25

Ø6mm
1mm depth

DATE	EXPT. TITLE :	PAGE NO. ☐
EXP. NO.		

Blank   maximum : $x = 50$, $y = 50$

minimum : $x = -50$, $y = -50$

O1001

G21   G94

G91   G28   ~~Z0~~

G28   X0   Y0

M06   T0101

M03   S1500

G90   G00   X0   Y0   ~~Z0~~   Z5

~~G01 Z-5 F35~~   M98   P0015000

M70

M98   P015000

M80

M70

M71

M98   P0015000

M80

M81

M71

M98   P0015000

G00   Z5

G91   G28   Z5

M05   M30

O5000

G00   X25   Y12
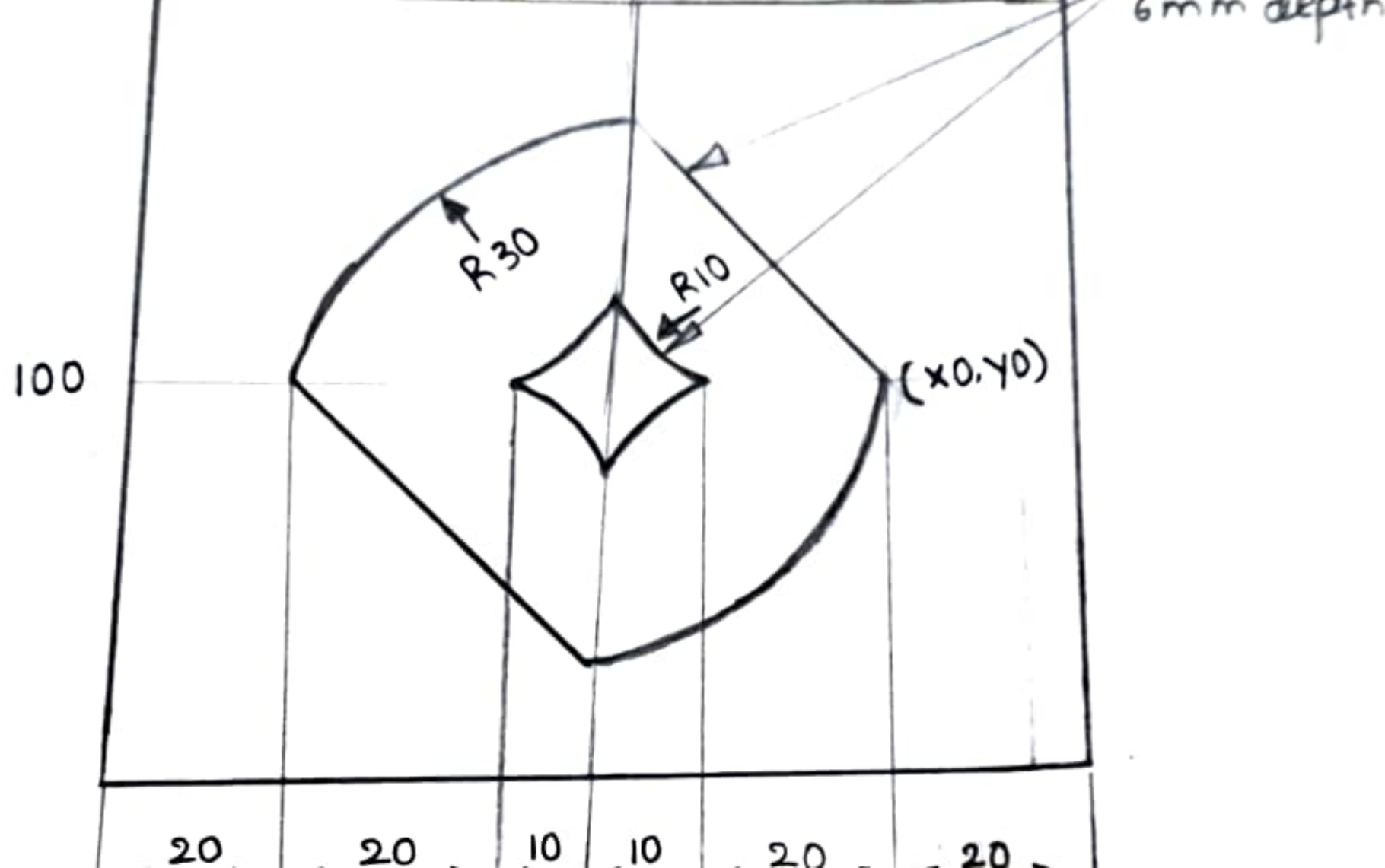
G01   Z-5   F35   G00   Z5

G01   X37.5   Y24.5   G00   X0   Y0

G01   X0   Y37   M99.

