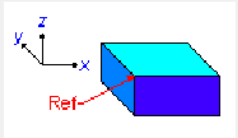
Let’s Program Together

…do it by the numbers

Let’s Program Together

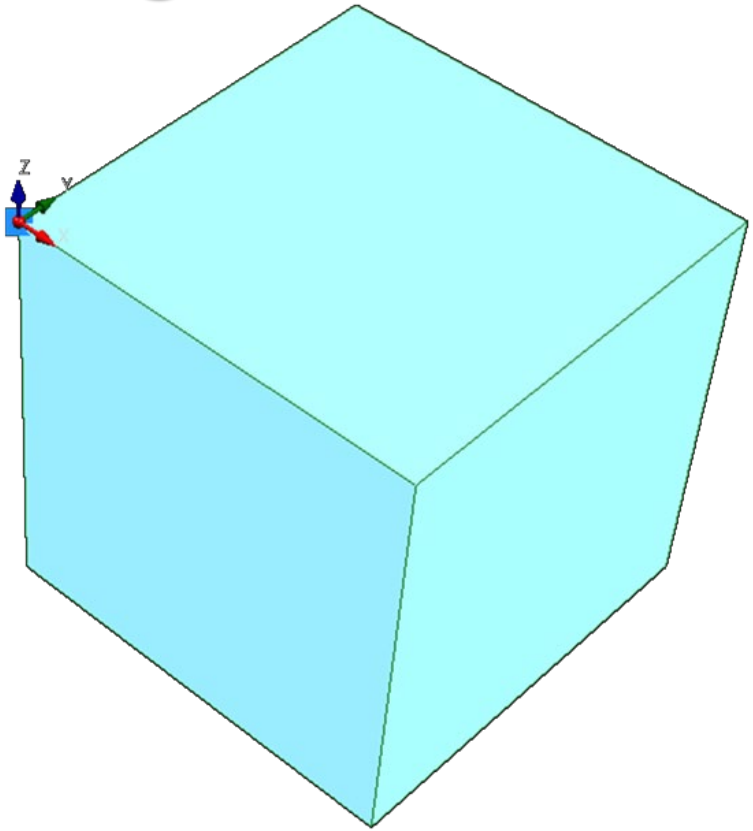
STOCK GEOMETRY

MANUAL STOCK SIZING	YES	ZERO REF	PART ZERO
		X REF POSITION	0.0000
		Y REF POSITION	0.0000
		Z REF POSITION	0.0000
STOCK TYPE	BOX		
X LENGTH	6.0000		
Y LENGTH	6.0000		
Z LENGTH	6.0000		

