

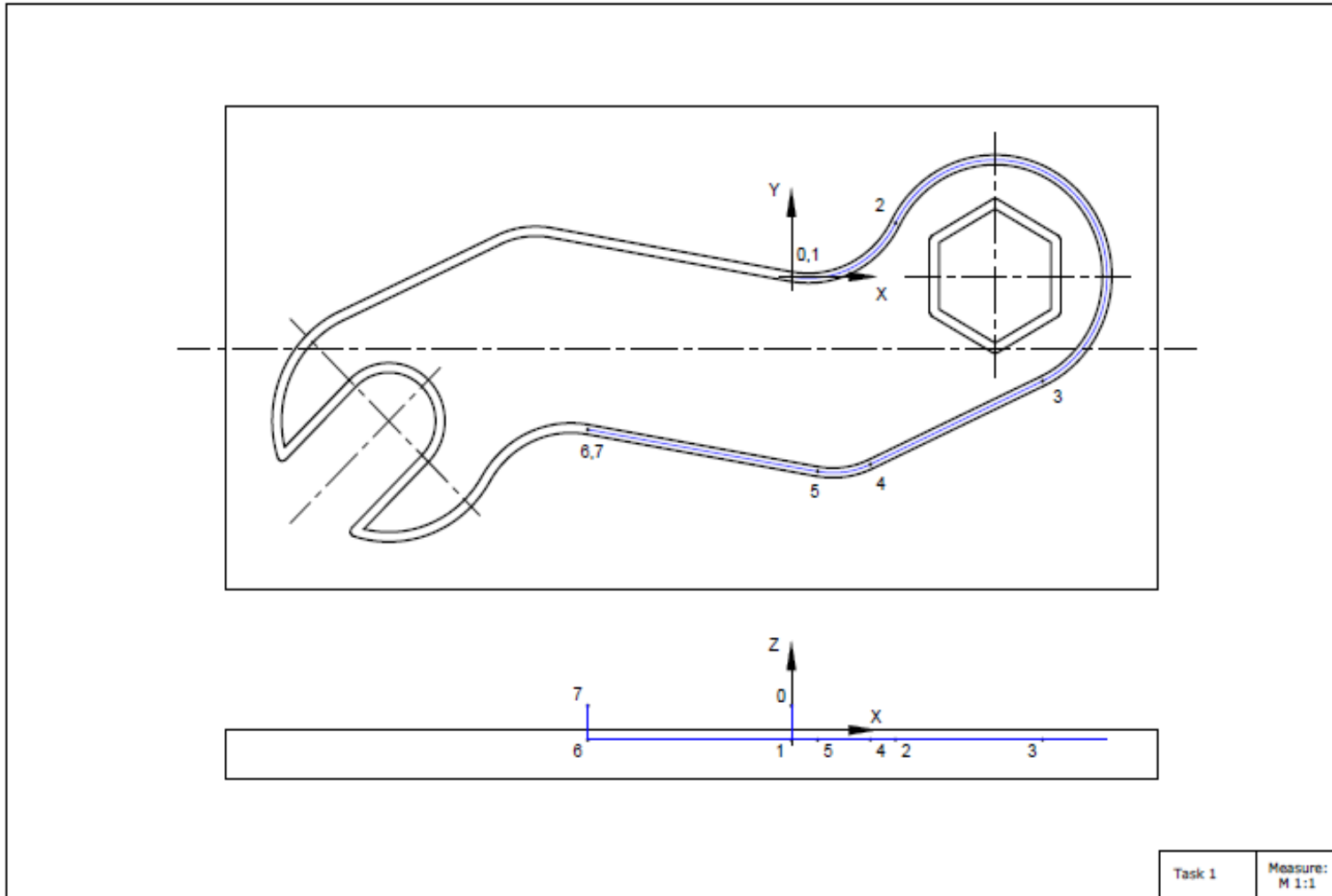
Field of education:
Mechanical engineering

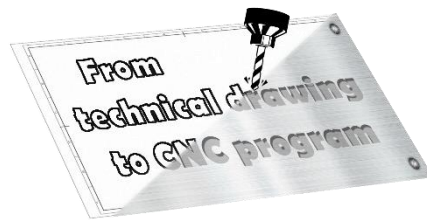
Professional qualification:
CNC operator

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

Variant:
Task 15 – Wrench 5.2.

Solution:





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

G1 Z-2

G3 X22,335 Y11,102 R21

G2 X53,835 Y-21,597 R-24

G1 X16,936 Y-38,803

G2 X5,607 Y-40,295 R19

G1 X-43,657 Y-31,608

Z5

M30

Explanation of the G-code:

%Setting the coordinate system $x=0$, $y=0$, $z=5$; point 0

G1 Z-2 %Tool entry into material; point 1

G3 X22,335 Y11,102 R21 %Radial milling; point 2

G2 X53,835 Y-21,597 R-24 %Radial milling; point 3

G1 X16,936 Y-38,803 %Straight milling; point 4

G2 X5,607 Y-40,295 R19 %Radial milling; point 5

G1 X-43,657 Y-31,608 %Straight milling; point 6

Z5 %Lifting of tool

M30 %End of program