



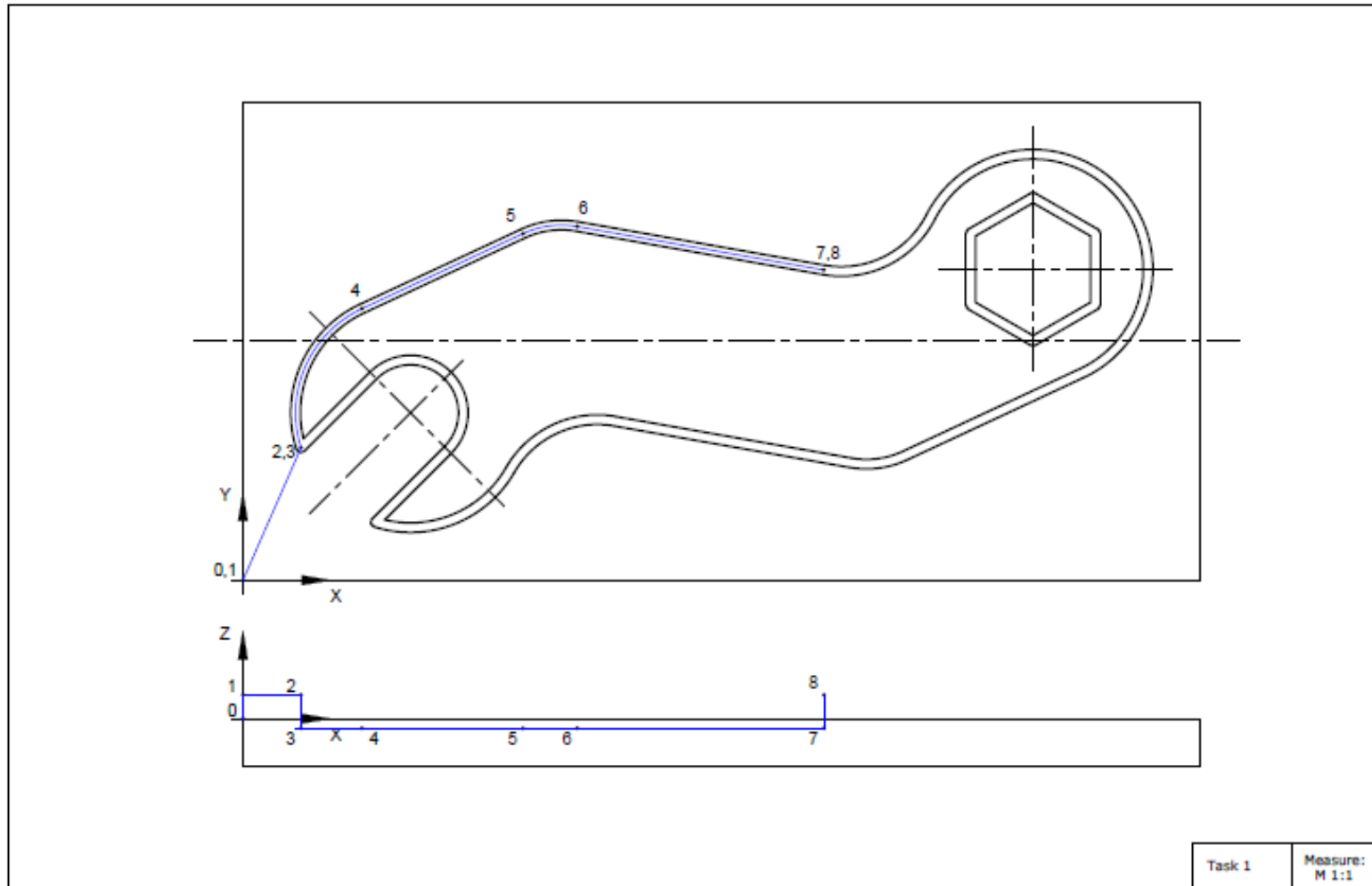
Field of education:
Mechanical engineering

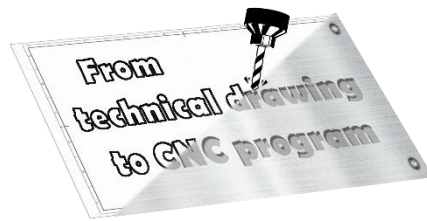
Professional qualification:
CNC operator

Exercise:
**Programming of CNC machine
(solution)**

Variant:
Task 14 – Wrench 5.1.

Solution:





Required written code that should be inserted into the control unit:

```
G0 Z5  
X12,139 Y27,695  
G1 Z-2  
G2 X24,857 Y56,751 R24  
G1 X58,488 Y72,433  
G2 X69,817 Y73,925 R19  
G1 X121,308 Y64,846  
Z5  
M30
```

Explanation of the G-code:

```
%Setting the coordinate system x=0, y=0, z=0; point 0  
G0 Z5 %Lifting of tool; point 1  
X12,139 Y27,695 %Positioning at the starting point; point 2  
G1 Z-2 %Tool entry into material; point 3  
G2 X24,857 Y56,751 R24 %Radial milling; point 4  
G1 X58,488 Y72,433 %Straight milling; point 5  
G2 X69,817 Y73,925 R19 %Radial milling; point 6  
G1 X121,308 Y64,846 %Straight milling; point 7  
Z5 %Lifting of tool; point 8  
M30 %End of program
```