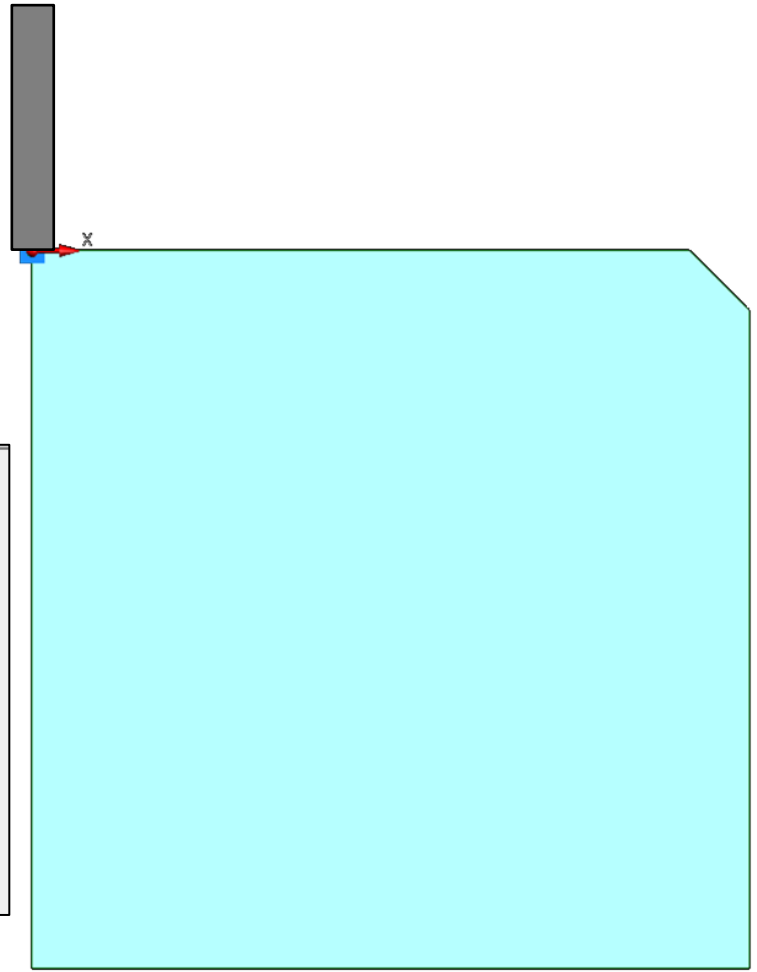
Controlling the Direction

…chamfer with end and side of endmill



BLOCK 1 TRANSFORM PLANE

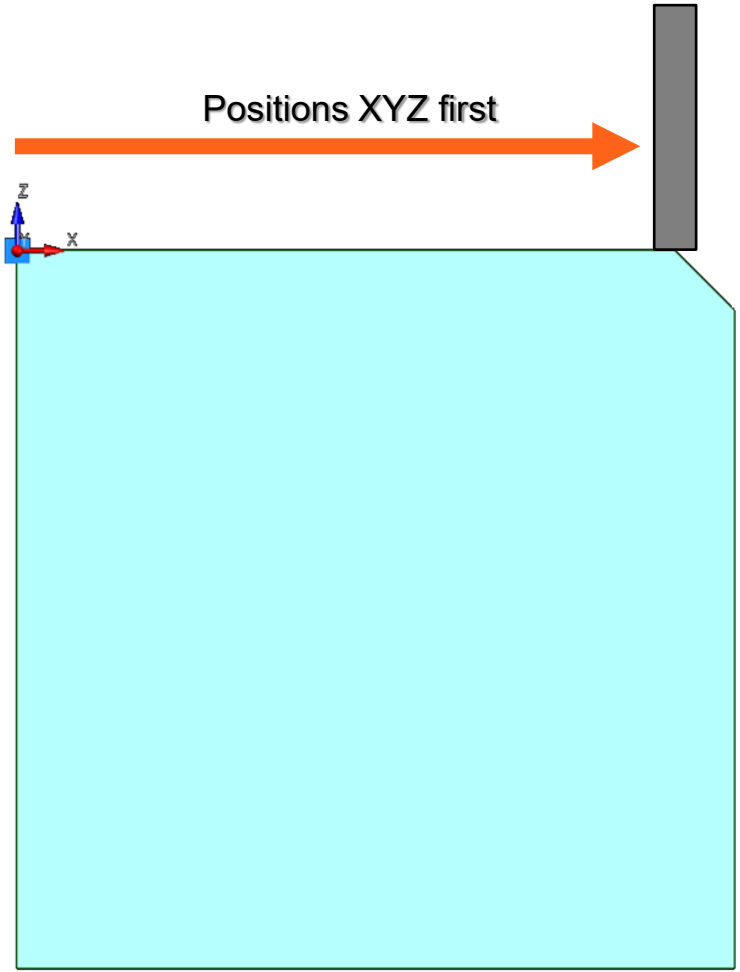
ORIENT METHOD ANGLES

ORIGIN POINT

X	5.5000
Y	0.0000
Z	0.0000

ROTATION ANGLES

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



BLOCK 1 TRANSFORM PLANE

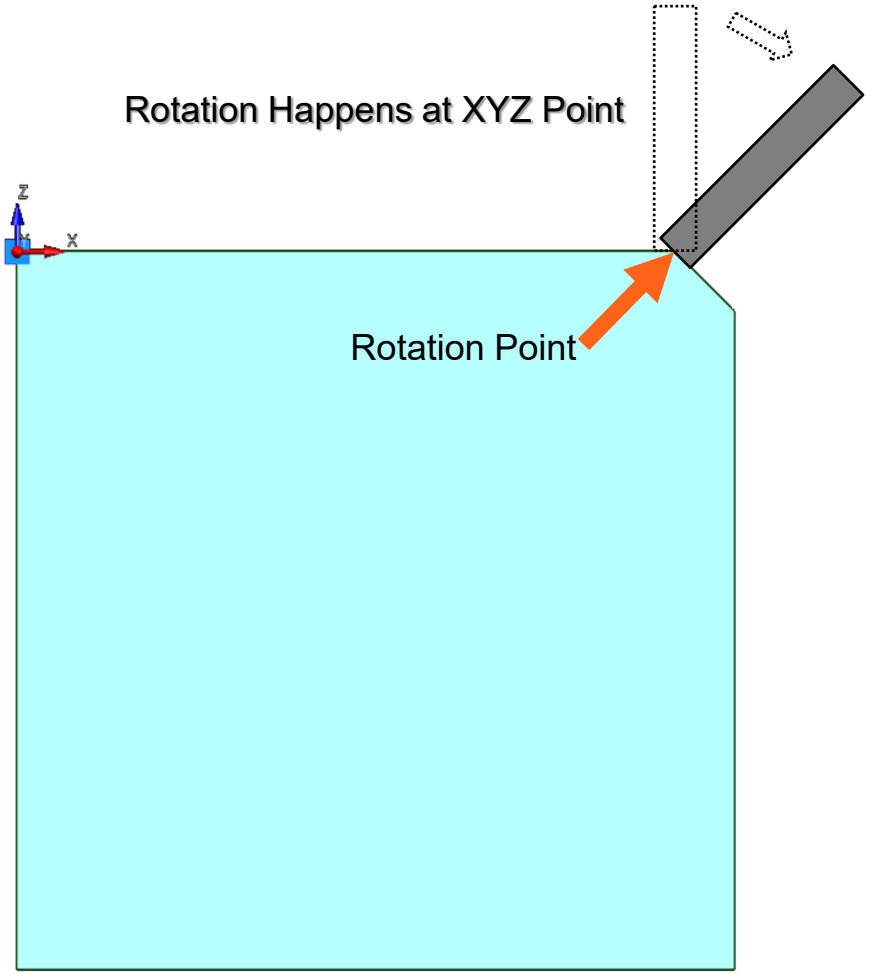
ORIENT METHOD ANGLES

