

PartMaster CAM - [Umbau auf Drehstrom Antrieb-z-Fräsen_4-Mot-loch.cnc]

File Edit View Setup Tooling Machining Macros Execute Window Help

Tooling Definitions

- No 2 : 5.5mm, Fräser Schrupp 5mm
- No 3 : 5.0mm, Fräser Schlicht 5mm
- No 1 : 3.0mm, Fräser Schlicht 3mm
- No 10 : 3.0mm, NC-Anbohrer
- No 11 : 1.6mm, Bohrer 1.6mm
- No 4 : 6.0mm, Fräser Schlicht 6mm
- No 12 : 2.0mm, Bohrer 2.0
- No 13 : 5.0mm, Bohrer 5mm
- No 14 : 6.1mm, Bohrer 6.1
- No 5 : 16.0mm, Fräser Schlicht 16mm eff.
- No 6 : 16.5mm, Fräser Schrupp 16mm
- No 7 : 12.0mm, Fräser Schlicht 12mm
- No 8 : 6.0mm, Chamfering Tool 6mm 90°
- No 9 : 4.9mm, Fräser Schlicht 4.9mm
- No 15 : 12.0mm, Twist Drill / Center Drill 12mm

Program Operations

- 2, MachineStop
- 3, MachineStop
- 4, Goto X89.362mm Y29.938mm Z8.0mm (Abs)
- 5, MachineStop
- 6, Goto X89.362mm Y90.057mm Z8.0mm (Abs)
- 7, MachineStop
- 8, MachineStop
- M6 9, Select Tool No 3 CRC 3 TLC 3, Spin 1000.0000 Clw, ConstSpinSpeed**
- 10, MachineStop
- 11, Spindle START
- 12, Goround "Con_1-Motor", Forward, Left At 20.0mm, 6.0mm deep
- 13, Goround "Con_2-Spindel", Forward, Left At 20.0mm, 6.0mm deep
- 14, Goround "Con_3-Mot-Loch1", Forward, Left At 26.0mm, 7.0mm deep
- 15, Goround "Con_4-Mot-Loch2", Forward, Left At 26.0mm, 7.0mm deep
- 16, Goround "Con_5-Mot-Loch3", Forward, Left At 26.0mm, 7.0mm deep
- 17, Goround "Con_6-Mot-Loch4", Forward, Left At 26.0mm, 7.0mm deep
- 18, MachineStop
- M6 19, Select Tool No 5 CRC 5 TLC 5, Spin 1000.0000 Clw, ConstSpinSpeed**
- 20, MachineStop
- 21, MachineStop
- 22, Spindle START
- 23, Goround "Con_7-Aussen", Forward, Left At 20.0mm, 10.0mm deep
- 24, Goround "Con_7-Aussen", Forward, Left At 20.0mm, 20.0mm deep
- 25, Goround "Con_7-Aussen", Forward, Left At 20.0mm, 30.0mm deep
- 26, MachineStop
- 27, Goround "Con_7-Aussen", Forward, Left At 20.0mm, 10.0mm deep
- 28, Goround "Con_7-Aussen", Forward, Left At 20.0mm, 20.0mm deep
- 29, Goround "Con_7-Aussen", Forward, Left At 20.0mm, 30.0mm deep
- 30, MachineStop
- M6 31, Select Tool No 8 CRC 8 TLC 8, Spin 1000.0000 Clw, ConstSpinSpeed**
- 32, MachineStop
- 33, MachineStop
- 34, Spindle START
- 35, Chamfer "Con_1-Motor", Forward, Left At 20.0mm, 0.5mm deep
- 36, Chamfer "Con_2-Spindel", Forward, Left At 20.0mm, 0.7mm deep
- 37, Chamfer "Con_7-Aussen", Forward, Left At 20.0mm, 1.0mm deep
- 38, Chamfer "Con_7-Aussen", Forward, Left At 20.0mm, 1.0mm deep
- 39, MachineStop
- 40, Chamfer "Con_4-Mot-Loch2", Forward, Left At 20.0mm, 0.5mm deep
- 41, Chamfer "Con_5-Mot-Loch3", Forward, Left At 20.0mm, 0.5mm deep
- 42, Chamfer "Con_6-Mot-Loch4", Forward, Left At 20.0mm, 0.5mm deep
- 43, Chamfer "Con_3-Mot-Loch1", Forward, Left At 20.0mm, 0.5mm deep
- 44, Spindle STOP

Current tool position

X 31.098mm
Y 29.948mm
Z 50.0mm

Current tool
Chamfering Tool 6mm
In position 8

Spindle speed 0.0rpm
Feed rate 100.0mm/min
Cycle time 17 mins 55 secs

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( Produced      :- 17:49:32 Saturday, July 28, 2012 )
( CNC File     :- Umbau auf Drehstrom Antrieb-z-Fräsen_4-Mot-loch )
( Post Processor :- M_MACH3 )
( Part Number ID :- RF20-1-Korrekturen )
M5G00G21G17G90G40G49G80
M6G49
N7T3M06 ( Fräser Schlicht 5mm )
N8G00G43Z50.0H3
N9S1000M03
N10G94
N11M00
N12S0
N13G94
N14M00
N15M00
N16S1000M03
N17G94
N18G00X29.998I29.948
N19Z16.0
N20G01Z-1.0F100
N21G03X29.248I30.698I29.248O29.948
N22X28.498I29.948I29.248O29.948
N23X29.248I29.198I29.248O29.948
N24X29.998I29.948I29.248O29.948
N25G00Z50.0
N26X90.102I29.948
N27Z16.0
N28G01Z-1.0

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PartMaster For Help, press F1

Append X 31.098mm Y 29.948mm Z 50.0mm