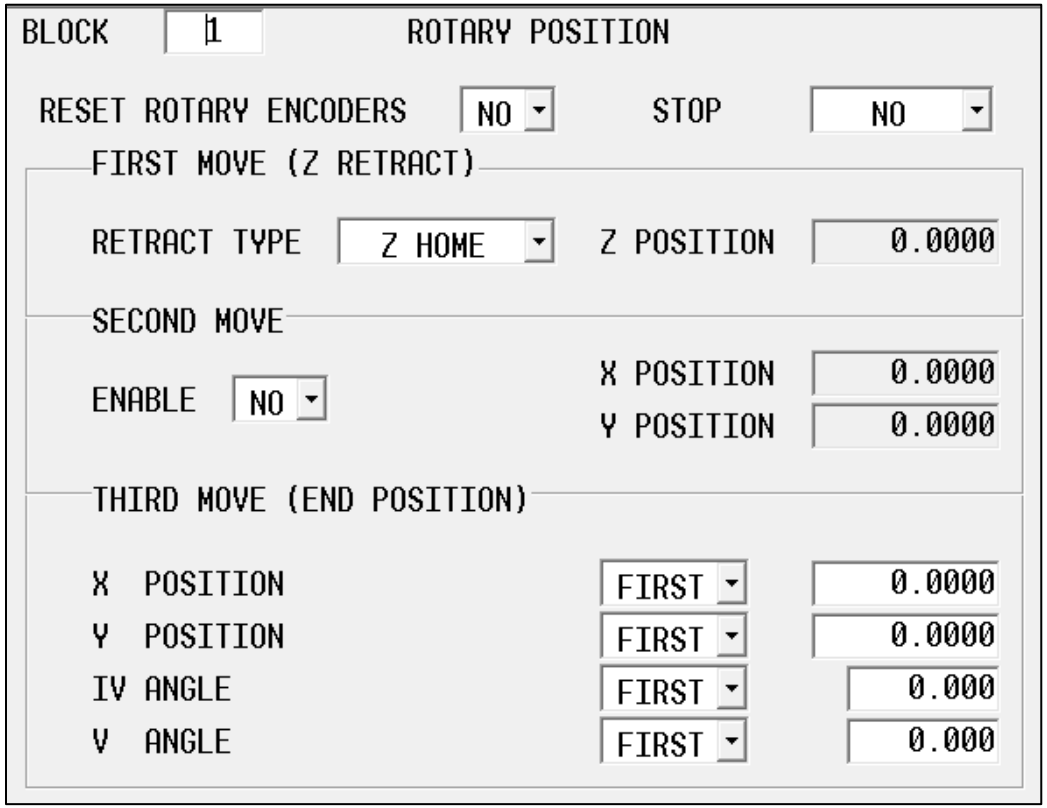


PROGRAM REVIEW SCREEN

DATA BLOCKS	SUB BLOCKS
1. ROTARY POSITION	
END OF PROGRAM	



Let’s Program Together



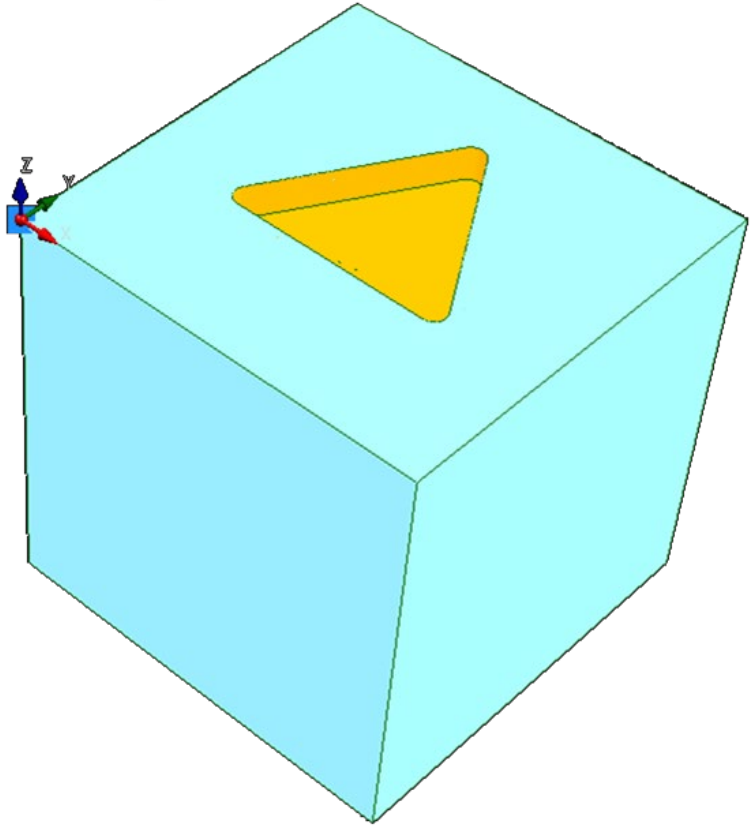
- Start every program with a Rotary Position Block
- Ensures that the tilting and rotary axes are at a known location before starting the program
- Almost always leave the data to the default values

Let’s Program Together

BLOCK	2	MILL POLYGON	
NUMBER OF SIDES	3	Z START	0.1000
X CENTER	3.0000	Z BOTTOM	-0.5000
Y CENTER	3.0000	CORNER RADIUS	0.0000
SIZING METHOD	OUTER DIAMETER		
SIZING DIAMETER	4.0000		
ORIENTATION ANGLE	0.000		