G01   X12.5   Y24.5

G01   X25   Y12

6 mm depth

R30

R10

100

(x0, y0)

| 20 | 20 | 10 | 10 | 20 | 20 |

Blank : Maximum x=20 ; y=50

Minimum x = -80; y=-50

4- Pages Pdf
Problem NO: 2

O1001

G21 G94

G91 G28 20

G28 X0 Y0

M06 T0101

M03 S1500

G90 G00 X0 Y0 25

G01 Z-1 F35

G01 X-30 Y30

G03 X-60 Y0 R30

G01 X-30 Y-30

G03 X0 Y0 R30

G00 Z5 → G01 Z-1 F35

G00 X20 Y0 F35
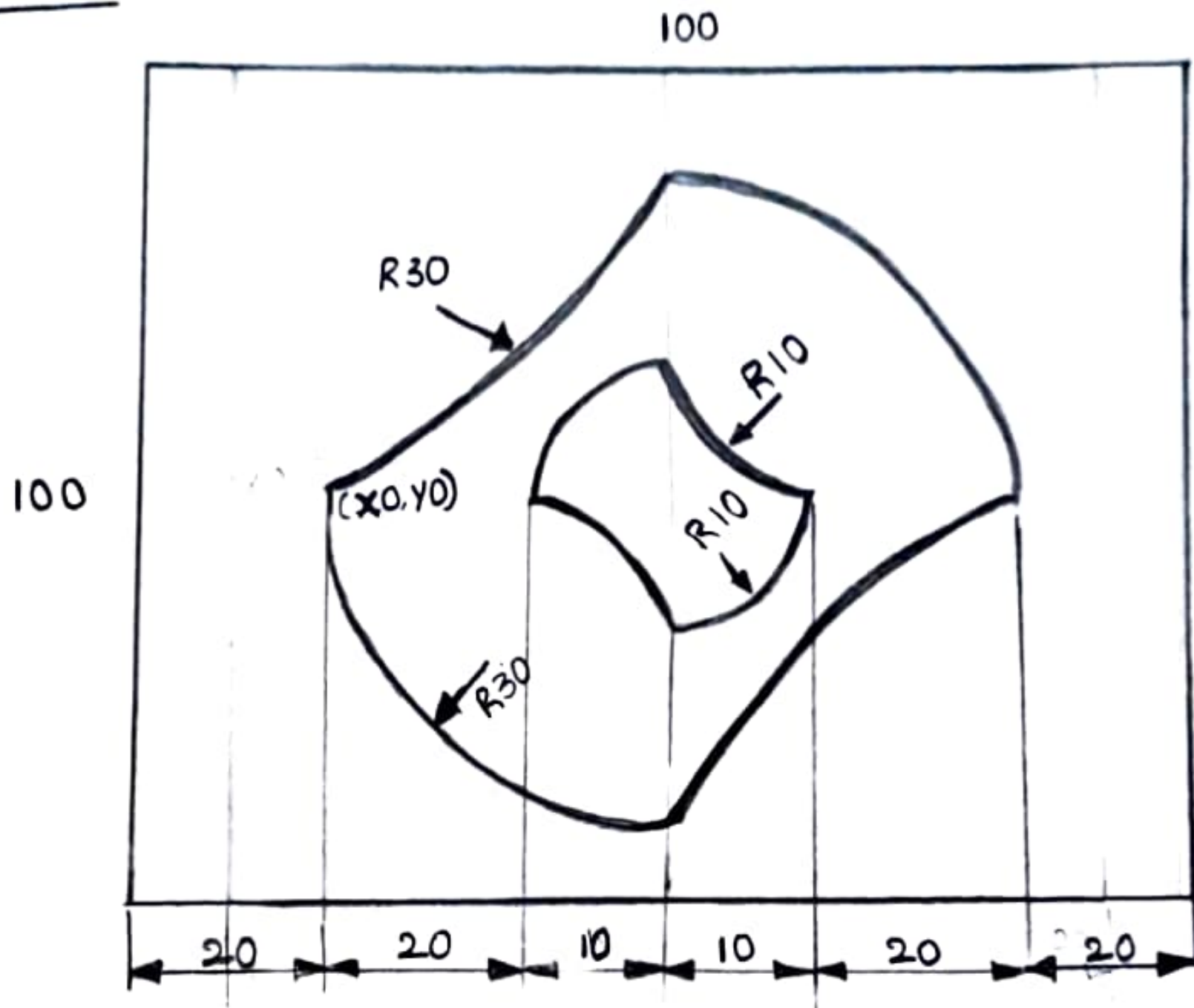
G02 X-30 Y10 R10

G02 X-40 Y0 R10

G02 X-30 Y-10 R10

G02 X-20 Y0 R10

G00 Z5 G00 Z5

G91 G28 Z0

G28 X0 Y0

M05 M30

100

100

R30

R10

(x0,y0)

