



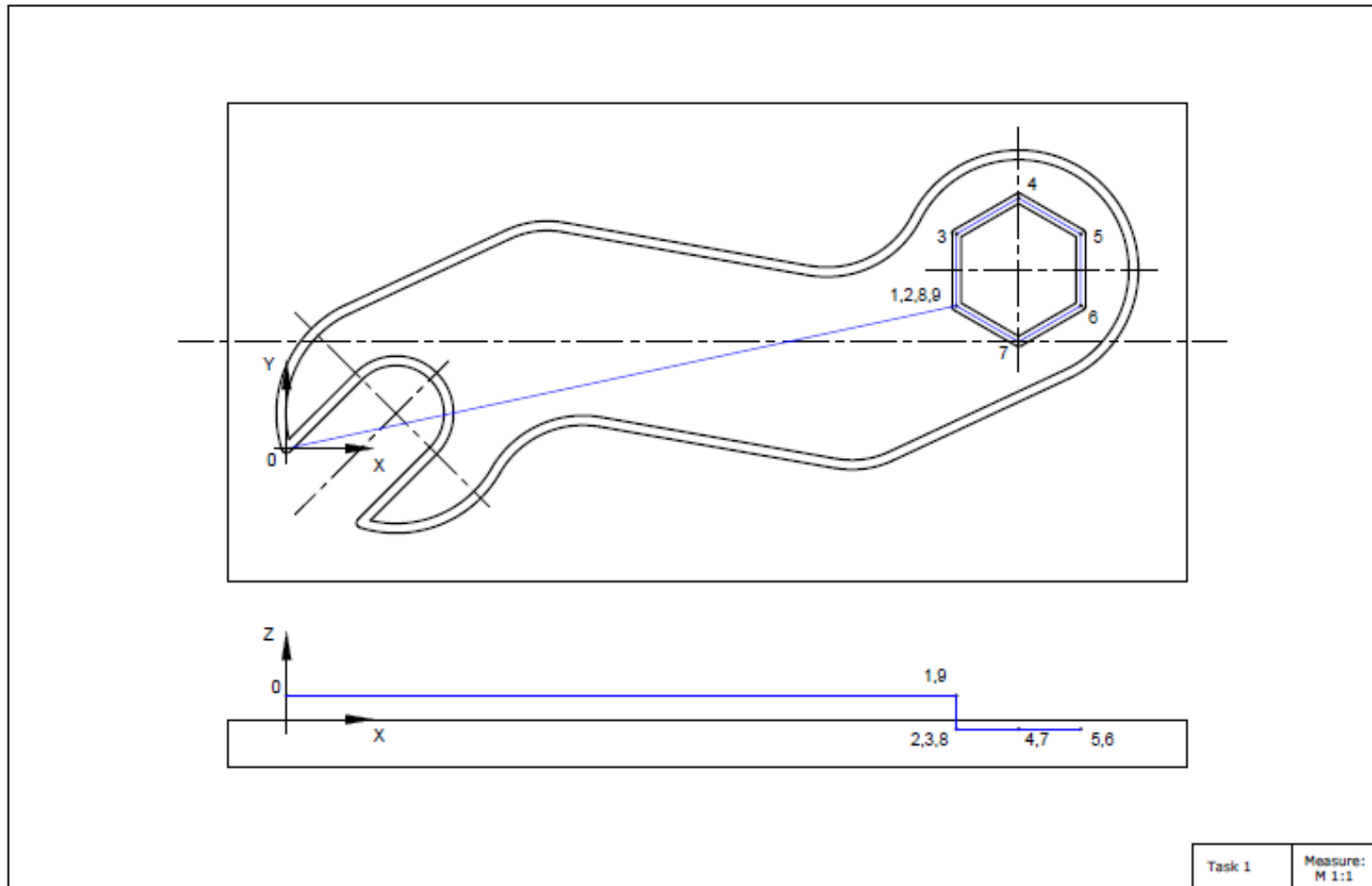
Field of education:
Mechanical engineering

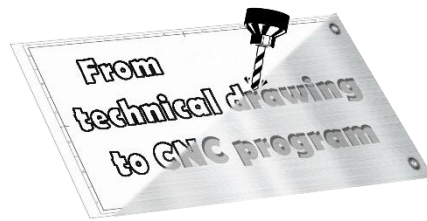
Professional qualification:
CNC operator

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

Variant:
Task 17 – Wrench 5.4.

Solution:





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

G0 X139,861 Y29,799

G1 Z-2

Y44,81

X152,861 Y52,316

X165,861 Y44,81

Y29,799

X152,861 Y22,294

X139,861 Y29,799

Z5

M30

Explanation of the G-code:

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

G0 X139,861 Y29,799 %Positioning at the starting point; point 1

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

Y44,81 %Straight milling; point 3

X152,861 Y52,316 %Straight milling; point 4

X165,861 Y44,81 %Straight milling; point 5

Y29,799 %Straight milling; point 6

X152,861 Y22,294 %Straight milling; point 7

X139,861 Y29,799 %Straight milling; point 8

Z5 %Lifting of tool

M30 %End of program