ORIGIN POINT

X	5.5000
Y	0.0000
Z	0.0000

ROTATION ANGLES

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



BLOCK 1 TRANSFORM PLANE

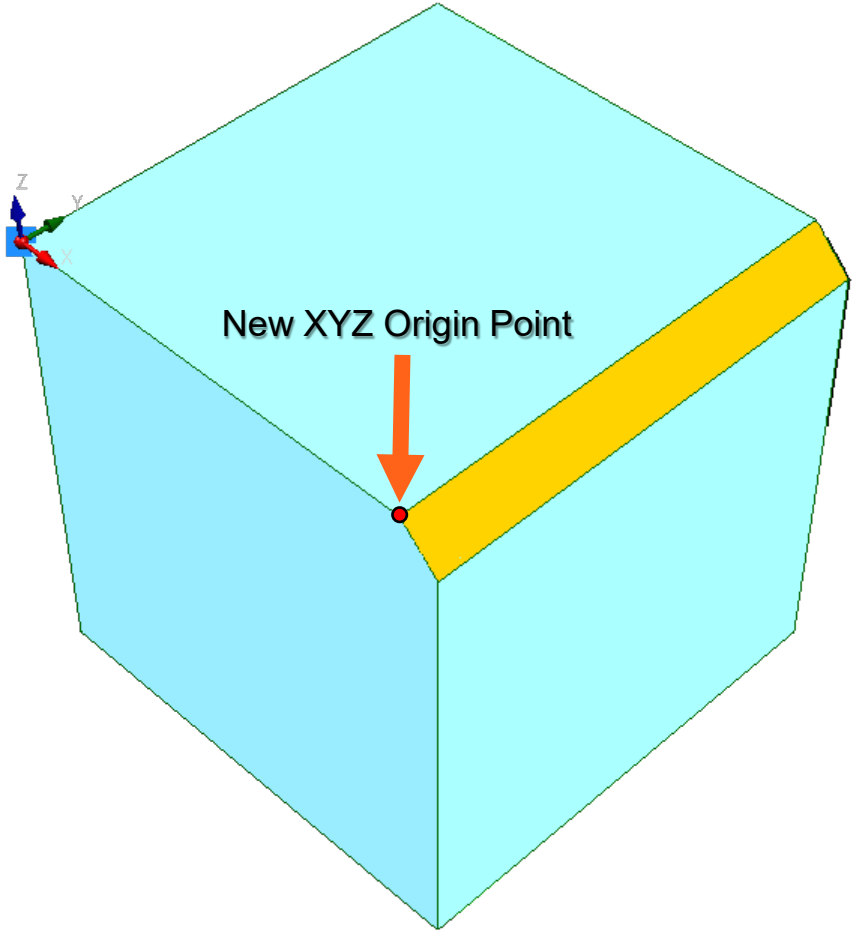
ORIENT METHOD ANGLES

ORIGIN POINT

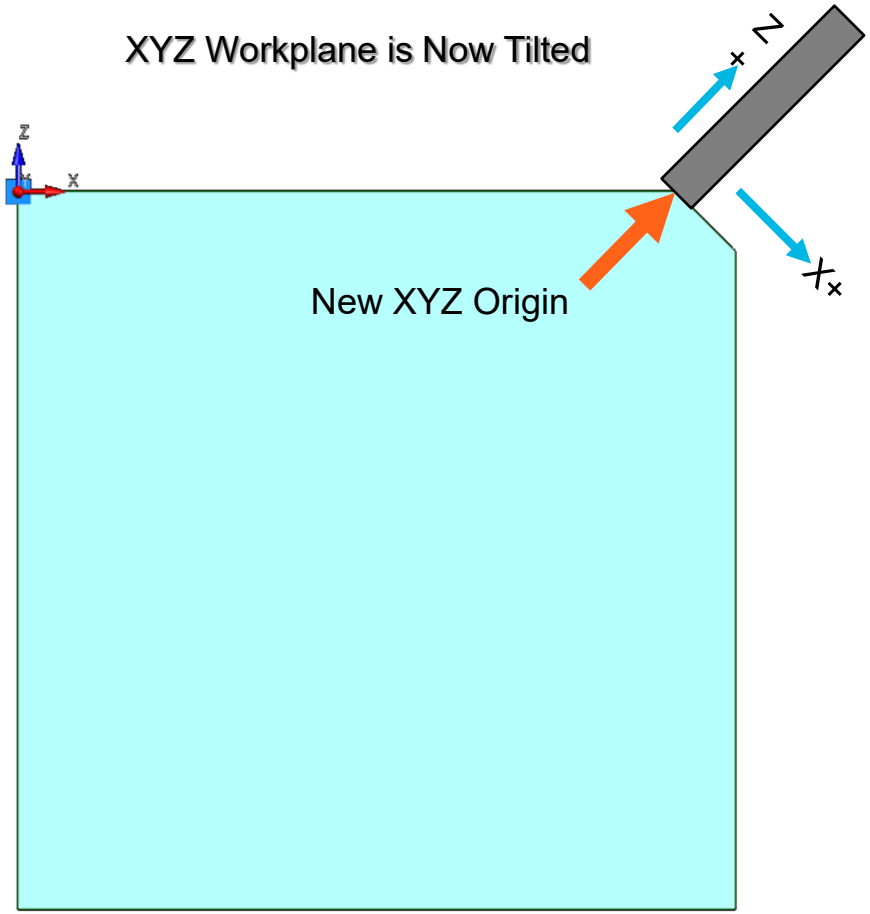
X	5.5000
Y	0.0000
Z	0.0000

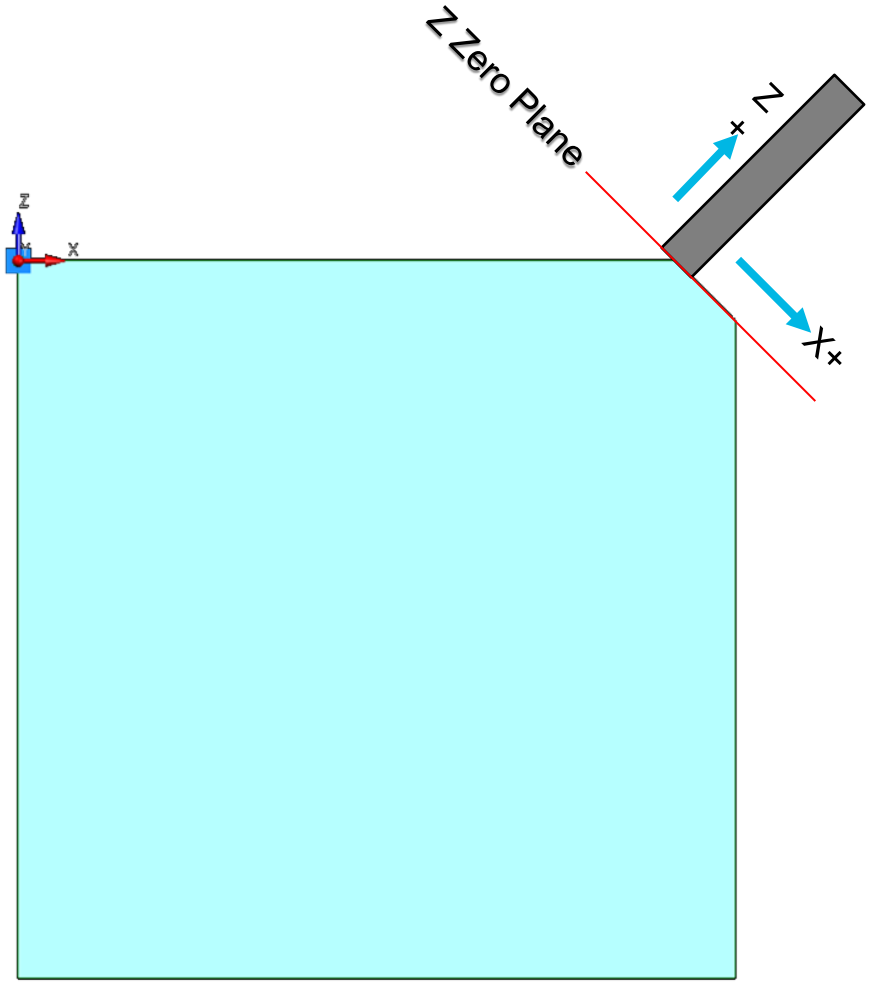
ROTATION ANGLES

R(X)	0.000
R(Y)	45.000
R(Z)	0.000

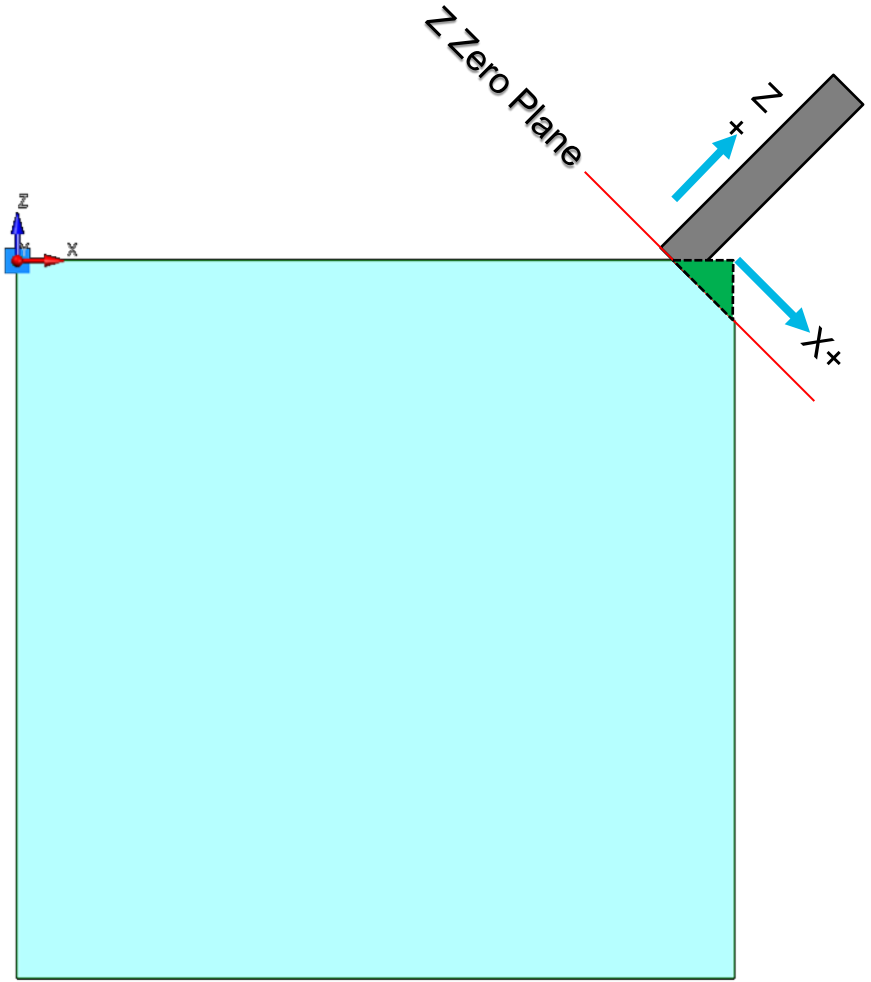


