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In this section you will find examples of programming the G76 feature around it. Below is a list of links to different types of controls. In each link, you'll find examples of programs for that control. The list of control types is regularly updated with new examples. To indicate that a new example or link exists, the icon is used to notify you that there has been an update to the content in that section. In FANUC 21i TA controls, the G76 function is a fixed thread cycle. Below are the examples of the different controls: - CONTROL FANUC 21i TA (Fixed Threading Cycle) FANUC controls have three subdivisions of commands, each called A, B, or C. In this case (FANUC series 0i -TC), refers to: FANUC control, zero series in, for lathe and subdivision of commands for programming is C. Below is attached a small table where you can see more clearly that subdivision. In the table, you can see that in the command subdivision C G70 function is measurement in inches, while in command subdivisions A and B, the G70 statement is a final cycle. Note that the way this control is programmed is very similar to the subject controls. Click the picture to see the table in large size. The following link explains very clearly the logic that fanuc follows for naming its controls. Explanation. Extension knowledgeFANUC 0i-TC RegisterPoints and monographsLifestyle»Education»Notes and monographs27 Christmas. 2016G72 G72 G72 W__R__G72 P__Q__U__W__F__ G72 AUTOMATIC DESBASTE CYCLE: Automatic transverse cycle W: Cutting depth on Z.R axis: Reverse distance (radial) P: Number of the first block in profile Q: Number of the last block of profile U: When measuring on the X axis for additional tuning (diametric) : U-) W: When measuring on the Z axis for additional setting F: Insertion speed AUTOMATIC DESBASTE CYCLE G71 G71 G71 U__R__G71 P__Q__U__W__F__G71: Automatic desbacycle U: Depth of cut (radial) R: Re spacing (radial) P: Number of the first block of profile Q: Number of the last profile block U: Overmeasurement on the X axis for additional tuning (diametric) (interior) : U-) W: When measuring on the Z axis for a subsequent setting F : Feed rate. G70 G70 G70 AUTOMATIC CYCLE P__Q__F__ G70: Automatic setting cycle P: Number of the first block of the profile. Q: The number of the last block in profile F: Feedrate. *Note: In this case, when cutting the X-axis (U) the overmeasurement of the X axis (U) will be negative (e.g. AUTOMATIC CYCLE OF DESBASING OVER G73 This cycle is used for cutting forged or molded parts where we have a material envelope that requires multiple passes. The structure of the cycle is as follows: G73 U(-d) W(-k) R(d) G73 P(ni) Q(nf) U(-u) W(-w) F__ Where the tool will make the following trajectory: 'd' upper material in radius presenting the raw, with the corresponding sign. Overmaterial in the length of the raw part, with the corresponding sign. d - number of desbasing passports. or the number of the first profile description block. nf - the number of the last profile description block. Upper material in the diameter of termination. Overmaterial in length for termination. G74 front R__G74 X__Z__P__Q__F__ G74: Automatic front grooving cycle R: Recoil distance after each cut. (Incremental). X: X slot endpoint location (Absolute) Z: Z slot endpoint z position (Absolute) P: Distance between radial passes in millimetres thousandth of one millimetre Q: Depth for each cut in thousandth of one millimetre F: Tightening speed Q x2mm x 1000 P x 2.5mm x 1000 RADIAL G75 G75 Automatic OMENGING CYCLE R__G75 X__Z__P__Q__F__ G75 : Automatic front