

1.3 Program slot – 1205948

744 650 A4

Text:		ID number	
Change No. C000941-05		Phase: Nicht-Serie	
Werkstoff: 3.1645		Material:	
●blanke Flächen/Blank surfaces			
Oberflächen nach ISO 1302		Surfaces as per ISO 1302	
Oberflächenbehandlung: Surface treatment:			

Maße in mm / Dimensions in mm		Einzelteilzeichnung / Component Drawing	
Werkstückkanten nach ISO 13715 Workpiece edges ISO 13715		Allgemeintoleranzen ISO 2768-mH $\leq 6\text{mm}$: $\pm 0,2$ General tolerances ISO 2768-mH $\leq 6\text{mm}$: $\pm 0,2$	
Tolerierung nach ISO 8015 Tolerances as per ISO 8015		Oberflächenbehandlung: Surface treatment:	


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	13.02.2017			Document number			1

Program parameters

Milling	X	Y	Z
Safe position	+150	+150	+100
Safety clearance	-	-	+5
Pre-position	-60	+35	+100

Tool parameters

	Ø	T	S	F₁	F₂	DZ	IZ
	10	5	8900	1100	2000	-5	5

- Ø) Diameter
- T) Tool number
- S) Speed
- F₁) Machining feed
- F₂) Retraction feed rate
- DZ) Max. machining depth
- IZ) Infeed

Program solution

0 BEGIN PGM 1205948 MM	
1 BLK FORM 0.1 Z X-75 Y-50 Z-20	
2 BLK FORM 0.2 X+75 Y+50 Z+0	
3 TOOL CALL 5 Z S8900 F1100	
4 L Z+100 R0 FMAX M3	
5 L X-60 Y+35 Z+5 R0 FMAX M8	
6 L Z-5 R0 F AUTO	
7 L Y-20	
8 L X-20	
9 L X+0 Y+35	
10 L X+20 Y+20	
11 L X+0 Y-35	
12 L X+60 Y-20	
13 L Z+5 R0 F2000	
14 L X+150 Y+150 Z+100 R0 FMAX	
15 M30	
16 END PGM 1205948 MM	