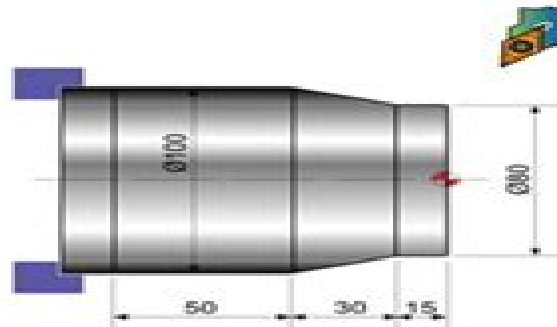


G01 PROGRAM

Example1)



O0001 :

```

N10 G50 S1500 T0100 M42 :
  G96 S180 M03 :
  G00 X100.5 Z5.0 T0101 M08 :
  G01 Z-95.0 F0.25 :
  G00 U2.0 Z0.5 :
  G01 X-1.6 F0.2 :
  G00 X95.0 W1.0 :
  G01 Z-37.3 F0.25 :
    X100.0 Z-45.5 :
  G00 Z1.0 :
    X90.0 :
  G01 Z-29.8 :
    X95.0 Z-37.3 :
  G00 Z1.0 :
    X85.0 :
  G01 Z-22.3 :
    X90.0 Z-29.8 :
  G00 Z1.0 :
    X80.5 :
  G01 Z-15.55 :
    X85.0 Z-22.3 :
  G00 X200.0 Z200.0 M09 T0100 :
  M01 :
```

```

N20 G50 S2000 T0300 :
  G96 S200 M03 :
  G00 X85.0 Z5.0 T0303 M08 :
  Z0 :
  G01 X-1.6 F0.2 :
  G00 X80.0 Z3.0 :
  G42 Z1.0 :
  G01 Z-15.0 F0.18 :
  X100.0 Z-45.0 :
  Z-95.0 :
  G40 U2.0 W1.0
  G00 X200.0 Z200.0 M09 T0300 :
  M30 :
```

G50 : Setting the rotating time of max. speed of main spindle

G96 : Constant surface speed control command

G40 : Compensation cancel

G42 : Right hand compensation

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Peter Smid



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CNC Programming using Fanuc Custom Macro B S. K Sinha, 2010-06-22 Master CNC macro programming CNC Programming Using Fanuc Custom Macro B shows you how to implement powerful advanced CNC macro programming techniques that result in unparalleled accuracy flexible automation and enhanced productivity Step by step instructions begin with basic principles and gradually proceed in complexity Specific descriptions and programming examples follow Fanuc s Custom Macro B language with reference to Fanuc Oi series controls By the end of the book you will be able to develop highly efficient programs that exploit the full potential of CNC machines **COVERAGE INCLUDES** Variables and expressions Types of variables local global macro and system variables Macro functions including trigonometric rounding logical and conversion functions Branches and loops Subprograms Macro call Complex motion generation Parametric programming Custom canned cycles Probing Communication with external devices Programmable data entry **CNC Control Setup for Milling and Turning** Peter Smid, 2010 This unique reference features nearly all of the activities a typical CNC operator performs on a daily basis Starting with overall descriptions and in depth explanations of various features it goes much further and is sure to be a valuable resource for anyone involved in CNC **CNC Programming Handbook** Peter Smid, 2000 This handbook is a comprehensive guide to CNC programming covering virtually all CNC programming subjects in exceptional detail Both milling and turning topics are discussed with nearly 1 000 illustrations tables formulas and actual examples Besides being an invaluable in depth reference this book is well suited for use as a basic text in a wide variety of CNC training programs The National Guide to Educational Credit for Training Programs American Council on Education, 2005 Highlights over 6 000 educational programs offered by business labor unions schools training suppliers professional and voluntary associations and government agencies *TOP SECRET Resumes & Cover Letters, the Third Edition Ebook* Steven Provenzano CPRW/CEIP, 2012 As seen on in CNBC CNN WGN The Wall Street Journal and endorsed by The Chicago Tribune the new edition of Top Secret Resumes is now the complete career marketing tool for all job seekers This is the only book of its kind that includes a free consultation by the author Includes more than 100 high impact Resumes and Cover Letters for virtually all professions 250 8 5 x 11 pages total Bonus includes tips on effective LinkedIn Profiles Networking Career Marketing Interviewing and Online Resources Covers Executive Positions Technical Non Technical Management Engineering IT Software Hardware design Sales and Marketing Teachers Nurses HR Public Relations and more many with documented results Steven Provenzano s books have sold more than 100 000 copies and remain essential guides for serious job seekers He has written more than 5000 resumes for clients worldwide for over 20 years and the full cost of this book is reimbursed with any resume writing service by the author at <https://www.execareers.com> *Control Engineering*, 1990 Instrumentation and automatic control systems *NC Machine Programming and Software Design* Chao-Hwa Chang, Michel A. Melkanoff, 1989 Very Good No Highlights or Markup all pages are intact SME Technical Paper Society