grooving cycle R : Recoil distance after each cut. (Incremental). X: X the position of the wear endpoint (Absolute) Z: Z position for the wear endpoint (Absolute) P: Radial depth for each cut in a thousandth of one millimetre Q: Distance between throughput in a thousandth of one millimetre F: Feed speed P s 2.5mm x 1000 Q x 2 mm x 1000 AUTOMATIC CYCLE OF ROSCADO G76 G76 P aa bb cc Q__R__G76 X__Z__P__Q__R__F__ G76 : Automatic threading cycle P aa: Number of iterations of the last adjustment pass. bb: Progressive thread output (tenths of a step). cc: Thread angle to define the input angle of the mtv. Q: Depth per pass in thousandth of one millimeter R: Depth of last pass in millimeters. X: X coordinate of the thread endpoint (Ext thread: Main diameter - 2 * Prof.) (Thread int: Minor Diameter + 2 * Prof.) Z: Z coordinate of the thread endpoint. Q: Total Thread Depth in thousandth of a millimeter. Q: The depth of the first pass in a millimeter. A: Radial difference in millimeters for tapered threads (-ext thread; + int thread) F: Thread pitch in millimeters. Example: Thread height: 2 mm Total thread depth: 1.5 mm first pass depth: 0.22 mm Next pass depth: 0.16 mm Depth for last throughput: 0.02 mm G97 S1000 M3 G0 X25. Z5. G76 P010030 Q160 R0.02 G76 X19. Z-42. P1500 Q220 R0. F2. G0 X200. Z200. Hi well here I leave you the plane of a few simple pieces for anyone who wants to do the program in I have done it with fagor 8050 and later I will do it with fanuc16iT. Uploaded with ImageShack.us N10 G54 N20 G92 S2200 N30 G90 G95 G96 F0.2 S150 T1 D1 M4 N40 G0 X32 Z2 M8 N50 G82 X30 Z0 Q-1 R0 C0.5 L0 M0 N60 G0 G42 X30.5 Z2 N70 G68 X8.5 Z0 C1 D1 L0.25 M0.2 H0 S110 E160 N80 G0 G40 X200 Z200 N90 G90 G95 G96 F0.175 S175 T3 D3 N100 G0 G42 X12 Z5 N110 G1 X8.5 Z0 N120 X17 Z-8 N130 X17 Z-13 N140 X29 Z-19 N150 X29 Z-24.9 N160 X30 Z-24.9 N170 G0 G40 X200 Z200 N180 M30 PIEZA10CNCdJvicenteleon.avi Otra mas que la llamaremos pieza 20 Uploaded with ImageShack.us N10 G54 N20 G92 S2200 N30 G90 G95 G96 F0.2 S175 T1 D1 M4 N40 G0 G40 X55 Z2 M8 N50 G82 X50 Z0 Q-1 R0 C0.5 L0 M0 H0 N60 G0 G42 X51 Z2 N70 G68 X14 Z0 C1 L0.2 M0.1 H0 S110 E170 N80 G0 G40 X200 Z200 N90 G90 G95 G96 F0.175 S200 T3 D3 N100 G0 G42 Z16 Z2 N110 G1 X14 Z0 N120 G3 X20 Z-3 I0 K-3 N130 G1 X20 Z-25 N140 X30 Z-25 N150 G3 X40 Z-30 I0 K-5 N160 G1 X40 Z-50 N170 G2 X50 Z-55 R5 R5 N180 G0 G40 X200 Z200 N190 M30 PART20CdJvicenteleon.avi A salu2 good work a auxi for the initiative, a greeting. If you want to see my photo gallery click on the picture Thanks for auxi zoxki33, here's another one we'll call it part21. Uploaded with ImageShack.us N10 G54 N20 G92 S2200 N30 G90 G95 G96 F0.175 S180 T1 D1 D1 M4 N40 G0 G40 X54 Z2 M2 M8 N50 G8 N50 G82 X50 Z0 Q-1 R0 C0.5 L0 M0 N60 G0 G42 X51 Z2 N270 G66 X24 Z0 I12 C1.5 L0.25 M0.1 H0 S110 E210 N80 G0 G40 X200 Z230 N90 G90 G95 G96 F0.175 S200 T3 D3 N100 G0 G42 X26 Z2 N110 G1 X24 Z0 N120 G3 X30 Z-3 I0 K-3 N130 G1 X30 Z-10 N140 G1 X34 Z-10 N150 G3 X40 Z-13 I0 K-3 N160 G1 X38 Z-15 N170 G1 X38 Z-25 N180 X44 Z-25 N190 X44 Z-39 N200 X48 Z-42 N210 X48 Z-57 N220 G0 G40 X200 Z200 N230 M30 part21cncDJVICENTELEON.avi A salu2 Well here I leave the machining in fanuc 16i-tc of part number 10. N10 G10 P0 Z-53 N20 G92 S2200 N30 G90 G95 G96 F0.2 S150 T0101 M4 N40 G0 X32 Z2 M8 N50 G24 X-1 Z1.5 F0.150 N60 Z1 N70 Z0.5 N80 Z0 N90 G42 X30 Z2 N100 G73 U1.5 R1 N110 G73 P120 Q170 U0.25 W0.2 F0.175 S170 N120 G0 X8 Z0 N13 10 G1 X17 Z-8 N140 X17 Z-13 N150 X29 Z-19 N160 Z-24.9 N170 X30 Z-24.9 N180 G0 G40 X200 Z200 N190 T0303 N2 00 G90 G95 G96 F0.118 S180 N210 G0 G42 X32 Z2 N220 G72 P120 Q170 N230 G0 G40 X40 N240 G28 U10 W0 N250 M30 