R10

R30

20   20   10   10   20   20

Blank: maximum $x = 80$ $y = 60$

minimum $x = -20$ $y = -40$

4 pages pdf

Program No: 3.

```
O1002
G21     G94
G91     G28   Z0
G28     X0    Y0
M06     T0101
M03     S1500
G90     G00   X0    Y0    Z0
G01     Z-1   F35
G03     X30   Y30   R30
G02     X60   Y0    R30
G03     X+30  Y-30  R30
G02     X0    Y0    R30.
G00     X20 25 Y0   .
G00     X20   Y0    25
G01     Z-1   F35
G02     X30   Y10   R10
G03     X40   Y0    R10
G02     X30   Y-10  R10
G03     X20   Y0    R10
G00     25
G91     G28   Z0
G28     X0    Y0
M05
M30.
```
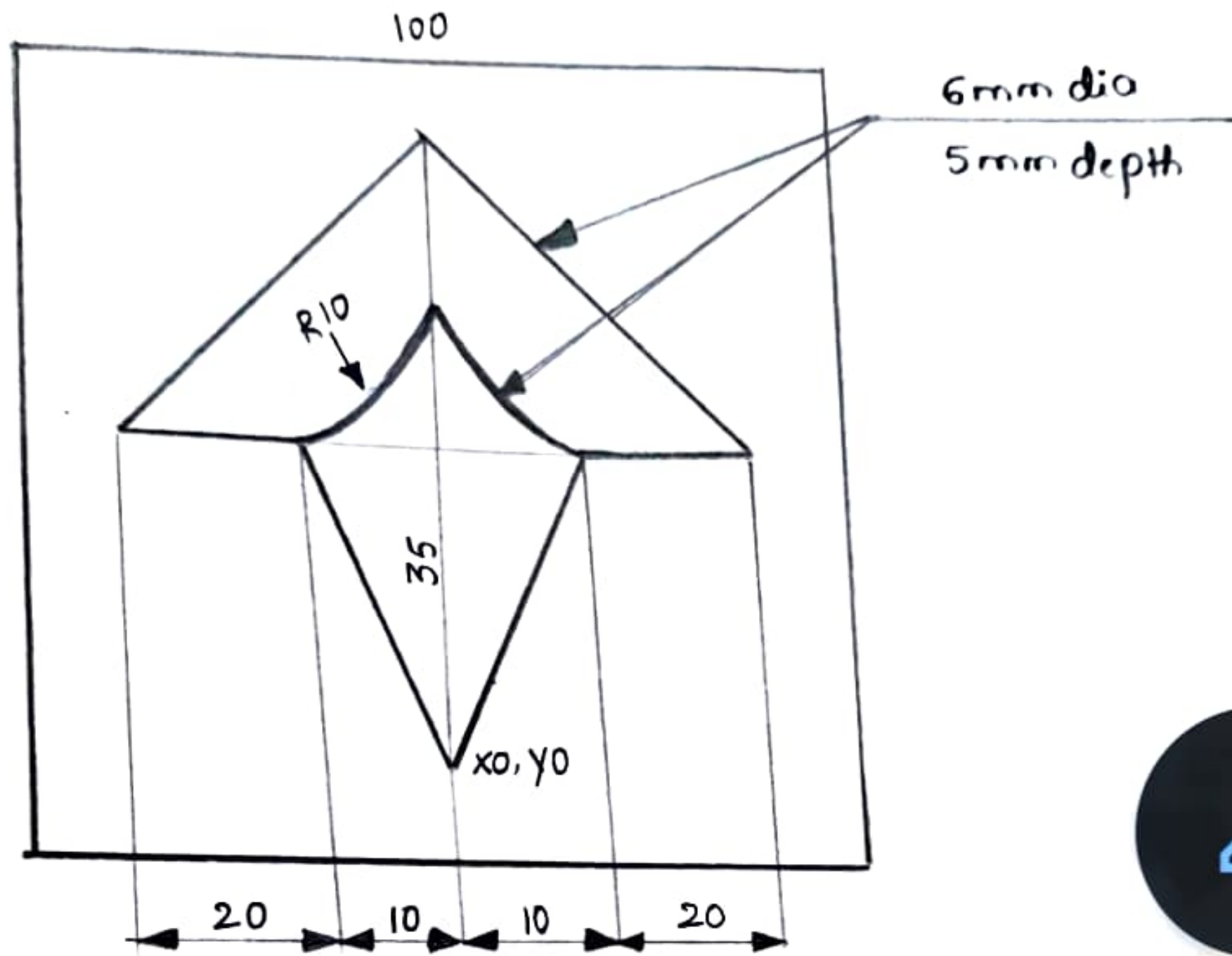
100

