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Operation List POST: Fagor 8055

OP 1 ROUGHING PASS TOOL 1 FLAT 20MM 4F EC SCB ROUGHING

EFFECTIVE DIAMETER 20, STOCK AMOUNT 5.5

Feed Distance: 2540.8 Time for OP 1: 10m 25s

OP 2 FINISH PASS TOOL 5 FLAT 20MM 4F EC SCB

EFFECTIVE DIAMETER 20

Feed Distance: 599.1 Time for OP 2: 2m 26s

OP 3 SPIRAL POCKET - FINISH TOOL 1 FLAT 20MM 4F EC SCB ROUGHING

EFFECTIVE DIAMETER 20, WIDTH OF CUT 15

Feed Distance: 614.8 Time for OP 3: 2m 46s

OP 4 FINISH PASS TOOL 5 FLAT 20MM 4F EC SCB

EFFECTIVE DIAMETER 20

Feed Distance: 162.8 Time for OP 4: 0m 42s

OP 5 ROUGHING PASS TOOL 3 CONE - 40MM DIA X 45 DEG

EFFECTIVE DIAMETER 2, STOCK AMOUNT -1

ROUGHING PASS TOOL 3 CONE - 40MM DIA X 45 DEG

EFFECTIVE DIAMETER 2, STOCK AMOUNT -1

Feed Distance: 753.1 Time for OP 5: 3m 17s

OP 7 DRILL HOLES TOOL 7 DRILL - 5MM DIA

TOOL DIAMETER 5, HOLE DIAMETERS 5

Feed Distance: 90 Time for OP 7: 1m 18s

Total Feed Distance 4807.1

Tool Change Time 1m 10s

Total Time 22m 07s

Material: Mild Steel Roughing

Use Emulsion Coolant

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START

'(PIEZASIMPLE_ISLACENTRAL_FE)

%PIEZASIMPLE, MX, RT

N10 (PROGRAM PRODUCED -)

N20 G90 G71

N30 G40 G80

'(OP 1 ROUGHING PASS TOOL 1 FLAT 20MM 4F EC SCB ROUGHING)

'(EFFECTIVE DIAMETER 20, STOCK AMOUNT 5.5)

N40 T01 D01 M03 'Select tool and offset

N50 S2500 M06 'Next tool is 05, Next XY is -72.96, -92.102

N60 G0 X-72.96 Y-92.102

N70 G43 Z20.

N80 Z5.

N90 G1 Z-3.475 F150

N100 G3 Y-77.96 I-7.071 J7.071 F250

N110 G1 X-77.96 Y-72.96

N120 G2 X-82.5 Y-62. I10.96 J10.96

N130 G1 Y62.

N140 G2 X-77.96 Y72.96 I15.5

N150 G1 X-72.96 Y77.96

N160 G2 X-62. Y82.5 I10.96 J-10.96

N170 G1 X62.

N180 G2 X72.96 Y77.96 J-15.5

N190 G1 X77.96 Y72.96

N200 G2 X82.5 Y62. I-10.96 J-10.96

N210 G1 Y-62.

N220 G2 X77.96 Y-72.96 I-15.5

N230 G1 X72.96 Y-77.96

N240 G2 X62. Y-82.5 I-10.96 J10.96

N250 G1 X-62.

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N260 G2 X-72.96 Y-77.96 J15.5

N270 G0 Z20.

N280 X-72.96 Y-92.102

N290 Z1.525

N300 G1 Z-6.95 F150

N310 G3 Y-77.96 I-7.071 J7.071 F250

N320 G1 X-77.96 Y-72.96

N330 G2 X-82.5 Y-62. I10.96 J10.96

N340 G1 Y62.

N350 G2 X-77.96 Y72.96 I15.5

N360 G1 X-72.96 Y77.96

N370 G2 X-62. Y82.5 I10.96 J-10.96

N380 G1 X62.

