

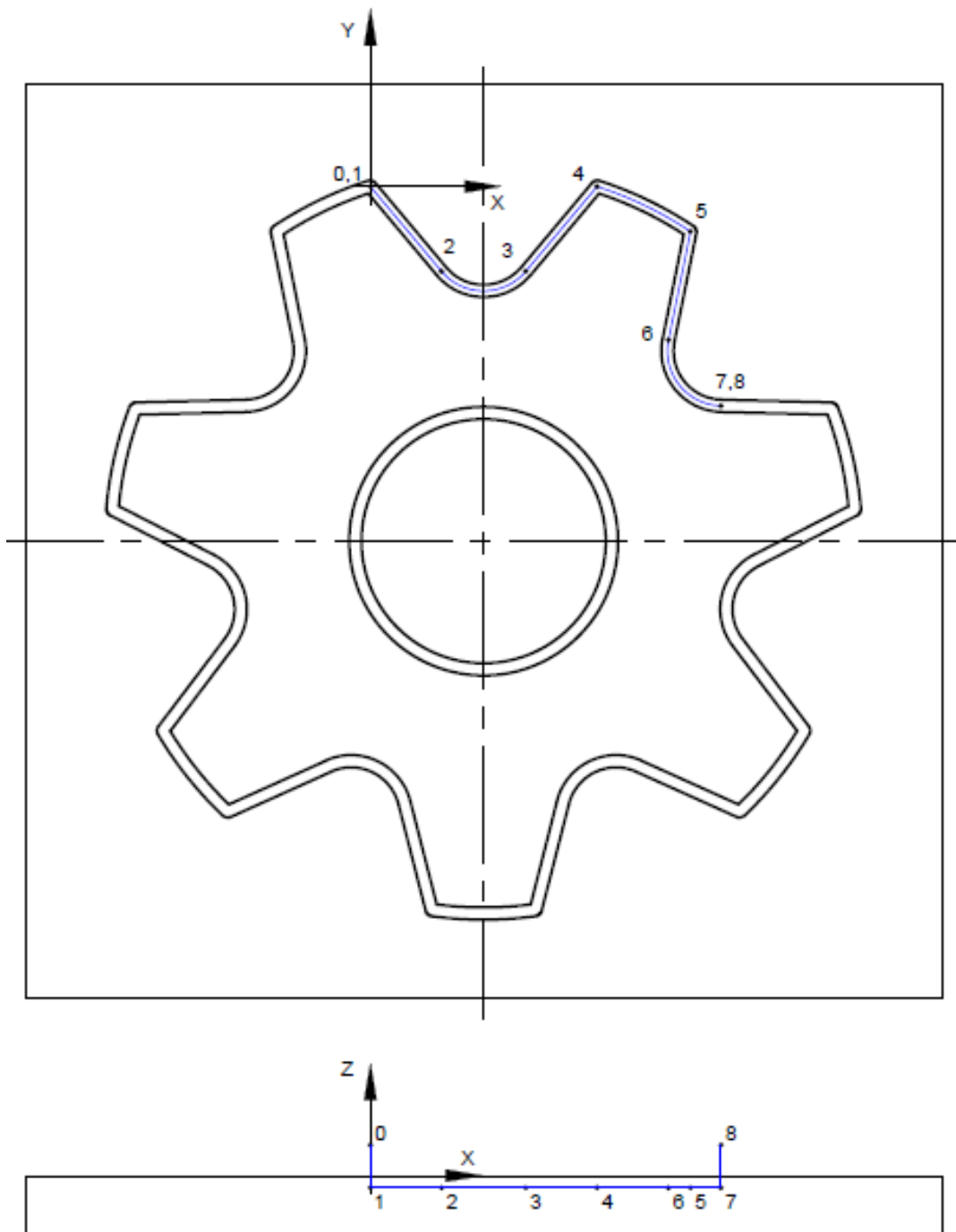
Field of education:
Mechanical engineering

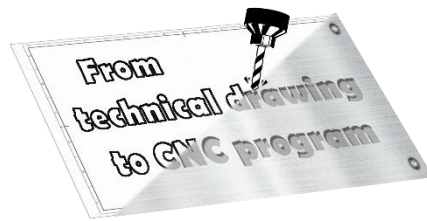
Professional qualification:
CNC operator

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

Variant:
Task 44 – Sprocket 2.2.

Solution:





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

G1 Z-2

X11,659 Y-13,895

G3 X25,448 R9

G1 X37,107 Y0

G2 X52,418 Y-7,373 R61

G1 X48,824 Y-25,152

G3 X57,421 Y-35,933 R9

G1 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

X11,659 Y-13,895 %Straight milling; point 2

G3 X25,448 R9 %Radial milling; point 3

G1 X37,107 Y0 %Straight milling; point 4

G2 X52,418 Y-7,373 R61 %Radial milling; point 5

G1 X48,824 Y-25,152 %Straight milling; point 6

G3 X57,421 Y-35,933 R9 %Radial milling; point 7

G1 Z5 %Lifting of tool; point 8

M30 %End of program