

SECTION 48

PROGRAMMING EXAMPLES

DRAWING No.	TEST 1
DESCRIPTION	PROGRAM 1
PROGRAMME No.	1
MATERIAL	BRASS
PROGRAMME BY	T QUARMBY
DATE	06/03/85

TOOLING & SETTING DATA

TOOL 1 R.H. KNIFE TOOL
TOOL 2 THREADING TOOL
TOOL 3 PARTING TOOL

Starturn

BILLET LENGTH 40mm
BILLET DIA 19mm

N	G	X/R	Z	F	S	T	M	REMARKS
1	00	15	5					RAPID TRAVERSE
2						1	06	TOOL CHANGE (TOOL 1)
3					500		03	SPINDLE FWD
4	00	9.2	0.2					RAPID TRAVERSE
5	91							INCREMENTAL
6	73	3						DO-LOOP (3 TIMES)
7	00	-1						INCREMENTAL CUT DEPT
8	01		-15.2	40				INCREMENTAL C LENC
9	00		15.2					RAPID RETURN
10	06							END DO-LOOP
11	90							ABSOLUTE FORMAT
12	00	5	0.2					RAPID TRAVERSE
13	01	6.2	-1	40				LINEAR
14	00	5	0.2					RAPID TRAVERSE
15	01	4.5	0.2					LINEAR
16	01	6	-1.5					LINEAR
17	01	6	-15					LINEAR
18	02	9	-18					CIRCULAR CW RAD.3
		3						
19	01	9	-20					LINEAR
20	00	10	-20					RAPID TRAVERSE
21	00	15	5					RAPID TRAVERSE
22							05	SPINDLE STOP
23						2	06	TOOL CHANGE (TOOL 2)
24					180		03	SPINDLE FWD
25	00	6	3					RAPID TRAVERSE
26	33	5.4	-10	PITCH 1.75 CUTS 35				THREADING
27	00	15	5					RAPID TRAVERSE
28							05	SPINDLE STOP
29							06	TOOL CHANGE (TOOL 3)
30					500		03	SPINDLE FWD
31	00	9.5	-22					RAPID TRAVERSE
32	01	-0.2						LINEAR
33	00	12						RAPID TRAVERSE
34	00	15	5					RAPID TRAVERSE
35							02	END OF PROGRAM