6mm dia

5mm depth

R10

35

xo, yo

20

10

10

20

$$\begin{array}{r} 100 \\ -15 \\ \hline 85 \end{array}$$

Blank: maximum $x = 50$ $y = 85$
         minimum $x = -50$ $y = -15$

O1003

4 pages pdf
program No: 4

G21   G94

~~G07~~ G91   G28   Z0   ~~Y0~~

G28   X0 Y0

M06   T0101

M03   S1500

G90   G00   X0   Y0   Z0

G01   Z-1   ~~X~~ F35

G01   X-10   Y35

G03   X0   Y45   R10

G03   X10   Y35   R10 → G00   Z5

G01   X0   Y0

G00   X-10   Y35 → G01   Z-1   F35

G01   X30   Y35

G01   X0   Y65

G01   X30   Y35

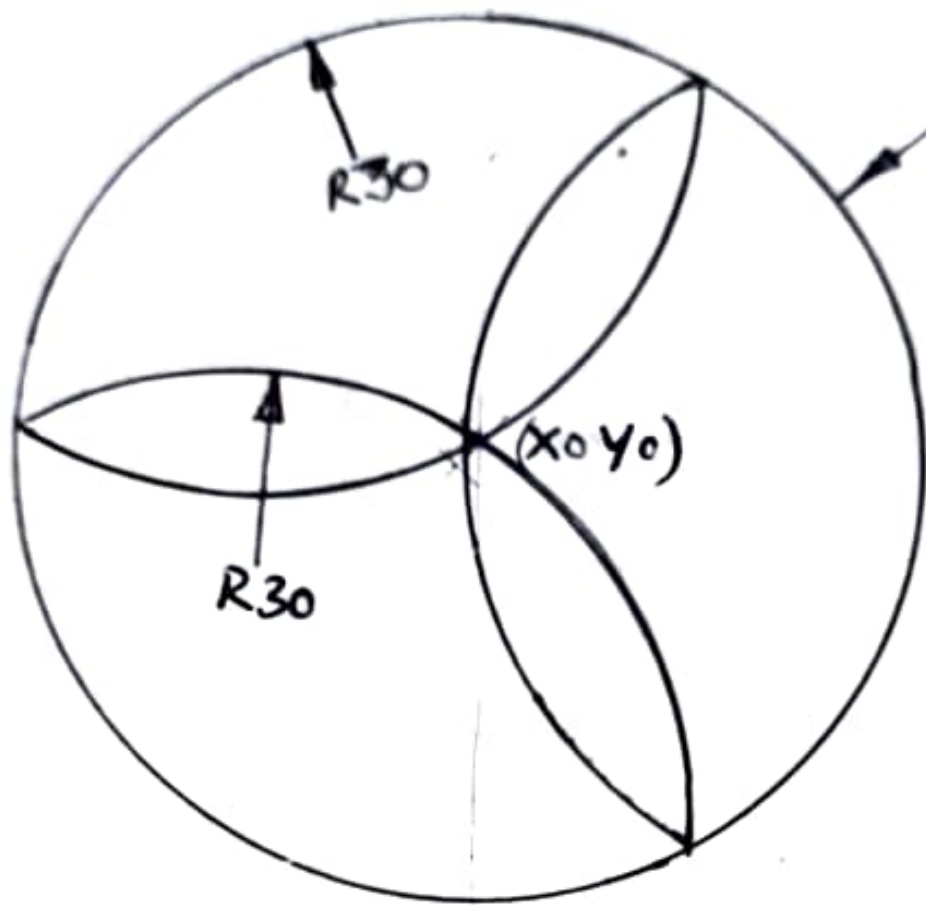G01   X10   Y35

G00   Z5

G91   G28   Z0

G28   X0   Y0

M05

M30.

