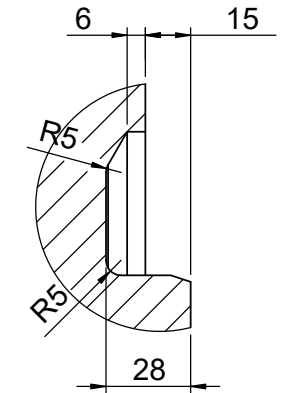
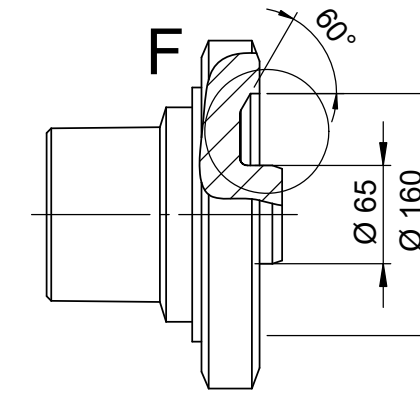
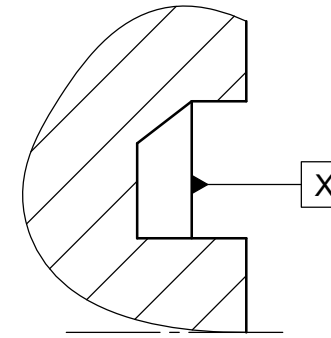
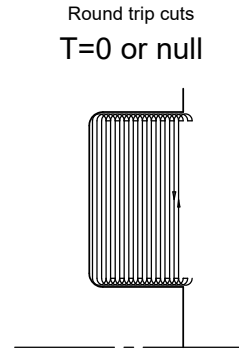
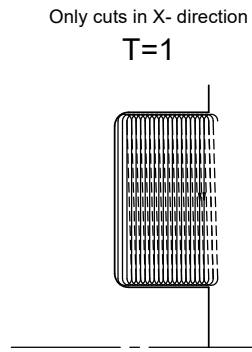
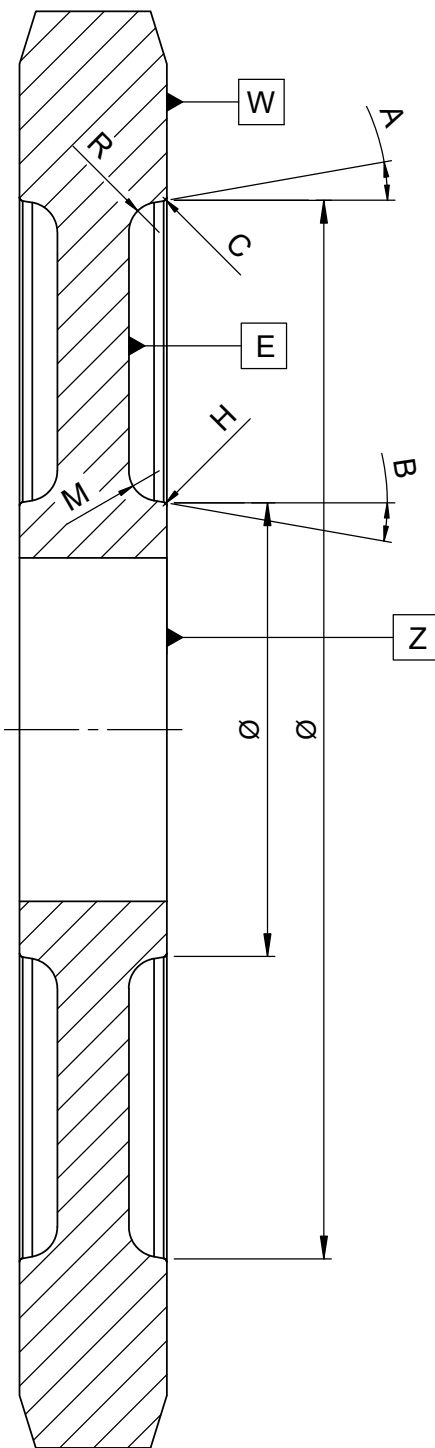
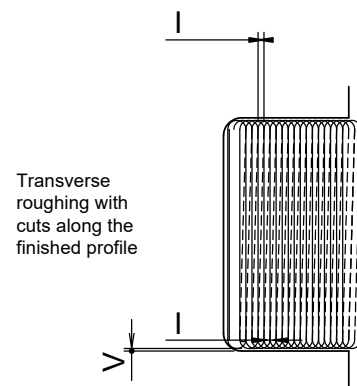


GEOMETRIC PARAMETERS



If the inclined profile starts after a straight line, the macro automatically recognises the type of profile by entering the X parameter for the Z coordinate of the start of the inclined line.