DRAWING No.	TEST 2
DESCRIPTION	PROGRAM 2
PROGRAMME No.	2
MATERIAL	MILD STEEL
PROGRAMME BY	S CROWTHER
DATE	15/9/85

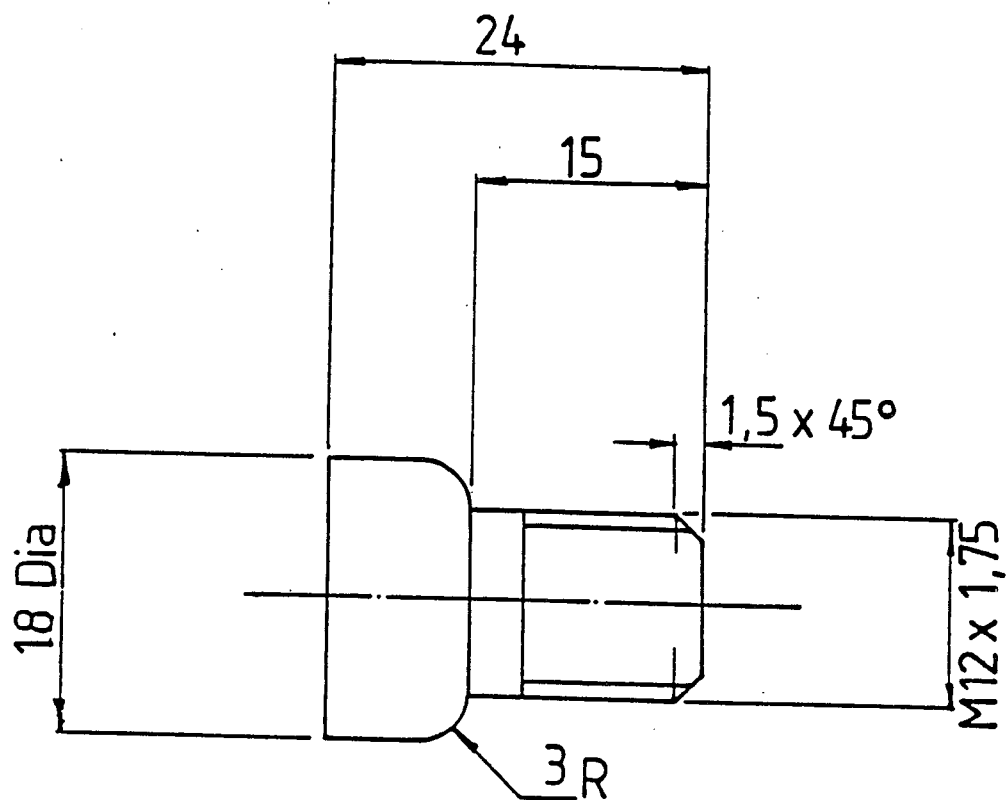
TOOLING & SETTING DATA

TOOL 1 RH KNIFE TOOL
TOOL 2 THREADING TOOL
TOOL 3 PARTING TOOL

Starturn

BILLET LENGTH 80 mm
BILLET DIA 25 mm

N	G	X /R	Z	F	S	T	M	REMARKS
1	90							ABSOLUTE
2	71							METRIC UNITS
3	00	25	25					RAPID TRAVERSE
4						1	06	TOOL CHANGE (TOOL 1)
5					1200		03	SPINDLE START (1200 RPM)
6	00	12.2	2					RAPID TRAVERSE
7	01		-55	100				LINEAR
	00		2					RAPID TRAVERSE
9	00	11						RAPID TRAVERSE
10	01		-34.9	100				LINEAR
11	00		2					RAPID TRAVERSE
12	91							INCREMENTAL
13	73	3						START DO-LOOP (3 TIME
14	00	-1	1					RAPID TRAVERSE
15	01		-30.5	90				LINEAR
16	00		30.5					RAPID TRAVERSE
17	06							END DO-LOOP
18	90							ABSOLUTE
19	00	8	2					RAPID TRAVERSE
20	91							INCREMENTAL
					1400		03	SPINDLE SPEED 1400 RPM
22	73	3						START DO-LOOP (3 TIME
23	00	-0.8	0.8					RAPID TRAVERSE
24	01		-27.3					LINEAR
25	00		27.3					RAPID TRAVERSE
26	06							END DO-LOOP
27	90							ABSOLUTE
28	00	3	2					RAPID TRAVERSE
29	01		0.2	80				LINEAR
30	01	5.8	-1.5					LINEAR
31	00		0.2					RAPID TRAVERSE
32	00	1.5						RAPID TRAVERSE
	01	5.8	-2.5					LINEAR
34	00		0.2					RAPID TRAVERSE
35	00	0	0.2					RAPID TRAVERSE
36	01	5.8	-3.5					LINEAR