XYZ Workplane is Now Tilted

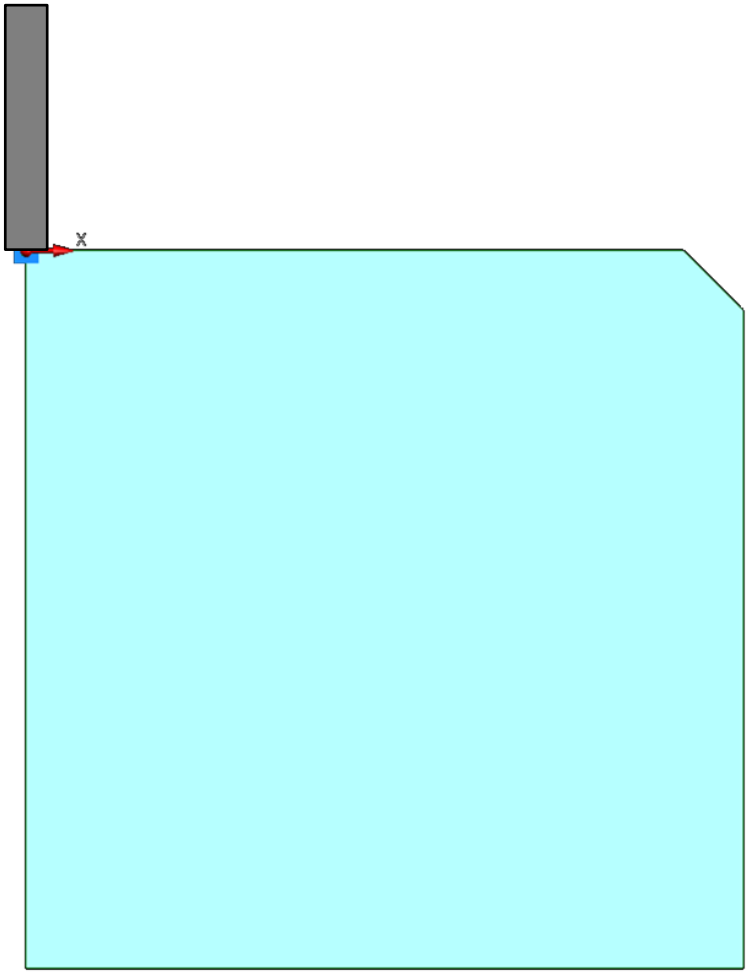




BLOCK	2	MILL FRAME	
GEOMETRY	CORNERS		
X CORNER	-0.2500	Z START	0.5000
Y CORNER	-0.2500	Z BOTTOM	0.0000
X LENGTH	1.0000	CORNER RADIUS	0.0000
Y LENGTH	6.5000		



BLOCK	2	MILL FRAME	
GEOMETRY	CORNERS		
X CORNER	-0.2500	Z START	0.5000
Y CORNER	-0.2500	Z BOTTOM	0.0000
X LENGTH	1.0000	CORNER RADIUS	0.0000
Y LENGTH	6.5000		