100

6mm dia
1mm depth

R30

R30

$(x_0 y_0)$

100

Blank   max : $X = 50$ $y = 50$

min : $X = -50$ $y = -50$

```
O1010
G21    G94
G28    X0 Y0        G91  G28  X0
G28    X0 Y0
M06    T0101
M03    S1500
G90    G00   X0   Y0   F50
G01    X-30    Y0
G01    Z-5
G02         X30    Y0   R30
G02         X-30   Y0   R30
G02         X15    Y-25  R30
G02         X15    Y25   R30
G02         X-30   Y0    R30
G00         Z0
G28    X0  Y0
M05    M30
```
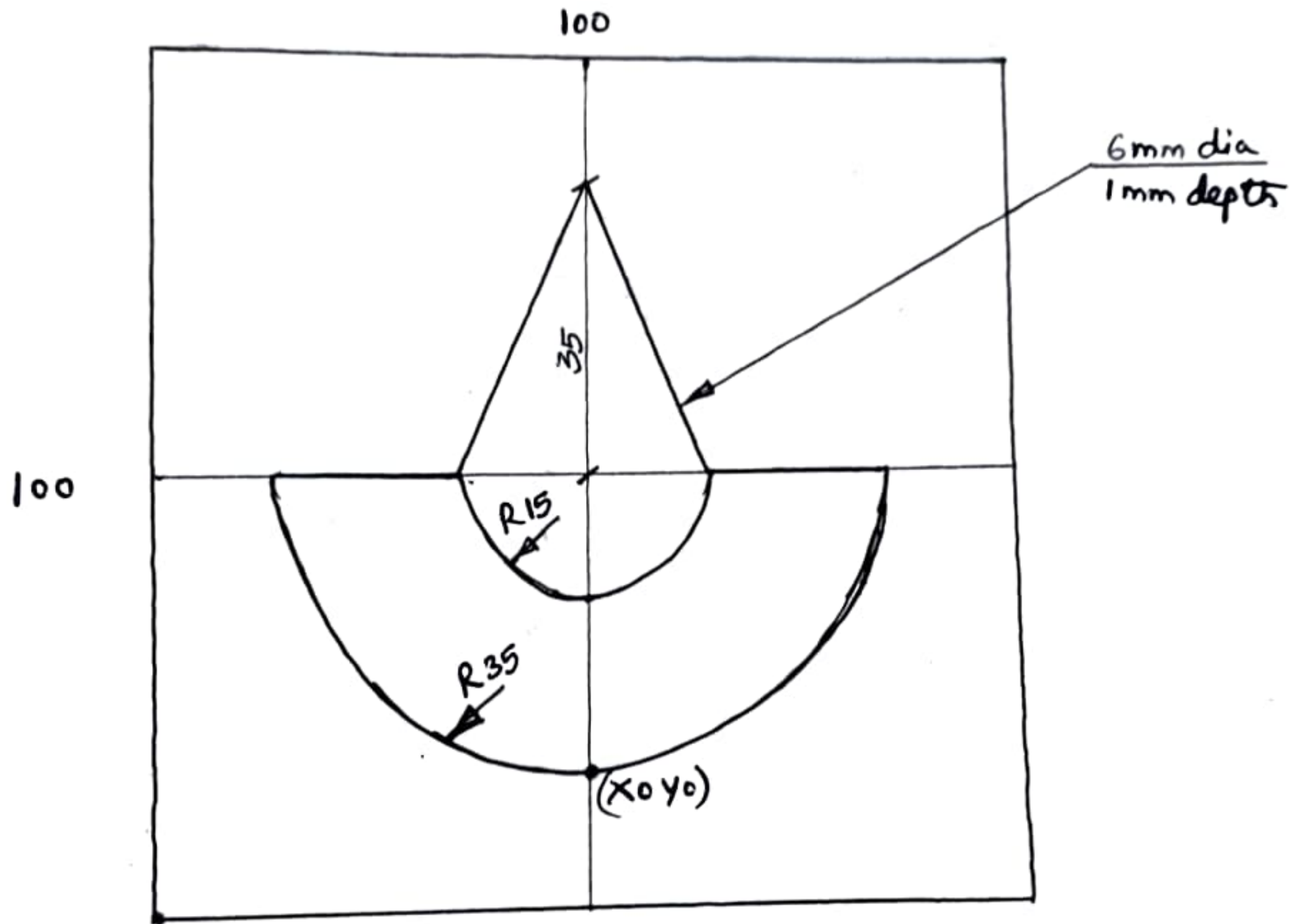
6 Page Pdf

Program No. 1

100

100

6mm dia
1mm depth

35

R15

R35

(Xo Yo)

Blank

	maximum :	$x = 50$	$y = 85$
	minimum :	$x = -50$	$y = -15$

o1004

6page Pdf

program NO:2

G21	G94
G91	G28	Z0
G28	X0	Y0
M06	T0101
M03	S1500
G90	G00	X0	Y0	Z0
G01	Z-1	F35
G03	X35	Y35	R35
G01	X15	Y35
G02	X0	Y20	R15
G02	X-15	Y35	R15
G01	X-35	Y35
G03	X0	Y0	R35
G00	Z5
G00	X 15	Y35	Z5
G01	Z-1	F35
G01	X0	Y70
G01	X-15	Y35
G00	Z5
G91	G28	Z0
G28	X0	Y0
M05
M30

φ6mm
Depth 5mm

120

R40

120

(0,0)

