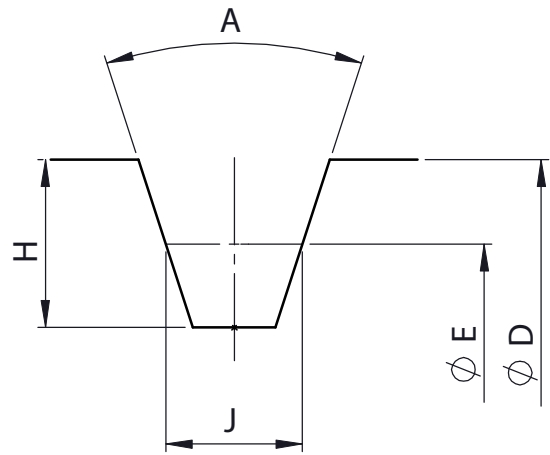
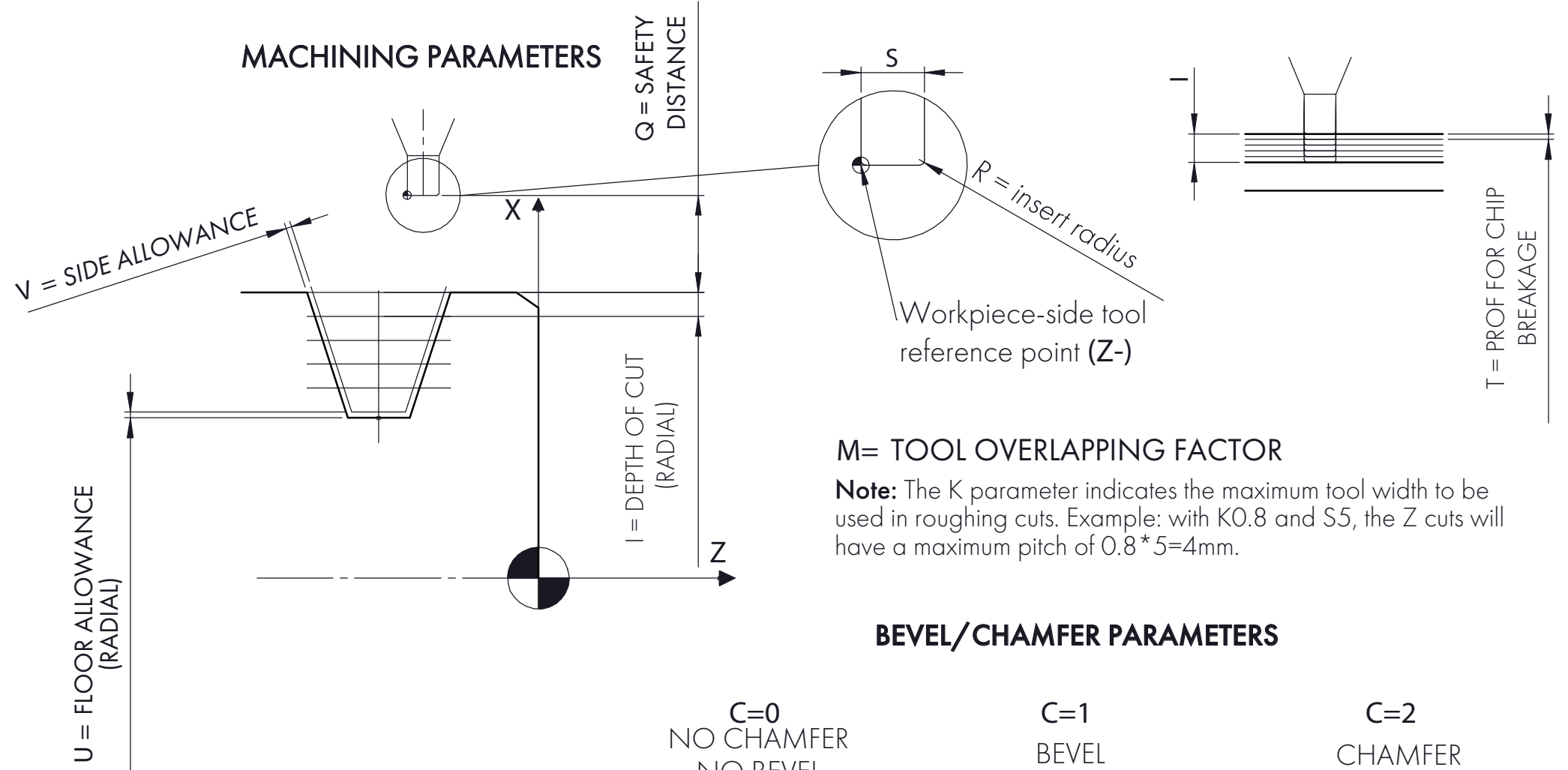