YouTube - broadcast yourself. and number 20 with fanuc tb N10 G10 P0 Z-78 N20 G92 S2200 N30 G90 G95 G96 F0.170 S180 T0101 M4 N40 G0 G40 X52 Z2 M8 N50 G1 G24 X-1 Z1.5 N60 Z1 N70 Z0.5 N80 Z0 N90 G0 G42 X50 Z2 N100 G73 U1 R1 N110 G73 P120 Q180 U0.25 W0.2 N120 G0 X14 Z0 N130 G3 X20 Z-3 I0 K-3 N140 G1 X20 Z-25 N150 X30 Z-25 N160 G3 X40 Z-30 I0 K-5 N170 G1 X40 Z-50 N180 G2 X50 Z-55 I5 K0 N190 G0 G40 X200 Z200 N20 t0303 N210 G90 G95 G96 F0.118 S190 N220 G0 G42 Z52 Z2 N230 G72 P120 Q180 N240 G0 G40 X80 N250 G28 U50 W0 N260 M30 YouTube - Broadcast Yourself. e-mail. Everything to add / suggestions / . Comments? Glad to send them. Thanks.. Read by Jose Meccanico INSTITUTO TECNICO INDUSTRIAL FRANCISCO JOSE DE CALDAS GUIA . 3 LIC. JOSE ARNULFO VILLANUEVA M. MECANICA INDUSTRIAL-TECHNICAL PROGRAM C. N.C GRADE 1105-AUGUST 28 2013THEM: INTRODUCTION TO ISO FRESADORA AND TORNO CNC PROGRAMMING. Students:... More Read the publication Read of jose mechanical computer numerical control C. N.C. PRINCIPLES OF CNC PROGRAMMING FOR NUMERICAL CONTROL MACHINING CENTERS WITH FANUC CNC CONTROL means computer numerical control, in Spanish numerical control of computer. Control is taken as ... More Read the publication (The PC must be set so that the decimal point is effectively a period and not a comma (If it is to run this program on a genuine CNC lathe (We define the size of the mole so that the simulator knows, what to start with [TICKET X25 Z55 (Spindle speeds and tool feed are the ones that would correspond (to a medium machine working a steel relatively soft type 1010 (The tool changer would have a thin/polished grinding tool at position 1 (a 5mm wick at position 2 (and a threaded tool at position 3 (The names of the old CNC programs could only contain numbers (If this program had been called 0001.fln, the next line would be its unique

identifier O0001 (We use G21 metric system (Advances will be defined by the G99 revolution (another way could have been forward by the minute (Before you start , we asked for a tool change. Tool 01 with local offset set 01 M06 T0101 (Spindle speed will be specified in RPM (We now ask for 1800 rpm (and start the engine clockwise G97 S1800 M03 (We ask, that each axle moves as fast as it can to the coordinates relative to the coordinates related to the part (diameter X-26 mm and Z-axis x 2 mm (The movement will not necessarily be a straight line (probably it will result in a broken line according to the place from which it is divided (and the shaft displacement speeds, that the machine in question has the G00 X26 Z2 (reach this point near the part we move straight to the Z-0 right edge (but still out of the mole, as its diameter would be 25 mm (We continue inside the G00 that may have multiple lines indicating successive offsets Z0 (Now if we move the tool in a controlled way through segments straight and circumference (This controlled way is sometimes called linear or circular interpolation as the case may be (We move to a negative diameter (We pass the middle to face mole (The feed will be 5 G01 X-1 F.05 (Now we return to an external position as soon as possible (This position was selected above and to the right of the contour to be defined under the G00 X26 Z2 (ATTENTION one of the best CNC instructions Cycle on top Displacement bolts (Serves to debate large amounts of material in multiple shear passes (making a ladder, but without having to define movements of the ladder (but only the movements describing the desired final contour (There are two limitations to be taken into account. (a) The contour must be monotonously growing or descending (b) The first defined