R40

20 20
40   40
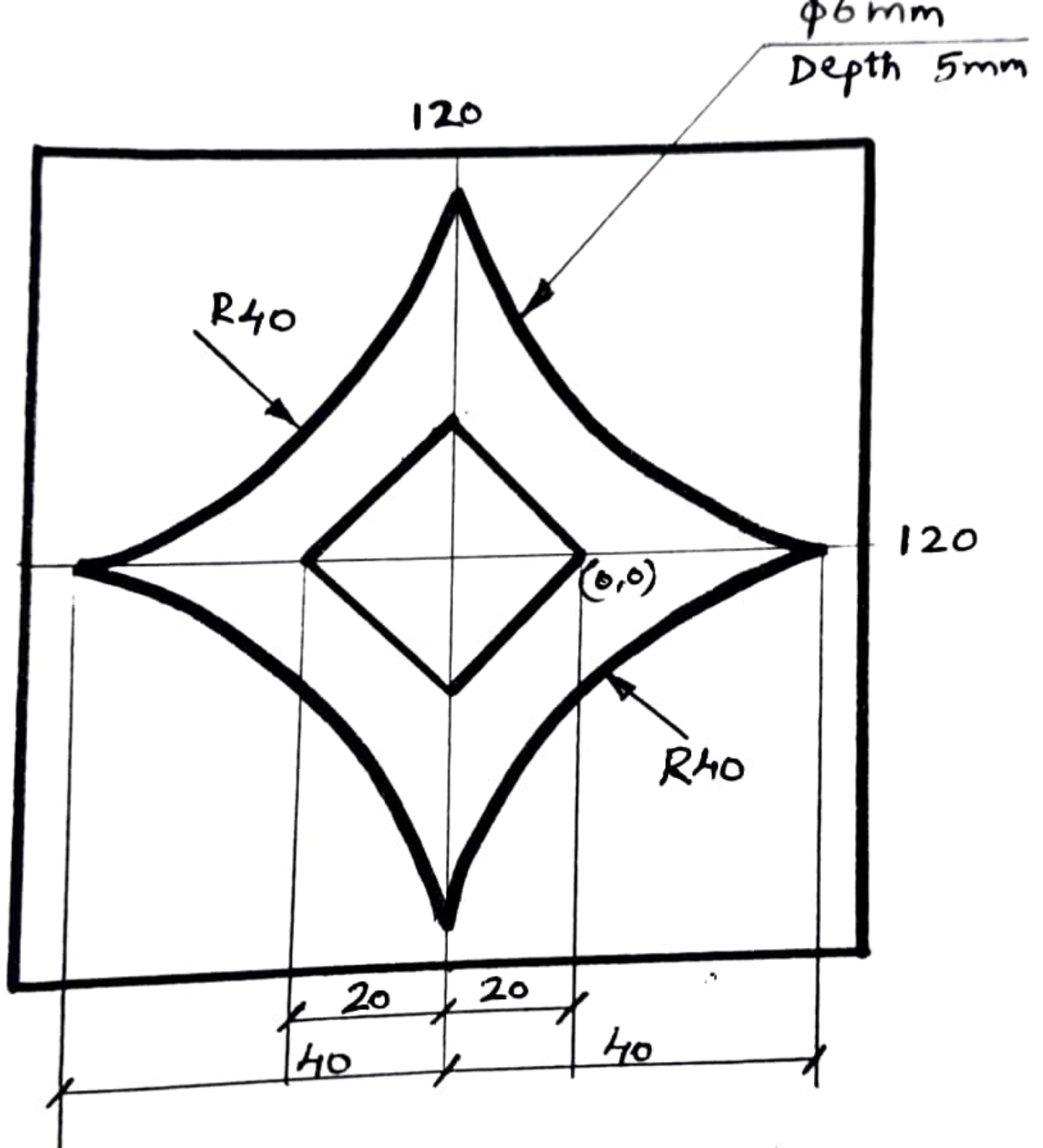
maximum :   X = 40   y = ~80 60