N390 G2 X72.96 Y77.96 J-15.5

N400 G1 X77.96 Y72.96

N410 G2 X82.5 Y62. I-10.96 J-10.96

N420 G1 Y-62.

N430 G2 X77.96 Y-72.96 I-15.5

N440 G1 X72.96 Y-77.96

N450 G2 X62. Y-82.5 I-10.96 J10.96

N460 G1 X-62.

N470 G2 X-72.96 Y-77.96 J15.5

N480 G0 Z20.

N490 X-69.778 Y-88.92

N500 Z5.

N510 G1 Z-3.475 F150

N520 G3 Y-74.778 I-7.071 J7.071 F250

N530 G1 X-74.778 Y-69.778

N540 G2 X-78. Y-62. I7.778 J7.778

N550 G1 Y62.

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N560 G2 X-74.778 Y69.778 I11.

N570 G1 X-69.778 Y74.778

N580 G2 X-62. Y78. I7.778 J-7.778

N590 G1 X62.

N600 G2 X69.778 Y74.778 J-11.

N610 G1 X74.778 Y69.778

N620 G2 X78. Y62. I-7.778 J-7.778

N630 G1 Y-62.

N640 G2 X74.778 Y-69.778 I-11.

N650 G1 X69.778 Y-74.778

N660 G2 X62. Y-78. I-7.778 J7.778

N670 G1 X-62.

N680 G2 X-69.778 Y-74.778 J11.

N690 G0 Z20.

N700 X-69.778 Y-88.92

N710 Z1.525

N720 G1 Z-6.95 F150

N730 G3 Y-74.778 I-7.071 J7.071 F250

N740 G1 X-74.778 Y-69.778

N750 G2 X-78. Y-62. I7.778 J7.778

N760 G1 Y62.

N770 G2 X-74.778 Y69.778 I11.

N780 G1 X-69.778 Y74.778

N790 G2 X-62. Y78. I7.778 J-7.778

N800 G1 X62.

N810 G2 X69.778 Y74.778 J-11.

N820 G1 X74.778 Y69.778

N830 G2 X78. Y62. I-7.778 J-7.778

N840 G1 Y-62.

N850 G2 X74.778 Y-69.778 I-11.

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N860 G1 X69.778 Y-74.778

N870 G2 X62. Y-78. I-7.778 J7.778

N880 G1 X-62.

N890 G2 X-69.778 Y-74.778 J11.

N900 G0 Z20.

N910 M09

'(OP 2 FINISH PASS TOOL 5 FLAT 20MM 4F EC SCB)

'(EFFECTIVE DIAMETER 20)

N920 T05 D05 M03 'Select tool and offset

N930 S2500 M06 'Next tool is 01, Next XY is -69.071, -74.071

N940 G0 X-69.071 Y-74.071

N950 G43 Z5.

N960 G1 Z-6.95 F150

N970 X-74.071 Y-69.071 F250

N980 G2 X-77. Y-62. I7.071 J7.071

N990 G1 Y62.

N1000 G2 X-74.071 Y69.071 I10.

N1010 G1 X-69.071 Y74.071

N1020 G2 X-62. Y77. I7.071 J-7.071

N1030 G1 X62.

N1040 G2 X69.071 Y74.071 J-10.

N1050 G1 X74.071 Y69.071

N1060 G2 X77. Y62. I-7.071 J-7.071

N1070 G1 Y-62.

N1080 G2 X74.071 Y-69.071 I-10.

N1090 G1 X69.071 Y-74.071

N1100 G2 X62. Y-77. I-7.071 J7.071

N1110 G1 X-62.

N1120 G2 X-69.071 Y-74.071 J10.

N1130 G0 Z5.

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N1140 M09

'(OP 3 SPIRAL POCKET - FINISH TOOL 1 FLAT 20MM 4F EC SCB ROUGHING)

'(EFFECTIVE DIAMETER 20, WIDTH OF CUT 15)

N1150 T01 D01 M03 'Select tool and offset

N1160 S2500 M06 'Next tool is 05, Next XY is 0., 0.