of Manufacturing Engineers,2002 ESD Technology ,1990 **CNC Programming Skills: Program Entry and Editing on Fanuc Machines** S. K. Sinha,2015-05-05 Do you know how to insert a part of a program into another program at the desired location Background editing Using PCMCIA card Or maybe a simple task such as replacing G02 by G03 in the whole file When it comes to manual program entry on the machine or searching deleting editing copying moving inserting an existing program residing in the control memory or the PCMCIA card most people resort to trial and error method While they might be able to accomplish what they desire the right approach would save a lot of their precious time If this is exactly what you want this book is for you The information contained herein is concise yet complete and exhaustive The best part is that you can enjoy the convenience of having the wealth of useful information on editing techniques even on your smart phone which is always with you You would often need to refer to it because it is not possible to memorize all the steps which are many a time too complex and devoid of common logic so as to make the correct guess The following excerpt from the book would give an idea of the methodical and step by step approach adopted in the book Writing a file on the memory card The following operation will save program number 1234 in the memory card with the name TESTPRO Select the EDIT mode on the MOP panel Press the PROG key on the MDI panel Press the next menu soft key Press the soft key CARD Press the soft key OPRT Press the soft key PUNCH Type 1234 and press the soft key O SET Type TESTPROG and press the soft key F NAME Press the soft key EXEC While the file is being copied on the memory card the character string OUTPUT blinks at the lower right corner of the screen Copying may take several seconds depending on the size of the file being copied If a file with file name TESTPROG already exists in the memory card it may be overwritten unconditionally or a message confirming the overwriting may be displayed depending on a parameter setting In case of such a warning message press the EXEC soft key to overwrite and CAN soft key to cancel writing However system information such as PMC ladder is always overwritten unconditionally The copied file is automatically assigned the highest existing file number plus one The comment if any with the O word i e in the first block of the program will be displayed in the COMMENT column of the card directory To write all programs type 9999 as the program number In this case if file name is not specified all the programs are saved in file name PROGRAM ALL on the memory card A file name can have up to 8 characters and an extension up to 3 characters XXXXXXXX XXX Repeat the last three steps to copy more files Finally press the CAN soft key to cancel the copying mode and go to the previous menu Introduction to Computer Numerical Control (CNC) James Valentino,Joseph Goldenberg,2008 Putting all the elements together this book addresses CNC Computer Numerical Control technology in a comprehensive format that offers abundant illustrations examples and exercises It includes a strong foundation in blue print reading graphical descriptions of CNC machine tools a chapter on right triangle trigonometry and programming that uses Fanuc Controllers It emphasizes program pattern recognition and contains completely solved programming examples and self contained programming examples Thoroughly updated for this edition it includes two new chapters four new appendices and is bundled

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