minimum :   X = -80   y =   -60

Blank

6page Pdf

Program   NO:3

```
O1005
G21    G94
G91    G28  Z0
G28    X0  Y0
M06    T01 01
M03    S1500
G90    G00  X0    Y0    Z0
G01    Z-5  F35
G01    X-20  Y20
G01    X-40  Y0
G01    X-20  Y-20
G01    X0  Y0
G00    Z5
G00    X20   Y0     Z0
G01    Z-5   F35
G02    X-20  Y40  R40
G02    X-60  Y0   R40
G02    X-20  Y-40 R40
G02    X20   Y0   R40
G00 Z5
G91    G28  Z0
G24    X0  Y0
M05
M30.
```
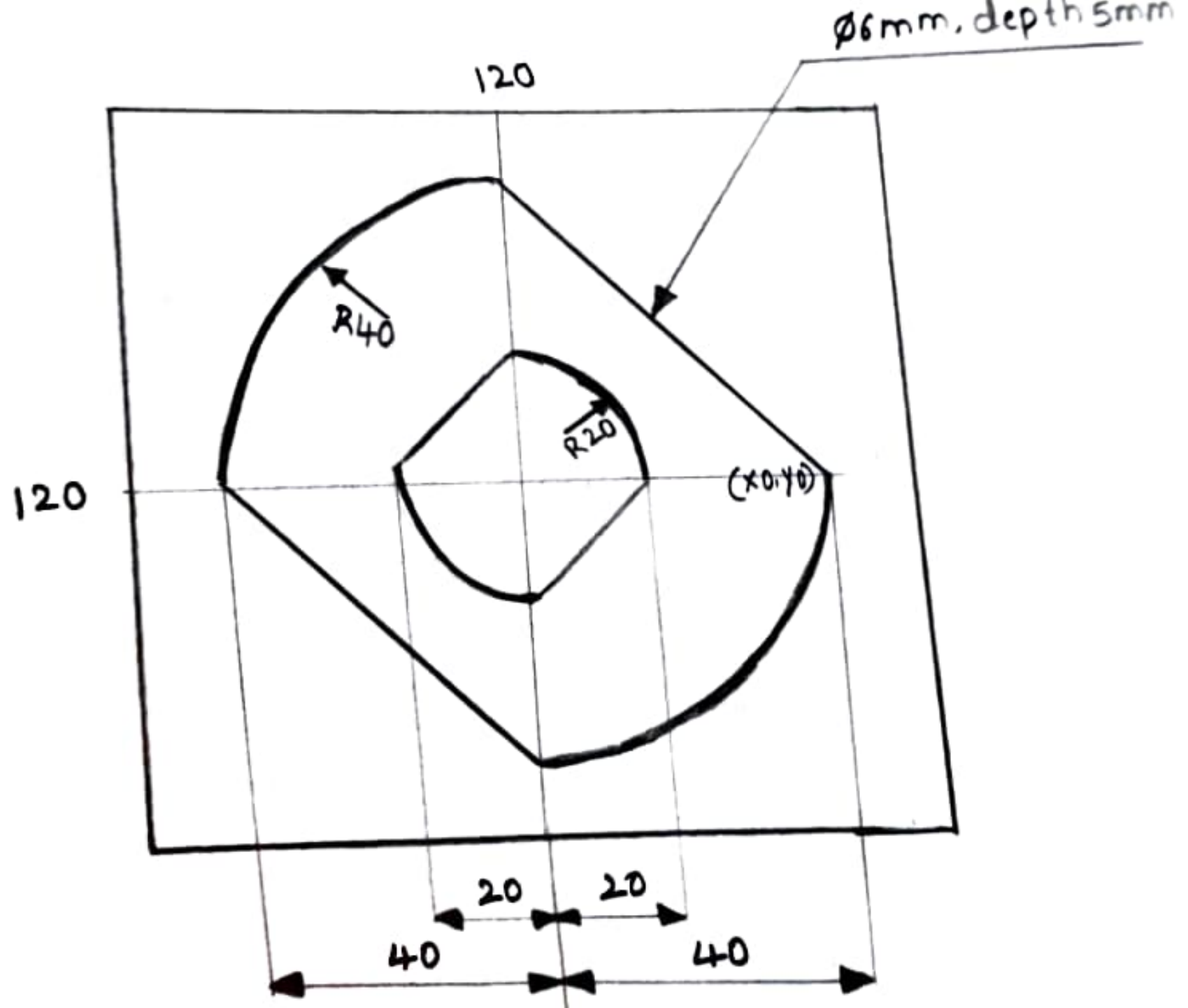
Ø6mm, depth 5mm

120

120

R40

R20

(xo,yo)