BLOCK 1 TRANSFORM PLANE

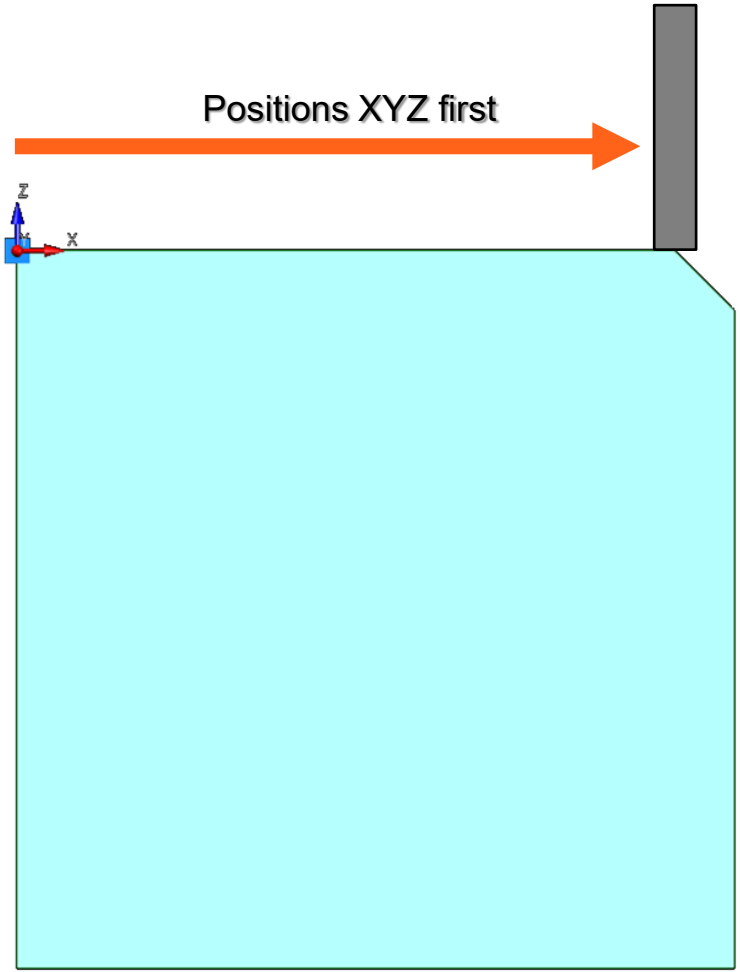
ORIENT METHOD ANGLES

ORIGIN POINT

X	5.5000
Y	0.0000
Z	0.0000

ROTATION ANGLES

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



BLOCK 1 TRANSFORM PLANE

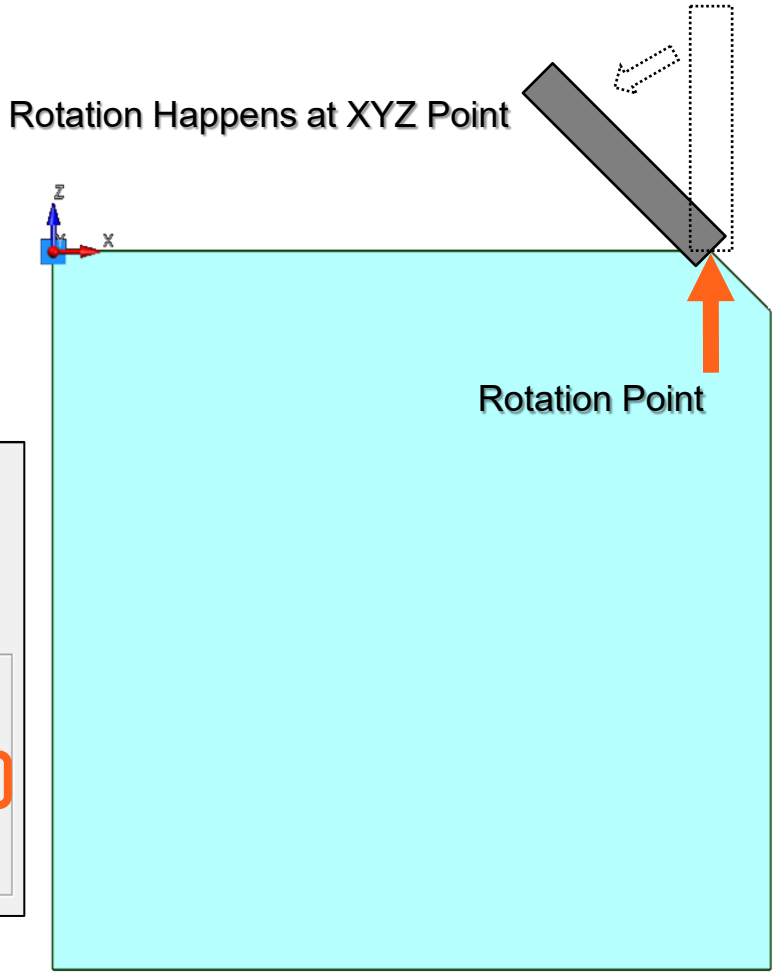
ORIENT METHOD ANGLES

ORIGIN POINT

X	5.5000
Y	0.0000
Z	0.0000

ROTATION ANGLES

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



BLOCK 1 TRANSFORM PLANE

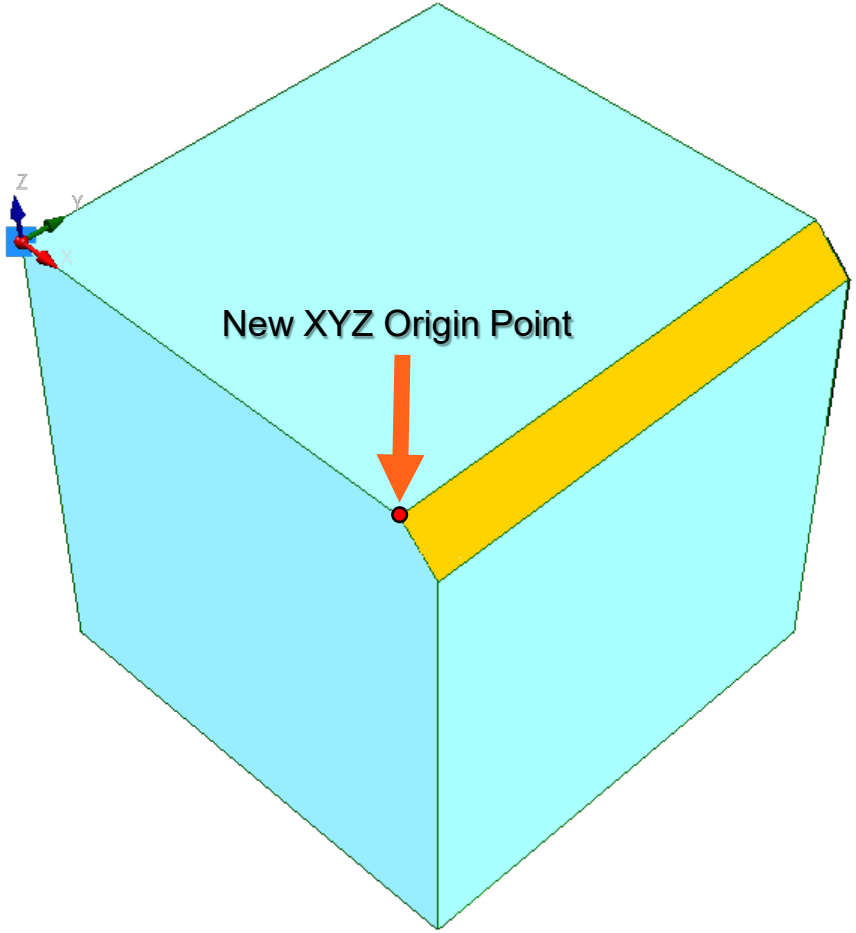
ORIENT METHOD ANGLES

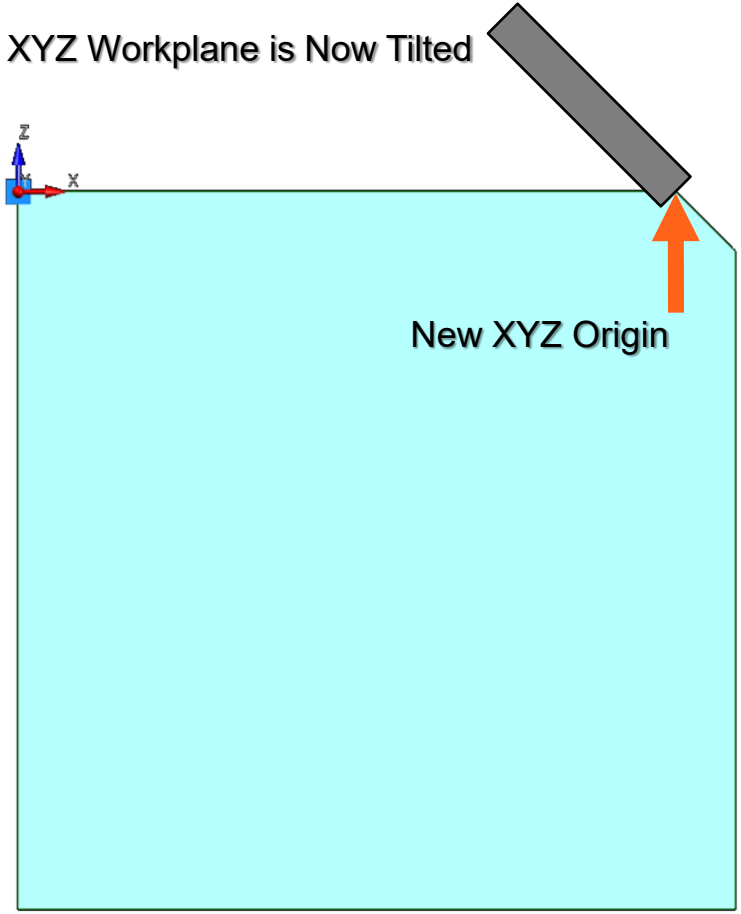
ORIGIN POINT

X	5.5000
Y	0.0000
Z	0.0000

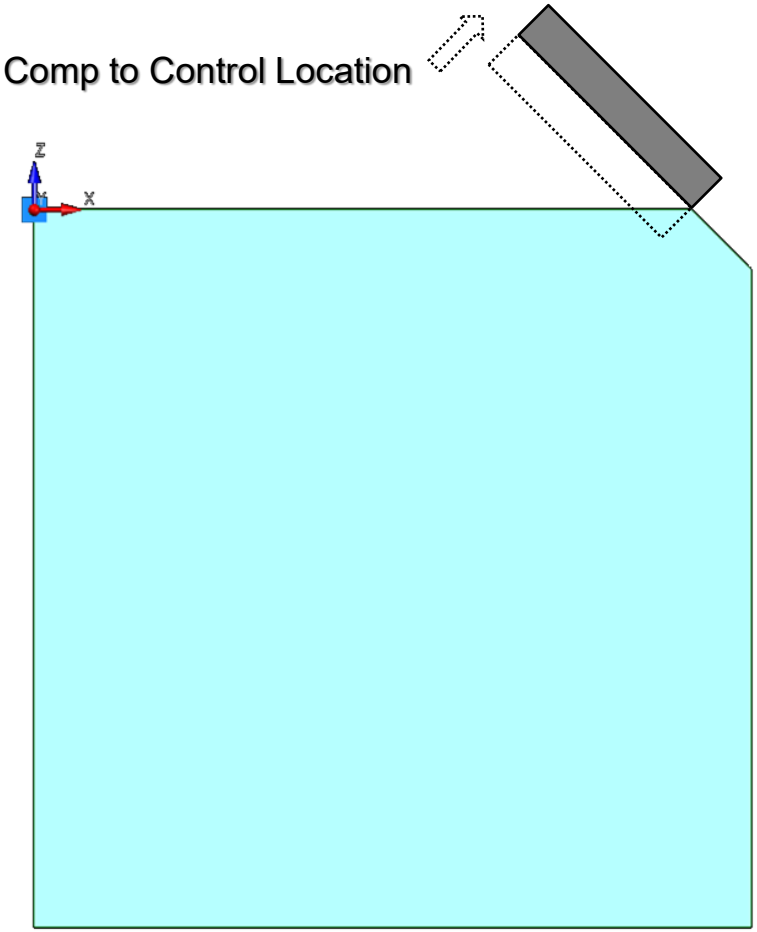
ROTATION ANGLES

R(X)	0.000
R(Y)	-45.000
R(Z)	0.000


Z
Y
X
New XYZ Origin Point


XYZ Workplane is Now Tilted
