

CncSimulator Torna Kodları

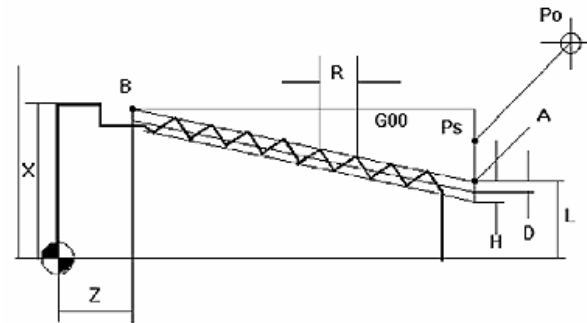
G0 or G00	Rapid movement
G1 or G01	Linear interpolation
G2 or G02	Clockwise interpolation
G3 or G03	Anti-clockwise interpolation
G25	Subprogram call
G26	Separate subprograms (disk)
G83	Threading cycle
G84	Rough machining cycle
G53	No zero point displacement
G54	Zero point 1
G55	Zero point 2
G56	Zero point 3
G57	Zero point 4
G58	Zero point 5
G59	Zero point 6
G90	Absolute programming
G91	Incremental programming
G92	Zero point displacement
G94	Specify feed rate in mm/min
G95	Specify feed rate in mm/revolution

F	Feed rate
S	Spindle speed
N	Block number
T	Tool
X	Code for the X-axis
Z	Code for the Z-axis
I	Incremental distance to the center in the X-axis
K	Incremental distance to the center in the Z-axis
R or Z	Arc <180 grader
R- or Z-	Arc >180 grader
L	Threading cycle parameter diam/radius, point A
D	Threading cycle depth mm/cut
H	Threading cycle total thread depth
U	Sub program amount of repetitions

M0 or M00	Program stop
M3 or M03	Spindle start clockwise
M4 or M04	Spindle start anti-clockwise
M5 or M05	Spindle stop
M8 or M08	Coolant on
M9 or M09	Coolant off
M17	Return from subprogram
M30	Program end

G83 X... Z... R... L... D... H...

The threading cycle can be used for both straight ($L=X$) and taper (L is not equal to X) threads. Before calling the threading cycle the tool should be at the start position (P_s). G83 can not be used incrementally. The cycle returns to the point P_s upon completion. D should be set to 1 to obtain the best graphical results (only for simulating).

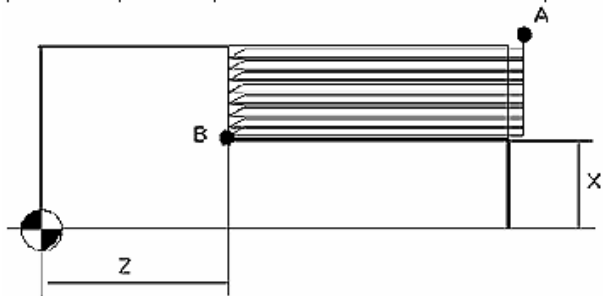


X diameter or radius of point B
Z co-ordinate of point B
R the lead of the thread in mm/revolution
L diameter or radius of point A

D depth per cut
H total thread depth

G84 X... Z... P...

The rough machining cycle is used to take off excess material in several cuts. Before calling the cycle the tool should be placed at point A. Upon completion the tool will return to point A.



X Diameter or radius of point B
Z co-ordinate of point B
P-depth per cut (a negative value)