20   20

40   40

maximum : $x = 50$ 20

minimum : $x = -100$

$y = 50$ 60

$y = 80$ -60

O1005

cop G21   G98

G91   G28   20

G28   X0   Y0

M06   T0101

M03   S1500

G90   G00   X0   Y0   20

G01   Z-5   F35

G01   X-40   Y+40

G03   X-80   Y0   R40

G01   X-40   Y-40

G03   X0   Y0   R40   → G00 25

G00   X-20   Y0   → G01   Z-5   F35

G03   X-40   Y20   R20

G01   X-60   Y0

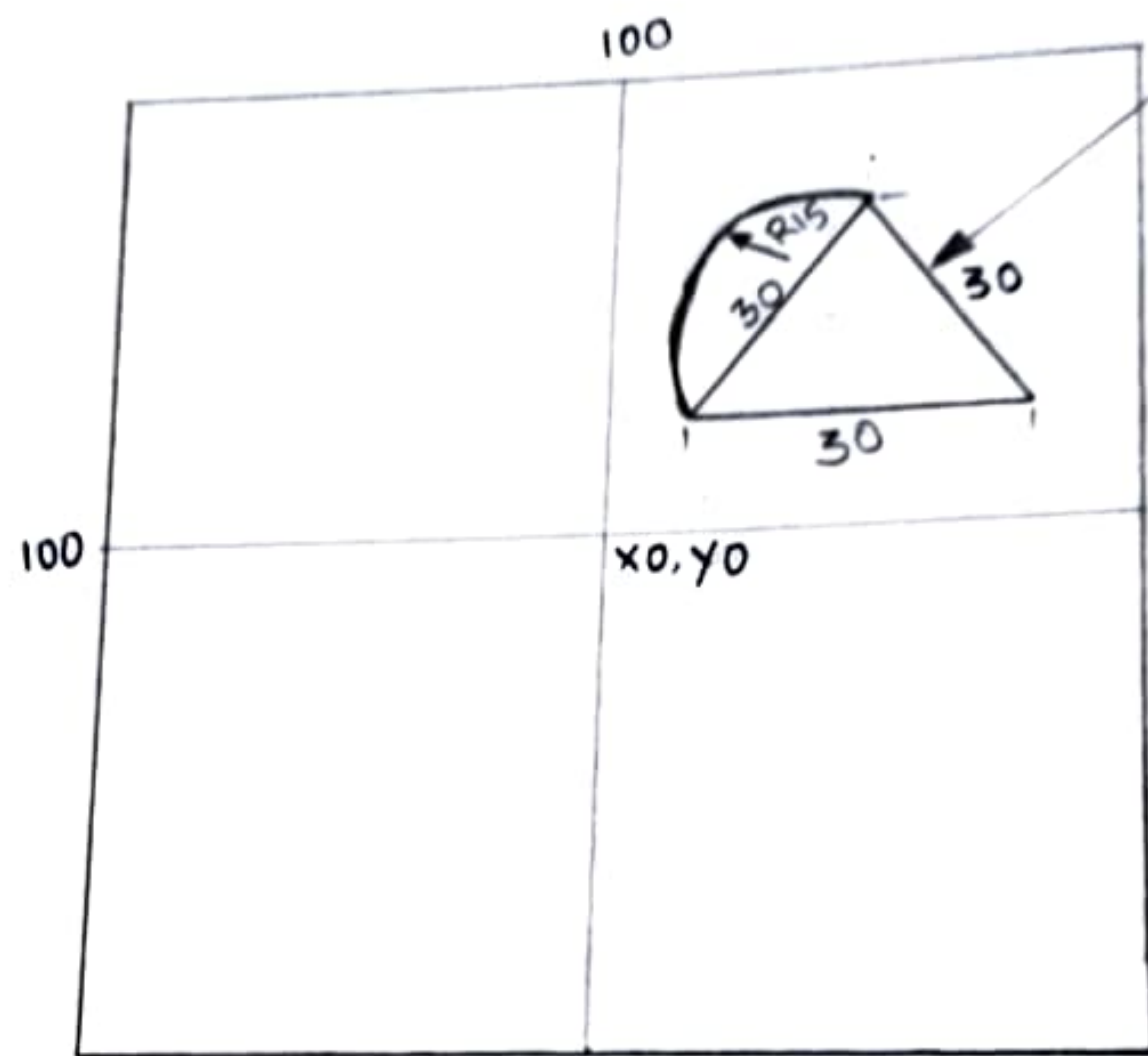G03   X-40   Y-20   R20

G01   X-20   Y0

G00   25

G91   G28   20

G28   X0   Y0

M05

M30.

6 page pdf

Program No:4.

MILLING — MIRRORING

100

6mm dia
1mm depth

R15
30
30
30

100

xo, yo

Blank:

maximum: $x=50$, $y=50$.
minimum: $x=-50$, $y=-50$.

6 page Pd
5: on unatory
Program:

```
O1009
G21
G91
G28 X0 Y0
M06 T0101
H03 S1500
G90 X0 Y0 Z5
M98 P001S000
M70
M98 P001S000
M80
M81
M71
M98 P001S00
G00 S2
G91 G28 X0 Z0
M05 M30.
O5000
G00 15 Y12
G01 Z-5 F35
G01 X30 Y38
G01 X45 Y12
G01 X15 Y12
G02 X30 Y38 R15
G00 Z5
G00 X0 Y0
M99
```