

Obróbka wykańczająca G-Code

Mgr inż. Stanisław Pabiszczak

03/27/18
11:16 AM



JOG

Tool list

MAGAZIN1

Loc.	Type	Tool name	ST	D	Length	Ø		N	⌚	✓	✗
5		CUTTER 20	1	1	100.000	20.000		3	⌚	✓	✗
6		CUTTER 32	1	1	110.000	32.000		3	⌚	✓	✗
7		CUTTER 60	1	1	110.000	60.000		6	⌚	✓	✗
8		FACEMILL 63	1	1	120.000	63.000		5	⌚	✓	✗
9		CENTERDRILL 12	1	1	120.000	12.000	90.0		⌚	✓	✗
10		DRILL 8.5	1	1	120.000	8.500	118.0		⌚	✓	✗
11		DRILL 10	1	1	120.000	10.000	118.0		⌚	✓	✗
12		PREDRILL 30	1	1	120.000	30.000	180.0		⌚	✓	✗
13		DRILL_Tool	1	1	110.000	25.000			⌚	✓	✗
14		THREAD CUTTER	1	1	110.000	20.000		1	⌚	✓	✗
15		THREADCUTTER M10	1	1	130.000	10.000	1.500		⌚	✓	✗
16		Frez fi12 z2	1	1	83.000	12.000		2	⌚	✓	✗
17		Frez fi14 z3	1	1	83.000	14.000		3	⌚	✓	✗
18											
19											
20											
21											
22											

Edges

Unload

Delete
tool

Magazine
selection

SD Setting
data

Tool
list

Tool
wear

Maga-
zine

Work
offset

R User
variable

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Tool list

MAGAZINE 1

Loc.	Type	Tool name	ST	D	Length	Ø	N	⌀	⌀	⌀
5		CUTTER 20	1	1	100.000	20.000	3	⌀	✓	
6		CUTTER 32	1	1	110.000	32.000	3	⌀	✓	
7		CUTTER 60	1	1	110.000	60.000	6	⌀	✓	
8		FACEMILL 63	1	1	120.000	63.000	5	⌀	✓	
9		CENTERDRILL 12	1	1	120.000	12.000	90.0	⌀	✓	
10		DRILL 8.5	1	1	120.000	8.500	118.0	⌀	✓	
11		DRILL 10	1	1	120.000	10.000	118.0	⌀	✓	
12		PREDRILL 30	1	1	120.000	30.000	180.0	⌀	✓	
13		DRILL_Tool	1	1	110.000	25.000		⌀	✓	
14		THREAD CUTTER	1	1	110.000	20.000	1	⌀	✓	
15		THREADCUTTER M10	1	1	130.000	10.000	1.500	⌀	✓	
16		Frez fi12 z2	1	1	83.000	12.000	2	⌀	✓	
17		Frez fi14 z3	1	1	83.000	14.000	3	⌀	✓	
18										
19										
20										
21										
22										

New cutting edge

Delete cutting edge

Back

Tool list

Tool wear

Maga-zine

Work offset

User variable

SD Setting data



JOG

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Tool list

MAGAZIN1

Loc.	Type	Tool name	ST	D	Length	Ø		N			
5		CUTTER 20	1	1	100.000	20.000		3		☒	☐
6		CUTTER 32	1	1	110.000	32.000		3		☒	☐
7		CUTTER 60	1	1	110.000	60.000		6		☒	☐
8		FACEMILL 63	1	1	120.000	63.000		5		☒	☐
9		CENTERDRILL 12	1	1	120.000	12.000	90.0			☒	☐
10		DRILL 8.5	1	1	120.000	8.500	118.0			☒	☐
11		DRILL 10	1	1	120.000	10.000	118.0			☒	☐
12		PREDRILL 30	1	1	120.000	30.000	180.0			☒	☐
13		DRILL_Tool	1	1	110.000	25.000				☒	☐
14		THREAD CUTTER	1	1	110.000	20.000		1		☒	☐
15		THREADCUTTER M10	1	1	130.000	10.000	1.500			☒	☐
16		Frez fi12 z2	1	1	83.000	12.000		2		☒	☐
17		Frez fi14 z3	1	1	83.000	14.000		3		☒	☐
		Frez fi14 z3	1	2	83.000	14.000		3			
18											
19											
20											
21											

Sort

Filter

Search

Details

Settings

Tool
listTool
wearMaga-
zineWork
offsetUser
variableSetting
data



JOG

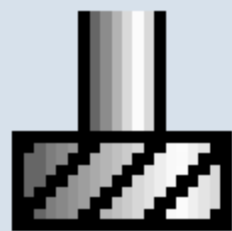
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Tool wear

MAGAZ...

Tool details

Loc.	Type	Tool name	ST
5		CUTTER 20	1
6		CUTTER 32	1
7		CUTTER 60	1
8		FACEMILL 63	1
9		CENTERDRILL 12	1
10		DRILL 8.5	1
11		DRILL 10	1
12		PREDRILL 30	1
13		DRILL_Tool	1
14		THREAD CUTTER	1
15		THREADCUTTER M10	1
16		Frez fi12 z3	1
17		Frez fi14 z3	1
		Frez fi14 z3	1
18			
19			
20			
21			



Magazine loca **17**
Frez fi14 z3
ST 1
Number C 2 D 1

Tool data

Cutting
edge data

Monitoring
data

Further
details

Back

Tool type



Length

83.000

Geometry

Wear

0.000

Geometry

Wear

Ø
14.000
0.000

N

3



Tool
list



Tool
wear



Maga-
zine



Work
offset



User
variable



Setting
data

Przykładowy program:

```
N140 T="Frez fi14 z3" S2500 F525 M06 D1; obrobka zgrubna¶  
N160 G00 G41 X-52 Y-35 Z2¶  
N170 G01 Z-6 ¶  
N180 X-45 Y0¶  
N190 G02 X-45 Y0 I45 J0¶  
N191 D2; obrobka wykarczajaca)¶  
N191 G02 X-45 Y0 I45 J0¶
```