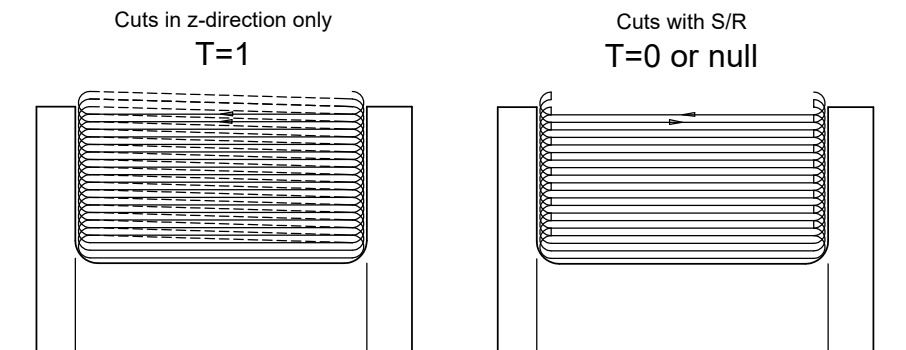
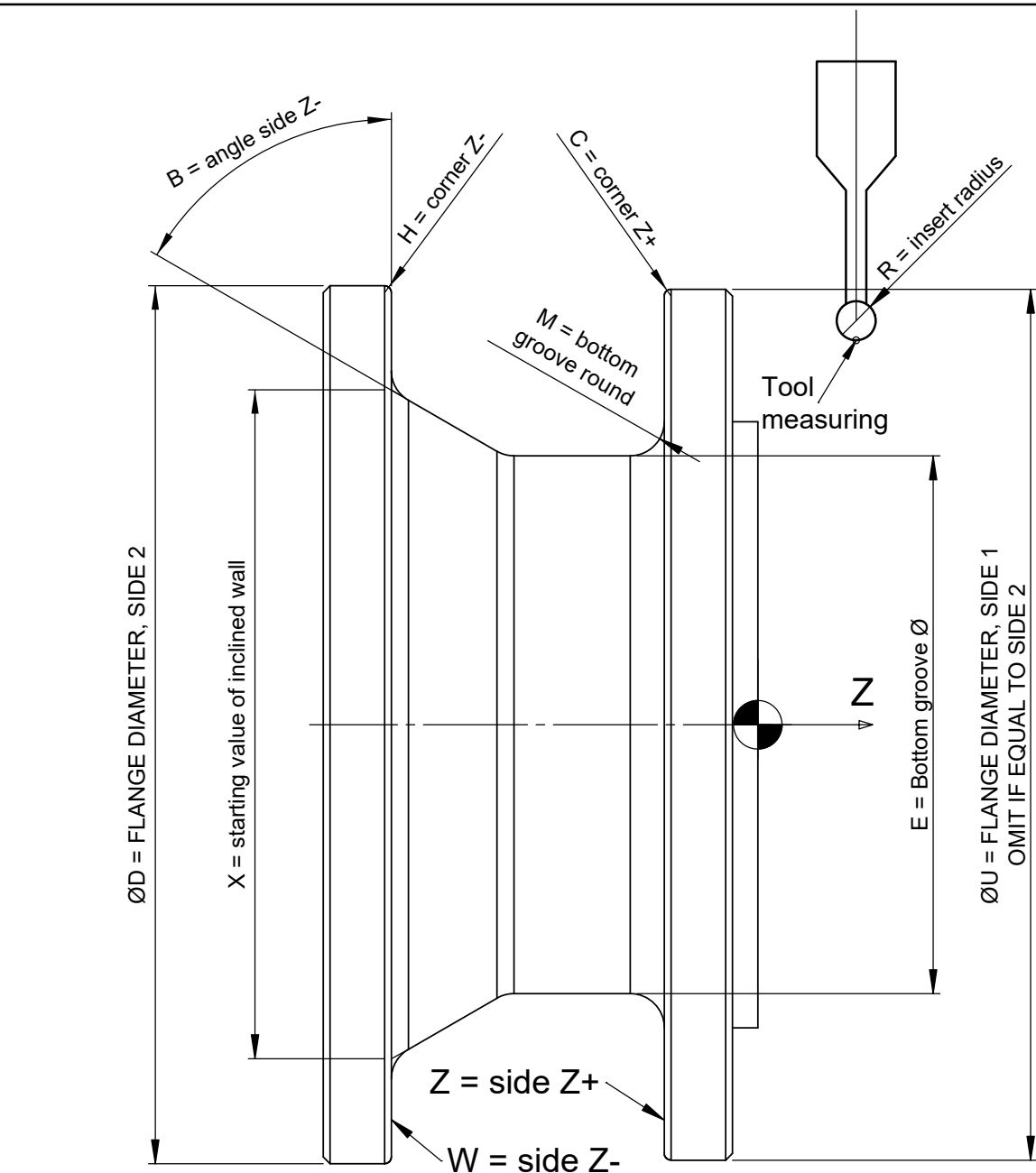