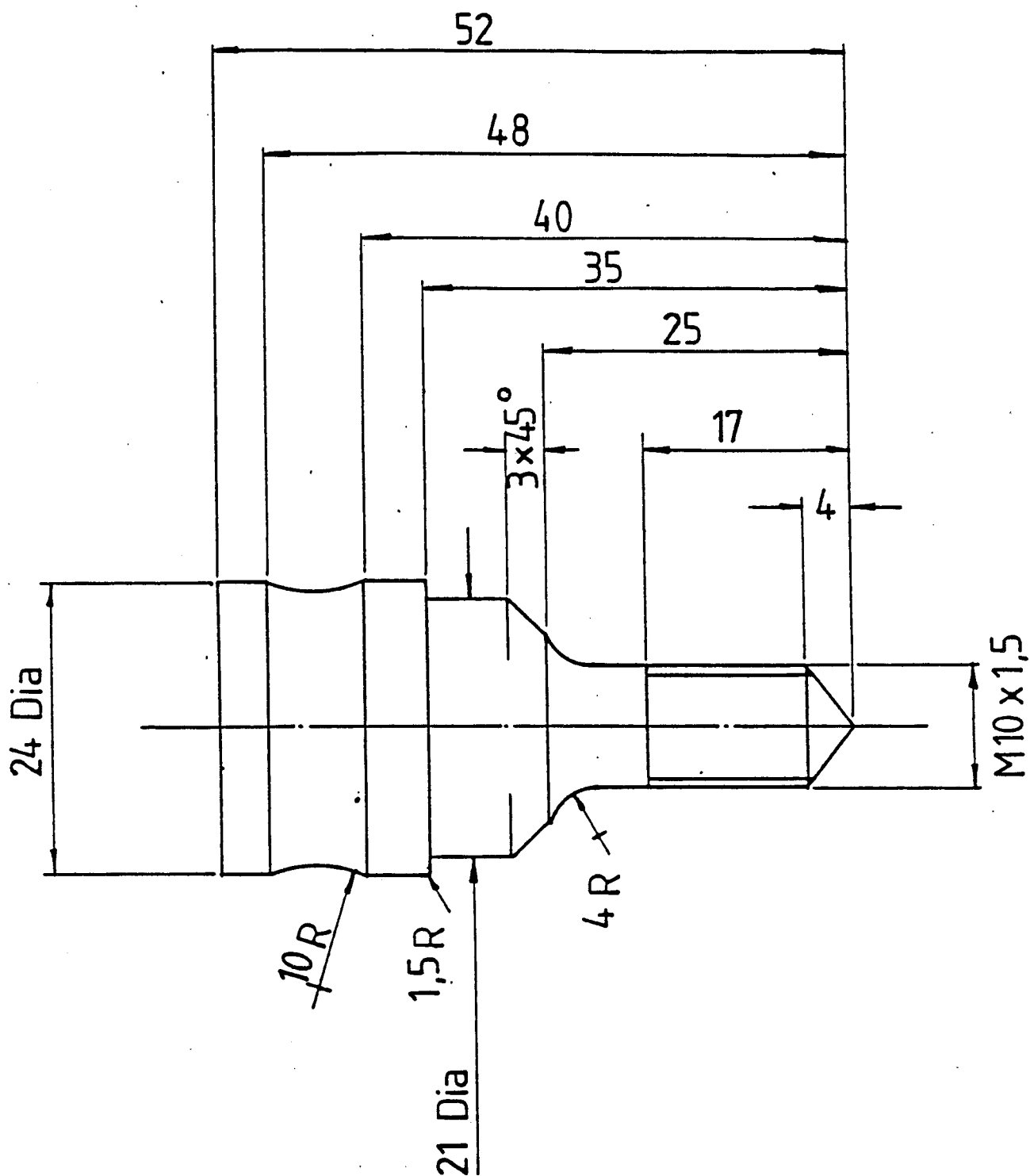


DRAWING No.

TOOLING & SETTING DATA

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DRAWING No.	TEST 3
DESCRIPTION	TEST PROGRAM 3
PROGRAMME No.	3
M. ERIAL	MILD STEEL
PROGRAMME BY	T QUARMBY
DATE	25/02/86

TOOLING & SETTING DATA

Starturn

TOOL 1 R.H. KNIFE TOOL
TOOL 2 THREADING TOOL
TOOL 3 PARTING TOOL

BILLET LENGTH 80
BILLET DIA 25

N	G	X/R	Z	F	S	T	M	REMARKS
1	00	15	5					RAPID TRAVERSE
2						1	06	TOOL CHANGE (Tool 1)
3					1000		03	SPINDLE FWD
4	00	12	1		1200			RAPID TRAVERSE
5	01	12	-35	130				LINEAR
6	00	12	1					RAPID TRAVERSE
7	00	10	1					RAPID TRAVERSE
8	01	10	-35					LINEAR
9	00	10	1					RAPID TRAVERSE
10	00	8	1					RAPID TRAVERSE
11	01		-32	130				LINEAR
12	01	10.2	-35					LINEAR
13	00		1					RAPID TRAVERSE
14	00	6.5	1					RAPID TRAVERSE
15	01	6.5	-30	130				LINEAR
16	01	8.2	-32					LINEAR
17	00		1					RAPID TRAVERSE
18	00	3						RAPID TRAVERSE
19	01	7	-3	100				LINEAR
20	00		1					RAPID TRAVERSE
21	00	1	1					RAPID TRAVERSE
22	01	7	-5	100				LINEAR
23	00		-12					RAPID TRAVERSE
24	03	7	-26					CIRCULAR CCW. RAD 30
		30						
25	00	8	-26					RAPID TRAVERSE
26	00		1					RAPID TRAVERSE
27	00	0	1					RAPID TRAVERSE
28	01	0	0	100	1800			LINEAR
29	01	6	-6	80				LINEAR
30	01		-12					LINEAR
31	03	6	-26					CIRCULAR CCW RAD 30
		30						
32	01	6	-30					LINEAR
33	01	10	-35	80				LINEAR
34	02	12.5	-37.5					CIRCULAR CW RAD 2.5
		2.5						

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