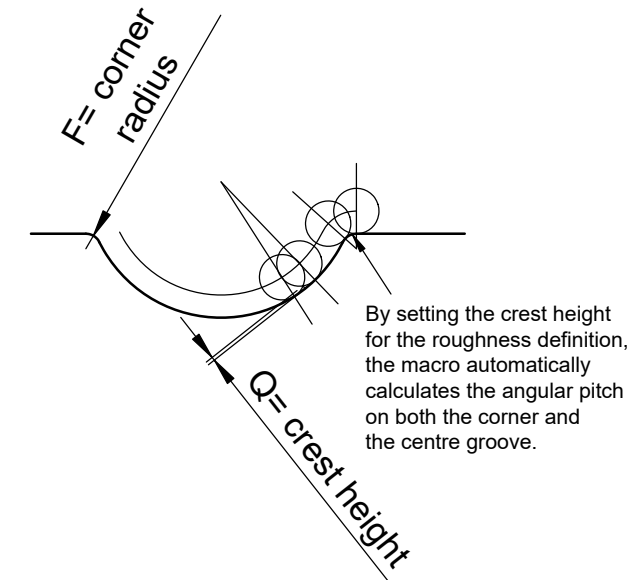


H parameter for the machining selection  
 H=1 carries out roughing only  
 H=2 carries out finishing only  
 H=3 carries out roughing and finishing

**Finishing parameters**



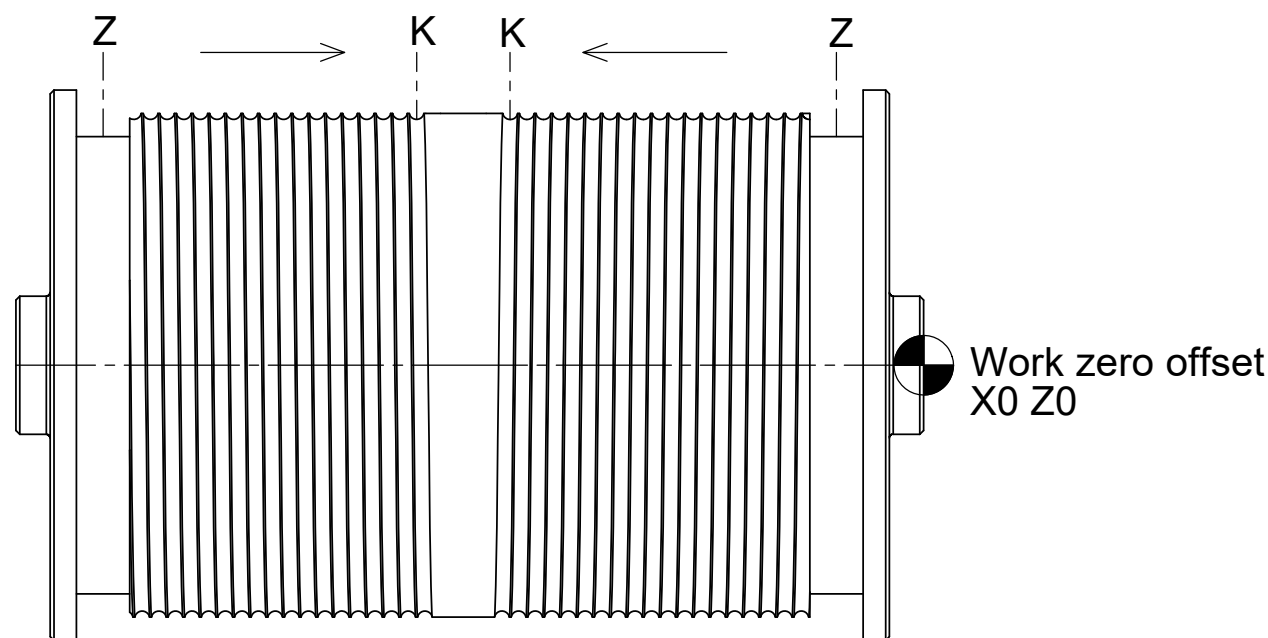
**Parameter summary**

- I =BOTTOM GROOVE DIAMETER
- A=DIAMETRAL PITCH DEPTH (for roughing only)
- E=CREST DIAMETER
- R=GROOVE RADIUS
- U=INSERT RADIUS
- W=THREAD PITCH
- Z=Z VALUE FOR START GROOVE
- K=Z VALUE FOR END GROOVE
- X=RETRACTION VALUE
- S=SAFETY DISTANCE
- V=EXIT TYPE
  - V=0 STRAIGHT EXIT
  - V=1 INTERP. EXIT FOLLOWING THE THREAD
- M= TOOL DIAMETER ENGAGEMENT FACTOR (EXAMPLE M0.7) (for roughing only)
- H=MACHINING TYPE =1 ROUGHING =2 FINISHING =3=ROUGH.+FINISH.
- Y=FINISHING ALLOWANCE (for roughing only)
- Q=CREST HEIGHT (for finishing only)
- F=ROUNDING RADIUS (for finishing only)


Example of a ROUGHING+FINISHING cycle call:  
 G65P8013I344A0.5E354R7.5U4W15Z-428K-2458X370S5V1M0.6H3Q0.01F1Y0.3

Example of a ROUGHING cycle call:  
 G65P8013I309.1A0.5E318R25U4W16Z-736K-32X350S1V0M0.5H1Y0.3

Example of a FINISHING only cycle call:  
 G65P8013I309.1E318R25U4W16Z-736K-32X350S1V0H2Q0.01F2



Note: Depending on the position of the Z and K co-ordinates, the macro will perform the machining in the Z- or Z+ direction.

|   |             |                      |      |  |           |
|---|-------------|----------------------|------|--|-----------|
|  |             | www.cncofcourse.com  |      | Scale:   | Material: |
|   |             | info@cncofcourse.com |      | Non-quoted chamfers 0.5 mm<br>General tolerances: UNI ISO 2768-m |           |
|   |             | Drawn by:            | Date | Dis. N°:   |           |
|   |             | Checked by:          | Name |  |           |
|   |             | Detail:              |      |  |           |
| MOD   | DESCRIPTION | DATE                 | NAME | Cable reel groove table  |           |