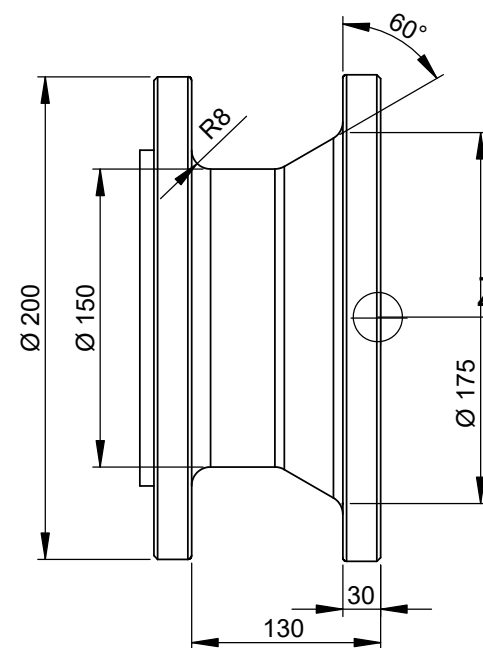


PARAMETER LIST

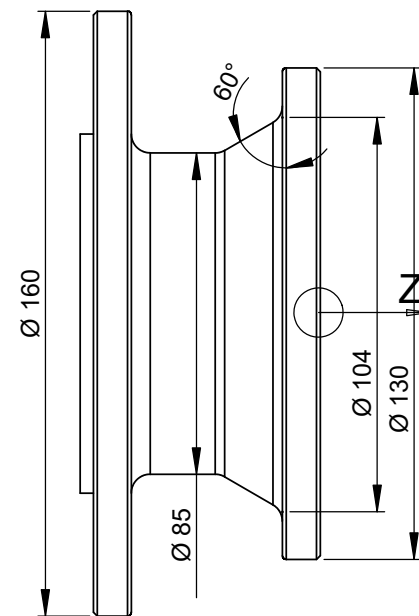
D=EXTERNAL DIAMETER OF SIDE2
 U= EXTERNAL DIAMETER SIDE1 (omit if equal to side 2)
 E=INTERNAL DIAMETER
 Z=POSITION IN Z GROOVE SIDE Z+
 A=ANGLE SIDE Z
 W=POSITION IN Z-GROOVE SIDE Z-
 B=GROOVE ANGLE ON SIDE Z-
 M=RADIUS ENTITY (BE CAREFUL THAT (M-V) MUST BE GREATER THAN R)
 V=ALLOWANCE ON PROFILE
 R=INSERT RADIUS
 Q=RADIAL SAFETY DISTANCE
 I =DEPTH OF RADIAL CUT
 T = 0 or none S/R T=1 ONLY START Z-
 S 1=ROUGH 2=ROUGH+FINISHING 3=FINISHING
 4=RADIUS RECOVERY 5=ROUGH+RADIUS RECOVERY
 6=ROUGH+RADIUS RECOVERY+FINISHING
 C=CHAMFER RADIUS SIDE 1
 H=CHAMFER RADIUS SIDE 2
 X=ANGLE START DIMENSION
 Y=BOTTOM RADIUS FOR RADIUS RECOVERY
 J=VALUE FOR CHIP BREAKAGE ZERO OR ZERO WITHOUT BREAKAGE
 F=ENTRY FEEDRATE
 K=FINISHING FEEDRATE
 THE ROUGHING FEED IS TAKEN FROM THE PROGRAM