Z
X
New XYZ Origin

Cutter Comp to Control Location



BLOCK	4	MILL CONTOUR	
SEGMENT	0	START	
X START	0.0000	Z START	0.1000
Y START	0.0000	Z BOTTOM	-1.0000

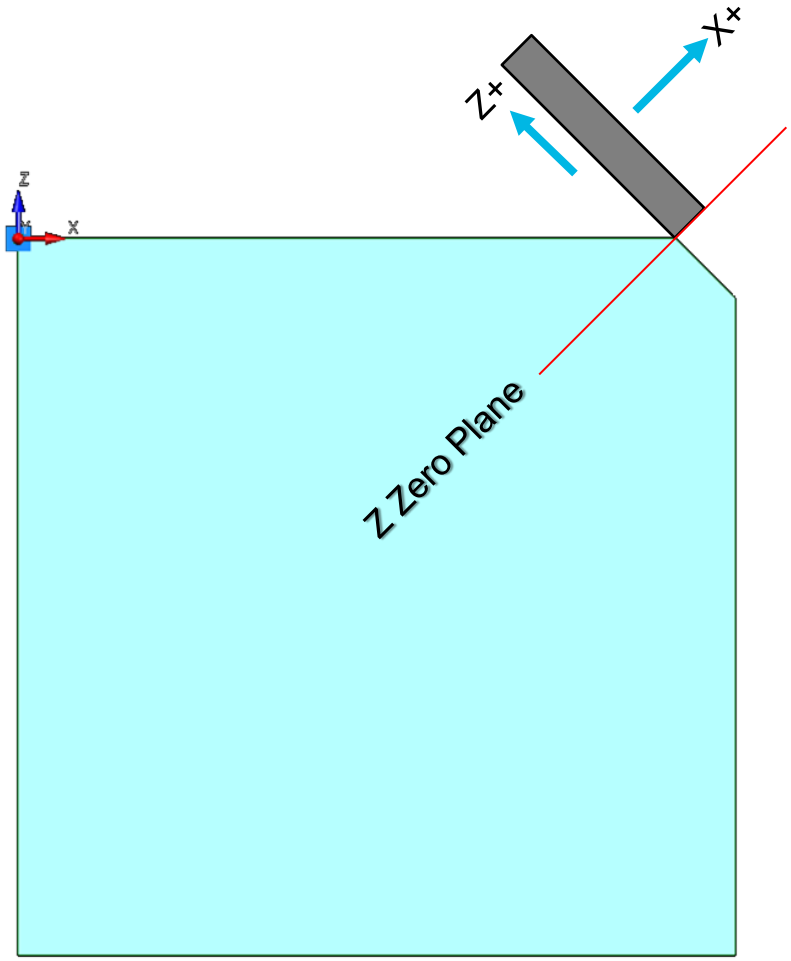
ROUGHING | FINISHING | SFQ | ALLOWANCES

TOOL	73 END MILL, dia. 0.5000		
MILLING TYPE	RIGHT		
ENABLE BLEND MOVES	YES		
MILL FEED	85.0	PECK DEPTH	0.0000
SPEED (RPM)	5000	PLUNGE FEED	0.0

BLOCK	4	MILL CONTOUR	
SEGMENT	0	START	
X START	0.0000	Z START	0.1000
Y START	0.0000	Z BOTTOM	-1.0000

ROUGHING | FINISHING | SFQ | ALLOWANCES

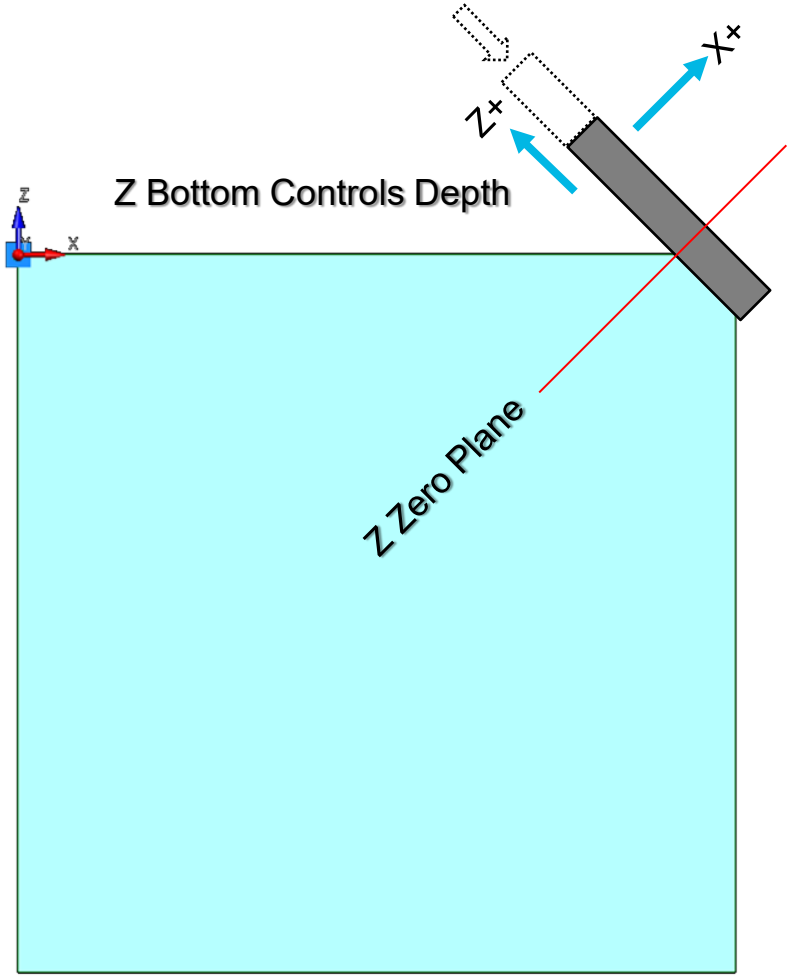
TOOL	73 END MILL, dia. 0.5000		
MILLING TYPE	RIGHT		
ENABLE BLEND MOVES	YES		
MILL FEED	85.0	PECK DEPTH	0.0000
SPEED (RPM)	5000	PLUNGE FEED	0.0