ROUGHING | FINISHING | SFQ

TOOL	1 END MILL, dia. 0.5000		
MILLING TYPE	POCKET BOUNDARY		
POCKET TYPE	OUTWARD	POCKET OVERLAP (%)	50
MILL FEED	91.7	PECK DEPTH	0.1000
SPEED (RPM)	9167	PLUNGE FEED	20.0



Let’s Program Together

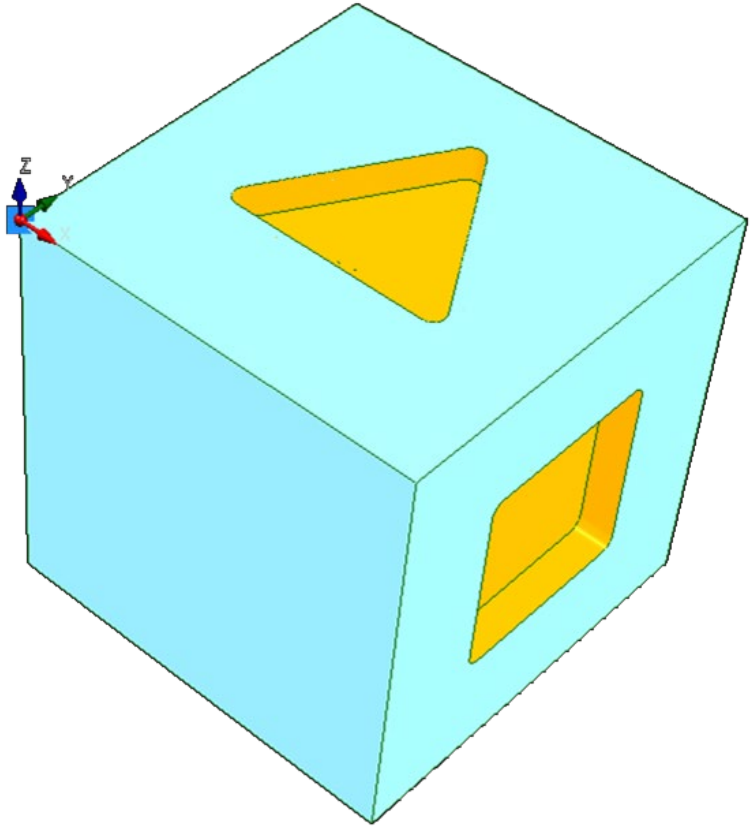
BLOCK 3 UNIVERSAL ROTARY TRANSFORM PLANE

ORIENT METHOD ANGLES

ORIGIN POINT		AXIS ANGLES	
X	6.0000	R(X)	0.000
Y	0.0000	R(Y)	90.000
Z	0.0000	R(Z)	0.000

PROGRAM REVIEW SCREEN

DATA BLOCKS	SUB BLOCKS
1. ROTARY POSITION	
2. MILL POLYGON (POCKET BOUNDARY)	
3. TRANSFORM PLANE	
4. MILL POLYGON (POCKET BOUNDARY)	
5. TRANSFORM PLANE END	
END OF PROGRAM	



Let’s Program Together

BLOCK 6 UNIVERSAL ROTARY TRANSFORM PLANE

ORIENT METHOD ANGLES

ORIGIN POINT

X	0.0000
Y	0.0000
Z	-6.0000

AXIS ANGLES

R(X)	90.000
R(Y)	0.000
R(Z)	0.000

PROGRAM REVIEW SCREEN

DATA BLOCKS	SUB BLOCKS
3. TRANSFORM PLANE	
4. MILL POLYGON (POCKET BOUNDARY	
5. TRANSFORM PLANE END	
6. TRANSFORM PLANE	
7. MILL POLYGON (POCKET BOUNDARY	
8. TRANSFORM PLANE END	
END OF PROGRAM