PARAMETERS RELATING TO THE GROOVE SIZE



MACHINING PARAMETERS



M= TOOL OVERLAPPING FACTOR

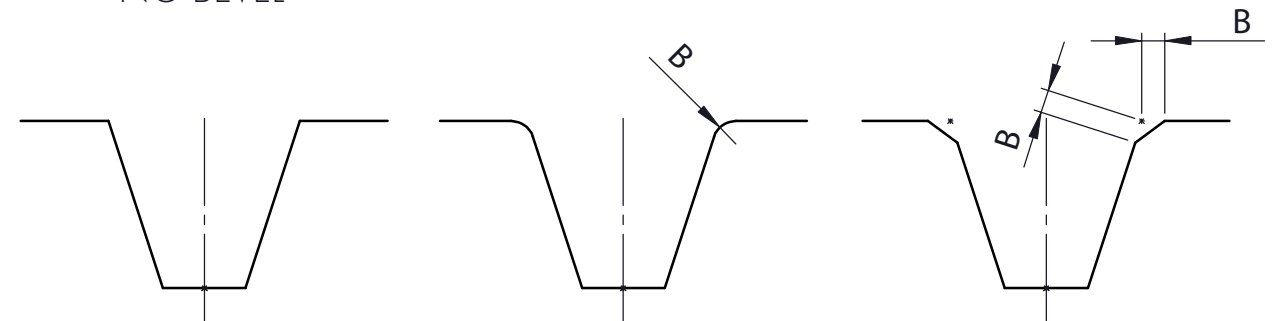
Note: The K parameter indicates the maximum tool width to be used in roughing cuts. Example: with K0.8 and S5, the Z cuts will have a maximum pitch of $0.8 * 5 = 4\text{mm}$.

BEVEL/CHAMFER PARAMETERS

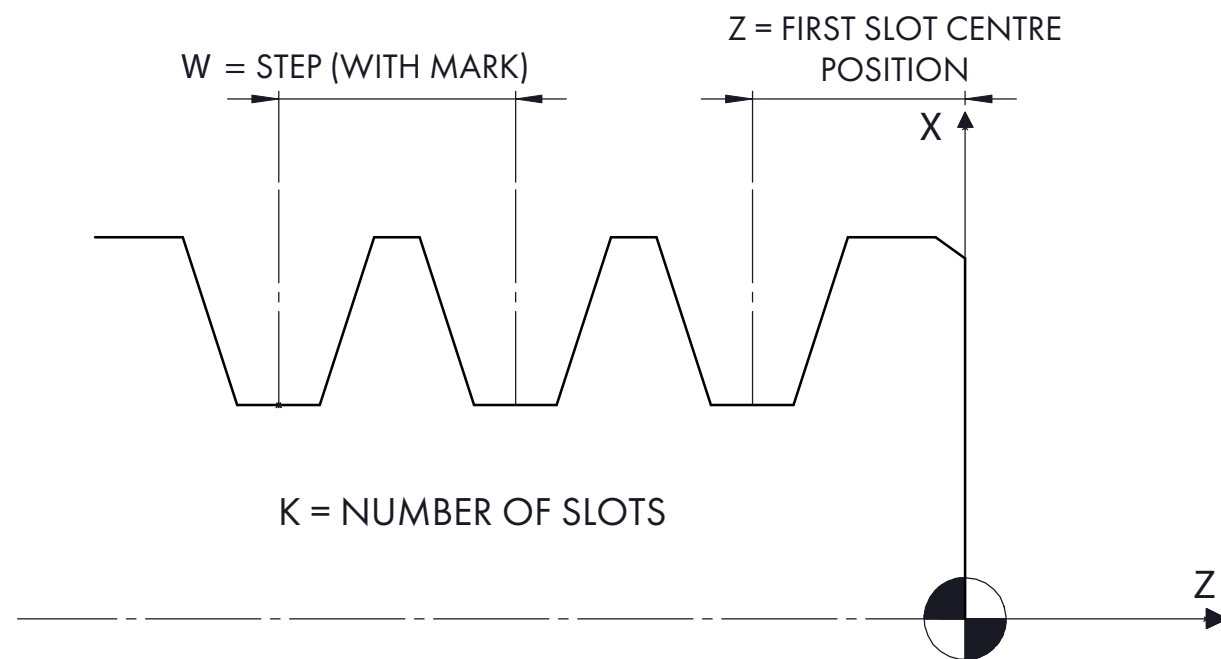
C=0
NO CHAMFER
NO BEVEL

C=1
BEVEL

C=2
CHAMFER



PARAMETERS RELATING TO THE GROOVE POSITION



Recall example:

G65 P8000 D1210 E1200 H24 I2.5 J19.5 K6 A38 Z-22.5 S5 R0.2 Q5 W-26 K1 M0.8 F0.15 V0.15 U0.05 C2 B1

NOTE: The parameter W represents the step between one groove and the next, its sign indicating the direction in which the grooves following the first are to be developed. In the case of the figure above, w must be negative.

	www.cncofcourse.com		Scale:	Material:
			Non-quoted chamfers 0.5 mm General tolerances: UNI ISO 2768-m	
		Date	Dis. N°:	
	Drawn by:		Ing.P.Zanetti	
	Checked by:			
Detail: PULLEY GROOVE PARAMETER DIAGRAM				
MOD	DESCRIPTION	DATE	NAME	