BLOCK	4	MILL CONTOUR	
SEGMENT	0	START	
X START	0.0000	Z START	0.1000
Y START	0.0000	Z BOTTOM	-1.0000

ROUGHING | FINISHING | SFQ | ALLOWANCES

TOOL	73 END MILL, dia. 0.5000		
MILLING TYPE	RIGHT		
ENABLE BLEND MOVES	YES		
MILL FEED	85.0	PECK DEPTH	0.0000
SPEED (RPM)	5000	PLUNGE FEED	0.0



Let’s Program Together

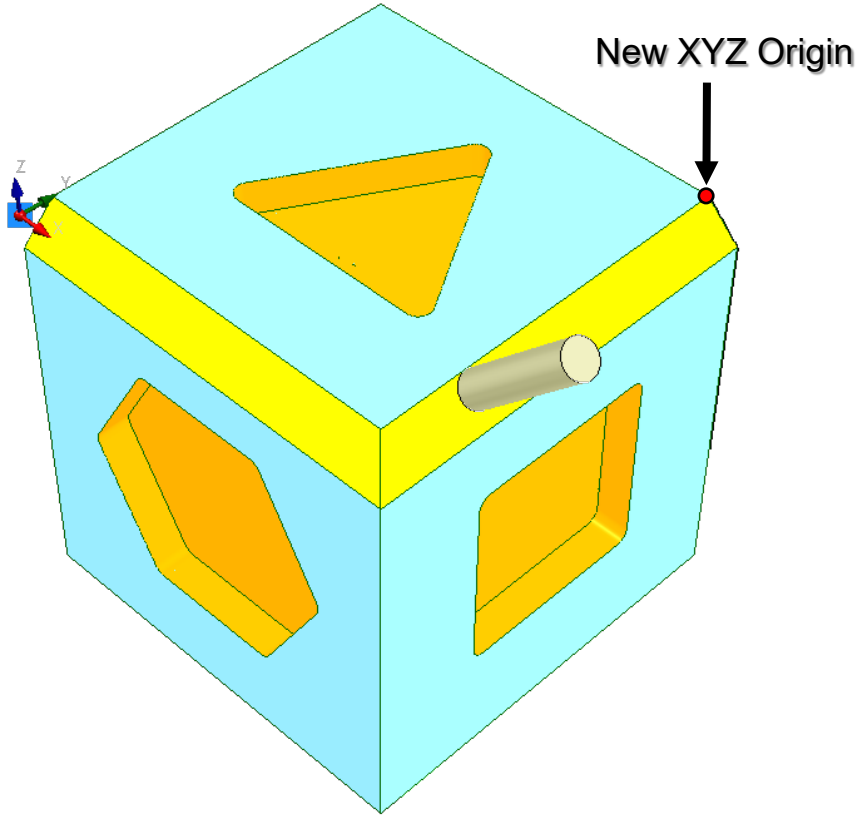
BLOCK 9 UNIVERSAL ROTARY TRANSFORM PLANE

ORIENT METHOD ANGLES

ORIGIN POINT		AXIS ANGLES	
X	5.7500	R(X)	0.000
Y	6.0000	R(Y)	45.000
Z	0.000	R(Z)	0.000

PROGRAM REVIEW SCREEN

DATA BLOCKS	SUB BLOCKS
6. TRANSFORM PLANE	
7. MILL POLYGON (POCKET BOUNDARY	
8. TRANSFORM PLANE END	
9. TRANSFORM PLANE	
10. MILL FRAME (POCKET BOUNDARY)	
11. TRANSFORM PLANE END	
END OF PROGRAM	



Let’s Program Together

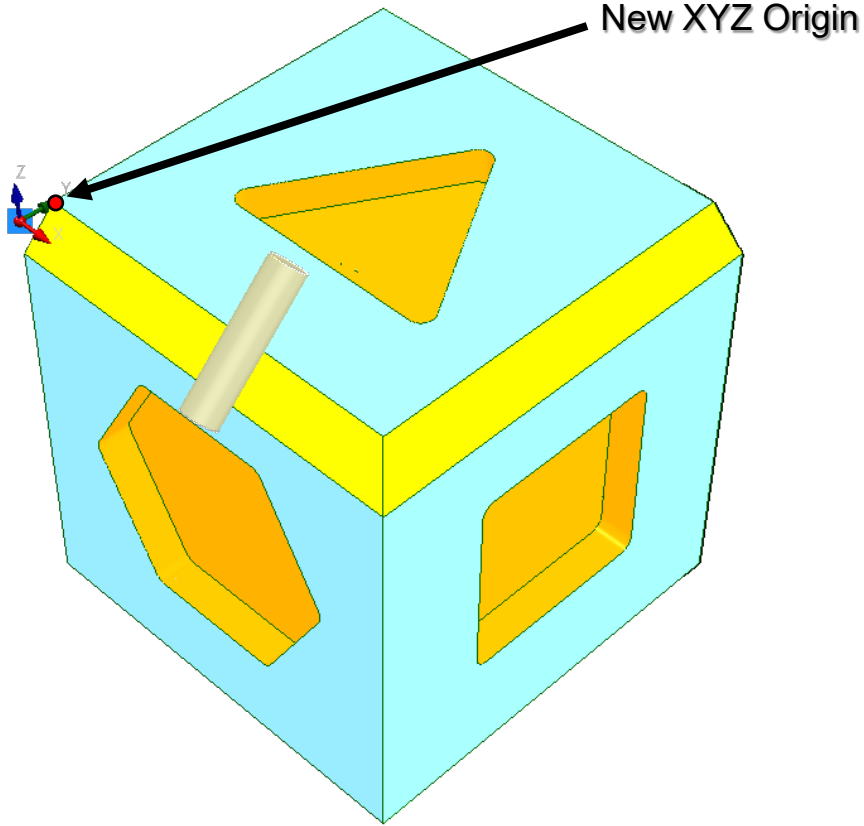
BLOCK 12 UNIVERSAL ROTARY TRANSFORM PLANE

ORIENT METHOD ANGLES

ORIGIN POINT		AXIS ANGLES	
X	0.0000	R(X)	-45.000
Y	0.5000	R(Y)	0.000
Z	0.0000	R(Z)	0.000

PROGRAM REVIEW SCREEN

DATA BLOCKS	SUB BLOCKS
9. TRANSFORM PLANE	START OF CONTOUR
10. MILL FRAME (POCKET BOUNDARY)	1. LINE
11. TRANSFORM PLANE END	END OF CONTOUR
12. TRANSFORM PLANE	
13. MILL CONTOUR (LEFT)	
14. TRANSFORM PLANE END	
END OF PROGRAM	



