

PARAMETER LIST

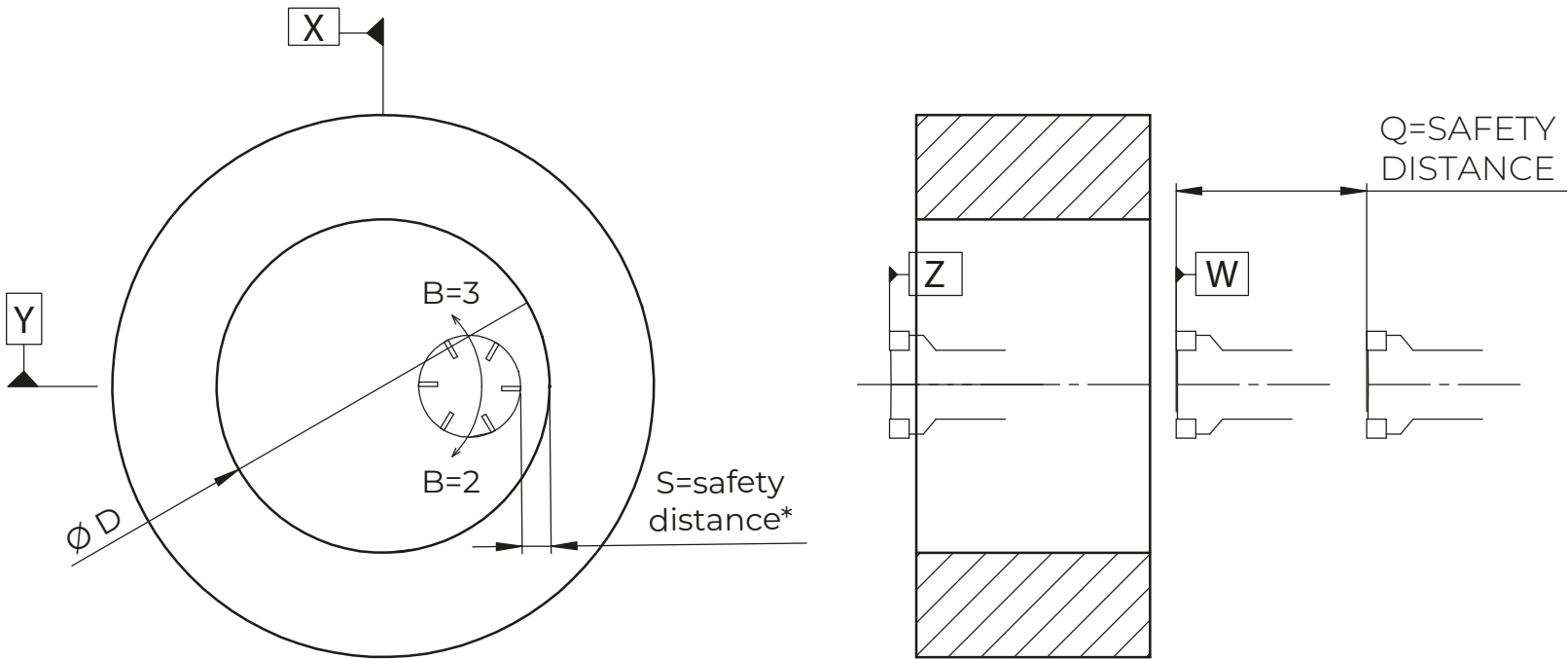
X= CENTRE POSITION IN X  
Y= CENTRE POSITION IN Y  
D= DIAMETER  
Z= END QUOTE IN Z (ABSOLUTE)  
W= STARTING QUOTE IN Z (ABSOLUTE)  
I= HELICAL INTERPOLATION PITCH  
S= LATERAL SAFETY DISTANCE S=0 AND U=1 STARTS FROM THE CENTRE HOLE  
Q= SAFETY DISTANCE IN Z (**INCREMENTAL** TO W)  
K= LEAD ANGLE  
U= 1= INTERNAL MACHINING 2= EXTERNAL 3= FACE MILL. WITH CENTRE CUTTER  
B= INTERP. DIRECTION 2= CLOCKWISE 3= COUNTERCLOCKWISE  
T= CLEARANCE SELECTION  
T=0 or NULL, PERFORMS ENTRY AND EXIT CLEARANCE  
T=1, CLEARANCE AT Q ONLY ON ENTRY  
T=2, NEVER PERFORMS THE CLEARANCE  
T=3, CLEARANCE ONLY ON EXIT

Example of a macro call


Internal contouring of a d.100 hole starting from Z5 to Z-20 by performing a helical interpolation with a 2 mm pitch per revolution. The start is from the centre of the hole and the approach is along the X+ axis by setting the angle of approach K0. The helical interpolation will be performed counterclockwise by setting B equal to 3.

G65P8008X-100Y200D100B3W5Z-20I2S0K0Q10U1

*NOTE: all parameters except I and K may be placed in any order, only parameter I must always be written before parameter K.*



\* By setting S=0 the positioning before and after helical interpolation will be in the centre of the hole (only for internal contours U=1).

<div></div> <div>CNC <i>of course!</i></div>				www.cncofcourse.com			Scale:	Material:
							Non-quoted chamfers 0.5 mm General tolerances: UNI ISO 2768-m	
				Drawn by:	Date	Name	Dis. N°: TABLE_FA18_EN	
				Checked by:		Ing. P. Zanetti		
				Detail:				
				Helical interpolation milling				
MOD	DESCRIPTION	DATE	NAME					