N1170 G0 X0. Y0.

N1180 G43 Z20.

N1190 Z5.

N1200 G1 Z-3.5 F150

N1210 G2 X7.5 Y7.5 I7.5 F250

N1220 X15. Y0. J-7.5

N1230 X0. Y-15. I-15.

N1240 X-15. Y0. J15.

N1250 X8.4 Y22.482 I22.5

N1260 X15.274 Y-18.512 I-8.4 J-22.482

N1270 X-23.671 Y-3.961 I-15.274 J18.512

N1280 X8.4 Y22.482 I23.671 J3.961

N1290 X15.441 Y7.041 I-4.2 J-11.241

N1300 X0. Y0. I-11.241 J4.2

N1310 G1 Z-7. F150

N1320 G2 X7.5 Y7.5 I7.5 F250

N1330 X15. Y0. J-7.5

N1340 X0. Y-15. I-15.

N1350 X-15. Y0. J15.

N1360 X8.4 Y22.482 I22.5

N1370 X15.274 Y-18.512 I-8.4 J-22.482

N1380 X-23.671 Y-3.961 I-15.274 J18.512

N1390 X8.4 Y22.482 I23.671 J3.961

N1400 X15.441 Y7.041 I-4.2 J-11.241

N1410 X0. Y0. I-11.241 J4.2

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N1420 G0 Z20.

N1430 M09

'(OP 4 FINISH PASS TOOL 5 FLAT 20MM 4F EC SCB)

'(EFFECTIVE DIAMETER 20)

N1440 T05 D05 M03 'Select tool and offset

N1450 S2500 M06 'Next tool is 03, Next XY is 1.765, 23.935

N1460 G0 X1.765 Y23.935

N1470 G43 Z5.

N1480 G1 Z-7. F150

N1490 G2 X19.849 Y-13.492 I-1.765 J-23.935 F250

N1500 X-21.613 Y-10.435 I-19.849 J13.492

N1510 X1.765 Y23.935 I21.613 J10.435

N1520 G0 Z5.

N1530 M09

'(OP 5 ROUGHING PASS TOOL 3 CONE - 40MM DIA X 45 DEG)

'(EFFECTIVE DIAMETER 2, STOCK AMOUNT -1)

N1540 T03 D03 M03 'Select tool and offset

N1550 S1500 M06 'Next tool is 06, Next XY is -62., -68.414

N1560 G0 X-62. Y-68.414

N1570 G43 Z20.

N1580 Z5.

N1590 G1 Z-1. F100

N1600 G3 Y-67. I-0.707 J0.707 F250

N1610 G1 X-67. Y-62.

N1620 Y62.

N1630 X-62. Y67.

N1640 X62.

N1650 X67. Y62.

N1660 Y-62.

N1670 X62. Y-67.

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N1680 X-62.

N1690 G0 Z20.

N1700 X1.429 Y32.984

N1710 Z5.

N1720 G1 Z-1. F100

N1730 G2 X2.5 Y33.908 I0.997 J-0.074 F250

N1740 X28.119 Y-19.113 I-2.5 J-33.908

N1750 X-30.618 Y-14.783 I-28.119 J19.113

N1760 X2.5 Y33.908 I30.618 J14.783

N1770 G0 Z130.

N1780 M09

'(OP 7 DRILL HOLES TOOL 7 DRILL - 5MM DIA)

'(TOOL DIAMETER 5, HOLE DIAMETERS 5)

N2070 T07 D07 M03 'Select tool and offset

N2080 S3000 M06 'Next tool is 00, Next XY is 55., 55.

N2090 G0 X55. Y55.

N2100 G43 Z10.

N2105 G1 Z5 F50

N2110 G81 G99 X55. Y55. Z5. I-17.5 K150. F100

N2120 X-55. Y55.

N2130 X55. Y-55.

N2140 X-55. Y-55.

N2150 M09

N2160 G80

N2170 G0 Z10.

N2180 M09

N2190 M30

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