Let’s Program Together

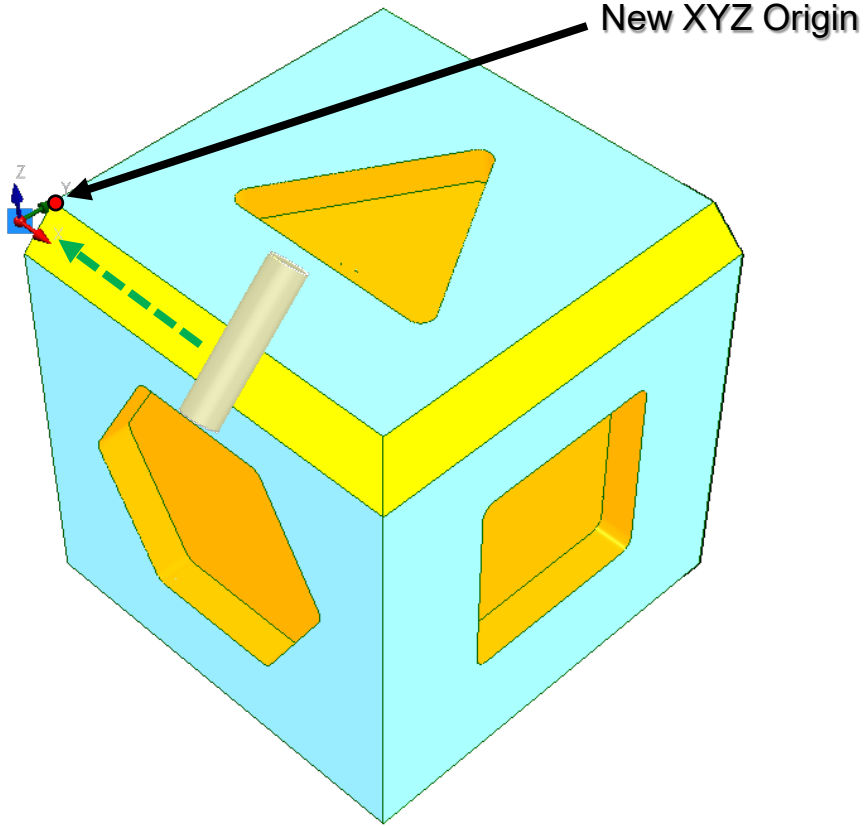
BLOCK 12 UNIVERSAL ROTARY TRANSFORM PLANE

ORIENT METHOD ANGLES

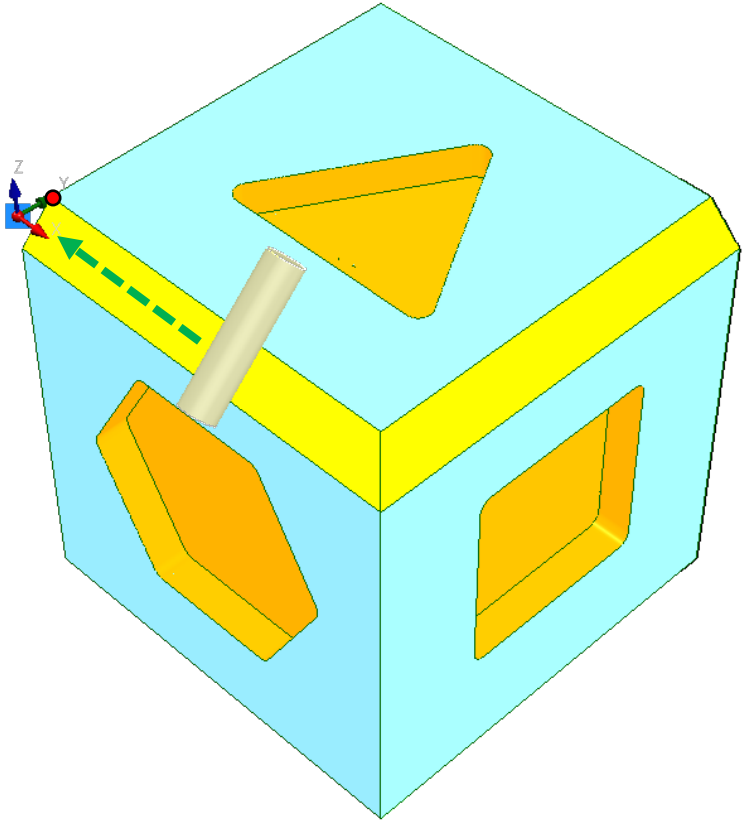
ORIGIN POINT		AXIS ANGLES	
X	0.0000	R(X)	-45.000
Y	0.5000	R(Y)	0.000
Z	0.0000	R(Z)	0.000

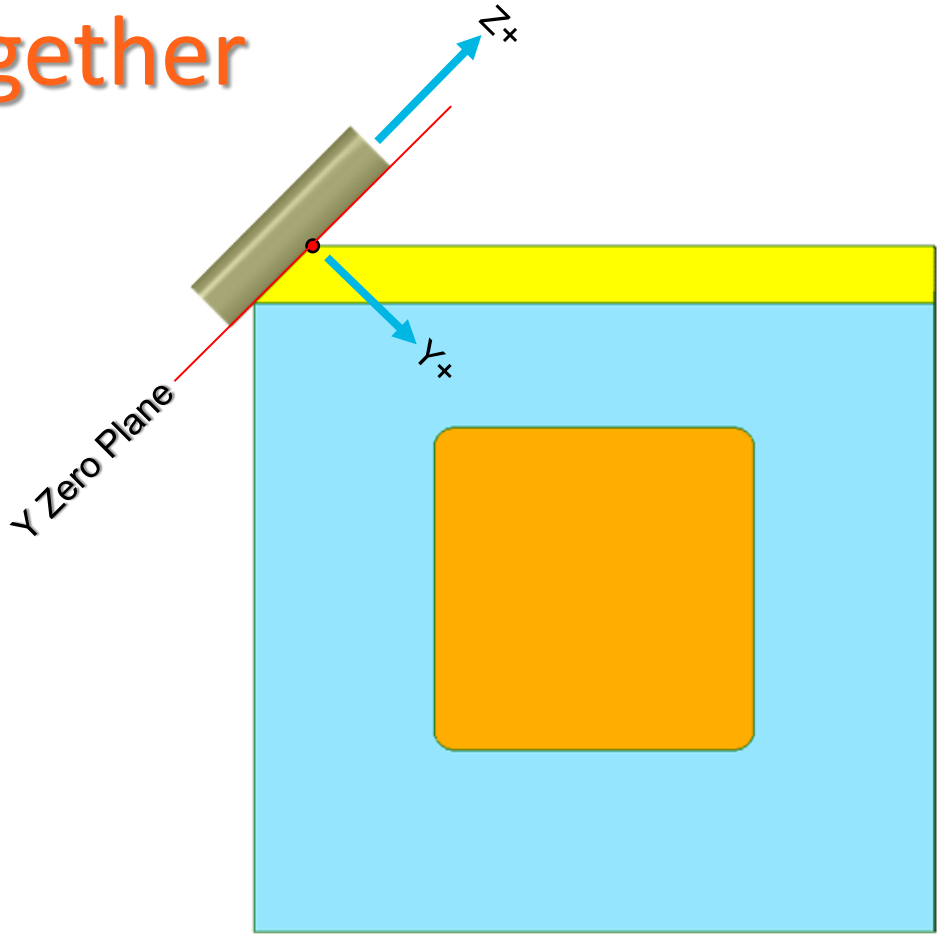
PROGRAM REVIEW SCREEN

DATA BLOCKS	SUB BLOCKS
9. TRANSFORM PLANE	START OF CONTOUR
10. MILL FRAME (POCKET BOUNDARY)	1. LINE
11. TRANSFORM PLANE END	END OF CONTOUR
12. TRANSFORM PLANE	
13. MILL CONTOUR (LEFT)	
14. TRANSFORM PLANE END	
END OF PROGRAM	