movement must front (G71 is so long that it does not fit on old plant displays with large characters and low resolution (so it is despot in 2 consecutive lines G71 U.75 R.25 G71 P1 Q1 Q2 U1 .0 W.1 F.07 (U.75 In each offset we calamos 75 centesimas mm (R.25 Reached at the end of the cylinder we separate the tool 25 centesimas of mm so as not to scratch the part (P1 Contour begins to be defined in line N1. N1 does not need to be adjacent to G71 (Q2 Contour is finished defining in line N2 (U1.0 We reserve 1 mm diameter upper dimensions to leave it for finishing/polishing cycle (W 1 We reserve 1 decima mm overmeasure on the Z axis for the same purpose (F.07 Tool will promote 7 cents of mm for each turn (Line N1 begins the contour, makes a clean FRONT advance from the last position before the G71 (almost to the nose of the N1 G00 X0 tocho (We enter despacio machining to the nose of the G01 Z0 mole (We cut an arc of anti-clock circumference from where we are up to Z-8mm with a radius of 8 mm and a half (We let CNC take care of calculation , where the center should be etc (We define a speed of 2500 rpm that will be ignored in the thick, but taken into account in the finish G03 X17 Z-8.5 R8.5 S2500 (Now we are cylindrical up to Z-13 mm and medium G01 Z-13.5 (We make a cone strain up to 20 mm in diameter and Z-2 14 and some mm X20 Z-14.36 (Cilindramos up to Z-28 mm and half Z-28.5 (Second cone trunk (Note that the diameters always grow (If a notch should be machined another monotonous descending cycle X24 Z-46.5 (One step up to the diameter of 26 mm X26 (Last line of the cycle (We sent the tool to the same position as it had before claiming G71 N2 G00 X26 Z2 (Now that we have done the thick we do finish in a single pass with the G70 (The contour to follow is the same used before and defined between lines N1 and N2 G70 P1 Q2 (We send the cart to the resting position from G28 U0 W0 part (We stop the M05 engine (We ask for a tool change (It comes threading with tool 03 using its offset set 03 M06 T0303 that the spindle speed will be set to RPM (We lower the turning speed drastically and restart the G97 S500 M03 engine (We are fast approaching the G00 X20.5 Z engine piece 10 (We start a threading cycle with multiple passes (G76 is another long instruction unfolded in 2 lines (G76 is more complex than the G71, because the section seen by the tool depends on the depth (which has come to lust (This is why the first draft can be relatively deep , but each of the following has a lower draft G76 P050060 Q035 R.0 G76 X18.00 Z-26.5 P1000 Q070 F1.5 (P05 thread FINISH will be done in 5 passes There will be other clear previous passes (00 angle chanfle when they come in and out the thread cutting (60 is the angle that has the thread tip used (Q035, if what remains to be squipped is 35 microns or less will be done in a single pass (R.0 overmeasured (R.0 overmeasured which is left to a finishing pass with another tool In this case we leave nothing (X18.00 inner diameter of 18 mm thread (Z-26.5 thread will expand to this position of Z (P1000 thread fillet trend 1000 microns in diameter direction (Q070 The first cut will have a draft of 70 microns or 7 centesimes (In the following passes the tip will always see the same material range , to be barked (F1.5 thread will have a pitch of 1 mm and a half (We send the cart to the resting position away from the G28 U0 W0 part (Mission completed we stop the program and rewind it leaving it ready for another M30 execution (Also could use M00 that slows it down but does not rewind it rewind it rewind

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