G65P8029Z0W-15D160U65E-28X-21A60B0V.4R4I1M5Q3S2F0.5K0.4C0.5H0T1

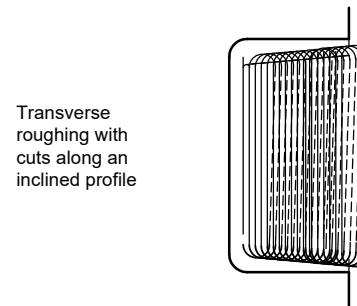


CASE1: All profile types

Roughing transverse cuts are carried out close to the profile, leaving the desired allowance for finishing set by parameter V.

D200E150X175M8Z-30W-130A0B011.5...

- S=1 ROUGHING
- S=2 ROUGHING+FINISHING
- S=3 FINISHING

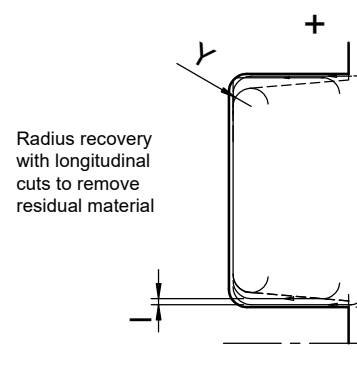


CASE2: Only for finished profile with 0° sides

If the finished profile has 0° sides, it is possible to execute a roughing operation with transverse cuts along an inclined profile to allow better management of vibrations and cutting forces, and then remove the material along the taper with longitudinal cuts. The macro recognises the profile type by entering the Y parameter corresponding to the radius left on the bottom by the recovery cuts. Angles A and B will then only be used to construct the temporary profile (with draft).

D200E150X175M8Y10Z-30W-130A15B15I1.5...

- S=1 ROUGHING
- S=3 FINISHING
- S=4 RADIUS RECOVERY
- S=5 ROUGH.+RADIUS RECOVERY
- S=6 ROUGH.+RADIUS RECOVERY+FINISHING



PARAMETER LIST

- D=MAX. DIAMETER SIDE 2
- U=MIN. DIAMETER SIDE 1
- Z=Z-COORDINATE OF GROOVE START ON THE X SIDE MIN.
- W=Z-COORDINATE OF GROOVE STAR ON THE X SIDE MAX. (OMIT IF SAME AS Z)
- E=Z-COORDINATE OF GROOVE BOTTOM
- A=ANGLE X SIDE MAX.
- B=ANGLE X SIDE MIN.
- M=RADIUS SIZE OF THE GROOVE BOTTOM
- V=SIDE ALLOWANCE
- R=INSERT RADIUS
- Q=RADIAL SAFETY DISTANCE
- I=DEPTH OF CUT
- T = 0 or null S/R T=1 ONLY START IN X-
- S 1=ROUGH. 2=ROUGH.+FINISHING 3=FINISHING
- 4=RADIUS RECOVERY 5=ROUGH.+RADIUS RECOVERY
- 6=ROUGH.+RADIUS RECOVERY+FINISHING
- C=RADIUS/CHAMFER SIDE 1
- H=RADIUS/CHAMFER SIDE 2
- X=Z-DIMENSION OF ANGULAR START
- Y= BOTTOM RADIUS OF THE RADIUS RECOVERY
- J=VALUE FOR CHIP BREAKAGE NULL OR ZERO WITHOUT BREAKAGE
- F=STARTING FEEDRATE
- K=FINISHING FEEDRATE
- THE ROUGHING FEEDRATE IS TAKEN FROM THE PROGRAM

| | | | | |
|-------------|---------------------|---------------|--|-----------|
| | www.cncofcourse.com | | Scale: | Material: |
| | | | Non-quoted chamfers 0.5 mm General tolerances: UNI ISO 2768-m | |
| Drawn by: | Date: | Name: | Dis. N°: FA29_REV0 | |
| Checked by: | | Ing.P.Zanetti | | |
| Detail: | | | Macro FA29: Face grooving | |
| MOD | DESCRIPTION | DATE | | |