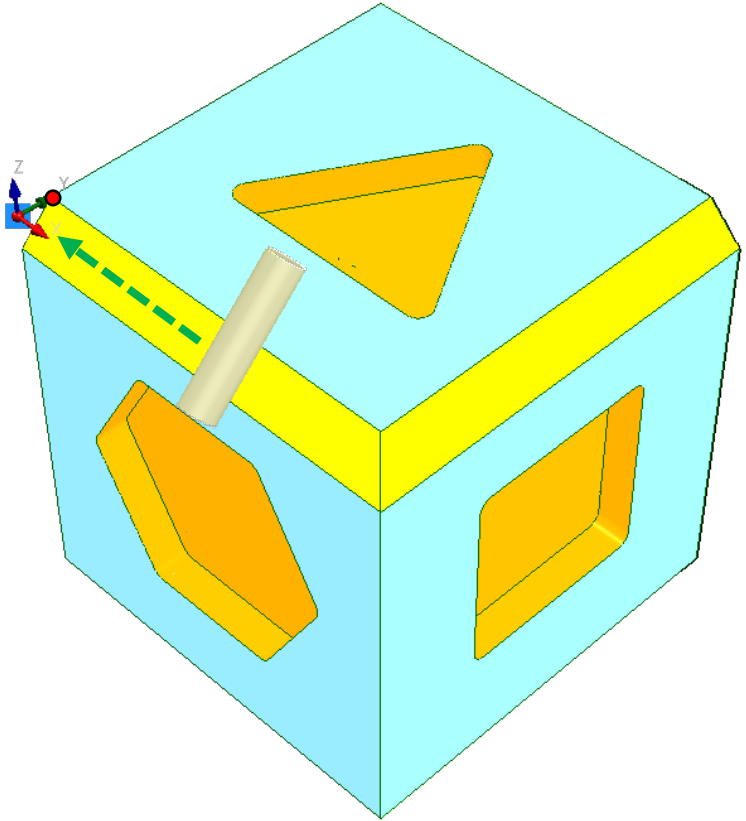


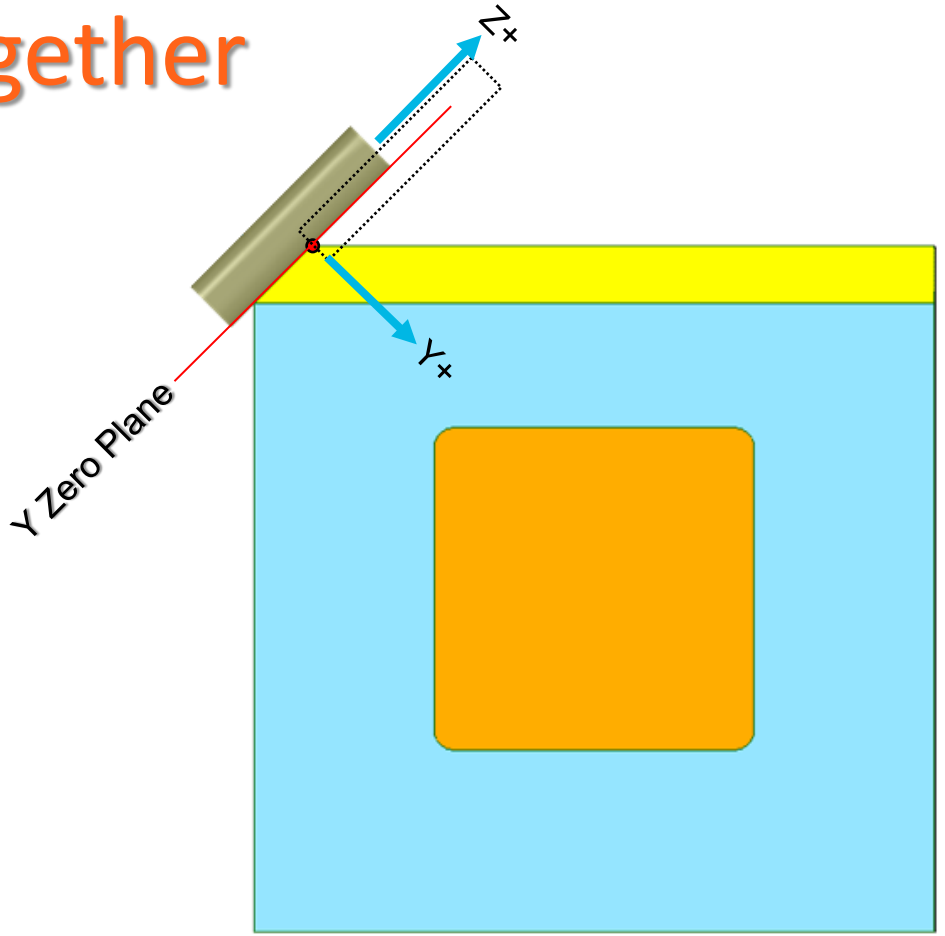
Let’s Program Together





Let’s Program Together





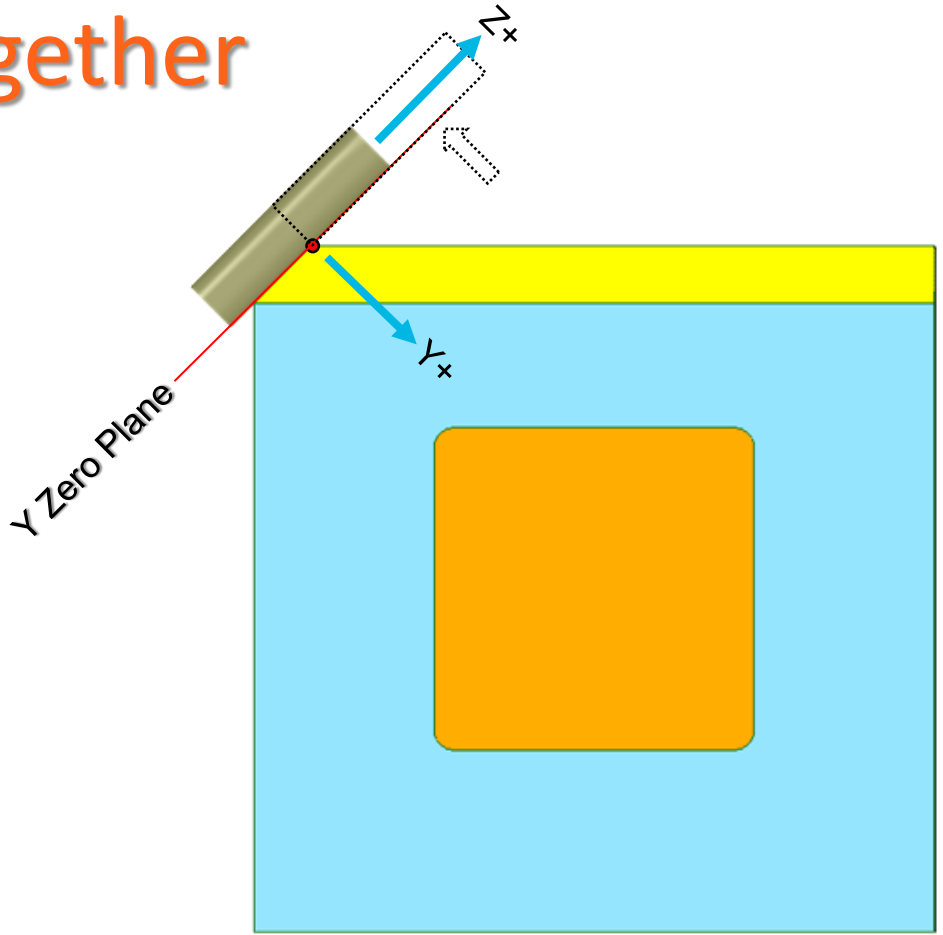
Let’s Program Together

Cutter Comp to Control Location

BLOCK	13	MILL CONTOUR	
SEGMENT	0	START	
X START	6.5000	Z START	0.1000
Y START	0.0000	Z BOTTOM	-1.0000

ROUGHING | FINISHING | SFQ | ALLOWANCES

TOOL	73 END MILL, dia. 0.5000		
MILLING TYPE	LEFT		
ENABLE BLEND MOVES	YES		
MILL FEED	150.0	PECK DEPTH	0.0000
SPEED (RPM)	8000	PLUNGE FEED	15.0



Let’s Program Together

BLOCK 12 UNIVERSAL ROTARY TRANSFORM PLANE

ORIENT METHOD ANGLES

ORIGIN POINT		AXIS ANGLES	
X	0.0000	R(X)	-45.000
Y	0.5000	R(Y)	0.000
Z	0.0000	R(Z)	0.000

PROGRAM REVIEW SCREEN

DATA BLOCKS	SUB BLOCKS
9. TRANSFORM PLANE	START OF CONTOUR
10. MILL FRAME (POCKET BOUNDARY)	1. LINE
11. TRANSFORM PLANE END	END OF CONTOUR
12. TRANSFORM PLANE	
13. MILL CONTOUR (LEFT)	
14. TRANSFORM PLANE END	
END OF PROGRAM