Example of setting the geometric parameters

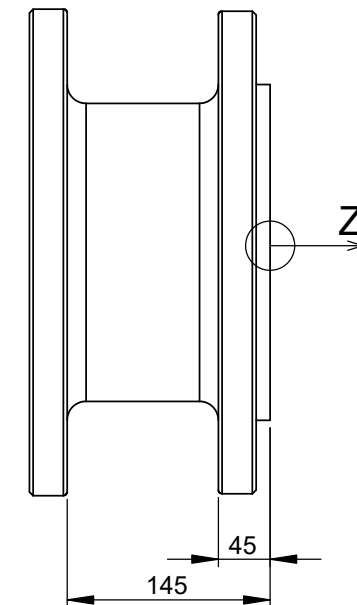
Example 1
 D200E150X175 M8Z-30W-130A60B0...



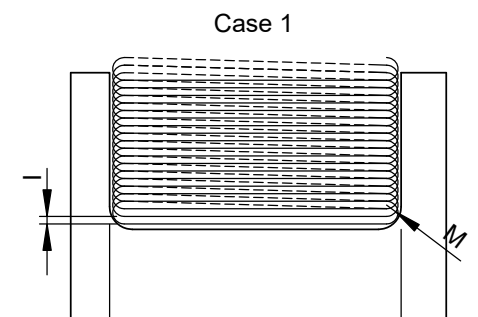
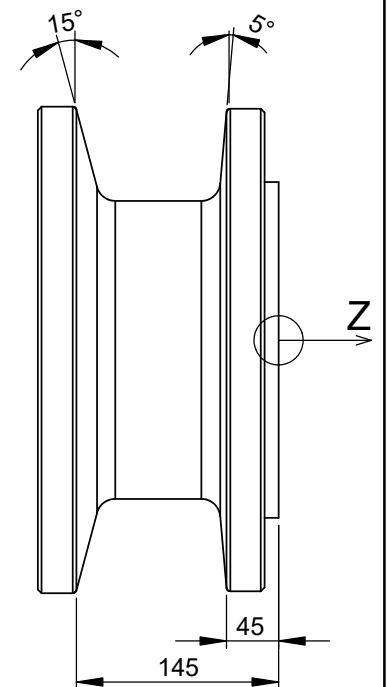
Example 2
 D160U130E85X104A60B0...



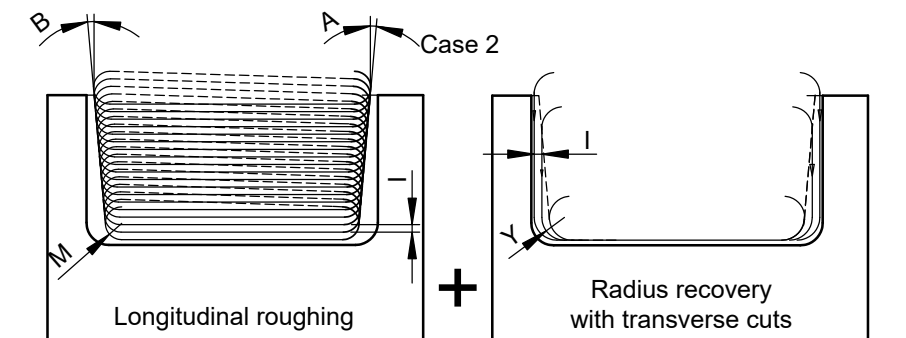
Example 3
 D200E150M8Z-45W-145A0B0...
 (X is omitted)



Example 4
 D200E150M8 Z-45W-145A5B15...
 (X is omitted)



D200E150X175 M8 Z-30W-130A0B0I1.5...
 S=1 ROUGHING
 S=2 ROUGHING+FINISHING
 S=3 FINISHING



D200E150X175 M8Y10 Z-30W-130A15B15I1.5...
 S=1 ROUGHING
 S=3 FINISHING
 S=4 RADIUS RECOVERY
 S=5 ROUGH. + RADIUS RECOVERY
 S=6 ROUGH. + RADIUS RECOVERY + FINISHING

							Scale:	Material:
							Non-quoted chamfers 0.5 mm General tolerances: UNI ISO 2768-m	
					Date	Name	Dis. N°:	
				Drawn by:		Ing.P.Zanetti		
				Checked by:				
MOD	DESCRIPTION	DATE	NAME	Detail: HIGH PERFORMANCE GROOVE				